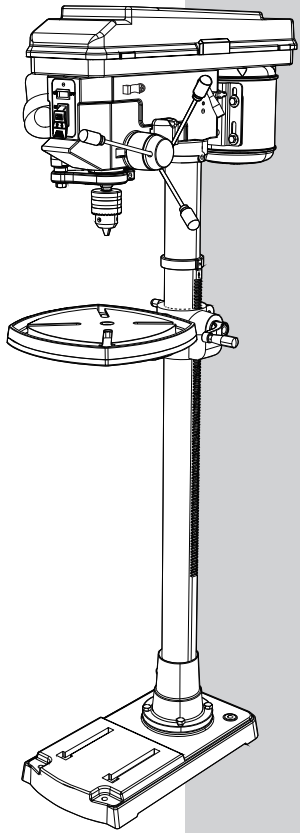
PORTER CABLE®

15 IN. (381 MM) DRILL PRESS

PERCEUSE À COLONNE 381 MM (15 PO)

TALADRO DE COLUMNA 381 MM (15 PULG.)



Instruction Manual
Manuel d'instructions
Manual de instrucciones

www.portercable.com

INSTRUCTIVO DE OPERACIÓN, CENTROS DE SERVICIO Y PÓLIZA DE GARANTÍA.
⚠ **ADVERTENCIA:** LÉASE ESTE INSTRUCTIVO ANTES DE USAR EL PRODUCTO.

CATALOG NUMBER
PCB660DP
TYPE 2

TABLE OF CONTENTS

PRODUCT SPECIFICATIONS

MOTOR		Chuck size	5/8 in. (16 mm)
Power source	120 V, 60 Hz, 8 A	Column size	2-7/8 in. (73 mm)
Horsepower	1 HP (Max. Developed)	**TABLE**	
Speed (RPM)	1790 (No load)	Size	13-5/16 in. x 13-3/16 in. (338 mm x 335 mm)
Type	Induction	**BASE**	
Volts	120 volts AC only	Size	20-3/8 in. x 11 in. (518 mm x 279 mm)
LASER	Class IIIa	Chuck to column	7-1/2 in. (190 mm)
Spindle travel	4 in. (102 mm)	Chuck to base	44-3/8 in. (1127 mm)
Speeds (RPM)	300 ~ 3100 RPM	Quill diameter	1.85 in. (47 mm)

⚠ WARNING

To avoid electrical hazards, fire hazards or damage to the tool, use proper circuit protection. Use a separate electrical circuit for your tools.

The Drill Press is wired at the factory for 110-120 Volt operation. It must be connected to a 120 V, 8 AMP branch circuit and use a 8 AMP time delay fuse or circuit breaker. To avoid shock or fire, replace power cord immediately if it is worn, cut or damaged in any way.

CALIFORNIA PROPOSITION 65

⚠ WARNING

Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to the state of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints,**
- **Crystalline silica from bricks and cement and other masonry products, and**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

Avoid prolonged contact with dust from power sanding, sawing, grinding, drilling and other construction activities. Wear protective clothing and wash exposed areas with soap and water. Allowing dust to get into your mouth, eyes, or lay on the skin may promote absorption of harmful chemicals.

⚠ WARNING

Use of this tool can generate and/or disperse dust, which may cause serious and permanent respiratory or other injury. Always use NIOSH/OSHA approved respiratory protection appropriate for the dust exposure. Direct particles away from face and body.

SAFETY GUIDELINES - DEFINITIONS

WARNING ICONS

Your power tool and its Instruction Manual may contain "WARNING ICONS" (a picture symbol intended to alert you to and/or instruct you how to avoid a potentially hazardous condition). Understanding and heeding these symbols will help you operate your tool better and safer. Shown below are some of the symbols you may see.

SAFETY ALERT: Precautions that involve your safety.

PROHIBITION

WEAR EYE PROTECTION: Always wear safety goggles or safety glasses with side shields.

WEAR RESPIRATORY AND HEARING PROTECTION: Always wear respiratory and hearing protection.

READ AND UNDERSTAND INSTRUCTION MANUAL: To reduce the risk of injury, user and all bystanders must read and understand instruction manual before using this product.

KEEP HANDS AWAY FROM THE MOVING PART AND CUTTING SURFACE: Failure to keep your hands away from the moving part and cutting surface will result in serious personal injury.

SUPPORT AND CLAMP WORK

⚠ DANGER **DANGER:** Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

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

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

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

POWER TOOL SAFETY RULES

GENERAL SAFETY INSTRUCTIONS BEFORE USING THIS POWER TOOL

Safety is a combination of common sense, staying alert and knowing how to use your power tool.

⚠ WARNING

To avoid mistakes that could cause serious injury, do not plug the tool in until you have read and understood the following.

1.  **READ** and become familiar with the entire Instruction Manual. **LEARN** the tool's application, limitations and possible hazards. Retain this manual as it contains important information regarding safe operation of this tool.
2. **KEEP GUARDS IN PLACE** and in working order.
3. **REMOVE ADJUSTING KEYS AND WRENCHES**. Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning ON.
4. **KEEP WORK AREA CLEAN**. Cluttered areas and benches invite accidents.
5. **DO NOT USE IN DANGEROUS ENVIRONMENTS**. Do not use power tools in damp locations, or expose them to rain or snow. Keep work area well lit.
6. **KEEP CHILDREN AWAY**. All visitors and bystanders should be kept a safe distance from work area.
7. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches or by removing starter keys.
8. **DO NOT FORCE THE TOOL.** It will do the job better and safer at the rate for which it was designed.
9. **USE THE RIGHT TOOL**. Do not force the tool or an attachment to do a job for which it was not designed.
10. **USE PROPER EXTENSION CORDS**. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will result in a drop in line voltage and in loss of power which will cause the tool to overheat. The table on page 6 shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.
11. **WEAR PROPER APPAREL**. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
12.  **ALWAYS WEAR EYE PROTECTION**. Any power tool can throw foreign objects into the eyes and could cause permanent eye damage. **ALWAYS** wear Safety Goggles (not glasses) that comply with ANSI Safety standard Z87.1. Everyday eyeglasses have only impact–resistant lenses. They **ARE NOT** safety glasses. **NOTE**: Glasses or goggles not in compliance with ANSI Z87.1 could seriously injure you when they break.
13.  **WEAR A FACE MAS K OR DUST MASK**. Sawing operation produces dust.
14.  **SECURE WORK**. Use clamps or a vise to hold work when practical. It is safer than using your hand and it frees both hands to operate the tool.
15. **DISCONNECT TOOLS FROM POWER SOURCE** before servicing, and when changing accessories such as blades, bits and cutters.
16. **REDUCE THE RISK OF UNINTENTIONAL STARTING**. Make sure switch is in the OFF position before plugging the tool in.
17. **USE RECOMMENDED ACCESSORIES**. Consult this Instruction Manual for recommended accessories. The use of improper accessories may cause risk of injury to yourself or others.
18. **NEVER STAND ON THE TOOL**. Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
19. **CHECK FOR DAMAGED PARTS**. Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function – check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
20. **NEVER LEAVE THE TOOL RUNNING UNATTENDED. TURN THE POWER "OFF".** Do not walk away from a running tool until the blade comes to a complete stop and the tool is unplugged from the power source.
21. **DO NOT OVERREACH**. Keep proper footing and balance at all times.
22. **MAINTAIN TOOLS WITH CARE**. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
23. **DO NOT** use power tool in presence of flammable liquids or gases.
24. **DO NOT** operate the tool if you are under the influence of any drugs, alcohol or medicationn that could affect your ability to use the tool properly.
25. Dust generated from certain materials can be hazardous to your health. Always operate saw in well-ventilated area and provide for proper dust removal.
26.  **WEAR HEARING PROTECTION** to reduce the risk of induced hearing loss.

ADDITIONAL SAFETY RULES FOR DRILL PRESSES

Following good safety practices when using drill presses is a must. Make a habit of including safety in all your activities.

⚠ WARNING

READ ALL INSTRUCTIONS BEFORE OPERATING PRODUCT. FAILURE TO FOLLOW ALL INSTRUCTIONS LISTED BELOW MAY RESULT IN ELECTRIC SHOCK, FIRE AND OR SERIOUS INJURY. Do not operate this tool until it is assembled and installed according to the instructions.

1. **YOUR DRILL PRESS MUST BE BOLTED** securely to a workbench. In addition, if there is any tendency for your drill press to move during certain operations, bolt the workbench to the floor.
2. **DO NOT** try to drill material too small to be securely held.
3. **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.
4. **DO NOT** install or use any drill bit that exceeds 7 in. (175 mm) in length or extends 6 in. (150 mm) below the chuck jaws. They can suddenly bend outward or break.
5. **DO NOT USE** wire wheels, router bits, shaper cutters, circle (fly) cutters, or rotary planers on this drill press.
6. **WHEN** cutting a large piece of material, make sure it is fully supported at the table height.
7. **NEVER** hold the work piece by hand. Secure the work piece with a clamp or another appropriate fixture if it is not long enough to be braced against the table column.
8. **CLAMP THE WORKPIECE OR BRACE IT** against the left side of the column to prevent rotation. If it is too short or the table is tilted, clamp it solidly to the table.
9. **IF THE WORKPIECE** overhangs the table such that it will fall or tip if not held, clamp it to the table or provide auxiliary support.
10. **SECURE THE WORK.** Use clamps or a vise to hold the work. It's safer than using your hand and it frees both hands to operate tool.
11. **WHEN** using a drill press vise, always fasten to the table.
12. **MAKE SURE** all clamps and locks are firmly tightened before drilling.
13. **MAKE SURE** there are no nails or foreign objects in the part of the workpiece to be drilled.
14. **SECURELY LOCK THE HEAD** and table support to the column, and the table to the table support before operating the drill press.
15. **NEVER** turn your drill press on before clearing the table of all objects (tools, scraps of wood, etc.). Remove material or debris from the area that might be ignited by hot chips.
16. Crowded, cluttered work areas that can cause tripping or loss of balance are particularly dangerous.
17. **BEFORE STARTING** the operation, jog the motor switch to make sure the drill bit does not wobble or vibrate.
18. **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 the unit until the problem is corrected.
19. **DO NOT** perform layout assembly or set up work on the table while the drill press is in operation.
20. **USE THE RECOMMENDED SPEED** for any drill press accessory and for different workpiece material. **READ THE INSTRUCTIONS** that come with the accessory.
21. **WHEN DRILLING** large diameter holes, clamp the workpiece firmly to the table. Otherwise, the bit may grab and spin the workpiece at high speeds. **DO NOT USE** fly cutters or multiple-part hole cutters, as they can come apart or become unbalanced in use.

22. **DO NOT** use bits with screw tips. These bits will pull the workpiece up from the table and start to spin, causing a serious risk of injury.
23. **MAKE SURE** the spindle has come to a complete stop before touching the workpiece.
24. **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.
25. Be sure the chuck is tightly secured to the spindle.
26. **USE ONLY THE SELF-EJECTING TYPE CHUCK KEY** as provided with the drill press. Tighten the bit securely in the chuck. The chuck key can be thrown at a high velocity if not removed, causing risk for injury.
27. **DO NOT FORCE DRILLING**. The tool will do the job better and safer at the rate for which it is was intended.
28. If the bit binds in the workpiece, release the on/off switch immediately. Unplug the tool, then free the bit from the workpiece. Do not try to free a jammed bit by starting and stopping the tool.
29. **DO NOT** touch the drill bit or cuttings. The drill bit and cuttings are hot immediately after drilling.
30. **ALWAYS** shut off, unplug and lock the drill press, if a lock in available, and store the key.

ADDITIONAL SAFETY RULES FOR THE LASER

⚠ DANGER

FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS INJURY.

Laser radiation, avoid direct eye exposure, serious eye injury can result.

- Do not use optical tools such as a telescope or transit to view the laser beam.
- Position the laser so unintentional eye contact will be avoided.
- Do not operate the laser around children or allow children to operate the laser / power tool.
- Do not disassemble. Modifying the product in any way can increase the risk of laser radiation. Use of controls or adjustments or performance of procedures other than those specified in this manual may result in hazardous laser radiation exposure.
- Do not operate in explosive atmospheres, such as in the presence of flammable liquids, gases, or dust.
- Turn the laser off when it is not in use.
- Store idle product out of reach of children and other untrained persons. Lasers / power tools are dangerous in the hands of untrained users.
- Use only accessories that are recommended by the manufacturer for your model. Accessories that may be suitable for one laser / power tool, may create a risk of injury when used on another laser / power tool.
- Repairs and servicing MUST be performed by a qualified repair facility. Repairs performed by unqualified personnel could result in serious injury.
- Do not remove or deface warning labels. Removing labels increases the risk of exposure to radiation.
- For indoor use only.
- This product is intended for use in a temperature range of 41°F(5°C) - 104°F(40°C).

⚠ WARNING

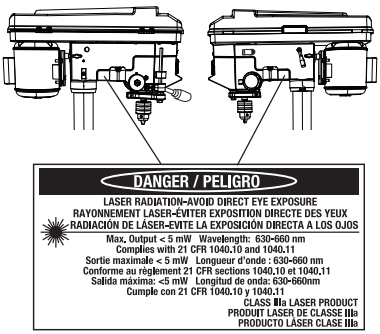
LASER RADIATION. AVOID DIRECT EYE EXPOSURE. Do not stare into the laser light source. Never aim light at another person or object other than the work piece. Laser light can damage your eyes.

⚠ WARNING

LASER RADIATION. Never aim the beam at a work piece with a reflective surface. Bright shiny reflective sheet steel or similar reflective surfaces are not recommended for laser use. Reflective surfaces could direct the beam back toward the operator.

⚠ WARNING

DO NOT use tinted glasses to enhance the laser light. Tinted glasses will reduce overall vision for the application and interfere with the normal operation of the tool.



ELECTRICAL REQUIREMENTS AND SAFETY

POWER SUPPLY AND MOTOR SPECIFICATIONS

⚠ WARNING

To avoid electrical hazards, fire hazards, or damage to the tool, use proper circuit protection. Use a seperate electrical circuit for your tool. Your drill press is wired at the factory for 120 V operation. Connect to a 120 V, 8 Amp circuit and use a 8 Amp time delay fuse or circuit breaker. To avoid shock or fire, if power cord is worn, cut, or damaged in any way, have it replaced immediately.

GROUNDING INSTRUCTIONS

⚠ WARNING

This tool must be grounded while in use to protect the operator from electrical shock.

IN THE EVENT OF A MALFUNCTION OR BREAKDOWN, grounding provides a path of least resistance for electric currents and reduces the risk of electric shock. This tool is equipped with an electrical cord that has an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching receptacle that is properly installed and grounded in accordance with all local codes and ordinances.

DO NOT MODIFY THE PLUG PROVIDED. If it will not fit the receptacle, have the proper receptacle installed by a qualified electrician.

IMPROPER CONNECTION of the equipment grounding conductor can result in risk of electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment grounding conductor. If repair or replacement of the electrical cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.

CHECK with a qualified electrician or service person if you do not completely understand the grounding instructions, or if you are not certain the tool is properly grounded.

USE only 3-wire extension cords that have three-pronged grounding plugs with three-pole receptacles that accept the tool's plug. Repair or replace damaged or worn cords immediately.

Use a separate electrical circuit for your tool. This circuit must not be less than #18 wire and should be protected with a 8 Amp time lag fuse. Before connecting the motor to the power line, make sure the switch is in the off position and the electric current is rated the same as the current stamped on the motor nameplate. Running at a lower voltage will damage the motor.

GUIDELINES FOR EXTENSION CORDS USE THE PROPER EXTENSION CORD. Make sure your extension cord is in good condition. Use an extension cord heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power, overheating and burning out of the motor. The table below shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Make sure your extension cord is properly wired and in good condition. Always replace a damaged extension cord or have it repaired by a qualified technician before using it. Protect your extension cords from sharp objects, excessive heat and damp or wet areas.

MINIMUM GAUGE FOR EXTENSION CORDS (AWG)

(WHEN USING 120 VOLTS ONLY)

Ampere Rating		Total Length of Cord			
More Than	Not More Than	25 (7.62 m)	50	100	150 ft. 45.72 m)
		AWG- American Wire Gauge			
0	6	18	16	16	14
6	10	18	16	14	12
10	12	16	16	14	12
12	16	14	12	Not Recommended	

⚠ WARNING

This tool is for indoor use only. Do not expose to rain or use in damp locations.

This tool is intended for use on a circuit that has a receptacle like the one illustrated in Fig. 1. Fig. 1 shows a three-pronged electrical plug and receptacle that has a grounding conductor. If a properly grounded receptacle is not available, an adapter (Fig. 2) can be used to temporarily connect this plug to a two-contact grounded receptacle. The adapter (Fig. 2) has a rigid lug extending from it that MUST be connected to a permanent earth ground, such as a properly grounded receptacle box.

⚠ CAUTION

In all cases, make certain the receptacle is properly grounded. If you are not sure, have a qualified electrician check the receptacle.

Fig. 1

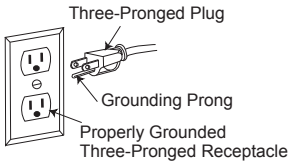
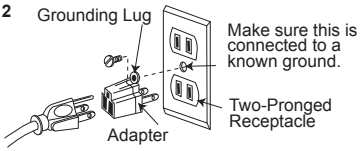


Fig. 2



TOOLS NEEDED FOR ASSEMBLY

Supplied

3 mm hex key

5 mm hex key

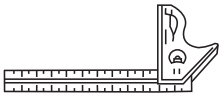
6 mm hex key

Not Supplied

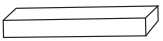
Slotted screwdriver

Wrench

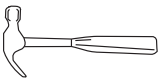
Adjustable wrenches



Combination square



Block of wood



Hammer or rubber mallet

CARTON CONTENTS

UNPACKING AND CHECKING CONTENTS

Carefully unpack the drill press and all its parts, and compare against the list below and the illustration on the next page. Place the drill press on a secure surface and examine it carefully.

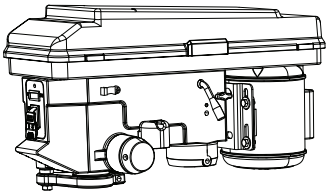
⚠ WARNING

- To avoid injury from unexpected starting or electrical shock, do not plug the power cord into a source of power during unpacking and assembly. This cord must remain unplugged whenever you are adjusting/assembling the drill press.
- The drill press is heavy and should be lifted with care. If needed, get the assistance of someone to lift and move the drill press.
- If any part is missing or damaged, do not attempt to assemble the drill press, or plug in the power cord until the missing or damaged part is correctly replaced.

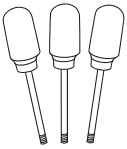
TABLE OF LOOSE PARTS

ITEM	DESCRIPTION	Q'TY
A.	Head Assembly	1
B.	Feed Handles Assembly	3
C.	Table Assembly	1
D.	Hardware Bag	
	Crank Handle	1
	Hex Wrenches	3
	Lock Handle	1
	Hex Bolts	4
	Wedge	1
	Arbor	1
	Worm Gear	1
E.	Base	1
F.	Chuck & Key Hardware	
	Chuck	1
	Chuck Key	1
G.	Column Assembly	1

UNPACKING YOUR DRILL PRESS



A



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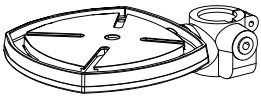

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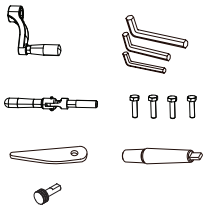

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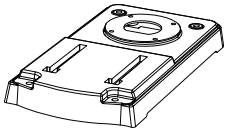

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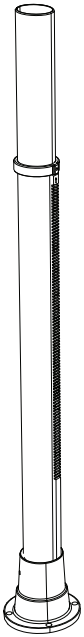

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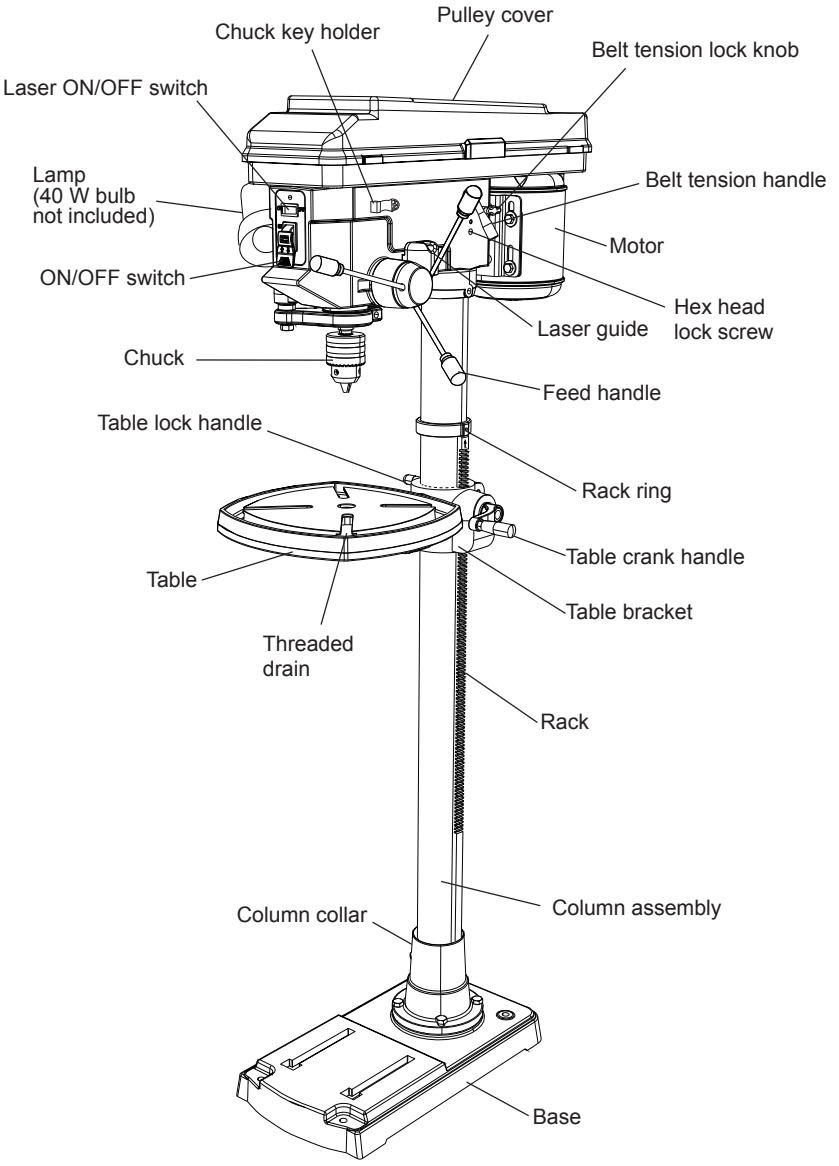
KNOW YOUR DRILL PRESS



GLOSSARY OF TERMS

BASE – Supports drill press. For additional stability, holes are provided in the base to bolt drill press to the floor. (See "ADDITIONAL SAFETY RULES FOR DRILL PRESSES".)

BACKUP MATERIAL – A piece of scrap wood placed between the workpiece and table. The backup board prevents wood in the workpiece from splintering when the drill passes through the backside of the workpiece. It also prevents drilling into the table top.

PULLEY COVER – Covers the pulleys and belt during operation of the drill press.

BELT TENSION – Refer to the "Assembly" Section, "Installing and Tensioning Belt."

BELT TENSION HANDLE – Turn the handle counterclockwise to apply tension to belt, turn the handle clockwise to release belt tension.

BELT TENSION LOCK KNOBS – Tightening the knobs locks the motor bracket support and the belt tension handle, maintaining correct belt distance and tension.

BEVEL SCALE – Shows degree of table tilt for bevel operations. The scale is mounted on the side of the arm.

CHUCK – Holds a drill bit or other recommended accessory to perform desired operations.

CHUCK KEY – A self-ejecting chuck key which will pop out of the chuck when you let go of it. This action is designed to help prevent throwing of the chuck key from the chuck when the power is turned "ON." Do not use any other key as a substitute; order a new one if damaged or lost.

COLUMN ASSEMBLY – Connects the head, table, and base on a one piece tube for easy alignment and movement. Mounts to base.

COLUMN COLLAR – Holds the rack to the column. Rack remains movable in the collar to permit table support movements.

DEPTH SCALE STOP NUTS – Lock the spindle to a selected depth.

DEPTH SCALE – Indicates depth of hole being drilled.

DRILL BIT – The cutting tool used in the drill press to make holes in a workpiece.

ON/OFF SWITCH – Has locking feature. This feature is intended to help prevent unauthorized and possible hazardous use by children and others. Insert the key into the switch to turn the drill press on.

DRILLING SPEED – Changed by placing the belt in any of the steps (grooves) in the pulleys. See the Spindle Speed Chart inside belt guard.

FEED HANDLE – Moves the chuck up or down. One or two of the handles may be removed if necessary whenever the workpiece is of such unusual shape that it interferes with the handles.

HEX HEAD LOCK SCREWS – Locks the head to the column. ALWAYS lock the head in place while operating the drill press.

LAMP – or Worklight. This tool comes equipped with a worklight (bulb not included) that provides additional light to the work area.

RACK – Combines with gear mechanism to provide easy elevation of the table by the hand operated table crank.

RACK RING – Hold the top of the rack in place on the column. Make sure this is tight before operating drill.

REVOLUTIONS PER MINUTE (R.P.M.) – The number of turns completed by a spinning object in one minute.

SPINDLE SPEED – The R.P.M. of the spindle.

SPRING CAP – Adjusts the quill return spring tension.

TABLE HANDLE LOCK – Tightens the table bracket to the column. Always have it locked in place while operating the drill press.

TABLE – Provides a working surface to support the workpiece.

TABLE BEVEL LOCK – Locks the table in any position from 0° to 45°.

TABLE CRANK HANDLE – Elevates and lowers the table. Turn clockwise to elevate the table. Support lock must be released before operating the crank.

TABLE LOCK – Locks the table after it is rotated to various positions.

TABLE BRACKET – Rides on the column to support the table arm and table.

THREADED DRAIN – Attach a 5/8 in. (15.9 mm, pipe threaded) metal pipe to the threaded opening for draining excess oil into a quill container. For a non-draining surface, attach a threaded metal plug. Pipe and plug not included.

WORKPIECE – Material being drilled.

ASSEMBLY AND ADJUSTMENTS

Estimated Assembly Time: 20 ~ 35 minutes
ASSEMBLY INSTRUCTIONS

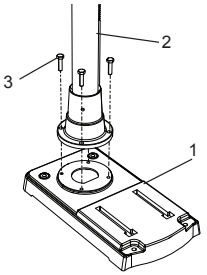
⚠ WARNING

- For your own safety, never connect plug to power source outlet until all assembly steps are complete and you have read and understood the safety and operating instructions.
- The drill press is a heavy power tool and should be lifted with the help of two people OR MORE to safely assemble it.

ASSEMBLING COLUMN TO BASE (FIG. A)

1. Position the base (1) on a flat work surface.
2. Place the column (2) on the base, aligning the mounting holes to the base.
3. **Bag "D" -** Locate the four hex bolts (3) from the loose parts bag.
4. Place a hex bolt (3) in each hole through the column support and thread into the base. Tighten with a 17 mm hex wrench.

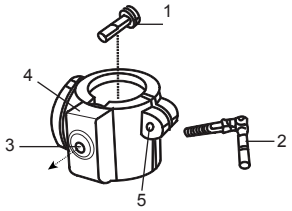
Fig. A



INSTALLING THE TABLE (FIG. B-F)

1. **Bag "D" -** Locate the worm gear (1) and table lock handle (2) from the loose parts bag. (Fig. B)
2. Insert the worm gear (1) into the table crank handle hole (3) from inside the table assembly (4). Make sure the worm gear (1) meshes with the inside raising/ lowering gear.
3. Insert the table lock handle (2) from the left to right into the hole (5) at the rear of the table assembly.

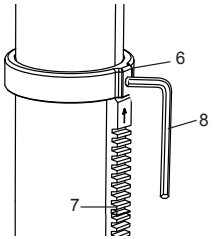
Fig. B



NOTE: Table removed from bracket in illustration for clarity.

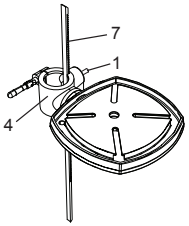
4. Remove the rack ring (6) and rack (7) from the column using a 3 mm hex key (8). (Fig. C)

Fig. C



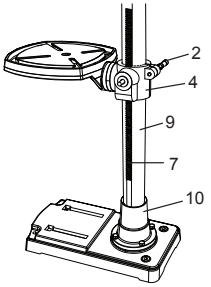
5. Place the rack (7) into the table assembly (4), making sure the worm gear (1) on the inside of the table assembly is engaged with the teeth of the rack and the arrow stamped on the rack is pointing up. (Fig. D)

Fig. D



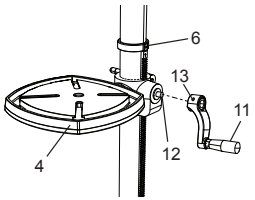
6. Slide the table assembly (4) with the rack (7) onto the column (9). (Fig. E)
7. Engage the bottom of the rack (7) with the lip of the column support (10). Lock the table assembly to the column using the lock handle (2).

Fig. E



8. Replace the rack ring (6) and tighten. (Fig. F)
9. Install the table crank handle (11) onto the worm gear shaft (12).
10. Line up the flat side of the shaft with the set screw (13) in the table crank handle and tighten the screw with a 3 mm hex key.

Fig. F



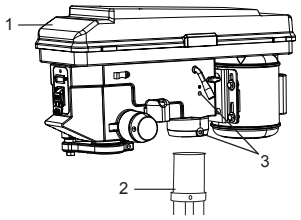
INSTALLING THE HEAD (FIG. G)

⚠ WARNING

The Drill Press head is very heavy and MUST be lifted with the help of 2 people OR MORE to safely assemble the Drill Press head on the column.

1. Carefully lift the head (1) above the column (2) and slide it onto the column. Make sure the head slides down over the column as far as possible. Align the head with the base.
2. Tighten the two head lock set screws (3) on the right side of the head with a 5 mm hex key.

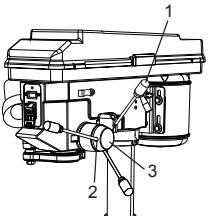
Fig. G



INSTALLING FEED HANDLES (FIG. H)

1. **Bag "B" -** Locate the three feed handles (1) in the loose parts bag.
2. Thread the three feed handles (1) into the threaded holes (2) on the right side hub assembly (3) and tighten.

Fig. H



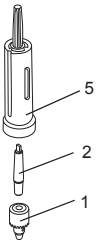
INSTALLING THE CHUCK (FIG. I, J, K)

⚠ WARNING

Before installing the chuck and arbor to the drill press head, clean all mating surfaces with a non petroleum based product; such as alcohol or lacquer thinner. Any oil or grease used in the packing of these parts must be removed otherwise the chuck may come loose during operation.

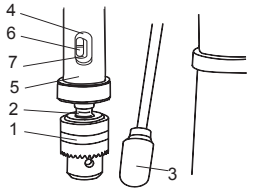
1. **Bag "D, F" -** Push the chuck (1) onto the spindle arbor (2). Tap gently on the arbor with a hammer or rubber mallet to ensure a proper seat. (Fig. I)

Fig. I



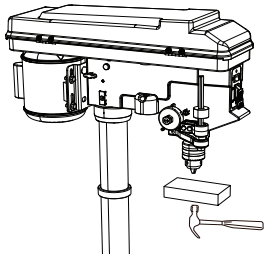
2. Lower the spindle by turning the feed handle (3) counterclockwise, until the outer slot (4) appears on the quill (5). (Fig. J)
3. Push the chuck (1) and spindle arbor (2) up into the spindle, making sure the tang (6) (upper narrow end of the spindle arbor shank) is engaged and locked in the inner slot (7) of the spindle. This can be seen through the outer slot (4) of the quill by rotating the chuck and arbor until the two slots are aligned.
4. Open the jaws of the chuck (1) by rotating the chuck sleeve clockwise. To prevent damage, make sure the jaws are completely receded into the chuck. **NOTE:** Clean the taper with a non-alcohol based cleaner before inserting it into the arbor.

Fig. J



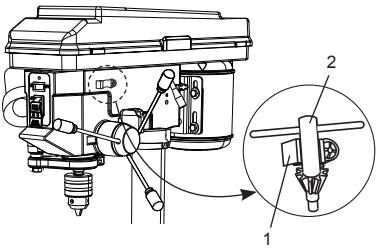
5. Using a rubber mallet, or a hammer and a block of wood, firmly tap the chuck upward into position on the spindle shaft.

Fig. K



CHUCK KEY STORAGE (FIG. L)
Storage holder (1) for the chuck key (2) is located on the right side of the drill press.

Fig. L

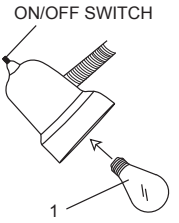


INSTALLING THE BULB (FIG. M)
NOTE: Bulb is not included.
1. Install a light bulb (1) (no larger than 40 watt) into the socket.

⚠ WARNING

- **For your own safety, never connect plug to power source outlet until all assembly steps are complete and you have read and understood the safety and operating instructions.**
- **To prevent injury resulting from heat of the light bulb. Never touch the light bulb.**
- **To prevent electric shock, never touch the bulb socket when the plug is connected to the power source.**

Fig. M



ADJUSTMENT INSTRUCTIONS
NOTE: All the adjustments for the operation of the drill press have been completed at the factory. Due to normal wear and use, some occasional readjustments may be necessary.

⚠ WARNING

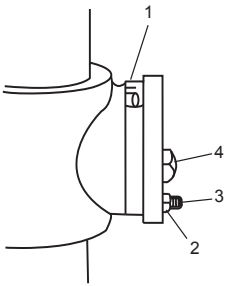
To avoid injury from an accidental start, ALWAYS make sure the switch is in the “OFF” position, the switch key is removed, and the plug is not connected to the power source outlet before making adjustments.

BEVEL DRILLING (FIG. N)
NOTE: A bevel scale (1) has been included to measure approximate bevel angles. If precision is necessary, a square or other measuring tool should be used to position the table.

⚠ WARNING
To prevent personal injury, always disconnect the plug from the power source when making any adjustments.

1. Turn the nut (2) on the locking pin (3) clockwise with an adjustable wrench to RELEASE the locking pin (3) and pull it out from the table bracket.
2. Loosen the large hex head table bevel locking bolt (4) using the adjustable wrench.
3. Tilt the table, aligning the desired angle measurement to the zero line opposite the scale (1).
4. Tighten the table bevel locking bolt (4).
5. To return the table to its original position, loosen the table bevel locking bolt (4). Return the table to the 0° position.
6. Return nut (2) on locking pin. Gently tap locking pin until it is seated in the mating hole of the table bracket. Hand tighten the nut (2).
   NOTE: The table bracket has been removed from the illustration for clarity.

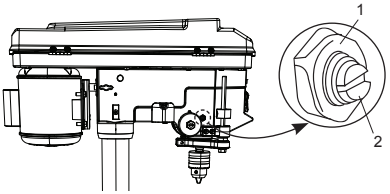
Fig. N



SPINDLE / QUILL (FIG. O)
Rotate the feed handles counterclockwise to lower spindle to its lowest position. Hold the chuck and move it front to back. If there is excessive play, proceed with the following adjustments:

1. Loosen the lock nut (1) located on the left side of the drill press, using a 14 mm wrench.
2. Turn the screw (2) clockwise to eliminate the play, using a slotted screwdriver, but without obstructing the upward movement of the the spindle. (A little play in the spindle is normal.)
3. Tighten the lock nut (1).

Fig. O

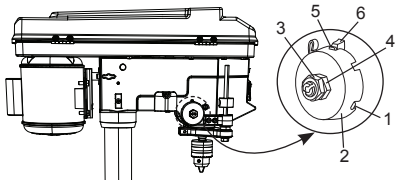


QUILL RETURN SPRING (FIG. P)
The quill return spring may need adjustment if the tension causes the quill to return too rapidly or too slowly.

1. Lower the table for additional clearance.
2. Place a screwdriver in the lower front notch (1) of the spring cap (2). Hold it in place while loosening and removing only the outer jam nut (3).
3. With the screwdriver still engaged in the notch, loosen the inner nut (4) just until the notch (5) disengages from the base (6) on the drill press head.
   NOTE: DO NOT REMOVE THIS INNER NUT, because the spring will forcibly unwind.
4. Carefully turn the spring cap (2) counterclockwise with the screwdriver, engaging the next notch.
5. Lower the quill to the lowest position by rotating the feed handle in a counterclockwise direction while holding the spring cap (2) in position.
6. Adjust the quill up and down as you desire and tighten the inner nut (4) snugly against the spring cap. Secure the outer nut (3) against the inner nut with the adjustable wrench.

NOTE: DO NOT OVERTIGHTEN and restrict quill movement.

Fig. P



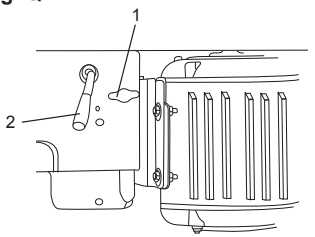
BELT TENSION (FIG. Q)

⚠ WARNING

To avoid injury from an accidental start, ALWAYS make sure the switch is in the "OFF" position, the switch key is removed, and the plug is not connected to the power source outlet before making belt adjustments.

1. To release the belt tension, turn the belt tension lock knobs (1) on each side of the drill press head counterclockwise.
2. To tighten the belts, push the belt tension handle (2) toward the rear (motor) end.
3. Lock the two belt tension lock knobs (1) by turning clockwise.
   NOTE: Belt tension is correct if the belt deflects approximately 1/2 in. (12.7 mm) when pressed at its center.
   NOTE: To loosen the belts, pull the belt tension handle toward the front (switch) end.

Fig. Q



LASER ADJUSTMENT (FIG. R, S, T)

NOTE: The laser assembly has been installed and preset at the factory. However, any adjustments should be checked and made before operating the drill press. It should also be rechecked periodically, as constant machine vibration may cause it to become misaligned.

⚠ WARNING

A laser light is radiated when the laser guide is turned on. Avoid direct eye contact. Always unplug the drill press from the power source before making any adjustments.

1. Remove the guards (1) by loosening the screw (2) to access the laser assemblies. (Fig. R)
2. Take a length of board (3) and draw a perpendicular line (4) on one side using a square. (Fig. S)
3. Place a small drill bit (5) in the chuck (6), then place the board (3) on the table on edge against the drill bit with the marked line side toward the back of the drill press. **NOTE:** The table should be in horizontal position and locked. Verify that the line (4) is perpendicular to the table.
4. Connect power to the drill press, and turn on the laser using the button at the front of the drill press head.

Fig. R

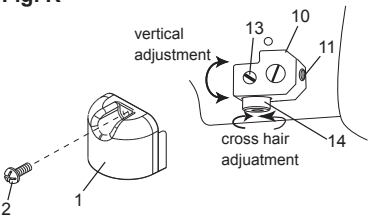
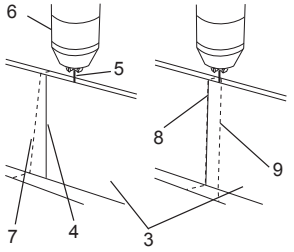


Fig. S



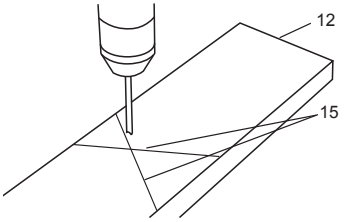
Vertical Alignment (FIG. R, S)

5. Loosen the three setscrews (11), then manually rotate the laser assembly (10) and move the board from side to side as required until the laser light (7-Fig. S) lines up with the board marking to look like (8). Then, carefully tighten the three setscrews (11). Repeat step 5, if necessary, until the light and marking are aligned.
6. Adjust the other laser in the same manner. Two parallel laser markings should look like (8) and (9) in Fig. S – the distance between the lines will vary with board thickness; however, the lines must be parallel.

Cross Hair Alignment (FIG. R, T)

7. Place board (12) flat on the table. Do not allow the board to move from this position; use clamps if needed. Bring the bit down until it leaves a slight perforation in the board; then raise it back up. (Fig. T)
8. Using a small screwdriver, loosen the laser setscrew (13) and adjust (14), so the laser line crosses the perforation. Tighten setscrew (13). (Fig. R)
9. Adjust the other laser assembly in the same manner until the laser lines form cross hairs (15) exactly over the perforation in the board. (Fig. T)
10. Tighten setscrew (13-Fig. R). Re-check the vertical alignment to insure that the laser lines did not shift during the tightening process. The laser is now calibrated properly and the location of your holes can be centered at the cross hairs for accurate drilling.
11. Assemble guards with the screws (2) over the laser on each side.

Fig. T



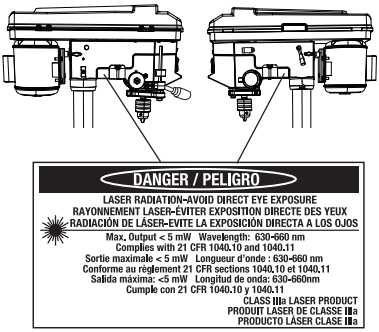
LASER LABEL (FIG. U)

The label on your laser may include the following symbols.

V .....volts
mW.....milliwatts
nm.....wavelength in nanometers
IIIa.....Class IIIA Laser

For your convenience and safety, the following labels are on your laser. (Fig. U)

Fig. U



OPERATION

BASIC DRILL PRESS OPERATION

⚠ WARNING

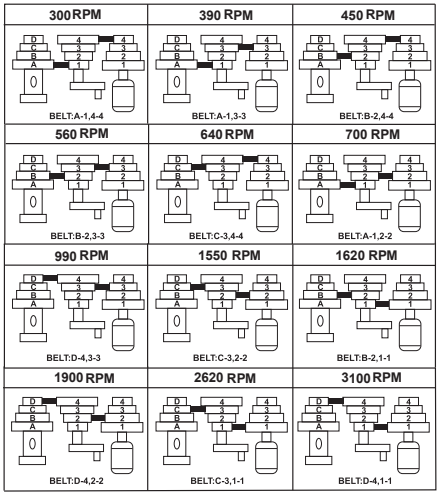
To avoid possible injury, keep guard closed and in place while tool is in operation.

To avoid injury from an accidental start, ALWAYS make sure the switch is in the “OFF” position, the switch key is removed, and the plug is not connected to the power source outlet before making belt adjustments.

SPEEDS AND BELT PLACEMENT (FIG. V)

The drill press has 12 speeds, see the chart in Fig. V to select the correct belt placement for your project.

Fig. V



DRILLING SPEED TABLE (RPM)-FOR 15 IN. (381 MM) DRILL PRESS					
Drill Dim. Inches (mm)	Material				
	Wood	Aluminum	Plastic	Mild Steel	Stainless
1/32 (0.7 mm)	3100	3100	3100	3100	3100
1/16 (2.5 mm)					1620-2620
1/8 (3.18 mm)				1620-2620	990-1550
3/16 (4.8 mm)				990-1550	640-700
1/4 (6.4 mm)		1620-2620	1620-2620		
5/16 (7.9 mm)				640-700	390-560
3/8 (9.5 mm)		990-1550	990-1550		
7/16 (11.1 mm)	1620-2620			390-560	300
1/2 (12.7 mm)		640-700	640-700		
9/16 (14.3 mm)					
5/8 (15.9 mm)					

ON / OFF SWITCH PANEL (FIG. W)

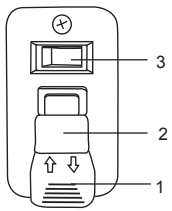
The “ON / OFF” switch has a removable safety key. With the key removed from the switch, unauthorized and hazardous use by children and others is minimized.

1. To turn the drill press “ON,” insert the key (2) into the slot of the switch (1), and move the switch upward to the “ON” position.
2. To turn the drill press “OFF,” move the switch (1) downward.
3. To lock the switch in the OFF position, grasp the sides of the safety key (2), and pull it out.
4. With the safety key removed, the switch will not operate to power the drill press on.
5. If the safety key is removed while the drill press is running, it can be turned “OFF” but cannot be restarted without inserting the safety key.
6. To turn the laser “ON,” press the rocker switch (3) to the on position.
7. Never leave the drill press unattended. Turn the laser switch and power switch “OFF” and wait until it comes to a complete stop, and remove the safety key to prevent unauthorized starts.

⚠ WARNING

ALWAYS lock the switch “OFF” when the drill press is not in use. Remove the key and keep it in a safe place. In the event of a power failure, blown fuse, or tripped circuit breaker, turn the switch “OFF” and remove the key, preventing an accidental startup when power comes on.

Fig. W



INSTALLING A DRILL BIT IN THE CHUCK (FIG. X)

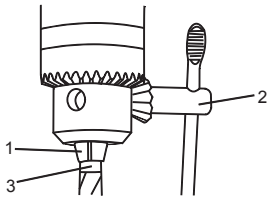
1. With the switch "OFF" and the safety key removed, open the chuck jaws (1) using the chuck key (2). Turn the chuck key counterclockwise to open the chuck jaws (1).
2. Insert the drill bit (3) into the chuck far enough to obtain maximum gripping by the jaws, but not far enough to touch the spiral grooves (flutes) of the drill bit when the jaws are tightened.
3. Make sure that the drill is centered in the chuck.
4. Turn the chuck key (2) clockwise to tighten the jaws (1).

⚠ WARNING

To avoid injury or accident by the chuck key ejecting forcibly from the chuck when the power is turned "ON," use only the self-ejecting chuck key supplied with this drill press. ALWAYS recheck and remove the chuck key before turning the power "ON."

NOTE: To prevent the workpiece or backup material from being torn from your hands while drilling, you MUST position the workpiece against the LEFT side of the column. If the workpiece or the backup material is not long enough to reach the column, clamp them to the table. Failure to secure the workpiece could result in personal injury.

Fig. X



DRILLING TO A SPECIFIC DEPTH (FIG. Y)

Drilling a blind hole (not all the way through workpiece) to a given depth can be done two ways:

Workpiece method

1. Mark the depth of the hole (1) on the side of the workpiece.
2. Turn the switch to "OFF," bring the drill bit down until the tip is even with the mark.
3. Hold the feed handle (2) at this position.
4. Depress the spring-loaded button (3) and move the stop nut (4) until the bottom of the nut contacts the stop (5).
5. Connect the machine to the power source and drill a test hole to check the adjustment. The drill bit will now stop after traveling the distance marked on the workpiece.

   NOTE: Readjust, if necessary, by rotating the stop nut (4) for fine adjustment. You do not have to depress the button (3) to rotate the stop nut (4).

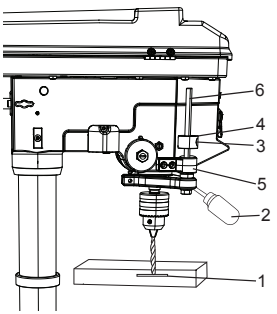
Depth scale method

NOTE: With the chuck quill assembly fully retracted the tip of the drill bit, the drill bit must be just slightly above the top of the workpiece.

1. Turn the switch to "OFF," rotate the feed handle (2) until stop (5) points to the desired depth on the depth scale (6) and hold the feed handle (2) in that position.
2. Depress the spring-loaded button (3) and move the stop nut (4) until the bottom of the nut contacts the stop (5).
3. Connect the machine to the power source and drill a test hole to check the adjustment. The drill bit will stop after traveling the distance selected on THE DEPTH SCALE.

   NOTE: Readjust, if necessary, by rotating the stop nut (4) for fine adjustment. You do not have to depress the button (3) to rotate the stop nut (4).

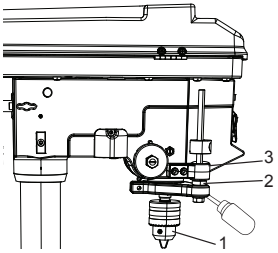
Fig. Y



LOCKING THE CHUCK AT THE DESIRED DEPTH (FIG. Z)

1. Turn the switch to “OFF,” turn the feed handles until the chuck (1) is at the desired depth. Hold the feed handles at this position.
2. Turn the stop nut (2), located under the stop (3), counterclockwise and upwards, until it is against the stop (3).
3. The chuck will now be held at this position when the feed handles are released.

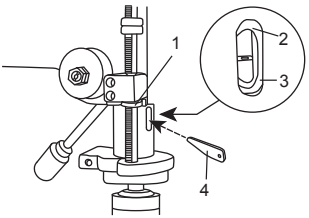
Fig. Z



REMOVING CHUCK AND ARBOR (FIG. AA)

1. With the switch “OFF” and the unit unplugged, adjust the depth stop nut (1) to hold the drill at a depth of 3 in. (7.6 cm). (See instructions for “LOCKING CHUCK AT DESIRED DEPTH”).
2. Align the key holes in the spindle (2) and quill (3) by rotating the chuck by hand.
3. **Bag “D” -** Insert the key wedge (4) into the key holes (2 & 3).
4. Tap the key wedge (4) lightly with a plastic tipped hammer, until the chuck and arbor fall out of the spindle.
   NOTE: Place one hand below the chuck to catch it when it falls out.

Fig. AA



BASIC OPERATION INSTRUCTIONS

To get the best results and minimize the likelihood of personal injury, follow these instructions for operating your drill press.

⚠ WARNING

For your own safety, always observe the SAFETY INSTRUCTIONS listed on pages 4, 5, 6, 7, 8 and 9 of this instruction manual when operating the drill press.

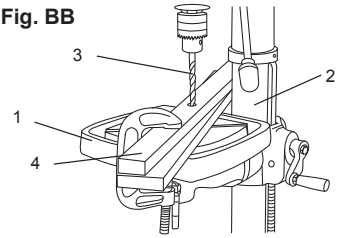
POSITIONING THE TABLE AND WORKPIECE (FIG. BB, CC)

1. Lock the table (1) to the column (2) at a position so the tip of the drill bit (3) is just above the top of the workpiece (4).
2. ALWAYS place BACK-UP MATERIAL (scrap wood) on the table beneath the workpiece. This will prevent splintering or heavy burring on the underside of the workpiece. To keep the back-up material from spinning out of control, it MUST contact the LEFT side of the column.

⚠ WARNING

To prevent the workpiece or back-up material from being thrown while drilling, you MUST position the workpiece against the LEFT side of the column. If the workpiece or the back-up material is not long enough to reach the column, clamp them to the table, or use the fence provided with the drill press to brace the workpiece. Failure to secure the workpiece could result in personal injury.

Fig. BB

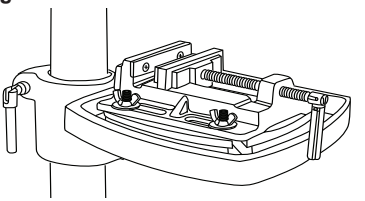


3. For small pieces that cannot be clamped to the table, use a drill press vise (optional accessory).

⚠ WARNING

When using a drill press vise, it MUST be clamped or bolted to the table to avoid injury from a spinning workpiece, or damaged vise or bit parts.

Fig. CC



TILTING THE TABLE (FIG. DD)

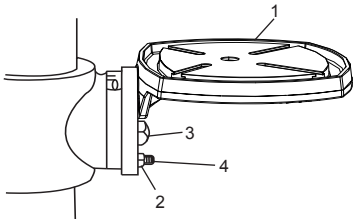
NOTE: The table (1) has a threaded hole with a locking set screw inserted for locking the table into a predetermined 0° horizontal position.

1. Turn the nut (2) on the locking pin (4) clockwise with an adjustable wrench to RELEASE the locking pin (4) and pull it out from the table (1).
2. LOOSEN the large hex head table bevel locking bolt (3) and move table to desired position then re-tighten.

⚠ WARNING

To prevent injury, be sure to hold the table and table bracket, so it will not swivel or tilt.

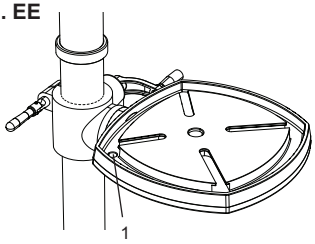
Fig. DD



METAL DRILLING (FIG. EE)

When metal drilling, always use a proper vise or a clamp to secure the metal workpiece and use metal drilling lubricant. The table has a drain hole (1) and use a plug (PT3/8"-19) to gather the drilling lubricant. When the drilling lubricant is full or the drilling is completed, remove the plug to drain the drilling lubricant out and clean up the dust through the drain hole (1).

Fig. EE



MAINTENANCE

⚠ WARNING

For your own safety, turn the switch off and remove the plug from the power source outlet before maintaining or lubricating your drill press.

GENERAL MAINTENANCE

Frequently blow out dust and grit that accumulates in the motor housing using compressed air.

⚠ WARNING

ALWAYS use safety glasses. Everyday eyeglasses are NOT safety glasses. Also use face or dust mask if cutting operation is dusty. ALWAYS WEAR CERTIFIED SAFETY EQUIPMENT:

- ANSI Z87.1 eye protection (CAN/CSA Z94.3),
- ANSI S12.6 (S3.19) hearing protection,
- NIOSH/OSHA/MSHA respiratory protection.

A coat of automotive paste wax applied to the table and column will help to keep the surface clean.

⚠ WARNING

To avoid shock or fire hazard, if the power lead is worn or cut in any way, replace it immediately.

LUBRICATION

Ball bearings in the drill press are packed with grease at the factory and require no further lubrication.

Use only mild soap and a damp cloth to clean the tool. Never let any liquid get inside the tool; never immerse any part of the tool into a liquid. **IMPORTANT:** To assure product SAFETY and RELIABILITY, repairs, maintenance and adjustment (other than those listed in this manual) should be performed by authorized service centers or other qualified service organizations, always using identical replacement parts.

To clean cast iron parts of rust, you will need the following materials (not supplied): scouring pad, spray lubricant, can of degreaser. Apply the spray lubricant and polish with surface with the scouring pad. Degrease the surface, then apply a protective product such as an automotive paste wax.

ACCESSORIES AND ATTACHMENTS

AVAILABLE ACCESSORIES

⚠ WARNING

Since accessories, other than those offered by Porter-Cable, have not been tested with this product, use of such accessories with this tool could be hazardous. To reduce the risk of injury, only Porter-Cable recommended accessories should be used with this product.

A complete line of accessories is available from your Porter-Cable Factory Service Center or a Porter-Cable Authorized Warranty Service Center. Please visit our Website www.portercable.com for a catalog or for the name of your nearest supplier.

⚠ WARNING

Do not use any accessory unless you have completely read the Instruction Manual for that accessory.

TROUBLESHOOTING GUIDE

⚠ WARNING

To avoid injury from an accidental start, turn the switch OFF and always remove the plug from the power source before making any adjustments.

REPLACEMENT PARTS

Use only identical replacement parts. For a parts list or to order parts, visit our service website at www.portercable.com. You can also order parts from your nearest Porter-Cable Factory Service Center or Porter-Cable Authorized Warranty Service Center. Or, you can call our Customer Care Center at (888) 609-9779.

SERVICE AND REPAIRS

All quality tools will eventually require servicing and/or replacement of parts. For information about Porter-Cable, its factory service centers or authorized warranty service centers, visit our website at www.portercable.com or call our Customer Care Center at (888) 609-9779. All repairs made by our service centers are fully guaranteed against defective material and workmanship. We cannot guarantee repairs made or attempted by others. You can also write to us for information at Power Tool Specialists, Inc. 684 Huey Road, Rock Hill, SC 29730, (888) 609-9779 - Attention: Product Service. Be sure to include all of the information shown on the nameplate of your tool (model number, type, serial number, etc.).

GENERAL

Troubleshooting Chart

Symptom(s)	Possible Cause(s)	Corrective Action(s)
Noisy operation	1. Incorrect belt tension. 2. Dry spindle. 3. Loose spindle pulley. 4. Loose motor pulley.	1. Adjust tension. See section “Assembly - Belt Tension”. 2. Lubricate spindle. 3. Check tightness of retaining nut on pulley, and tighten if necessary. 4. Tighten set screw in motor pulley.
Drill bit burns	1. Incorrect speed. 2. Chips not coming out of hole. 3. Dull drill bit. 4. Feeding too slowly. 5. Not lubricated.	1. Change speed. See Section “ Operation - Speeds and Belt Placement Table”. 2. Retract drill frequently to clear chips. 3. Resharpen drill bit. 4. Feed fast enough – allow drill to cut. 5. Lubricate drill.
Run out of drill bit point/ drilled hole not round.	1. Grain in wood or lengths of cutting flutes and/or angles not equal. 2. Bent drill bit.	1. Resharpen drill bit correctly. 2. Replace drill bit.
Wood splinters on underside.	1. No backup material under workpiece.	1. Use backup material. See Section “BASIC DRILL PRESS OPERATION”.
Workpiece torn loose from hand.	1. Not supported or clamped properly.	1. Support workpiece or clamp it. See Section “BASIC DRILL PRESS OPERATION”.
Drill bit binds in workpiece.	1. Workpiece pinching drill bit, or excessive feed pressure. 2. Improper belt tension.	1. Support workpiece or clamp it. See Section “BASIC DRILL PRESS OPERATION”. 2. Adjust tension. See Section “Assembly - Belt Tension”.
Excessive drill bit runout or wobble.	1. Bent drill bit. 2. Worn bearings. 3. Drill bit not properly installed in chuck. 4. Chuck not properly installed.	1. Replace drill bit. 2. Replace bearings. 3. Install drill properly. See Section “BASIC DRILL PRESS OPERATION” and “ASSEMBLY”. 4. Install chuck properly. See Section “ASSEMBLY INSTALLING THE CHUCK”.
Quill returns too slow or too fast.	1. Coil spring has improper tension.	1. Adjust spring tension. See Section “ASSEMBLY ADJUSTMENTS QUILL/RETURN SPRING”.
Chuck will not stay attached to spindle. It falls off when trying to install.	1. Dirt, grease, or oil on the tapered inside surface of chuck or on the spindle’s tapered surface.	1. Using a non-alcohol based cleaner, clean the tapered surface of the chuck and spindle to remove all dirt, grease and oil. See Section “ASSEMBLY INSTALLING THE CHUCK”.

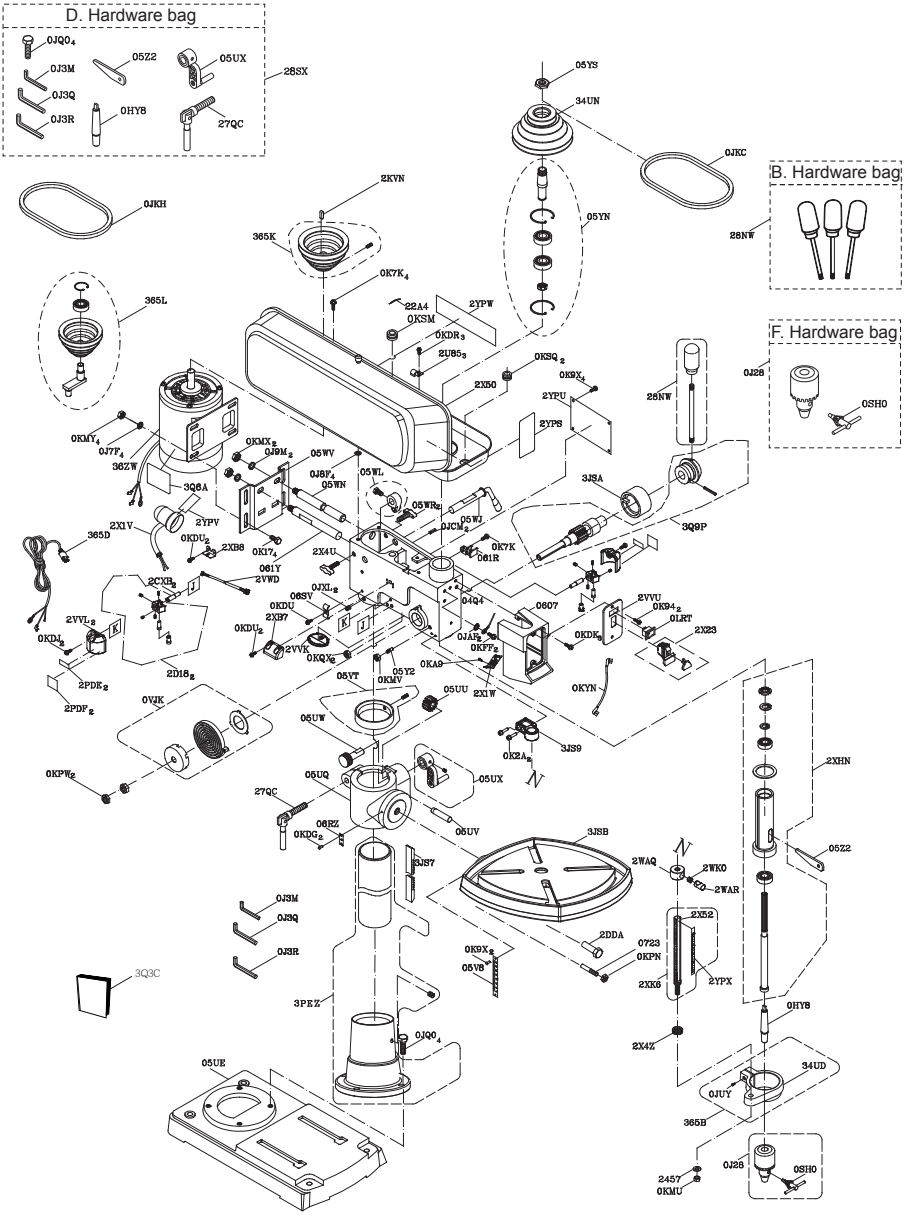
For assistance with your product, visit our website at www.portercable.com for a list of service centers, or call the Porter-Cable Customer Care Center at (888) 609-9779.

PARTS LIST

15 IN. (381 MM) DRILL PRESS PARTS LIST

I.D. No.	Description	Size	Q'ty
04Q4	STICKER		1
05UE	BASE		1
05UQ	TABLE BRACKET		1
05UU	GEAR		1
05UV	GEAR SHAFT		1
05UW	WORM		1
05UX	CRANK HANDLE ASS'Y		1
05V8	TILTING SCALE		1
05VT	RACK RING ASS'Y		1
05WJ	HANDLE SHIFTER		1
05WL	MOTOR BAR SHIFTER ASS'Y		1
05WN	MOTOR ROD		1
05WR	SHIFTER BOLT	M10*1.5-33	2
05WV	MOTOR BASE		1
05Y2	QUILL SET SCREW	M10*1.5-2A	1
05YN	DRIVING SLEEVE ASS'Y		1
05YS	PULLEY SET NUT	φ22.5	1
05Z2	WEDGE SHIFTER		1
0607	SWITCH BOX		1
061R	CHUCK KEY HOLDER		1
061Y	MOTOR ROD		1
06RZ	CENTERING SCALE		1
06SV	CORD CLAMP		1
0723	LOCATION PIN		1
0HY8	DRILLING ARBOR	MT2*JT3	1
0J28	CHUCK & KEY		1
0J3M	HEX. WRENCH		1
0J3Q	HEX. WRENCH		1
0J3R	HEX. WRENCH		1
0J7F	FLAT WASHER	5/16*7/8-5/64	4
0J8F	FLAT WASHER	φ8.5*22-3	4
0J9M	SPRING WASHER	φ1/2"	2
0JAF	EXTERNAL TOOTH LOCK WASHER	φ5	2
0JCM	SPRING PIN		2
0JKC	FRONT V-BELT	M-24	1
0JKH	REAR V-BELT	M-26	1
0JQ0	HEX. HD. BOLT	M10*1.5-40	4
0JUY	HEX. SOC. HD. CAP BOLT	M8*1.25-35	1
0JXL	HEX. SOC. SET SCREW	M10*1.5-12	2
0K17	HEX. HD. SCREW AND WASHER	M8*1.25-20	4
0K2A	HEX. SOC. HD. CAP SCREW	M6*1.0-25	2
0K7K	CR. RE. ROUND WASHER HD. SCREW	M6*1.0-12	5
0K94	CR. RE. TRUSS HD. TAPPING SCREW	M5*12-16	2
0K9X	DRIVE SCREW	φ2.3-5	6
0KA9	CR. RE. PAN HD. TAPPING SCREW	M3*24-10	1
0KDG	CR. RE. PAN HD. SCREW	M5*0.8-6	2
0KDJ	CR. RE. PAN HD. SCREW	M5*0.8-12	2
0KDK	CR. RE. PAN HD. SCREW	M5*0.8-16	3
0KDR	CR. RE. PAN HD. SCREW	M5*0.8-10	3
0KDU	CR. RE. PAN HD. SCREW	M6*1.0-12	5
0KFF	CR. RE. PAN HD. SCREW	M5*0.8-8	2
0KMU	HEX. NUT	M10*1.5 T=8	1
0KMV	HEX. NUT	M10*1.5 T=8	1
0KMX	HEX. NUT	M12*1.75 T=10	2
0KMY	HEX. NUT	M8*1.25 T=6.5	4
0KPN	HEX. NUT	1/4*20UNC T=4.7	1
0KPW	HEX. NUT	1/2*20UNF T=8	2
0KQX	NUT	M6*1.0 T=6	2
0KSM	STRAIN RELIEF		1
0KSQ	STRAIN RELIEF		2
0KYN	LEAD WIRE ASS'Y		1
0LRT	ROCKER SWITCH		1
0SH0	CHUCK KEY		1
0VJK	PLATE SPRING ASS'Y		1
22A4	LOCKING CABLE TIE		1
2457	FLAT WASHER	φ10*22-2	1
27QC	COLUMN LOCK HANDLE	M12*1.75-35	1
28NW	HANDLE BAR ASS'Y		1
28SX	HARDWARE BAG ASS'Y		1
2CXB	SET BOLT		2
2D18	LASER ASS'Y		2
2DDA	HEX. HD. BOLT	5/8-11UNC-2 3/8	1
2KVN	PARALLEL KEY		1
2PDE	LASER WARNING LABEL		2
2PDF	LASER WARNING LABEL		2
2U85	CORD CLAMP		3
2VVK	PLATE COVER		1
2VVL	COVER		2
2VVU	SWITCH COVER		1
2VWD	LEAD WIRE ASS'Y		1
2WAQ	LOCKING RING		1
2WAR	ADJUSTING NUT		1
2WK0	COMPRESSION SPRING		1
2X1V	LAMP		1
2X1W	CONTROLLER ASS'Y		1
2X23	ROCKER SWITCH		1
2X4U	HEAD		1
2X4Z	NUT		1
2X50	PULLEY COVER ASS'Y		1
2X52	SET BOLT		1
2XB7	POWER CABLE		1
2XB8	LAMP SET		1
2XHN	SPINDLE ASS'Y		1
2XK6	SET BOLT ASS'Y		1
2YPS	TRADEMARK LABEL		1
2YPU	WARNING LABEL		1
2YPV	WARNING LABEL		1
2YPW	SPEED DIAGRAM		1
2YPX	SCALE		1
34UD	SET RING		1
34UN	SPINDLE PULLEY		1
365B	SET RING ASS'Y		1
365D	POWER CABLE		1
365K	MOTOR PULLEY ASS'Y		1
365L	CENTER PULLEY ASS'Y		1
36ZW	MOTOR ASS'Y		1
3JS7	RACK		1
3JS9	PLUNGER HOUSING		1
3JSA	SCALE RING		1
3JSB	TABLE		1
3PEZ	COLUNM ASS'Y		1
3Q3C	INSTRUCTION MANUAL		1
3Q6A	LABEL		1
3Q9P	FEED SHAFT ASS'Y		1
	HARDWARE BAG		
0J28	CHUCK & KEY		1
28NW	HANDLE BAR ASS'Y		1
28SX	HARDWARE BAG ASS'Y		1

15 IN. (381 MM) DRILL PRESS SCHEMATIC



WARRANTY

THREE YEAR LIMITED WARRANTY

PORTER-CABLE will repair, without charge, any defects due to faulty materials or workmanship for three years from the date of purchase. This warranty does not cover part failure due to normal wear or tool abuse. For further detail of warranty coverage and warranty repair information, visit www.portercable.com or call (888) 609-9779. This warranty does not apply to accessories or damage caused where repairs have been made or attempted by others. This warranty gives you specific legal rights and you may have other rights which vary in certain states or provinces.

In addition to the warranty, PORTER-CABLE tools are covered by our:

1 YEAR FREE SERVICE: PORTER-CABLE will maintain the tool and replace worn parts caused by normal use, for free, any time during the first year after purchase.

90 DAYS MONEY BACK GUARANTEE: If you are not completely satisfied with the performance of your PORTER-CABLE Power Tool for any reason, you can return it within 90 days from the date of purchase with a receipt for a full refund – no questions asked.

LATIN AMERICA: This warranty does not apply to products sold in Latin America. For products sold in Latin America, see country specific warranty information contained in the packaging, call the local company or see website for warranty information.

To register your tool for warranty service visit our website at www.portercable.com.

WARNING LABEL REPLACEMENT
If your warning labels become illegible or are missing, call (888) 609-9779 for a free replacement.

PORTER CABLE.

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