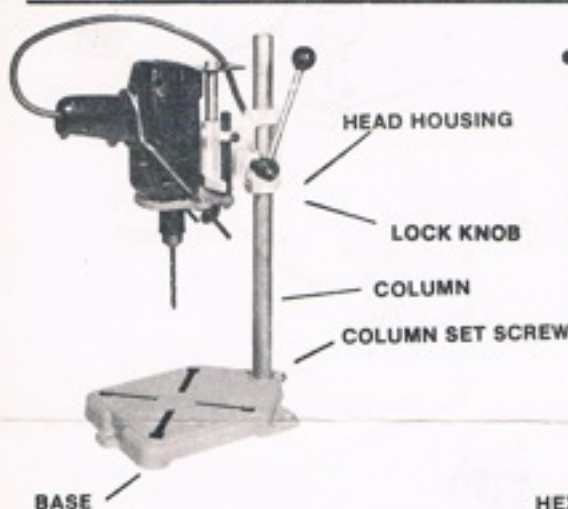


DRILL PRESS STAND

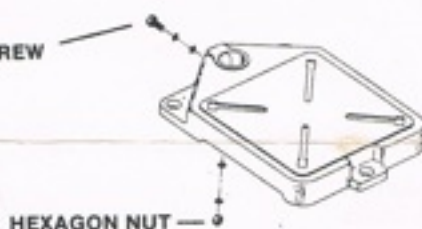
FOR 1/4" AND 3/8" ELECTRIC DRILLS

Model 25921
25926

• Assembly



Place 3/8-16 hexagon nut in nut well at rear of column hole and thread column set screw thru hole in rear of base and thru hex nut. Insert column into base and tighten column set screw. Slip head housing over column and tighten head lock arm.



• Safety Rules

Secure your Drill Press Stand solid to bench before using. Fasten work to table and use goggles when drilling. Follow Safety Rules of your drill manufacturer when using this attachment.

OPERATING INSTRUCTIONS

2. Lock a drill bit in your electric drill chuck. (For aligning drill straight to column.)

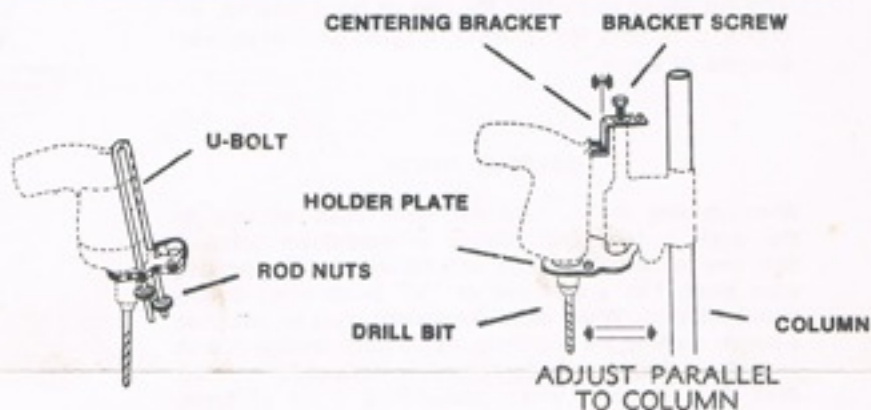
3. Insert drill chuck thru holder plate and hold drill body against centering bracket. Loosen bracket screw and slide centering bracket until drill bit is parallel to column, retighten bracket screw.

4. Place the U-Bolt over the drill body and insert the U-Bolt legs thru the side holes in the holder plate. Place the U-Bolt at the BEST position on the drill. This bolt will locate at different places on different styles of drills.

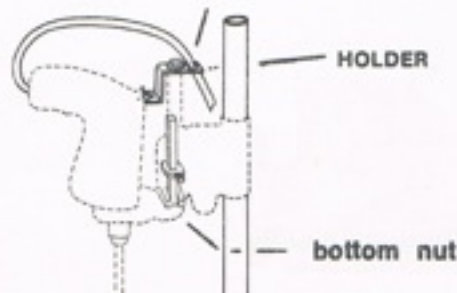
5. Thread the rod nuts on the U-Bolt with even tension to hold the drill securely in place. The drill can be drawn straight by tightening the rod nuts properly. U-Bolt may be too long for some model drills, cut length to suit.

6. Place the drill cord in the holder. (This keeps cord away from the drill bit.)

7. To eliminate side play in holder plate loosen bottom nut on depth shaft. Turn depth shaft slightly and retighten nut.



U-BOLT over handle OR U-BOLT INVERTED for some models of drills



TO ELIMINATE SIDE PLAY IN HOLDER PLATE LOOSEN BOTTOM NUT ON DEPTH SHAFT. TURN DEPTH SHAFT SLIGHTLY AND RETIGHTEN NUT.

8. With your electric drill lined up, drill a **work hole** thru the base. This hole will not always be in the center of the base depending on the model of drill.

Step 9 for Model 25926 only.

9. **INDEXING HEAD** — Remove head from column. Then remove **lock knob** and nut. Screw lock knob into **index boss**. Slip over column to desired height and tighten knob. Adjust safety guard for wire brushing, buffing and polishing.

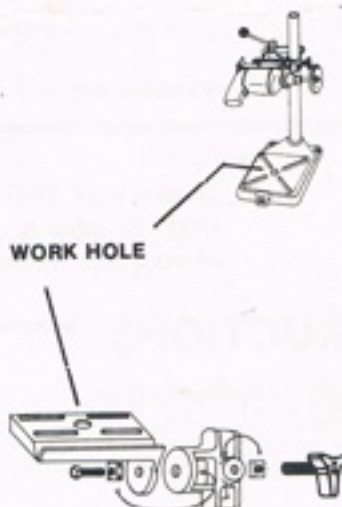
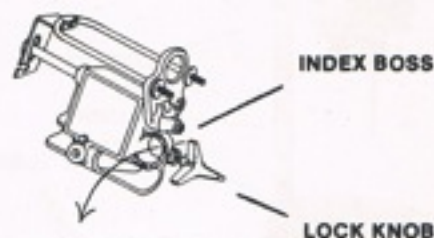
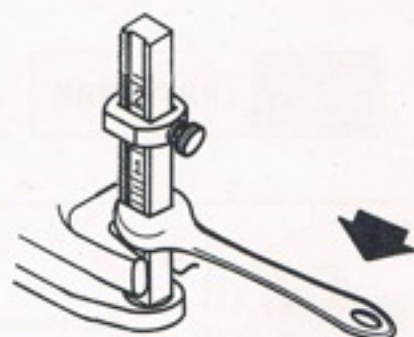
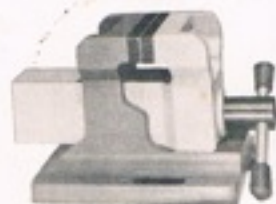
USING TILT TABLE — Adjust **tilt table** to horizontal position. With your electric drill lined up, drill **work hole** thru the table. (Accurately aligns work hole to your drill.)

The tilt table is slotted for use of hold downs. V-Block provided for rounds, angles and irregular shapes of work.

HELPFUL HINTS

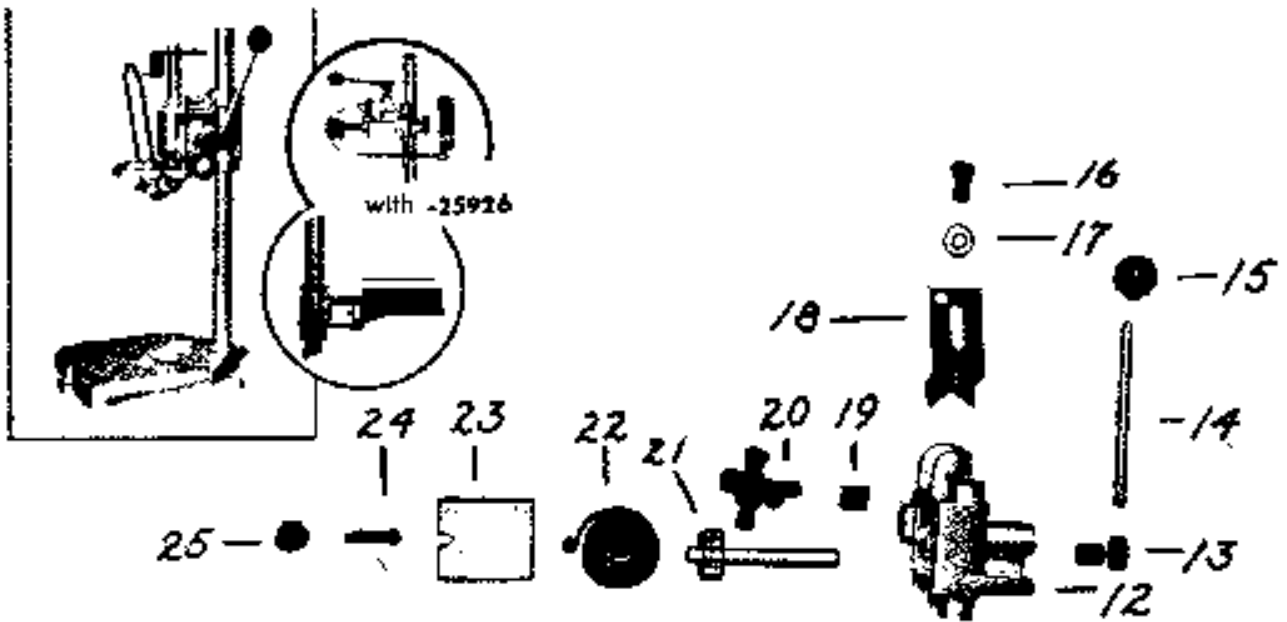
When drilling metal, hold the work piece securely to the work surface with clamps or hold-down bolts. A drill vise is an inexpensive and handy tool for holding your work. Use a drill vise or "V" block when drilling round material. When close dimensions must be held, use a punch mark to aid in drilling. Avoid force feeding to such an extent that the motor speed is noticeably reduced. Also, feed carefully when approaching point of break-through, especially in soft metals and woods. This will avoid making break-through edges ragged or breaking the drill bit. Use properly sharpened drill bits: off-center bits will tend to impart a side wobble to the spindle which will drill an oversized hole and put undue strain on bearings.

10. Sears lists a low cost drill vise for use with the Drill Stands. **Model 2597 VISE** has a 2" wide jaw



TILT TABLE





- 1 Base table Parts #: 4001
- 2 Set screw Parts #: 4002
- 3 Column Parts #: 4003
- 4 Hex nut Parts #: 4015
- 5 Holder plate Parts #: 4016
- 6 Wing nut Parts #: 4018
- 7 Hex nut, Parts #: 4020
- 8 Depth shaft Parts #: 4019
- 9 Draw rod Parts #: 4017
- 9B Draw rod Parts #: 4029
- 10 Lock nut Parts #: 4021
- 11 Drill rack Parts #: 4014
- 12 Head housing Parts #: 4007
- 13 Pinion collar Parts #: 4009
- 14 Shaft handle Parts #: 4010
- 15 Handle knob Parts #: 4011
- 16 Bracket screw Parts #: 4024
- 18 Bracket Parts #: 4022
- 19 Lock arm nut Parts #: 4005
- 20 Head lock arm Parts #: 4004
- 21 Pinion gear Parts #: 4008
- 22 Pinion spring Parts #: 4012
- 23 Spring cover Parts #: 4025
- 24 Lock screw Parts #: 4013
- 25 Acorn nut Parts #: 4023
- 28 Tilt housing Parts #: 4037
- 29 Tilt table Parts #: 4036
- 30 Table screw Parts #: 4038
- 31 Lock screw Parts #: 4504
- 32 Guard shaft Parts #: 4506
- 33 Guard Parts #: 4505
- Not Clip Parts #: 40-29-1

