OPERATING INSTRUCTIONS AND PARTS LIST FOR DRILL PRESS

MODEL 2532

ASSEMBLY: For safety in shipment the head and base assembly of this machine are unassembled. Procedure to assemble is as follows:

1. Using 4 bolts or screws attach base casting (53) to your workbench.
2. Slip large coil spring (48) over vertical column tube 22" long (49) and then slide tube into hole in base casting (53). Lock securely with 2 bolts furnished (26) - NOTE Spring will extend above vertical column. It must be compressed when attaching horizontal drill assembly.
3. Check to see that locking wedge (47) is in proper position in recess of two-way clamp (44). NOTE: See exploded view on page 2. Slide horizontal tube (18" long, #45) into two-way clamp (44).
4. Slide motor mount (46) onto horizontal tube (45). Lock securely with two bolts furnished.
5. Slide headstock (30) onto horizontal tube (45). Lock securely with two bolts furnished (26).
6. Check to see that locking wedge (47) is in proper position, then slide complete head assembly onto vertical column (49) as shown on page 2.
7. Lock head assembly securely on column by tightening 2 handles furnished (43).
8. Attach gear chuck (2) to spindle by simply tightening it against spindle shoulder. Thread is right hand.
9. Belt Guard (21) is placed on headstock (30) by slipping guard under front lug and on top of side lugs. Place two carriage bolts (24) in square holes in guard. Lock securely with guard nuts (26). These nuts can be adjusted to square the guard.

MOTOR MOUNT: Motor mount furnished (46) is designed for all standard 1/4 or 1/3 HP, 1725 RPM base mounted motors. Attach motor to motor mount bracket (46) using (2) 1/2" carriage bolts (50), nuts (51), and washers (52) furnished. For most motors, mounting should be in center of elongated slot in motor mount bracket (46).

BELT AND PULLEY: The machine is designed to take a standard "V" belt. Gates #2580 or equivalent. Motor pulley should be a 3 step to match head stock pulley (19). This will give a wide range of possible speeds. Belt tension can be controlled by loosening 2 screws (26) holding motor mount brackets (46) on tube (45), and then moving motor mount bracket (46) in or out. Belt should be run slightly loose for best drive and minimum bearing wear. NOTE: When drill press is running at lowest speed with the complete head assembly lowered down the column the belt may rub the vertical column (49). This will not damage the belt or the machine.

LUBRICATION: All moving parts should be oiled both to prevent rust and to ease the sliding actions. The spindle bearings (3, 18) can all be oiled by applying a few drops of oil down through the pulley keyway. Use light machine oil, approximately SAE 20.

SPEEDS: The speed to use the various jobs will depend upon the material being drilled and the size of the drill. Normally it is recommended that a slower speed be used for larger drills or harder material.

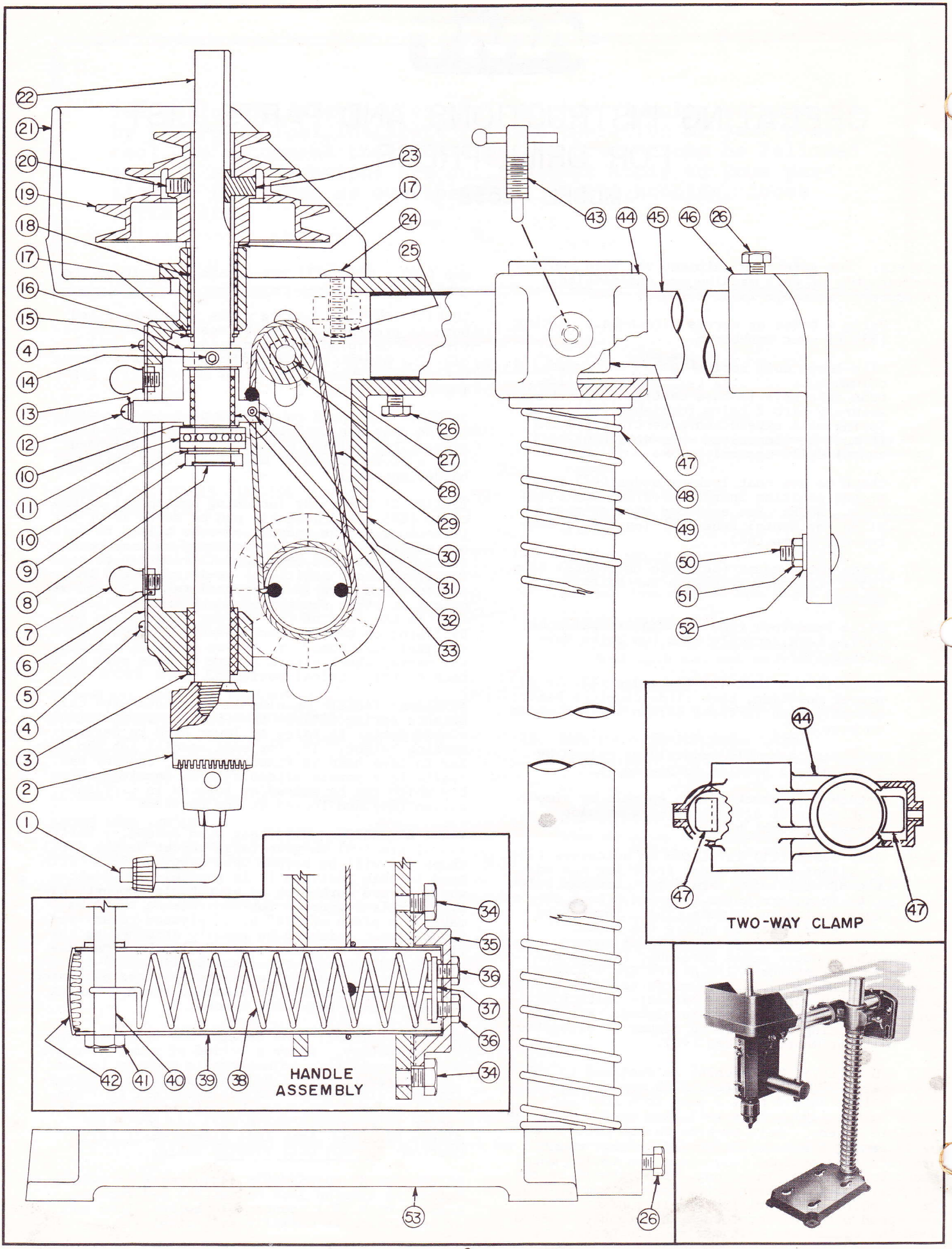
TILTING OF HEAD: By loosening horizontal column clamp (44), head assembly can be moved in or out to various depths and can also be tilted to various angles. It will be necessary on many occasions to make sure that head is returned to perfectly vertical position. It is suggested that you scribe a mark in horizontal tube (45) and with chisel or other sharp instrument make an index mark in the face of the two-way slide clamp (44). By lining up the two marks head will return to vertical position. Or, if you have not scribed the marks, check with a square to make sure it is back to the vertical position.

AUXILIARY TABLE: Machine is furnished with coil balance spring (48) so that it is a comparatively simple matter to raise or lower head to desired working height. If, for some special job you prefer to have head in fixed position, company has available separate slidable table casting assembly which can be raised or lowered in vertical column (49) and locked at any position.

TABLE EXTENSION: Note that when extending horizontal arm (45) to give large throat depth, drill chuck (2) will be beyond base casting (53). With head in this position it is possible, on light work, to use workbench as your table support; however, it is suggested for convenience that you make up a piece of 3/4" or 1" plywood to any size you desire. This can be readily attached to the finished base with (4) - 5/16" flat head machine screws and square nuts. Base casting (53) has keyed lugs on under side so that plywood extension can be easily removed or attached without having to remove base from your bench.

CABLE ADJUSTMENT: The machine has been adjusted at the factory. After a period of time the cable may become loose. Adjustment is made by loosening 2 screws(26) that hold headstock (30) on horizontal column (45). Remove headstock (30) and insert screw drive through horizontal column hole. Loosen idler sleeve shaft (27) and pry idler sleeve (28) up. Lock idle sleeve shaft (27). Caution: DO NOT OVER TIGHTEN cable.

RETURN SPRING ADJUSTMENT: Adjustment is made by loosening tension lock bolts (34) and turning tension knob (35) counter clockwise. (One notch of adjustment is normally sufficient.)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TWO-WAY CLAMP
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REF NO.	PART NO.	DESCRIPTION
1	253-40K	Chuck Key (Jacobs)
2	253-40	Chuck (Jacobs)
3	253-17A	Headstock Bushing (7/8 x 5/8 x 1-1/8)
*4	253-35A	Guide Plate Fasteners (8-32 x 1/4 screw)
5	253-35	Guide Plate
*6	253-7	Square Nute (1/4-20)
*7	253-7A	Thumb Screw Stops (1/4-20 x 1/2 shoulder screw)
8	253-23	Spindle Snap Ring
9	253-41	Shroud for Snap Ring
10	253-32A	Ball Thrust Bearing Spacer
11	253-32	Ball Thrust Bearing
*12	253-51A	Depth Pointer Fasteners (10-24 x 1/4 screw)
13	253-51	Depth Pointer
*14	253-22A	Spindle Collar Set Screw (1/4-20 x 3/16)
15	253-22	Spindle Collar
16	253-19	Pulley Adapter Snap Ring
17	253-9A	Pulley Shims
18	253-17B	Headstock Bushing (7/8 x 3/4 x 1-5/8)
19	253-9	Three Step Pulley With Adapter
*20	253-20B	Pulley Set Screw (5/16-18 x 1/4)
21	2532-1A	Belt Guard
22	253-21	Spindle
23	253-20	Pulley Key
*24	2532-1B	Guard Fasteners (1/4-20 x 1 Carriage Bolt)
*25	2532-1C	Guard Nut (1/4-20)
*26	253-27	Headstock Lock (1/4-20 x 3/4 Cap Screw)
*27	253-15	Idler Sleeve Shaft (5/16-18 x 2-1/2 Cap Screw)
28	253-5	Idler Sleeve
29	2532-30	Cable
30	2532-1	Headstock
31	253-4	Cable Bushing
*32	253-6A	Cable Lock Set Screw (10-24 x 1/4)
33	253-4A	Cable Bushing Bearing (7/8 x 5/8 x 7/8)
*34	317-39A	Tension Lock (5/16-18 x 3/4 Washer Base Bolt)
35	317-39	Tension Knob
*36	317-40A	Spring Fasteners (1/4-20 x 1/2 Cap Screw)
37	317-40B	Spring Fastener Nut
38	317-37	Return Spring
39	2532-25	Pull Down Shaft
40	2532-26	Pull Down Handle
*41	2532-26A	Pull Down Handle Nut (3/8-16)
42	317-38A	End Cap
43	253-39B	Lock Handle for Two-Way Clamp (2 Req'd)
44	253-2	Two-Way Clamp
45	253-29	Horizontal Column
46	2531-14	Motor Mount Casting
47	253-24	Tube Clamp "V" Block
48	253-38	Counter Balance Spring
49	253-28	Vertical Column
*50	253-52	Motor Mount Carriage Bolts (1/4-20 x 3/4)
*51	253-52B	Motor Mount Nut (1/4-20)
*52	253-52A	Motor Mount Washer (5/8 O.D. x 1/4 I.D.)
53	253-11	Base

* THESE PARTS ARE STANDARD ITEMS AND CAN BE PURCHASED LOCALLY.

The following safety rules are the general rules recommended by the Power Tool Institute for the operation of your power tool. We recommend that these safety precautions be followed as well as the obvious precautions that apply to your particular tool such as overspeeding, overtightening, loose parts, etc.

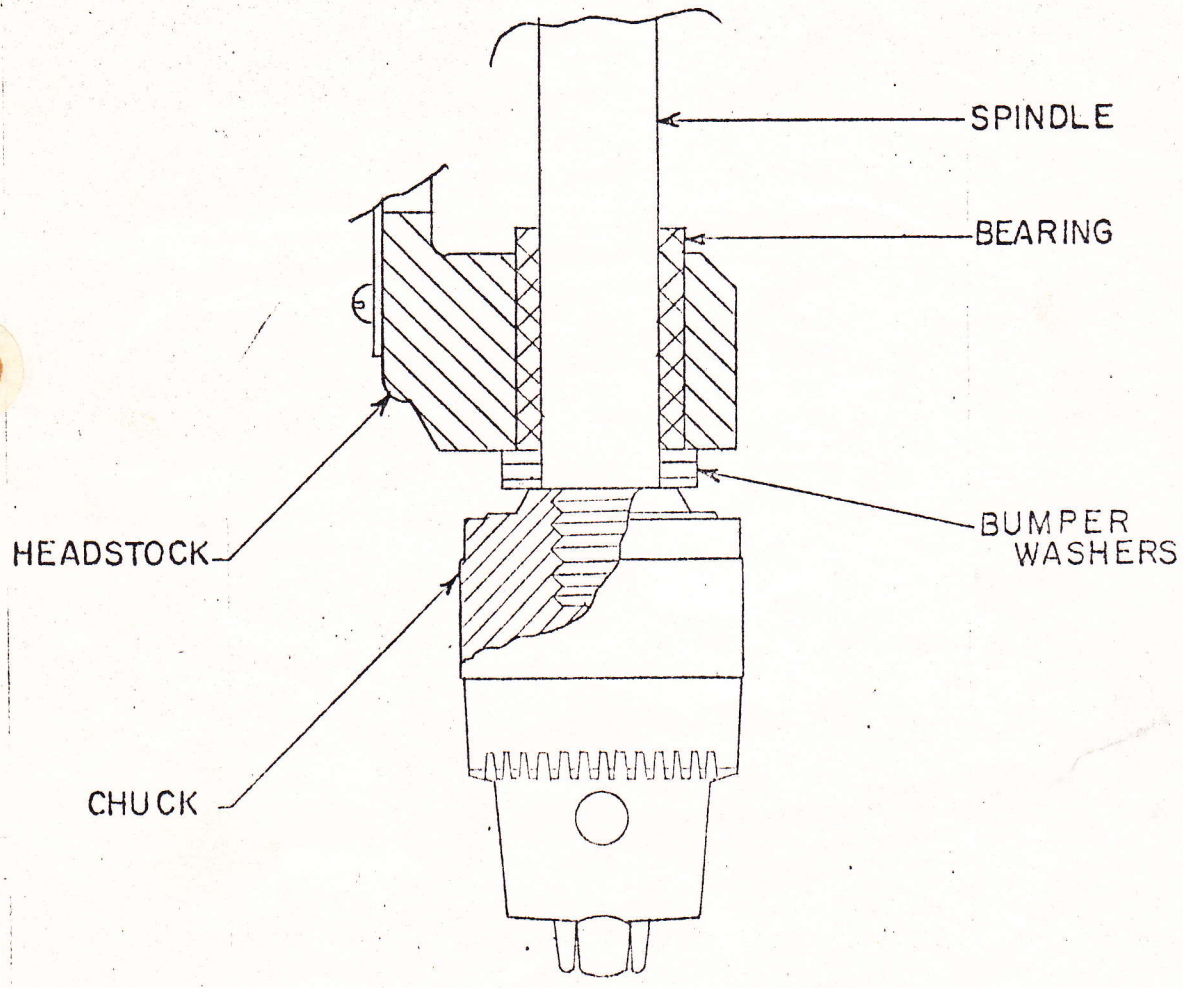
SAFETY RULES FOR POWER TOOLS

1. **KNOW YOUR POWER TOOL**
   Read owner's manual carefully. Learn its applications and limitations as well as the specific potential hazards peculiar to this tool.
2. **GROUND ALL TOOLS — UNLESS DOUBLE-INSULATED**
   If tool is equipped with three-prong plug, it should be plugged into a three-hole electrical receptical. If adapter is used to accommodate two-prong receptacle, the adapter wire must be attached to a known ground. Never remove third prong. Be sure to check that the part of your wall socket that accepts the third prong is grounded.
3. **KEEP GUARDS IN PLACE**
   and in working order.
4. **KEEP WORK AREA CLEAN**
   Cluttered areas and benches invite accidents.
5. **AVOID DANGEROUS ENVIRONMENT**
   Don't use power tool in damp or wet locations, and keep work area well lit.
6. **KEEP CHILDREN AWAY**
   All visitors should be kept safe distance from work area.
7. **STORE IDLE TOOLS**
   When not in use, tools should be stored in dry, high or locked-up place — out of reach of children.
8. **DON'T FORCE TOOL**
   It will do the job better and safer at the rate for which it was designed.
9. **USE RIGHT TOOL**
   Don't force small tool or attachment to do the job of a heavy duty tool.
10. **WEAR PROPER APPAREL**
    No loose clothing or jewelry to get caught in moving parts. Rubber gloves and footwear are recommended when working outdoors.
11. **USE SAFETY GLASSES**
    with most tools. Also face or dust mask if cutting operation is dusty.
12. **DON'T ABUSE CORD**
    Never carry tool by cord or yank it to disconnect from receptacle. Keep cord from heat, oil and sharp edges.
13. **SECURE WORK**
    Use clamps or a vise to hold work. It's safer than usin your hand and it frees both hands to operate tool.
14. **DON'T OVERREACH**
    Keep proper footing and balance at all times.
15. **MAINTAIN TOOLS WITH CARE**
    Keep tools sharp at all times, and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **DISCONNECT TOOLS**
    When not in use, before servicing; when changing accessories such as blades, bits, cutters, etc.
17. **REMOVE ADJUSTING KEYS AND WRENCHES**
    Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
18. **AVOID ACCIDENTAL STARTING**
    Don't carry plugged-in tool with finger on switch.

Wear Your SAFETY GLASSES

The operation of any power tool can result in foreign objects being thrown into the eyes, which can result in severe eye damage. Always wear safety glasses or eye shields before commencing power tool operation. We recommend **Wide Vision Safety Mask** for use over spectacles, or standard safety glasses.

Bumper washers included in the package with your chuck must be placed on the spindle above the chuck before screwing the chuck onto the spindle (see drawing). If these washers are not in place, the spindle will bind and the up-thrust mechanism can receive too much shock when the spindle is allowed to "snap" up.



SHIP VIA	AMT. PAID	RECEIPT NO.	DATE OF INVOICE	WT. OF SHIPMENT	NO. OF PKGS.	CHARGES	TARIFF	TOTAL VALUE
UPS	$ 48.80	772m12/9	12/74	#		$	I.C.C.	$ 48.80

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21655	RF	2731	2433	A359 ARM
21655B	CF	2731B	2433B	58" BELT
21645	RF & BL	FP (214 X 273)	252	29" BELT
21645B	CF & BL	CHI	252/HD	2" PULLEY
271	X PKG	A407	253DP	4" PULLEY
271SD	XE PKG	2141W	A384	3 STEP PULLEY
271SD/MG	A401	1¼HP MOTOR ( )	1HP MOTOR ( )	A386

IMPORTANT: REFER TO THIS NUMBER IF YOU EVER CONTACT FACTORY REGARDING THIS SHIPMENT →

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