

DRILL PRESS HOW TO's

Before you start:

Put your safety glasses on and work safely

Turn the machine off, disconnect the power and mount your bit in the drill chuck. If necessary, adjust the drill press speed for the drill bit type and the diameter of hole you are drilling. (*The larger the bits the slower the speed*) Before you do anything else, review the drill press safety sheet.

Important Note –

Always place scrap blocks under and/or behind your work-piece to protect the table surface or rip fence when through-drilling. These back-up blocks are also a valuable aid in preventing splintering on the exit side of your holes. Be sure to move these scrap blocks slightly after boring each hole so you always have a flat, firm surface to back-up each new hole.

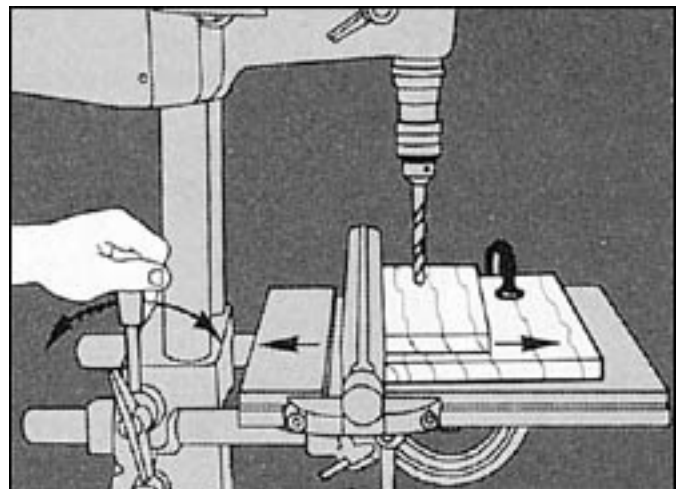
The Basics --

There are basically two types of holes that can be drilled. Through holes and stopped holes.

THROUGH HOLES:

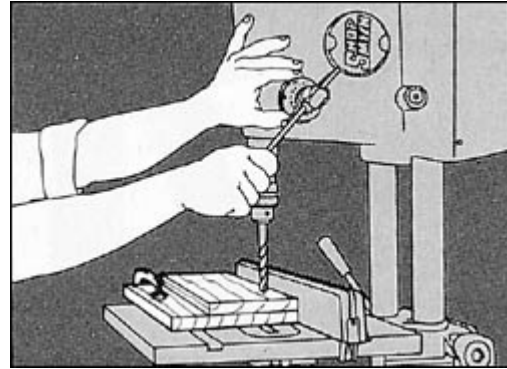
One:

Mount the rip fence and/or miter gauge to your worktable for use as a backstop, as required and adjust it to position your stock (and scrap) for drilling. Clamp your scrap block to the table. Adjust your table height so the bit is 1-2-inch above the surface of the stock when fully retracted.



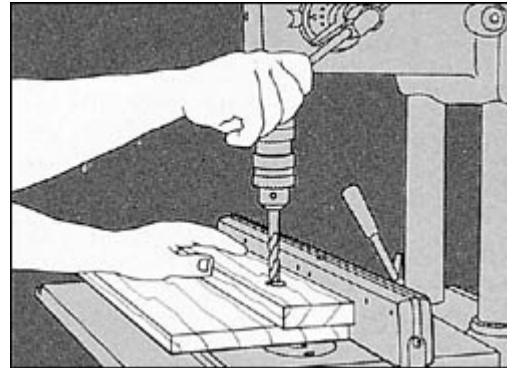
Two:

With the **power off** Extend the quill until the tip of the bit touches the surface of your stock. Now, set the depth control so the bit will pass all the way through your stock and into the scrap. **but NOT all the way through the scrap.** Allow the quill to retract.



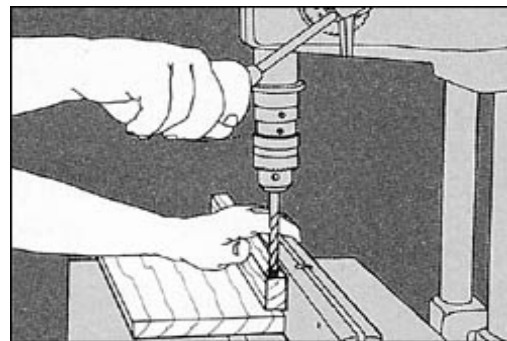
Three:

Turn on the machine and feed the bit into the stock while maintaining a **steady pressure**. Stop when the depth control halts the movement of the quill. Retract the quill and turn off the machine, allowing it to come to a **complete stop** before removing your stock.



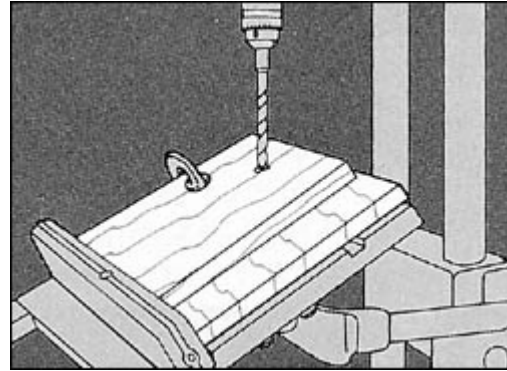
STOP DRILLING:

Follow the procedures for through drilling **except** set the **depth control** to limit the depth of your hole. *All holes will be exactly the same depth until you change the setting.* Although no scrap block is necessary, If you clamp one to the table and use it in conjunction with a fence it will help **keep your stock from sliding.**



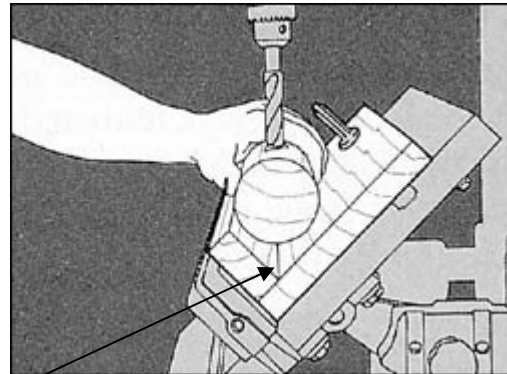
ANGLE DRILLING:

Tilt the worktable to drill any angle you prefer between “0” and 90-degrees and **lock it** into position. Mount your rip fence on **the downside** of the table. If your angle is steep, clamp scrap blocks to the table to protect the surfaces of the table and rip fence.



DRILLING ROUND STOCK:

Mount the rip fence in the **centre** of your worktable and tilt the table to **45 degrees**, forming a V-Block. Clamp scrap blocks to the table to **protect its surface**. Lower the quill and adjust your table to align your bit point with the **intersection** of the table and fence. Insert work-piece and drill.



Intersection

When using the drill press, do not lean too close to your work. Your hair or clothing may be caught in the spindle or the drill.