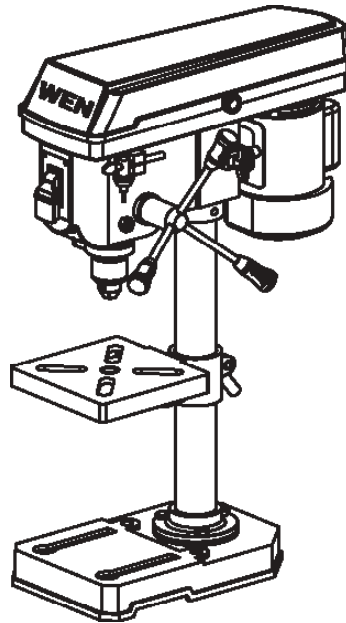




# 8-INCH FIVE-SPEED DRILL PRESS




Model # 4208  
[bit.ly/wenvideo](http://bit.ly/wenvideo)

## IMPORTANT:

Your new tool has been engineered and manufactured to WEN's highest standards for dependability, ease of operation, and operator safety. When properly cared for, this product will supply you years of rugged, trouble-free performance. Pay close attention to the rules for safe operation, warnings, and cautions. If you use your tool properly and for intended purpose, you will enjoy years of safe, reliable service.

## NEED HELP? CONTACT US!

Have product questions? Need technical support?  
Please feel free to contact us at:

 **800-232-1195** (M-F 8AM-5PM CST)

 **techsupport@wenproducts.com**

 **WENPRODUCTS.COM**



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## TECHNICAL DATA

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Model:	4208
Motor:	120V, 60 Hz, 2.3A, 1/3 HP
Chuck Capacity:	1/2 inch
Spindle Stroke:	2 inches
Spindle Taper:	JT33
Speeds:	740, 1100, 1530, 2100, 3140 RPM
Swing:	8 inches
Table Size:	6-1/2 x 6-1/2 inches
Base Size:	11 x 7 inches
Total Height:	23-1/8 inches
Weight:	34.2 lbs.

## GENERAL SAFETY RULES

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Safety is a combination of common sense, staying alert and knowing how your item works. **SAVE THESE SAFETY INSTRUCTIONS.**



**WARNING:** To avoid mistakes and serious injury, do not plug in your tool until the following steps have been read and understood.

1. **READ** and become familiar with this entire instruction manual. **LEARN** the tool's applications, limitations, and possible hazards.
2. **AVOID DANGEROUS CONDITIONS.** Do not use power tools in wet/damp areas or expose them to rain. Keep work areas well lit.
3. **DO NOT** use power tools in the presence of flammable liquids or gases.
4. **ALWAYS** keep your work area clean, uncluttered, and well lit. **DO NOT** work on floor surfaces that are slippery with sawdust or wax.
5. **KEEP BYSTANDERS AT A SAFE DISTANCE** from the work area, especially when the tool is operating. **NEVER** allow children or pets near the tool.
6. **DO NOT FORCE THE TOOL** to do a job for which it was not designed.
7. **DRESS FOR SAFETY.** Do not wear loose clothing, gloves, neckties, or jewelry (rings, watches, etc.) when operating the tool. Inappropriate clothing and items can get caught in moving parts and draw you in. **ALWAYS** wear non-slip footwear and tie back long hair.
8. **WEAR A FACE MASK OR DUST MASK** to fight the dust produced by sawing operations.



**WARNING:** Dust generated from certain materials can be hazardous to your health. Always operate the tool in a well-ventilated area and provide for proper dust removal. Use dust collection systems whenever possible.

9. **ALWAYS** remove the power cord plug from the electrical outlet when making adjustments, changing parts, cleaning, or working on the tool.
10. **KEEP GUARDS IN PLACE AND IN WORKING ORDER.**
11. **AVOID ACCIDENTAL START-UPS.** Make sure the power switch is in the OFF position before plugging in the power cord.
12. **REMOVE ADJUSTMENT TOOLS.** Always make sure all adjustment tools are removed from the drill press before turning it on.
13. **NEVER LEAVE A RUNNING TOOL UNATTENDED.** Turn the power switch to OFF. Do not leave the tool until it has come to a complete stop.
14. **NEVER STAND ON A TOOL.** Serious injury could result if the tool tips or is accidentally hit. **DO NOT** store anything above or near the tool.

## GENERAL SAFETY RULES

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15. **DO NOT OVERREACH.** Keep proper footing and balance at all times. Wear oil-resistant rubber-soled footwear. Keep the floor clear of oil, scrap, and other debris.
16. **MAINTAIN TOOLS PROPERLY.** ALWAYS keep tools clean and in good working order. Follow instructions for lubricating and changing accessories.
17. **CHECK FOR DAMAGED PARTS.** Check for alignment of moving parts, jamming, breakage, improper mounting, or any other conditions that may affect the tool's operation. Any part that is damaged should be properly repaired or replaced before use.
18. **MAKE THE WORKSHOP CHILDPROOF.** Use padlocks and master switches and ALWAYS remove starter keys.
19. **DO NOT** operate the tool if you are under the influence of drugs, alcohol, or medication that may affect your ability to properly use the tool.
20. **USE SAFETY GOGGLES AT ALL TIMES** that comply with ANSI Z87.1. Normal safety glasses only have impact resistant lenses and are not designed for safety. Wear a face or dust mask when working in a dusty environment. Use ear protection such as plugs or muffs during extended periods of operation.

## SPECIFIC RULES FOR DRILL PRESS

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**WARNING:** Do not operate this tool until it is completely assembled and installed according to the instructions.

1. Never turn the drill press on until the table is clear of all foreign objects (tools, scraps, etc.).
2. Always keep hands and fingers away from the drill bit.
3. Do not drill materials without a flat surface unless a suitable support is used (clamp or vice).
4. Never start the drill press with the drill bit pressed against the workpiece.
5. Make sure the table lock is tightened before starting the drill press.
6. Never layout, assemble, or set-up any work on the table while the drill is on.
7. Make sure the drill bit is securely locked in the chuck.
8. Make sure the chuck key is removed from the chuck before turning power on.
9. Adjust the table or depth stop to avoid drilling into the table.

## SPECIFIC RULES FOR DRILL PRESS

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10. Always stop the drill before removing scrap pieces from the table.
11. Use clamps or a vise to secure a workpiece to the table. This will prevent the workpiece from rotating with the drill bit.
12. Do not wear gloves when operating a drill press.
13. Set the drill press to the speed that is appropriate for the material being drilled.
14. If any part of the drill press is missing/damaged or if the electrical components fail to perform properly, shut the power OFF and unplug the drill press. Replace missing, damaged or failed parts before resuming operation.
15. Before leaving the machine, shut the power off, remove the drill bit and clean the table.

## ELECTRICAL INFORMATION

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### GROUNDING INSTRUCTIONS

IN THE EVENT OF A MALFUNCTION OR BREAKDOWN, grounding provides the path of least resistance for an electric current and reduces the risk of electric shock. This tool is equipped with an electric cord that has an equipment grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching outlet 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 outlet, have the proper outlet installed by a licensed electrician.

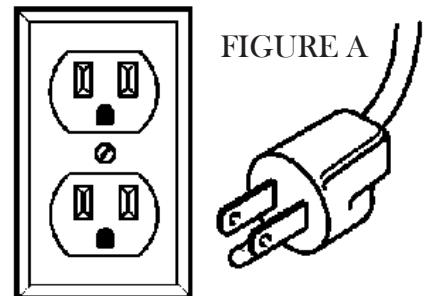
**IMPROPER CONNECTION** of the equipment grounding conductor can result in electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment grounding conductor. If repair or replacement of the electric cord or plug is necessary, **DO NOT** connect the equipment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

**CHECK** with a licensed electrician or service personnel if you do not completely understand the grounding instructions or whether the tool is properly grounded.

**USE ONLY THREE-WIRE EXTENSION CORDS** that have three-pronged plugs and outlets that accept the tool's plug as shown in Fig. A. Repair or replace a damaged or worn cord immediately.

**CAUTION:** In all cases, make certain the outlet in question is properly grounded. If you are not sure, have a licensed electrician check the outlet.

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



# ELECTRICAL INFORMATION

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## GUIDELINES FOR USING 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 cause a drop in line voltage resulting in loss of power and overheating. The table below shows the correct size to be used according to cord length and nameplate ampere rating. When in doubt, use a heavier cord. The smaller the gauge number, the heavier the cord.

AMPERAGE	REQUIRED GAUGE FOR EXTENSION CORDS			
	25 ft.	50 ft.	100 ft.	150 ft.
2.3 A	18 gauge	16 gauge	16 gauge	14 gauge

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 person before using it.

Protect your extension cords from sharp objects, excessive heat and damp/wet areas.

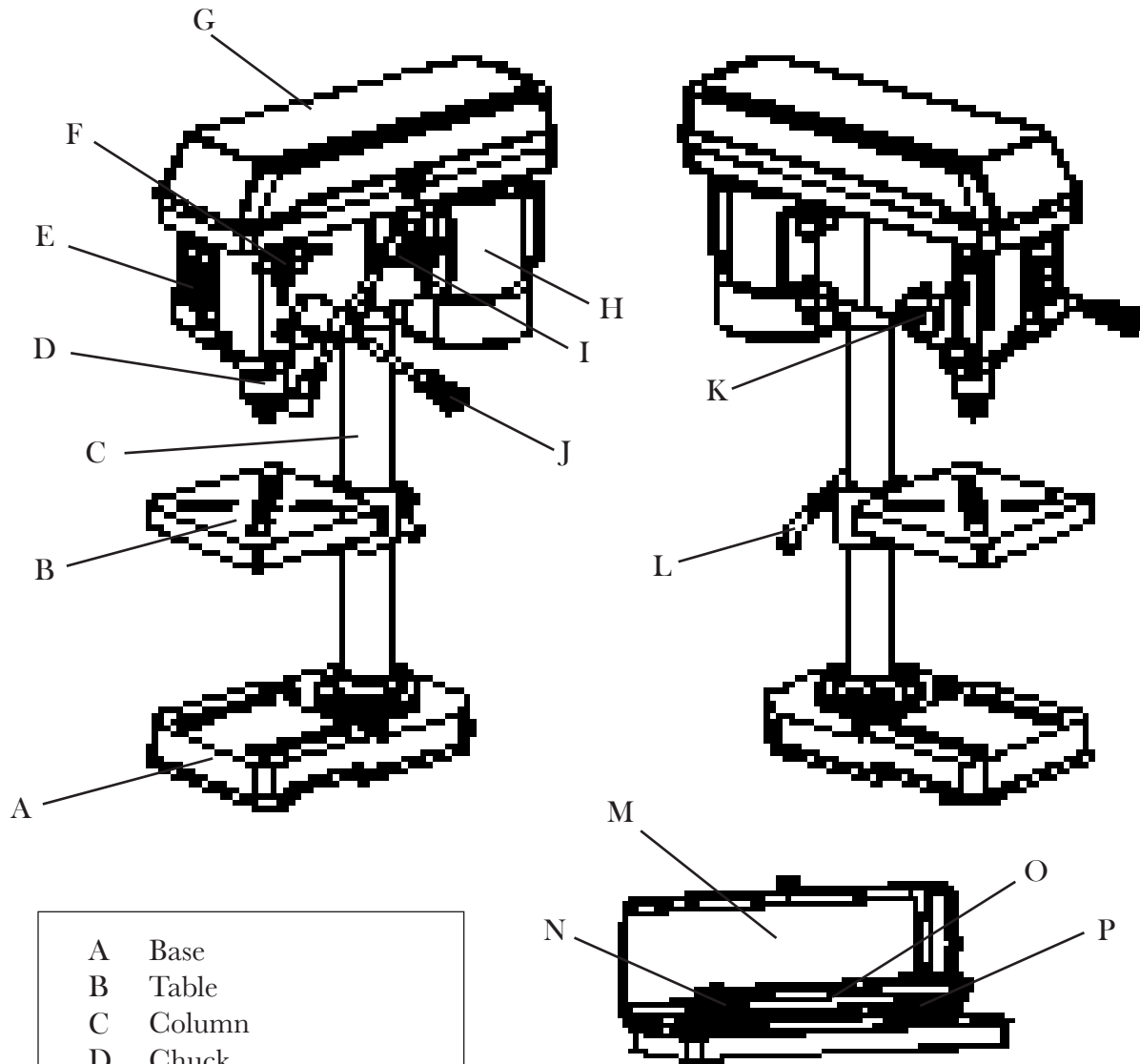


Use a separate electrical circuit for your tools. This circuit must not be less than a #12 wire and should be protected with a 15 A time-delayed fuse. Before connecting the motor to the power line, make sure the switch is in the OFF position and the electric current is rated the same as the current stamped on the motor nameplate. Running at a lower voltage will damage the motor.

**WARNING:** This tool must be grounded while in use to protect the operator from electric shock.

# KNOW YOUR DRILL PRESS

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- A Base
- B Table
- C Column
- D Chuck
- E ON/OFF Switch
- F Chuck Key
- G Housing Cover
- H Motor
- I Belt Tension Knob
- J Feed Handle
- K Spindle Return Spring
- L Table Lock
- M Speed Chart
- N Front Spindle
- O Belt
- P Back Spindle

# ASSEMBLY AND ADJUSTMENTS

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## UNPACKING

Unpack the drill press and all of its parts. Compare against the list below. Do not discard the carton or any packaging until the drill press is completely assembled.

To protect the drill press from moisture, a protective coating has been applied to the machine's surfaces. Remove this coating with a soft cloth moistened with kerosene or WD-40®. Do not use acetone, gasoline, or lacquer thinner to clean. Apply a coat of good paste wax to the table and column. Wipe all parts with a clean dry cloth.

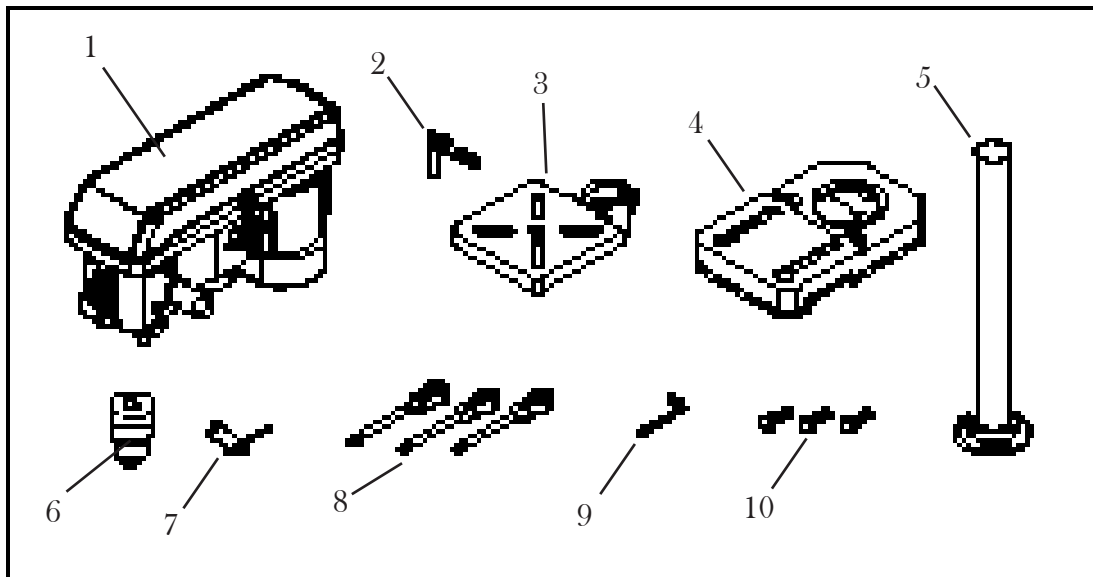


**WARNING:** If any part is missing or damaged, do not plug the drill press in until the missing or damaged part is repaired or replaced.

The column assembly (column, column support, rack, rack collar, and table support bracket) must be attached to the base. The table and table support handles must be attached to the table support bracket. The motor housing must be attached to the column.

Tools needed for assembly

- Adjustable wrench
- Hammer and block of wood



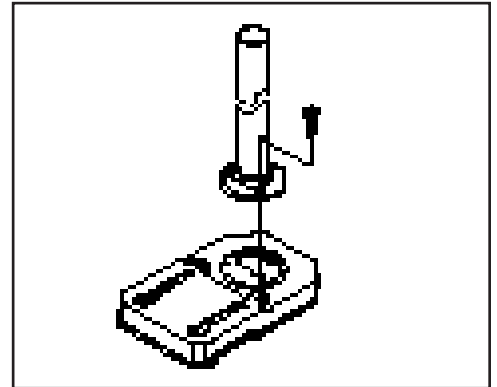
- |   |                                       |    |                    |
|---|---------------------------------------|----|--------------------|
| 1 | Head/Motor Assembly (1)               | 6  | Chuck (1)          |
| 2 | Table Locking Handle (1) (with table) | 7  | Chuck Key (1)      |
| 3 | Table Assembly (1)                    | 8  | Feed Handles (3)   |
| 4 | Base (1)                              | 9  | Hex Wrench (1)     |
| 5 | Column Assembly (1)                   | 10 | Hex Head Bolts (3) |



# ASSEMBLY AND ADJUSTMENTS

## ATTACHING COLUMN ASSEMBLY TO BASE

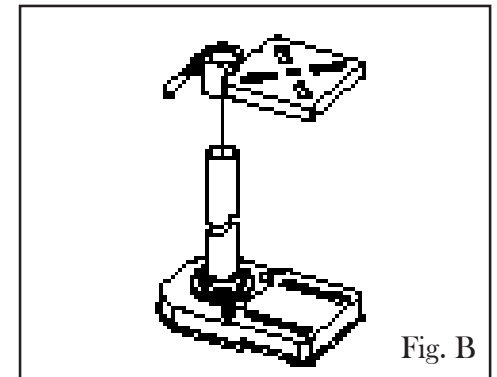
1. Place the column tube on the base, aligning the column support holes to the base holes.
2. Install a hex head bolt in each column support hole and tighten bolts using the adjustable wrench (Fig A).



## ATTACHING TABLE TO COLUMN

1. Slide the table assembly down directly onto the column (Fig. B) with the top of the table facing upwards.
2. Position the table directly over the base, and tighten the table locking handle to secure table assembly.

NOTE: Make sure to insert the table locking handle into the side of the column as shown in Fig. B (the lefthand side if facing the front of the drill press). Otherwise, the table will not tighten correctly.

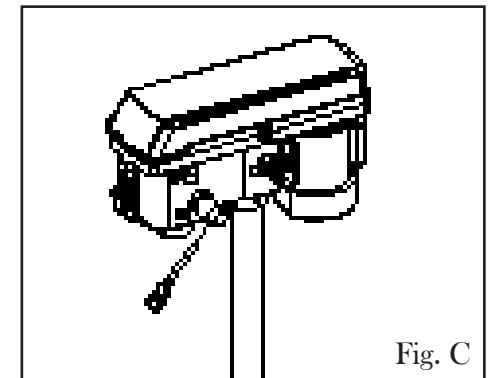


## DRILL PRESS HEAD TO COLUMN



**CAUTION:** The drill press head is somewhat heavy. To avoid injury, it is best if two people place it onto the column.

1. Carefully lift the drill press head assembly and position it over the column.
2. Place the mounting opening on the drill press head over the top of the column. Make sure the drill press head is seated properly on the column.
3. Align the direction of the drill press head with the direction of the base and the table.
4. Tighten the set screws where the head attaches to the column using a hex wrench.



## FEED HANDLES (Fig. C)

1. Insert the three feed handles into the threaded openings on the feed hub.
2. Manually tighten the handles into the openings.

Note: When using the drill press, one or two of the feed handles may be removed if an unusually-shaped work-piece interferes with handle rotation.

# ASSEMBLY AND ADJUSTMENTS

## MOUNT THE DRILL PRESS (FIG. D)

The drill press must be securely fastened through the mounting holes to a stand or workbench with heavy-duty fasteners (Fig. D). This will prevent the drill press from tipping over, sliding, or walking during operation.



**IMPORTANT:** If the stand or workbench has a tendency to move during operation, fasten the workbench securely to the floor.

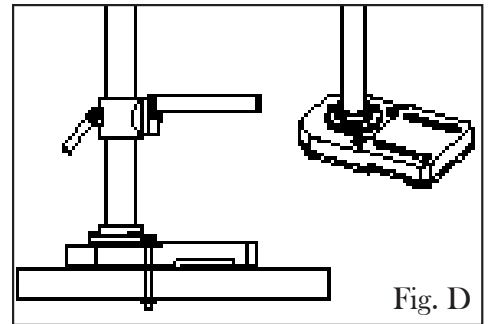


Fig. D

## INSTALL THE CHUCK (FIG. E)



**WARNING:** Before any assembly of the chuck to the drill press spindle, 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.

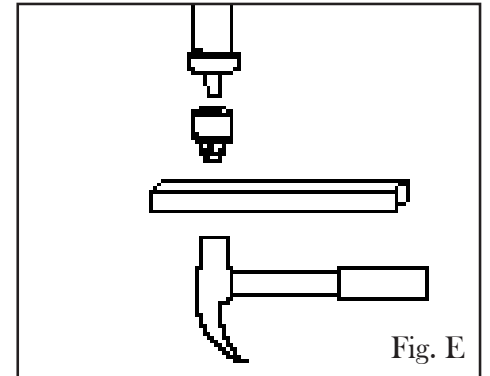


Fig. E

1. Inspect and clean the taper hole in the chuck and the spindle. Remove all grease, coatings, and particles from the chuck and spindle surfaces with a clean cloth.

**CAUTION:** To avoid damaging the chuck, make sure the jaws are completely recessed into the chuck. Do not use a metal hammer to drive the chuck into the spindle.

2. Align the chuck with the spindle.

3. Using a wood mallet, firmly tap the chuck upward into position on the spindle. Alternatively, you can use a block of wood and a regular hammer, using the wood to cushion the blow and prevent damage to the chuck (Fig. E).

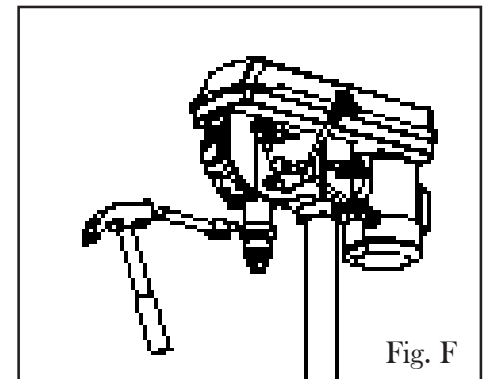


Fig. F

## REMOVE THE CHUCK (FIG. F)

If you ever need to remove the chuck:

1. Turn the feed handles to lower the chuck to the lowest position.

2. Place a ball joint separator above the chuck and tap it lightly with a hammer to cause the chuck to drop from the spindle.

**Note:** To avoid possible damage to the drill or chuck, be prepared to catch the chuck as it falls.

# ASSEMBLY AND ADJUSTMENTS

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## RAISE OR LOWER THE TABLE

1. Loosen the table locking handle and slide the table is at the desired height.
2. Tighten the table locking handle before drilling.

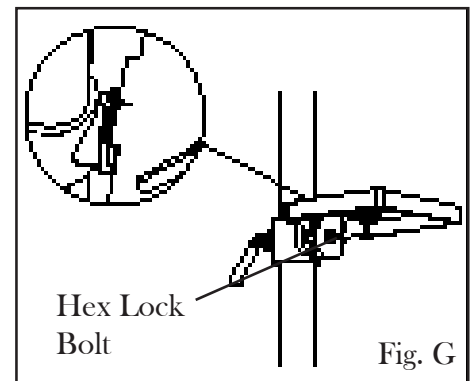
## ROTATE THE TABLE

1. Loosen the support lock handle and turn the table around the column to the desired position.
2. Tighten the support lock before drilling.

## TILT THE TABLE

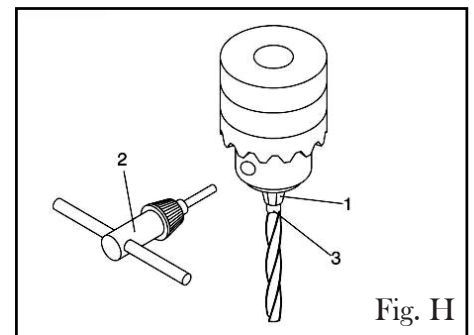
1. Loosen the hex lock bolt with a suitable socket wrench (located under the table, 1 in Fig. G).
2. Tilt the table to the desired angle, using the bevel scale (Fig. G) as a basic guide.
3. Re-tighten the bevel lock bolt.

**NOTE:** To return the table to its original horizontal position, loosen the bevel lock bolt. Realign the table to the 0° setting on the bevel scale. Tighten the bevel lock bolt with the wrench.



## INSTALLING A DRILL BIT

1. Place the chuck key into the side keyhole of the chuck, meshing the key with the gear teeth.
2. Turn the chuck key counterclockwise to open the chuck jaws.
3. Insert a drill bit into the chuck far enough to obtain the maximum grip of the chuck jaws.
4. Center the drill bit in the chuck jaws before the final tightening of the chuck.
5. Tighten the chuck jaws using the chuck key to ensure that the drill bit will not slip while drilling.
6. Remove the chuck key. Store on the rubber mounted chuck key storage on the side of the drill press.



**WARNING:** To avoid injury, make sure the chuck key is removed from the chuck before starting any drilling operation.

# ASSEMBLY AND ADJUSTMENTS

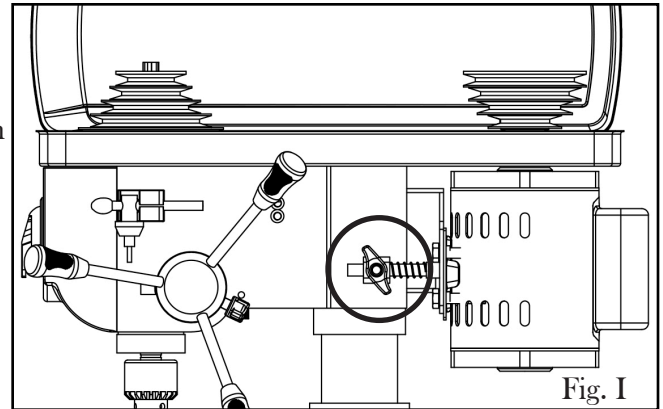
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## SPEED ADJUSTMENT

For a video of how to adjust the drill press speed, visit <http://bit.ly/1LGcLIb>

1. To change to another one of the five available speeds, open the belt housing and loosen the belt tension locking knob found circled in Fig. I.

2. Pull the motor towards the front of the drill press in order to move the two spindles closer to one another. This release in tension should allow you to change the location of the belt on the belt spindles (Fig. I).



3. Using the speed chart printed on this inside cover of the spindle housing, move the belt to the desired position.

4. Slide the motor back to the rear and lock the belt tension knob once the belt no longer has any slack. Close the spindle housing.

## REPLACING THE BELT

**WARNING:** Disconnect the drill press from the power source before replacing the belt.

Belt tension and drill press speed is controlled by automatic adjustments made to the diameter of the front spindle when the drive handle is moved.

1. Open the housing cover. Loosen the belt tension locking knob (Fig I).

2. Remove the belt from the housing cover if it is broken. If it is not broken, but is too stretched to operate correctly, work the belt off the drive (motor) spindle. Then remove the belt from the front spindle.

3. Replace the belt by putting a new belt over the front spindles at the desired speed. Return the motor back to its initial position in order to make the belt taut. Once the desired tension has been achieved, tighten the belt tension locking knob (Fig I).

## ASSEMBLY AND ADJUSTMENTS

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### SPINDLE RETURN SPRING (Fig. J)

The spindle is equipped with an auto-return mechanism. The main components are a spring and a notched housing. The spring was properly adjusted at the factory and should not be readjusted unless absolutely necessary.

**WARNING: ALWAYS WEAR WORK GLOVES TO PREVENT INJURY DURING SPINDLE RETURN SPRING ADJUSTMENTS.**

1. Unplug the drill press.
2. Loosen the two housing nuts (2) approximately 1/4" (6 mm). Do not remove the nuts from the threaded shaft. Do not allow the spring or spring housing to slip out of control. Keep a firm grip on the return spring using work gloves.
3. While firmly holding the spring housing (3), carefully pull the spring housing out until it clears the raised notch (2).
4. Turn the housing so that the next notch is engaged with the raised notch (2).
  - To increase the spindle return tension, turn the spring housing counter-clockwise.
  - To decrease the tension, turn the spring housing clockwise.
5. Tighten the two housing nuts. Do not overtighten the two nuts. If the nuts are tightened too much, the movement of the spindle and feed handles will become sluggish.

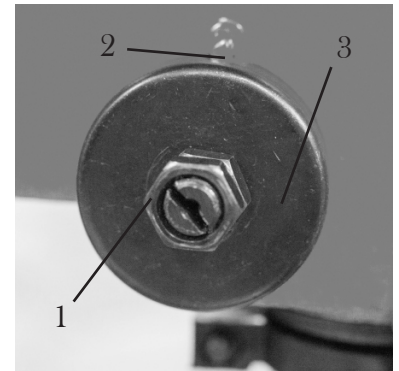


Fig. J

## MAINTENANCE

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**WARNING:** For your safety, turn the switch off and remove the plug from the power supply before maintaining or lubricating the drill press.

Vacuum sawdust or metal shavings that accumulate in and on the motor, pulley housing, table, and work surface.

Apply a light coat of paste wax to the column and table to help keep these surfaces clean and rust-free.

The ball bearings in the spindle and the V-belt pulley assembly are greased and permanently sealed. Pull the spindle down and oil the spindle sleeve moderately every three months.

Lubricate the locking knobs if they become difficult to use.

**CAUTION:** All servicing of the drill press should be performed by a qualified service technician.

## OPERATION

### **DRILL PRESS ON/OFF SWITCH (Fig. U)**

1. To turn the drill press ON, insert the yellow safety key (1) into the switch housing (2). As a safety feature, the switch cannot be turned ON without the safety key.

2. Flip the switch upward to the ON position.

3. To turn the drill press OFF, flip the switch downward.

4. To lock the switch in the OFF position, remove the safety key (1) from the switch. Store the safety key in a safe place.

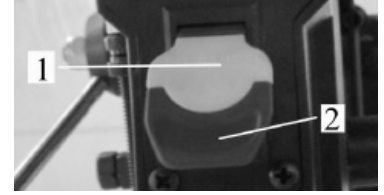


Fig. U

### **POSITION THE TABLE AND WORKPIECE**

Always place a piece of backup material (wood, plywood, etc.) on the table underneath the workpiece. This will prevent splintering on the underside of the workpiece as the drill bit breaks through. To keep the material from spinning out of control, it must contact the left side of the column as illustrated (Fig. V), or be clamped (not included) to the table.

Note: For small workpieces that cannot be clamped to the table, use a drill press vise (not included). The vise must be clamped or bolted to the table to avoid injury.

### **GENERAL DRILLING GUIDELINES - DRILLING A HOLE**

**WARNING:** To prevent the workpiece and the backup material from slipping from your hand while drilling, position the workpiece and backup material to the left side of the column. If the workpiece and the backup material are not long enough to reach the column, clamp the workpiece and backup material to the table. Failure to do this could result in personal injury.

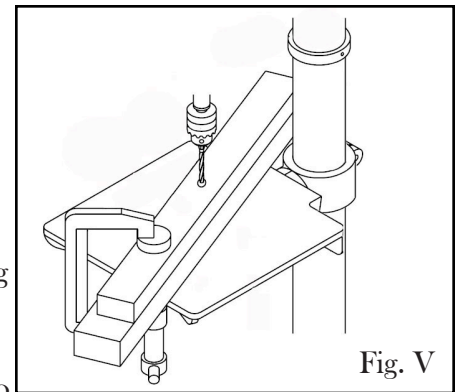


Fig. V

1. Mark where you want to drill in workpiece by using a center punch or a sharp nail or turn ON the laser to mark your drilling point.

2. Before turning the drill press ON, turn the feed handles to bring the drill bit down. Line the drill bit tip up with the mark. Clamp the workpiece in place.

3. Turn ON the drill press and pull down on the feed handles with the appropriate force needed to allow the drill bit to drill the material.

Note: Feeding too slowly might cause the drill bit to turn in the chuck. Feeding too rapidly might stop the motor, cause the belt to slip, force the workpiece loose, or break the drill bit. Practice with scrap material to get the feel of the machine before attempting to do any drilling operation.

# OPERATION

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## **DRILLING SPEEDS**

There are a few important factors to keep in mind when determining the best drilling speed:

- Material type
- Hole size
- Drill bit or cutter type
- Quality desired

Smaller drill bits require greater speed than larger drill bits. Softer materials require greater speed than harder materials.

## **DRILLING WOOD**

- Brad point bits are preferred. Metal piercing twist bits may be used on wood.
- Do not use auger bits. Auger bits turn so rapidly that they can lift the workpiece off of the table and whirl it around.
- Always protect the drill bit by positioning the table so that the drill bit will enter the center hole when drilling through the workpiece.
- To prevent splintering, feed the drill bit slowly right as the bit is about to cut through to the backside of the workpiece.
- To reduce splintering and protect the point of the bit, use scrap wood as a backing or a base block under the workpiece.

## **FEEDING THE DRILL BIT**

- Pull down on the feed handles with only enough force to allow the drill bit to cut.
- Feeding too rapidly might stall the motor, cause the belt to slip, damage the workpiece, or break the drill bit.
- Feeding too slowly will cause the drill bit to heat up and burn the workpiece.

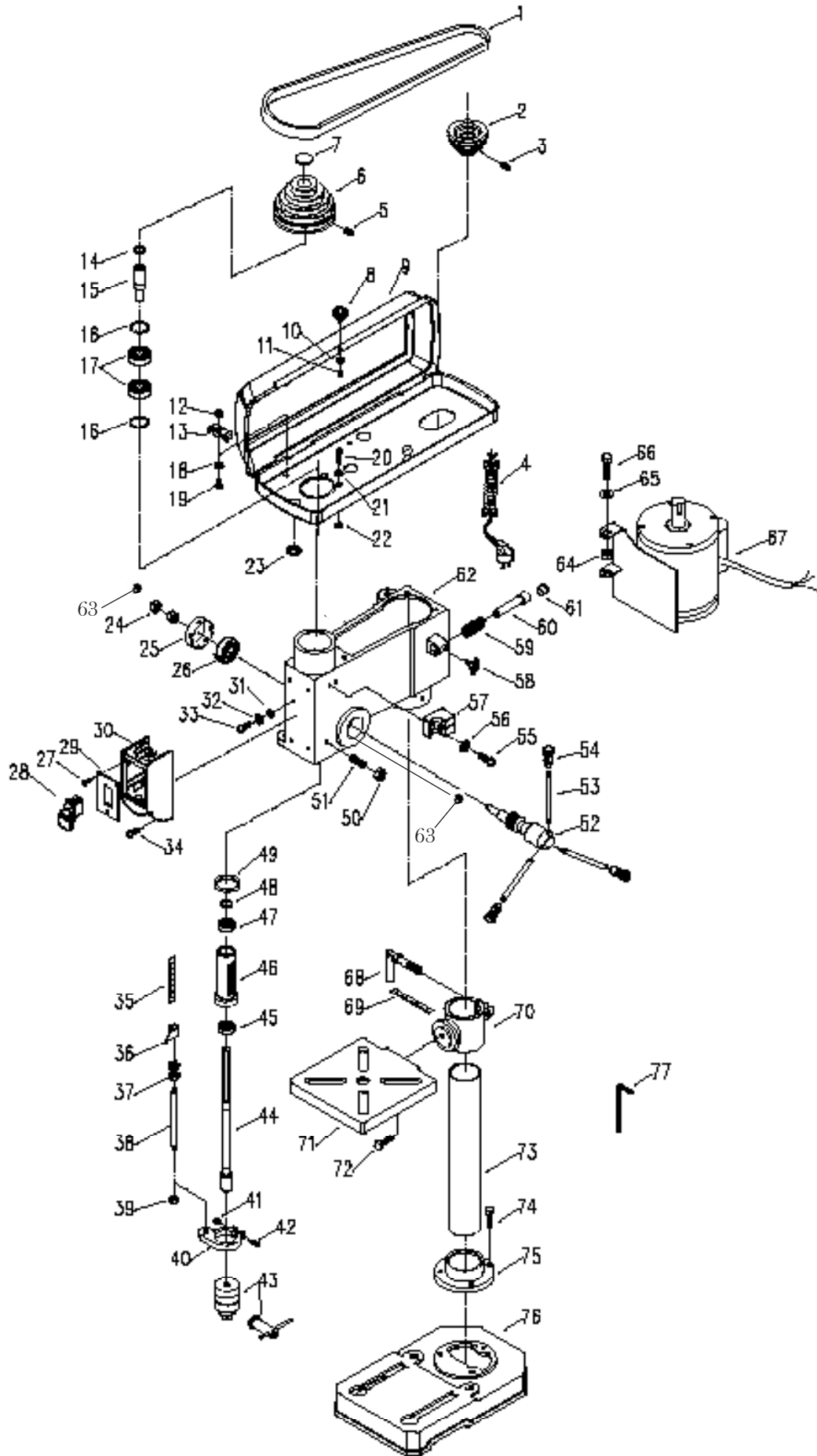
## EXPLODED VIEW & PARTS LIST

Item	Stock #	Description	Qty
1	4208C-001	V belt	1
2	4208C-002	Motor pulley	1
3	4208C-003	Set screw	1
4	4208C-004	Power cord	1
5	4208C-005	Set screw	1
6	4208C-006	Spindle pulley	1
7	4208C-007	Pulley cap	1
8	4208C-008	Belt house knob	1
9	4208C-009	Belt house	1
10	4208C-010	Flat washer	1
11	4208C-011	Nut	1
12	4208C-012	Hex nut	2
13	4208C-013	Cord clamper	2
14	4208C-014	Retaining ring	1
15	4208C-015	Sleeve	1
16	4208C-016	Retaining ring	2
17	4208C-017	Ball bearing	2
18	4208C-018	Flat washer	2
19	4208C-019	Pan head screw	2
20	4208C-020	Pan head screw	4
21	4208C-021	Flat washer	4
22	4208C-022	Rubber washer	4
23	4208C-023	Bushing	2
24	4208C-024	Hex nut	2
25	4208C-025	Spring cap	1
26	4208C-026	Spring	1
27	4208C-027	Screw	3
28	4208C-028	Switch	1
29	4208C-029	Switch plate	1
30	4208C-030	Switch box	1
31	4208C-031	Serrated washer	2
32	4208C-032	Lock washer	2
33	4208C-033	Screw	2
34	4208C-034	Screw	4
35	4208C-035	Depth scale	1
36	4208C-036	Pointer	1
37	4208C-037	Hex nut	2
38	4208C-038	Depth rod	1
39	4208C-039	Hex nut	1

Item	Stock #	Description
40	4208C-040	Quill collar
41	4208C-041	Hex nut
42	4208C-042	Screw
43	4208C-043	Chuck with key
44	4208C-044	Spindle
45	4208C-045	Ball bearing
46	4208C-046	Quill
47	4208C-047	Ball bearing
48	4208C-048	Retaining ring
49	4208C-049	Rubber washer
50	4208C-050	Hex nut
51	4208C-051	Set screw
52	4208C-052	Gear shaft
53	4208C-053	Feeding handle
54	4208C-054	Knob
55	4208C-055	Flat washer
56	4208C-056	Pan head screw
57	4208C-057	Chuck key seat
58	4208C-058	Wing screw
59	4208C-059	Spring
60	4208C-060	Pushing shaft
61	4208C-061	Cap
62	4208C-062	Head
63	4208C-063	Set screw
64	4208C-064	Hex nut
65	4208C-065	Flat washer
66	4208C-066	Bolt
67	4208C-067	Motor
68	4208C-068	Locking handle
69	4208C-069	Angle scale
70	4208C-070	Table support bracket
71	4208C-071	Table
72	4208C-072	Bolt
73	4208C-073	Column
74	4208C-074	Bolt
75	4208C-075	Column support
76	4208C-076	Base
77	4208C-077	Wrench



# EXPLODED VIEW & PARTS LIST



## TROUBLESHOOTING

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PROBLEM	CAUSES	SOLUTIONS
Noisy operation	<ol style="list-style-type: none"> <li>1) Incorrect belt tension</li> <li>2) Dry spindle</li> <li>3) Loose spindle pulley</li> <li>4) Loose motor pulley</li> </ol>	<ol style="list-style-type: none"> <li>1) Adjust the belt tension (See <b>REPLACE THE BELT</b> section)</li> <li>2) Lubricate the spindle</li> <li>3) Tighten the retaining nut on the pulley insert</li> <li>4) Tighten the set screw on the side of the motor pulley</li> </ol>
The drill bit burns or smokes	<ol style="list-style-type: none"> <li>1) Drilling at the incorrect speed</li> <li>2) The wood chips are not coming out of the hole</li> <li>3) Dull drill bit</li> <li>4) Feeding the workpiece too slowly</li> <li>5) Not lubricated</li> </ol>	<ol style="list-style-type: none"> <li>1) Change the speed</li> <li>2) Retract the drill bit frequently to clear the chips</li> <li>3) Resharpen or replace the drill bit</li> <li>4) Feed fast enough to cut the workpiece</li> <li>5) Lubricate the drill bit with cutting oil or motor oil</li> </ol>
Excessive drill run out or wobble; drilled hole is not round	<ol style="list-style-type: none"> <li>1) Bent drill bit</li> <li>2) Bit improperly installed in the chuck</li> <li>3) Worn spindle bearings</li> <li>4) Lengths of cutting flutes or angles not appropriate for the hardness of the wood grain</li> <li>5) Chuck not properly installed</li> </ol>	<ol style="list-style-type: none"> <li>1) Replace the drill bit</li> <li>2) Reinstall the bit.</li> <li>3) Replace the bearing. Take the press to a qualified service technician</li> <li>4) Resharpen the drill bit correctly or replace with the appropriate type.</li> <li>5) Reinstall the chuck.</li> </ol>
Drill bit binds in the workpiece	<ol style="list-style-type: none"> <li>1) The workpiece is pinching the bit</li> <li>2) Excessive feed pressure</li> </ol>	<ol style="list-style-type: none"> <li>1) Support or clamp the workpiece.</li> <li>2) Feed more slowly.</li> </ol>
Spindle returns too slowly or too quickly	Coil spring has improper tension	Adjust the coil spring tension
Chuck falls off spindle	Dirt, grease, or oil on the tapered surface on the spindle or in the chuck	Clean the tapered surface of both the chuck and spindle with a household detergent.
Motor will not run	<ol style="list-style-type: none"> <li>1) Defective or broken switch</li> <li>2) Defective or damaged power cord</li> <li>3) Open circuit, loose connections, or burned out motor</li> <li>4) Low voltage</li> </ol>	<ol style="list-style-type: none"> <li>1) Take to a qualified service technician</li> <li>2) Take to a qualified service technician</li> <li>3) Take to a qualified service technician</li> <li>4) Check the power line for the proper voltage. Use another circuit or have a qualified electrician upgrade the service.</li> </ol>
Motor stalls	<ol style="list-style-type: none"> <li>1) Short circuit in motor</li> <li>2) Incorrect fuses or circuit breakers</li> <li>3) Overloaded circuit</li> <li>4) Low Voltage</li> </ol>	<ol style="list-style-type: none"> <li>1) Take to a qualified service technician</li> <li>2) Replace with correct fuse or circuit breaker for the circuit</li> <li>3) Turn off other machines and retry</li> <li>4) Check the power line for the proper voltage. Use another circuit or have a qualified electrician upgrade the service.</li> </ol>

## LIMITED TWO YEAR WARRANTY

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**Thanks for  
remembering**

