

## PARTS LIST

Item	Description	Part No.
1	Slotted Set Screw	UA11029
–	Spring (not shown)	DP10612
3	Lock Nut	DP10614
4	Threaded Rod	DP10613
–	Knob Spacer (not shown)	UA11021
6	Machine Head	DP10603WM
7	Post	UA11030
–	Flat Point Socket Set Screw (not shown)	UA11027
9	Machine Base	DP10618WM
10	Adjustable Table	DP10602
11	Adjusting Knob with Spacer	DP10611/DP10620
12	Cap Screws - Socket Head	DP10610
13	Metric Dial Indicator	UA11025
–	Head Locking Pin (not shown)	UA11018
15	Indicator Mounting Bracket	UA11023
16	Indicator Datum Plate	UA11017
17	Locking Arm Grip	UA11020
18	Head Locking Arm	UA11019
19	Handle	DP10608
20	Handle Grip	DP10609
21	Flat Washer	BG1-242
22	Dial Indicator Control Knob	UA11024
23	Acorn Nut	DP10617
24	Adjusting Knob	UA11022
25	Handle Link	DP10606
26	Shoulder Screws	DP10607
–	Disc Spring (not shown)	HP10708
–	Hardened Washer (not shown)	HP10707
29	Indicator Mounting Locking Knob	UA11022
–	Allen Wrench (7/64")	DP10619

### Optional Accessories for the P-DP39 Drill Press:

**Micro Chuck (A-MC2)** – An accurate, economical adapter chuck, used for 60 to 80 wire gauge drills. The A-MC2 can be held in any 1/8" or 3/16" collet.

**Hardened Tool Steel Step Drills** – Drill point sizes from .5mm to 2.3mm. Refer to the Foredom Accessory Catalog for a complete listing of sizes. All have 3/32" diameter shanks.

**Chuck Key Handle (HPCK-0)** – For H.30® and H.30H Handpiece users. Comes with #0 chuck key in handle.

#### For More Information

For more information on Foredom machines, handpieces, and accessories, contact your local dealer. When no local dealer is available, write The Foredom Electric Company, 16 Stony Hill Road, Bethel, CT 06801 USA, call 203-792-8622 or email customerservice@blackstone.com.

**Please retain your proof of purchase for warranty repairs.**

#### LIMITED WARRANTY

The Foredom Electric Company warrants the P-DP39 Drill Press to be free of defects in material or workmanship for a period of 1 year after purchase. During the warranty period, the defective product will be repaired or replaced without charge or, at our option, the purchase price will be refunded. This warranty does not cover damage caused in transit or by accident, misuse, or ordinary wear.

ALL IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO WARRANTIES OF FITNESS AND MERCHANTABILITY, ARE HEREBY LIMITED IN DURATION TO A PERIOD ENDING ONE YEAR FROM DATE OF PURCHASE, AND WE WILL NOT BE LIABLE OR RESPONSIBLE FOR ANY SPECIAL OR CONSEQUENTIAL DAMAGES.

Repair or replacement will be made at our option if the product is returned post-paid to:

The Foredom Electric Company  
16 Stony Hill Road  
Bethel, CT USA 06801

All warranty repairs must be done at the factory at the above address. We will not pay any shipping or transportation charges. This warranty only covers the original purchaser of the product. Some states do not allow limitations on how long an implied warranty lasts, so the above limitations may not apply to you. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

**FOREDOM®**  
The Foredom Electric Company  
Bethel, CT USA 06801  
[www.foredom.com](http://www.foredom.com)



**FOREDOM®**

**P-DP39  
Drill  
Press**

**OWNER'S  
MANUAL**

**For Your Own Safety:**

Always wear eye protection.

Read this Owner's Manual

before operating your Foredom tool.

## GENERAL INFORMATION

The Foredom® P-DP39 Drill Press is designed for use with the H.30® and H.44T Handpieces. It securely holds the handpiece in a vertical position for drilling straight, accurate holes to specified depths. It is ideal for drilling, modeling, spotfacing, countersinking and reaming in wood, wax, plastic, metal, glass and gemstone. It can be used with any Foredom flexible shaft power tool.

### PLEASE FOLLOW THESE IMPORTANT SAFETY INSTRUCTIONS:

**Always** wear safety glasses to protect eyes from flying debris and chips.

**Never** continue to use a drill or accessory which appears to be wobbling, out of round, vibrating or not running true.

**Always** use drills and accessories rated for 18,000 RPM or higher.

**Never** wear loose clothing, dangling jewelry or other apparel which may become caught in the equipment.

**Always** keep hands, fingers and hair well away from the drill or other accessories.

**Always** bolt down the Drill Press for extra stability.

## SET-UP AND OPERATION

As you unpack the Drill Press, make sure that you have the complete P-DP39 assembly (see illustration) and the allen wrench provided. Loosen the adjusting knob (24) and move the head up the post (7) to the desired height. Tighten the knob securely. Be sure that the head, table and base are aligned and centered. Foredom recommends bolting the drill press to the workbench or platform for extra stability. Insert suitable length bolts through the four holes provided in the base plate (9). Fasten to the workbench or to a piece of plywood approximately 2' x 2' x 3/4".

### Arm Adjustment

Test the downstroke action of the handle. This has been preadjusted at the factory, but may have rattled loose during shipping. It should feel smooth and free. If it feels too loose, adjust the shoulder screws (26) in the handle arm assembly. These screws should be tightened snugly.

### Inserting the Handpiece

Do not tighten the two socket cap screws (12) unless handpiece is inserted in holder. To insert the handpiece, loosen the two socket cap screws with the allen wrench provided. Insert the handpiece into the handpiece guides. When using the H.30® Handpiece, make sure the chuck key hole is facing forward and is accessible. If using the H.44T Handpiece, make sure that the pin hole is accessible. Insert the handpiece through both guides until the tip of the collet or chuck is approximately 1" below the bottom guide. Tighten alternately the two socket cap screws enough to prevent the handpiece from turning in the guides. Next, insert the drill or accessory and tighten securely in the chuck or collet using the chuck key for the H.30 Handpiece and the pin and wrench for the H.44T.

*Be sure to remove the pin from the handpiece hole of the H.44T before starting the motor.*

### Table Adjustment

Determine the desired table height for the thickness of the material to be worked, leaving approximately one inch between tip of drill and workpiece when placed on adjustable table. When using a drill, make sure that the drill tip is aligned with the center of the table drill hole by moving the drill gently through the hole while the motor is still off.

### Dial Indicator Installation and Adjustment

The Foredom P-DP39 is equipped with a dial indicator measurable in millimeters. (The tic marks on the face of the large dial represent 1/100mm; small dial represents full millimeters.) This feature allows an operator to have precise control of the vertical movement of the handpiece head assembly. Install the indicator by placing it into the hole in the indicator mounting bracket (15), and tightening set screw (1).

#### Adjusting dial indicator to zero:

1. Place workpiece on adjustable table (10).
2. Lower the drill press head using handle (19) until the accessory or drill touches the workpiece. Lock the head in place using head locking arm (18).
3. Loosen indicator mounting bracket using indicator mount locking knob (29) with your right hand and holding mounting bracket (15) with your left hand.
4. Lower dial indicator assembly (15 & 13) until it touches datum (16), then compress indicator plunger until small dial has rotated more than the hole depth desired (up to 25mm). Hold mounting bracket in place and retighten knob (29).
5. Turn outer ring of dial indicator until large needle meets the zero point.
6. Unlock the head by turning the head locking arm (18).

### Drill Stroke Adjustment

This adjustment will allow you to return to the same specified depth for multiple drilling strokes. Turn precision stroke adjustment knob (22) until the screw touches the black head assembly (6). Reset large needle to zero point if necessary. Release head locking arm (18). To adjust the drill stroke depth, move the head down to the desired depth as shown on the dial indicator from zero point by pressing down on the handle or turning the precision stroke adjustment knob (22) clockwise. Move locknuts (3) until they hold the head in this position. (Unscrew the knob (22) enough to allow head to rise freely.)

### Drilling

High speed steel, carbide and diamond drills are most often used. Whatever accessory you use, let the speed of the tool do the work. Too much feeding pressure can damage or break your drill, and may cause loss of control. When drilling, lift the drill up and down frequently to clear away dust and chips. *Note:* when using twist drills for drilling holes on work items with rounded surfaces such as rods, it is a good idea to centerpunch a starting hole to keep the tip of the drill from "walking" or wandering from the desired starting point.

### Speed

Always use drills and accessories rated for 18,000 RPM or higher. Generally, work speed is determined by experience and varies with the type of material being drilled or worked on, the type of drill or accessory, the thickness of the material and the type of work being done. Follow recommendations of the drill or accessory manufacturer. Usually, higher speeds are used on soft materials and lower speeds on harder materials. It is always a good idea to experiment on a scrap piece of material before beginning the final work operation.

### Coolants

Coolants are sometimes needed to help keep the accessory cool and to keep the workpiece clean of debris. Which type to use is determined by the material and the accessory and will vary with operator preference. Wetting agents with rust inhibitors, waxes, oils and water are often used when drilling extremely hard materials such as metals, gems and stones.

### Lubrication

All unpainted surfaces are sprayed with a rust inhibitor when shipped. Be sure to clean away all debris after use. Respray with rust inhibitor when necessary, especially during storage. The spring and two shoulder screws (26) should be lubricated periodically with a light coat of oil.

