

## Optional Accessories for the P-DP30 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 (#76) to 2.3mm (#43). 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®, H.25C and H.30H Handpieces. 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, visit [www.foredom.com](http://www.foredom.com) on the web.

The Foredom Electric Company  
16 Stony Hill Road, Bethel, CT 06801  
Tel.: 203-792-8622 • Fax: 203-796-7861

### LIMITED WARRANTY

The Foredom Electric Company warrants the P-DP30 Drill Press to be free of defects in material or workmanship for a period of one 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.

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Bethel, CT USA 06801  
[www.foredom.com](http://www.foredom.com)

# FOREDOM®

## P-DP30 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-DP30 Drill Press is designed for use with the H.30®, H.30H, H.44T and H.44HT handpieces. It securely holds the handpiece in a vertical position for drilling straight, accurate holes to specified depths. In addition to drilling, it is ideal for modeling, spot-facing, countersinking and reaming in wood, wax, plastic, metal, glass and gemstone.

## 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 assembly (see illustration) and the 7/64" Allen wrench provided. Loosen the Adjusting Knob and move the Head Assembly up the Post 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. Fasten to the workbench or to a piece of plywood approximately 2' x 2' x ¾".

### 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 in the handle arm assembly. These screws should be tightened snugly.

### Inserting the Handpiece

**Do not tighten cap screws unless handpiece is inserted in holder.** To insert the handpiece, loosen the two Socket Cap Screws with the supplied Allen Wrench. Insert the handpiece into the Handpiece Guides. When using the H.30® or H.30H Handpiece, make sure the **chuck key hole** is facing forward and is accessible. If using the H.44T or H.44HT 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® or H.30H handpiece and the pin and wrench for the H.44T or H.44HT.

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

### Table Adjustment

Determine the desired table height for the thickness of the material to be worked. 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.

### Removing Adjustable Table

If you need to remove the adjustable table, the Handpiece Head Assembly must be removed first. Loosen the Head Adjusting Knob and slide the Head Assembly up and off the Post. **Note:** Make sure that you have a firm grip on the Head Assembly before loosening the knob. It could be damaged if allowed to drop. Place the head on the work surface, handle side up. Repeat procedure with the Adjustable Table. Replace the Handpiece Head Assembly onto the post and tighten the Adjusting Knob, aligning head and base plate.

### Drill Stroke Adjustment

Adjust the drill stroke depth from (0–1¼") with Lock Nuts. Move the Depth Stroke Indicator to the desired measurement on the Scale by pressing down on the handle. Hold at desired setting and move Lock Nuts until the depth indicator is stopped.

### Securing the Workpiece

Slots are provided in the Adjustable Table and Base Plate for use with clamps, jigs, and other holding devices. Make sure the workpiece is securely fastened before beginning work.

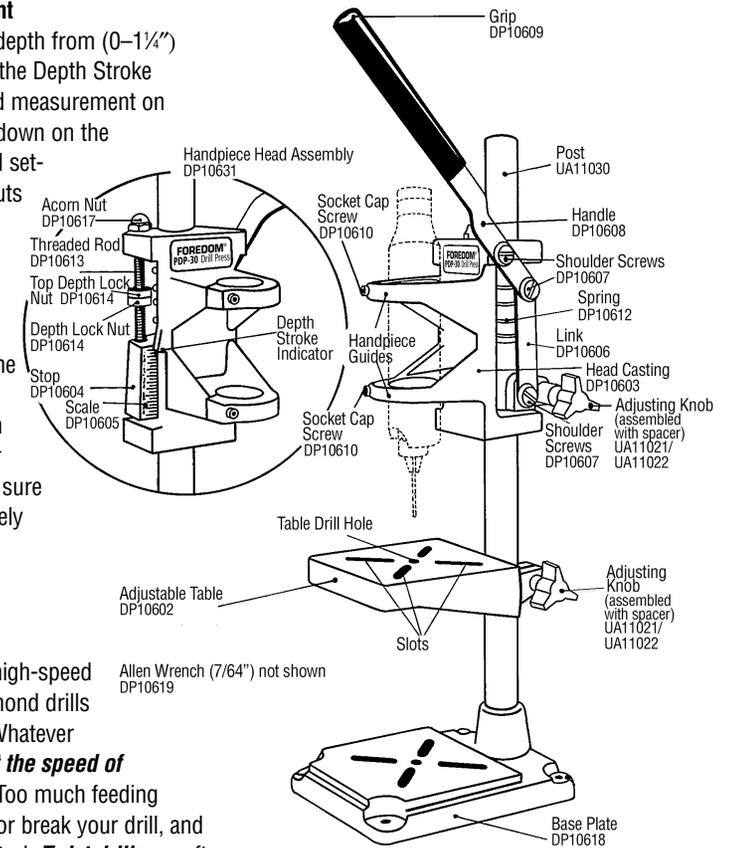
### Drilling

For drilling, generally 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. **Twist drills** are often used for drilling holes in metals, woods, and plastics. 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.

**When drilling, lift the drill up and down frequently to clear away dust and chips.**

### 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, 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 very 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 should be lubricated periodically with a light coat of oil.