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.

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 key hole is facing forward and is accessible. If using the H.44T Handpiece, make sure that the pin and wrench for the H.44T are inserted.

Determining the table height for the desired 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.

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 & 18) 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).

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).

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.

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. Reapplications 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.