

PALMGREN

33" RADIAL ARM BENCH AND FLOOR DRILL PRESSES



Read carefully and follow all safety rules and operating instructions before first use of this product.

DESCRIPTION

Palmgren Radial Arm Drill Presses feature a heavy cast iron base, work table and head. Head moves 12" forward and backward using a rack and pinion. Head also swivels 360° around column, tilts 90° right and 45° left. Work table height is also adjustable using rack and pinion. Table can be tilted 45° both right and left, and rotates 360° on a vertical axis. Work table surface is precision ground which features slots for secure, accurate mounting of workpiece. Other features of the Palmgren drill press are an enclosed ball bearing quill assembly, quick belt change and tension mechanism, positive quick-adjust feed depth stop and a 1/2 HP, 1725 RPM motor. Chuck and chuck arbor are included.

Palmgren drill presses are ideal for use in home shops, maintenance shops and light industrial applications. Spindle speeds are adjustable for drilling steel, cast iron, aluminum, wood and plastic.

UNPACKING

Check for loose, missing or damaged parts. If any damage or loss has occurred, claim must be filed with carrier immediately. Check for completeness. Immediately report missing parts to dealer.

Drill press is shipped unassembled. Locate and identify the following assemblies and loose parts (Refer to Figures 1 and 2):

MODEL 80341A BENCH DRILL PRESS

- A Head Assembly
- B Column Assembly
- C Base
- D Table and Bracket Assembly with Worm Gear
- E Quill Feed Handle (3)
- F Table Crank Handle
- G Retaining Ring
- H Rack
- I Drill Chuck with Key
- J Yoke
- K Strap

Not Shown: Chuck arbor, Drift key, Lock handle, Shoe, M10 x 30 Hex head bolts (2), M10 Flat washers (2), M10 Hex nuts (2), M8 x 30 Hex head bolts (4), M8 Flat washers (4), M8 Lock washers (4), and 3mm and 4mm hex wrenches.

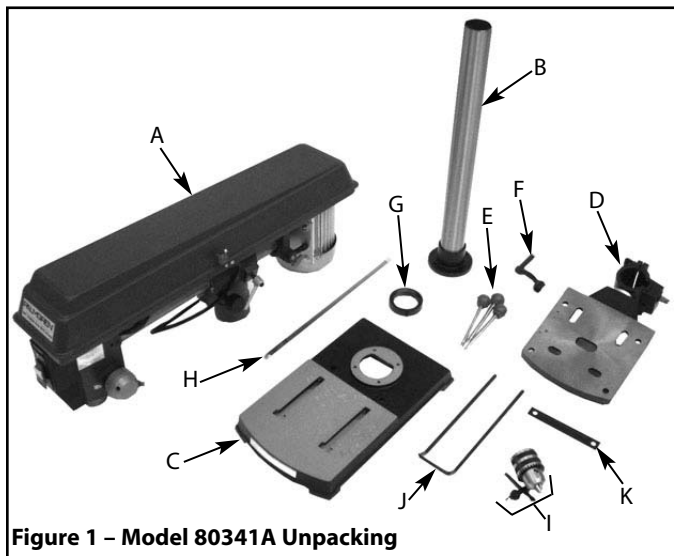


Figure 1 – Model 80341A Unpacking

MODEL 80342A FLOOR DRILL PRESS

- A Head Assembly
- B Column
- C Column Flange
- D Base
- E Table Arm and Bracket Assembly with Worm Gear
- F Extension Arm
- G Table
- H Drill Chuck with Key
- I Table Crank Handle
- J Quill Feed Handle (3)
- K Retaining Ring
- L Rack

Not Shown: Chuck arbor, Drift key, Lock handle, Shoe, M10 x 40 Hex head bolts (4), M8 Flat Washers (4), M8 Lock washers (4), and 3mm, 4mm and 5mm hex wrenches.

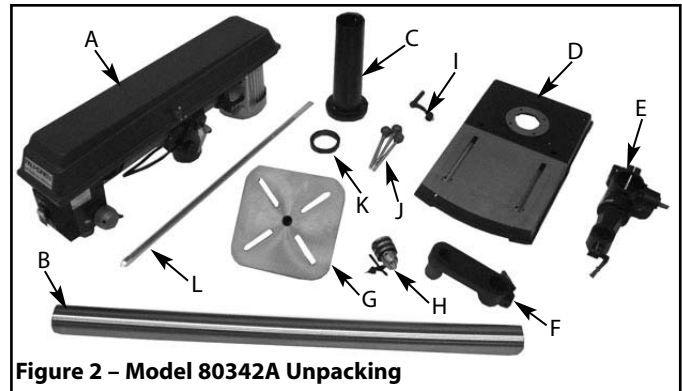


Figure 2 – Model 80342A Unpacking

IMPORTANT: The tool has been coated with a protective coating. In order to ensure proper fit and operation the coating must be removed. Remove coating with mild solvents such as mineral spirits and a soft cloth. Nonflammable solvents are recommended. After cleaning, cover all exposed surfaces with a light coating of oil. Paste wax is recommended for table top.

CAUTION: Never use highly volatile solvents. Avoid getting cleaning solution on paint as it may tend to deteriorate these finishes. Use soap and water on painted components.

SPECIFICATIONS

MODEL 80341A

Chuck size	1-16mm, 3JT
Spindle taper	MT2
Spindle travel	3.15"
Quill diameter	1.85"
Quill collar diameter	2.16"
Column diameter	2.36"
Speeds	5
RPM	575-3520
Swing	9-33"
Head tilt	45°L, 90°R
Table size	8 ⁷ / ₈ x 9"
Table slot	1/2"
Base size	10 ¹ / ₈ x 16 ³ / ₄ "
Base working surface	9 ¹ / ₂ x 9"
Drilling capacity (cast iron)	5/8"
Distance, spindle to table	3 ¹ / ₄ -15"
Distance, spindle to base	22"
Overall height	37"
Weight	100 lbs
Motor	1/2 HP, 115 V, 1725 RPM, 4.8 Amps

UNPACKING (CONTINUED)

MODEL 80342A

Chuck size	1-16mm, 3JT
Spindle taper	MT2
Spindle travel	3.15"
Quill diameter	1.85"
Quill collar diameter	2.16"
Column diameter	2.76"
Speeds	5
RPM	575-3520
Swing	9-33"
Head tilt	45°L, 90°R
Table size	10 ³ / ₈ x 10 ³ / ₈ "
Table slot	¹ / ₂ "
Base size	14 x 23 ³ / ₄ "
Base working surface	12 ⁷ / ₈ x 12 ³ / ₈ "
Drilling capacity (cast iron)	⁵ / ₈ "
Distance, spindle to table	4-30"
Distance, spindle to base	50"
Overall height	65"
Weight	150 lbs
Motor	¹ / ₂ HP, 115 V, 1725 RPM, 4.8 A

SAFETY RULES

PROPOSITION 65 WARNING: Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to the state of California to cause cancer, birth defects or other reproductive harm.

Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks and cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures vary, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area and work with approved safety equipment. Always wear **OSHA/NIOSH** approved, properly fitting face mask or respirator when using such tools.

Before any work is done, carefully read the cautions listed. Working safely prevents accidents.

BE PREPARED FOR JOB

- Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of machine.
- Wear protective hair covering to contain long hair.
- Wear safety shoes with non-slip soles.
- Wear safety glasses which comply with United States ANSI Z87.1. Everyday glasses have only impact resistant lenses. They are NOT safety glasses.
- Wear face mask or dust mask if cutting operation is dusty.
- Be alert and think clearly. Never operate power tools when tired, intoxicated or when taking medications that cause drowsiness.

WORK AREA SHOULD BE READY FOR JOB

- Keep work area clean. Cluttered work areas and work benches invite accidents.
- Do not use power tools in dangerous environments. Do not use power tools in damp or wet locations. Do not expose power tools to rain.

- Work area should be properly lighted.
- Proper electrical outlet should be available for tool. Three-prong plug should be plugged directly into properly grounded, three-prong receptacle.
- Extension cords should have a grounding prong, and the three wires of the extension cord should be of the correct gauge.
- Keep visitors at a safe distance from work area.
- Keep children out of workplace. Make workshop childproof. Use padlocks, master switches or remove switch keys to prevent any unintentional use of power tools.

TOOL SHOULD BE MAINTAINED

- Always unplug tool prior to inspection.
- Read operating instructions manual for specific maintaining and adjusting procedures.
- Keep tool lubricated.
- Use sharp cutters and keep the tool clean for safest operation.
- Remove adjusting tools. Form the habit of checking that adjusting tools are removed before turning on the machine.
- Keep all parts in working order. Check to determine that the guard or other parts will operate properly and perform their intended function.
- Check for damaged parts. Check for alignment of moving parts, binding, breakage, mounting and any other condition that may affect a tool's operation.
- Damaged parts should be properly repaired or replaced. Do not perform makeshift repairs. (Use the parts list provided to order replacement parts.)

KNOW HOW TO USE TOOL

- Use the right tool for the job. Do not force tool or attachment to do a job for which it was not designed.
- Disconnect tool when changing accessories such as bits, cutters and the like.
- Avoid accidental start-up. Make sure switch is in OFF position before plugging in.
- Do not force tool. It will work most efficiently at the rate for which it was designed.
- Handle workpiece correctly. Secure work with clamps or vise. Leave hands free to operate machine to protect hands from possible injury.
- Never leave a tool running unattended. Turn the power off and do not leave tool until it comes to a complete stop.
- Do not overreach. Keep proper footing and balance.
- Never stand on tool. Serious injury could occur if tool is tipped or if cutter is unintentionally contacted.
- Keep hands away from moving parts and cutting surfaces.
- Know your tool. Learn its operation, application and specific limitations.
- Feed work into a bit or cutter against the direction of rotation of bit or cutter.
- Turn the machine off if it jams. A cutter jams when it digs too deeply into the workpiece. (The motor force keeps it stuck in workpiece.)
- Use recommended accessories. Refer to page 13. Use of improper accessories may cause risk of injury to persons.
- Clamp workpiece or brace against column to prevent rotation.
- Use recommended speed for drill accessory and workpiece material.

WARNING: Think Safety! Safety is a combination of operator common sense and alertness at all times when drill press is being used.

ASSEMBLY

Refer to Figures 3 - 12 and 22.

MOUNT COLUMN ASSEMBLY TO BASE (80341A)

Refer to Figures 3 and 23.

- Place base on flat level surface.
- Mount column assembly to base using four hex head bolts, lock washers and flat washers.
- Push supporting yoke (Ref. No. 6) into holes at rear of base (Ref. No. 1) with bent portion of yoke facing down.
- Use strap, washers, bolts and nuts (Ref. Nos. 2 - 5) to secure yoke in position.

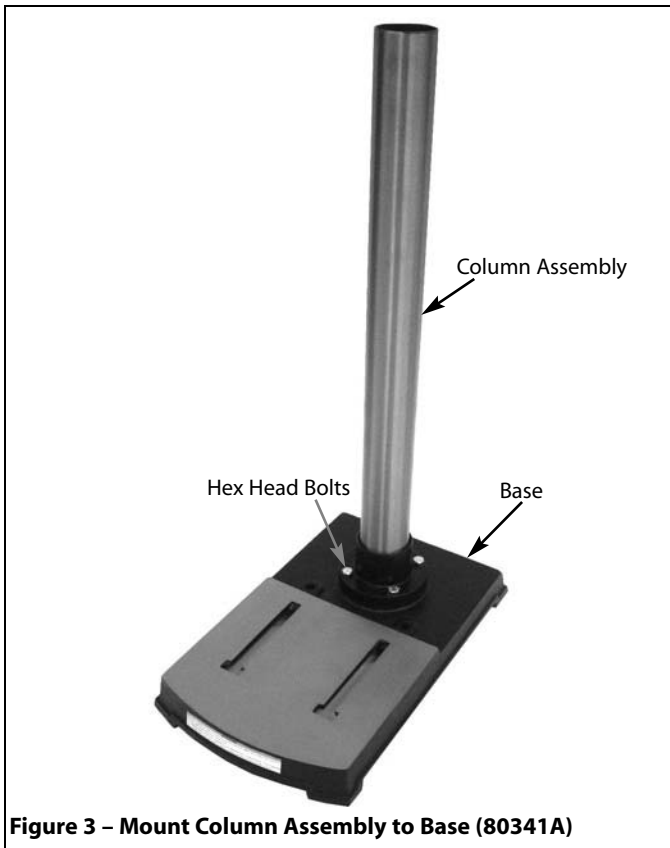


Figure 3 – Mount Column Assembly to Base (80341A)

MOUNT COLUMN ASSEMBLY TO BASE (80342A)

Refer to Figure 4.

- Place base on flat level surface.
- Mount column flange to base using four hex head bolts, lock washers and flat washers.
- Insert column into flange. Push column down until it seats in flange. Secure column in position with the two set screws.

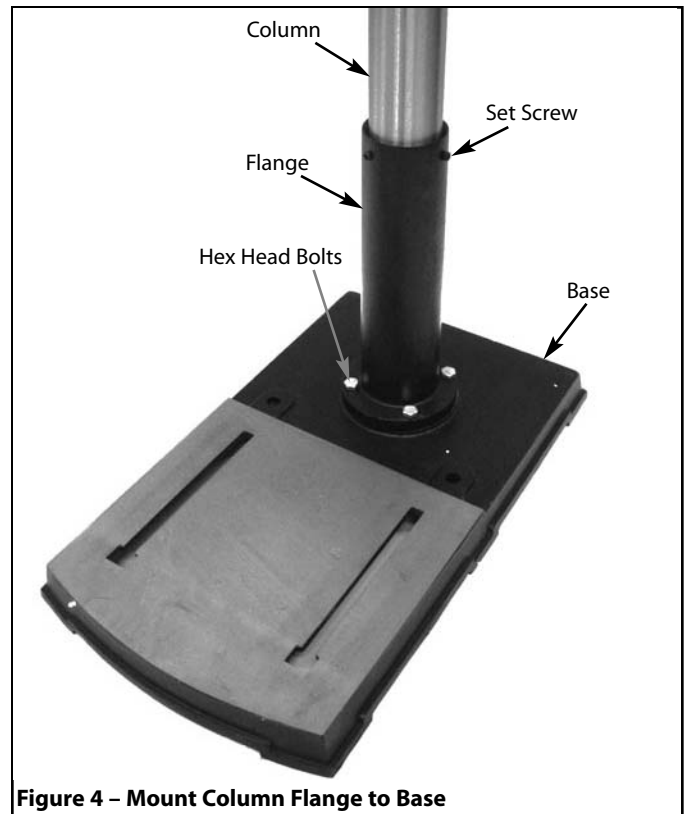


Figure 4 – Mount Column Flange to Base

MOUNT TABLE BRACKET ASSEMBLY (80341A)

Refer to Figures 5 and 6, page 4 and 5.

- Make sure worm gear is in the table bracket and engages pinion teeth.
- Place rack inside table bracket. Slide rack into the slot in the bracket so that rack teeth engage the pinion gear in the bracket. Large non-machined portion of rack should be at top.

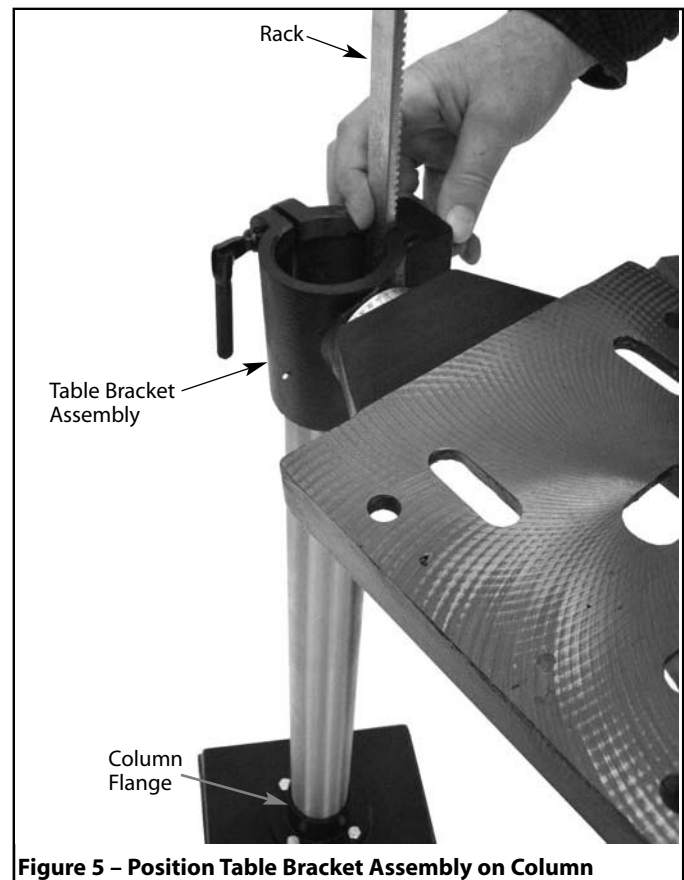


Figure 5 – Position Table Bracket Assembly on Column

ASSEMBLY (CONTINUED)

- Slide table bracket assembly with rack over column. Place bottom end of rack inside beveled edge of column flange. See Figure 5, page 4.
- Slide retaining ring over column with beveled edge down. Position ring against top of rack so that rack is in beveled edge of ring. Secure ring with set screw.
- Rotate table assembly around column. Adjust ring as necessary to prevent binding of rack.
- Attach crank handle onto worm gear shaft. Secure handle with screw, tighten screw on flat of worm gear shaft.

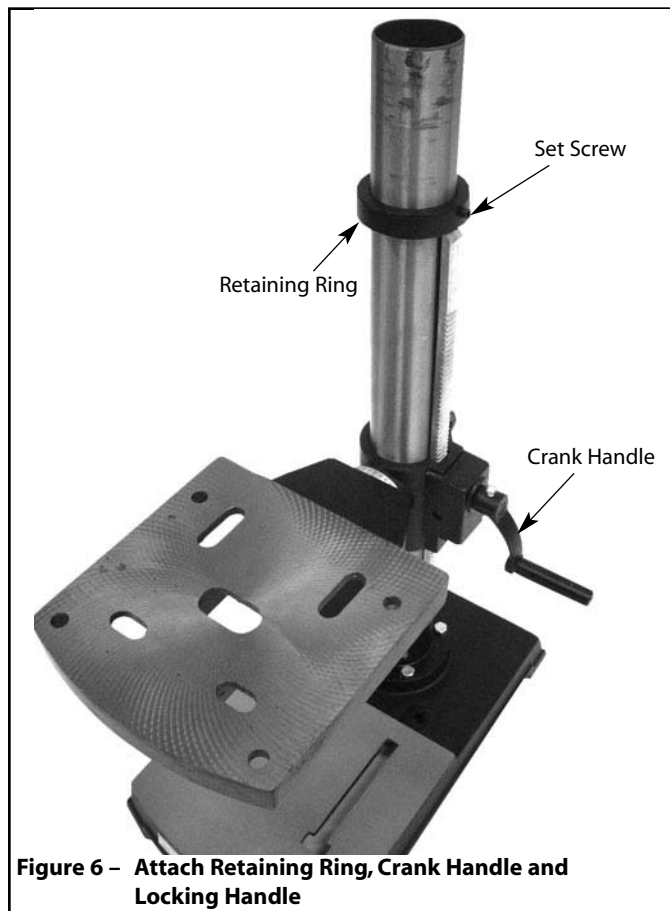


Figure 6 – Attach Retaining Ring, Crank Handle and Locking Handle

MODEL 80342A

Refer to Figures 7 and 8.

- Make sure worm gear is in the table bracket and engages pinion teeth.
- Place rack inside table bracket with large, unmachined portion of rack to the top. Slide rack onto the slot in the bracket so that rack teeth engage the pinion gear in the bracket.
- Slide table bracket assembly with rack over column. Place bottom end of rack inside beveled edge of column flange. See Figure 7.
- Slide retaining ring over column with beveled edge down. Position ring against top of rack so that rack is in beveled edge of ring. Secure ring with set screw.
- Rotate table assembly around column. Adjust ring as necessary to prevent binding of rack.
- Attach crank handle onto worm gear shaft. Secure handle with screw, tighten screw on flat of worm gear shaft.

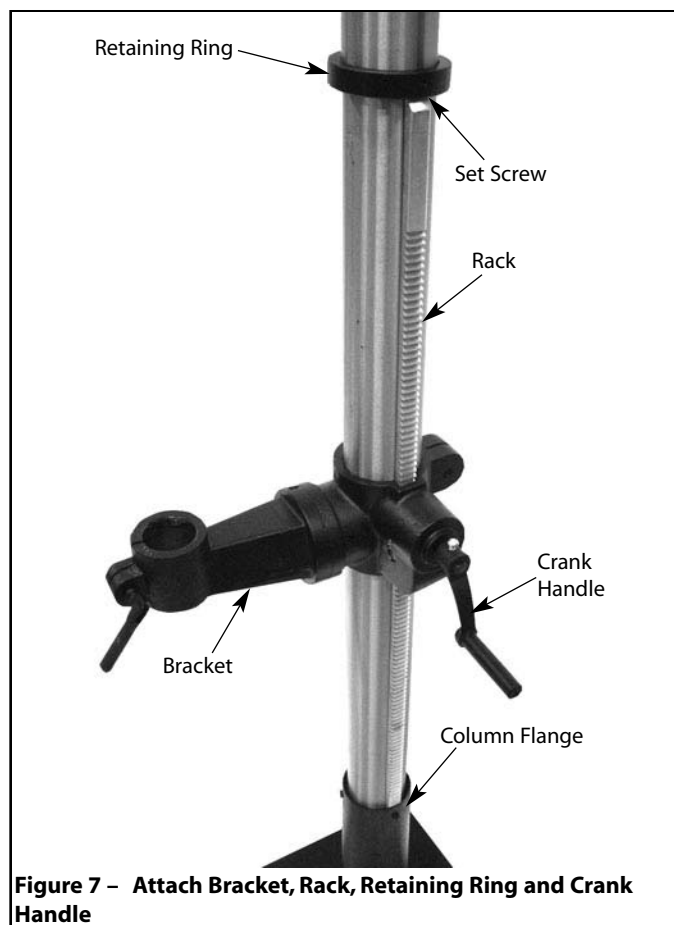


Figure 7 – Attach Bracket, Rack, Retaining Ring and Crank Handle

- Insert the extension arm into the table arm bracket assembly. **NOTE:** The table can be installed directly to the table arm bracket assembly.
- Insert the table into the extension arm.
- Tighten locking handles to secure table, extension arm and bracket.

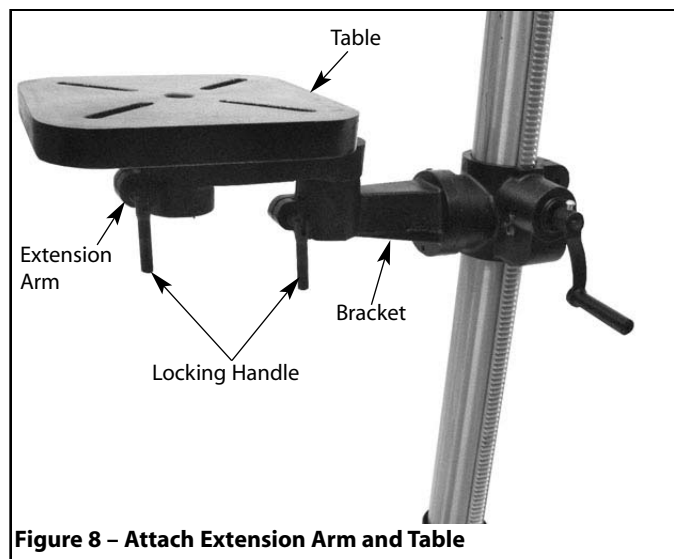


Figure 8 – Attach Extension Arm and Table

ASSEMBLY (CONTINUED)**MOUNT HEAD ASSEMBLY**

Refer to Figures 9 and 10.

WARNING: Although compact, the drill press head assembly is heavy. Two people are required to mount the drill press head assembly onto the column.

- Place locking shoe into the cavity in the ram bracket.

WARNING: Do not install the head assembly onto column unless the locking shoe is in place. The head assembly cannot be properly secured to the column without locking shoe.

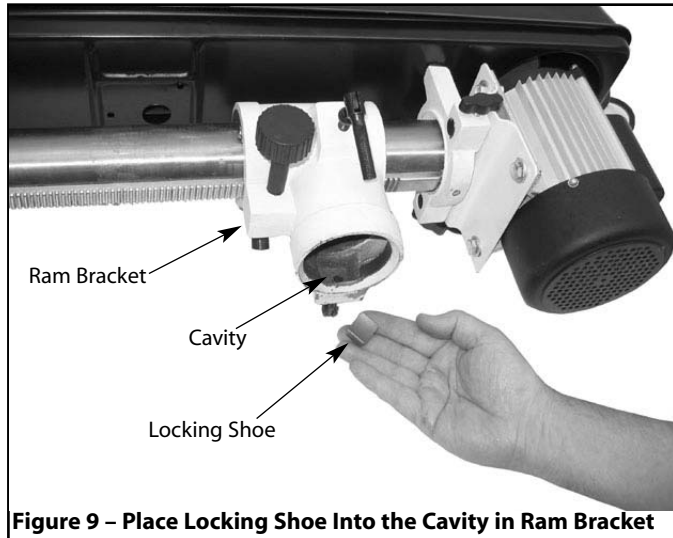


Figure 9 – Place Locking Shoe Into the Cavity in Ram Bracket

- Slide drill press head assembly onto top of column.
- Position head so that it is centered over base.
- Secure head assembly into position by tightening the locking handles (see Figure 10).

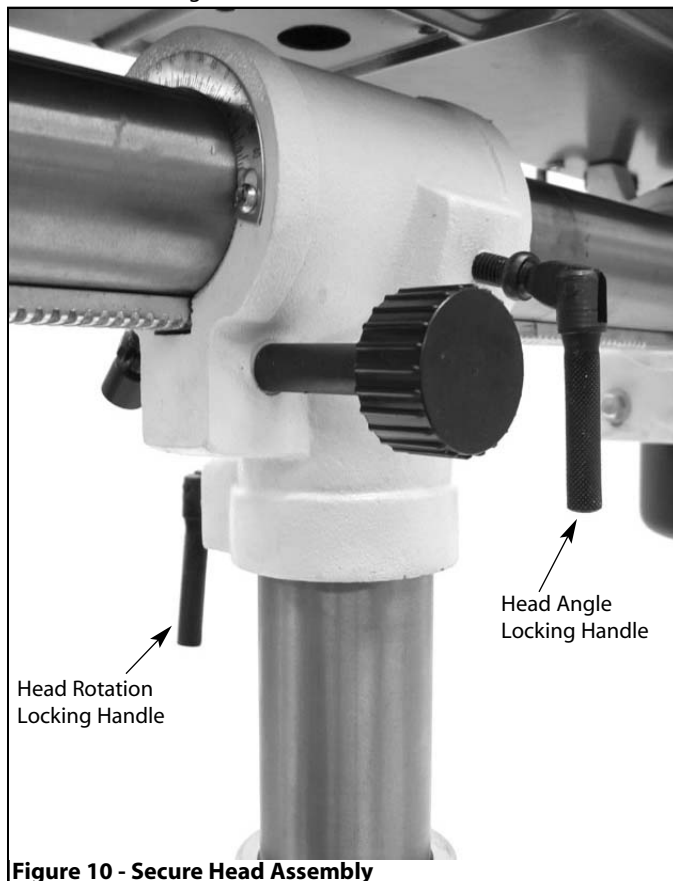


Figure 10 - Secure Head Assembly

MOUNT CHUCK AND ARBOR

Refer to Figure 22, page 12.

- Be sure spindle, arbor and chuck tapers are clean and dry. Make sure quill is completely retracted.
- Use the provided chuck key (Ref. No. 1) to adjust the jaws of the chuck (Ref. No. 2) until they are recessed inside the drill chuck body.
- Place drill chuck on a workbench face down. Arbor (Ref. No. 80) has a short taper and a long taper. Place short taper into top of drill chuck and tap with a rubber or wooden mallet.
- Slide arbor into the spindle (Ref. No. 4) while slowly rotating drill chuck. Spindle has a rectangular pocket in which the tang fits into. Once tang is oriented correctly, drill chuck will not rotate without turning the spindle.
- Tap the end of drill chuck with a rubber or wooden mallet to seat it into the spindle.
- Use a hammer to carefully tap chuck securely onto the spindle.

MOUNT QUILL FEED HANDLES

Refer to Figure 11.

- Thread the three quill feed handles into the threaded holes on the pinion hub.

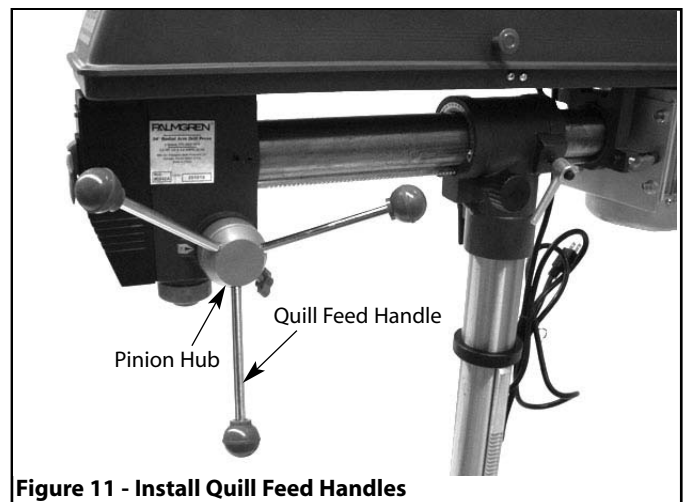


Figure 11 - Install Quill Feed Handles

ADJUST V-BELT TENSION

Refer to Figure 12.

- Open the pulley cover and loosen both motor lock knobs (one on each side of the head).
- Push motor back to apply tension to v-belt.
- Correct tension is obtained when the v-belt can be flexed approximately $\frac{3}{8}$ " at belt midpoint using finger pressure.
- When correct tension is obtained, secure motor in position by tightening motor lock knobs.

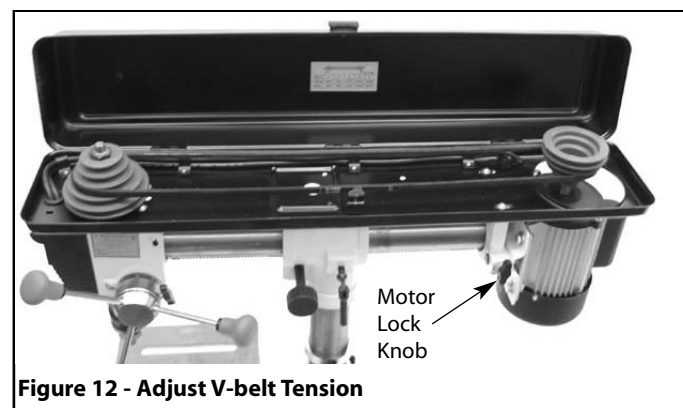


Figure 12 - Adjust V-belt Tension

INSTALLATION

MOUNT DRILL PRESS

Refer to Figure 13, page 7.

WARNING: The drill press must be mounted securely to a stand, bench or floor to prevent tipping of the machine which could cause severe personal injury.

- Drill press must be mounted to flat level surface. Use shims or machine mounts if necessary.
- Be sure to bolt drill press to floor or bench securely to prevent tipping and minimize vibration.
- Tighten all nuts and bolts that may have loosened during shipment.



Figure 13 - Secure Drill Press to Bench or Stand

POWER SOURCE

The motor is designed for operation on the voltage and frequency specified. Normal loads will be handled safely on voltages not more than 10% above or below the specified voltage.

Running the unit on voltages which are not within the range may cause overheating and motor burn out. Heavy loads require that the voltage at motor terminals be no less than the voltage specified.

Drill press requires a 115 volt, 60 Hz power source.

GROUNDING INSTRUCTIONS

WARNING: Improper connection of equipment grounding conductor can result in the risk of electrical shock. Equipment should be grounded while in use to protect operator from electrical shock. Check with a qualified electrician if grounding instructions are not understood or if in doubt as to whether the tool is properly grounded.

This tool is equipped with an approved 3-conductor cord rated up to 150V and a 3-prong grounding type plug (see Figure 14) for your protection against shock hazards.

Grounding plug should be plugged directly into a properly installed and grounded 3-prong grounding-type receptacle, as shown (Figure 14).

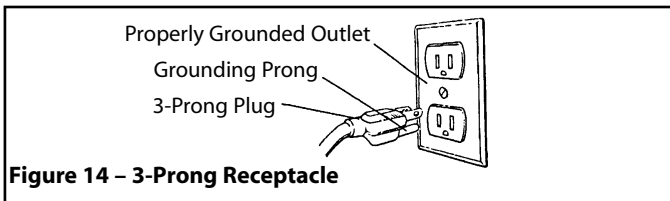


Figure 14 - 3-Prong Receptacle

Do not remove or alter grounding prong in any manner. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electrical shock.

WARNING: Do not permit fingers to touch the terminals of plug when installing or removing from outlet.

Plug must be plugged into matching outlet that is properly installed and grounded in accordance with all local codes and ordinances. Do not modify plug provided. If it will not fit in outlet, have proper outlet installed by a qualified electrician.

Inspect tool cords periodically, and if damaged, have repaired by an authorized service facility.

Green (or green and yellow) conductor in cord is the grounding wire. If repair or replacement of the electric cord or plug is necessary, do not connect the green (or green and yellow) wire to a live terminal.

Where a 2-prong wall receptacle is encountered, it must be replaced with a properly grounded 3-prong receptacle installed in accordance with National Electric Code and local codes and ordinances.

WARNING: This work should be performed by a qualified electrician.

A temporary 3-prong to 2-prong grounding adapter (see Figure 15) is available for connecting plugs to a two pole outlet if it is properly grounded.

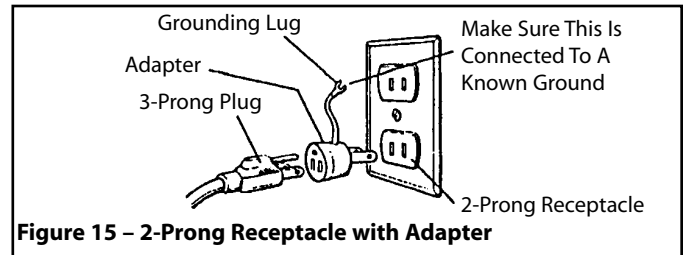


Figure 15 - 2-Prong Receptacle with Adapter

Do not use a 3-prong to 2-prong grounding adapter unless permitted by local and national codes and ordinances.

(A 3-prong to 2-prong grounding adapter is not permitted in Canada.) Where permitted, the rigid green tab or terminal on the side of the adapter must be securely connected to a permanent electrical ground such as a properly grounded water pipe, a properly grounded outlet box or a properly grounded wire system.

Many cover plate screws, water pipes and outlet boxes are not properly grounded. To ensure proper ground, grounding means must be tested by a qualified electrician.

EXTENSION CORDS

- The use of any extension cord will cause some drop in voltage and loss of power.
- Wires of the extension cord must be of sufficient size to carry the current and maintain adequate voltage.
- Use the table to determine the minimum wire size (A.W.G.) extension cord.
- Use only 3-wire extension cords having 3-prong grounding type plugs and 3-pole receptacles which accept the tool plug.
- If the extension cord is worn, cut, or damaged in any way, replace it immediately.

EXTENSION CORD LENGTH

Wire Size.....	A.W.G.
Up to 25 ft.....	18
25-100 ft.....	16
100-150 ft.....	14

NOTE: Using extension cords over 150 ft. long is not recommended.

INSTALLATION (CONTINUED)

ELECTRICAL CONNECTIONS

WARNING: All electrical connections must be performed by a qualified electrician. Make sure unit is off and disconnected from power source while motor is mounted, connected, reconnected or anytime wiring is inspected.

- The motor is wired for 115 volts and in a clockwise rotation as viewed from shaft end of motor.
- The motor cord must be secured to protect the wiring connections from possible strain.
- The power supply to motor is controlled by a locking rocker switch. Power lines are connected to the quick connect terminals of the switch.
- The green ground line must remain securely fastened to the motor ground terminal and drill press head to provide proper grounding.

OPERATION

WARNING: Read and understand operating instructions and parts manual before operating this machine.

CAUTION: The operation of any power tool can result in foreign objects being thrown into the eyes, which can result in severe eye damage. Always wear safety glasses complying with United States ANSI Z87.1 (shown on package) before commencing power tool operation.

ON/OFF SWITCH

Refer to Figure 16.

The ON/OFF switch is located on the front of the drill press head. To turn the drill press On, move the switch up to the ON position. To turn the drill press Off, move the switch down to the OFF position.

The drill press can be locked from unauthorized use by locking the switch. To lock the switch:

- Turn the switch to OFF position and disconnect drill press from power source.
- Pull the key out. The switch cannot be turned on with the key removed.

NOTE: Should the key be removed from the switch at the ON position, the switch can be turned off but cannot be turned on again.

- To replace key, slide key into the slot on switch until it snaps.

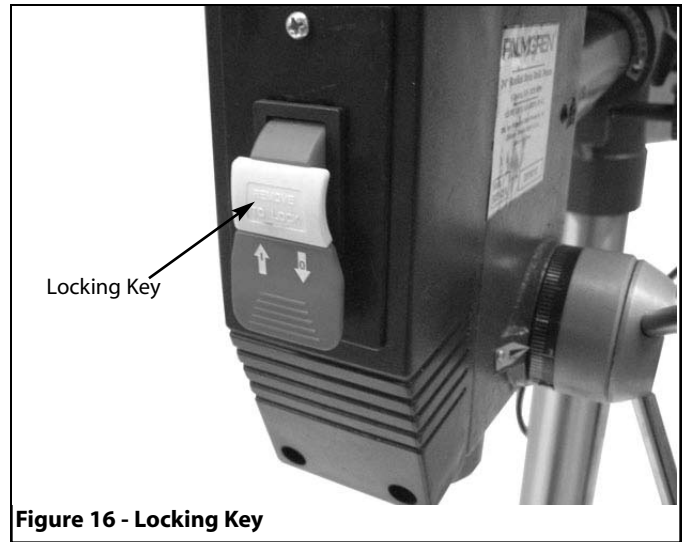


Figure 16 - Locking Key

SPEED ADJUSTMENTS

Refer to Figures 12 and 17.

WARNING: Be sure drill press is turned off and is disconnected from power source before adjusting speeds.

- To change spindle speed, loosen motor lock knob (see Figure 14), and push the motor toward front of drill press. This will loosen the belt and permit relocating the belt to the desired pulley groove for the required spindle speed (See Figure 17).
- After belt has been repositioned, push motor toward rear of drill press and tighten motor lock knob.
- Check belt for proper tension and make any final adjustment. A belt is properly tensioned when light pressure applied to mid-point of the belt produces about 3/8" deflection.

HEAD ADJUSTMENTS

Refer to Figures 18 and 19, page 9.

WARNING: Be sure drill is turned off and is disconnected from power source before adjusting head.

- Head can be tilted 45° right and 90° left.
- To tilt head loosen head angle lock handle. Then pull out guide pin and turn guide pin 90°.
- Tilt head to desired angle, aligning reference mark on ram with corresponding angle on the scale. Secure in position by tightening head angle lock handle.

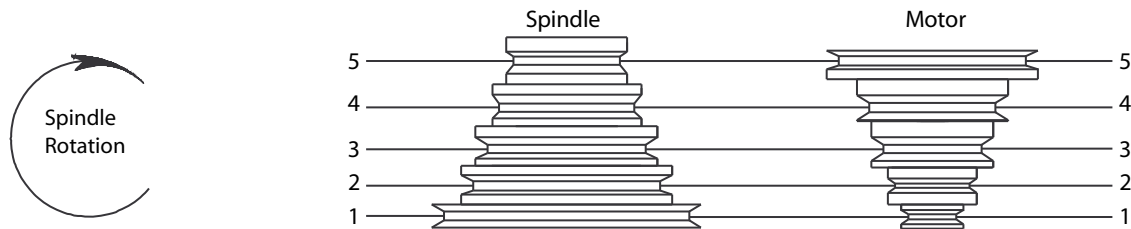


Figure 17 – Spindle Speed Adjustment

Recommended Drill Size per Material for 5 Speeds

Belt Location	RPM	Wood		Zinc Diecast		Alum. & Brass		Plastic		Cast Iron & Bronze		Steel Mild & Malleable		Steel Cast & Med. Carbon		Steel Stainless & Tool	
		in/mm		in/mm		in/mm		in/mm		in/mm		in/mm		in/mm		in/mm	
5-5	3520	5/16	7.9	3/16	4.8	11/64	4.4	5/32	4.0	7/64	2.8	3/32	2.4	1/16	1.6	1/32	0.8
4-4	2630	3/8	9.5	1/4	6.4	7/32	5.6	3/16	4.8	1/8	3.2	3/32	2.4	1/16	1.6	3/64	1.2
3-3	1860	5/8	15.9	3/8	9.5	11/32	8.7	5/16	7.9	1/4	6.4	5/32	4.0	1/8	3.2	1/16	1.6
2-2	1120	7/8	22.2	1/2	12.7	15/32	11.9	7/16	11.1	11/32	8.7	1/4	6.4	3/16	4.8	1/8	3.2
1-1	575	1 1/4	31.8	3/4	19.0	11/16	17.5	5/8	15.9	1/2	12.7	3/8	9.5	5/16	7.9	1/4	6.4

OPERATION (CONTINUED)

- To return head to 0° vertical position, loosen head angle lock handle, rotate guide pin 90° and tilt head. The guide pin will snap into slot at 0° vertical. Secure in position by tightening head angle lock handle.
- To move head forward and backward, loosen head angle lock handle. Turn head traverse knob until head is in desired position. Secure head by tightening head angle lock handle.
- To rotate head about the column, loosen head rotation lock handle. Rotate head to desired position and secure by tightening head rotation lock handle.

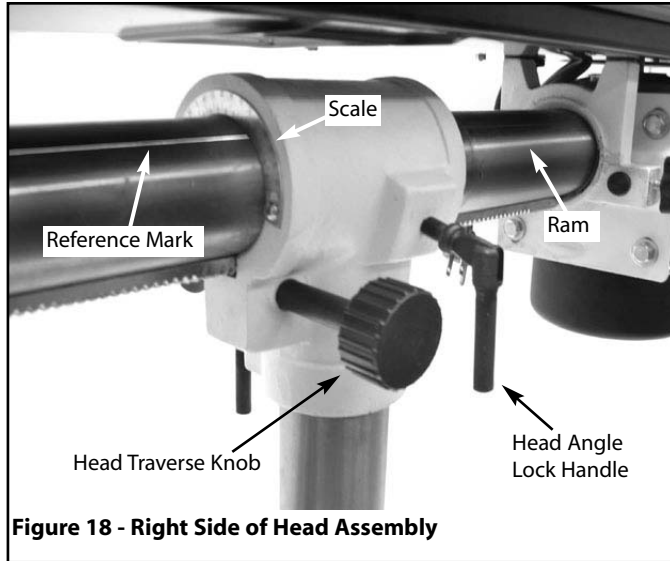


Figure 18 - Right Side of Head Assembly

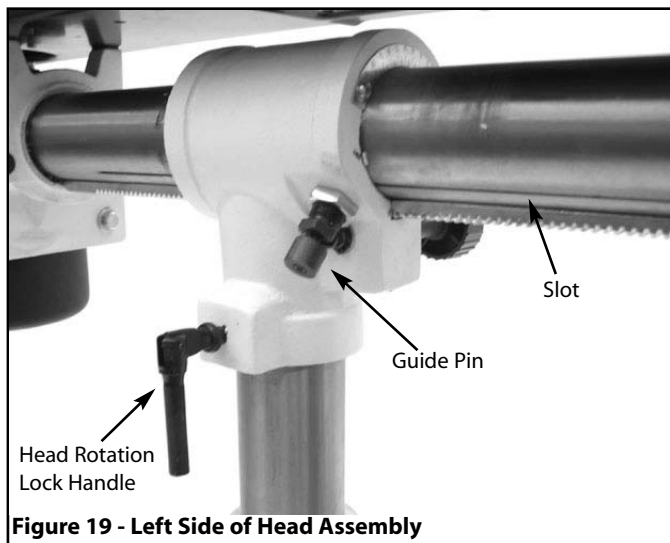


Figure 19 - Left Side of Head Assembly

TABLE ADJUSTMENTS

- Height adjustments: To adjust table, loosen locking handle and turn crank handle to desired height. Immediately retighten table bracket locking handle.
- Rotation of work table : Loosen table locking handle and rotate table to desired position and retighten handle. (Refer to Figure 7, page 5).
- Tilting work table: Loosen hex head bolt. Remove pin and nut. To do this, tighten nut until pin slips out easily. Tilt table to desired angle up to 45° and retighten hex head bolt. Reinsert pin and nut when returning the table to 0° position.
- To obtain more distance between chuck and table, the work table can be rotated 180° and base can be used as a work surface. This permits drilling of larger objects.

- Clamp table securely after adjustments have been made. (See Figure 20).

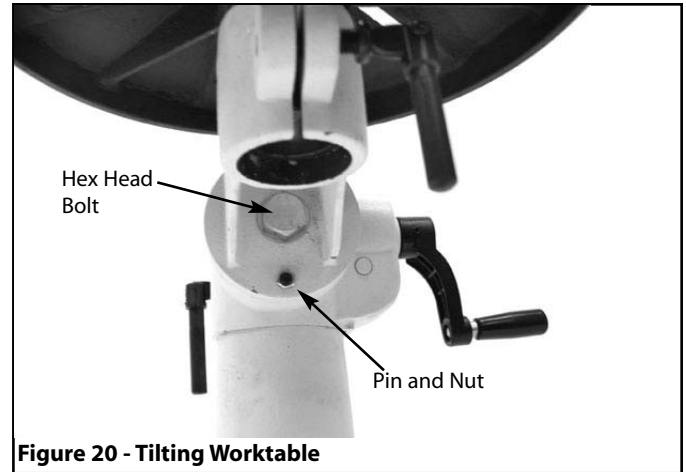


Figure 20 - Tilting Worktable

DEPTH STOP ADJUSTMENT

Refer to Figure 21.

To control drilling depth, loosen hub locking knob and rotate hub until the desired depth on scale coincides with the pointer. Tighten knob to secure hub in position. Use this feature to drill more than one hole to the same depth.

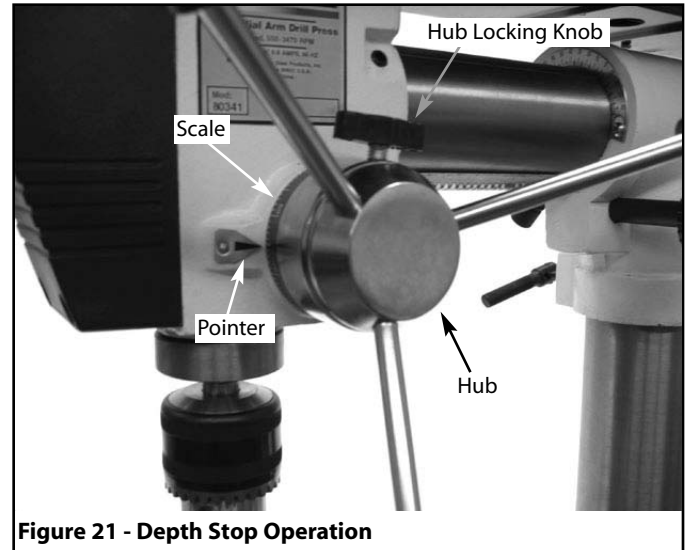


Figure 21 - Depth Stop Operation

MOUNT DRILL BIT

WARNING: Be sure drill press is turned off and is disconnected from power source before adjusting speeds.

- Place drill bit in jaws of drill chuck.
- Tighten chuck with drill chuck key. Be sure to tighten the chuck using all three key positions on the chuck body and remove chuck key.

MAINTENANCE

WARNING: Turn switch off and remove plug from power source outlet before maintaining or lubricating your drill press

V-BELT

Replace V-belt when worn.

LUBRICATION

The ball bearings are lubricated at the factory and need no further lubrication. Using 20wt. non detergent oil, periodically lubricate the splines (grooves) in the spindle and the rack (teeth on the quill) as follows:

- Lower spindle assembly (Figure 22, Ref. No. 3) all the way down.
- Apply lubricant around the inside of the hole in the spindle pulley (Figure 22, Ref. No. 72).
- Apply lubricant to rack (teeth) on quill (Figure 22, Ref. No. 6) while extended below drill press head.
- Apply lubricant to rack and pinion gear (Figures 23 and 24, Ref. Nos. 11 and 22) on column and table assembly.

CLEAN MOTOR

Frequently blow out any dust that may accumulate inside motor. If power cord is worn, cut or damaged in any way, have it replaced immediately.

TROUBLESHOOTING

SYMPTOM	POSSIBLE CAUSES	CORRECTIVE ACTION
Spindle does not turn	<ol style="list-style-type: none"> 1. No power to drill press 2. Defective switch 3. Defective motor 	<ol style="list-style-type: none"> 1. Check wiring, fuse or circuit breaker 2. Replace switch 3. Replace motor
Noisy spindle	Defective bearings	Replace bearings
Noisy operation	<ol style="list-style-type: none"> 1. Incorrect belt tension 2. Dry spindle 3. Loose spindle 4. Loose motor pulley 	<ol style="list-style-type: none"> 1. Adjust tension 2. Lubricate spindle 3. Tighten pulley nut 4. Tighten set screw in pulley
Bit burns or smokes	<ol style="list-style-type: none"> 1. Incorrect speed 2. Chips not coming out of table 3. Dull bit 4. Feeding too slow 5. Bit not lubricated 6. Bit running backwards 	<ol style="list-style-type: none"> 1. Change speed 2. Retract bit frequently to clear chips 3. Sharpen or replace bit 4. Feed faster; enough to allow drill to cut 5. Lubricate bit 6. Check motor rotation to be sure it is clockwise facing shaft end
Excessive drill runout or wobble	<ol style="list-style-type: none"> 1. Bent bit 2. Bit not properly installed in chuck 3. Chuck not properly installed 4. Worn spindle bearings 	<ol style="list-style-type: none"> 1. Replace bit 2. Install bit properly 3. Install chuck properly 4. Replace bearings
Drill bit binds in workpiece	<ol style="list-style-type: none"> 1. Workpiece pinching bit or excessive feed 2. Improper belt tension 3. Workpiece not supported or clamped properly 	<ol style="list-style-type: none"> 1. Support or clamp work, decrease feed pressure 2. Adjust tension tighter 3. Support or clamp workpiece securely

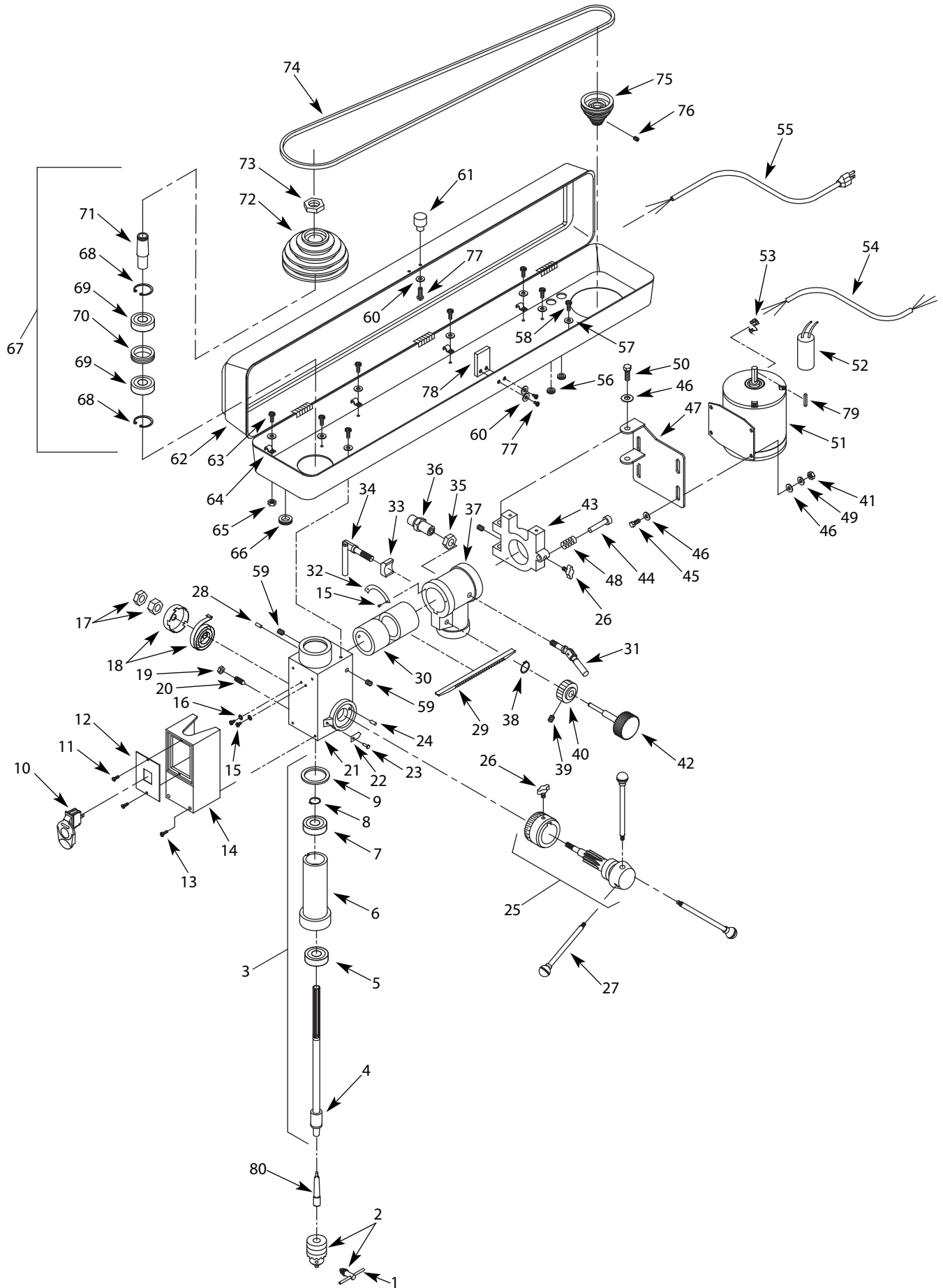


Figure 22 - Replacement Parts Illustration for Head

REPLACEMENT PARTS LIST FOR HEAD

Ref. No.	Description	Part No.	Qty.	Ref. No.	Description	Part No.	Qty.
1	Chuck Key	30535.00	1	41	8-1.25mm Hex Nut	*	4
2	Chuck with Key (incl. Ref No. 1)	30536.00	1	42	Knob	30557.00	1
3	Lower Spindle Assembly (incl. Ref. Nos. 4-9)	30537.00	1	43	Bracket	30558.00	1
4	Spindle	30538.00	1	44	Tension Adjustment Bar	30559.00	1
5	6005Z Ball Bearing	00956.00	1	45	8-1.25 x 25mm Hex Head Bolt	*	4
6	Quill	30539.00	1	46	8mm Flat Washer	*	12
7	6003Z Ball Bearing	05092.00	1	47	Motor Mount Plate	30560.00	1
8	3AMI-17 Retaining Ring	00341.00	1	48	Spring	30578.00	1
9	Rubber Bumper	30540.00	1	49	8mm Lock Washer	*	4
10	Switch	26035.00	1	50	8-1.25 x 20mm Hex Head Bolt	*	4
11	4-1.6 x 12mm Threadforming Screw	22655.00	2	51	Motor (incl. Ref. Nos. 52-54)	30561.00	1
12	Switch Plate	30541.00	1	52	Capacitor	30562.00	1
13	5-0.8 x 14mm Pan Head Screw	*	4	53	Strain Relief	01413.00	1
14	Cover	30542.00	1	54	Motor Cord	30563.00	1
15	4-0.7 x 5mm Pan Head Screw	*	4	55	Line Cord	30564.00	1
16	4mm Serrated Washer	*	2	56	Grommet	30565.00	2
17	12-1.50mm Hex Nut	07817.00	2	57	6mm Flat Washer	*	8
18	Cap cover and spring	30543.00	1	58	6-1.0 x 12mm Pan Head Screw	*	4
19	10-1.5mm Hex Nut	*	1	59	8-1.25 x 8mm Set Screw	*	3
20	10-1.5 x 30mm Dog Point Set Screw	30579.00	1	60	5mm Flat Washer	*	3
21	Drill Press Head	30544.00	1	61	Knob	30566.00	1
22	Pointer	22620.00	1	62	Pulley Housing	30567.00	1
23	Rivet	22621.00	1	63	6-1.0 x 14mm Pan Head Screw	*	4
24	Threaded Pin	30545.00	1	64	Cord Clamp	30568.00	4
25	Quill Feed Assembly (incl. Ref. Nos. 26 and 27)	30546.00	1	65	6-1.0mm Hex Nut	*	4
26	Knob	22622.00	2	66	Grommet	04076.00	1
27	Handle with grip	30547.00	3	67	Upper Spindle Assembly (incl. Ref. Nos. 68-71)	30569.00	1
28	4 x 25mm Spring Pin	01509.00	1	68	3BMI-47 Retaining Ring	04790.00	2
29	Radial Rack	30548.00	1	69	6204ZZ Ball Bearing	00803.00	2
30	Ram	30549.00	1	70	Spacer	30570.00	1
31	Handle	30577.00	1	71	Upper Spindle Sleeve	30571.00	1
32	Scale	30550.00	1	72	Spindle Pulley	30572.00	1
33	Locking Shoe	30551.00	1	73	Pulley Nut	30573.00	1
34	Handle	30552.00	2	74	V-Belt	30574.00	1
35	16-2.0mm Hex Nut	*	1	75	Motor Pulley	30575.00	1
36	Guide Pin Assembly	30553.00	1	76	6-1.0 x 10mm Set Screw	*	1
37	Ram Bracket (Model 80341)	30554.00	1	77	5-0.8 x 10mm Pan Head Screw	*	3
37	Ram Bracket (Model 80342)	30555.00	1	78	Latch	30576.00	1
38	3AMI-10 Retaining Ring	00221.00	1	79	5 x 5 x 40mm Key	07885.00	2
39	5-0.8 x 6mm Set Screw	*	1	80	Arbor	18908.00	1
40	Gear	30556.00	1	Δ	Operator's Manual	30982.29	1

* Standard hardware item available locally.

Δ Not shown.

Recommended Accessories		
Δ	Multi Tool Stand	70102
Δ	Drill Press Guard	15008
Δ	3" Drill Press Vise	12303
Δ	4" Drill Press Vise	12403

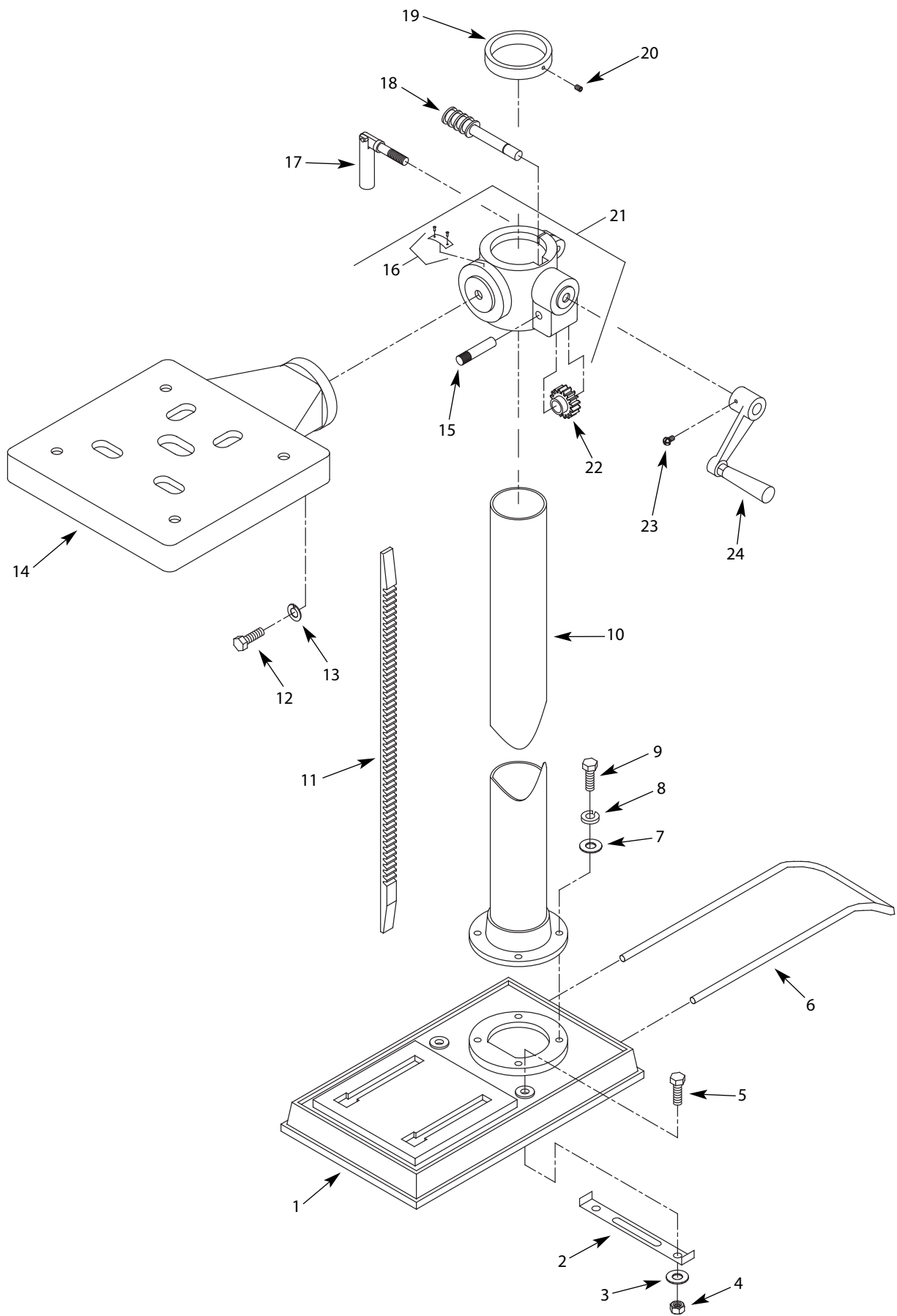


Figure 23 - Replacement Parts Illustration for Base (Model 80341A)

REPLACEMENT PARTS LIST FOR BASE (MODEL 80341A)

Ref. No.	Description	Part Number	Qty.
1	Base	30898.00	1
2	Clamp	30899.00	1
3	10mm Flat Washer	*	2
4	10-1.5mm Hex Nut	*	2
5	10-1.5 x 30mm Hex Head Bolt	*	2
6	Supporting Yoke	30900.00	1
7	8mm Flat Washer	*	4
8	8mm Lock Washer	*	4
9	8-1.25 x 30mm Hex Head Bolt	*	4
10	Column Assembly	30901.00	1
11	Rack	30902.00	1
12	12-1.75 x 30mm Hex Head Bolt	*	1
13	12mm Lock Washer	*	1
14	Table	30903.00	1
15	Pinion Gear Shaft	30904.00	1
16	Scale with Rivets	30905.00	1
17	Locking Handle	30906.00	1
18	Worm Gear	30907.00	1
19	Rack Retaining Ring	30908.00	1
20	8-1.25 x 10mm Set Screw	*	1
21	Table Bracket Assembly (Incl.Ref. Nos. 15, 16, & 22)	30909.00	
22	Pinion Gear	30910.00	1
23	5-0.8 x 12mm Pan Head Screw	*	1
24	Crank	30911.00	1

* Standard hardware item available locally.

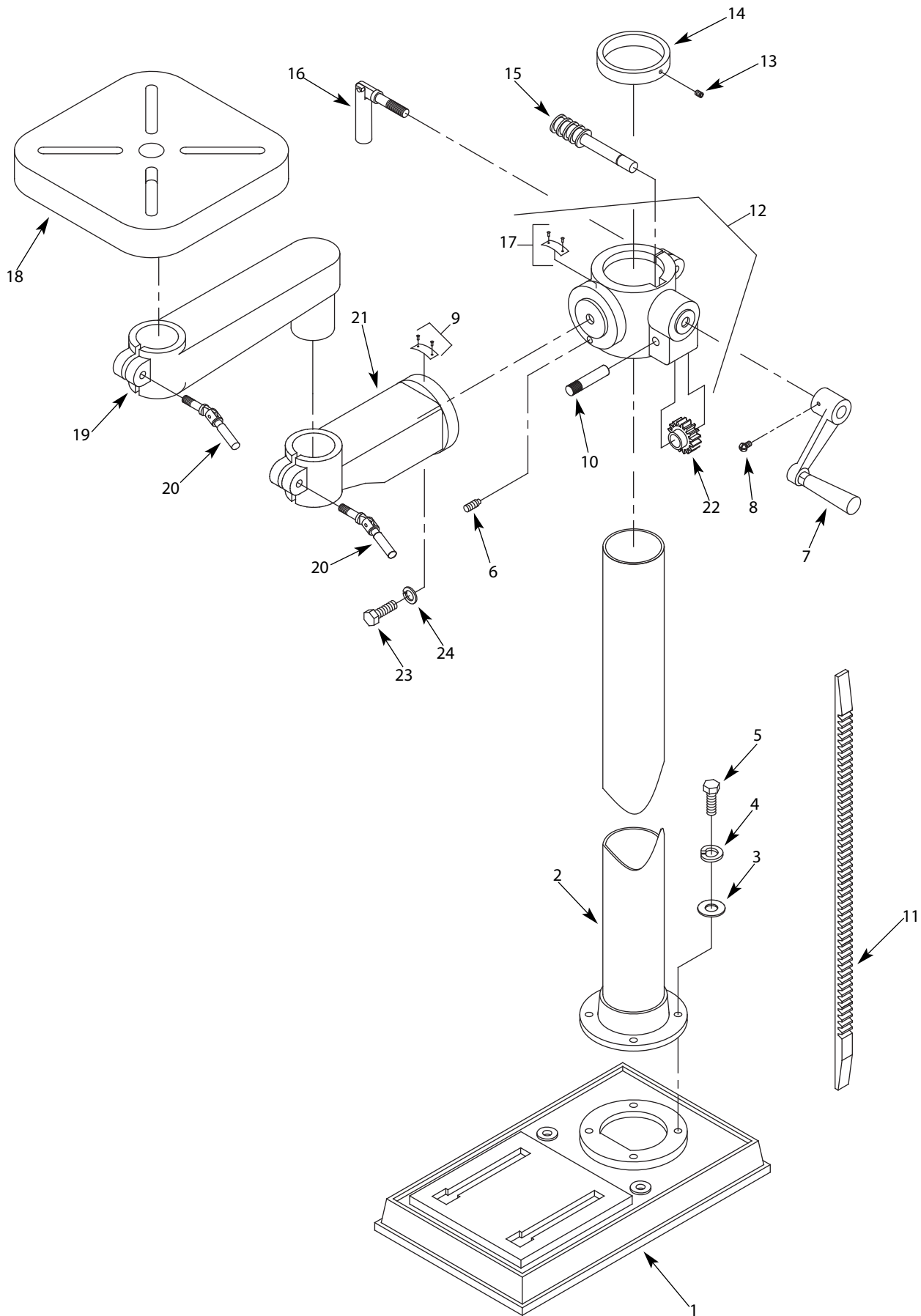


Figure 24 - Replacement Parts Illustration for Base (Model 80342A)

REPLACEMENT PARTS LIST FOR BASE (MODEL 80342A)

Ref. No.	Description	Part Number	Qty.
1	Base	30912.00	1
2	Column Assembly	30913.00	1
3	10mm Flat Washer	*	4
4	10mm Lock Washer	*	4
5	10-1.5 x 35mm Hex Head Bolt	*	4
6	6-1.0 x 10mm Dog Point Set Screw	06858.00	1
7	Crank Handle	30915.00	1
8	5-0.8 x 12mm Pan Head Screw	*	1
9	Indicator with Rivets	30927.00	1
10	Pinion Gear Shaft	30917.00	1
11	Rack	30914.00	1
12	Table Bracket Assembly (Incl. Ref. No. 9, 10 & 17)	30918.00	1
13	6-1.0 x 12mm Set Screw	*	1
14	Rack Retaining Ring	30919.00	1
15	Worm Gear	30920.00	1
16	Locking Handle	30921.00	1
17	Scale with Rivets	30922.00	1
18	Table	30923.00	1
19	Table Arm Extension	30924.00	1
20	Locking Handle	30925.00	2
21	Table Arm	30926.00	1
22	Pinion Gear	30916.00	1
23	16-2.0 x 25mm Hex Head Bolt	*	1
24	16mm Lock Washer	*	1

* Standard hardware item available locally.

LIMITED WARRANTY

Palmgren warrants their products to be free of deficiency in material or workmanship. The duration of this warranty is expressly limited to one year parts and labor unless otherwise noted beginning from the date of delivery to the original user. The following Palmgren products carry the following warranties on parts with a 1 year warranty on labor:

- USA Machine vises – Lifetime
- Imported Machine vises – 2 years
- Bench vises – 2 years
- Positioning tables – 2 years
- Bench grinders & buffers – 3 years
- Tapping machines – 2 years
- Drilling machines – 2 years
- Finishing machines – 2 years
- Band saws – 2 years
- Work stands – 2 years

The obligation of Palmgren is limited solely to the repair or replacement, at our option, at its factory or authorized repair agent of any part that should prove deficient. The warranty does not cover expendable and/or wear parts (i.e. v-belts, coated abrasives), damage to tools arising from alteration, abuse or use other than their intended purpose, packing and freight. Purchaser must lubricate and maintain the product under normal operating conditions at all times. Proper use and care instructions are provided in the operator's manual. Failure to follow these instructions will void the warranty.

This warranty is the purchaser's exclusive remedy against Palmgren for any deficiency in its products. Under no circumstances is Palmgren liable for any direct, indirect, incidental, special or consequential damages including lost profits in any way related to the use or inability to use our products. This warranty gives you specific legal rights which may vary from state to state.

SERVICE & REPAIR

1. If a Palmgren product requires a repair or warranty service **DO NOT** return the product to the place of purchase.
2. All warranty related work must be evaluated and approved by Palmgren.
3. Prior to returning any item the user must obtain factory approval and a valid RGA number.
4. For instructions and RGA number call toll free (800) 621-6145.