

Original Instruction Manual

DP25B

Bench Top Drill Press

Version 3.0
January 2014



To register this product please visit
www.recordpower.info

It is important to register your product as soon as possible in order to receive efficient after sales support and be entitled to the full **5 year guarantee**. Your statutory rights are not affected. Please see back cover for contact details.



Always wear safety glasses when using woodworking equipment.



Always read the instructions provided before using woodworking equipment.



Important

For your safety read instructions carefully before assembling or using this product. Save this manual for future reference.








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1. Explanation of Symbols

THE SYMBOLS AND THEIR MEANINGS SHOWN BELOW MAY BE USED THROUGHOUT THIS MANUAL. PLEASE ENSURE THAT YOU TAKE THE APPROPRIATE ACTION WHEREVER THE WARNINGS ARE USED.

Mandatory Instructions

-  Read and fully understand the instruction manual before attempting to use the machine.
-  Indicates an instruction that requires particular attention
-  Wear protective eyewear
-  Use respiratory protective equipment
-  Use hearing protection
-  Use suitable protective footwear
-  Use protective work gloves

Warning

-  Indicates a risk of severe personal injury or damage to the machine
-  Indicates a risk of severe personal injury from electrical shock
-  Risk of personal injury from lifting of heavy items
-  Indicates a risk of severe personal injury from airborne objects
-  Risk of fire

2. General Health & Safety Guidance

Ensure that you carefully read and fully understand the instructions in this manual before assembly, installation and use of this product. Keep these instructions in a safe place for future reference.

WARNING: for your own safety, do not attempt to operate this machine until it is completely assembled and installed according to these instructions.

WARNING: When using any machine, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury.

Safe Operation

1. Use Personal Protective Equipment (PPE)

- The operation of any machine can result in foreign objects being thrown into your eyes, which can result in severe eye damage. Protective eyewear or other suitable eye protection or face shield should be used at all times. Everyday spectacles only have impact resistant lenses. They are not protective eyewear and do not give additional lateral protection.
- Use respiratory protective equipment (dust mask etc.) if the machining operation creates dust. Exposure to high levels of dust created by machining hardwoods, softwoods and man made composite boards can result in serious health problems. Some imported hardwoods give off highly irritating dust, which can cause a burning sensation. The use of respiratory protective equipment should not be seen as an alternative to controlling the risk of exposure at source by using adequate dust extraction equipment.
- The use of ear plugs or ear defenders is recommended when the machine is in use, particularly if the noise level exceeds 85 dB.
- Wear suitable protective gloves when handling cutting tools or blades. Gloves should NOT be worn when using the machine as they can be caught in moving parts of the machine.
- Non-slip safety footwear is recommended when using the machine and handling large work pieces.

2. Dress appropriately

- Do not wear loose clothing, neckties or jewellery; they can be caught in moving parts of the machine.
- Roll up long sleeves above the elbow.
- Wear protective hair covering to contain long hair.

3. Safety warnings

- Find and read any warning labels on the machine

- It is important that any labels bearing health and safety warnings are not removed, defaced or covered. Replacement labels can be obtained by contacting our Customer Service Department.

4. Familiarise yourself with the machine

- If you are not thoroughly familiar with the operation of this machine, obtain advice from your supervisor, instructor, or other qualified person or contact your retailer for information on training courses. Do not use this machine until adequate training has been undertaken.

5. Take care when moving or positioning the machine

- Some machines can be very heavy. Ensure the floor of the area in which the machine is to be used is capable of supporting the machine.
- The machine and its various components can be heavy. Always adopt a safe lifting technique and seek assistance when lifting heavy components. In some cases it may be necessary to use mechanical handling equipment to position the machine within the work area.
- Some machines have optional wheel kits available to allow them to be manoeuvred around the workshop as required. Care should be taken to install these according to the instructions provided.
- Due to the nature of the design of some machines the centre of gravity will be high making them unstable when moved. Extreme care should be taken when moving any machine.
- If transportation of the machine is required then all precautions relating to the installation and handling of the machine apply. In addition, ensure that any vehicles or manual handling equipment used for transportation are of adequate specification.

6. The machine should be level and stable at all times

- When using a leg stand or cabinet base that is designed to be fitted to the machine, always ensure that it is securely fastened to the machine using the fixings provided.
- If the machine is suitable to be used on a workbench, ensure that the workbench is well constructed and capable of withstanding the weight of the machine. The machine should always be securely fastened to the workbench with appropriate fixings.
- Where possible, floor standing machines should always be secured to the floor with fixings appropriate to the structure of the floor.
- The floor surface should be sound and level. All of the feet of the machine should make contact with the floor surface. If they do not, either re-locate

2. General Health & Safety Guidance cont.

the machine to a more suitable position or use packing shims between the feet and the floor surface to ensure the machine is stable.

7. Remove adjusting keys and wrenches

- Ensure that all adjusting wrenches and keys are removed before switching the machine 'ON'. There is a risk of severe personal injury or damage to the machine from airborne objects.

8. Before switching the machine 'ON'

- Clear the machine table of all objects (tools, scrap pieces etc.)
- Make sure there is no debris between the work piece and the table / work support.
- Ensure that the work piece is not pressed against, or touching the saw blade or cutting tool.
- Check all clamps, work holding devices and fences to ensure that they are secure and cannot move during machining operations.
- Plan the way that you will hold and feed the work piece for the entire machining operation.

9. Whilst machining

- Before starting work, watch the machine while it runs. If it makes an unfamiliar noise or vibrates excessively, switch the machine 'OFF' immediately and disconnect it from the power supply. Do not restart until finding and correcting the source of the problem.

10. Keep the work area clear

- Working clearances can be thought of as the distances between machines and obstacles that allow safe operation of every machine without limitation. Consider existing and anticipated machine needs, size of material to be processed through each machine and space for auxiliary stands and/or work tables. Also consider the relative position of each machine to one another for efficient material handling. Be sure to allow yourself sufficient room to safely operate your machines in any foreseeable operation.
- Cluttered work areas and benches create the risk of accidents. Keep benches clear and tidy away tools that are not in use.
- Ensure that the floor area is kept clean and clear of any dust and debris that may create trip or slip hazards.

11. Consider the work area environment

- Do not expose the machine to rain or damp conditions.
- Keep the work area well lit and ensure that there is artificial lighting available when there is insufficient natural light to effectively light the work area. Lighting should be bright enough to eliminate shadow and prevent eye strain.
- Do not use the machine in explosive environments eg. in the presence of flammable liquids, gases or dust.
- The presence of high levels of dust created by machining wood can present a risk of fire or explosion. Always use dust extraction equipment to minimise the risk.

12. Keep other persons away (and pets)

- The machine is designed to be used by one person only.
- Do not let persons, especially children, touch the machine or extension cable (if used) and keep visitors away from the work area.
- Never leave the machine running unattended. Turn the power supply off and do not leave the machine unattended until it comes to a complete stop.
- If the work area is to be left unattended, all machinery should be switched 'OFF' and isolated from the mains power supply.

13. Store machines safely when not in use

- When not in use, machines should be stored in a dry place, out of reach of children. Do not allow persons unfamiliar with these instructions or with the machine to operate it.

14. Do not overreach

- Choose a working position that allows your body to remain balanced and feed the work piece in to the machine without overreaching.
- Keep proper footing and balance at all times.

15. Electrical supply

- Electrical circuits should be dedicated to each machine or large enough to handle combined motor amp loads. Power outlets should be located near each machine so that power or extension cables are not obstructing high-traffic areas. Observe local electrical guidelines for proper installation of new

lighting, power outlets, or circuits.

- The machine must be connected to an earthed power supply.
- The power supply must be equipped with a circuit breaker that provides short circuit, overload and earth leakage protection.
- The voltage of the machine must correspond to the voltage of the mains power supply.
- The mains plug fitted to the machine should always match the power outlet. Do not modify the plug in any way. If a replacement plug is required it should be fitted by a competent person and of the correct type and rating for the machine.
- If you are unsure about any electrical connections always consult a qualified electrician.

16. Avoid unintentional starting of the machine

- Most machines are fitted with a no-volt release (NVR) switch to prevent unintentional starting. If in doubt always ensure the machine switch is in the 'OFF' position before connecting it to the power supply. This means the machine will not automatically start up after a power cut or switching on of the power supply, unless you first reset the start switch.

17. Outdoor use

- Your machine should not be used outdoors.

18. Extension cables

- Whenever possible, the use of extension cables is not recommended. If the use of an extension cable is unavoidable, then it should have a minimum core cross section of 2.5 mm² and limited to a maximum length of 3 metres.
- Extension cables should be routed away from the direct working area to prevent a trip hazard.

19. Guard against electric shock

- Avoid body contact with earthed or grounded surfaces such as pipes and radiators. There is an increased risk of electric shock if your body is earthed or grounded.

20. Always work within the machine's intended capacities

- Operator safety and machine performance are seriously adversely affected if attempts to make the machine perform beyond its limits are made.

21. Do not abuse the power cable

- Never pull the power cable to disconnect it from the power socket. Always use the plug.
- Keep the power cable away from heat, oil and sharp edges.
- Do not use the power cable for carrying or moving the machine.

22. Secure the work piece

- Ensure that the work piece is securely held before starting to machine it.
- When working within 300 mm of the machining area, always use a push stick to feed the work piece in to the blade or cutting tool. The push stick should have a minimum length of 400 mm. If the push stick becomes damaged, replace it immediately.
- Use extra supports (roller support stands etc.) for any work pieces large enough to tip when not held down to the table top.
- Do not use another person as a substitute for a table extension, or as additional support for a work piece that is longer or wider than the basic table, or to help feed, support, or pull the work piece.
- Do not attempt to machine more than one work piece at a time.
- When feeding the work piece towards the blade or cutting tool never position your hands in direct line of the cutting path. Avoid awkward operations and hand positions where a sudden slip could cause your hand or fingers to move into the machining area.

23. Stay alert

- Safety is a combination of operator common sense and alertness at all times when the machine is being used.
- Use all machines with extreme care and do not use the machine when you are tired or under the influence of drugs, alcohol or medication.

24. Use the correct tool for the job

- Do not use the machine for any purpose other than which it was designed.
- When selecting replacement cutting tools and blades, always ensure that they are designed to cut the material that you intend to use them for. If in any

2. General Health & Safety Guidance cont.

doubt seek further advice from the manufacturer.

25. Connect dust extraction equipment

- Always use dust extraction equipment. The dust extractor should be of suitable size and capacity for the machine that it is connected to and have a filtration level appropriate to the type of waste being collected. Refer to the relevant section of the manual for details of the specific dust extraction requirements for this machine.
- The dust extractor should be switched 'ON' before starting the machine that it is connected to. The dust extractor should be left running for 30 seconds after the last machining operation is complete in order to clear any residual waste from the machine.

26. Ensure that the machine is correctly guarded

- Never use the machine if any of the standard safety guards and equipment are removed or damaged.
- Some machines incorporate safety interlocks to prevent the machine from being used without the guards in place. Never attempt to bypass or modify the interlocks to allow the machine to be used without the guards in place.

27. Maintain your machine with care

- This manual gives clear instructions on installation, set up and operation of the machine and also details any routine and preventative maintenance that should be performed periodically by the user.
- Remember always to switch off and unplug the machine from the power supply before carrying out any setting up or maintenance operations.
- Follow any instructions for the maintenance of accessories and consumables.
- Do not use compressed air to clean the machine. Always use a brush to dislodge dust in places that are awkward to reach and a dust extractor to collect the waste.
- Inspect electric cables periodically and, if damaged, have them replaced by an authorised service facility or qualified electrician.
- Inspect extension cables (if used) periodically and replace if damaged.

28. Keep cutting tools sharp and clean

- Correctly maintained cutting tools are easier to control and less likely to bind.
- Cutting tools and blades can become hot during use. Take extreme care when handling them and always allow them to cool before changing, adjusting or sharpening them.

29. Disconnect the machine from the power supply

- When not in use, before servicing, changing blades etc. always disconnect the machine from the power supply.

30. Check for damaged parts

- Before each use of the machine, it should be carefully checked to determine that it will operate properly and perform its intended function.
- Check for alignment of moving parts, binding of moving parts, breakage of parts and any other conditions that may affect the operation of the machine.
- A guard or other part that is damaged should be properly repaired or replaced by a qualified person unless otherwise indicated in this instruction manual.
- Do not use the machine if the switch does not turn the machine 'ON' and 'OFF'.
- Have defective switches replaced by a qualified person.

31. Warning!

- The use of any accessory or attachment, other than those recommended in this instruction manual, or recommended by our Company may present a risk of personal injury or damage to the machine and invalidation of the warranty.

32. Have your machine repaired by a qualified person

- This machine complies with the relevant safety rules and standards appropriate to its type when used in accordance with these instructions and with all of the standard safety guards and equipment in place. Only qualified persons using original spare parts should carry out repairs. Failure to do this may result in considerable danger to the user and invalidation of warranty.

33. Caution! Motor may become hot during use

- It is normal for motors on some machines to become hot to the touch during use. Avoid touching the motor directly when in use.

3. Record Power Guarantee

“**Products**” means the Products sold by Record Power subject to these terms and conditions;

“**Record Power**” is Record Power Limited, whose company registration number is 4804158 and registered office address is Centenary House, 11 Midland Way, Barlborough Links, Chesterfield, Derbyshire, S43 4XA and sells through a network of Authorised Dealers;

“**Authorised Distributor**” is the nominated importer for your region who will generally sell through a network of Authorised Dealers. Details of Authorised Distributors for specific countries can be found in the Product manual or at www.recordpower.info;

“**Authorised Dealer**” is a retailer or business authorised to sell Record Power Products to end users.

1 Guarantee

- 1.1 Record Power guarantees that for a period of 5 years from the date of purchase the components of qualifying Products (see clauses 1.2.1 to 1.2.9) will be free from defects caused by faulty construction or manufacture.
- 1.2 During this period Record Power, its Authorised Distributor or Authorised Dealer will repair or replace free of charge any parts which are proved to be faulty in accordance with paragraphs 1.1 above provided that:
 - 1.2.1 you follow the claims procedure set out in clause 2 below;
 - 1.2.2 Record Power, our Authorised Distributor or Authorised Dealer are given a reasonable opportunity after receiving notice of the claim to examine the Product;
 - 1.2.3 if asked to do so by Record Power, its Authorised Distributor or Authorised Dealer, you return the Product, at your own cost, to Record Power’s premises or other approved premises such as those of the Authorised Distributor or supplying Authorised Dealer, for the examination to take place;
 - 1.2.4 the fault in question is not caused by industrial use, accidental damage, fair wear and tear, wilful damage, neglect, incorrect electrical connection, abnormal working conditions, failure to follow our instructions, misuse, or alteration or repair of the Product without our approval;
 - 1.2.5 the Product has been used in a domestic environment only;
 - 1.2.6 the fault does not relate to consumable Products such as blades, bearings, drive belts or other wearing parts which can reasonably be expected to wear at different rates depending on usage (for full details contact Record Power or your local Authorised Distributor);
 - 1.2.7 the Product has not been used for hire purposes, by you or by a previous owner;
 - 1.2.8 the Product has been purchased by you as the guarantee is not transferable from a private sale.
 - 1.2.9 where the Product has been purchased from a retailer, the 5 year guarantee is transferable and begins on the date of the first purchase of the Product and in the event of a claim under this guarantee proof of the original purchase date will be required to validate the warranty period.

2 Claims Procedure

- 2.1 In the first instance please contact the Authorised Dealer who supplied the Product to you. In our experience many initial problems with machines that are thought to be due to faulty parts are actually solved by correct setting up or adjustment of the machines. A good Authorised Dealer should be able to resolve the majority of these issues much more quickly than processing a claim under the guarantee.

- 2.2 Any damage to the Product resulting in a potential claim under the guarantee must be reported to the Authorised Dealer from which it was purchased within 48 hours of receipt.

- 2.3 If the Authorised Dealer who supplied the Product to you has been unable to satisfy your query, any claim made under this Guarantee should be made directly to Record Power or its Authorised Distributor (for details of the Authorised Distributor in your country please see your Product manual or check www.recordpower.info for details). The claim itself should be made in a letter setting out the date and place of purchase, and giving a brief explanation of the problem which has led to the claim. This letter should then be sent with proof of the purchase date (preferably a receipt) to Record Power or its Authorised Distributor. If you include a phone number or email address this will help to speed up your claim.

- 2.4 Please note that it is essential that the letter of claim reaches Record Power or its Authorised Distributor on the last day of this Guarantee at the latest. Late claims will not be considered.

3 Limitation of Liability

- 3.1 We only supply Products for domestic and private use. You agree not to use the Product for any commercial, business or re-sale purposes and we have no liability to you for any loss of profit, loss of business, business interruption or loss of business opportunity.
- 3.2 This Guarantee does not confer any rights other than those expressly set out above and does not cover any claims for consequential loss or damage. This Guarantee is offered as an extra benefit and does not affect your statutory rights as a consumer.

4 Notice

This Guarantee applies to all Products purchased from an Authorised Dealer of Record Power within the United Kingdom of Great Britain and Northern Ireland. Terms of Guarantee may vary in other countries – please check with the Authorised Distributor in your country (details of the Authorised Distributor for your country can be found in the manual or at www.recordpower.info).

4. Specifications

Throat Depth:	127 mm
Depth of Feed:	60 mm
Chuck to Table:	235 mm
Chuck to Base:	355 mm
Speeds:	500, 890, 1400, 1900 & 2500 rpm
Motor:	1/3 hp
Chuck:	2 Morse Taper / 13 mm
Weight:	27 kg
Size:	H850 x W210 x D380 mm
Noise emission:	Sound power level < 85 dB (A) Sound pressure level < 85 dB (A)

5. Unpacking & Checking Contents

1. Separate all parts from packaging materials and check each item make sure all items are accounted for before discarding any packing materials.

2. Remove the protective oil that is applied to the table and column. Use any ordinary household type grease and spot remover.

3. Apply CWA195 Silicone Spray or a coat of paste wax to the table and column to prevent rust. Wipe all parts thoroughly with a clean dry cloth.



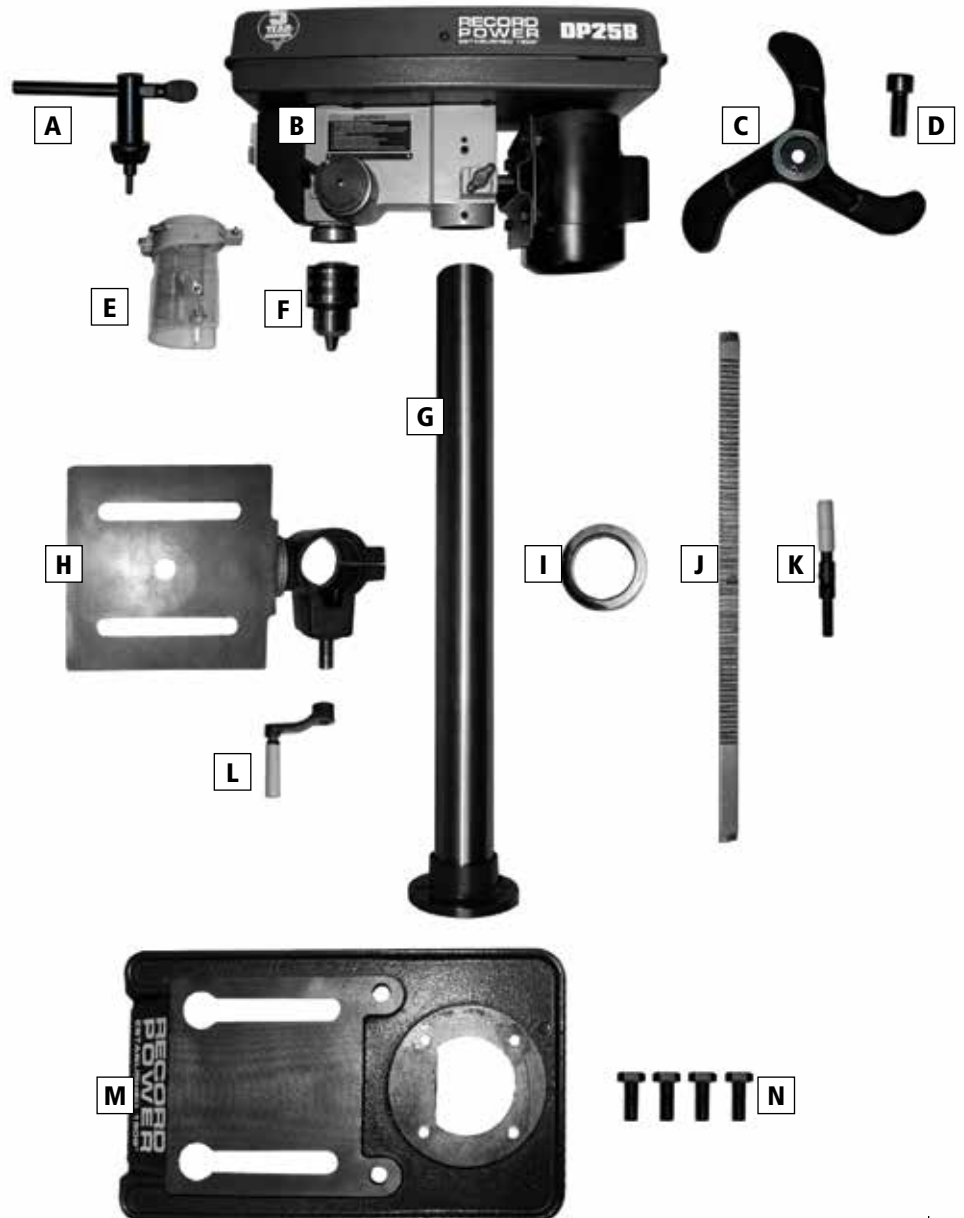
The machine serial number is located inside the headstock cover.



The guard may be packed inside the headstock. It is essential to remove it and install before use to avoid damage to the machine.

Parts List

Item	Description	Quantity
A	Chuck Key	1
B	Headstock	1
C	Handwheel	1
D	Hex Head Screw	1
E	Guard	1
F	Drill Chuck	1
G	Column and Support Casting	1
H	Table	1
I	Locking Collar	1
J	Toothed Rack	1
K	Locking Handle	1
L	Crank Handle	1
M	Base	1
N	Hex Head Screws	4

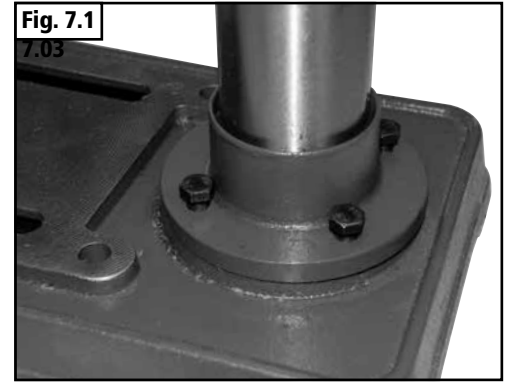


6. Getting to Know Your Machine

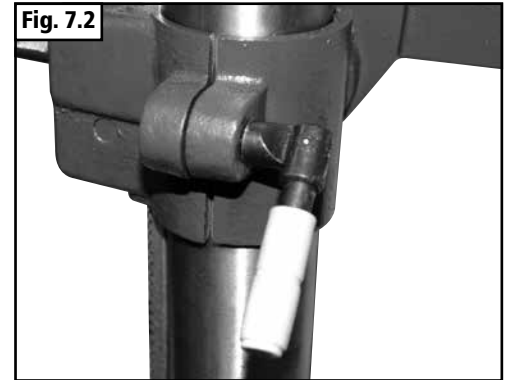


7. Assembly

1. The column and support casting are supplied pre-assembled. Align the four holes in the support casting with the corresponding holes in the base casting and secure using four M8 x 20mm hex. head screws item N. from parts list (**Fig. 7.1**).



2. Fit the locking handle in to the table support casting. Note that one side of the support casting has a plain bore, and the other side has a tapped hole. Ensure that the locking handle is first passed through the plain bore and into the tapped hole in order for the table support casting to clamp correctly around the column. Release this handle when moving table up/down (**Fig 7.2**).

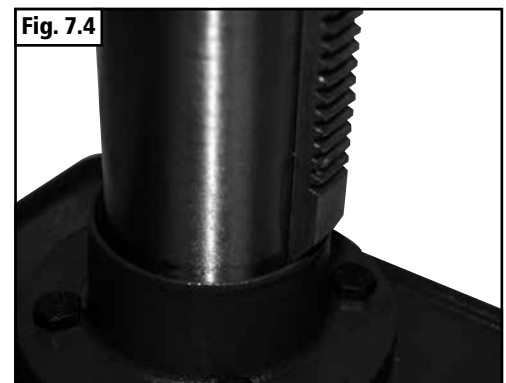


3. Position the toothed rack inside the table support casting so that it meshes with the worm gear. Note that the rack has a plain area at each end which has no teeth. The longest plain end is the top of the rack and this end should be positioned so that it is above the table surface, (**Fig. 7.3**).

Note: This may already be factory assembled.



4. Slide the assembled table and rack on to the column and ensure that the lower end of the rack locates in to the recess at the base of the column, (**Fig. 7.4**).

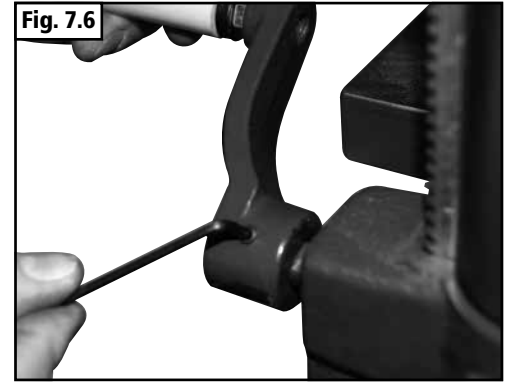


5. Secure the top of the rack to the column using the locking collar and secure with the M6 x 8mm screw (**Fig. 7.5**). Note that the collar has a chamfer on the underside that forms a recess to secure the rack to the column – check that the collar is the correct way up before fitting. Try to ensure that the collar is fitted so that it allows the rack to move freely around the circumference of the column as this will allow the table to be swung out of the way when not needed if machining larger work pieces.



7. Assembly cont.

6. Fit the crank handle (L) to the worm gear on the table support. Secure using the M6 x 8mm socket head screw against the flat area of the shaft, (**Fig. 7.6**).



7. Attach headstock to the top of the column and secure using two M8 x 8mm socket head screws which are already fitted in the headstock. Before fully tightening the screws check that the head is correctly aligned with the base so that the spindle is above the centre line of the base casting, (**Fig. 7.7**).



8. Attach the handwheel to the spindle pinion and secure with the M8 x 25mm socket head screw, (**Fig. 7.8**). Align both parts before locking with screw.



9. Fit the chuck to the spindle nose. Before fitting the chuck, both the taper of the spindle and the corresponding taper in the rear of the chuck should be thoroughly cleaned to remove any foreign bodies that may prevent the chuck from seating correctly. Clean both surfaces with white spirit to remove any heavy deposits of grease and dirt and then apply a thin coat of silicone spray or similar to both tapers before assembling. Once the chuck is in position, tap it firmly and squarely with a soft faced mallet to ensure it is fully seated on to the spindle, (**Fig. 7.9**).



10. Fit the chuck guard to the spindle collar using the M5 x 20mm domed screw and M5 nut supplied with the guard. Before fully tightening the fixing screw, check that the guard is correctly aligned, (**Fig. 7.10**).



8. Maintenance & Operation

Checking Belt Tension and Changing Speed Settings

Before attempting to use the machine, check that the correct speed is selected in relation to the size and type of drill bit and type of material being machined. It is important to apply the correct level of tension, as over tensioning the belt will apply excessive load to the motor and spindle bearings and may cause damage to the machine. Insufficient tensioning of the belt will cause the machine to be noisy as there will be excess movement of the belt as it runs between the pulleys and the spindle may stall when machining as pressure is applied to the work piece. Periodically check the belt tension to maintain optimum performance of the machine.



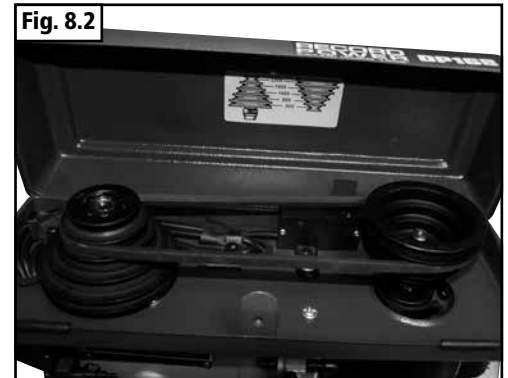
Before attempting any maintenance or adjustment ALWAYS ensure that the machine is disconnected from the power supply.

Changing the Speed Setting

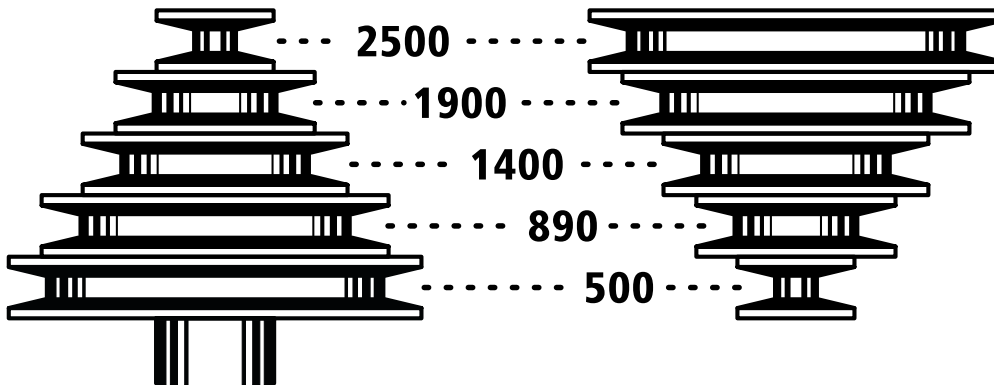
1. Loosen the securing screw (Fig. 8.1) and open the belt guard to allow access to the drive belt (Fig. 8.2).



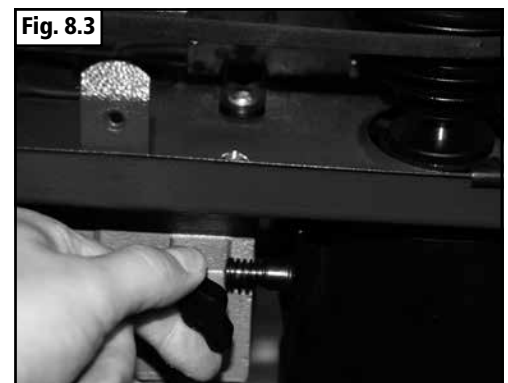
2. Loosen the belt tension screw located at the side of the head unit to allow free movement of the motor plate (Fig. 8.3). The correct speed can now be selected. When selecting a speed always ensure that the belt is correctly located on the correct step of each pulley. A speed chart as below is located inside the belt guard for reference.



Speed Chart



3. To re-tension the belt, gently push the motor plate away from the head of the machine until the required level of tension is applied to the belt. Tighten the tension screw at the side of the head unit to maintain the tension.



Please note: when applying gentle pressure to the centre of the drive belt between the pulley, movement of 6-12 mm indicates correct belt tension.

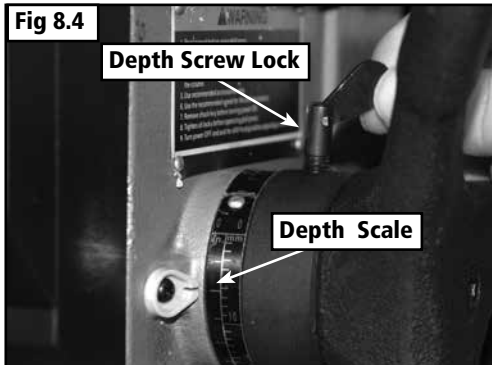
Lubrication

This machine uses sealed bearing units which require no maintenance for the life of the product. Periodically you may need to lubricate and clean the table elevation mechanism as well as the splines (grooves) in the spindle pulley system.

8. Maintenance & Operation

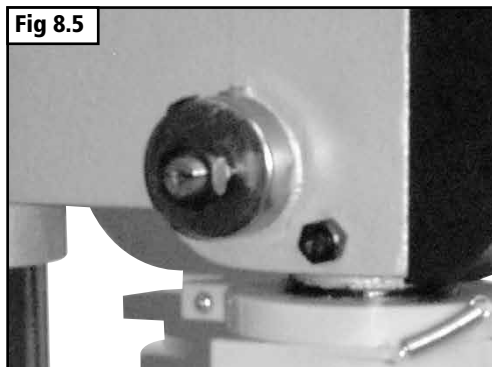
Depth Stop Adjustment

Move the drill/cutter to be directly above the workpiece, zero the scale then move the scale to the required depth to be cut and lock in position with the depth screw lock, **Fig 8.4**.



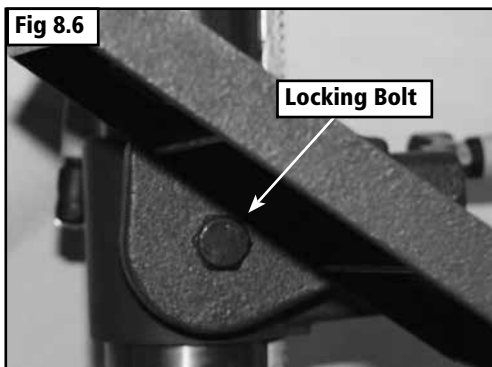
To Adjust Tension

First undo lock nut, removed remove the first nut from the shaft, then adjust the second nut only move a small distance to allow spring cap enough room to turn from its location on headstock, turn anti clockwise to decrease and clockwise to increase pressure on spring. Refit parts and test.



Drilling at An angle

Always ensure the workpiece is securely held in a vice or clamped to the table. To adjust the angle of the table, loosen the locking bolt beneath the table, move the table to the required angle and re-tighten the bolt, **Fig 8.6**.



Keeping the Machine Clean

Use CWA195 Silicone Spray or a thin coat of paste wax to protect the table and base from excessive dust. Protect the column with silicone spray or light coat of oil spray.



In the event of a blockage or if the machine stalls:

If the machine stalls during use, the most likely cause is excessive pressure being applied to the feed hand wheel. Simply reducing the pressure will usually allow the drill bit to return to full speed.

In the event that the machine stalls due to a blockage that prevents the drill bit from rotating, immediately switch the machine off by pressing the red button marked 'O' on the switch.

Locate and rectify the source of the blockage and check that there is sufficient tension on the drive belt. Rotate the chuck by hand to ensure free rotation of the drill bit.

To re-start the machine press the green button marked 'I' on the switch.

In the event of a power failure:

The drilling machine is fitted with a no volt release (NVR) switch to protect the user against automatic starting of the machine when power is restored after a power failure.

In the event of a power failure, first locate and rectify the source of the failure. If the fault is within the power circuit of the workshop, there may be an underlying cause (circuit overload etc.) that should be investigated by a qualified electrician, before attempting to restore the power source.

Once the power is restored, the machine can be re-started by pressing the green button marked 'I' on the switch.

9. Electrical Connection & Wiring Diagram

Machines supplied for use in the UK are fitted with a 3 pin plug conforming to BS1363, fitted with a fuse conforming to BS1362 and appropriate to the current rating of the machine.

Machines supplied for use in other countries within the European Union are fitted with a 2 pin Schuko plug conforming to CEE 7/7.

Machines supplied for use in Australia & New Zealand are fitted with a 3 pin plug conforming to AS/NZS3112.

In all cases, if the original plug or connector has to be replaced for any reason, the wires within the mains power cable are colour coded as follows:

230 V (Single Phase)

Brown: Live (L)
 Blue: Neutral (N)
 Green and Yellow: Earth (E)

The wire coloured brown must always be connected to the terminal marked 'L' or coloured red.

The wire coloured blue must always be connected to the terminal marked 'N' or coloured black.

The wire coloured green and yellow must always be connected to the terminal marked 'E' or with the earth symbol:



or coloured green / green and yellow.

It is important that the machine is effectively earthed. Some machines will be clearly marked with the double insulated logo:



In this case there will not be an earth wire within the circuit.

In the case of the BS1363 plug for use in the UK, always ensure that it is fitted with a fuse conforming to BS1362 appropriate to the rating of the

machine. If replacing the original fuse, always fit a fuse of equivalent rating to the original. Never fit a fuse of a higher rating than the original. Never modify the fuse or fuse holder to accept fuses of a different type or size.

Where the current rating of the machine exceeds 13 A at 230 V, or if the machine is designated for use on a 400 V 3 phase supply a connector conforming to BS4343 (CEE17 / IEC60309) will be used.

230 V machines will be fitted with a blue 3 pin connector. The wiring for this type of this connector will be the same as shown above.

400 V, 3 phase machines will be fitted with a red 4 or 5 pin connector. The wiring for this type of connector is as shown below:

400 V (3 phase)

Brown: Live (L1)
 Black: Live (L2)
 Grey: Live (L3)
 Blue: Neutral (N)
 Green and Yellow: Earth (E)

The wire coloured brown must always be connected to the terminal marked 'L1'.

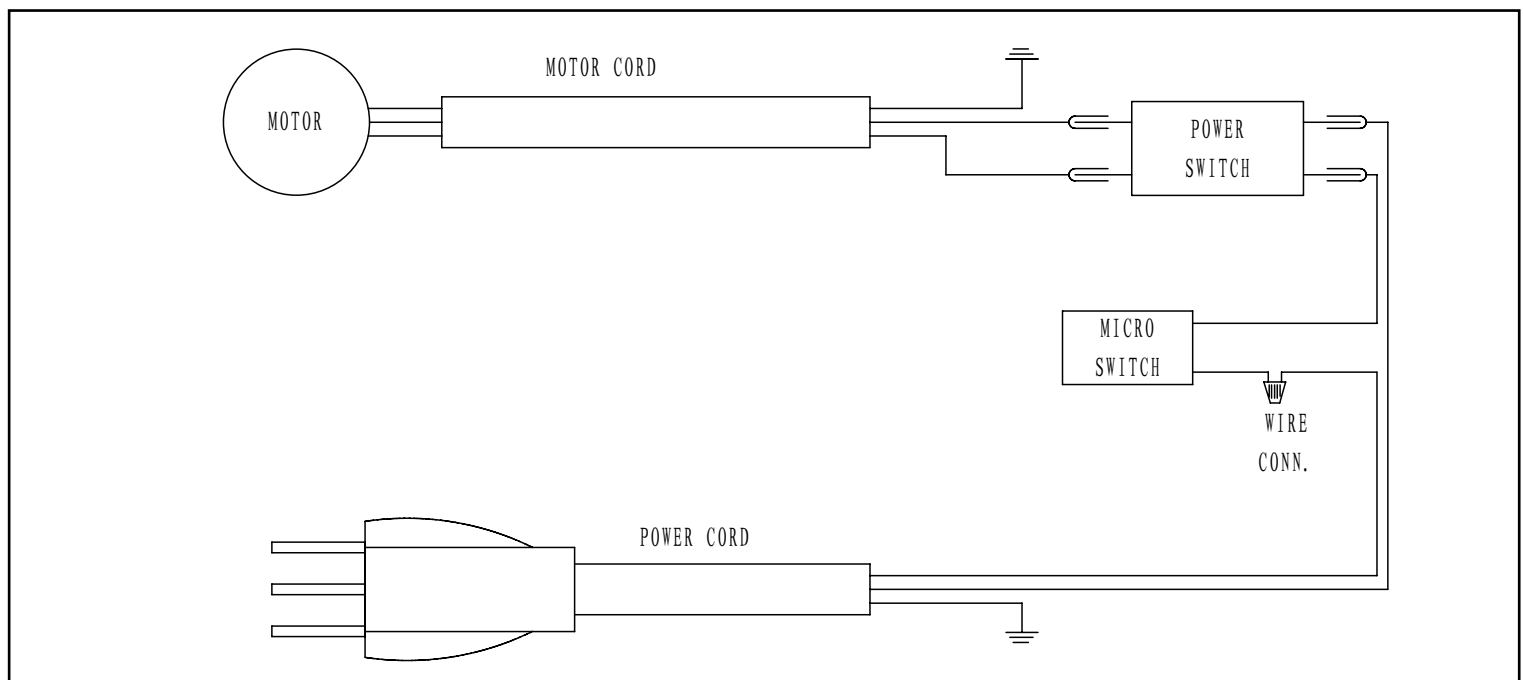
The wire coloured black must always be fitted to the terminal marked 'L2'.

The wire coloured grey must always be connected to the terminal marked 'L3'.

The wire coloured blue must always be connected to the terminal marked 'N' or coloured black.

The wire coloured green and yellow must always be connected to the terminal marked 'E' or with the earth symbol

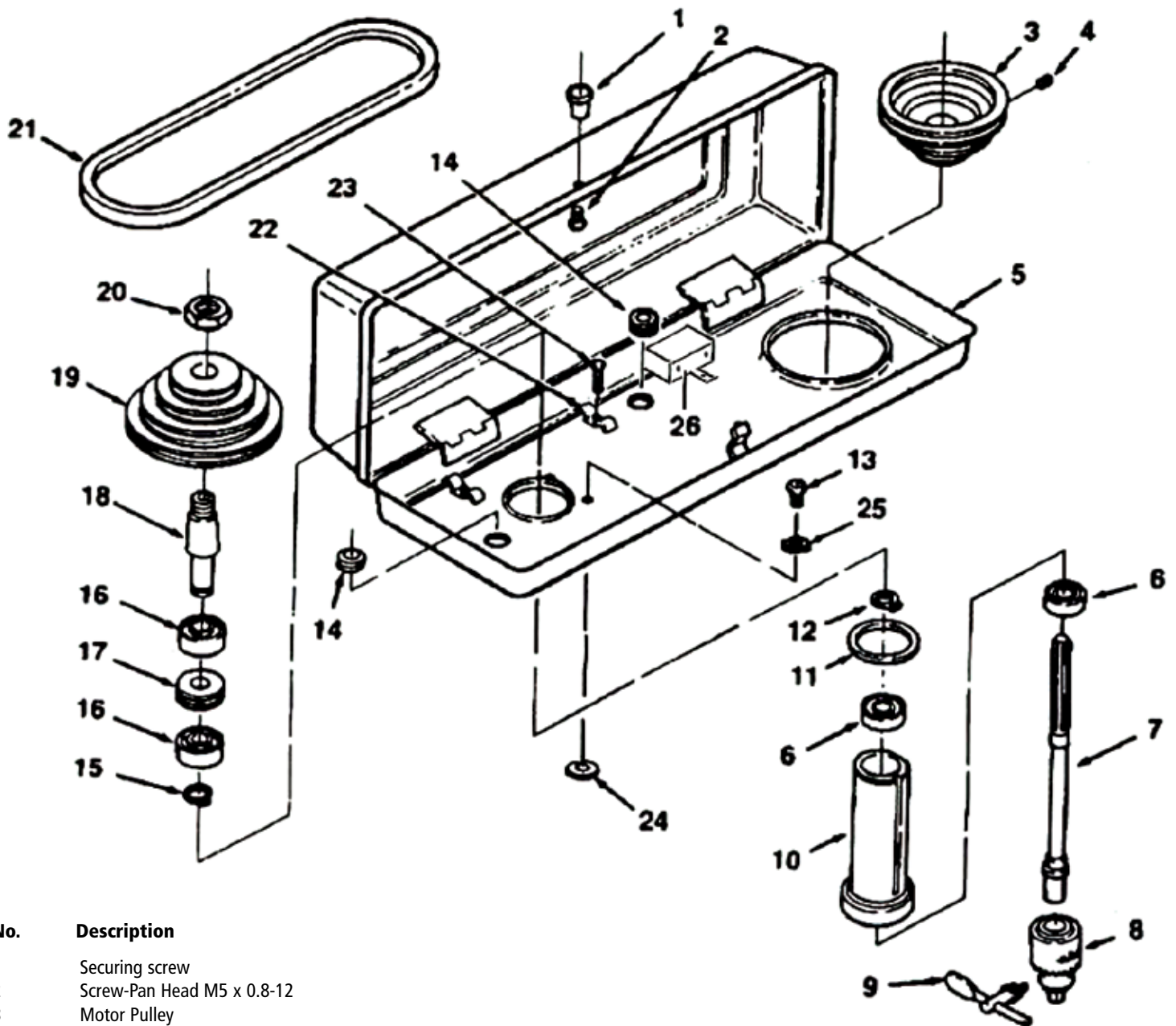
If in doubt about the connection of the electrical supply, always consult a qualified electrician.



10. Troubleshooting

Problem	Cause	Remedy
Noisy operation	<ol style="list-style-type: none"> 1. Incorrect belt tension 2. Dry spindle 3. Loose spindle pulley 4. Loose motor pulley 	<ol style="list-style-type: none"> 1. Adjust tension 2. Lubricate spindle 3. Check tightness of retaining nut on pulley and tighten if necessary 4. Tighten set screws in pulleys
Drill bit burns	<ol style="list-style-type: none"> 1. Incorrect speed 2. Chips not coming out of hole 3. Dull drill bit 4. Feeding too slow 5. Not lubricated 	<ol style="list-style-type: none"> 1. Change speed 2. Retract drill bit frequently to clear chips 3. Resharpener or change the drill bit 4. Change speed 5. Lubricate drill bit
Drill bit wanders off centre or hole not circular	<ol style="list-style-type: none"> 1. Hard grain in wood 2. Lengths of cutting lips and/or angles not equal 3. Bent drill bit 	<ol style="list-style-type: none"> 1. Resharpener drill bit correctly 2. Resharpener drill bit correctly 3. Replace drill bit
Wood splinters on underside	No sacrificial material under workpiece	Use sacrificial material
Workpiece turns loose	<ol style="list-style-type: none"> 1. Not supported or clamped properly 	<ol style="list-style-type: none"> 1. Support workpiece or clamp it in vice
Drill bit binds in workpiece	<ol style="list-style-type: none"> 1. Workpiece pinching drill bit 2. Excessive feed pressure 3. Improper belt tension 	<ol style="list-style-type: none"> 1. Support workpiece or clamp it 2. Reduce feed pressure 3. Adjust tension.
Excessive drill bit run out or wobble	<ol style="list-style-type: none"> 1. Bent drill bit 2. Worn spindle bearings 3. Drill bit not properly installed in chuck 4. Chuck not properly installed 	<ol style="list-style-type: none"> 1. Replace drill bit 2. Replace bearings 3. Install drill bit properly 4. Install chuck properly
Quill returns too slowly or too quickly	Spring has improper tension	Adjust spring tension see Maintenance & Operation
Chuck will not stay attached to spindle, it falls off when trying to install	Dirt, grease or oil on the tapered inside surface of chuck or on the tapered surface of the spindle dirt, grease and oil	Using a household detergent, clean the tapered surface of the chuck and spindle to remove all

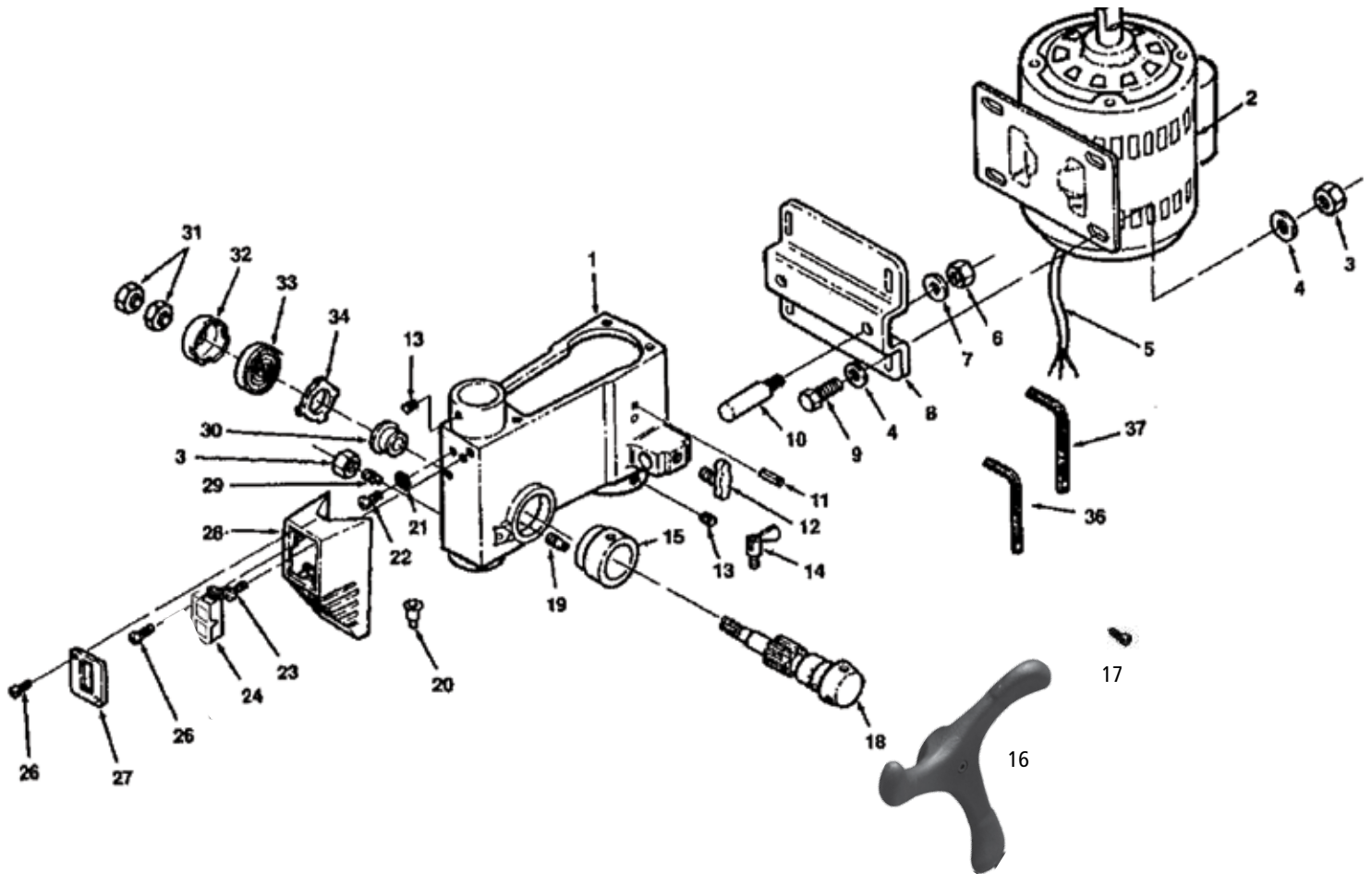
11. Parts Lists & Diagrams



No.	Description
1	Securing screw
2	Screw-Pan Head M5 x 0.8-12
3	Motor Pulley
4	Screw - Hex Socket Set M6 x 1.0 - 10
5	Pulley Assembly Cover
6	*Ball Bearing 12mm x2
7	Spindle Shaft
8	Chuck
9	Chuck Key
10	Quill Tube
11	Quill Gasket
12	Circlip
13	Screw - Washer Head M6 x 1.0 - 12
14	Rubber Grommit x2
15	Circlip x2
16	*Ball Bearing 17mm x2
17	Spacer
18	Insert Pulley (Includes Key 15 & 20)
19	Spindle Pulley
20	Nut - Pulley
21	V - Belt 5/16x31
22	Clamp Cord
23	Screw - Pan Head M5 X 0.8 - 10
24	Washer Foam
25	*Star Washer M6
26	Micro Switch

*Standard Hardware Item - May be purchased locally

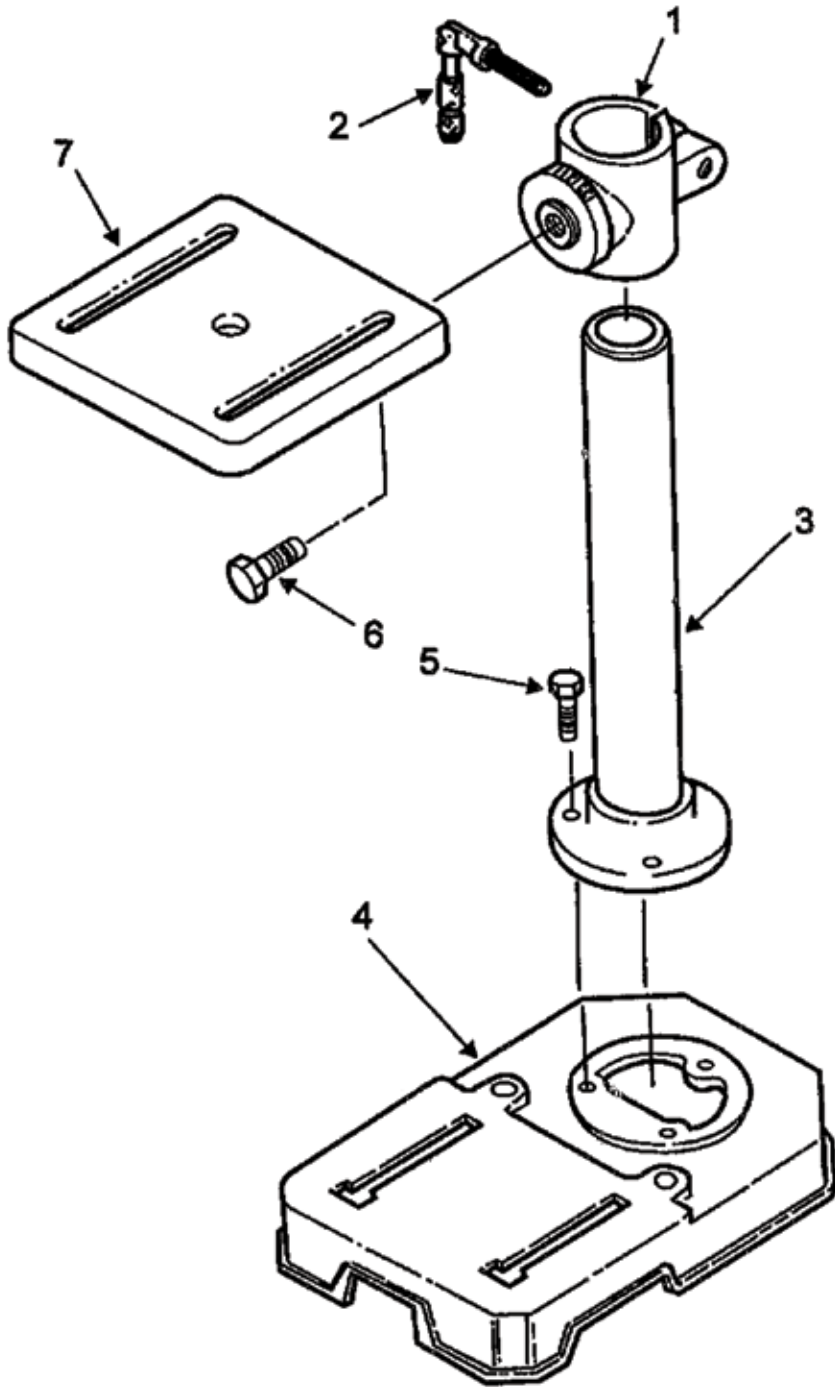
11. Parts Lists & Diagrams - Cont.



No.	Description	No.	Description
1	Head with Pointer & Trim	20	*Wire Connector
2	Motor	21	*Lockwasher - Extension 5mm
3	*Nut - Hex M8	22	Screw - Pan Head M5 x 0.8-12
4	*Washer M8 x 16 x 1.6	23	Screw - Pan Head M5 x 0.8-12
5	Power Cord	24	NVR Switch
6	*Nut - Hex M10	26	Screw - Self Tapping Pan Head M4 2x1.4 - 9.5
7	*Locking Washer M10	27	Switch Plate Cover
8	Motor Bracket	28	Switch Box
9	Hex Head Bolt M8 x 1.25-20	29	Screw - Special Set M8 x 1.25 x 18
10	Motor Bracket Support	30	Spring Seat
11	Pin - Roll 6 x 16	31	*Nut - Hex M12 x 1.5-8
12	Motor Adjustment Knob	32	Spring Cap
13	Blind Set Screw M8 x 1.25-8	33	Torsion Spring
14	Depth Screw Lock	34	Spring Retainer
15	Depth Stop with Scale Ring	35	Hexagonal Wrench 3mm
16	Handle	36	Hexagonal Wrench 4mm
17	Bolt		
18	Pinion Hub		
19	Stop Pin		

*Standard Hardware Item - May be purchased locally

11. Parts Lists & Diagrams - Cont.



No.	Description
1	Table support casting with scale
2	Locking Handle
3	Main column
4	Base
5	Hex head screw M8 x 1.25-20 x4
6	Hex head screw 1/2 - 12 x 7/8
7	Table

EU Declaration of Conformity

Cert No: EU / DPB / 1

RECORD POWER LIMITED,

Centenary House, 11 Midland Way, Barlborough Links
Chesterfield, Derbyshire S43 4XA

declares that the machinery described:-

1. Type: **Drill Press**
2. Model No: **DP25B**
3. Serial No

Conforms with the following directives:-

MACHINERY DIRECTIVE	2006/42/EC
LOW VOLTAGE DIRECTIVE	2006/95/EC
ELECTROMAGNETIC COMPATIBILITY DIRECTIVE	2004/108/EC EN 55014-1:2006 EN 61000-3-2:2006 EN 61000-3-3:1995+A1+A2 EN 55014-2:1997+A1



and conforms to the machinery example for which the
EC Type-Examination Certificate No. **BM50168849, AN50168850, AE50136036**
has been issued by **TUV Rheinland Product Safety GmbH,**
at: Am Grauen Stein, D-51105. Cologne, Germany

and complies with the relevant essential health and safety requirements.

A handwritten signature in black ink, appearing to read 'Andrew Greensted', is written over a dotted line.

Signed.....Dated: **01/08/2011**

Andrew Greensted
Managing Director



Over
100
 years

Experience • Knowledge
 Support • Expertise

RECORD POWER
 ESTABLISHED 1909®

Woodworking Machinery & Accessories

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