



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.

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.

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.

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".

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.

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.

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.

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.

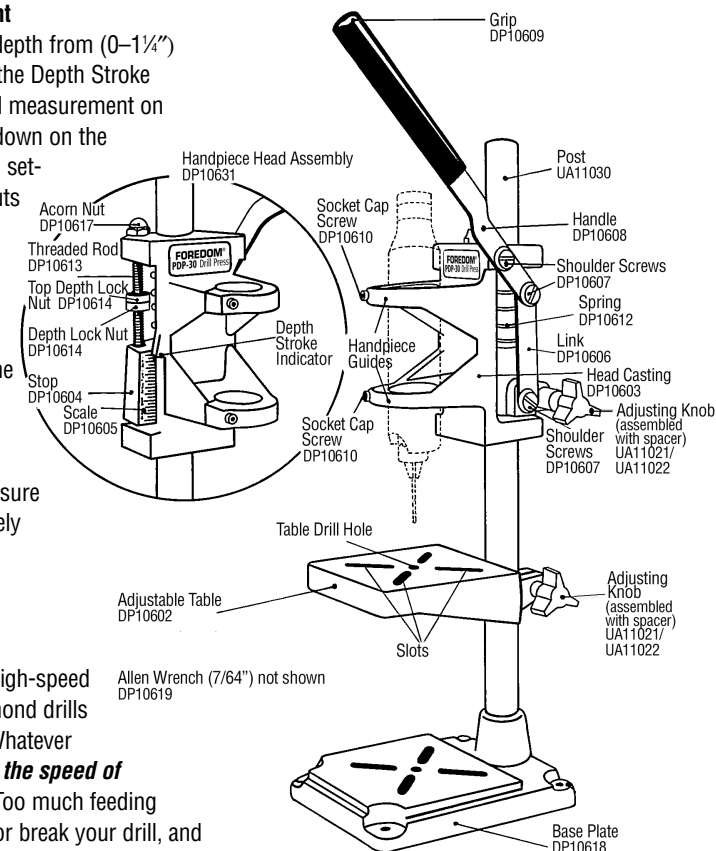
Adjust the drill stroke depth from (0–1¼") with Lock Nuts. Move the Depth Stroke Indicator to the desired measurement on the Scale by pressing down on the handle. Hold at desired setting and move Lock Nuts until the depth indicator is stopped.

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.

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.

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 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.

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.