

## 17" VS Drill Press



# Operator's Manual

Record the serial number and date of purchase in your manual for future reference.

Serial Number: \_\_\_\_\_ Date of purchase: \_\_\_\_\_

For technical support or parts questions, email [techsupport@rikontools.com](mailto:techsupport@rikontools.com) or call toll free at (877)884-5167

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## SPECIFICATIONS

Motor .....	1-1/2 HP
Motor Speed (no load).....	1,700 RPM
Volts .....	115 / 230 V
Amps, Hertz .....	13.3 / 6.7 A, 60 Hz
Swing .....	17"
Chuck Size .....	5/8"
Chuck Taper .....	JT3
Drilling Capacity .....	1"
Spindle Travel .....	6"
Spindle Taper .....	MT2
Head Rotates .....	360°
Speed Range (RPM) .....	Variable 200-700 & 600-2,200
Quill Diameter .....	2-5/8" (66mm)
Table Size .....	14" x 14"
Table Tilts .....	90° Left & Right
Table Rotates .....	360°
Maximum Chuck to Table .....	27-1/4"
Maximum Chuck to Base .....	46-5/16"
Column Diameter .....	3-1/8" (80mm)
Height .....	71-1/2"
Base Size .....	22-7/8" x 16-5/16"
Net Weight .....	214 lbs.

**NOTE:** The specifications, photographs, drawings and information in this manual represent the current model when the manual was prepared. Changes and improvements may be made at any time, with no obligation on the part of Rikon Power Tools, Inc. to modify previously delivered units. Reasonable care has been taken to ensure that the information in this manual is correct, to provide you with the guidelines for the proper safety, assembly and operation of this machine.

# SAFETY INSTRUCTIONS

**IMPORTANT!** Safety is the single most important consideration in the operation of this equipment. **The following instructions must be followed at all times.** Failure to follow all instructions listed below may result in electric shock, fire, and/or serious personal injury.

There are certain applications for which this tool was designed. We strongly recommend that this tool not be modified and/or used for any other application other than that for which it was designed. If you have any questions about its application, do not use the tool until you have contacted us and we have advised you.

## SAFETY SYMBOLS



**SAFETY ALERT SYMBOL:** Indicates DANGER, WARNING, or CAUTION. This symbol may be used in conjunction with other symbols or pictographs.



Indicates an imminently hazardous situation, which, if not avoided, could result in death or serious injury.



Indicates a potentially hazardous situation, which, if not avoided, could result in death or serious injury.



Indicates a potentially hazardous situation, which, if not avoided, could result in minor or moderate injury.

**NOTICE:** Shown without Safety Alert Symbol indicates a situation that may result in property damage.

## GENERAL SAFETY

**KNOW YOUR POWER TOOL.** Read the owner's manual carefully. Learn the tool's applications, work capabilities, and its specific potential hazards.

### BEFORE USING YOUR MACHINE

To avoid serious injury and damage to the tool, read and follow all of the Safety and Operating Instructions before operating the machine.

1. Some dust created by using power tools 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, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, 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, such as those dust masks that are specially designed to filter out microscopic particles.

2. **READ** the entire Owner's Manual. **LEARN** how to use the tool for its intended applications.

3. **GROUND ALL TOOLS.** If the tool is supplied with a 3 prong plug, it must be plugged into a 3-contact electrical receptacle. The 3rd prong is used to ground the tool and provide protection against accidental electric shock. **DO NOT** remove the 3rd prong. See Grounding Instructions on the following pages.

4. **AVOID A DANGEROUS WORKING ENVIRONMENT.** **DO NOT** use electrical tools in a damp environment or expose them to rain.

5. **DO NOT** use electrical tools in the presence of flammable liquids or gasses.

6. **ALWAYS** keep the work area clean, well lit, and organized. **DO NOT** work in an environment with floor surfaces that are slippery from debris, grease, and wax.

7. **KEEP VISITORS AND CHILDREN AWAY. DO NOT** permit people to be in the immediate work area, especially when the electrical tool is operating.

8. **DO NOT FORCE THE TOOL** to perform an operation for which it was not designed. It will do a safer and higher quality job by only performing operations for which the tool was intended.

9. **WEAR PROPER CLOTHING. DO NOT** wear loose clothing, gloves, neckties, or jewelry. These items can get caught in the machine during operations and pull the operator into the moving parts. The user must wear a protective cover on their hair, if the hair is long, to prevent it from contacting any moving parts.

10. **CHILDPROOF THE WORKSHOP AREA** by removing switch keys, unplugging tools from the electrical receptacles, and using padlocks.

11. **ALWAYS UNPLUG THE TOOL FROM THE ELECTRICAL RECEPTACLE** when making adjustments, changing parts or performing any maintenance.

# SAFETY INSTRUCTIONS

**12. KEEP PROTECTIVE GUARDS IN PLACE AND IN WORKING ORDER.**

**13. AVOID ACCIDENTAL STARTING.** Make sure that the power switch is in the “OFF” position before plugging in the power cord to the electrical receptacle.

**14. REMOVE ALL MAINTENANCE TOOLS** from the immediate area prior to turning “ON” the machine.

**15. USE ONLY RECOMMENDED ACCESSORIES.** Use of incorrect or improper accessories could cause serious injury to the operator and cause damage to the tool. If in doubt, check the instruction manual that comes with that particular accessory.

**16. NEVER LEAVE A RUNNING TOOL UNATTENDED.** Turn the power switch to the “OFF” position. **DO NOT** leave the tool until it has come to a complete stop.

**17. DO NOT STAND ON A TOOL.** Serious injury could result if the tool tips over, or you accidentally contact the tool.

**18. DO NOT** store anything above or near the tool where anyone might try to stand on the tool to reach it.

**19. MAINTAIN YOUR BALANCE. DO NOT** extend yourself over the tool. Wear oil resistant rubber soled shoes. Keep floor clear of debris, grease, and wax.

**20. MAINTAIN TOOLS WITH CARE.** Always keep tools clean and in good working order. Keep all blades and tool bits sharp, dress grinding wheels and change other abrasive accessories when worn.

**21. EACH AND EVERY TIME, CHECK FOR DAMAGED PARTS PRIOR TO USING THE TOOL.** Carefully check all guards to see that they operate properly, are not damaged, and perform their intended functions. Check for alignment, binding or breaking of moving parts. A guard or other part that is damaged should be immediately repaired or replaced.

**22. DO NOT OPERATE TOOL WHILE TIRED, OR UNDER THE INFLUENCE OF DRUGS, MEDICATION OR ALCOHOL.**

**23. SECURE ALL WORK.** Use clamps or jigs to secure the work piece. This is safer than attempting to hold the work piece with your hands.

**24. STAY ALERT, WATCH WHAT YOU ARE DOING, AND USE COMMON SENSE WHEN OPERATING A POWER TOOL.**

A moment of inattention while operating power tools may result in serious personal injury.

**25. ALWAYS WEAR A DUST MASK TO PREVENT INHALING DANGEROUS DUST OR AIRBORNE PARTICLES,** including wood dust, crystalline silica dust and asbestos dust. Direct particles away from face and body. Always operate tool in well ventilated area and provide for proper dust removal. Use dust collection system wherever possible. Exposure to the dust may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. Allowing dust to get into your mouth or eyes, or lay on your skin may promote absorption of harmful material. Always use properly fitting NIOSH/OSHA approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

**26. USE A PROPER EXTENSION CORD IN GOOD CONDITION.** When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. The table on the following page shows the correct size to use depending on cord length and nameplate amperage rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the larger diameter of the extension cord. If in doubt of the proper size of an extension cord, use a shorter and thicker cord. An undersized cord will cause a drop in line voltage resulting in a loss of power and overheating.  
**USE ONLY A 3-WIRE EXTENSION CORD THAT HAS A 3-PRONG GROUNDING PLUG AND A 3-POLE RECEPTACLE THAT ACCEPTS THE TOOL’S PLUG.**

**27. ADDITIONAL INFORMATION** regarding the safe and proper operation of this product is available from:

- Power Tool Institute  
1300 Summer Avenue  
Cleveland, OH 44115-2851  
[www.powertoolinstitute.org](http://www.powertoolinstitute.org)
- National Safety Council  
1121 Spring Lake Drive  
Itasca, IL 60143-3201  
[www.nsc.org](http://www.nsc.org)
- American National Standards Institute  
25 West 43rd Street, 4th Floor  
New York, NY 10036  
[www.ansi.org](http://www.ansi.org)
- ANSI 01.1 Safety Requirements for Woodworking Machines and the U.S. Department of Labor regulations  
[www.osha.gov](http://www.osha.gov)

**28. SAVE THESE INSTRUCTIONS.** Refer to them frequently and use them to instruct others.

# SAFETY INSTRUCTIONS

## ELECTRICAL SAFETY

**⚠ WARNING:** THIS TOOL IS PRE-WIRED FOR 115V CIRCUITS, AND MUST BE GROUNDED WHILE IN USE TO PROTECT THE OPERATOR FROM ELECTRIC SHOCK.

**IN THE EVENT OF A MALFUNCTION OR BREAKDOWN,** grounding provides the path of least resistance for electric current and reduces the risk of electric shock. This tool is equipped with an electric cord that has an equipment grounding conductor and requires a grounding plug (not included). The plug **MUST** be plugged into a matching electrical receptacle that is properly installed and grounded in accordance with **ALL** local codes and ordinances.

**DO NOT MODIFY ANY PLUG.** If it will not fit the electrical receptacle, have the proper electrical receptacle installed by a qualified electrician.

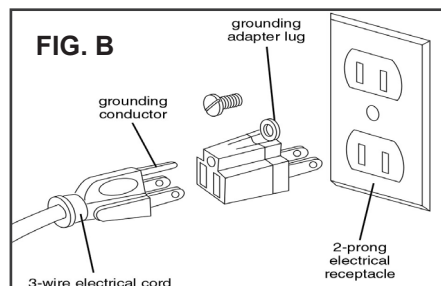
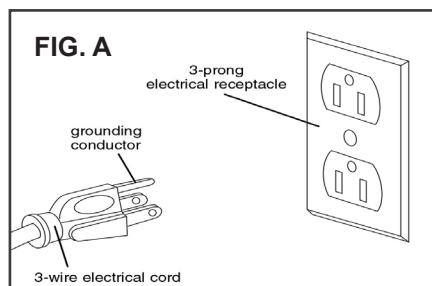
**IMPROPER ELECTRICAL CONNECTION** of the equipment grounding conductor can result in risk of electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment grounding conductor. **DO NOT** connect the equipment grounding conductor to a live terminal if repair or replacement of the electric cord or plug is necessary.

**CHECK** with a qualified electrician or service personnel if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded when installing or replacing a plug.

**USE ONLY A 3-WIRE EXTENSION CORD THAT HAS THE PROPER TYPE OF A 3-PRONG GROUNDING PLUG THAT MATCHES THE MACHINE'S 3-PRONG PLUG AND ALSO THE 3-POLE RECEPTACLE THAT ACCEPTS THE TOOL'S PLUG.** \* See Figures A and B.

**REPLACE A DAMAGED OR WORN CORD IMMEDIATELY.**

This tool is intended for use on a circuit that has a 120 volt electrical receptacle. **FIGURE C** shows the type of the 220v, 3-wire electrical plug and electrical receptacle that has a grounding conductor that is required if the motor wiring is changed. See page 18.



## EXTENSION CORDS

**⚠ WARNING:** THE USE OF AN EXTENSION CORD WITH THIS MACHINE IS NOT RECOMMENDED. For best power and safety, plug the machine directly into a dedicated, grounded electrical outlet that is within the supplied cord length of the machine.

If an extension cord needs to be used, it should only be for a limited operation of the machine. The extension cord should be as short as possible in length, and have a minimum gauge size of 14AWG.

**⚠ WARNING:** Check extension cords before each use. If damaged replace immediately. Never use a tool with a damaged cord, since touching the damaged area could cause electrical shock, and serious injury.

Use a proper extension cord. Only use cords listed by Underwriters Laboratories (UL). Other extension cords can cause a drop in line voltage, resulting in a loss of power and overheating of tool. When operating a power tool outdoors, use an outdoor extension cord marked "W-A" or "W". These cords are rated for outdoor use and reduce the risk of electric shock.

### MINIMUM RECOMMENDED GAUGE FOR EXTENSION CORDS (AWG)

120 VOLT OPERATION ONLY				
	25' LONG	50' LONG	100' LONG	150' LONG
0 to 6 Amps	18 AWG	16 AWG	16 AWG	14 AWG
6 to 10 Amps	18 AWG	16 AWG	14 AWG	12 AWG
10 to 12 Amps	16 AWG	16 AWG	14 AWG	12 AWG

**⚠ WARNING:** Keep the extension cord clear of the working area. Position the cord so that it will not get caught on lumber, tools or other obstructions while you are working with your power tool.

\* Canadian electrical codes require extension cords to be certified SJT type or better.

\*\* The use of an adapter in Canada is not acceptable.

**FIG. C** Sample of 220 volt plug required for this machine.



NEMA 6-15P

Consult a qualified electrician if the distance of the machine from the electrical panel is greater than 30 feet.

# SAFETY INSTRUCTIONS

## SPECIFIC SAFETY INSTRUCTIONS FOR DRILL PRESSES

This machine is intended for the drilling of wood, composite materials, plastics, ferrous and non-ferrous metals. The permissible workpiece dimensions must be observed (see Technical Specification). Any other use not as specified, including modification of the machine or use of parts not tested and approved by the equipment manufacturer, can cause unforeseen damage and invalidate the warranty.

**ATTENTION:** Use of this drill press still presents risks that cannot be eliminated by the manufacturer. Therefore, the user must be aware that wood working machines are dangerous if not used with care and all safety precautions are adhered to.

1. Do not operate the Drill Press until it is assembled and you have read all of the instructions.
2. Do not operate the Drill Press unless you are familiar with its safe operation. If you are not familiar with the operation of a Drill Press seek advice from your supervisor, instructor or other qualified individual.
3. If you are using a bench top Drill Press, it must be securely fastened to a stand or bench.
4. If you are operating a floor Drill Press it must be securely fastened to the floor.
5. Always clear the table and work area before turning on the Drill Press.
6. Always use drill bits, cutting tools and accessories with a 1/2" shank or less.
7. Never place hands near the drill bit, cutting tool or accessory while operating the Drill Press.
8. Always wear approved, safety eye wear and hearing protection while operating the Drill Press.
9. Never wear loose clothing, gloves or ties while operating the Drill Press. Tie loose hair back.
10. Always wear a dust mask and use adequate dust collection and proper ventilation.
11. Always have a firm footing while operating the Drill Press.
12. Always keep the work surface and work areas clear of debris.
13. Never attempt to do set-up work, assembly or layout work on the Drill Press while it is in operation.
14. Always lock all table, column and head locks before turning on the Drill Press.
15. Never start the Drill Press with the drill bit, cutting tool or accessory in contact with the work piece.
16. Never operate the Drill Press with a damaged drill bit, cutting tool or accessory.
17. Always check that the drill bit, cutting tool or accessory is held tight in the chuck.
18. Never operate the Drill Press with the chuck key in the chuck.
19. Always adjust the depth stop to avoid drilling into the table surface.
20. Never drill material unless it is properly supported. Non flat work pieces require additional support.
21. Always clamp the work piece to the table.
22. Always support large work pieces at the same height as the table.
23. Never remove the work piece or clear the table until the Drill Press comes to a complete stop.
24. Never operate the Drill Press with missing, damaged, worn, loose or defective parts.
25. Never adjust, change speeds or perform maintenance on the Drill Press while it is operating.
26. Always clean the work surface and work area when finished operating the Drill Press.
27. Always disconnect the power when adjusting or performing maintenance on the Drill Press.
28. Always disconnect the power when finished using the Drill Press to prevent accidental operation.

## SAVE THESE INSTRUCTIONS. Refer to them often.

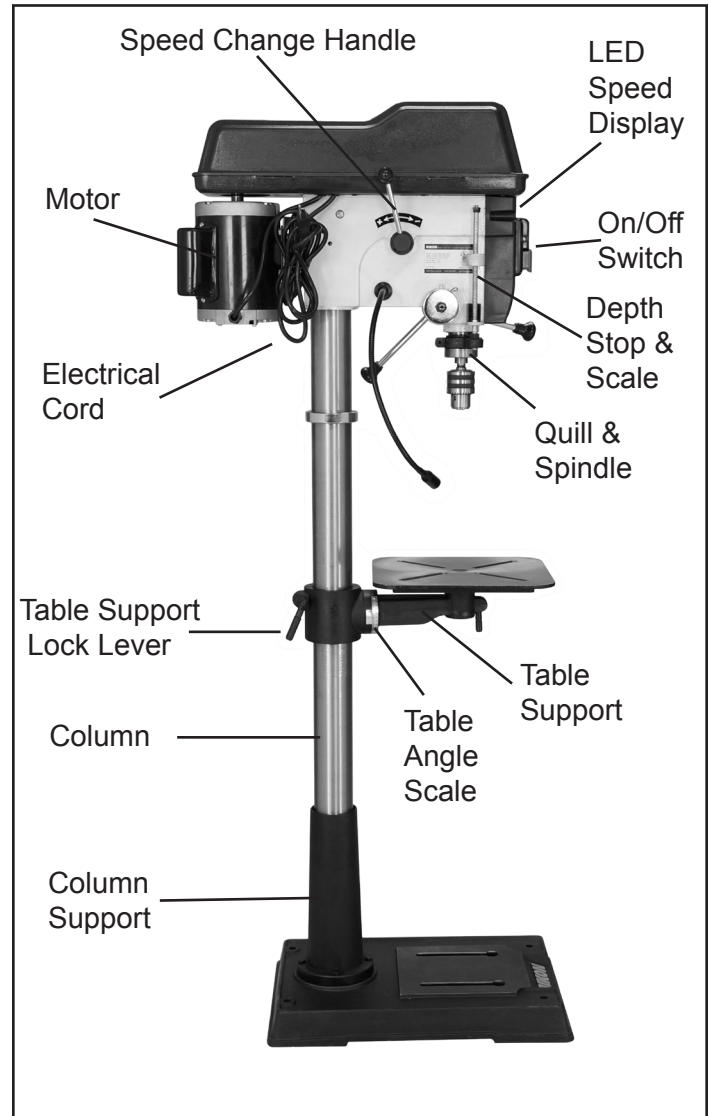
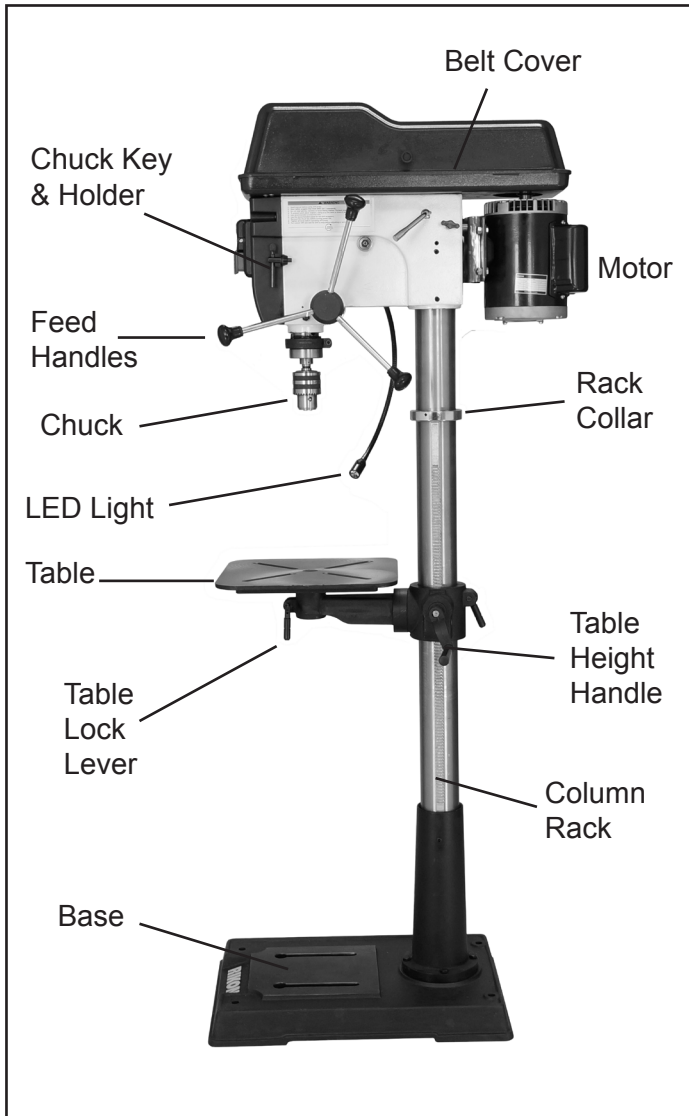
**This owner's manual is not a teaching aid. Use of this owner's manual is intended to show assembly, adjustments, and general use.**

### California Proposition 65 Warning

**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 and birth defects or other reproductive harm. Your risk from exposure to these chemicals varies, depending on how often you do this type of work. To reduce your exposure, work in a well-ventilated area and with approved safety equipment, such as dust masks that are specially designed to filter out microscopic particles.

For more detailed information about California Proposition 65 log onto [rikontools.com](http://rikontools.com).

## GETTING TO KNOW YOUR MACHINE



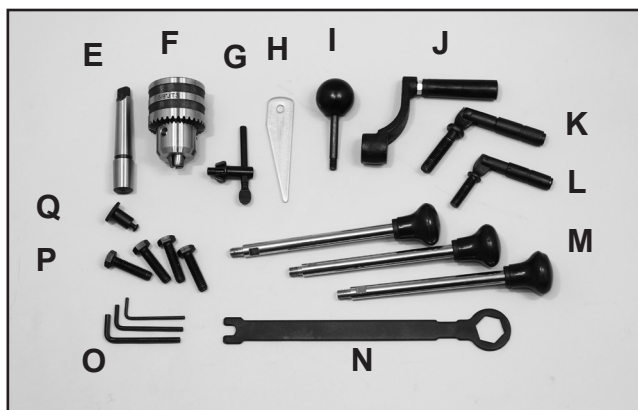
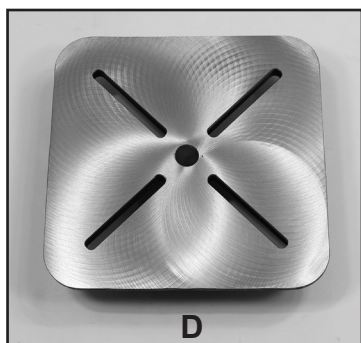
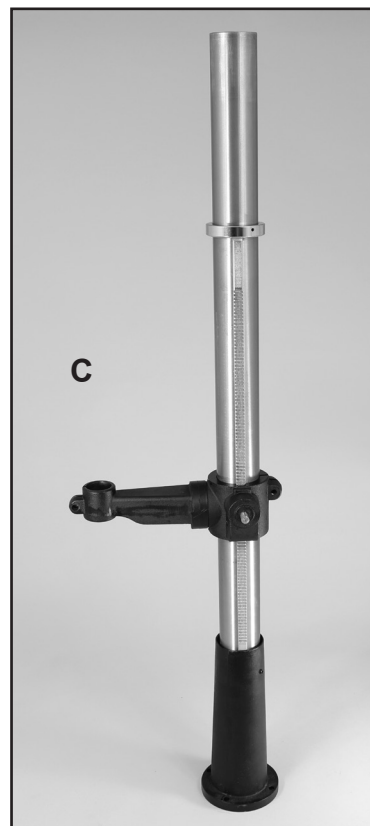
## CONTENTS OF PACKAGE

Model #30-217 17" Variable Speed Drill Press is shipped complete in one box.

### Unpacking and Clean-up

1. Carefully remove all contents from the shipping carton. Compare the contents with the list of contents to make sure that all of the items are accounted for, before discarding any packing material. Place parts on a protected surface for easy identification and assembly. If any parts are missing or broken, please call RIKON Customer Service (877-884-5167) as soon as possible for replacements. DO NOT turn your machine ON if any of these items are missing. You may cause injury to yourself or damage to the machine.
2. Report any shipping damage to your local distributor.
3. Clean all rust protected surfaces with ordinary house hold type grease or spot remover. Do not use; gasoline, paint thinner, mineral spirits, etc. These may damage painted surfaces.
4. Apply a coat of paste wax to the table to prevent rust. Wipe all parts thoroughly with a clean dry cloth.
5. Set packing material and shipping carton aside. Do not discard until the machine has been set up and is running properly.

## CONTENTS OF PACKAGE



### LIST OF LOOSE PARTS

- |                    |                                       |
|--------------------|---------------------------------------|
| A. Head Assembly   | J. Crank Handle                       |
| B. Base            | K. Large Lever Handle                 |
| C. Column Assembly | L. Small Lever Handle                 |
| D. Table           | M. Drive Handles (3)                  |
| E. Arbor JT3 - MT2 | N. Special Wrench - 24mm              |
| F. 5/8" Chuck      | O. Hex Wrenches - 3, 4 & 5mm          |
| G. Chuck Key       | P. Hex Head Bolts (4)                 |
| H. Drift Wedge     | Q. Cover Knob                         |
| I. Speed Handle    | R. Manual & Warranty Card (not shown) |

### Tools Needed for Assembly

- Phillips Screwdriver
- 10mm, 16mm or Adjustable Wrench
- Rubber Mallet or Hammer & Block of Wood

## INSTALLATION

### MOVING & INSTALLING THE DRILL PRESS

**CAUTION** When moving the assembled Drill Press, at least two people are needed. The machine is extremely heavy, and top heavy. Tilt the drill press backwards so that one person can hold the head section. Then the base can be lifted by the second person, and the machine moved to the desired new location. **DO NOT** move or carry the Drill Press with the work table, chuck or operating handles, as this may damage the machine.

1. Position the machine on a solid, level foundation that is located in an area that has ample space in front and to both sides of the drill press for the moving of lumber and projects to be drilled.

2. Align the machine so that during use, any kickback will not face aisles, doorways, or other work areas that bystanders may be in. Do not locate or use the machine in damp or wet conditions.

3. If possible, secure the machine to the floor with lag screws or other fasteners (not supplied). This will ensure the stability of the machine and reduce any possible vibration during use. If this is not possible, the base can be bolted to a larger piece of plywood to help stabilize the machine. **DO NOT** use a mobile base with this machine.

4. For best power and safety, the Drill Press should be directly plugged into a dedicated grounded electrical outlet that is within the supplied cord length of the machine. The use of an extension cord is not recommended.



# ASSEMBLY

**NOTE:** Parts referenced throughout the manual refer to the different sheets and key numbers of the Parts Diagrams and Parts Lists on pages 28 to 39. Example: (#1A) refers to Part #1 on Sheet A.

**WARNING** THE MACHINE MUST NOT BE PLUGGED IN AND THE POWER SWITCH MUST BE IN THE OFF POSITION UNTIL ASSEMBLY IS COMPLETE.

## BASE AND COLUMN ASSEMBLY

1. Place the Base (Part #1A, Figure 1, A) on a level floor where the machine will be used. FIG. 1.
2. Attach the Column (#3A, B) to the base using four M10x40 hex Bolts (#2A). Tighten all four bolts.

**NOTE:** The column is shipped with the toothed Rack (#4A), Collar Rack (#10A) and Table Arm Assembly pre-assembled on the column. The column should be positioned on the base with the table arm facing forward with the rack to the right side of the column.

3. Check the Hex Screw (#22A) on the rear of the support column (B), and the Hex Screw (#11A) on the Collar Rack (#10A) to make sure that they are secure.

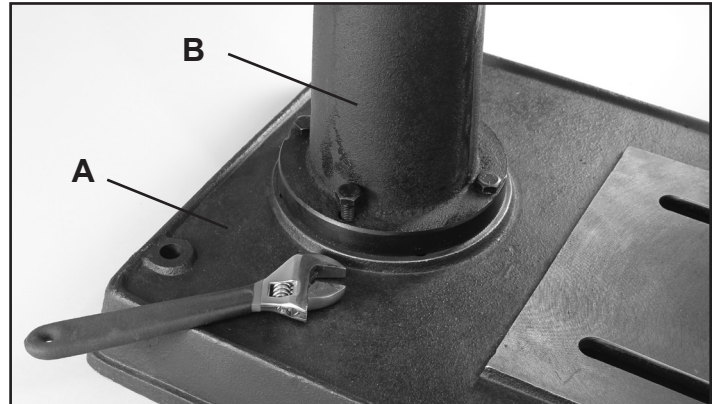


FIG. 1

## INSTALLING THE TABLE

1. Install the large Locking Lever (#12A) onto the rear joint of the table support bracket and tighten the locking lever. FIG. 2.

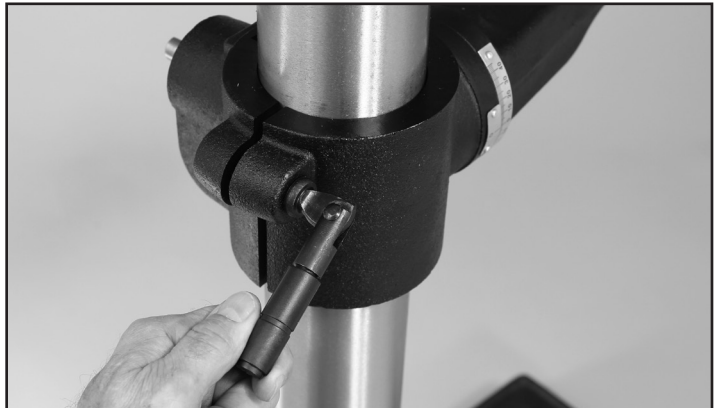


FIG. 2

2. Install the table raising/lowering crank Handle (#6A) to the side shaft of the Table Support (#7A) with a hex wrench. FIG. 3.



FIG. 3

3. If not pre-installed at the factory, install the small Locking Lever (#18A, Fig. 4, A) onto the front joint of the Table Support Bracket (#17A, B). FIG. 4.

4. Insert the table post (C) into the table support bracket (B) as shown in Figure 4. Tighten the locking lever (A) to secure the table in position.

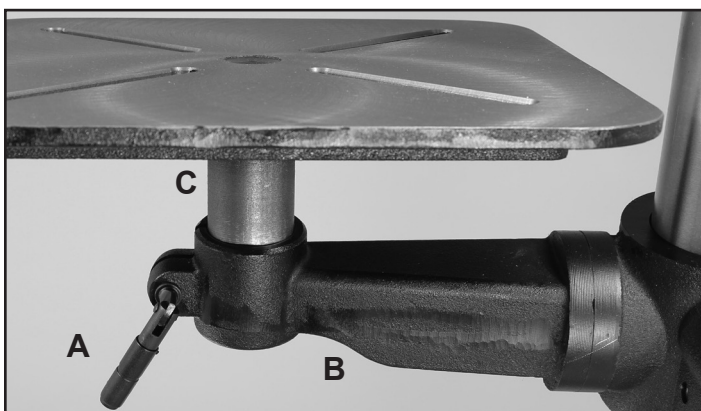


FIG. 4

LINK TO THE #30-217  
ASSEMBLY VIDEO INSTRUCTIONS  
ON THE RIKON WEBSITE  
[WWW.RIKONTOOLS.COM](http://WWW.RIKONTOOLS.COM)



# ASSEMBLY

**⚠ WARNING** THE MACHINE MUST NOT BE PLUGGED IN AND THE POWER SWITCH MUST BE IN THE OFF POSITION UNTIL ASSEMBLY IS COMPLETE.

## HEAD ASSEMBLY

**⚠ CAUTION** Assistance is needed for this next step.

1. Carefully lift and place the drill press head onto the top of the column. It should slip down until the column stops against the inside end of the head casting hole. Swivel the drill press head until it is in line with the base and table. FIG. 5.



FIG. 5

2. Secure the drill press head to the column by tightening the two set screws (#2B) on the right side of the head. FIG. 6, A.

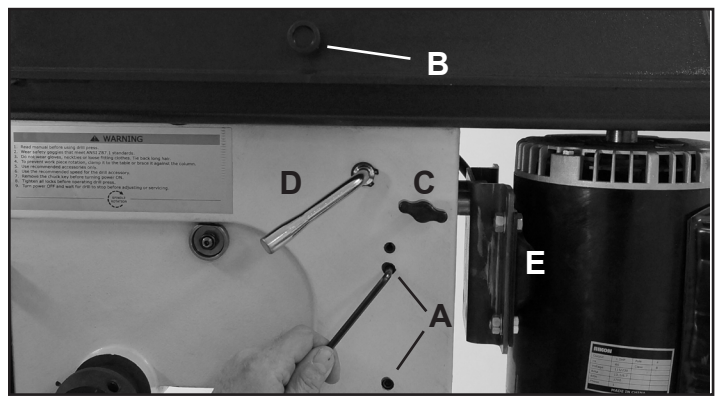


FIG. 6

3. Install the small, belt cover Handle Knob (#2, on Parts Diagram C) onto the right side of the top lid. Open the belt cover and insert the Phillips head screw through the hole in the lid from the inside. Thread the handle on the outside of the belt cover and tighten it in place with a screwdriver. FIG. 6, B.

4. Install the three feed Handles (#67B) into the pre-threaded holes in the Handle Seat (#68B). Use a 10mm or adjustable wrench (not supplied) to secure the handles in place. FIG. 7.



FIG. 7

**NOTE:** Figures 6 & 7 also show the motor Lock Knobs (#6B, C), Tension Lever (#5B, D) and the motor Mount Assembly (E) that are referenced in the section on Changing Belt Speeds on page 14.

5. On the left side of the drill press head, install the small Motor Speed Handle (#39B) onto the Handle Seat (#40B). The handle seat has 3 holes to allow the handle to be inserted into the one that is best positioned for your grasping and rotating to change the operating speeds of the machine. FIG. 8.



FIG. 8

Parts Diagrams and Parts Lists are listed on pages 20 to 26.

Replacement parts can be ordered through your local RIKON Tool Distributor, or directly from RIKON.

Visit [www.rikontools.com](http://www.rikontools.com) for contact information.

# ASSEMBLY

## INSTALLING & REMOVING THE CHUCK

**IMPORTANT!** It is important that the tapered hole in the chuck, tapered hole in the spindle and both tapered ends of the arbor are free of any grease, oil, lacquer or rust protection.

These tapered surfaces must be absolutely clean for a precision fitting of the parts, so slipping of the chuck during use does not occur unless there is extreme rotational pressure during use. This is a safety feature of this type of friction fit joint.

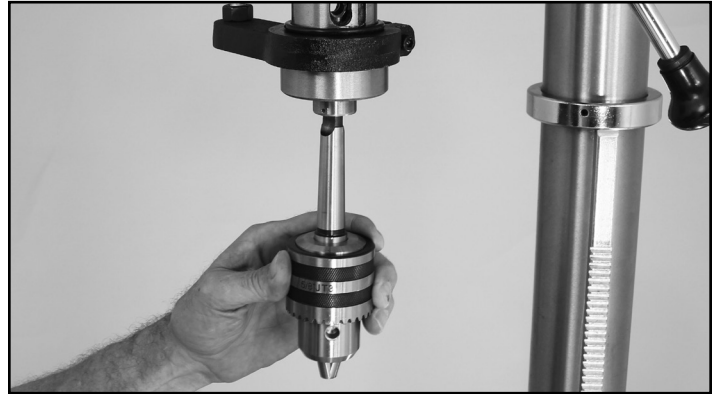


FIG. 9

## INSTALLING THE CHUCK

1. Carefully insert the arbor's short, JT3 tapered end into the rear tapered hole of the chuck. FIG. 9.

2. Next, take the chuck and insert the long, MT2 tapered end of the arbor into the drill press spindle's tapered hole. Make sure to align the flat part of the arbor with the slot in the spindle. FIG. 10.

3. Open the jaws of the chuck until the 3 jaws are completely hidden inside of the chuck body.

4. Using a rubber mallet, or hammer with a block of wood protecting the chuck, tap the chuck with its arbor into the drill press spindle. This will securely seat the chuck in place for drilling. FIG. 11.

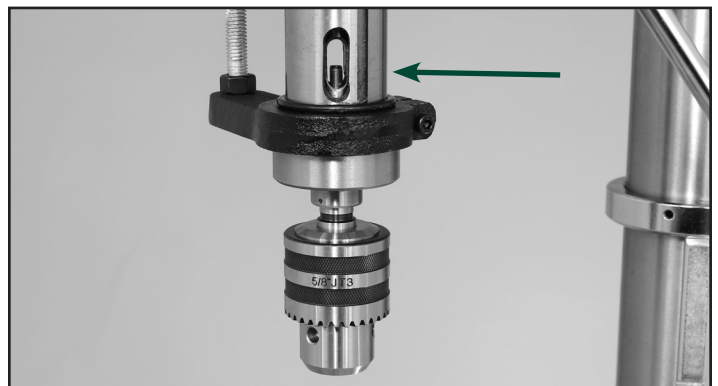


FIG. 10

**CAUTION** NEVER HIT THE CHUCK WITH A METAL HAMMER. This could damage the chuck assembly, arbor or drill press spindle.

## REMOVING THE CHUCK

1. Open the chuck jaws as wide as possible to prevent damage in the following steps.

2. Lower the spindle until the slot in the spindle is exposed, and lock it in place with the lower, Depth Stop Block/circular nut (#14, on Parts Diagram D). FIG. 12.

3. Turn the chuck until the slots in the spindle (#3D) and Quill (#6D) align, and a through-hole is exposed.

4. Insert the Key-Drift (#5D), into the slots and hole above the chuck arbor, with the drift's flat side up.

5. Gently tap the key-drift with a mallet to release the chuck. **NOTE:** Be prepared to catch the chuck as it is released to prevent any damage to it or the arbor.



FIG. 11

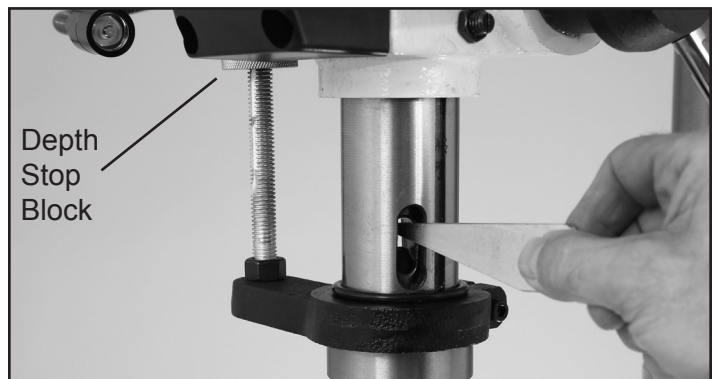


FIG. 12

# ADJUSTMENTS

## ADJUSTING THE TABLE

1. *TO RAISE OR LOWER THE TABLE* along the column, the Locking Handle (#12, on Parts Diagram A) must be loosened. FIG. 13, A.

2. Use the Crank Handle (#6A, B) to raise or lower the work table to the height that you need.

**NOTE:** Always *raise* the table to your final height so that the gears mesh together best to prevent slippage.

3. When the table is at the proper height, tighten the Locking Handle to secure the table in position.

4. *TO ROTATE THE TABLE* left or right, loosen the Locking Handle (#18A) that is positioned directly below the table. FIG. 14, C.

**NOTE:** If needed for special drilling or project clamping applications, the whole table assembly can be swiveled 360° around the column. Loosen the Set Screw (#11A) on the Collar Rack (#10A), Locking Lever (#12A) and carefully rotate the table assembly with the rack around the column to the location you need. Then re-tighten the set screws and lever to secure the parts in the new position on the column.

5. *TO TILT THE TABLE* on an angle, the table and support arm assembly move together. Loosen the large M16x35 Bolt (#19A) with the 24mm wrench provided. FIG. 15 & 16.

6. The table and support arm can be tilted left or right. An Angle Scale (#15A) is provided on the casting to indicate the degree of tilt of the table. FIG. 15. When the desired table tilting angle is found, the large bolt needs to be tightened.

7. To return the table to the level position, 90° to the spindle, loosen the large bolt secured in step 5. Rotate the table assembly until the angle scale cursor lines up with the 0° mark. Then re-tighten the large bolt on the support arm.

8. *TO SET THE TABLE TO HORIZONTAL*, or 90° to the Quill, use a mechanic's square. Set the square on the table and position it against a twist drill bit that is held in the chuck. Adjust the table angle as needed to set it at the horizontal 90° position.

**NOTE:** The hex screw (#11A) that is located below the large bolt can also be used to slightly tilt the table level towards the column, if necessary, to adjust the table horizontal in this direction.

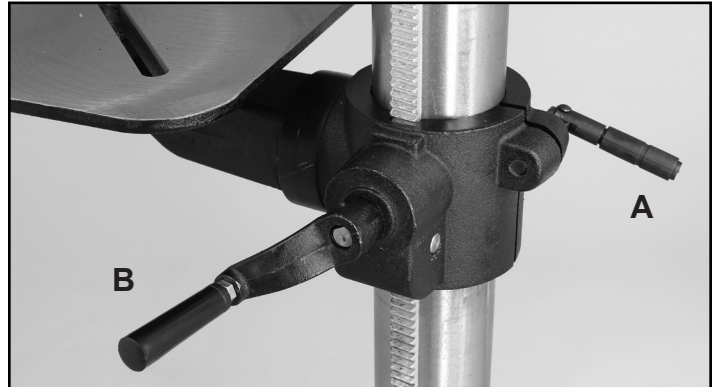


FIG. 13

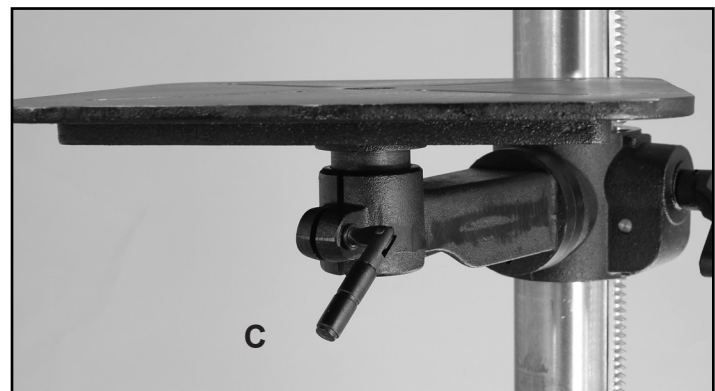


FIG. 14

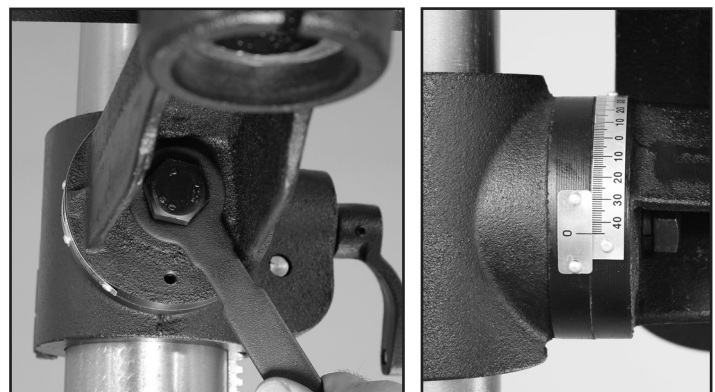


FIG. 15

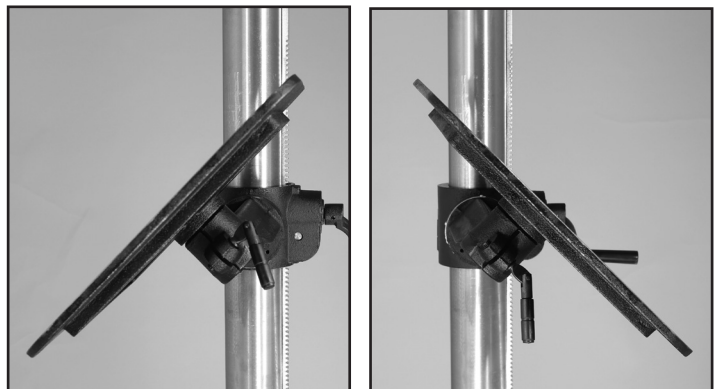


FIG. 16

# ADJUSTMENTS

## ADJUSTING THE DEPTH STOP

The Depth Stop is used for boring multiple holes at the same, identical depth. The threaded rod includes a scale and a large quick release nut for fast setting of the depth that the spindle/chuck will travel. FIG. 17.

The chuck's travel distance/depth is read on the scale at the top of the Depth Setting Nut (#16 on Parts Diagram D). At reading '0', the Depth Setting Nut should be down on top of the Depth Plate (#58 on Diagram B). FIG. 17.

Setting the a specific depth can be done in 2 ways:

### THE DEPTH SCALE METHOD

1. With your workpiece on the table, raise the table until the surface of the workpiece touches the drill bit that is in the chuck. Lock the table in position.
2. Adjust the Depth Setting Nut to the desired depth on the threaded rod's scale. The Depth Nut has a quick release button for fast moving of the nut.  
**NOTE:** Depth is read at the TOP of the nut. The Depth Nut can also be rotated for fine depth adjustments. FIG. 18.
3. Drill a test hole to check the depth setting, and adjust the depth setting as necessary. It is best to use a scrap piece of wood, that is the exact same thickness of your workpiece, for test drilling to ensure the proper results.

### THE WORKPIECE METHOD

1. Mark a line on the side of a workpiece at the desired depth needed.
2. Lower the drill bit that is in the chuck along the side of the workpiece, until it aligns with the drawn line.  
**NOTE:** The machine must be OFF for this procedure.
3. Holding the drill bit at the desired depth, lower the Depth Setting Nut until it rests down on the metal Depth Plate. The drilling depth is now set.
4. Drill a test hole to check the depth setting, and adjust as necessary. It is best to use a scrap piece of wood that is the exact same thickness of your workpiece for test drilling, to ensure the proper results.



FIG. 17

**WARNING** THE MACHINE MUST NOT BE PLUGGED IN AND THE POWER SWITCH MUST BE IN THE OFF POSITION UNTIL ALL ADJUSTMENTS ARE COMPLETE.



FIG. 18



FIG. 19

# ADJUSTMENTS

## ADJUSTING THE QUILL HEIGHT

The Quill (#6D, Fig. 20, A) can be set to a particular depth or position with the lower, round Depth Motion Nut (#14D, B) on the Depth Threaded Rod (#15D, C). This nut is located under the metal Depth Plate (#58D, FIG. 20 D).

1. Lower the Quill/Chuck to the depth that is desired with the feed handles.
2. Turn the Depth Motion Nut (B) up the Threaded Rod (C) until it stops up against the Depth Plate (D).
3. Release your hold on the drill press' feed handles and the Quill with chuck will stay in the set position.

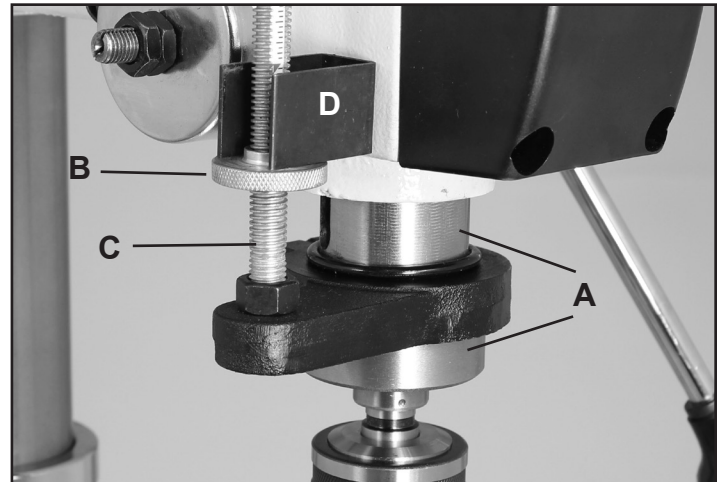


FIG. 20

## ADJUSTING THE DRILL SPEED

**CAUTION** The Drill Press motor **MUST** be operating before changing the speeds is done, or damage to the speed adjustment mechanisms may result.

1. To adjust the operating speeds while the drill press is running, rotate the Speed Handle Lever (#39B, Fig. 21, C) until the desired speed is shown on the LED display (D) on the machine front. FIG. 21.
  - Move the lever FORWARD for slower speeds.
  - Move the lever BACKWARD to increase speed.

This Drill Press has two variable speed ranges from 200 to 700 and 600 to 2,200 RPM. To change from one speed range to the other, only the rear Drive V-Belt (#1C) needs to be re-positioned on the pulleys.

2. Loosen the belt tension by moving the motor closer to the head casting. Loosen the two Lock Knobs (#6B) then pull the Tension Lever (#5B) forward to shift the motor mount assembly forward. See page 10, Figures 6 & 7 for photos identification of these parts.

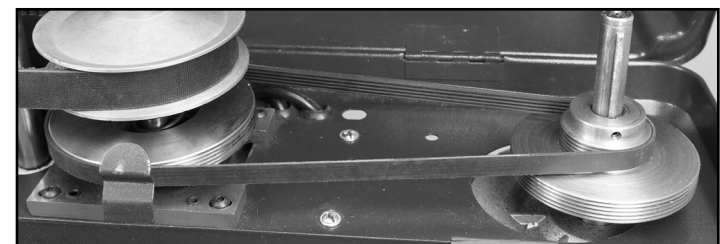
3. Move the V-Belt on the rear and center pulleys to set the drill press speeds as shown to the right;
  - LOW SPEED - Belt is on the large, top step on the center pulley to the small top step on the rear pulley.
  - HIGH SPEED - Belt is on the small, bottom step on the center pulley to the large, bottom step on the rear pulley.

4. Reset the Belt tension by moving the motor back from the head casting by reversing the steps in #2.

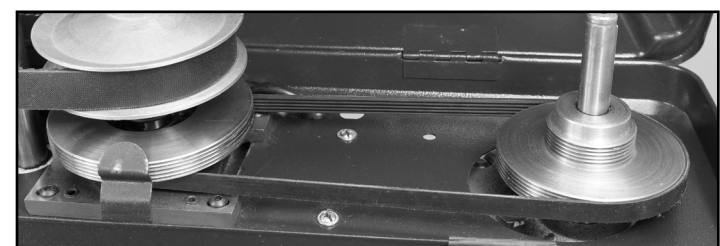


FIG. 21

RPM Reader  
Under the  
Front Pulley



Belt Position on Pulleys at Low Speed



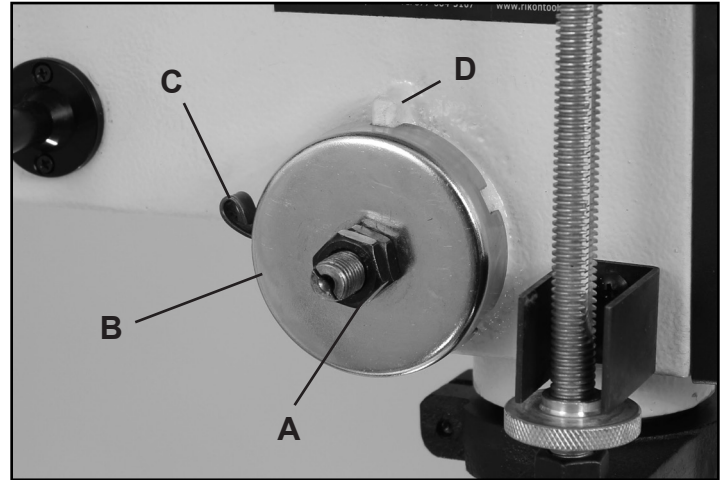
Belt Position on Pulleys at High Speed

# ADJUSTMENTS

## ADJUSTING THE SPINDLE RETURN SPRING

The Chuck will automatically return upward to its original starting position when the operating handle is released. The Return Spring Mechanism, FIG. 22, has been preset at the factory and should not require any adjustments. However, should the spring tension decline and need adjustment, follow these steps;

1. Disconnect the Drill Press from its power source.
2. Loosen the Spring Cover Nuts (FIG. 22, A, #45 on Parts Diagram B), but **DO NOT REMOVE** the nuts from the threaded pin.
3. Carefully pull out the Spring Cover (#46B, Fig. 22, B) slightly, and keep a firm grasp on it - **DO NOT LET THE COVER SPIN** as it keeps the spring from unwinding. Also, **DO NOT** let the spring end (C) disengage from its notch in the spring cover!
4. Pull out the cover just enough so that the notch in the cover clears the nub on the head casting (D).



**FIG. 22**

5. Rotate the cover to another notch as needed - **CLOCKWISE** to decrease the spring tension, and **COUNTER-CLOCKWISE** to increase spring tension.
6. With the cover set in the new position, push it back in place and tighten the spring cover nuts back against the cover to complete the adjustment.

## CHANGING MOTOR VOLTAGE

The 30-217 VS Drill Press is equipped with a dual voltage 115/230V motor. To change from the factory preset 115V operating mode to a 230V circuit, consult the wiring diagram on page 18.

**NOTE:** Changing of the motor wiring or power supply cable should only be done by a qualified electrician.

# OPERATION

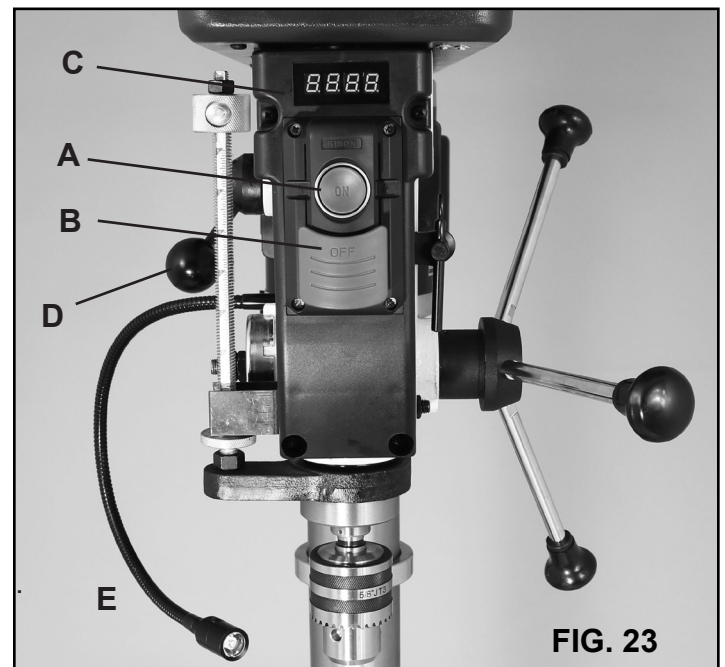
## CONTROL PANEL

1. **ON/OFF SWITCH.** The ON/OFF safety switch is located on the front of the drill press head for quick, easy and safe access. Push the top green button (A) to turn the machine on. Push the lower red paddle pad (B) to turn the drill press OFF. FIG. 23.

Behind the ON button is a thru hole for locking out the controls with a padlock that has a long hasp, thus preventing unauthorized use of the machine.

2. **SPEED RPM DIGITAL READOUT (C)** displays the Chuck's RPM as set by the Motor Speed Handle Lever (D) (see page 14). **NOTE:** Speeds indicated may fluctuate during use, as the RPM reader is constantly calibrating the spindle rotation.

3. **LED LIGHT (E)** with flexible neck can be easily positioned to best light your work. The light's housing has an ON/OFF push button for easy operation



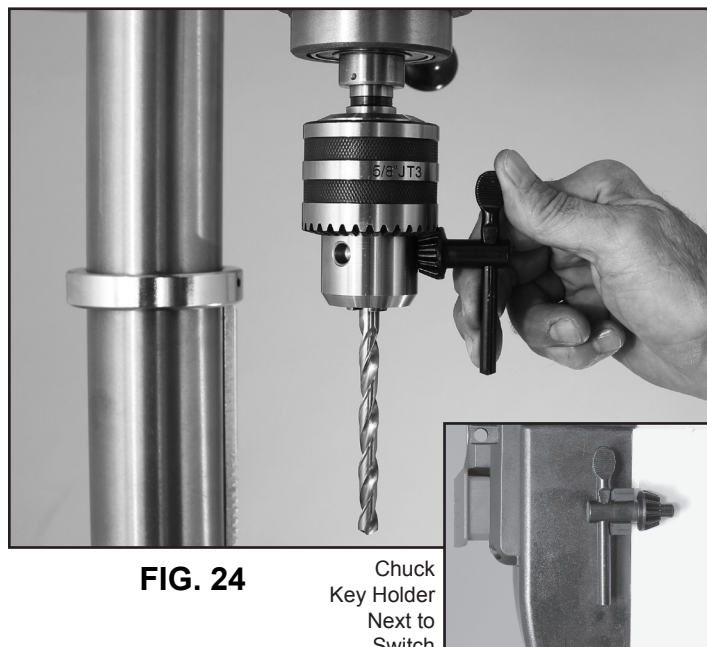
**FIG. 23**

# OPERATION

## INSTALLING AND REMOVING DRILL BITS

The 30-217 VS Drill Press includes a 3-jaw keyed chuck (ref. page 11) for the holding of drill bits with shanks up to 5/8" diameter. To install a drill bit;

1. Disconnect the machine from the power source and make sure that the switch is in the OFF position.
2. With the chuck key, turn the upper, knurled section of the chuck to open the three chuck jaws. FIG. 24.
3. Insert the shank of the drill bit into the chuck as far as it will go, or up to the beginning of the flutes that are in the drill bit.
4. Make sure that the drill bit is centered in the jaws, and with the supplied chuck key, insert the key into one of the chuck barrel's three holes and surrounding teeth. Turn the key to tighten the chuck jaws and secure the drill bit shank in place. Remove the key and repeat this tightening on the other 2 chuck holes.
5. To remove a drill bit from the chuck, reverse the chuck tightening operation detailed in step 4 above.



**WARNING:** DO NOT run the drill press to open or close the chuck when installing or removing a drill bit.

**WARNING:** Make sure that the drill bit is secure in the chuck, and the chuck key has been removed from the chuck before starting the drill press.

## DRILLING SPEEDS

This Drill Press has two variable speed ranges from 200 to 700 and 600 to 2,200 RPM. The correct drilling speed for your work depends on a variety of factors:

- a) the workpiece material & hardness
  - wood, composites, plastics or metal
- b) the size of hole diameter
- c) the depth of the hole
- d) the type of drill bit or other cutter needed to make the desired hole diameter and depth
- e) the quality of the bore

We recommend consulting various books, magazine articles, drill bit and material manufacturers' information for information on the proper operating speeds and types of drills for the material or hole desired.

- A general rule: The larger the hole and the harder the material = the slower the RPM speed.

**NOTE:** See page 6 for important safety information on drilling set-ups and procedures.

## WORKPIECE POSITIONING

**WARNING:** Always use clamps or hold-downs to secure the material onto the drill press table during drilling. This will prevent the work from being torn from the operator's hand should the drill bit gets caught in the material. Clamping the work to the table is particularly necessary if the table is tilted on an angle.

Place a scrap board or piece of plywood under your work to protect the metal table, drill bit, and to provide a solid base for a clean hole if the drill bit exits the work.

To prevent work from spinning, if possible, position the work to rest against the left side of the column. For shorter pieces, use a clamp or drill press vise secured to the table.

Feed bits into the material at a constant rate to allow the bit to work. Too slowly may cause the wood to burn and ruin the bit. Too fast may put excessive stress on the motor and cause the bit to break.



# MAINTENANCE

**⚠ WARNING:** Turn the power switch “OFF” and disconnect the plug from the outlet prior to adjusting or maintaining the machine. DO NOT attempt to repair or maintain the electrical components of the motor. Contact a qualified service technician for this type of maintenance.

1. Before each use:

- Check the power cord and plug for any wear or damage.
- Check for any loose screws, hardware or parts.
- Check the area to make sure it is clear of any misplaced tools, lumber, cleaning supplies, etc. that could hamper the safe operation of the machine.

2. To avoid a build-up of wood dust, regularly clean all parts of the machine using a soft cloth, brush or compressed air. A general cleaning should be done after every use to avoid future problems and ensure the machine is in ready condition for its next use.

**WARNING:** If blowing sawdust, wear proper eye protection to prevent debris from blowing into eyes.

3. Keep the machined surfaces of the drill press table and base free of resin and rust. Clean them regularly with a non-flammable solvent, then coat with a light film of dry lubricant spray or wax.

5. Lubricate the table bracket and locking lever bolts to keep them operating smoothly.

4. Clean the column on a regular basis to prevent the build-up of dust, drilling residue and rust. Treat the posts with a dry lubricant spray or a light coating of wax. Do not use ordinary oil which will collect dust and hamper the movement of parts along the column.

6. Periodically, lower the quill assembly and apply a light coating of machine oil to the quill and spindle surfaces. Raise and lower the quill a few times to distribute the oil on all of the internal surfaces.

7. Apply #2 tube grease to the worm gears in the table elevation mechanism and rack to keep them operating smoothly.

8. The ball bearings in the spindle and pulley assemblies are lifetime lubricated, sealed, and do not need any further care.

9. Keep the drive belt and pulley surfaces free of oil and grease. Periodically, check the drive belt for wear and replace if necessary.

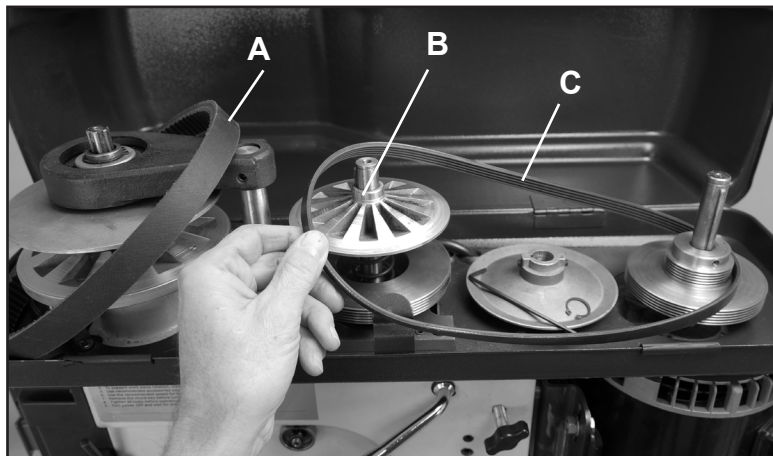
## CHANGING THE DRIVE BELT

1. Turn on the drill press and adjust the spindle speed to the highest speed setting, in either the low range 700 RPM or the high range 2,200 RPM. This sets the gear plates high up on their spindles. See page 14 for Adjusting Drill Speeds.

2. Turn the machine OFF and disconnect it from the power source.

3. Open the top lid to access the drive belts. Remove the large, front V-Belt (#12C, Fig. 24, A). This is done by first removing the top, Fixed Motor Pulley (#30B) from the center Pulley Shaft (#23B, B). Take off the Circlip Ring (#29B), loosen the two Hex Set Screws (#32B), and lift the pulley off of the shaft.

4. Work the front, large drive belt (A) up and off of the center shaft and lay in aside to re-install later.



**FIG. 24**

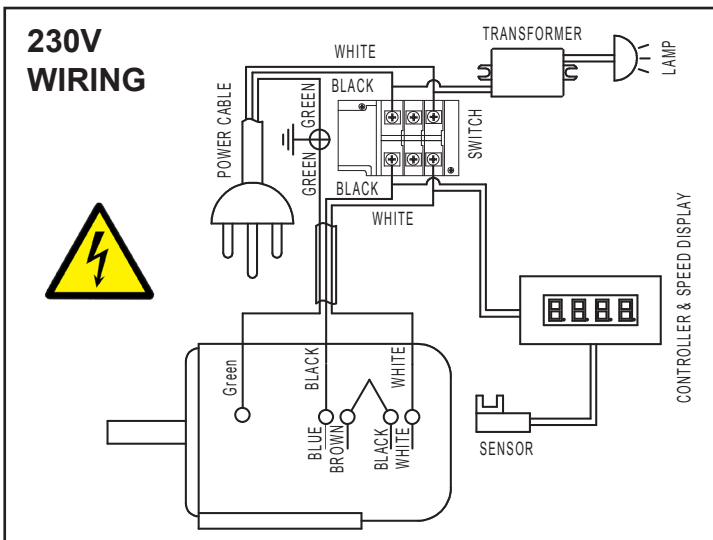
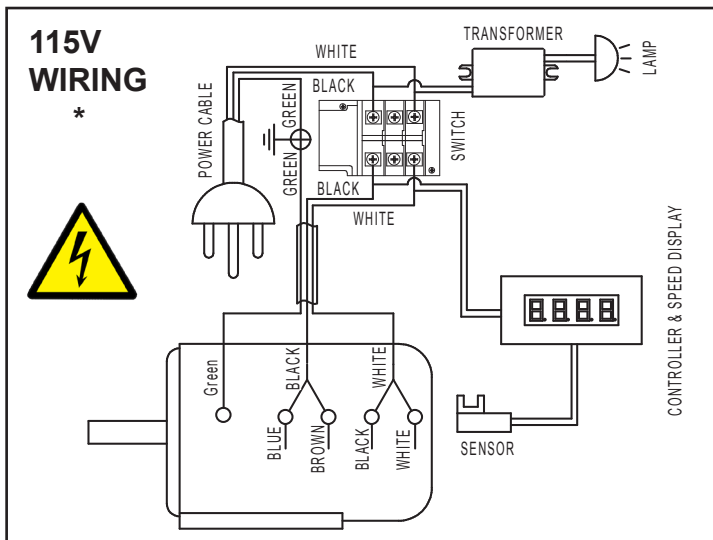
5. Remove the rear Drive V-Belt (#1C, Fig. 24, C) from the rear pulley and center shaft.

6. Replace the belts by reversing the process.

# WIRING DIAGRAM



This machine must be grounded. Replacement of the power supply cable should only be done by a qualified electrician. See page 5 for additional electrical information.



**For 115V wiring;** Connect the blue & brown motor terminal wires to the black switch wire lead, and connect the black & white terminal wires to the white switch wire lead. \* **NOTE:** The 30-217 is pre-wired for 115V use.

**For 230V wiring;** Tie the black & brown terminals together, connect the white motor terminal wire to the white switch wire lead, and connect the blue motor terminal wire to the black switch wire lead. Additional wire connectors (not included) may be required.

# TROUBLESHOOTING

PROBLEM	PROBABLE CAUSE	REMEDY
Motor will not start	<ol style="list-style-type: none"> <li>1. Machine is not plugged in</li> <li>2. Low line voltage</li> <li>3. Loose connection</li> <li>4. Defective switch</li> <li>5. Defective motor capacitor</li> </ol>	<ol style="list-style-type: none"> <li>1. Plug in machine</li> <li>2. Check fuses or reset circuit breaker, if using extension cord, discontinue and plug machine directly into wall outlet</li> <li>3. Check plug and all connections</li> <li>4. Replace switch</li> <li>5. Replace capacitor</li> </ol>
Motor fails to develop full power.	<ol style="list-style-type: none"> <li>1. Power line is overloaded</li> <li>2. Undersize wires in supply system</li> <li>3. Drive belt tension is too high</li> <li>4. Low line voltage</li> <li>5. Motor malfunctioning</li> </ol>	<ol style="list-style-type: none"> <li>1. Correct the overload condition</li> <li>2. Increase supply wire size or eliminate using an extension cord</li> <li>3. Adjust belt tension</li> <li>4. Have voltage checked by an electrician and corrected, if necessary</li> <li>5. Test motor to fix or replace</li> </ol>
Motor stalls	<ol style="list-style-type: none"> <li>1. Overfeeding of drill bit into material</li> <li>2. Dull drill bit</li> <li>3. Motor malfunction, not reaching speed</li> </ol>	<ol style="list-style-type: none"> <li>1. Slower feed rate of the bit into material</li> <li>2. Sharpen or replace drill bit</li> <li>3. Check motor capacitor and line voltage</li> </ol>
Motor overheats	<ol style="list-style-type: none"> <li>1. Motor is overloaded</li> <li>2. Air flow restricted on the motor</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load, slow down feed rate</li> <li>2. Clean motor to increase air flow</li> </ol>
Digital readout does not work	<ol style="list-style-type: none"> <li>1. Digital readout sensor out of position</li> </ol>	<ol style="list-style-type: none"> <li>1. Contact Technical Support at 877-884-5167 or email RIKON at techsupport@rikontools.com</li> </ol>

# TROUBLESHOOTING



**WARNING**

**FOR YOUR OWN SAFETY, ALWAYS TURN OFF AND UNPLUG THE MACHINE BEFORE CARRYING OUT ANY TROUBLESHOOTING.**

PROBLEM	PROBABLE CAUSE	REMEDY
Noisy operation	<ol style="list-style-type: none"> <li>1. Excessive machine vibration</li> <li>2. Dry spindle</li> <li>3. Loose pulleys</li> <li>4. Noisy motor</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten any loose parts. Secure drill press to the floor or plywood base</li> <li>2. Lubricate spindle, quill, etc.</li> <li>3. Make needed corrections</li> <li>4. Check motor bearings and fan</li> </ol>
Drill bit or material smokes or burns	<ol style="list-style-type: none"> <li>1. Drilling speed is too fast</li> <li>2. Chips are not clearing out of hole</li> <li>3. Dull drill bit</li> <li>4. Feeding bit is too slow</li> <li>5. Bit is not lubricated</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce drilling speed</li> <li>2. Retract drill bit frequently to clear chips</li> <li>3. Change or sharpen drill bit</li> <li>4. Increase feed speed</li> <li>5. Lubricate bit. Make sure bit and flutes are clean of rust, resin build-up, etc.</li> </ol>
Drill bit wanders or wobbles	<ol style="list-style-type: none"> <li>1. Bit not installed correctly in the chuck</li> <li>2. Bit sharpened incorrectly</li> <li>3. Bit is bent or shank is damaged</li> </ol>	<ol style="list-style-type: none"> <li>1. Re-install bit in chuck jaws correctly</li> <li>2. Sharpen bit correctly or replace bit</li> <li>3. Replace bit</li> </ol>
Drill bit binds in the work piece	<ol style="list-style-type: none"> <li>1. Work piece is pinching the drill bit</li> <li>2. Excessive feed rate</li> <li>3. Chuck jaws are not holding bit tight</li> </ol>	<ol style="list-style-type: none"> <li>1. Support or clamp down the work piece</li> <li>2. Slow down the feed rate</li> <li>3. Tighten the chuck jaws on the bit</li> </ol>
Drill bit slips	<ol style="list-style-type: none"> <li>1. Bit not installed securely in the chuck</li> </ol>	<ol style="list-style-type: none"> <li>1. Re-install the bit tightly in the chuck</li> </ol>
Wood splinters on the underside of work piece	<ol style="list-style-type: none"> <li>1. No supporting 'back up material' under the work piece</li> </ol>	<ol style="list-style-type: none"> <li>1. Use scrap board or plywood under the work piece for support when the drill bit bores through the work</li> </ol>
Work piece turns loose during drilling	<ol style="list-style-type: none"> <li>1. Work piece is not supported or clamped securely to the table</li> </ol>	<ol style="list-style-type: none"> <li>1. Support the work piece or clamp it securely to the drill press table</li> </ol>
Quill returns too slow or too fast	<ol style="list-style-type: none"> <li>1. Spindle return spring has improper tension</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust spindle return spring tension</li> </ol>
Chuck will not stay attached to the spindle	<ol style="list-style-type: none"> <li>1. Grease, oil or dirt is on the inside taper of the chuck or on the spindle taper</li> </ol>	<ol style="list-style-type: none"> <li>1. Clean the tapered surfaces of the chuck and spindle to remove residue</li> </ol>

## NOTES

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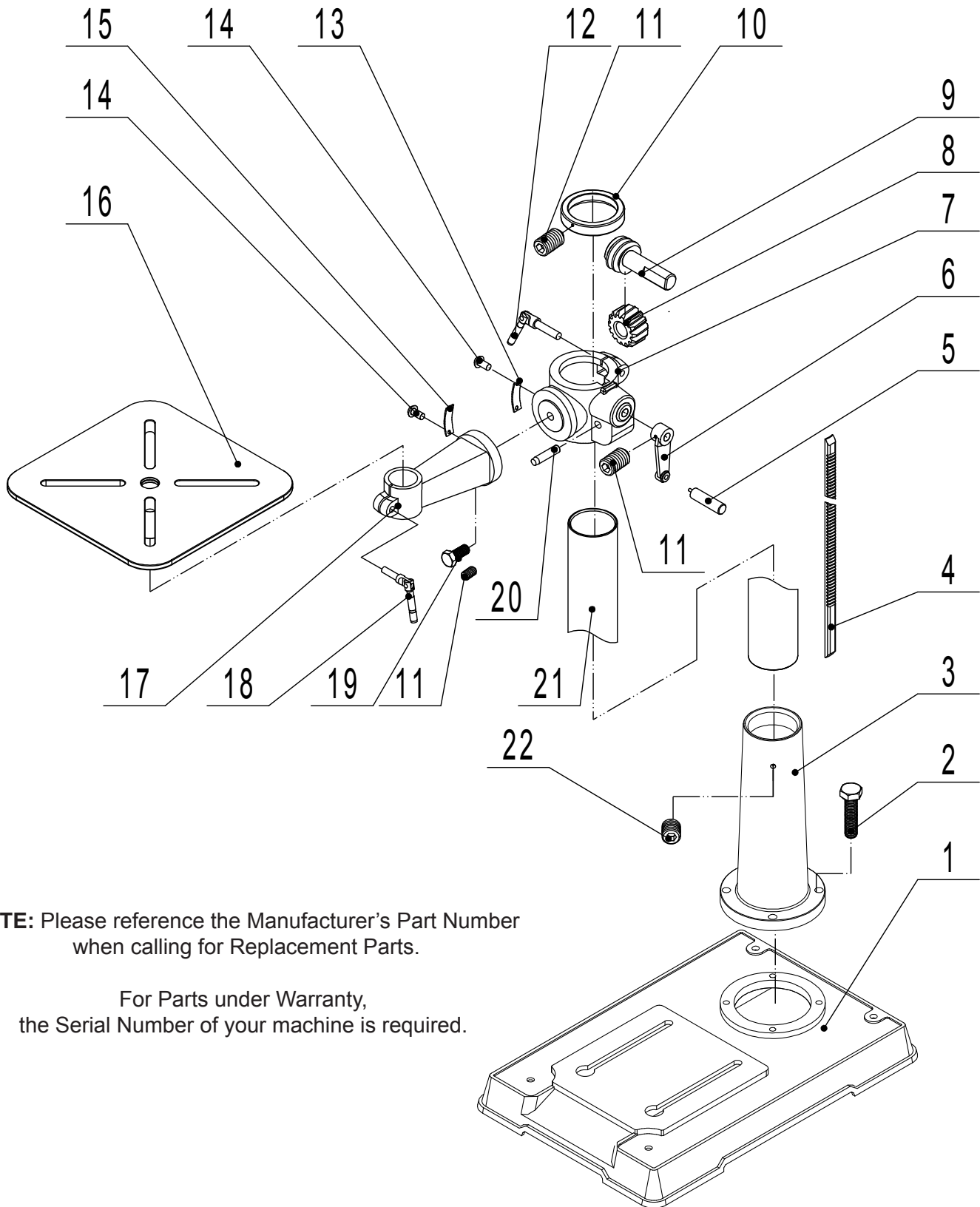
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# PARTS DIAGRAM

## COLUMN & TABLE SHEET A



**NOTE:** Please reference the Manufacturer's Part Number when calling for Replacement Parts.

For Parts under Warranty,  
the Serial Number of your machine is required.

# PARTS LIST

## COLUMN & TABLE SHEET A

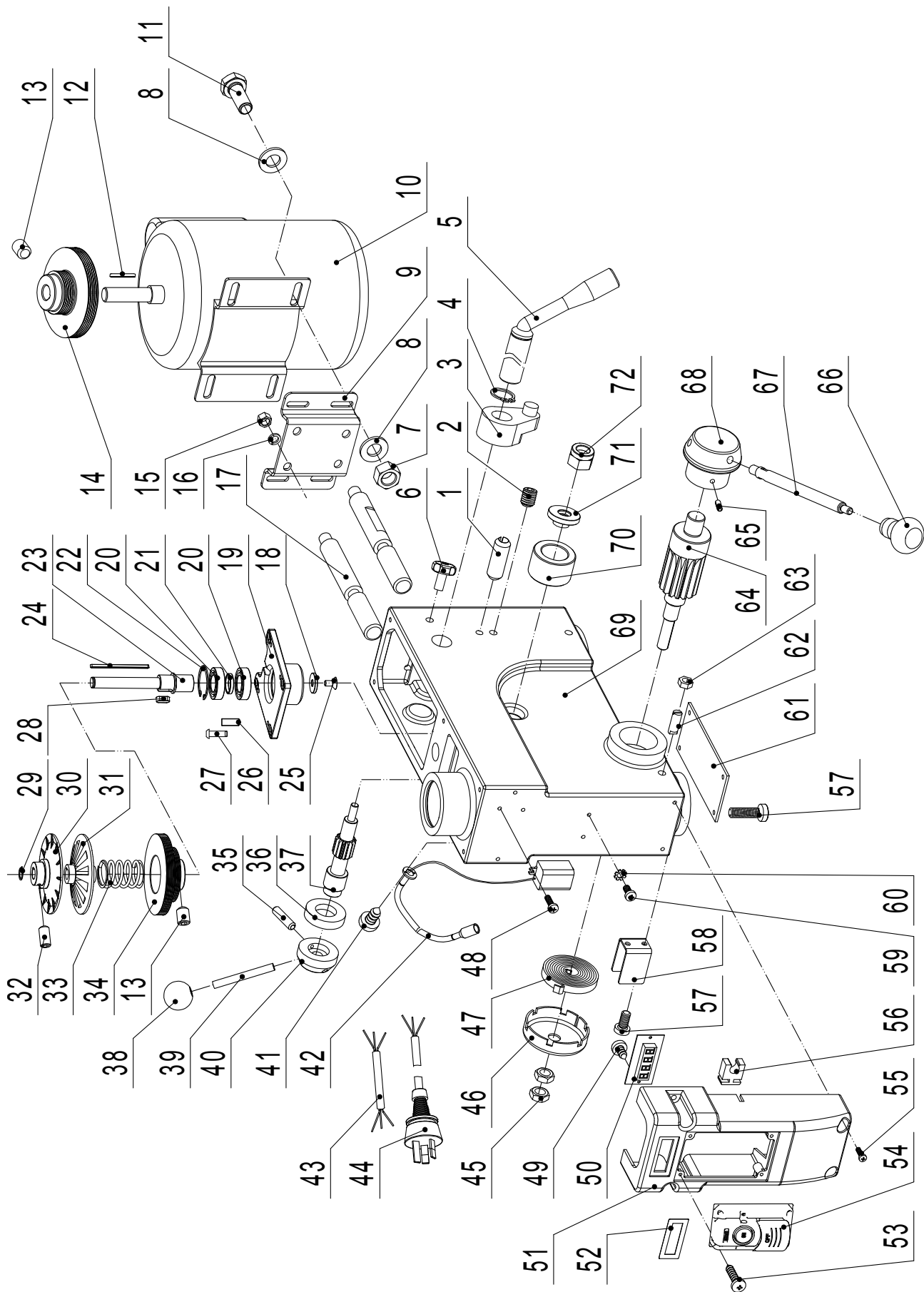
KEY NO.	DESCRIPTION	PART NO.	QTY.
1A	Base	1-1901001-01001G	1
2A	Hex bolt M12x40	1-M12X40GB5781B	4
3A	Support column	1-JMDP1701010002-001G	1
4A	Rack	1-1501010	1
5A	Handle assembly	1-1501009-20001S	1
6A	Crank	1-1501009-10001G	1
7A	Support table, with indicator	1-1701004-00001G	1
8A	Gear - helical	1-1501006	1
9A	Worm - elevation	1-1501008	1
10A	Collar rack	1-1701011-0001Z	1
11A	Socket head cap screw M6x10	1-M6X10GB80B	2
12A	Locking handle assembly	1-1501012-01001S	1
13A	Table angle degree indicator	1-1506002	1
14A	Rivet	1-RVT2D5X5GB827C	4
15A	Scale	1-1506001	1
16A	Table	1-JMDP1701010005-001G	1
17A	Arm table, with scale	1-1701005-00001G	1
18A	Locking handle assembly	1-1501013-01001S	1
19A	Bolt M16x35	1-M16X35GB5781B	1
20A	Pin - gear	1-1501007	1
21A	Tube column	1-JMDP1701010003	1
22A	Socket head cap screw M10x12	1-M10X12GB80B	1
23A	Table insert 30 x 4mm (not shown)	1-1701016-00001S	1

**NOTE:** Please reference the Manufacturer's Part Number when calling for Replacement Parts.  
For Parts under Warranty, the Serial Number of your machine is required.

# PARTS DIAGRAM

## HEAD, MOTOR & CONTROLS SHEET B

**NOTE:** Please reference the Manufacturer's Part Number when calling for Replacement Parts. For Parts under Warranty, the Serial Number of your machine is required.



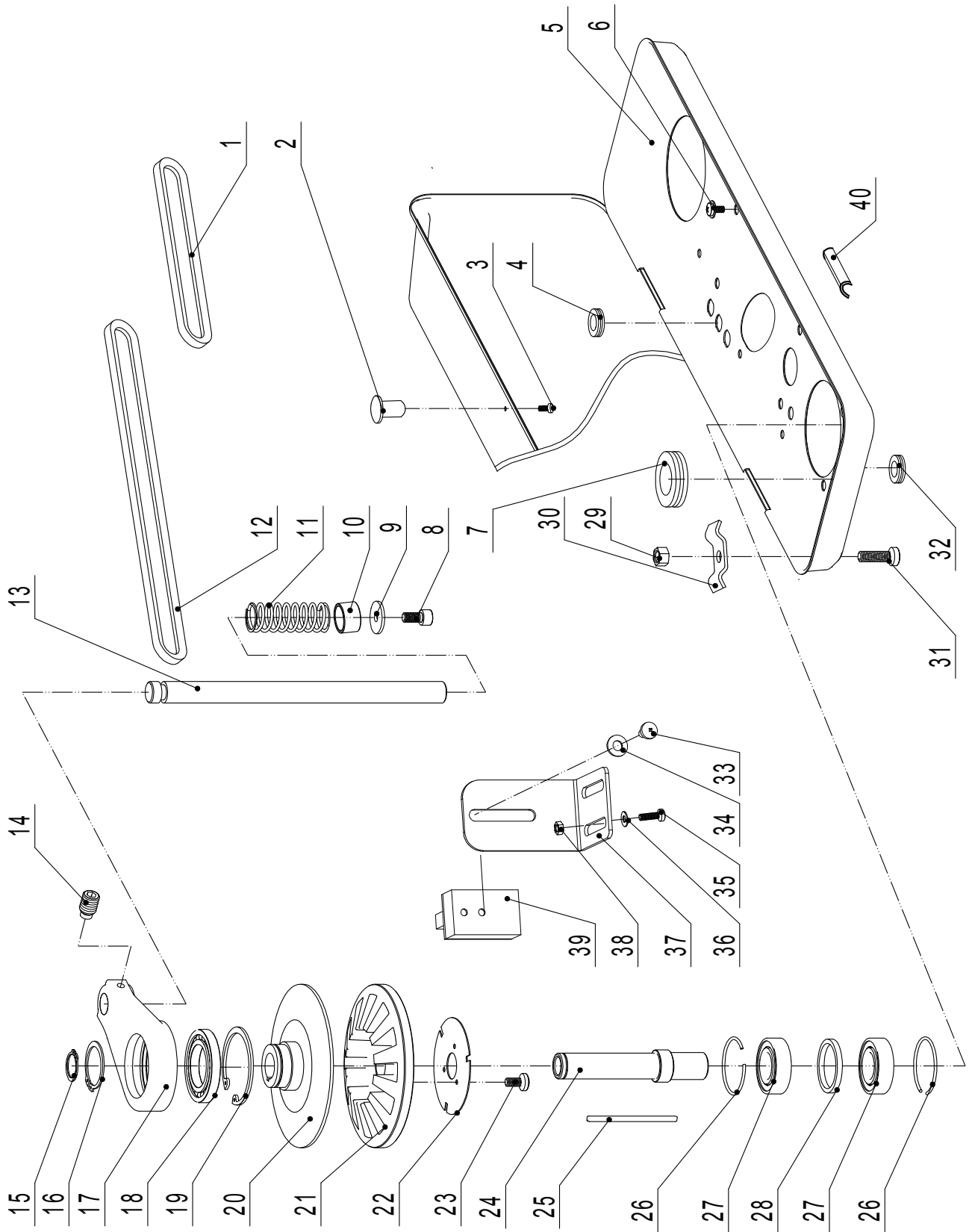
# PARTS LIST

KEY NO.	DESCRIPTION	PART NO.	QTY.	KEY NO.	DESCRIPTION	PART NO.	QTY.
1B	Roll pin	1-PIN8X25GB879B	2	37B	Speed control gear	1-JMDP1701021018	1
2B	Socket cap screw M10x12	1-M10X12GB80B	2	38B	Knob	1-RB1804011-001S	1
3B	Block	1-1502006	1	39B	Handle lever	1-0804005-03	1
4B	Circlip ring	1-CLP16GB894D1B	1	40B	Handle seat	1-JMDP0801021007-001U	1
5B	Tensioner	1-JMDP1701021034	1	41B	Cntsunk head screw M3x10	1-M3X10GB819B	2
6B	Locking knob	1-1502005	2	42B	LED Light	1-FLEX-T-1W	1
7B	Nut M8	1-M8GB6170B	4	43B	Three-core conductor	2-U13141000-717	1
8B	Flat washer	1-WSH8GB97D1B	8	44B	Cable plug	2-U23143500-717	1
9B	Junction plate	1-1502007-001Z	1	45B	Spring cover - nut	1-1504013	2
10B	Motor	2-YLG906114	1	46B	Spring cover	1-1904007	1
11B	Hex bolt M8x20	1-M8X20GB5781B	4	47B	Torsion spring	1-1904008	1
12B	Flat key (A)	1-PLN4X4X36GB1096	1	48B	Pan head screw M5x12	1-M5X12GB818B	2
13B	Hex socket set screw M6x8	1-M6X8GB77B	2	49B	Tapping screw	1-ST2D9X6D5GB845Z	2
14B	Belt pulley	1-JMDP1701020005	1	50B	Digital readout	1-CB07-3	1
15B	Hex nut M12	1-M12GB6170B	2	51B	Switch box	1-JMDP1701022003-001S	1
16B	Spring washer	1-WSH12GB93B	2	52B	Digital readout - cover	1-JMDP1701022001	1
17B	Rod	1-1702003	2	53B	Pan head self-drilling screw	1-ST4D2X19GB845B	4
18B	Washer	1-JMDP1701020008	1	54B	On/Off switch	1-HY56C	1
19B	Bearing block	1-JMDP1701020006	1	55B	Pan head screw M5x16	1-M5X16GB818B	4
20B	Bearing	1-BRG6005GB276	2	56B	Chuck key mount	1-1503026	1
21B	Bearing inner spacer	1-JMDP1701020007	1	57B	Pan head screw M5x10	1-M5X10GB818B	6
22B	Circlip ring	1-CLP47GB893D1B	1	58B	Depth stop plate	1-JMDP1701021002	1
23B	Shaft	1-JMDP1701020009	1	59B	Pan head screw M5x8	1-M5X8GB818B	2
24B	Flat key (A)	1-PLN4X90GB1096	2	60B	Washer	1-WSH5GB862D2B	2
25B	Hex cnsk head screw M8x16	1-M8X16GB70D3B	1	61B	Bottom cover plate	1-JMDP1701022008	1
26B	Hex socket set screw M8x12	1-M8X12GB77B	4	62B	Screw-set special	1-1502021	1
27B	Hex socket button screw M6x20	1-M6X20GB70D2B	4	63B	Stop nut	1-1504014	1
28B	Flat key (A)	1-PLN8X7X20GB1096	1	64B	Gear shaft	1-1904002	1
29B	Circlip ring	1-CLP16GB894D1B	1	65B	Roll pin	1-PIN5X16GB879B	1
30B	Fixed motor pulley	1-JMDP1701020002AA	1	66B	Knob	1-1504011-01001S	3
31B	Activity motor pulley	1-JMDP1701020002BA	1	67B	Handle lever	1-1504005-02	3
32B	Hex socket set screw M5x10	1-M5X10GB77B	2	68B	Handle seat	1-JMDP1701021007-001G	1
33B	Spring	1-JMDP1701021016	1	69B	Head casting	1-JMDP1701021001-117A	1
34B	Middle pulley	1-JMDP1701020004	1	70B	Shaft sleeve	1-JMDP1701021021	1
35B	Roll pin	1-PIN4X18GB879B	1	71B	Bushing	1-JMDP1701021031A	1
36B	Friction plate	1-JMDP1701021033	1	72B	Nut M8	1-M8GB6172D1B	2

**HEAD, MOTOR & CONTROLS - SHEET B**

# PULLEY & DRIVE ASSEMBLY SHEET C

**NOTE:** Please reference the Manufacturer's Part Number when calling for Replacement Parts. For Parts under Warranty, the Serial Number of your machine is required.





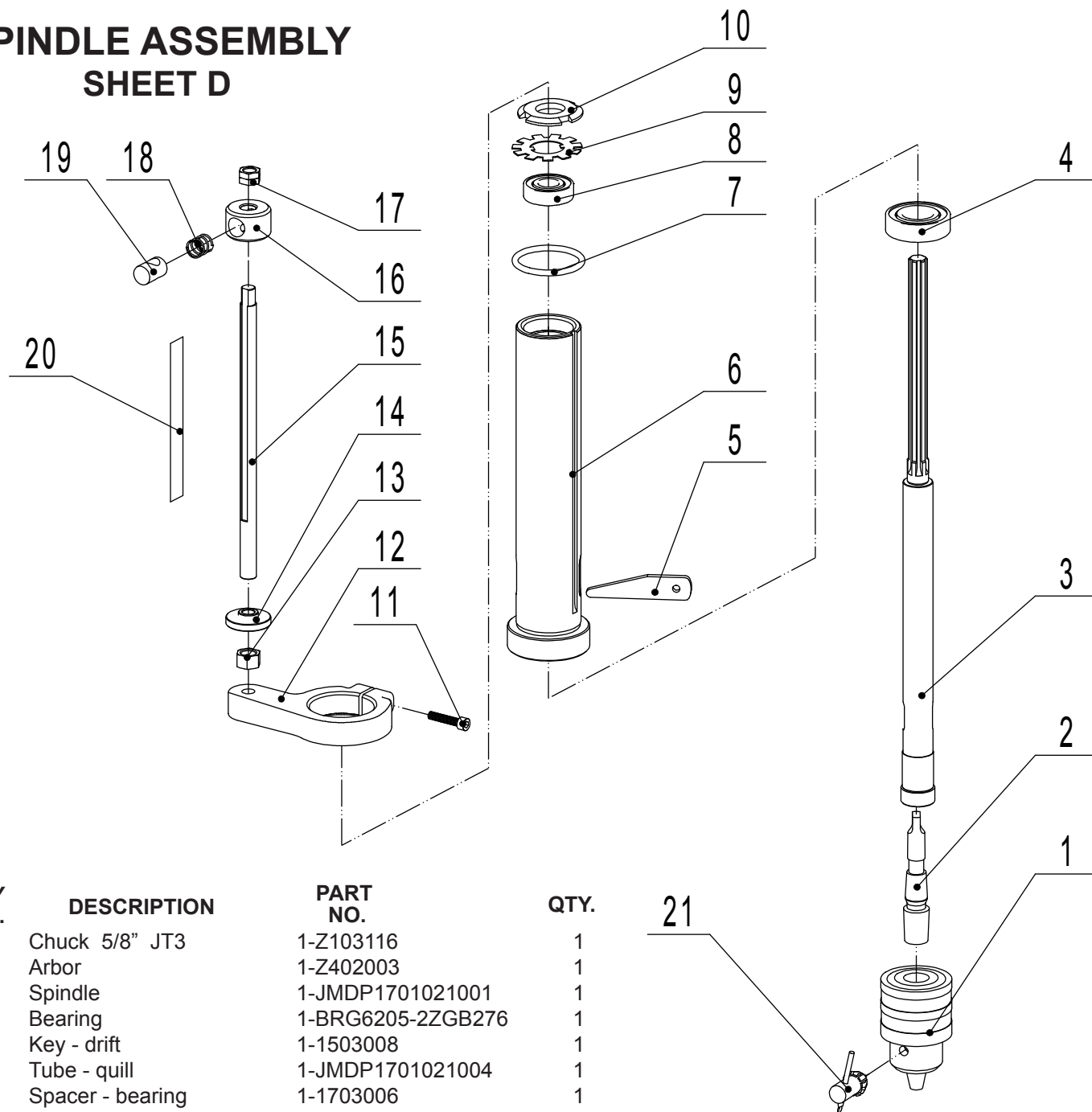
# PARTS LIST

## PULLEY & DRIVE ASSEMBLY SHEET C

KEY NO.	DESCRIPTION	PART NO.	QTY.
1C	Poly-V-Belt	1-JMDP1701022007	1
2C	Lid handle	1-1505008-00001S	1
3C	Cross recess pan head screw M5X12	1-M5X12GB818B	1
4C	Protecting bushing	1-G8812624L-032	1
5C	Guard	1-JMDP1701022010-076U	1
6C	Screw	1-M6X12GB9074D1Z	6
7C	Rubber bushing	1-1905010	1
8C	Hex socket cap screw M10X20	1-M10X20GB70B	1
9C	Washer	1-WSH10GB5287B	1
10C	Sleeve	1-JMDP1701021021	1
11C	Governing spring	1-JMDP1701021015	1
12C	V-belt	1-JMDP1701022006	1
13C	Speed rack	1-JMDP1701021019	1
14C	Hexagon socket set screws M8X12	1-M8X12GB79B	2
15C	Circlip ring	1-CLP24GB894D1B	1
16C	Circlip ring	1-CLP40GB894D1B	1
17C	Belt pulley - adjustment mount	1-JMDP1701021022-001G	1
18C	Bearing	1-BRG16008GB276-2RZ	1
19C	Circlip ring	1-CLP68GB893D1B	1
20C	Activity spindle pulley	1-JMDP1701020003B	1
21C	Fixed spindle pulley	1-JMDP1701020003A	1
22C	RPM Disc	1-JMDP1701021026	1
23C	Cross recess pan head screw M4X8	1-M4X8GB818B	3
24C	Pivot - idler	1-JMDP1701021014	1
25C	Flat key ( A)	1-PLN4X90GB1096	1
26C	Circlip ring	1-CLP50GB895D1B	2
27C	Bearing	1-BRG6205-2ZGB276	2
28C	Bearing - spacer ring	1-1702023	1
29C	Nut	1-M5GB6170B	3
30C	Cable - pressing plate	1-1502014	3
31C	Cross recess pan head screw M5X16	1-M5X16GB818B	3
32C	Protecting bushing	1-JL60010004	2
33C	Tapping screw	1-ST3D5X10GB845Z	2
34C	Flat washer	1-WSH4GB97D1Z	2
35C	Cross recess pan head screw M3X10	1-M3X10GB818Z	2
36C	Flat washer	1-WSH3GB97D1Z	2
37C	Mounting bracket	1-JMDP1701021025	1
38C	Self-locking nut	1-M3GB889Z	2
39C	Digital RPM reader	1-JMDP1701090001	1
40C	Rubber lid bumpers	1-JMDP1701022005	3

# PARTS DIAGRAM & PARTS LIST

## SPINDLE ASSEMBLY SHEET D

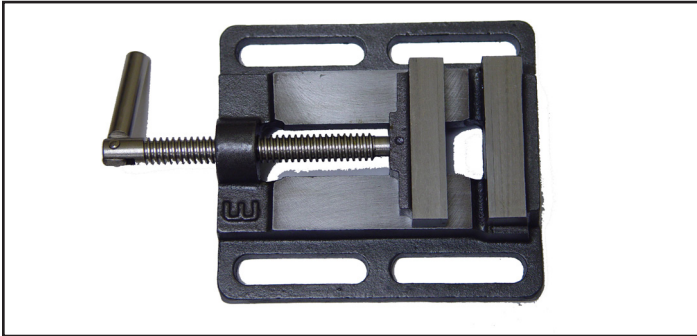


KEY NO.	DESCRIPTION	PART NO.	QTY.
1D	Chuck 5/8" JT3	1-Z103116	1
2D	Arbor	1-Z402003	1
3D	Spindle	1-JMDP1701021001	1
4D	Bearing	1-BRG6205-2ZGB276	1
5D	Key - drift	1-1503008	1
6D	Tube - quill	1-JMDP1701021004	1
7D	Spacer - bearing	1-1703006	1
8D	Bearing	1-BRG6203-2ZGB276	1
9D	Washer	1-1503004	1
10D	Lock nut	1-1503005	1
11D	Hex cap screw M6X30	1-M6X30GB70B	1
12D	Depth connecting base	1-JMDP1701021017-001G	1
13D	Hex nut	1-M12GB6170Z	1
14D	Depth motion block	1-JMDP1701021010	1
15D	Depth threaded rod	1-JMDP1701021011	1
16D	Depth threaded set	1-JMDP1701021013	1
17D	Nut	1-M10GB6172Z	2
18D	Depth adjust spring	1-JMDP1701021012	1
19D	Depth adjust button	1-JMDP1701021009	1
20D	Depth scale 6"	1-JMDP1701021028	1
21D	Chuck key	1-Z303116	1
22D	Wrench 24mm (not shown)	1-1501015-01001Y	1

**NOTE:** Please reference the Manufacturer's Part Number when calling for Replacement Parts.

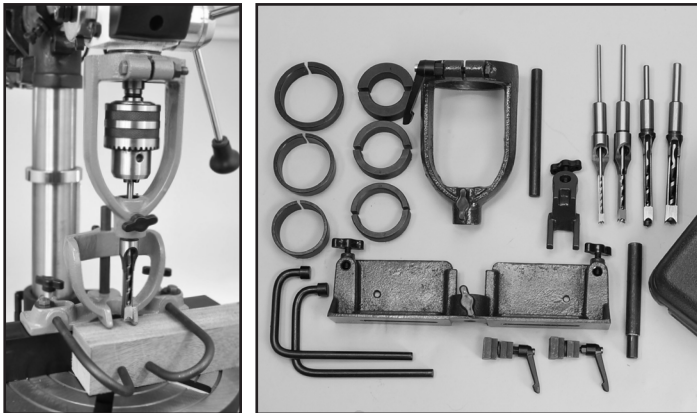
For Parts under Warranty, the Serial Number of your machine is required.

## ACCESSORIES



	Approximate Sizes	JAWS L x W	Jaws Open
<b>93-010</b>	<b>3" Vise</b>	3" x 13/16"	3-1/4"
<b>93-020</b>	<b>4" Vise</b>	4" x 15/16"	4-1/4"
<b>93-030</b>	<b>5" Vise</b>	5" x 7/8"	5"
<b>93-040</b>	<b>6" Vise</b>	6" x 1"	6"

All metal construction with side slots for mounting on drill press tables. Large toggle handles for fast adjusting of the jaws. Machined base and jaws to maintain table flatness and solid work support.



### 29-202 Mortising Attachment Kit

The Mortising Attachment converts your Drill Press in to an accurate mortising machine. It is ideal for drilling square holes for mortise & tenon joints that are commonly used in furniture, cabinets, sash, pattern shops and other woodworking plants.

The Mortising Attachment Kit can be installed on most any drill press with a collar size of: 40mm, 48mm, 50.8mm, 60mm, 66mm or 75mm. Kit includes yoke, collar adapters, fence, hold downs, 4 chisels & bits (1/4", 5/16", 3/8" 1/2") and plastic storage case.

## RIKON POWER TOOLS

### 5-Year Limited Warranty

RIKON Power Tools Inc. ("Seller") warrants to only the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship for a period of five (5) years from the date the product was purchased at retail. This warranty may not be transferred.

This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs, alterations, lack of maintenance or normal wear and tear. Under no circumstances will Seller be liable for incidental or consequential damages resulting from defective products. All other warranties, expressed or implied, whether of merchantability, fitness for purpose, or otherwise are expressly disclaimed by Seller. This warranty does not cover products used for commercial, industrial or educational purposes.

This limited warranty does not apply to accessory items such as blades, drill bits, sanding discs, grinding wheels, belts, ball bearings and other related items.

Seller shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, proof of purchase documentation must be provided which has the date of purchase and an explanation of the complaint.

The Seller reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever.

To take advantage of this warranty, please fill out the enclosed warranty card and send it to:  
RIKON Warranty, 16 Progress Road, Billerica, MA 01821

The card must be entirely completed in order for it to be valid. If you have questions, please contact us at  
877-884-5167 or [warranty@rikontools.com](mailto:warranty@rikontools.com)



For more information:  
16 Progress Road  
Billerica, MA 01821

877-884-5167 / 978-528-5380  
techsupport@rikontools.com

