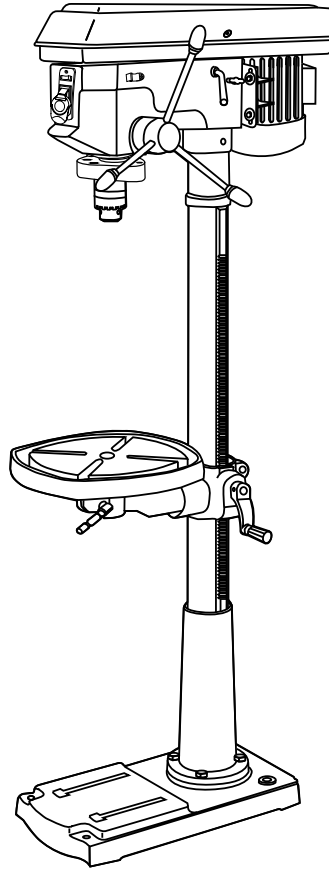


HITACHI

Model

B 16RM

Drill Press



INSTRUCTION MANUAL AND SAFETY INSTRUCTIONS

WARNING

Improper and unsafe use of this power tool can result in death or serious bodily injury!

This manual contains important information about product safety. Please read and understand this manual before operating the power tool. Please keep this manual available for others before they use the power tool.



N136

Hitachi Koki

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English

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 **WARNING**

Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals (known to the State of California) to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead 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 dust masks that are specially designed to filter out microscopic particles.

PRODUCT SPECIFICATIONS

Swing	15" (380mm)	Table Size	13-15/64" x 13-15/64"
Chuck Size.....	5/8" (16mm)		(336mm x 336mm)
No Load Speed.....	12 Speeds	Table Tilt	45° Right or Left
	210-2,580/min	Spindle Travel.....	3-11/32" (85mm)
Voltage	220-240V / 50Hz	Throat.....	7-1/2" (190.5mm)
Watts	750W	Base Size	11" x 20-3/8"
Amps	3.6A		(279.4mm x 518mm)
Built-in Light.....	60 Watt (Maximum)	Height.....	63-11/16" (1,617.5mm)
	(Bulb not included)	Net Weight... ..	165 lbs (75kg)

 **WARNING**

To avoid electrical hazards, fire hazards or damage to the drill press, use proper circuit protection. This drill press is wired at the factory for 220-240 Volt operation. It must be connected to a 220-240 Volt / 3.6 Ampere time delay fuse or circuit breaker. To avoid shock or fire, replace power cord immediately if it is worn, cut or damaged in any way.


Before using your drill press, it is critical that you read and understand these safety rules. Failure to follow these rules could result in serious injury to you or damage to the drill press.

POWER TOOL SAFETY

WARNING

Before using your drill press, it is critical that you read and understand these safety rules. Failure to follow these rules could result in serious injury or damage to the drill press.

Good safety practices are a combination of common sense, staying alert and understanding how to use your power tool. To avoid mistakes that could cause serious injury, do not plug in your power tool until you have read and understood the following safety rules:

1. **READ** and become familiar with this entire Operator's Manual. **LEARN** the tool's applications, limitations and possible hazards.
2.  **WARNING**
Look for this symbol that identifies important safety precautions. It means **BE ALERT! YOUR SAFETY IS INVOLVED!**
3. **NEVER OPERATE THIS MACHINE WITHOUT THE SAFETY GUARD IN PLACE FOR ALL OPERATIONS.**
4. **DO NOT USE IN A DANGEROUS ENVIRONMENT** such as damp or wet locations or in the rain. Keep work area well lighted.
5. **DO NOT** use power tools in the presence of flammable liquids or gases.
6. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
7. **KEEP CHILDREN AWAY.** All visitors should be kept at a safe distance from the work area.
8. **DO NOT FORCE THE TOOL.** It will do the job better and safer if used at the rate for which it was designed.
9. **USE THE RIGHT TOOL.** Don't force the tool or attachment to do a job for which it is not designed.
10. **WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, bracelets or other jewelry that may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
11. **WEAR A FACE MASK OR DUST MASK.** Sawing, cutting and sanding operations produce dust.
12. **DISCONNECT TOOLS** before servicing and when changing accessories, such as blades, cutters, etc.
13. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure the switch is in the OFF position before plugging tool into the power supply.
14. **USE ONLY RECOMMENDED ACCESSORIES.** Consult the Operator's Manual for recommended accessories. The use of improper accessories may cause injury to you or damage to the tool.
15. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning ON.
16. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN THE POWER OFF.** Do not leave the tool before the blade comes to a complete stop.
17. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
18. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
19. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for most efficient and safest performance. Follow instructions for lubricating and changing accessories.
20. **CHECK FOR DAMAGED OR LOOSE PARTS.** Check for alignment of moving parts, binding of moving parts, loose mounting and any other conditions that may affect its safe operation. A guard or other part that is loose or damaged should be properly adjusted, repaired or replaced.
21. **MAKE WORKSHOP CHILDPROOF** with padlocks, master switches or by removing starter keys.
22. **DO NOT** operate the tool if you are under the influence of any drugs, alcohol or medication that could impair your ability to use the tool safely.
23. **USE A DUST COLLECTION SYSTEM** whenever possible. Dust generated from certain materials can be hazardous to your health and, in some cases, a fire hazard. Always operate the power tool in a well-ventilated area with adequate dust removal.
24. **ALWAYS WEAR EYE PROTECTION.** Any power tool can throw debris into your eyes that could cause permanent eye damage. **ALWAYS** wear safety goggles (not glasses) that comply with ANSI safety standard Z87.1. Everyday glasses have only impact resistant lenses. They **ARE NOT** safety glasses.
NOTE: Glasses or goggles not in compliance with ANSI Z87.1 could cause serious injury when they break.
25. **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.

DRILL PRESS SAFETY

WARNING

For your own safety, do not try to use your drill press or plug it in until it is completely assembled and installed according to the instructions, and until you have read and understood this instruction manual:

1. **THIS DRILL PRESS** is intended for use in dry conditions, indoor use only.
2. **WEAR EYE PROTECTION.** USE A face or dust mask along with safety goggles if drilling operation is dusty. USE ear protectors, especially during extended periods of operation.
3. **DO NOT** wear gloves, neckties, or loose clothing.
4. **DO NOT** try to drill material too small to be securely held.
5. **ALWAYS** keep hands out of the path of a drill bit. Avoid awkward hand positions where a sudden slip could cause your hand to move into the drill bit.
6. **DO NOT** install or use any drill bit that exceeds 175 mm (7") in length or extends 150 mm (6") below the chuck jaws. They can suddenly bend outward or break.
7. **DO NOT USE** wire wheels, router bits, shaper cutters, circle (fly) cutters, or rotary planers on this drill press.
8. **WHEN** cutting a large piece of material, make sure it is fully supported at the table height.
9. **DO NOT** perform any operation freehand. **ALWAYS** hold the workpiece firmly against the table so it will not rock or twist. Use clamps or a vise for unstable workpieces.
10. **MAKE SURE** there are no nails or foreign objects in the part of the workpiece to be drilled.
11. **CLAMP THE WORKPIECE OR BRACE IT** against the left side of the column to prevent rotation. If it is too short or the table is tilted, clamp it solidly to the table and use the fence provided. power switch OFF immediately to prevent motor damage.
12. **IF THE WORKPIECE** overhangs the table such that it will fall or tip if not held, clamp it to the table or provide auxiliary support.
13. **SECURE THE WORK.** Use clamps or a vise to hold the work when practical. It's safer than using your hand and it frees both hands to operate tool.
14. **MAKE SURE** all clamps and locks are firmly tightened before drilling.
15. **SECURELY LOCK THE HEAD** and table support to the column, and the table to the table support before operating the drill press.
16. **NEVER** turn your drill press on before clearing the table of all objects (tools, scraps of wood, etc.)
17. **BEFORE STARTING** the operation, jog the motor switch to make sure the drill bit does not wobble or vibrate.
18. **LET THE SPINDLE REACH FULL SPEED** before starting to drill. If your drill press makes an unfamiliar noise or if it vibrates excessively, stop immediately, turn the drill press off and unplug. If do not restart until the problem is corrected.
19. **DO NOT** perform layout assembly or set up work on the table while the drill press is in operation.
20. **USE THE RECOMMENDED SPEED** for any drill press accessory and for different workpiece material. **READ THE INSTRUCTIONS** that come with the accessory.
21. **WHEN DRILLING** large diameter holes, clamp the workpiece firmly to the table. Otherwise, the bit may grab and spin the workpiece at high speeds. **DO NOT USE** fly cutters or multiple-part hole cutters, as they can come apart or become unbalanced in use.
22. **MAKE SURE** the spindle has come to a complete stop before touching the workpiece.
23. **TO AVOID INJURY** from accidental starting, always turn the switch "OFF" and unplug the drill press before installing or removing any accessory or attachment or making any adjustment.
24. **KEEP GUARDS IN PLACE** and in working order.
25. **USE ONLY THE SELF-EJECTING TYPE CHUCK KEY** as provided with the drill press.

ELECTRICAL REQUIREMENTS AND SAFETY

CONNECTING TO THE POWER SUPPLY

Check that the power supply and plug used is in accordance with your drill press. Have a look at the rating plate of the motor or the rating on the drill press. Any changes should always be carried out by a qualified electrician.

WARNING

This machine must be earthed.

If not properly earthed this machine can cause an electrical shock. Be sure that the power supply outlet is earthed. If there is any doubt, have it checked by a qualified electrician.

WARNING

Avoid contact with the terminals on the plug when installing (removing) the plug to (from) the power supply outlet. Contact will cause a severe electrical shock.

USING AN EXTENSION LEAD

The use of any extension lead will cause some loss of power. To keep this to a minimum and to prevent overheating and motor burn-out, ask advice from a qualified electrician to determine the minimum wire size of the extension lead.

The extension lead should be equipped with an earthed type plug that fits the power supply outlet at one end, and with an earthed type socket that fits the plug of this machine at the other end.

ACCESSORIES AND ATTACHMENTS

RECOMMENDED ACCESSORIES

WARNING

Visit your Hardware Department or see the Power and Hand Tools Catalog to purchase recommended accessories for this power tool.

WARNING

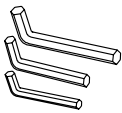
Use only accessories designed for this drill press to avoid injury from broken parts or thrown workpieces.

You may recommend other accessories not listed in this manual. See your nearest your store or Power and Hand Tool Catalog for all other accessories.

Do not use any accessory unless you have completely read the instruction or operator's manual for that accessory.

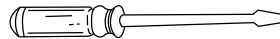
TOOLS NEEDED FOR ASSEMBLY

Supplied

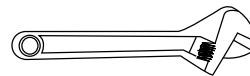


Hex Wrenches

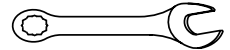
Not Supplied



Slotted Screwdriver



Adjustable Wrench



Wrench

CARTON CONTENTS

UNPACKING AND CHECKING CONTENTS

WARNING

If any part is missing or damaged, do not attempt to assemble the drill press, plug in the power cord, or turn the switch ON until the missing or damaged part is obtained and is installed correctly.

Carefully unpack the drill press and all its parts, and compare against the list below.

To protect the drill press from moisture, a protective coating has been applied to the machined surfaces. Remove this coating with a soft cloth moistened with kerosene or WD-40.

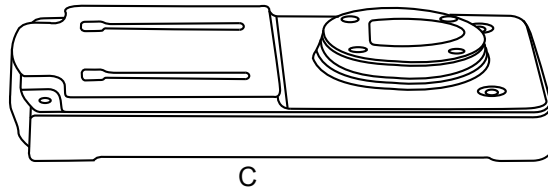
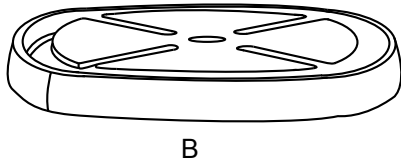
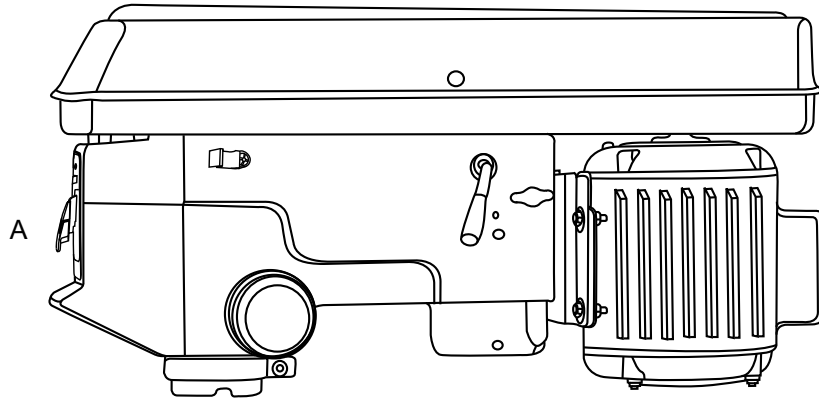
WARNING

To avoid fire or toxic reaction, never use gasoline, naphtha, acetone, lacquer thinner or similar highly volatile solvents to clean the drill press.

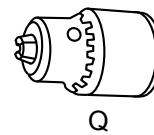
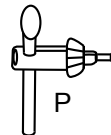
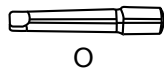
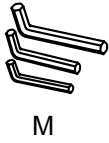
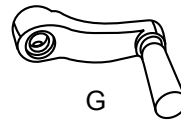
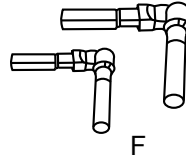
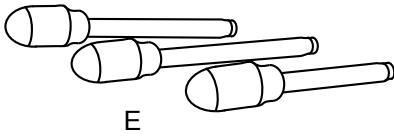
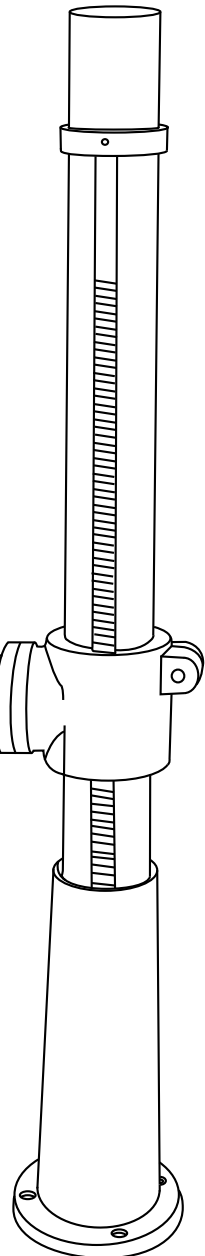
TABLE OF LOOSE PARTS

ITEM	DESCRIPTION	QUANTITY
A	Head assembly	1
B	Table	1
C	Base	1
D	Column assembly	1
	Loose parts bag :	
E	Feed handle	3
F	Lock handle	2
G	Crank Handle	1
H	Hex bolts	4
I	Batteries	2
M	Hex wrenches	3
N	Wedge	1
O	Arbor	1
	Box:	
P	Chuck key	1
Q	Chuck	1

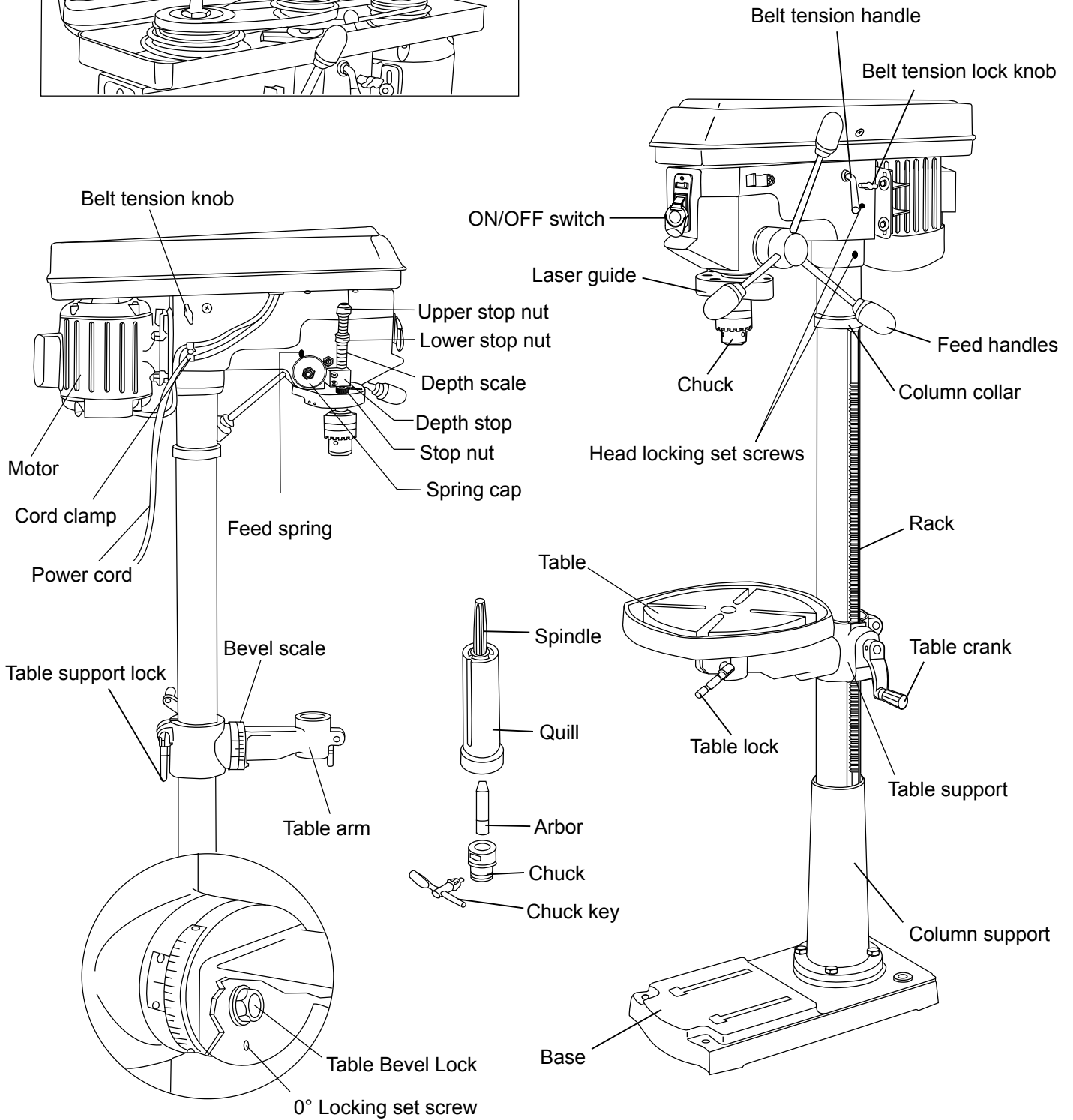
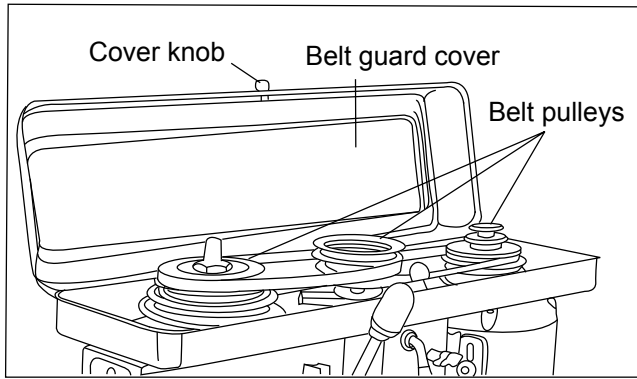
UNPACKING YOUR DRILL PRESS



D



KNOW YOUR DRILL PRESS



GLOSSARY OF TERMS

BASE – Supports drill press. For additional stability, holes are provided in base to bolt drill press to floor.

BACKUP MATERIAL – A piece of scrap wood placed between the workpiece and table. The backup board prevents wood in the workpiece from splintering when the drill passes through the backside of the workpiece. It also prevents drilling into the table top.

BELT GUARD ASSEMBLY – Covers the pulleys and belt during operation of the drill press.

BELT TENSION – Refer to the “Assembly” Section, “Installing and Tensioning Belt.”

BELT TENSION HANDLE – Push the handle toward the motor to apply tension to belt, turn the handle away from the motor to release the belt tension.

BELT TENSION LOCK KNOBS – Tightening the knobs locks the motor bracket support and the belt tension handle, maintaining correct belt distance and tension.

BEVEL SCALE – Shows degree of table tilt for bevel operations. The scale is mounted on the side of the table bracket.

CHUCK – Holds a drill bit or other recommended accessory to perform desired operations.

CHUCK KEY – A self-ejecting chuck key which will pop out of the chuck when you let go of it. This action is designed to help prevent throwing of the chuck key from the chuck when the power is turned ON. Do not use any other key as a substitute; order a new one if Damaged or lost.

COLUMN – Connects the head, table, and base on a one piece tube for easy alignment and movement.

COLUMN COLLAR – Holds the rack to the column. The rack remains movable in the collar to permit table support movements.

COLUMN SUPPORT – Supports the column, guides the rack and provides mounting holes for the column to the base.

DEPTH SCALE STOP NUTS – Lock the spindle to a selected depth.

DEPTH SCALE – Indicates depth of hole being drilled.

DRILL BIT – The cutting tool used in the drill press to make holes in a workpiece.

DRILL ON/OFF SWITCH – Has a locking feature. This feature is intended to help prevent unauthorized and possible hazardous use by children and others. Insert the key into the switch to turn the drill press on.

DRILLING SPEED – Changed by placing the belt in any of the steps (grooves) in the pulleys. See the Spindle Speed Chart inside belt guard or in the manual.

FEED HANDLE – Moves the chuck up or down. If necessary, one or two of the handles may be removed whenever the workpiece is of such unusual shape that it interferes with the handles.

RACK – Combines with gear mechanism to provide easy elevation of the table by the hand operated table crank.

SPRING CAP – Adjusts the quill return spring tension.

TABLE SUPPORT LOCK – Tightening locks the table support to the column. Always have it locked in place while operating the drill press.

TABLE – Provides a working surface to support the workpiece.

TABLE ARM – Extends beyond the table support for mounting and aligning the table.

TABLE BEVEL LOCK – Locks the table in any position from 0° to 45°.

TABLE CRANK – Elevates and lowers the table. Turn clockwise to elevate the table. Support lock must be released before operating the crank.

TABLE LOCK – Locks the table after it is rotated to various positions.

TABLE SUPPORT – Rides on the column to support the table arm and table.

THREADED DRAIN (5/8" (16mm)) – Attach a 5/8" (16mm) (pipe threaded) metal pipe to the threaded opening for draining excess oil into a quill container. For a non-draining surface, attach a threaded metal plug. Pipe and plug not included.

WORKPIECE – Material being drilled.

ASSEMBLY AND ADJUSTMENTS

ESTIMATED ASSEMBLY TIMES 20~40 MINUTES
ASSEMBLY INSTRUCTIONS

⚠ WARNING

For your own safety, never connect plug to power source outlet until all assembly and adjustment steps are completed, and you have read and understood the safety and operating instructions.

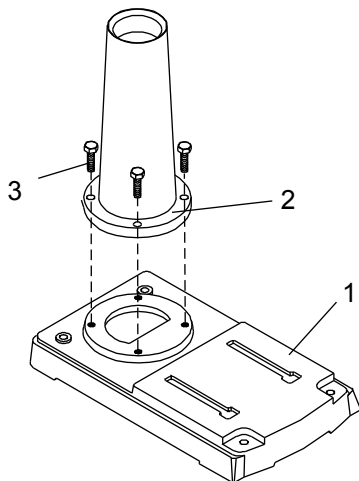
⚠ WARNING

The Drill Press is very heavy and **MUST** be assembled with the help of 2 PEOPLE OR MORE, to safely assembly it.

COLUMN SUPPORT TO BASE (FIG. A)

1. Position the base (1) on the floor.
2. Place the column (2) on the base, aligning the holes in the column support with the holes in the base.
3. Locate the four long hex bolts (3) from the loose parts bag.
4. Place a bolt in each hole through the column support and the base. Tighten with an adjustable wrench.

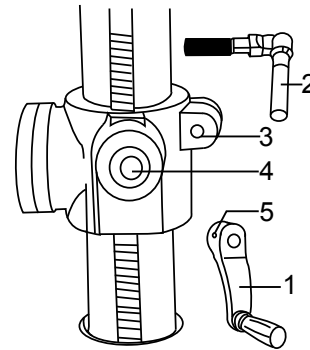
Fig. A



INSTALLING THE TABLE (FIG. B and C)

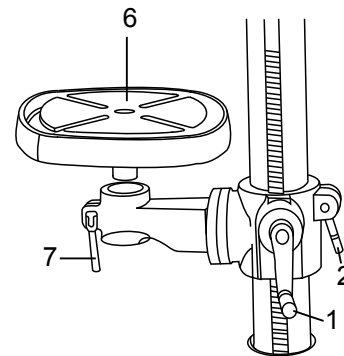
1. Locate the table crank handle (1) and support lock handle (2) from the loose parts bag.
2. Insert the support lock handle from the left to right into the hole (3) at the rear of the table support assembly. Tighten by hand.
3. Install the table crank handle (1) onto the small shaft (4), aligning the set screw (5) with the flat surface of the shaft (4). Tighten the set screw with a hex wrench.

Fig. B



4. Loosen the support lock (2). Raise the table arm assembly by turning the crank handle (1) clockwise. Tighten the support lock. (Fig. C)
5. Place the table (6) in the table arm assembly. Tighten the table lock handle (7). (Fig. C)

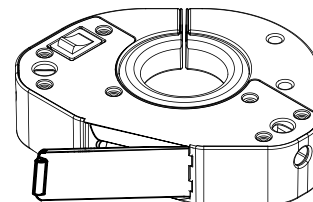
Fig. C



INSTALLING BATTERY FOR LASER GUIDE (FIG. C-1)

1. Open the cover of battery box.
2. Install 2 pieces of 1.5V 3A batteries into the battery box.
3. Close the cover.
4. Turn on the switch to check the LASER GUIDE.

Fig. C-1

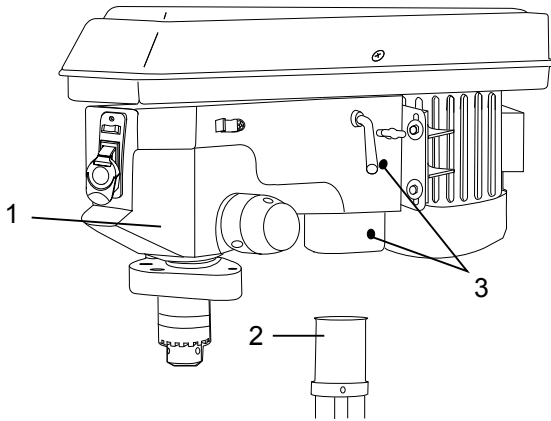


NOTE: Replace the batteries with batteries that have a rating of 1.5 volts (Number 4 series and AAA size or equivalent). When replacing the batteries, the battery guide should be thoroughly cleaned. Use a soft paintbrush or similar device, to remove all sawdust and debris.

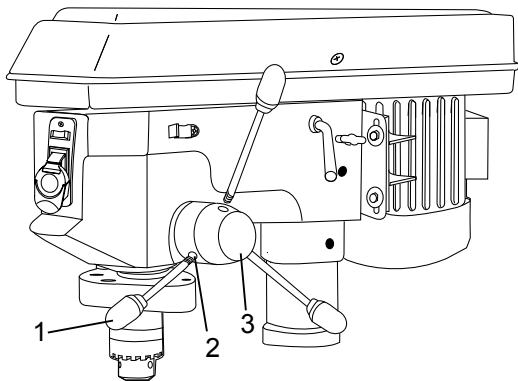
INSTALLING THE HEAD (FIG. D)**⚠ WARNING**

The Drill Press head is very heavy and **MUST** be lifted with the help of 2 PEOPLE OR MORE to safely assemble the Drill Press head on the column.

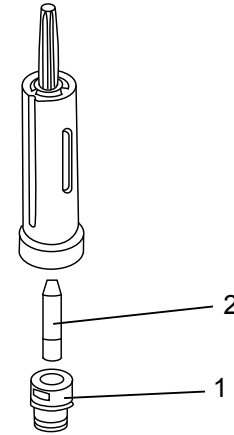
1. Carefully lift the head (1) above the column (2) and slide it onto the column. Make sure the head slides down over the column as far as possible. Align the head with the base.
2. Using the hex wrench, tighten the two head lock set screws (3) on the right side of the head.

Fig. D**INSTALLING FEED HANDLES (FIG. E)**

1. Locate the three feed handles in the loose parts bag.
2. Screw the feed handles (1) into the right of threaded holes (2) in the hub (3). Tighten.

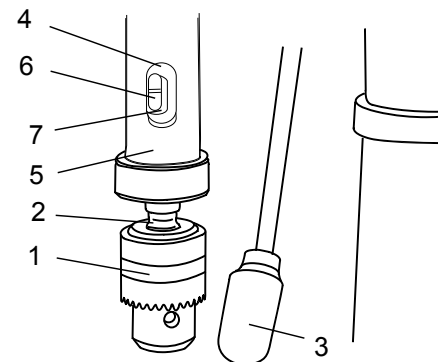
Fig. E**INSTALLING THE CHUCK (FIG. F, G and H)****⚠ WARNING**

Before any assembly of the chuck and arbor to the drill press head, clean all mating surfaces with a nonpetroleum based product; such as alcohol or lacquer thinner. Any oil or grease used in the packing of these parts must be removed otherwise the chuck may come loose during operation.

Fig. F

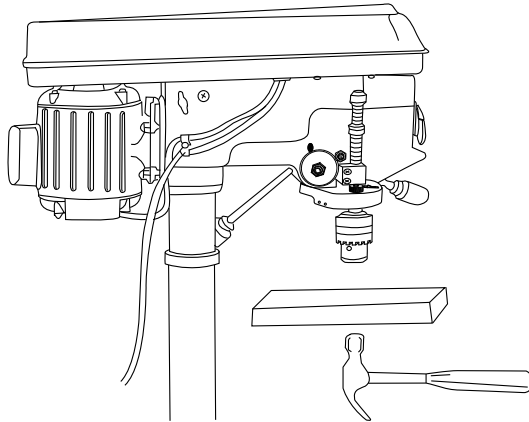
1. (Fig. G) Push the chuck (1) onto the spindle arbor (2). Tap gently on the arbor with a rubber hammer to ensure a proper seat.
2. Lower the spindle by turning the feed handles (3) counterclockwise, until the slot (4) appears on the quill (5).
3. Push the chuck and spindle arbor up into the spindle, making sure the tang (6) (upper narrow end of the spindle arbor shank) is engaged and locked in the inner slot (7) of the spindle. This can be seen through the outer slot (4) of the quill by rotating the chuck and arbor until the two slots are aligned.
4. Open the jaws of the chuck (1) by rotating the chuck sleeve clockwise. To prevent damage, make sure the jaws are completely retracted into the chuck.

NOTE: Clean the taper with a non-alcohol based cleaner before inserting it into the arbor.

Fig. G

- Using a rubber mallet, plastic-tipped hammer, or a block of wood and a hammer, firmly tap the chuck upward into position on the spindle shaft.

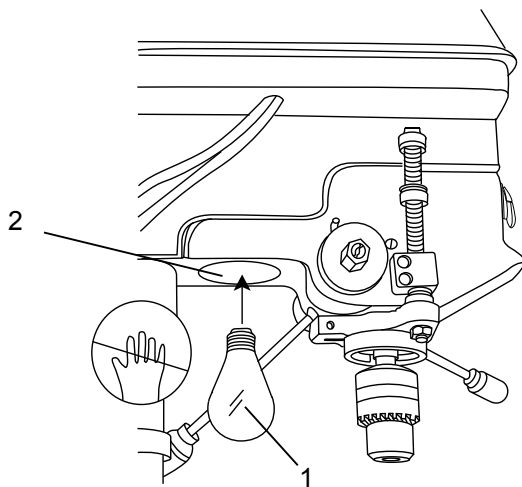
Fig. H



INSTALLING LIGHT BULB (FIG. I) (not included)

- Install a light bulb (1) (no larger than 60 watt) into the socket inside the head.

Fig. I



⚠ WARNING

- To prevent injury resulted from heat of the light bulb (1). Never touch the light bulb (1).
- To prevent electric shock. Never touch the bulb socket (2) when the plug from the power source is connected.

DRILL PRESS ADJUSTMENTS

CAUTION: All the adjustments for the operation of the drill press have been completed at the factory. Due to normal wear and use, some occasional readjustments may be necessary.

⚠ WARNING

To prevent personal injury, always disconnect the plug from the power source when making any adjustment.

BEVEL SCALE (FIG. K)

NOTE: The bevel scale has been included to measure approximate bevel angles. If precision is necessary, a square or other measuring tool should be used to position the table. To use the bevel scale (6):

- TIGHTEN the nut (4) on the locking pin in the clockwise direction to RELEASE the pin from the table support.
- Loosen the large hex head bevel locking bolt (5).

⚠ WARNING

To prevent injury, be sure to hold the table & table arm assembly, so it will not swivel or tilt.

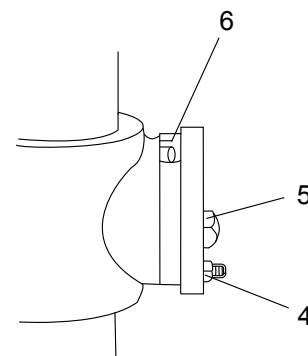
- Tilt the table, aligning the desired angle measurement to the zero line scribed on the table opposite the bevel scale (6).
- Tighten the bevel locking bolt (5).
- To return the table to its original position, loosen the bevel locking bolt (5). Realign the bevel scale (6) to the 0° scribed line on the table.
- Loosen by turning counterclockwise the nut (4) on the locking pin to the end of the threads. Tap the pin into its original position.
- Tighten the bevel locking bolt.

NOTE: The table has been removed from the illustration for clarity.

⚠ WARNING

To prevent personal injury, always disconnect the plug from the power source when making any adjustment.

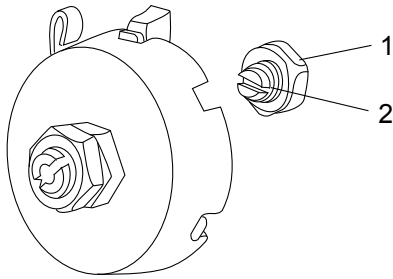
Fig. K



SPINDLE / QUILL (FIG. L)

Rotate the feed handles counterclockwise to lower spindle to its lowest position. Hand support the spindle securely and move it back and forth around the axis. If there is play, do the following:

1. Loosen the lock nut (1).
2. Turn the screw (2) clockwise to eliminate the play, but without obstructing the upward movement of the spindle.
3. Tighten the lock nut (1).

Fig. L**⚠ WARNING**

To prevent personal injury, always disconnect the plug from the power source when making any adjustment.

QUILL RETURN SPRING (FIG. M)

The quill return spring may need adjustment if the tension causes the quill to return too rapidly or too slowly.

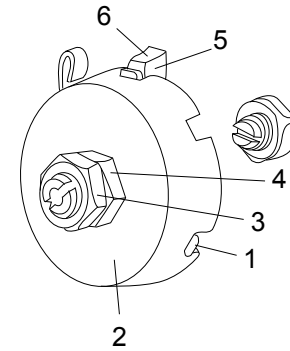
1. Lower the table for additional clearance.
2. Place a screwdriver in the lower front notch (1) of the spring cap (2). Hold it in place while loosening and removing only the outer jam nut (3).
3. With the screwdriver still engaged in the notch, loosen the inner nut (4) just until the notch (5) disengages from the boss (6) on the drill press head.

CAUTION: DO NOT REMOVE THIS INNER NUT, because the spring will forcibly unwind.

4. Carefully turn the spring cap (2) counterclockwise with the screwdriver, engaging the next notch.
5. Lower the quill to the lowest position by rotating the feed handle in a counterclockwise direction while holding the spring cap (2) in position.
6. If the quill moves up and down as easily as you desire, tighten the inner nut (4) with the adjustable wrench. If too loose, repeat steps 3 through 5 to tighten. If too tight, reverse steps 4 and 5.

DO NOT OVERTIGHTEN and restrict quill movement.

7. Replace the jam nut (3) and tighten against the inner nut (4) to prevent the inner nut from reversing.

Fig. M**⚠ WARNING**

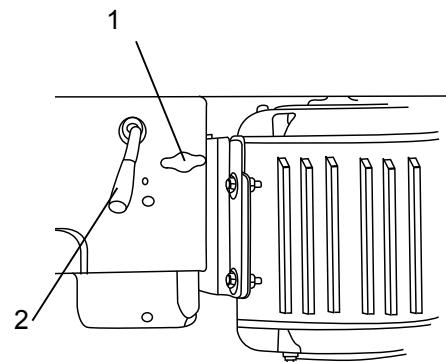
To avoid injury from an accidental start, ALWAYS make sure the switch is in the "OFF" position, the switch key is removed, and the plug is not connected to the power source outlet before making belt adjustments.

BELT TENSION (FIG. N)

Make sure pulleys are aligned properly as shown in Figure P.

1. To release the belt tension, turn the belt tension lock knobs (1) on each side of the drill press head counterclockwise.
2. To tighten the belts, push the belt tension handle (2) toward the rear (motor) end.
3. To loosen the belts, pull the belt tension handle (2) toward the front (switch) end.
4. Lock the two belt tension lock knobs (1) by turning clockwise.

NOTE: Belt tension is correct if the belt deflects approximately 1/2" (12.7mm) when pressed at its center.

Fig. N**⚠ WARNING**

To avoid injury from an accidental start, ALWAYS make sure the switch is in the "OFF" position, the switch key is removed, and the plug is not connected to the power source outlet before making belt adjustments.

THE LASER GUIDE

Your tool is equipped with our latest innovation, the Laser Guide, a battery powered device using Class II laser beams. The laser beams will enable you to preview the drill bit path on the workpiece to be drilled before you begin your operation.

WARNING

AVOID DIRECT EYE CONTACT

A Laser light is radiated when the laser guide is turned on. Avoid direct eye contact. Always turn off the laser and unplug the drill press from the power source before making any adjustments.

- A laser pointer is not a toy and should not come into hands of children. Misuse of this appliance can lead to irreparable eye injuries.
- Any adjustment to increase the laser power is forbidden.
- When using the laser pointer, do not point the laser beam towards people and /or reflecting surfaces. Even a laser beam of lower intensity may cause eye damage. Therefore, do not look directly into the laser beam.
- If the laser pointer is stored for more than three months without use, please remove the batteries to avoid damage from possibly leaking batteries.
- The laser pointer includes no servicing components. Never open the housing for repair or adjustments.
- On units equipped with the Laser-Guide attachment, repairs shall only be carried out by the laser manufacturer or an authorized agent.
- Laser Warning label: Max output <1mW DIODE LASER:630-670nm, Complies with 21CFR 1040.10 and 1040.11.

ADJUSTING THE LASER LINES (FIG. O)

A. How to check the Laser-beam Alignment?

1. Adjust the table height so it is 7 inches below the bottom of the chuck

2. Scribe a round circle (approx. 1/8 inch (3.175mm)) on a piece of scrap wood.
3. Insert a drill bit into the chuck and tighten.
4. Lower the quill and align the scribed circle with the drill bit and fasten the wood to the table.
5. Turn on the laser and verify the laser lines (x) are centered onto the scribed circle.

B. ALIGNING THE LASER-BEAM (FIG. O)

To adjust the laser lines:

NOTE: Lower the chuck quill and lock it in place by spinning the lower depth stop nut.

1. Lower the drill press quill One inch and lock into place by spinning the depth stop (see Fig. V).
2. Turn the screw (1) until the laser beam is at it's desired setting. (both screws)
3. If the laser guide is not centered on the scribe then contact your Authorized Service Center for bolt (2) adjustments.

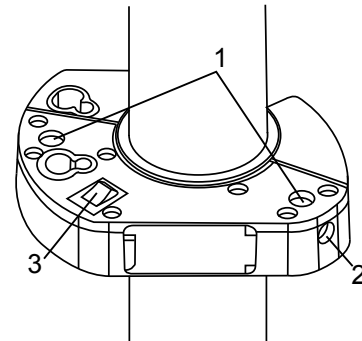
WARNING

Laser is radiated when laser guide is turned on. Avoid direct eye exposure. Always un-plug drill pres from power source before making any adjustment.

LASER ON/OFF SWITCH (FIG. O)

To turn the laser On or Off, press the rocker switch (3).

Fig. O



OPERATIONS

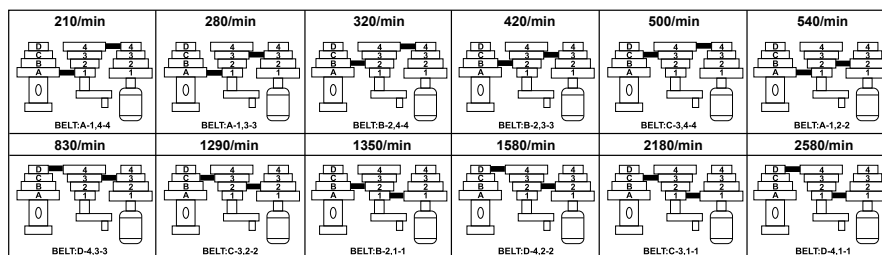
BASIC DRILL PRESS OPERATIONS

SPEEDS AND BELT PLACEMENT (FIG. P)

This drill press has 12 speeds, as listed below:

210/min	500/min	1350/min
280/min	540/min	1580/min
320/min	830/min	2180/min
420/min	1290/min	2580/min

See the inside of the pulley guard for same chart as shown in figure P.



WARNING

To avoid possible injury, keep the guard closed, in place, and in proper working order while the tool is in operation.

Fig. P SPEED CHART

THE NO VOLT RELEASE (NVR) SWITCH FOR THE DRILL PRESS (FIG. Q, Q-1, Q-2)-ONLY FOR SINGAPORE, MALAYSIA, INDONESIA

Your drill press is equipped with a No Volt Release (NVR) switch with emergency stop cover. This device can provide to stop the drill press immediately in urgent condition.

The main switch , No Volt Release (NVR) switch (1-Fig. Q), is on the front of drill head. Press "I" to turn on the power; press "O" to turn off the power. When the power breaks off accidentally, press "I" to restart. The emergency stop cover (2 - Fig. Q-1) will allow you to stop the operation of this drill press in urgent condition by hitting it by hand.

Fig. Q

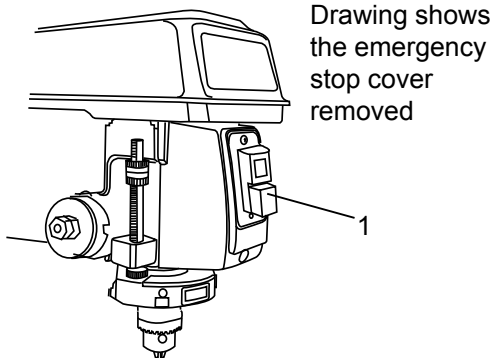
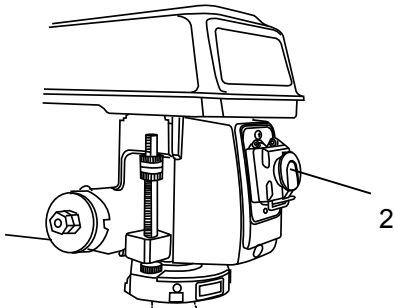


Fig. Q-1

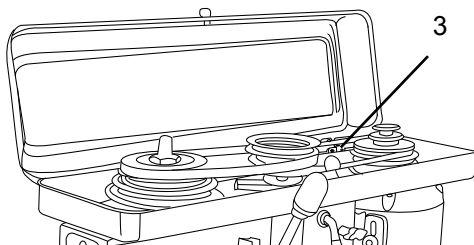


An interlock (micro) switch (3-Fig. Q-2), which will cut off the power when the lockable pulley cover is opened, is equipped with the drill press for double protection from the possible injury caused by the moving parts inside the pulley cover.

⚠ WARNING

To avoid possible injury, always keep the pulley cover closed and locked with the screw provided.

Fig. Q-2

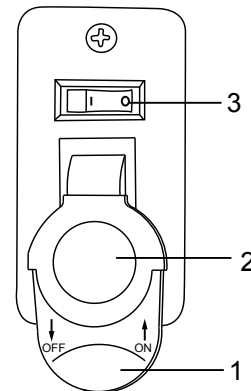


ON / OFF SWITCH PANEL (FIG. Q-3)-ONLY FOR AUSTRALIA AND NEW ZEALAND

The "ON / OFF" switch has a removable, safety key. With the key removed from the switch, unauthorized and hazardous use by children and others is minimized.

1. To turn the drill press "ON", insert the key (2) into the slot of the switch (1), and move the switch upward to the "ON" position.
2. To turn the drill press "OFF", move the switch downward.
3. To lock the switch in the "OFF" position, grasp the safety key of the toggle switch and pull it out.
4. With the switch key removed, the switch will not operate to power the drill press on.
5. If the switch key is removed while the drill press is running, it can be turned "OFF" but cannot be restarted without inserting the switch key.
6. To turn the worklight "ON", press the rocker switch (3) to the on position.
7. Never leave the drill press unattended. Turn the light switch and power switch "OFF" and wait until it comes to a complete stop, and remove the safety key to prevent unauthorized starts.

Fig. Q-3



⚠ WARNING

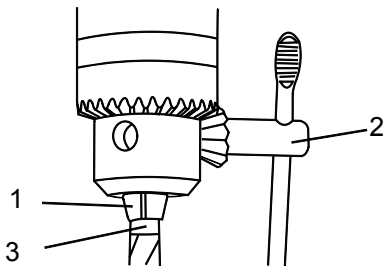
ALWAYS lock the switch "OFF" when the drill press is not in use. Remove the key and keep it in a safe place. In the event of a power failure, blown fuse, or tripped circuit breaker, turn the switch "OFF" and remove the key, preventing an accidental startup when power comes on.

INSTALLING A DRILL BIT IN THE CHUCK (FIG. R)

1. With the switch "OFF" and the safety key removed, open the chuck jaws (1) using the chuck key (2). Turn the chuck key counterclockwise to open the chuck jaws (1).
2. Insert the drill bit (3) into the chuck far enough to obtain maximum gripping by the jaws, but not far enough to touch the spiral grooves (flutes) of the drill bit when the jaws are tightened.
3. Make sure that the drill is centered in the chuck.
4. Turn the chuck key clockwise to tighten the jaws.

 **WARNING**

To avoid injury or accident by the chuck key ejecting forcibly from the chuck when the power is turned "ON", use only the self-ejecting chuck key supplied with this drill press. ALWAYS recheck and remove the chuck key before turning the power "ON".

Fig. R

To prevent the workpiece or backup material from being torn from your hands while drilling, you MUST position the workpiece against the LEFT side of the column. If the workpiece or the backup material is not long enough to reach the column, clamp them to the table. Failure to secure the workpiece could result in personal injury.

DRILLING TO A SPECIFIC DEPTH (FIG. S)

Drilling a blind hole (not all the way through workpiece) to a given depth can be done two ways:

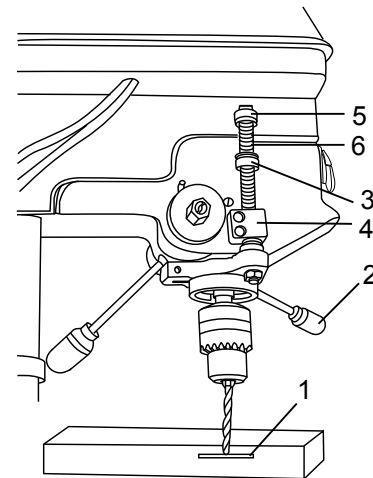
Workpiece method

1. Mark the depth (1) of the hole on the side of the workpiece.
2. With the switch "OFF", bring the drill bit down until the tip is even with the mark.
3. Hold the feed handle (2) at this position.
4. Spin the lower nut (3) down to contact the depth stop (4) on the head.
5. Spin the upper nut (5) down and tighten against the lower nut (3).
6. The drill bit will now stop after traveling the distance marked on the workpiece.

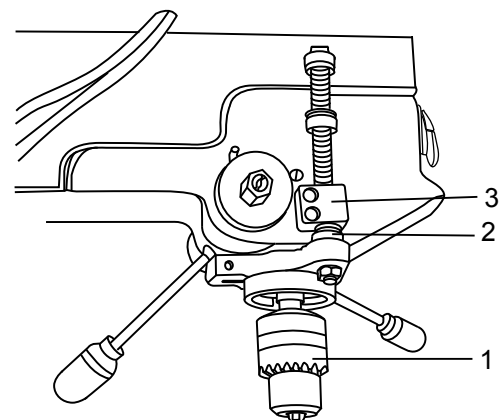
Depth scale method

Note: With the chuck quill assembly fully retracted the tip of the drill bit must be just slightly above the top of the workpiece.

1. With the switch "OFF", turn the feed handle (2) until depth stop (4) points to the desired depth on the depth scale (6) and hold the feed handle in that position.
2. Spin the lower nut (3) down to contact the depth stop (4).
3. Spin the upper nut (5) against the lower stop nut (3) and tighten.
4. The drill bit will stop after traveling the distance selected on the depth scale.

Fig. S**LOCKING THE CHUCK AT THE DESIRED DEPTH (FIG. T)**

1. With the switch "OFF", turn the feed handles until the chuck (1) is at the desired depth. Hold the feed handles at this position.
2. Turn the stop nut (2), located under the depth stop (3), counterclockwise and upwards, until it is against the depth stop.
3. The chuck will now be held at this position when the feed handles are released.

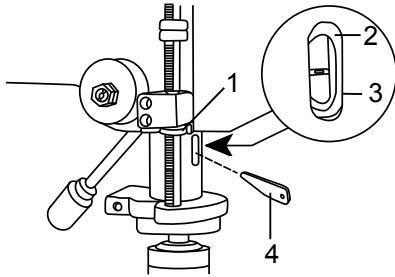
Fig. T

REMOVING CHUCK AND ARBOR (FIG. U)

1. With the switch "OFF" and the unit unplugged, adjust the depth stop nut (1) to hold the drill at a depth of three inches. (See instructions for "LOCKING CHUCK AT DESIRED DEPTH").
2. Align the key holes in the spindle (2) and quill (3) by rotating the chuck by hand.
3. Insert the key wedge (4) into the key holes (2 & 3).
4. Tap the key wedge (4) lightly with a plastic tipped hammer, until the chuck and arbor fall out of the spindle.

NOTE: Place one hand below the chuck to catch it when it falls out.

Fig. U

**BASIC OPERATION INSTRUCTIONS**

To get the best results and minimize the likelihood of personal injury, follow these instructions for operating your drill press.

 **WARNING**

For your own safety, always observe the SAFETY INSTRUCTIONS listed here and on pages 4, 5 & 6 of the instruction manual.

YOUR PROTECTION

 **WARNING**

To avoid being pulled into the power tool, do not wear loose clothing, gloves, neckties, or jewelry. Always tie back long hair.

1. If any part of your drill press is missing, malfunctioning, damaged or broken, stop operation immediately until that part is properly repaired or replaced.
2. Never place your fingers in a position where they could contact the drill bit or other cutting tool. The workpiece may unexpectedly shift, or your hand could slip.
3. To avoid injury from parts thrown by the spring, follow instructions exactly when adjusting the spring tension of the quill.
4. To prevent the workpiece from being torn from your hands, thrown, spun by the tool, or shattered, always properly support your workpiece as follows:
 - a. Always position BACKUP MATERIAL (used

- a. beneath workpiece) so that it contacts the left side of the column.
- b. When using a drill press vise, always fasten it to the table.
- c. Never do any work freehand (hand-holding the workpiece rather than supporting it on the table), except when polishing.
- d. Securely lock the head and support to the column, the table arm to the support, and the table to the table arm, before operating the drill press.
- e. Never move the head or the table while the tool is running.
- f. Before starting an operation, jog the motor switch to make sure the drill or other cutting tool does not wobble or cause vibration.
- g. If a workpiece overhangs the table so it will fall or tip if not held, clamp it to the table or provide auxiliary support.
- h. Use fixtures for unusual operations to adequately hold, guide, and position workpieces.
- i. Use the SPINDLE SPEED recommended for the specific operation and workpiece material. Check the panel on the inside pulley cover or the chart below for drilling speed information. For accessories, refer to the instructions provided with each accessory.

5. Never climb on the drill press table, it could break or pull the entire drill press down on you.
6. Turn the motor switch "OFF", and put away the switch key when leaving the drill press.
7. To avoid injury from thrown work or tool contact, do not perform layout, assembly, or set up work on the table while the cutting tool is rotating.

DRILLING SPEED CHART
FOR USE WITH HIGH SPEED TWIST DRILLS

Drill Dim. mm	Material				
	Wood	Aluminum	Plastic	Mild Steel	Stainless
0.8	2580	2580	2580	2580	2580
1.6					1580-2580
3				1580-2580	830-1580
5				830-1580	500-540
6		1580-2580	1580-2580		
8				500-540	320-500
10		830-1580	830-1580		
11	1580-2580			320-500	210
13		500-540	500-540		
14					
16					

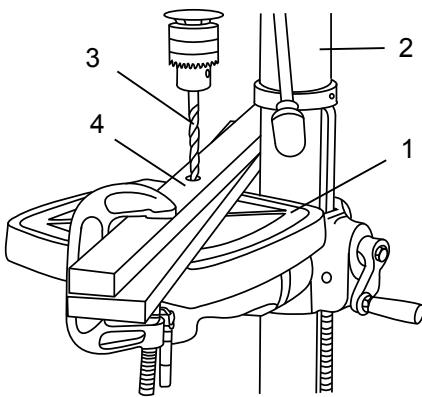
POSITIONING THE TABLE AND WORKPIECE (FIG. V AND Y)

1. Lock the table (1) to the column (2) at a position so the tip of the drill bit (3) is just above the top of the workpiece (4).
2. ALWAYS place BACK-UP MATERIAL (scrap wood) on the table beneath the workpiece. This will prevent splintering or heavy burring on the underside of the workpiece. To keep the back-up material from spinning out of control, it MUST contact the LEFT side of the column.

WARNING

To prevent the workpiece or backup material from being torn from your hands while drilling, you MUST position it against the LEFT side of the column. If the workpiece or the backup material is not long enough to reach the column. Failure to do this could result in personal injury.

Fig. V

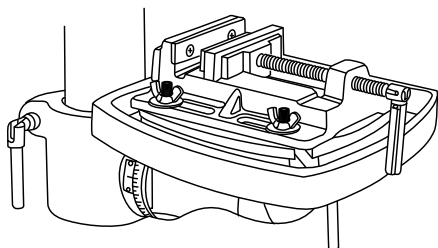


3. For small pieces that cannot be clamped to the table, use a drill press vise (optional accessory).

WARNING

The drill press vise MUST be clamped or bolted to the table to avoid injury from a spinning workpiece, or damaged vise or bit parts.

Fig. Y



TILTING THE TABLE (FIG. Z)

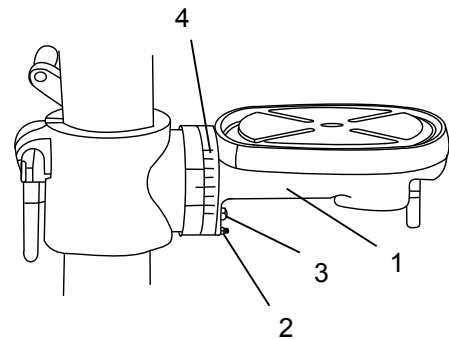
NOTE: The table arm and support (1) has a predrilled hole with a locking set screw inserted for locking the table into a predetermined 0° horizontal position.

1. TIGHTEN the nut (2) on the locking pin in the clockwise direction to RELEASE the pin from the table support.
2. LOOSEN the large hex head bevel locking bolt (3).

WARNING

To prevent injury, be sure to hold the table & table arm assembly, so it will not swivel or tilt.

Fig. Z



1. Tilt the table, aligning the desired angle measurement to the zero line opposite the scale (4). Tighten the bevel locking bolt.
2. To return the table to its original position, loosen the bevel locking bolt (3). Realign the bevel scale (4) to the 0° position.
3. Loosen the nut (2) on the locking pin to the end of the pin. Gently tap the locking pin until it is seated in the mating hole on the table bracket. Tighten the bevel locking nut against the bracket to hold position.

WARNING

To avoid injury from spinning work or tool breakage, always clamp workpiece and backup material securely to the table before operating the drill press with the table tilted.

FEEDING

1. Pull down the feed handles with only enough effort to allow the drill bit to cut.
2. Feeding too slowly might cause the drill bit to burn. Feeding too rapidly might stop the motor, cause the belt or drill to slip, or tear the workpiece loose and break the drill bit.
3. When drilling metal, it may be necessary to lubricate the drill bit tip with motor oil, to prevent burning.

MAINTENANCE

MAINTAINING YOUR DRILL PRESS

 **WARNING**

For your own safety, turn the switch “OFF” and remove the plug from the power source outlet before maintaining or lubricating your drill press.

Frequently blow out, using an air compressor or dust vacuum, any dust that accumulates inside the motor. A coat of automotive paste wax applied to the table and column will help to keep the surface clean & help to avoid rust.

To avoid shock or fire hazard, if the power cord is worn or cut in any way, have it replaced immediately.

LUBRICATION

All of the drill press ball bearings are packed with grease at the factory. They require no further lubrication. Periodically lubricate the gear and rack for table elevation, and the mechanism of the spindle the rack (teeth) of the quill.

TROUBLESHOOTING GUIDE

TROUBLESHOOTING GUIDE

WARNING

To avoid injury from an accidental start, turn the switch “OFF” and always remove the plug from the power source before making any adjustment.

- Consult Hitachi Authorized Service Center if for any reason the motor will not run.

SYMPTOM	POSSIBLE CAUSES	CORRECTIVE ACTION
Noisy operation	<ol style="list-style-type: none"> 1. Incorrect belt tension. 2. Loose spindle pulley. 3. Loose motor pulley. 	<ol style="list-style-type: none"> 1. Adjust tension. See Section “ASSEMBLY - TENSIONING BELT” 2. Check tightness of retaining nut on pulley, and tighten if necessary. 3. Tighten set screw in motor pulley.
Drill bit burns	<ol style="list-style-type: none"> 1. Incorrect speed. 2. Chips not coming out of hole. 3. Dull drill bit. 	<ol style="list-style-type: none"> 1. Change speed. See Section “BASIC DRILL PRESS OPERATION -SPINDLE SPEEDS” 2. Retract drill frequently to clear chips. 3. Resharpener drill bit.
Run out of drill bit point - drilled hole not round.	<ol style="list-style-type: none"> 1. Hand grain in wood or lengths of cutting flutes and/or angles not equal. 2. Bent drill bit. 	<ol style="list-style-type: none"> 1. Resharpener drill bit correctly. 2. Replace drill bit.
Wood splinters on underside.	<ol style="list-style-type: none"> 1. No backup material under workpiece. 	<ol style="list-style-type: none"> 1. Use backup material. See Section BASIC DRILL PRESS OPERATION”.
Workpiece torn loose from hand.	<ol style="list-style-type: none"> 1. Not supported or clamped properly. 	<ol style="list-style-type: none"> 1. Support workpiece or clamp it. See Section “BASIC DRILL PRESS OPERATION”.
Drill bit binds in workpiece.	<ol style="list-style-type: none"> 1. Workpiece pinching drill bit, or excessive feed pressure. 2. Improper belt tension. 	<ol style="list-style-type: none"> 1. Support workpiece or clamp it. See Section “BASIC DRILL PRESS] OPERATION”. 2. Adjust tension. See Section ASSEMBLY TENSIONING BELT”.
Excessive drill bit runout or wobble.	<ol style="list-style-type: none"> 1. Bent drill bit. 2. Worn 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 properly. See Section INSTALLING DRILL BIT”. 4. Install chuck properly. See Section “ASSEMBLY - INSTALLING THE CHUCK”.
Quill returns too slow or too fast.	<ol style="list-style-type: none"> 1. Spring has improper tension. 	<ol style="list-style-type: none"> 1. Adjust spring tension. See Section “ASSEMBLY - ADJUSTMENTS -QUILLRETURN SPRING”.
Chuck will not stay attached to spindle. It falls off when trying to install.	<ol style="list-style-type: none"> 1. Dirt, grease, or oil on the tapered insidesurface of chuck or on the spindle’ stapered surface. 	<ol style="list-style-type: none"> 1. Using a household detergent, clean the tapered surface of the chuck and spindle to remove all dirt, grease and oil. SeeSection “ASSEMBLY - INSTALLING THE CHUCK”.
The LASER GUIDE will not turn on.	<ol style="list-style-type: none"> 1. The batteries are broken. 	<ol style="list-style-type: none"> 1. See INSTALLING BATTERY FOR SER GUIDE section.

PARTS LIST-FOR AUSTRALIA AND NEW ZEALAND

15 in. (380mm) DRILL PRESS PARTS LIST PARTS LIST FOR SCHEMATIC

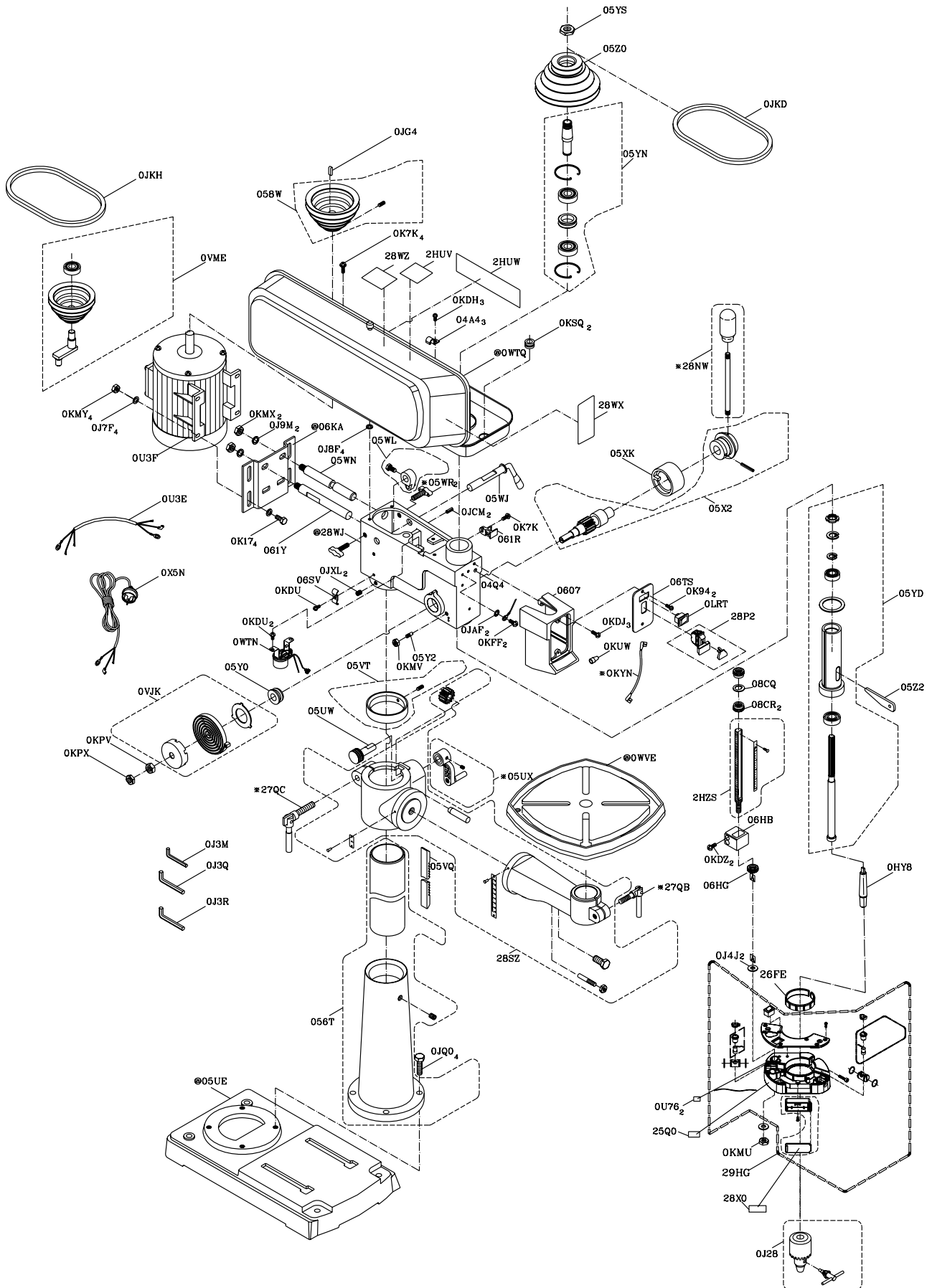
MODEL NO. B16RM

Always order by I.D. Number

Parts No.	I.D.	Description	Size	QTY	Parts No.	I.D.	Description	Size	QTY
726323	0607	SWITCH BOX		1	726521	OJKH	V-BELT		1
726359	04A4	CLAMP-CORD		3	726528	OJQ0	HEX. HD. BOLT	M10*1.5-40	4
726360	04Q4	STICKER		1	726535	OJXL	HEX. SOC. SET SCREW	M10*1.5-12	2
726361	056T	COLUMN ASS'Y		1	726535	OK17	HEX. HD. SCREW AND WASHER	M8*1.25-20	4
726362	058W	MOTOR PULLEY ASS'Y		1	726557	OK7K	CR. RE. ROUND WASHER HD. SCREW	M6*1.0-12	5
726363	05UE	BASE		1	726564	OK94	CR. RE. TRUSS HD. TAPPING SCREW	M5*12-16	2
326389	05UW	WORM		1	726579	OKDH	CR. RE. PAN HD. SCREW	M5*0.8-8	3
726364	05UX	CRANK HANDLE ASS'Y		1	726580	OKDJ	CR. RE. PAN HD. SCREW	M5*0.8-12	3
726366	05VQ	RACK		1	726582	OKDU	CR. RE. PAN HD. SCREW	M6*1.0-12	3
726367	05VT	RACK RING ASS'Y		1	726583	OKDZ	CR. RE. PAN HD. SCREW	M6*1.0-35	2
726368	05WJ	HANDLE SHIFTER		1	726586	OKFF	CR. RE. PAN HD. SCREW	M5*0.8-8	2
726369	05WL	MOTOR BAR SHIFTER ASS'Y		1	726599	OKMU	HEX. NUT	M10*1.5 T=8	1
726370	05WN	MOTOR ROD		1	726600	OKMV	HEX. NUT	M10*1.5 T=8	1
726371	05WR	SHIFTER BOLT	M10*1.5-33	2	726602	OKMX	HEX. NUT	M12*1.75 T=10	2
726373	05X2	FEED SHAFT ASS'Y		1	726603	OKMY	HEX. NUT	M8*1.25 T=6.5	4
726374	05XK	SCALE RING		1	726608	OKPV	HEX. NUT	1/2*20UNF T=10	1
726375	05Y0	SHAFT SEAT		1	726609	OKPX	HEX. NUT	1/2*20UNF T=6.5	1
726377	05Y2	QUILL SET SCREW	M10*1.5-2	1	726624	OKSQ	STRAIN RELIEF	φ20	2
726378	05YD	SPINDLE ASS'Y		1	726627	OKUW	TERMINAL		1
726379	05YN	DRIVING SLEEVE ASS'Y		1	726629	OKYN	LEAD WIRE ASS'Y		1
726380	05YS	PULLEY SET NUT	φ22.5	1	726634	OLRT	ROCKER SWITCH		1
726381	05Z0	SPINDLE PULLEY		1	326395	OU3E	MOTOR WIRE		1
726382	05Z2	WEDGE SHIFTER		1	326396	OU3F	MOTOR		1
726383	061R	CHUCK KEY HOLDER		1	326653	OU76	LASER STICKER		2
726384	061Y	MOTOR ROD		1	726645	OVJK	PLATE SPRING ASS'Y		1
726385	06HB	PLUNGER HOUSING		1	726646	OVME	CENTER PULLEY ASS'Y		1
726386	06HG	CIRCULAR NUT		1	326397	OWTN	BULB SOCKET ASS'Y		1
326392	06KA	MOTOR BASE		1	726647	OWTQ	PULLEY COVER ASS'Y		1
726388	06SV	CORD-CLAMP		1	326398	OWVE	TABLE		1
726389	06TS	SWITCH COVER		1	326529	OX5N	POWER CABLE		1
726432	08CQ	WASHER	φ24 T=1/16	1	326654	25Q0	WARNING LABEL		1
726433	08CR	NUT	M16*2.0 D=φ24 H=13	2	326399	26FE	COLLAR		1
726470	0HY8	DRILLING ARBOR		1	726776	27QB	TABLE LOCK HANDLE		1
726471	0J28	CHUCK & KEY		1	726777	27QC	COLUMN LOCK HANDLE		1
726472	0J3M	HEX. WRENCH		1	726810	28NW	HANDLE BAR ASS'Y		1
726474	0J3Q	HEX WRENCH		1	726811	28P2	ROCKER SWITCH		1
726475	0J3R	WRENCH HEX.		1	726821	28SZ	TABLE BRACKET ASS'Y		1
326393	0J4J	FLAT WASHER	φ10*20	2	326400	28WJ	HEAD		1
726493	0J7F	FLAT WASHER	5/16*7/8-5/64	4	326655	28WX	TRADE-MARK LABEL		1
726496	0J8F	FLAT WASHER	1/4*3/4-3/16	4	326656	28WZ	WARNING LABEL		1
726499	0J9M	SPRING WASHER	φ1/2	2	326657	28X0	LASER STICKER		1
726502	0JAF	EXTERNAL TOOTH LOCK WASHER	φ5	2	326401	29HG	LASER ASS'Y		1
726509	0JCM	SPRING PIN		2	326659	2HUV	LABEL		1
726516	0JG4	PARALLEL KEY		1	326658	2HUW	LABEL		1
726520	0JKD	V-BELT		1	326668	2HZS	SET BOLT ASS'Y		1

**15 in. (380mm) DRILL PRESS
SCHEMATIC-FOR AUSTRALIA AND NEW ZEALAND**

MODEL NO. B16RM



PARTS LIST-FOR SINGAPORE MALAYSIA INDONESIA

15 in. (380mm) DRILL PRESS PARTS LIST

MODEL NO. B16RM

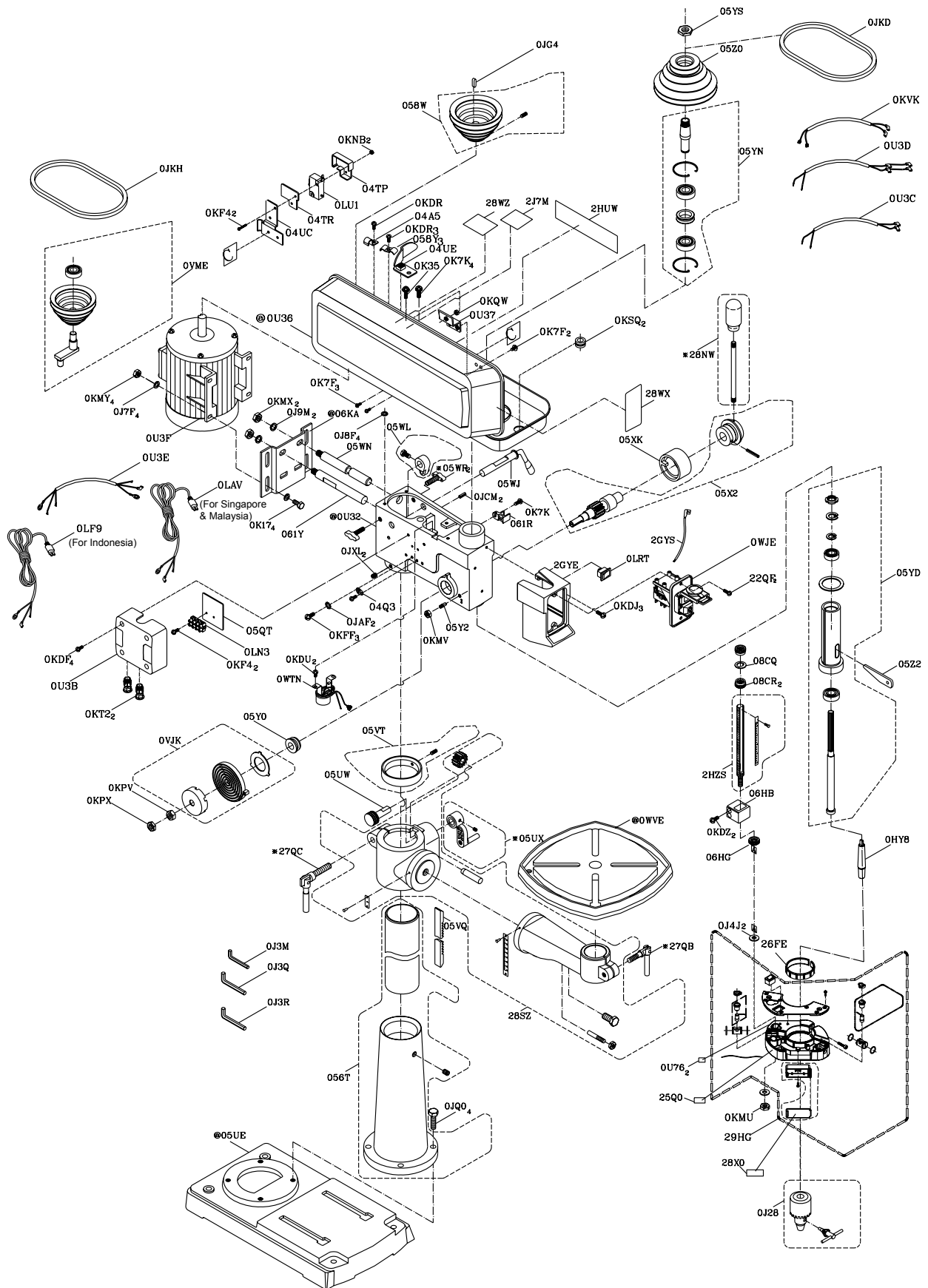
PARTS LIST FOR SCHEMATIC

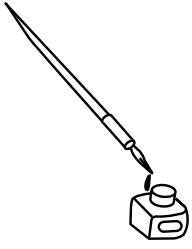
Always order by I.D. Number

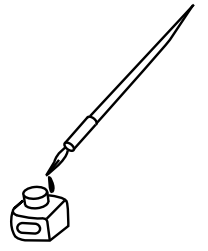
Parts No.	I.D.	Description	Size	QTY	Parts No.	I.D.	Description	Size	QTY
326402	04A5	CLAMP-CORD		1	726557	0K7K	CR. RE. ROUND WASHER HD. SCREW	M6*1.0-12	5
326403	04Q3	EARTH LABEL		1	326410	0KDF	CR. RE. PAN HD. SCREW	M5*0.8-45	4
326404	04TP	LIMIT SWITCH GUARD		1	726580	0KDJ	CR. RE. PAN HD. SCREW	M5*0.8-12	3
326405	04TR	LIMIT SWITCH INSULATION BLOCK		1	726581	0KDR	CR. RE. PAN HD. SCREW	M5*0.8-10	4
326406	04UC	RETAINING CLIP		1	726582	0KDU	CR. RE. PAN HD. SCREW	M6*1.0-12	2
326407	04UE	PRESSING		1	726583	0KDZ	CR. RE. PAN HD. SCREW	M6*1.0-35	2
726361	056T	COLUMN ASS'Y		1	326411	0KF4	CR. RE. PAN HD. SCREW	M3*0.5-20	4
726362	058W	MOTOR PULLEY ASS'Y		1	726586	0KFF	CR. RE. PAN HD. SCREW	M5*0.8-8	3
326408	058Y	CORD-CLAMP		3	726599	0KMU	HEX. NUT	M10*1.5 T=8	1
326409	05QT	INSULATE PLATE		1	726600	0KMV	HEX. NUT	M10*1.5 T=8	1
726363	05UE	BASE		1	726602	0KMX	HEX. NUT	M12*1.75 T=10	2
326389	05UW	WORM		1	726603	0KMY	HEX. NUT	M8*1.25 T=6.5	4
726364	05UX	CRANK HANDLE ASS'Y		1	326412	0KNB	HEX. NUT	M3*0.5 T=2.4	2
726366	05VQ	RACK		1	726608	0KPV	HEX. NUT	1/2*20UNF T=10	1
726367	05VT	RACK RING ASS'Y		1	726609	0KPX	HEX. NUT	1/2*20UNF T=6.5	1
726368	05WJ	HANDLE SHIFTER		1	726615	0KQW	LOCK NUT	M5*0.8 T=5	1
726369	05WL	MOTOR BAR SHIFTER ASS'Y		1	726624	0KSQ	STRAIN RELIEF	φ20	2
726370	05WN	MOTOR ROD		1	326413	0KT2	STRAIN RELIEF		2
726371	05WR	SHIFTER BOLT	M10*1.5-33	2	326414	0KVK	LEAD WIRE ASS'Y		1
726373	05X2	FEED SHAFT ASS'Y		1	326683	0LAV	POWER CABLE		1
726374	05XK	SCALE RING		1	326530	0LF9	POWER CABLE		1
726375	05Y0	SHAFT SEAT		1	326416	0LN3	WIRE CONNECTOR		1
726377	05Y2	QUILL SET SCREW	M10*1.5-2	1	726634	0LRT	ROCKER SWITCH		1
726378	05YD	SPINDLE ASS'Y		1	326417	0LU1	LIMIT SWITCH		1
726379	05YN	DRIVING SLEEVE ASS'Y		1	326669	0U32	HEAD		1
726380	05YS	PULLEY SET NUT	φ22.5	1	326418	0U36	PULLEY COVER ASS'Y		1
726381	05Z0	SPINDLE PULLEY		1	326419	0U37	TENSION PLATE		1
726382	05Z2	WEDGE SHIFTER		1	326420	0U3B	CONNECTOR BOX		1
726383	061R	CHUCK KEY HOLDER		1	326531	0U3C	LEAD WIRE ASS'Y		1
726384	061Y	MOTOR ROD		1	326532	0U3D	LEAD WIRE ASS'Y		1
726385	06HB	PLUNGER HOUSING		1	326395	0U3E	MOTOR WIRE		1
726386	06HG	CIRCULAR NUT		1	326396	0U3F	MOTOR		1
326392	06KA	MOTOR BASE		1	326653	0U76	LASER STICKER		2
726432	08CQ	WASHER	φ24 T=1/16	1	726645	0VJK	PLATE SPRING ASS'Y		1
726433	08CR	NUT	M16*2.0 D=φ24 H=13	2	726646	0VME	CENTER PULLEY ASS'Y		1
726470	0HY8	DRILLING ARBOR		1	326421	0WJE	PUSH BUTTON SWITCH ASS'Y		1
726471	0J28	CHUCK & KEY		1	326397	0WTN	BULB SOCKET ASS'Y		1
726472	0J3M	HEX. WRENCH		1	326398	0WVE	TABLE		1
726474	0J3Q	HEX WRENCH		1	326424	22QF	CR. RE. TRUSS HD. TAPPING SCREW	M5*12-20	2
726475	0J3R	WRENCH HEX.		1	326654	25Q0	WARNING LABEL		1
326393	0J4J	FLAT WASHER	φ10*20	2	326399	26FE	COLLAR		1
726493	0J7F	FLAT WASHER	5/16*7/8-5/64	4	726776	27QB	TABLE LOCK HANDLE		1
726496	0J8F	FLAT WASHER	1/4*3/4-3/16	4	726777	27QC	COLUMN LOCK HANDLE		1
726499	0J9M	SPRING WASHER	φ1/2	2	726810	28NW	HANDLE BAR ASS'Y		1
726502	0JAF	EXTERNAL TOOTH LOCK WASHER	φ5	2	726821	28SZ	TABLE BRACKET ASS'Y		1
726509	0JCM	SPRING PIN		2	326655	28WX	TRADE-MARK LABEL		1
726516	0JG4	PARALLEL KEY		1	326656	28WZ	WARNING LABEL		1
726520	0JKD	V-BELT		1	326657	28X0	LASER STICKER		1
726521	0JKH	V-BELT		1	326401	29HG	LASER ASS'Y		1
726528	0JQ0	HEX. HD. BOLT	M10*1.5-40	4	326534	2GYE	SWITCH BOX		1
325850	0JXL	HEX. SOC. SET SCREW	M10*1.5-12	2	326535	2GYS	LEAD WIRE ASS'Y		1
726535	0K17	HEX. HD. SCREW AND WASHER	M8*1.25-20	4	326658	2HUW	LABEL		1
325717	0K35	CR.RE. PAN HD. SCREW & WASHER	M5*0.8-25	1	326668	2HZS	SET BOLT ASS'Y		1
726555	0K7F	CR. RE. ROUND WASHER HD. SCREW	M5*0.8-8	5	326670	2J7M	LABEL		1

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