



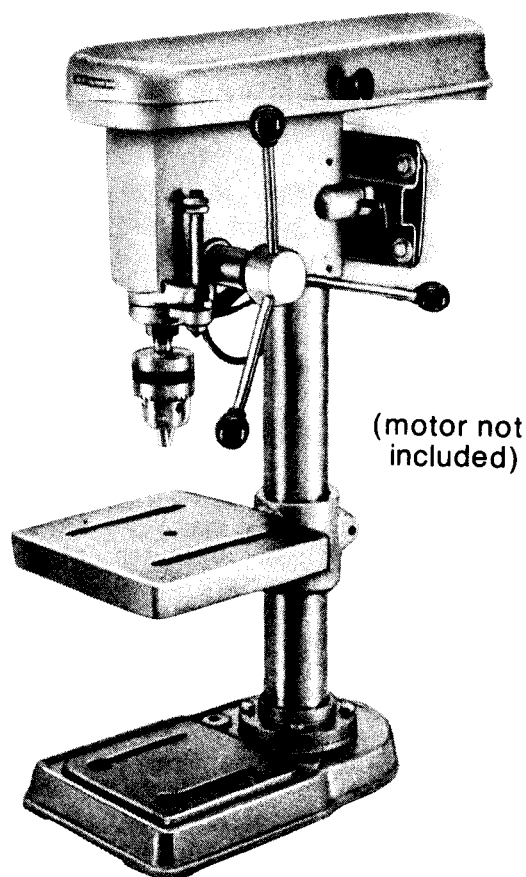
MODEL 4030

5 SPEED DRILL PRESS

INSTRUCTION MANUAL

ASSEMBLY : OPERATING MAINTAINANCE : PARTS LIST

ATTENTION: READ CAREFULLY BEFORE ATTEMPTING TO INSTALL, OPERATE OR SERVICE YOUR AMT DRILL PRESS. PROTECT YOURSELF AND OTHERS BY OBSERVING ALL SAFETY INFORMATION AND ADDITIONAL INSTRUCTIONS INCLUDED WITH THIS EQUIPMENT. FAILURE TO COMPLY WITH INSTRUCTIONS COULD RESULT IN PERSONAL INJURY AND/OR PROPERTY DAMAGE! RETAIN FOR FUTURE REFERENCE.



ASSEMBLY

1. Open the box and remove the base, working table assembly, and column assembly. Place the base on a flat surface and fasten the column assembly to the base using four cap screws, key #4, and four split washers, Key #3.
2. Slip the working table assembly onto the column and slide it down until it rests on the base.
3. Remove the head stock assembly and position it on top of the column and secure it in place by tightening two socket set screws key #15.
4. Assemble knobs, Key #26, onto one end of pull down handles, Key No. 25, and screw the handle assemblies into the pull down hub, Key #23.
5. Install motor using 4 sets of fasteners: (4) hex cap screws, (8) large washers (4) lockwashers on nut side, and (4) hex nuts. These parts are included but not shown on parts drawing. Install motor pulley key #65 and lock set screw Key #11 on motor

shaft. See "Changing Speeds" section for speed selection and belt tension. **WARNING:** Wiring of the motor and switch should be accomplished by a qualified electrician.

TABLE ADJUSTMENTS

- A. Height Adjustment: To adjust work table, Key #10, up or down, hold the table with one hand and loosen the clamp bolt, Key #9, then raise or lower the table to the desired position and retighten the clamp bolt.
- B. Tilting Work Table: To tilt the work table to the right or left, loosen bolt, Key #13, and tilt the table to the desired angle up to 45° and retighten bolt, Key No. 13.
- C. Rotation of Work Table: To rotate the work table, Key #10, loosen the clamp bolt, Key #9, and rotate the table to the desired position. The table is capable of a full 360° rotation. To obtain more distance between the chuck, Key #42, and the work table, the work table can be rotated 180° and the base, Key #1, can be used as a work table. This will permit the drilling of larger objects.

DRILL CHUCK INSTALLATION AND REMOVAL

- A. Installation: To install the drill chuck, turn chuck removal nut, Key #41, counterclockwise as far as it will go on spindle, Key #36. Open the chuck, Key #42, completely and place it snugly on the Morse taper of the spindle. Pull the feed handle down pressing the chuck against the work table, Key #10, until the taper is firmly secured.
- B. Removal: To remove the drill chuck, Key #42, open the belt guard, Key #54, while holding the pulley, Key #52, turn the chuck removal nut, Key #41, clockwise until it forces the chuck off of the spindle, Key #36.

SPINDLE ADJUSTMENT

- A. Depth Control: To control the depth of drill penetration, loosen depth control nuts, Key #46, turn the lower nut clockwise until it stops when the desired depth is obtained, then turn the upper nut clockwise until it locks tight against the lower nut. This feature is especially desirable when you are drilling several holes at the same depth.
- B. Stationary Depth: To lock in a stationary position, loosen the depth control nuts, Key #46, and turn the lower nut clockwise

until it bottoms against the head stock, Key #14. Turn the upper nut clockwise until it locks against the lower nut. Then adjust the work table height to obtain the desired spacing. This feature is useful for router and shaper work.

CHANGING SPEEDS

To change spindle speed, loosen the two motor mount lock handles, Key #16, on the right and left sides of the headstock, Key #14 and slide the motor toward the-front of the drill press. This will loosen the belt and permit relocating the belt to the appropriate pulley groove for the required spindle speed. After selection has been made, slide the motor toward the back of the drill press and tighten the motor mount lock handles. Check the belt for proper tension and make any final adjustment.

LUBRICATION

- A. Spindle Bearings: The ball bearings for the spindle are factory sealed for life and require no further lubrication.
- B. Quill Shaft: To lubricate the quill shaft, pull the handle down to maximum depth and oil moderately. This should be done once every three months.

Motor Slide Bars: Remove the motor belt as described for changing speeds and oil the right and left slide bars lightly every two months.

PARTS LIST

KEY NO.	PART NO.	DESCRIPTION	KEY NO.	PART NO.	DESCRIPTION
1	4030.01	BASE	38	4030.38	QUILL STOP
2	4030.02	COLUMN FLANGE	39	1727.00	*1/4-20 x 1-1/4 HEX CAP SCREW
3	4030.03	*5/16 SPLIT LOCKWASHER (4 Req.)	40	1773.00	*1/4-20 HEX NUT
4	1746.00	*5/16-18 x 1 HEX HEAD CAP SCREW (4 Req.)	41	4030.41	NUT-CHUCK REMOVAL
5	4030.05	COLUMN	42	4030.42	1/2" CHUCK
6	4030.06	TABLE POSITION CLAMP	43	4030.43	1/2" CHUCK KEY
7	4030.07	TABLE ANGLE SCALE	44	4030.44	DEPTH CONTROL STUD
8	4030.08	SCALE FASTENERS	45	4030.45	DEPTH INDICATOR
9	4030.09	LOCK HANDLE, TABLE	46	1782.00	*1/2-20 HEX JAM NUT (2 Req.)
10	4030.10	WORK TABLE	47	1781.00	*3/8-16 HEX NUT (2 Req.)
11	1713.01	*1/4-20 x 3/8 SOCKET SET SCREW (2 Req.)	48	4030.48	SNAP RING-BEARING RETAINER DRIVE
12	1798.02	*1/2 SAE WASHER	49	4030.49	BALL BEARING-SPINDLE DRIVE SLEEVE
13	1766.12	*1/2-13 x 1 HEX CAP SCREW	50	4030.50	SPINDLE DRIVE SLEEVE
14	4030.14	HEADSTOCK	51	4030.51	SNAP RING-PULLEY STOP
15	1738.01	*5/16-18 x 1/2 SOCKET SET SCREW (2 Req.)	52	4030.52	PULLEY-DRIVE
16	4030.16	LOCK HANDLE MOTOR MOUNT	53	1713.01	*SAME AS KEY #11
17	4030.17	MOTOR MOUNT SLIDE STUD	54	4030.54	BELT GUARD
18	1793.00	*3/8 SAE WASHER (4 Req.)	55	4030.55	KNOB-BELT GUARD
19	4030.19	MOTOR MOUNT BRACKET	56	4030.56	*1/4-20 x 3/8 PAN HEAD MACHINE SCREW (4 Req.)
21	1781.00	*3/8-16 HEX NUT (2 Req.)	57	4030.57	*1/4 SPLIT LOCKWASHER
22	4030.22	PULL DOWN SHAFT	58	4030.58	ON-OFF SWITCH
23	4030.23	PULL DOWN HUB	59	4030.59	COVER PLATE-SWITCH
24	4030.24	PIN PULL DOWN HUB	60	4030.60	SCREW-COVER PLATE
25	4030.25	PULL DOWN HANDLE	61	4030.61	POWER CORD-SWITCH TO MOTOR
26	4030.26	KNOB PULL DOWN HANDLE	62	4030.62	POWER CORD-SOURCE TO SWITCH
27	4030.27	RETURN SPRING	63	4030.63	GROMMET-RUBBER
28	4030.28	COVER-RETURN SPRING	64	4030.64	WIRE NUT
29	4030.29	NUT	65	4030.65	MOTOR PULLEY
31	4030.31	QUILL TENSION SCREW	N.S.	4030.66	BELT
32	1779.00	*5/16-18 HEX NUT	MOTOR MOUNT FASTENERS (NOT SHOWN)		
33	4030.33	SNAP RING	N.S.	1746.00	SCREW, SAME AS KEY #4 (4 Req.)
34	4030.34	BALL BEARING	N.S.	1790.00	5/16 SAE WASHER (8 Req.)
35	4030.35	QUILL	N.S.	4030.03	LOCKWASHER, SAME AS KEY #3 (4 Req.)
36	4030.36	SPINDLE	N.S.	1779.00	NUT, SAME AS KEY #32 (4 Req.)
37	4030.37	RUBBER WASHER			

