

INSTRUCTION SHEET

POWERTEC®

71184 Drill Press Table 16" x 24" with hold down clamps



WARNING

This product is to be used with a drill press. Before using this product, always read, understand and follow the instructions and safety warnings in the owner's manual for the drill press. If you do not have the owner's manual, obtain one from the tool's manufacturer before using it with this product.

You must be familiar with the use of any tool or accessory used with this drill press table/fence system. The supplier cannot be held responsible for any accident, injury or damage incurred while using this drill press table/fence system with any tool.

It is the responsibility of the purchaser of this product to ensure that any person using this product reads and complies with all instructions and safety precautions outlined in this manual and the operating manual of the tool being used prior to use.

CAUTION

Do not modify or use this drill press table/fence system for any application other than that for which it was designed.

WARNING

- To avoid serious injury, turn off and unplug the drill press before attaching, adjusting or changing accessories.

CAUTION

Think safety! Safety is a combination of operator common sense and alertness at all times when tool is being used.

WARNING

Do not use the drill press table/fence system until it is completely assembled and you have read and understood this entire operating manual and the operating manual of the tool being used with this drill press table/fence system.

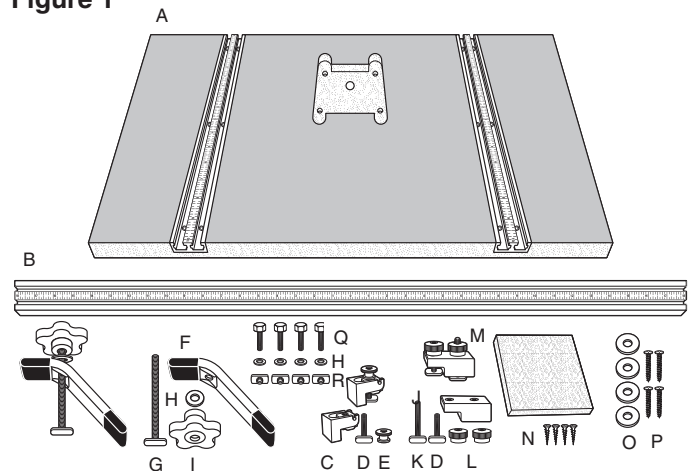
SAVE ALL WARNINGS AND INSTRUCTIONS FOR FUTURE REFERENCE

PACKAGING CONTENTS

ITEM	DESCRIPTION	QTY
A	16" x 24" Table with mounted double wide engraved T-Tracks	1
B	36" Double Wide Engraved Fence	1

ITEM	DESCRIPTION	QTY
C	Flip Stops	2
D	1/4"-20 x 1" T-Bolts	4
E	1/4"-20 x 5/8" Round Knobs (metal)	2
F	5-1/2" Hold Down Clamps	2
G	5/16"-18 x 3-1/2" T-Bolts	2
H	5/16" Washers	6
I	5/16"-18 Five Star Knobs	2
J	Fence Mounting Blocks	2
K	1/4"-20 x 1-1/2" T-Bolts	2
L	1/4"-20 x 3/4" Round Knobs (plastic)	4
M	Table Insert	1
N	#6 x 1/2" Adjustment Screws (Insert)	4
O	1" Fender Washers	4
P	#10 x 1-1/4" Pan Head Screws	4
Q	5/16"-18 x 1" Hex Bolts	4
R	Oval Nuts	4

Figure 1



ASSEMBLY

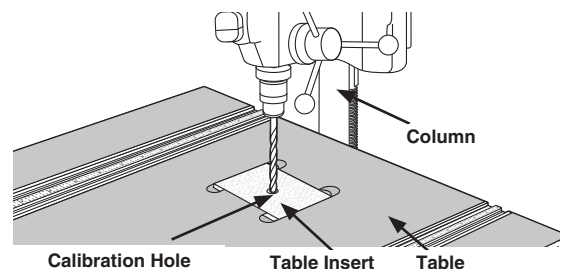
Assemble to Drill Press

Refer to Figure 2-5

Installation to Through Slotted Drill Press Tables

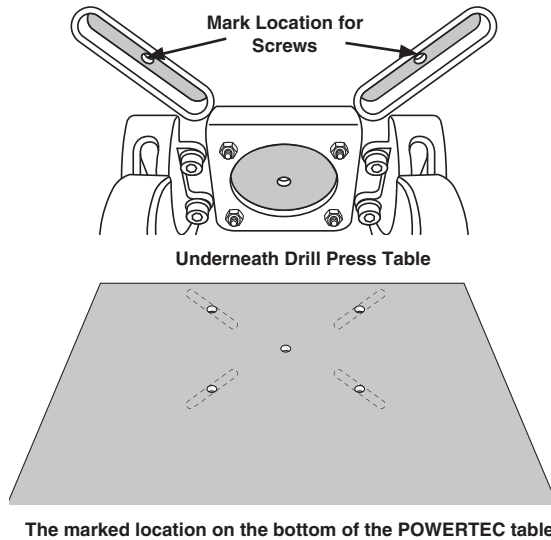
- Place the POWERTEC table onto the drill press table with the short side of insert opening to the column as shown.
- Insert a 3/8" bit into the drill chuck and feed it through the calibration hole in the table insert. Square the table and lock the spindle.

Figure 2



- From underneath the drill press table, mark through the slots for the location of the four attachment screws onto the underside of the POWERTEC table.
- Remove the POWERTEC table, turn it upside down and drill 5/32" pilot holes at the marks. DO NOT drill through the table.

Figure 3



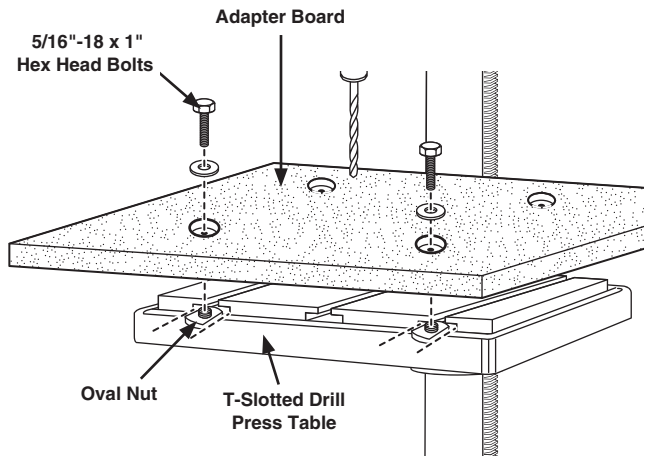
- Place the POWERTEC table back onto the drill press table, place the 3/8" bit through the calibration hole, square the table and lock the spindle.
- Place a fender washer onto each #10 x 1-1/4" pan head screw, from underneath the drill press table, thread the screw into the pilot holes. DO NOT over tighten the screws, over tightening can strip the holes.

Installation on T-Slotted Tables

Some larger drill presses have solid, T-Slotted tables. Follow these instruction to mount the POWERTEC table.

- An adapter board will need to be made to mount the POWERTEC table to this type of drill press table. Make the adapter board approximately 15-1/2" x 23-1/2" x 3/4" in thickness.
- Center the adapter board onto the drill press table and select the location on the adapter board for the four mounting bolts (provided 5/16"- 18 x 1" hex bolts). Mark these locations, making sure they are perfectly centered to the T-Slots in the drill press table. **NOTE:** The adapter board must be centered on the drill press table with overlap on each side.
- The holes should be 3/8" in diameter. **NOTE:** The bolts must be flush to the adapter board. Counter-bored holes are needed with the hex head bolts. Counter bored holes can be made by using a forstner bit and a standard 3/8" drill bit. If flat head screws are used a counter sunk hole is needed. Most hardware stores sell countersink bits for this purpose.
- Attach the adapter board to the drill press table.
 - Insert the 5/16"- 18 x 1" hex bolts with 5/16" washers through top of the adapter board and attach an oval nut onto each bolt.
 - Slide the oval nuts in to the correct T-Slot on the drill press table and tighten the bolts. Make sure the adapter board table top is flush.

Figure 4



- Attach the POWERTEC table to the adapter board.
 - Place the POWERTEC table onto the adapter board.
 - From underneath the adapter board, pre-drill two 7/32" holes through the adapter board.
 - Making sure the POWERTEC table is centered on the adapter board, pre-drill two 5/32" holes into the bottom of the table. DO NOT drill through the table.
 - Use four #10 x 1-1/4" pan head screws to attach the POWERTEC table to the adapter board.

Figure 5

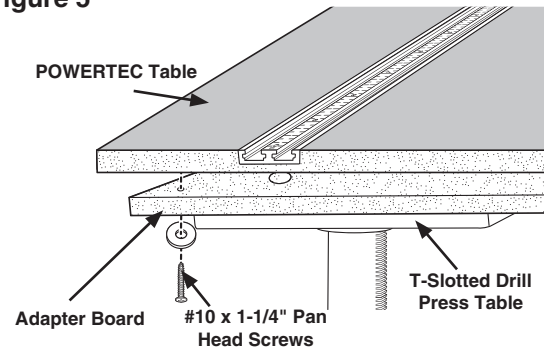
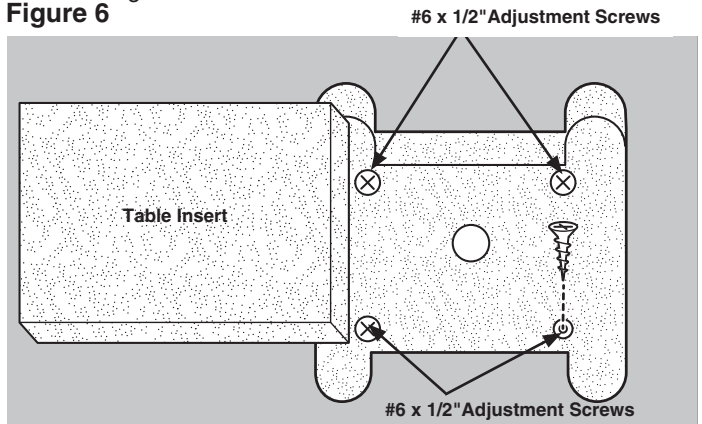


Table Insert

Refer to Figure 6–7

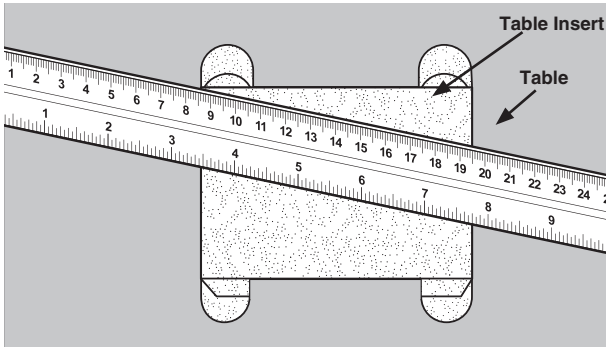
There is an opening in the table for the insert (filler), thread the four adjustment screws into the recessed area of this opening as shown in Figure 6.

Figure 6



- Place the insert into the opening and check with a straight edge. Use a Phillips screw driver to adjust the screws until the insert is flush with the top of the table.

Figure 7



Assemble Fence Mounting Blocks

Refer to Figure 8–10

- Insert two 1/4"-20 x 1-1/2" T-Bolts through the bottom of the each mounting blocks and thread a knob (Item L) onto each T-Bolt. Do not tighten.
- Slide the back T-Bolt into the T-Slot of the double-wide T-Track (either track may be used depending on your requirements). Make sure the overhang on the mounting block is assembled to the front. It will be assembled to the fence.
- Slide the front 1/4"-20 x 1" T-Bolt into the fence T-Slot as shown.
- Repeat to assemble the other end of the fence to the table.

Figure 8

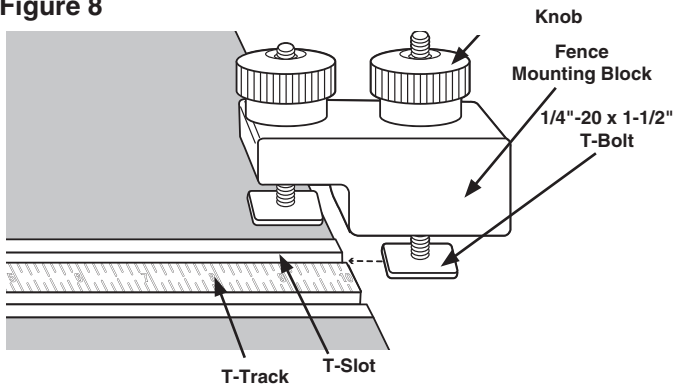
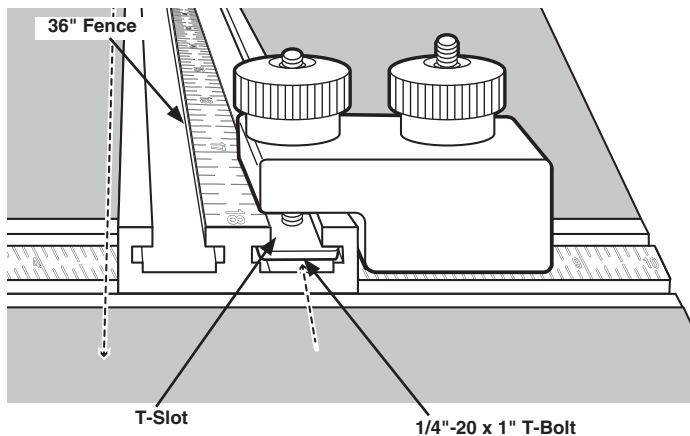
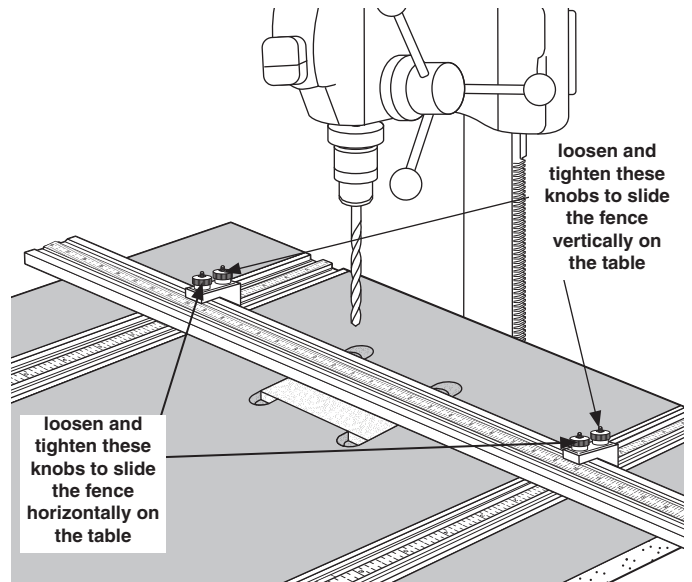


Figure 9



- Slide the fence horizontally across the table to the desired position. Tighten the front knobs on the fence mounting blocks to secure the fence to the mounting blocks.
- Slide the fence vertically into the desired position and tighten the back knobs. This will lock the fence in position onto the table.

Figure 10



To Adjust the Fence

Refer to Figure 10

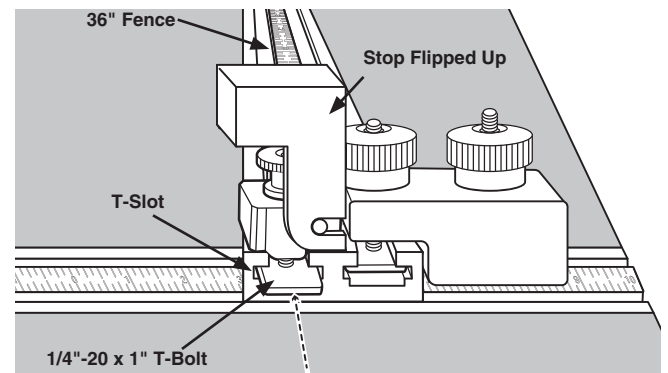
- Loosen the two back knobs on the mounting blocks to slide the fence vertically
- Loosen the two front knobs to slide the fence horizontally.
- Tighten the knobs securely to lock the fence in place after each adjustment.

Flip Stop

Refer to Figure 1, 11–12

- Assemble 1/4"-20 x 1" T-bolt (Item D) and 1/4"-20 x 5/8" round knobs (Item E) to flip stops (Item C) as shown in Figure 1.
- Flip up the flip stop and slide the 1/4"-20 x 1" T-bolt into the T-Slot to the front of the fence. Repeat on other side.

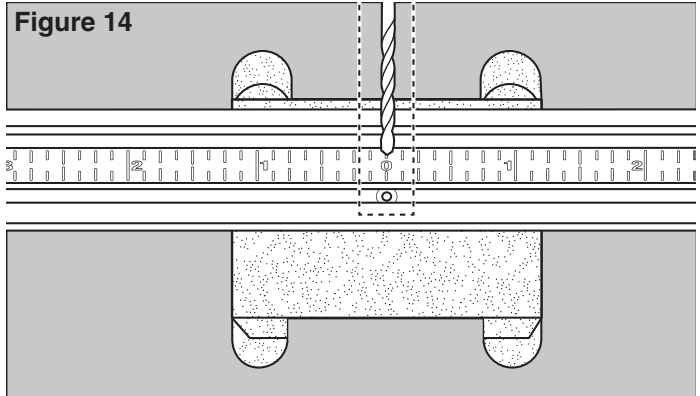
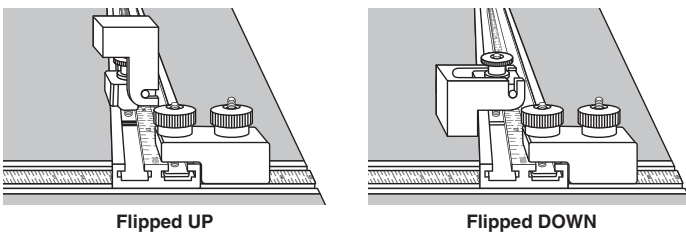
Figure 11



To Adjust the Flip Stop

- Flip up the flip stop.
- Slide the flip stop along the fence to the desired position.
- Flip the stop down to lock into position on the fence.

Figure 12



Hold Down Clamps

Refer to Figure 13

Slide the T-Bolts on hold-down clamps into the table T-Track slots.

Figure 13

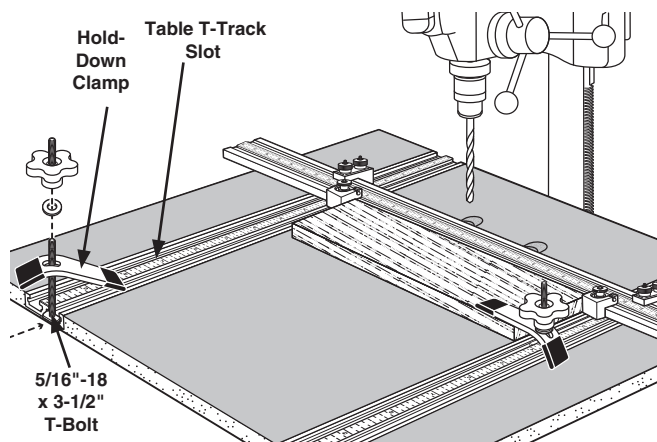


Figure 15

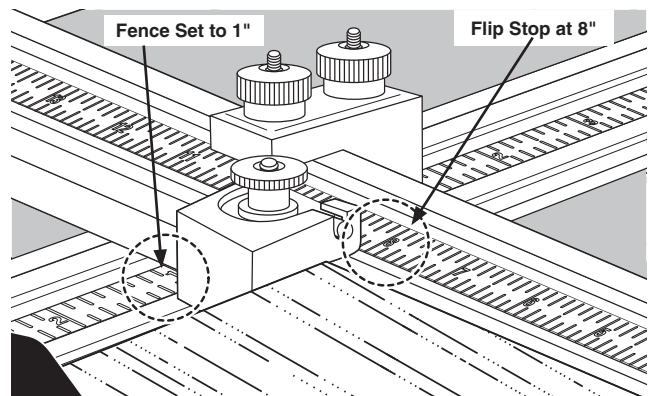
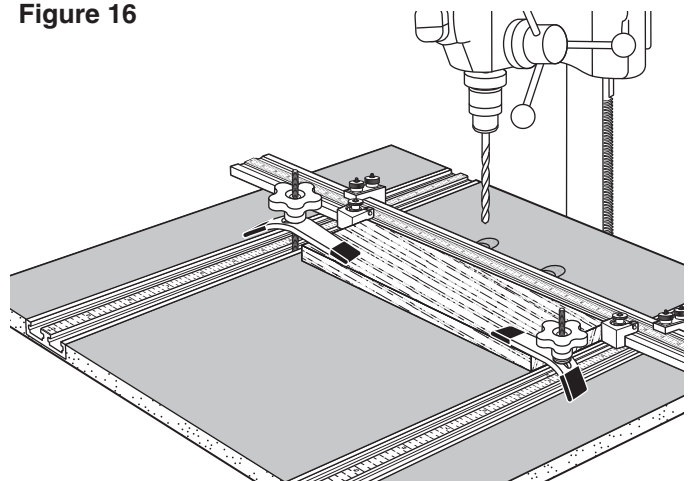


Figure 16



To Adjust the Hold Down Clamps

- Loosen knob on the hold down clamp.
- Slide the clamp along the T-Track to the desired position. Position the clamp onto the workpiece.
- Tighten the knob to secure the workpiece and clamp in place.

TIPS

- Turn the feed handles on the drill press to make sure they do not interfere with the fence system. If needed, one or more of the feed handles may need to be removed.
- When setting up using the 3/8" calibration hole in the center of the table, the fence and T-Slot scales are set zeroed to the drill bit, allowing accurate plus and minus settings from the zero points. **EXAMPLE:** To drill a hole, 1" from the top of a board and 8" from the left, perform the following:
 - Set the zero on the fence to the center point of the drill bit. (Figure 14)
 - On both of the T-Track scales, set the fence at the 1" mark. (Figure 15,16)
 - Slide the flip stop on the left end to the 8" mark on the fence scale and lock in place. (Figure 15,16)
 - Place the workpiece against the flip stop and fence and drill the hole. (Figure 15,16)

- Periodically check and make sure all knobs are tight and secure.
- Clean the drill press table/fence system after each use:
 - Wipe the drill press table and vacuum all T-Slots in the table and fence.
 - To prevent condensation and rust between the two tables, DO NOT leave the drill press table mounted on the drill press for long periods of time.

Visit us on the web at www.powertecproducts.com



Put these instructions and the original sales invoice in a safe, dry place for future reference.

Southern Technologies, LLC
Waukegan, IL 60087