



OPERATOR'S MANUAL

Metal Working



GEAR DRIVE DRILL PRESS MODEL: DP-1000G

Baileigh Industrial Holdings LLC
P.O. Box 531
Manitowoc, WI 54221-0531
Phone: 920.684.4990
Fax: 920.684.3944
sales@baileigh.com

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THANK YOU & WARRANTY

Thank you for your purchase of a machine from Baileigh Industrial Holdings LLC. We hope that you find it productive and useful to you for a long time to come.

Inspection & Acceptance. Buyer shall inspect all Goods within ten (10) days after receipt thereof. Buyer's payment shall constitute final acceptance of the Goods and shall act as a waiver of the Buyer's rights to inspect or reject the goods unless otherwise agreed. If Buyer rejects any merchandise, Buyer must first obtain a Returned Goods Authorization ("RGA") number before returning any goods to Seller. Goods returned without an RGA will be refused. Seller will not be responsible for any freight costs, damages to goods, or any other costs or liabilities pertaining to goods returned without a RGA. Seller shall have the right to substitute a conforming tender. Buyer will be responsible for all freight costs to and from Buyer and repackaging costs, if any, if Buyer refuses to accept shipment. If Goods are returned in unsalable condition, Buyer shall be responsible for full value of the Goods. Buyer may not return any special-order Goods. Any Goods returned hereunder shall be subject to a restocking fee equal to 30% of the invoice price.

Specifications. Seller may, at its option, make changes in the designs, specifications or components of the Goods to improve the safety of such Goods, or if in Seller's judgment, such changes will be beneficial to their operation or use. Buyer may not make any changes in the specifications for the Goods unless Seller approves of such changes in writing, in which event Seller may impose additional charges to implement such changes.

Limited Warranty. Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain a RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without a RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 10 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (e) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

EXCLUSION OF OTHER WARRANTIES. THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

Limitation of Liability. IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.



Force Majeure. Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightening, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

Installation. If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

Work By Others; Safety Devices. Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation or provision of Goods. Buyer is solely responsible for furnishing and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

Remedies. Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

Attorney's Fees. In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorney fees and costs.

Governing Law/Venue. This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. Each party waives to the fullest extent permitted by applicable law the right to a trial by jury.

Summary of Return Policy.

- 10 Day acceptance period from date of delivery. Damage claims and order discrepancies will not be accepted after this time.
- You must obtain a Baileigh issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh in new condition and in original packaging.
- Altered items are not eligible for return.
- Buyer is responsible for all shipping charges.
- A 30% re-stocking fee applies to all returns.

Baileigh Industrial Holdings LLC makes every effort to ensure that our posted specifications, images, pricing and product availability are as correct and timely as possible. We apologize for any discrepancies that may occur. Baileigh Industrial Holdings LLC reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

For Customer Service & Technical Support:

Please contact one of our knowledgeable Sales and Service team members at:
(920) 684-4990 or e-mail us at sales@baileigh.com



INTRODUCTION

The quality and reliability of the components assembled on a Baileigh Industrial Holdings LLC machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However, if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.

Our technical staff will do their best to help you get your machine back in working order.

In this manual you will find: (when applicable)

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Setup and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

GENERAL NOTES

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact Baileigh Industrial Holdings LLC and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any modifications.



Note: This symbol refers to useful information throughout the manual.



IMPORTANT

PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



SAFETY INSTRUCTIONS

LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**



Follow recommended precautions and safe operating practices.

UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** – is used with the safety alert symbol. **NOTICE**, which is not related to personal injury, is used without a symbol.

DANGER: Indicates a hazardous situation which, if not avoided, will result in death or serious injury.

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

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

NOTICE: Indicates a situation which, if not avoided, could result in property damage.

DANGER

WARNING

CAUTION

NOTICE

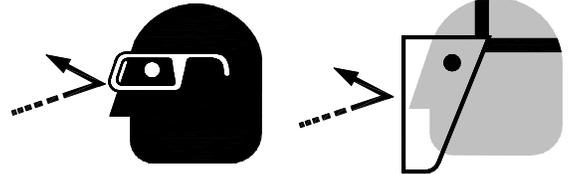


SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



PROTECT EYES

Wear safety glasses or suitable eye protection when working on or around machinery.



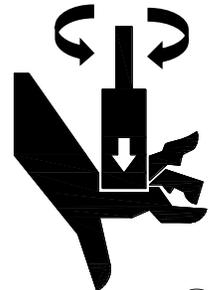
PROTECT AGAINST NOISE

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



BEWARE OF PIERCING POINTS AND CUTTING HAZARD

NEVER place hands, fingers, or any part of your body on or near rotating tooling. This tooling can be extremely dangerous if you do not follow proper safety procedures. **Keep hand at least 6 inches (150mm) from the tooling while operating.**



ENTANGLEMENT HAZARD – ROTATING SPINDLE

Contain long hair, **DO NOT** wear jewelry or loose fitting clothing.



EMERGENCY STOP BUTTON

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **E-STOP** button. Twist the emergency stop button clockwise (cw) to reset. Note: Resetting the E-Stop will not start the machine.



CALIFORNIA PROPOSITION 65

WARNING: Cancer and Reproductive Harm.
www.P65Warnings.ca.gov





SAFETY PRECAUTIONS



Metal working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, hold-downs, safety glasses, dust masks and hearing protection can reduce your potential for injury. But even the best guard will not make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.

REMEMBER: Your personal safety is your responsibility.



WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

Dear Valued Customer:

- All Baileigh machines should be used only for their intended use.
- Baileigh does not recommend or endorse making any modifications or alterations to a Baileigh machine. Modifications or alterations to a machine may pose a substantial risk of injury to the operator or others and may do substantial damage to the machine.
- Any modifications or alterations to a Baileigh machine will invalidate the machine's warranty.

PLEASE ENJOY YOUR BAILEIGH MACHINE!PLEASE ENJOY IT SAFELY!

1. **FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.** Learn the machine's application and limitations as well as the specific hazards.
2. **Only trained and qualified personnel can operate this machine.**
3. **Make sure guards are in place and in proper working order before operating machinery.**
4. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
5. **Keep work area clean.** Cluttered areas invite injuries.
6. **Overloading machine.** By overloading the machine, you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
7. **Dressing material edges.** Always chamfer and deburr all sharp edges.



8. **Do not force tool.** Your machine will do a better and safer job if used as intended. **DO NOT** use inappropriate attachments in an attempt to exceed the machine's rated capacity.
9. **Use the right tool for the job. DO NOT** attempt to force a small tool or attachment to do the work of a large industrial tool. **DO NOT** use a tool for a purpose for which it was not intended.
10. **Dress appropriately. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
11. **Use eye protection.** Always wear ISO approved protective eye wear when operating machinery. Wear a full-face shield if you are producing metal filings. Eye wear shall be impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specification. Use of eye wear which does not comply with ANSI Z87.1 specification could result in severe injury from breakage of eye protection.
12. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
13. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
14. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
15. **Observe work area conditions. DO NOT** use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
16. **Tooling maintenance.** Always keep drill bits sharp for optimum performance.
17. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
18. Keep visitors a safe distance from the work area.
19. **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
20. **DO NOT operate machine if under the influence of alcohol or drugs.** Read warning labels on prescriptions. If there is any doubt, **DO NOT** operate the machine.
21. **Turn off** power before checking, cleaning, or replacing any parts.
22. Be sure **all** equipment is properly installed and grounded according to national, state, and local codes.
23. Keep **all** cords dry, free from grease and oil, and protected from sparks and hot metal.
24. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. **Bare wiring can kill! DO NOT** touch live electrical components or parts.
25. **DO NOT** bypass or defeat any safety interlock systems.



MACHINE DESCRIPTION

The Baileigh DP-1000G is a very economical gear head drill press that can run in any fabrication or machine shop using only 110 volts of power. It can drill through mild steel with up to a 1" (25.4mm) drill bit. It comes standard with a heavy cast iron base and adjustable table. To reduce flexing this gear head drill press uses a column with a 4" (101.6mm) diameter. The gear head also can be adjusted up or down on the column. The transmission offers multiple speeds that are perfect for drilling and tapping an array of different materials. The DP-1000G comes standard with a halogen light and protective guarding.

TECHNICAL SPECIFICATIONS

Drill Capacity	1" (25.4mm)
Tapping Capacity	.625" (15.875mm)
Spindle Speed	125, 420, 535, or 1740 rpm
Spindle Taper	MT 3
Spindle Travel	5.3" (135mm)
Tables Dimensions (L x W)	19.75 x 13.75 (501 x 350mm)
Base Dimensions (L x W)	15.5 x 19.5 (393 x 495mm)
Motor	1.5hp (1.12kw), 110V, 60Hz, 14A
Power Supply	110V, 60Hz
Shipping Dimensions (L/W/H)	66" x 23" x 29" (1676 x 584 x 737mm)
Shipping Weight	484 lbs (220kg)

TECHNICAL SUPPORT

Our technical support department can be reached at 920.684.4990 and asking for the support desk for purchased machines. Tech Support handles questions on machine setup, schematics, warranty issues, and individual parts needs: (other than die sets and blades).

For specific application needs or future machine purchases contact the Sales Department at: sales@baileigh.com, Phone: 920.684.4990, or Fax: 920.684.3944.



Note: *The photos and illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.*



Note: *The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.*



UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.

⚠ WARNING: SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.
If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

Cleaning

⚠ WARNING: DO NOT USE gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.

⚠ CAUTION: When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.



Important: This waxy coating is **NOT** a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.



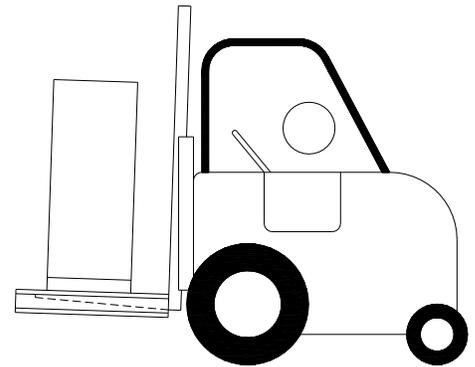


TRANSPORTING AND LIFTING

NOTICE: *Lifting and carrying operations should be carried out by skilled workers, such as a truck operator, crane operator, etc. If a crane is used to lift the machine, attach the lifting chain carefully, making sure the machine is well balanced.*

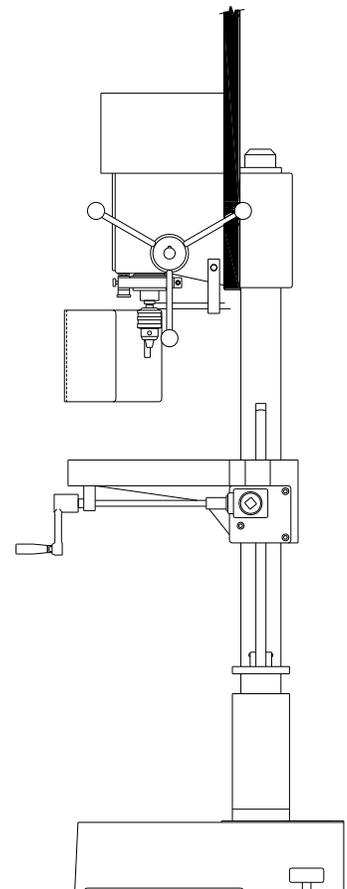
Follow these guidelines when lifting with truck or trolley:

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.
- Use a fork lift with sufficient lifting capacity and forks that are long enough to reach the complete width of the machine.
- Remove the securing bolts that attach the machine to the pallet.
- Approaching the machine from the side, lift the machine on the frame taking care that there are no cables or pipes in the area of the forks.
- Move the machine to the required position and lower gently to the floor.
- Level the machine so that all the supporting feet are taking the weight of the machine and no rocking is taking place.



Follow these guidelines when lifting crane or hoist:

- Always lift and carry the machine with the lifting holes provided at the top of the machine.
- Use lift equipment such as straps, chains, capable of lifting 1.5 to 2 times the weight of the machine.
- Take proper precautions for handling and lifting.
- Check if the load is properly balanced by lifting it an inch or two.
- Lift the machine, avoiding sudden accelerations or quick changes of direction.
- Locate the machine where it is to be installed, and lower slowly until it touches the floor.





INSTALLATION

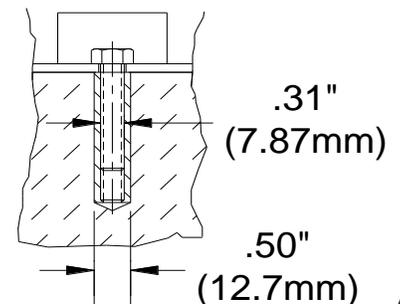
IMPORTANT:

Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they will not extend into any aisles.
- **LEVELING:** The machine should be sited on a level, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This tool distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.

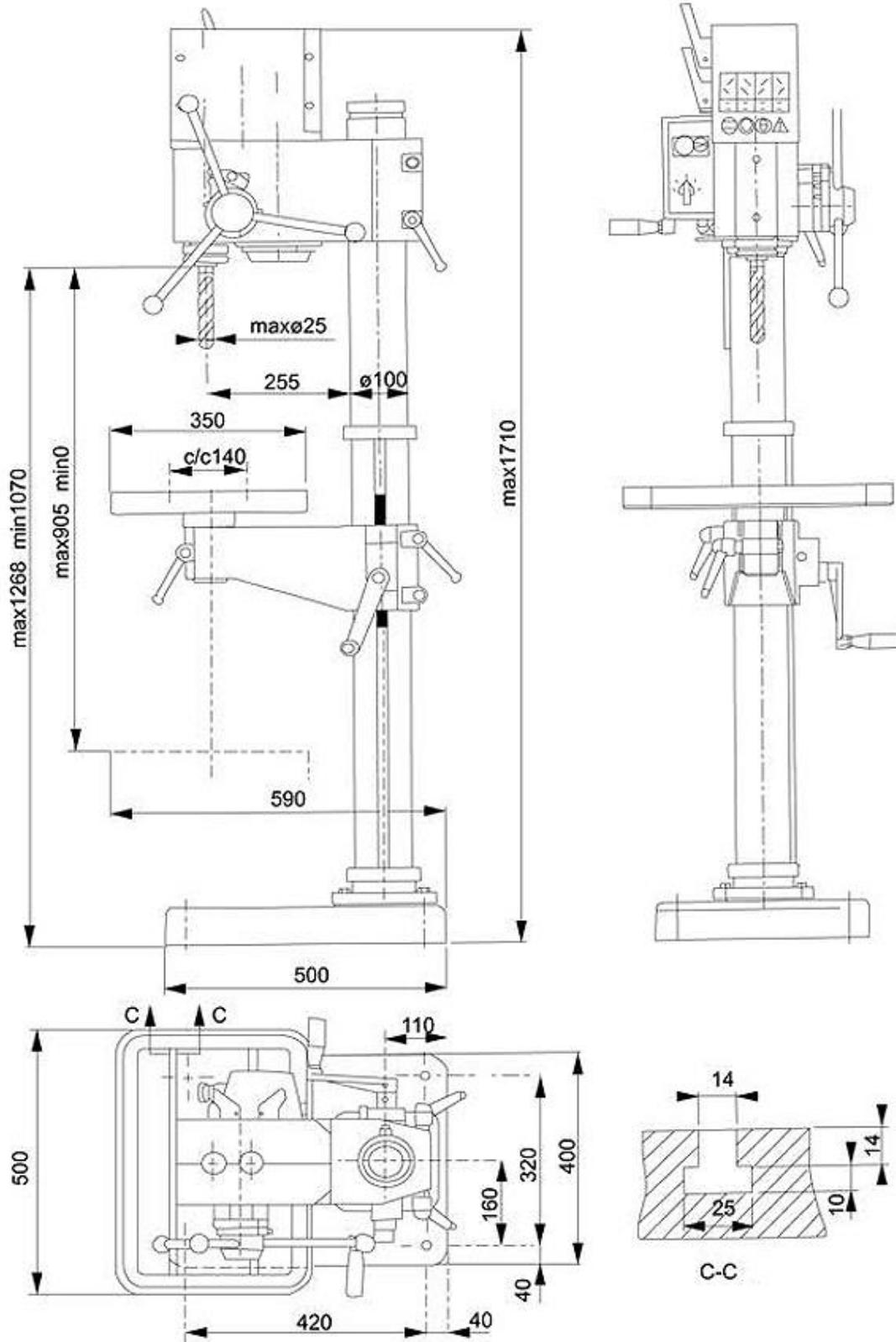
Anchoring the Machine

- Once positioned, anchor the machine to the floor, as shown in the diagram. Use bolts and expansion plugs or sunken tie rods that connect through and are sized for the holes in the base of the stand.
- This machine requires a solid floor such as concrete at a minimum of 4" (102mm) thick. 6" (153mm) minimum is preferred.



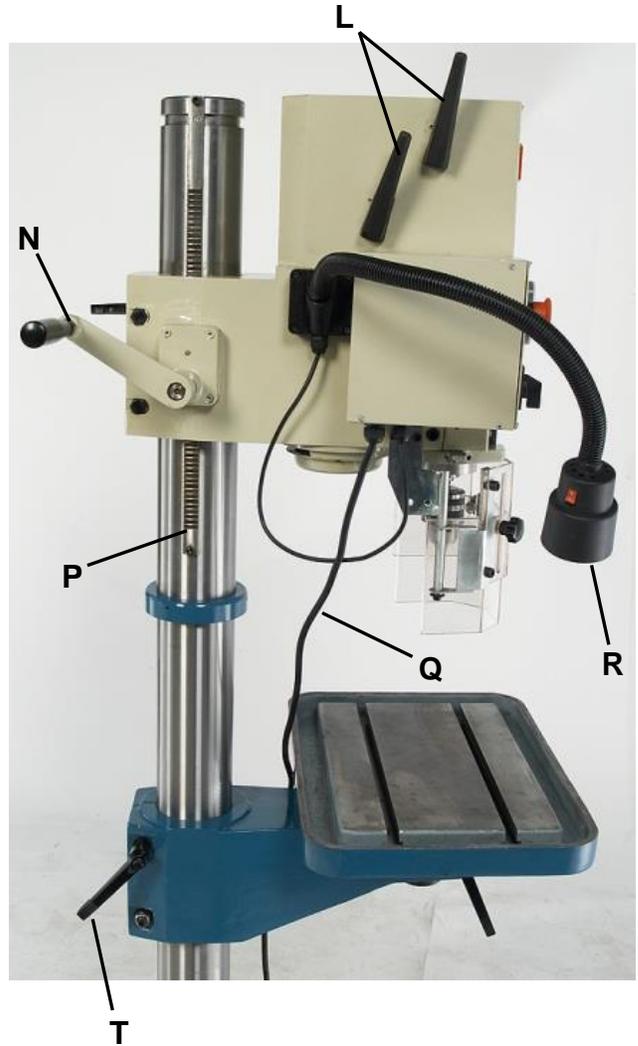
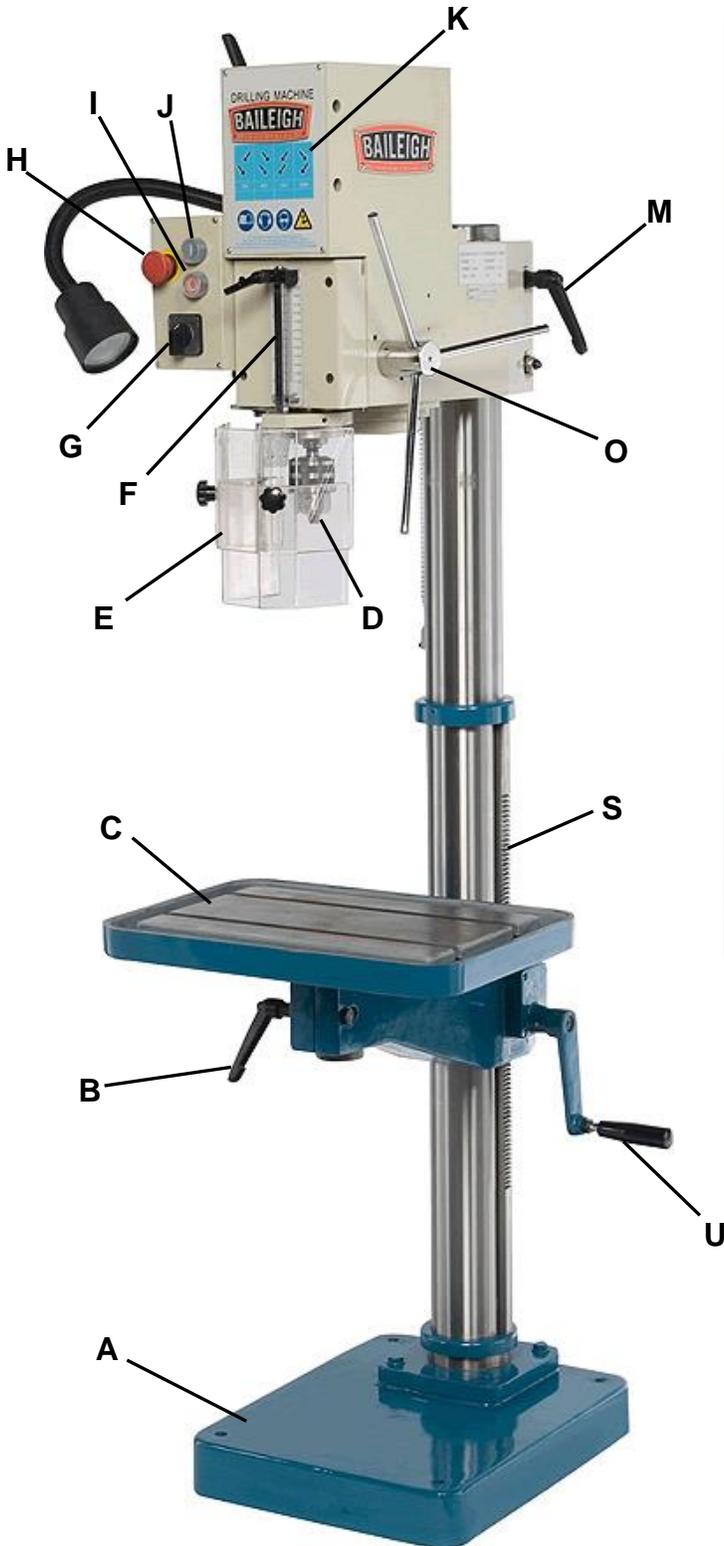


OVERALL DIMENSIONS





GETTING TO KNOW YOUR MACHINE





Item	Description	Function
A	Base	Support the drill press
B	Table Rotation Lock	Loosen to allow the table to rotate on its center axis. NEVER OPERATE THE MACHINE WHEN UNLOCKED.
C	Work Table	Work surface with T-slots
D	Chuck	Holds various tools for drilling and tapping
E	Drill Guard	Adjustable guard to cover the chuck and restrict access during operation
F	Depth Adjustment	Moves the depth stop up and down
G	Rotation Selector Switch	Selects if the chuck will rotate clockwise or counter-clockwise. DO NOT change rotation direction until the spindle has stopped completely.
H	Emergency Stop Button	Press to stop machine in the event of incorrect operation or dangerous condition. Twist the emergency stop button clockwise (cw) to reset.
I	Stop Button	Press to stop the motor
J	Start Button	Press to start the motor
K	Speed (RPM) Selection Chart	Shows a visual representation of the handle positions for each of the four RPM settings
L	Speed (RPM) Selection Handles	Position the handles to match the chart diagram to run the chuck at the RPM setting. DO NOT change spindle RPM until the spindle has stopped completely.
M	Drill Head Position Lock	Loosen to allow the drill head to move on the column. NEVER OPERATE THE MACHINE WHEN UNLOCKED.
N	Drill Head Adjustment Drive	Raises and lower the drill head on the column
O	Feed Handle	Operator control to lower and raise the drill spindle
P	Drill Head Gear Rack	Engages the drill head for height adjustment
Q	Power Cord	Connects to the proper power supply to provide power to the machine
R	Work Lamp	Provides additional lighting to the work area
S	Table Gear Rack	Engages the table support arm for height adjustment
T	Table Position Lock	Loosen to allow the table to move on the column. NEVER OPERATE THE MACHINE WHEN UNLOCKED.
U	Table Adjustment Drive	Raises and lower the table on the column



The Drill Head

The drill head attaches to the upper column. It houses the motor, spindle, and speed controls. Attached to it is the electrical enclosure, the protective guard, the work light. The drill head can be lowered, raised, and rotated on the column as needed. Always unlock the head clamp before changing position, and then lock the head in the new position.



The Work Table

The sturdy work table can be positioned at varying heights and rotated 180° in either direction. It has T-slots to allow the use of 1/2" or M14 bolts. Below the work table are two lock handle and a crankshaft. The crankshaft and lock handle near the column control the up /down and swing positions of the table and support arm. The front lock handle under the table controls the rotation of the table. Always unlock the table before changing the height or rotating it. Then lock the work table to secure in position.

The Machine Base

The machine base supports the entire machine and should be secured to the work surface.



ELECTRICAL

 **CAUTION:** HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!
Check if the available power supply is the same as listed on the machine nameplate.

 **WARNING:** Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

Power Specifications

Your machine is wired for 110 volts, 60hz alternating current. Before connecting the machine to the power source, make sure the power source is OFF.

Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is $\pm 5\%$, and for the frequency is $\pm 1\%$.

Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with an amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your machines. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the machine.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

 **WARNING:** In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.



- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.
- Repair or replace damaged or worn cord immediately.

Extension Cord Safety

Extension cord should be in good condition and meet the minimum wire gauge requirements listed below:

AMP RATING	LENGTH		
	25ft	50ft	100ft
1-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No
WIRE GAUGE			

An undersized cord decreases line voltage, causing loss of power and overheating. All cords should use a ground wire and plug pin. Replace any damaged cords immediately.

Power cord connection:

1. Turn the main disconnect switch on the control panel to the OFF position.
2. Unwrap the power cord and route the cord away from the machine toward the power supply.
 - a. Route the power cord so that it will NOT become entangled in the machine in any way.
 - b. Route the cord to the power supply is a way that does NOT create a trip hazard.
3. Connect the power cord to the power supply and check that the power cord has not been damaged during installation.
4. When the machine is clear of any obstruction. The main power switch may be turn ON to test the operation. Turn the switch OFF when the machine is not in operation.



OPERATION

⚠ CAUTION: Always wear proper eye protection with side shields. Restrain and contain long hair, loose or baggy clothing and remove jewelry to prevent entanglement.

Safety guard must be properly positioned.

1. Load and secure the piece part to the table.
2. Secure drill or tapping bit in the chuck.
3. Unlock the table, set to desired position, and re-lock. Adjust the safety guard as necessary.
4. To set the depth stop, use the feed handle (O), to bring the tip of the drill or tapping bit to the surface of the piece part and hold as in (fig. 2). This is zero position.
5. While holding the zero position, loosen the depth lock knob (F) counterclockwise (ccw) to release depth stop.
6. Lower or raise the depth stop to contact the stop plate (AA) to set the drill depth. Tighten lock knob (F) clockwise (cw).
7. Raise the drill or tapping bit off the piece part.
8. Position the spindle speed handles (L) to match the desired rpm setting as indicated on the speed selection chart (K). **DO NOT** change spindle RPM until the spindle has stopped completely.
9. Select either clockwise or counter-clockwise spindle rotation with selector switch (G). **DO NOT** change rotation direction until the spindle has stopped completely.
10. Verify that the chuck is clear of any entanglements and press start button (J) to begin spindle rotation.
11. Use the feed handle to start drilling or tapping.
12. While tapping, pause the spindle down-feed at the bottom of the operation to allow the breaking and reversal of rotation of the spindle. **DO NOT** change rotation direction until the spindle has stopped completely.

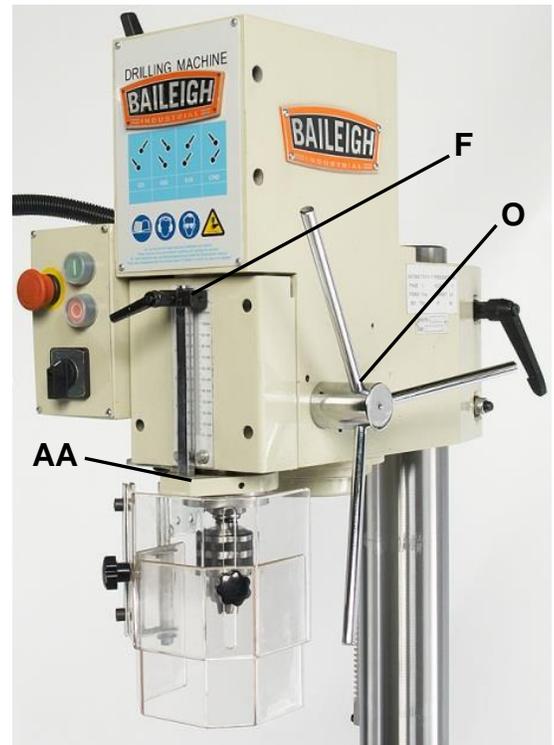


figure 1



figure 2



Note: In general, use low speeds for tapping. By tapping at high RPM there is a danger of damage to the piece part or the tooling. While tapping, the tool can be backed out at any time by stopping the spindle rotation and changing the selector switch (G).



13. At the end of a drilling or tapping operation, press the stop button (I) to turn **OFF** the machine.

In the event of incorrect operation or dangerous conditions, the machine can be stopped immediately by pressing the **E-STOP** button (H). Twist the button clockwise (**cw**) to reset.

MATERIAL SELECTION

 **CAUTION:** It must be determined by the customer that materials being processed through the machine are **NOT** potentially hazardous to operator or personnel working nearby.

When selecting materials keep these instructions in mind:

- Material must be clean and dry. (without oil)
- Material should have a smooth surface so it processes easily.
- Dimensional properties of material must be consistent and not exceed the machine capacity values.
- Chemical structure of material must be consistent.
- Buy certificated steel from the same vendor when possible.



LUBRICATION AND MAINTENANCE



WARNING: Make sure the electrical disconnect is OFF before working on the machine.

Maintenance should be performed on a regular basis by qualified personnel.

Always follow proper safety precautions when working on or around any machinery.

Daily Maintenance

- Inspect the power plug and cord.
- Keep area around machine clear of debris.
- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.

Weekly Maintenance

- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.
- On a weekly basis clean the machine and the area around it.

Monthly Maintenance

- Check that all screws on the motor and the guard are tight and secure.
- Check that the guard is operating properly.
- Grease the gear rack on the column so the table moves up and down smoothly.

Greasing the Machine

- Grease the gear rack on the column to keep the table moving smoothly.
- Lubricate the spline of the spindle and the teeth of the rack with a #2 grease.
- Fully extend the spindle and lightly grease the spindle shaft.

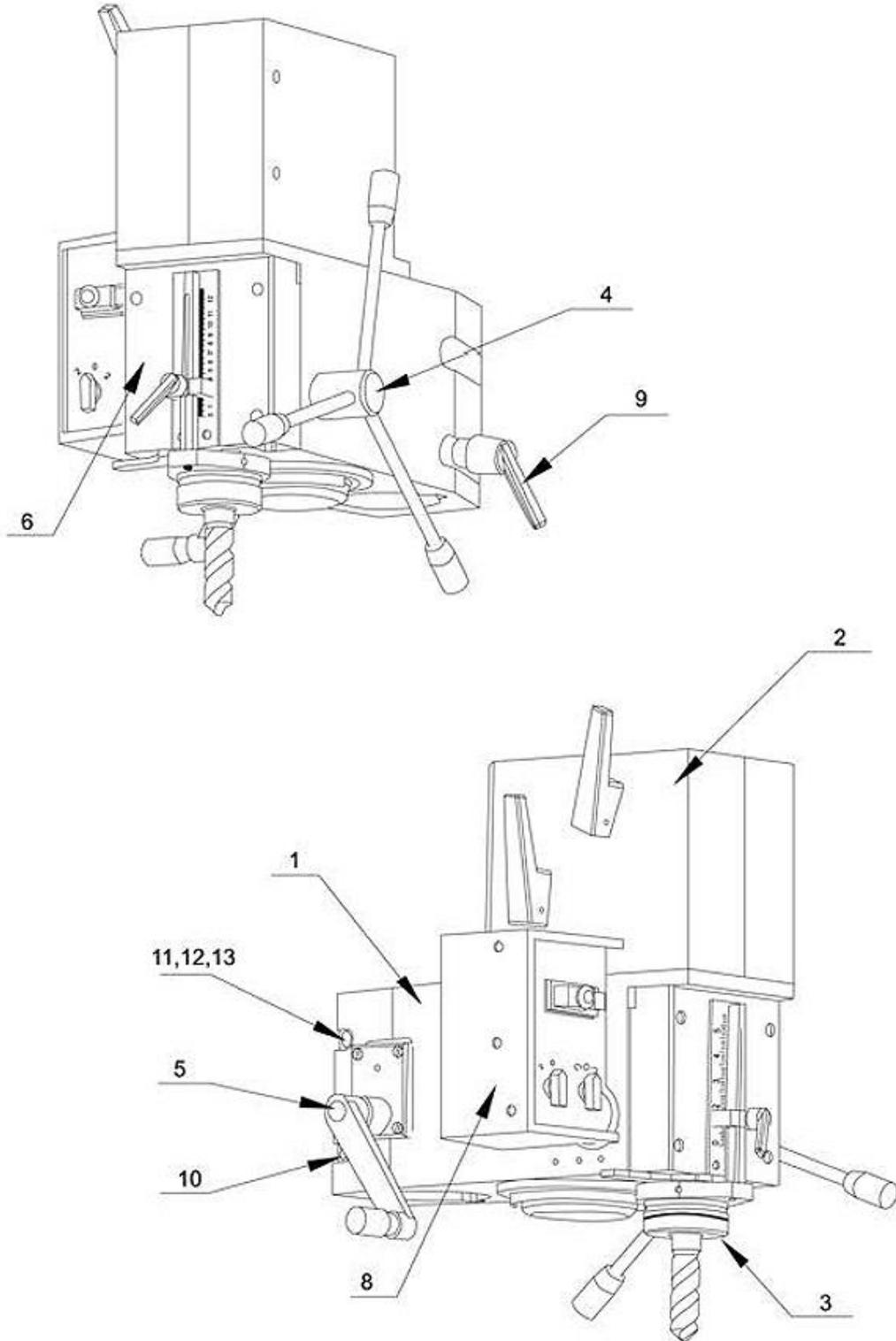
Storing Machine for Extended Period of Time

If the Drill Press is to be inactive for a long period of time, prepare the machine as follows:

- Detach the plug from the electrical supply panel.
- Clean and grease the machine.
- Cover the machine.



DRILL HEAD DIAGRAM – A



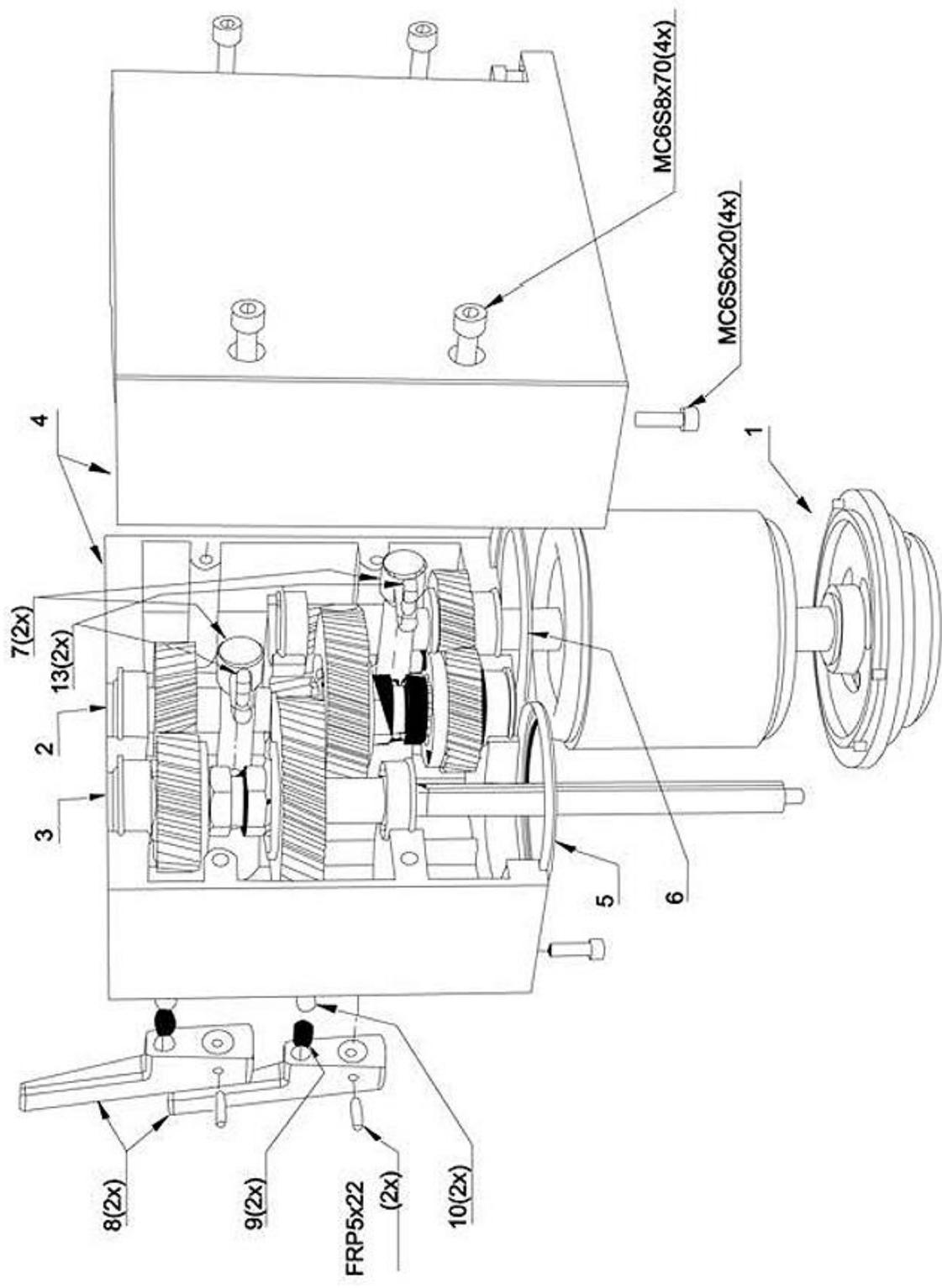


Drill Head Parts List – A

Item	Part No.	Ref. No.	Description
1	DP1000G-A1	2X08700	Spindle Housing
2	DP1000G-A2	2X08404	Gearbox
3	DP1000G-A-03	2X08719	Spindle Sleeve
4	DP1000G-A-04	2X08740-5	Feed Shaft Complete
5	DP1000G-WGBC	2X08720	Worm Gear Unit
6	DP1000G-A6	2X08702	Front Cover
8	DP1000G-A8	4U08705	Electric Box Cover
9	DP1000G-A-9	3R00014	Locking Lever
10	DP1000G-A10	3S02556	Screw M12x120
11	DP1000G-A11	3S02558	Screw M12x130
12	DP1000G-A12	3M09122	Locking Nut M12
13	DP1000G-A13	3B04178	Washer 13x24x4



GEARBOX DIAGRAM - B



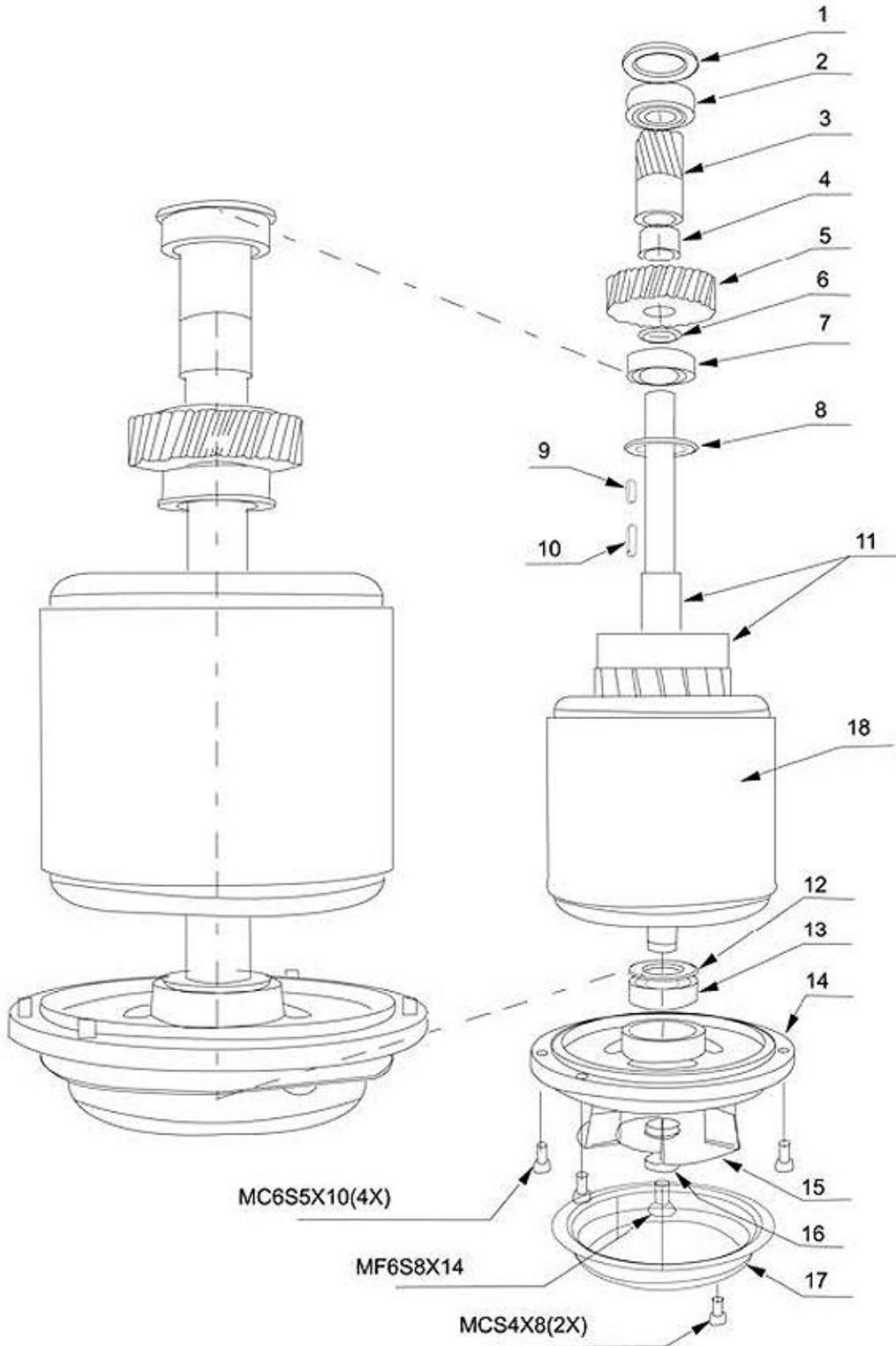


Gearbox Parts List – B

Item	Part No.	Ref. No.	Description
1	DP1000G-B1		Rotor shaft
2	DP1000G-B2	2X08404-2	2nd Shaft complete
3	DP1000G-B3	2X08404-3	3rd Shaft complete
4	DP1000G-B4	2X08422	Gear box complete
5	DP1000G-B5	4B00174	Ring
6	DP1000G-B6	4B00173	Ring
7	DP1000G-7-2X08536	2X08536	Gear selector arm
8	DP1000G-B8	4RS0653-1	Gear lever
9	DP1000G-B9	4C02921	Gear
10	DP1000G-B10	3T04028	Steel ball 8mm
13	DP1000G-13-4T04168	4T04168	Shift pin



ROTOR SHAFT DIAGRAM – C

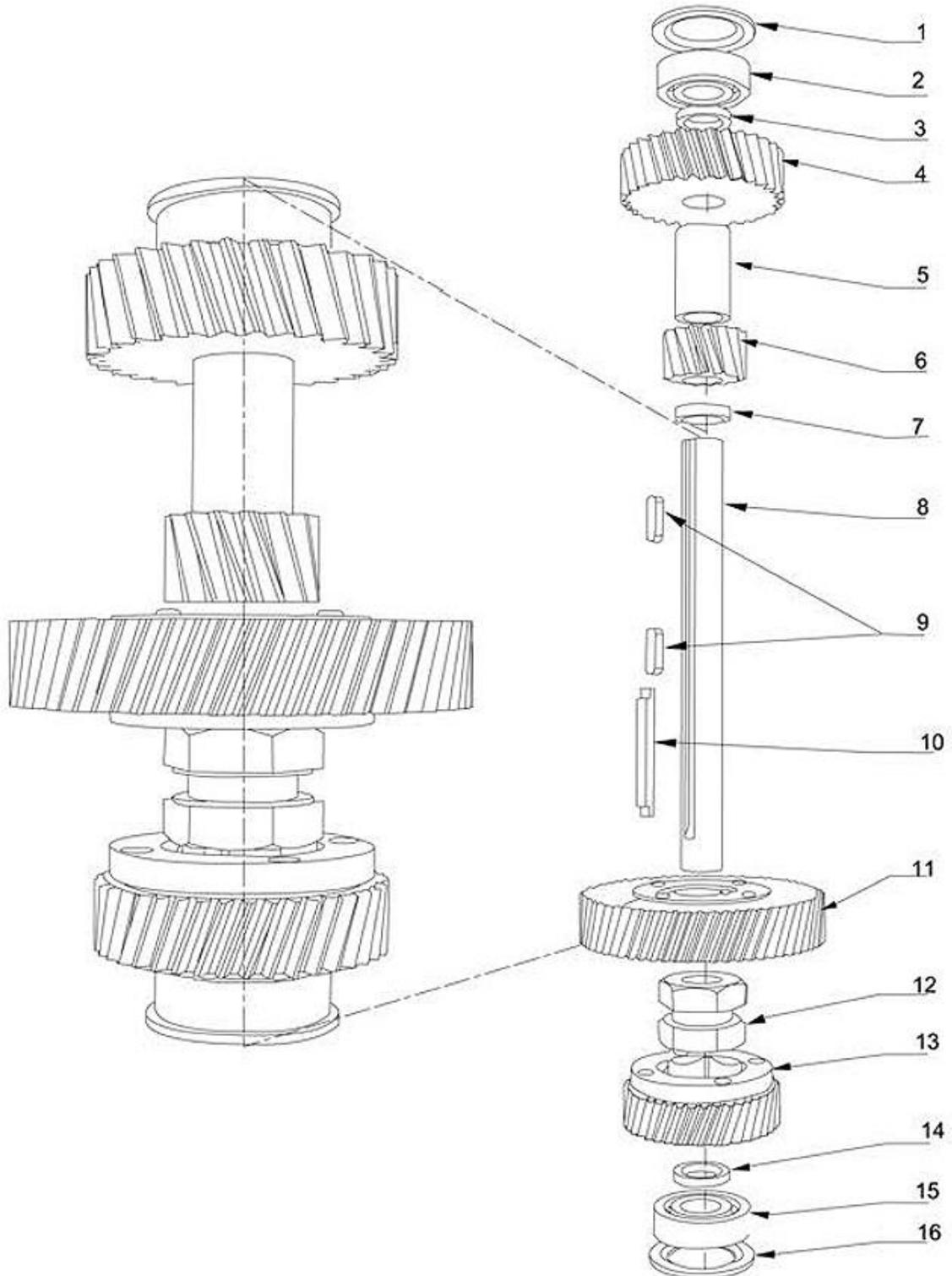




Rotor Shaft Parts List – C

Item	Part No.	Ref. No.	Description
1	DP1000G-C1	4B00137	Washer
2	DP1000G-C2	3L11003	Ball bearing 6203
3	DP1000G-C-3	2H07969	Gear 15-1, 5
4	DP1000G-C4	2D17014	Spacing sleeve 17x14
5	DP1000G-C5	2H07972	Gear 39-1, 5
6	DP1000G-C6	2D17002	Spacing sleeve 17x2
7	DP1000G-C7	3L11003	Ball bearing 6203
8	DP1000G-C8	4B00137	Washer
9	DP1000G-C9	3K00184	Key 5x5x14
10	DP1000G-C10	3K00187	Key 5x5x20
11	DP1000G-C-11	2X08405	Rotor Shaft
12	DP1000G-C12	4F06203	Washer FB 6203
13	DP1000G-C13	3L11003	Ball bearing 6203
14	DP1000G-C14	2N01889	Bearing cover B-1889
15	DP1000G-C15	4B00175	Fan B-175
16	DP1000G-C16	2B03449	Washer C-3449
17	DP1000G-C17	4B01890	Fan cover C-1890
18	DP1000G-C18	3E80103	Stator 80/2-4-70 380-440

2nd SHAFT DIAGRAM – D

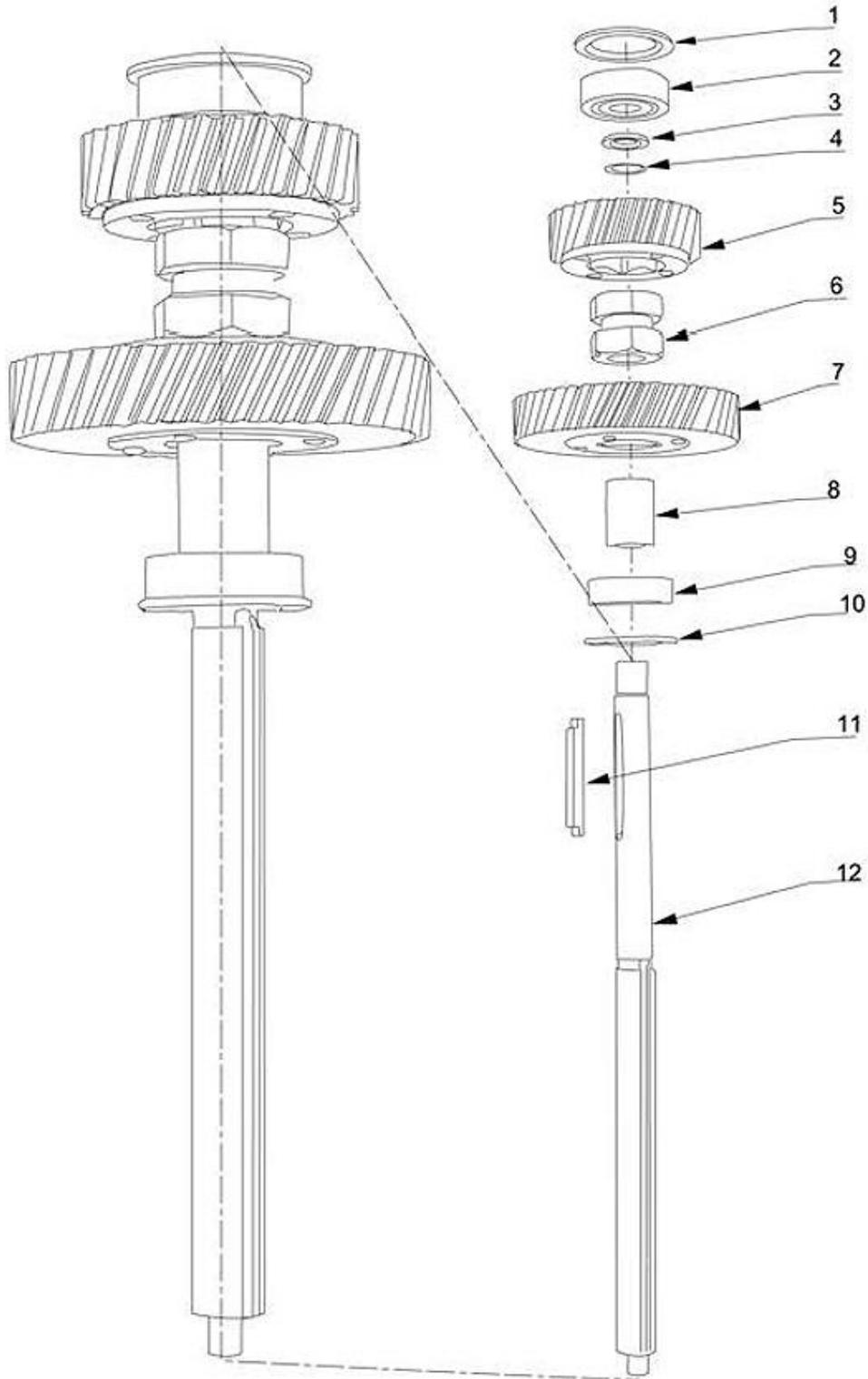




2nd Shaft Parts List – D

Item	Part No.	Ref. No.	Description
1	DP1000G-D1	4B00138	Washer C-138
2	DP1000G-D2	3L11003	Ball bearing 6203
3	DP1000G-D3	2D00009	Spacing sleeve 17x3, 5
4	DP1000G-2-4	2H07971	Gear 32-2
5	DP1000G-D5	2D17038	Spacing sleeve 17x38
6	DP1000G-2-6	2H07970	Gear 15-2
7	DP1000G-D7	2D17005	Spacing sleeve 17x5
8	DP1000G-D8	2A04871	2nd Shaft C-4871
9	DP1000G-D9	3K00187	Key 5x5x20
10	DP1000G-D10	2T06615	Key C-6615
11	DP1000G-2-11	2X08408	Gear Complete 64-1, 5
12	DP1000G-D12	2T04254	Clutch C-4254
13	DP1000G-D-13	2X08406	Gear complete 40-1, 5
14	DP1000G-D14	2D00009	Spacing sleeve 17x3, 5
15	DP1000G-D15	3L11003	Ball bearing 6203
16	DP1000G-D16	4B00138	Cover C-138

3rd SHAFT DIAGRAM – E



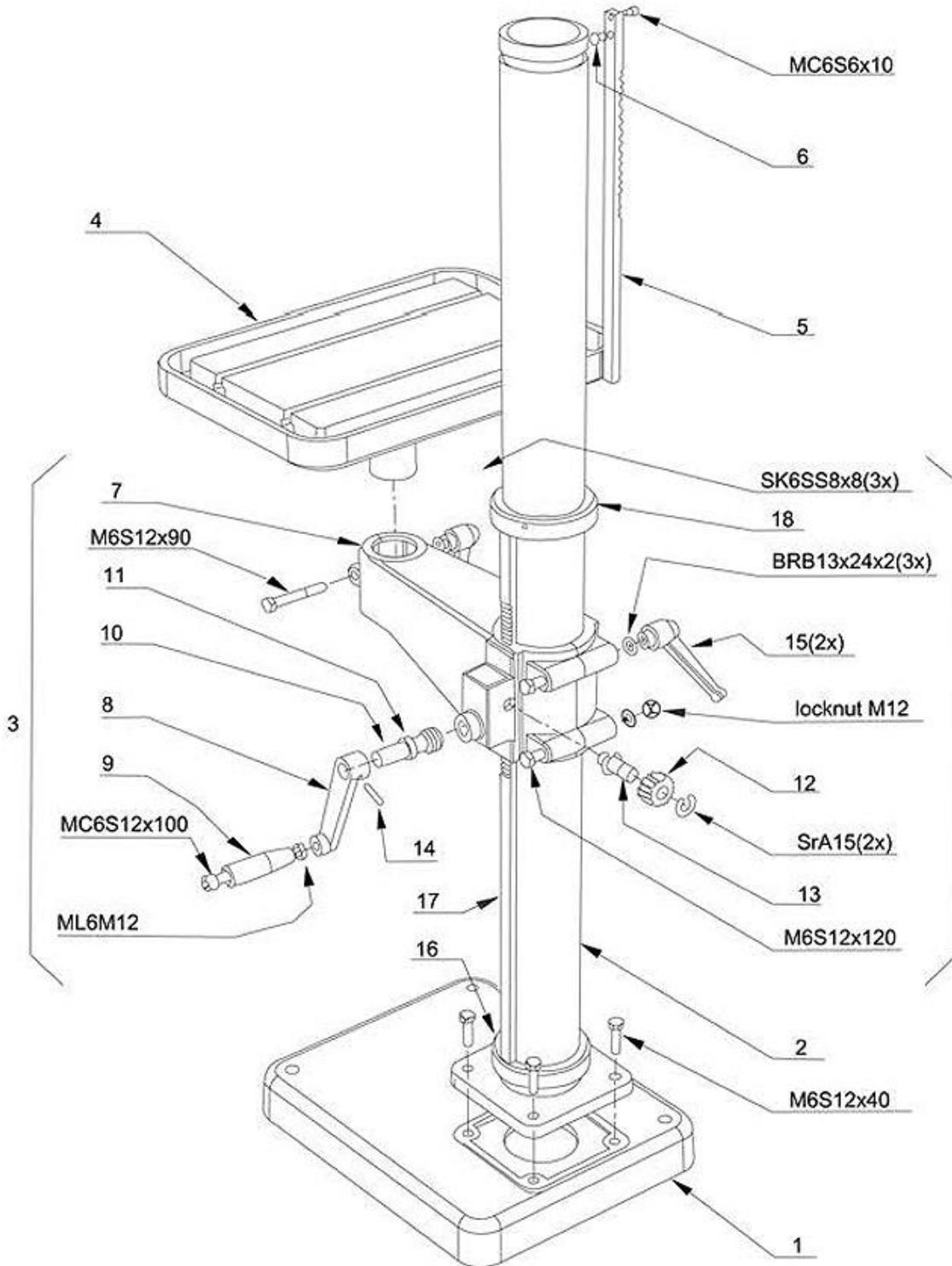


3rd Shaft Parts List – E

Item	Part No.	Ref. No.	Description
1	DP1000G-E1	4B00138	Cover C-138
2	DP1000G-E2	3L16002	Ball bearing 6302
3	DP1000G-E-3	3015002	Spacing sleeve 15x2
4	DP1000G-E4	3C01117	Circlip SgA 15
5	DP1000G-5-Gear	2X08413	Gear complete 32-2
6	DP1000G-E6	2T04254	Clutch C 4254
7	DP1000G-7	2X08411	Gear complete 49-2
8	DP1000G-E8	2000006	Spacing sleeve 17x31, 5
9	DP1000G-E9	3L11003	Ball bearing 6203
10	DP1000G-E10	4B00137	Cover C-137
11	DP1000G-E11	2T06615	Key C-6615
12	DP1000G-12	2A08410	3rd Shaft B-8410



COLUMN DIAGRAM – F



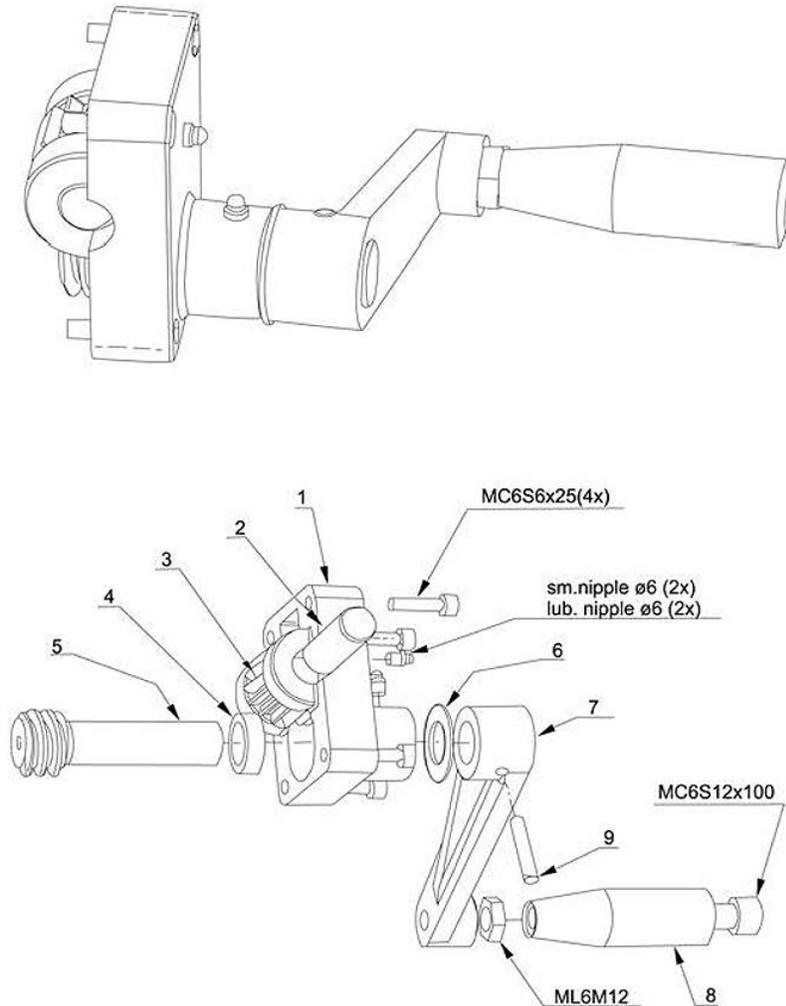


Column Parts List – F

Item	Part No.	Ref. No.	Description
1	DP1000G-F-1	2W07802	Base plate
2	DP1000G-F2	4X08300	Column L=1500
3	DP1000G-F3	2X08723	Table arm complete
4	DP1000G-F4	2WS1231	Table
5	DP1000G-Upper Column Rack	2X08445	Rack
6	DP1000G-F6	2T07146	Pin
7	DP1000G-F-7	2Y08723	Table arm
	DP1000G-F	2X08720-1	Worm gear complete
8	DP1000G-F8	2RS1182	Crank handle
9	DP1000G-F9	3RO1106	Handle
10	DP1000G-8	2IS1203	Worm shaft
11	DP1000G-11	2D20008	Spacer 20x8
12	DP1000G-12-Gear	2HS1201	Gear
13	DP1000G-13	2AS1202	Shaft
14	DP1000G-F14	3S04444	Stop screw SK6SS 8x8
15	DP1000G-F15	3R00014	Locking handle
16	DP1000G-F-16	2N00186	Lower ring
17	DP1000G-17	2103598	Rack
18	DP1000G-F-18	2N03668	Upper ring



WORM GEAR BOX COMPLETE DIAGRAM – G

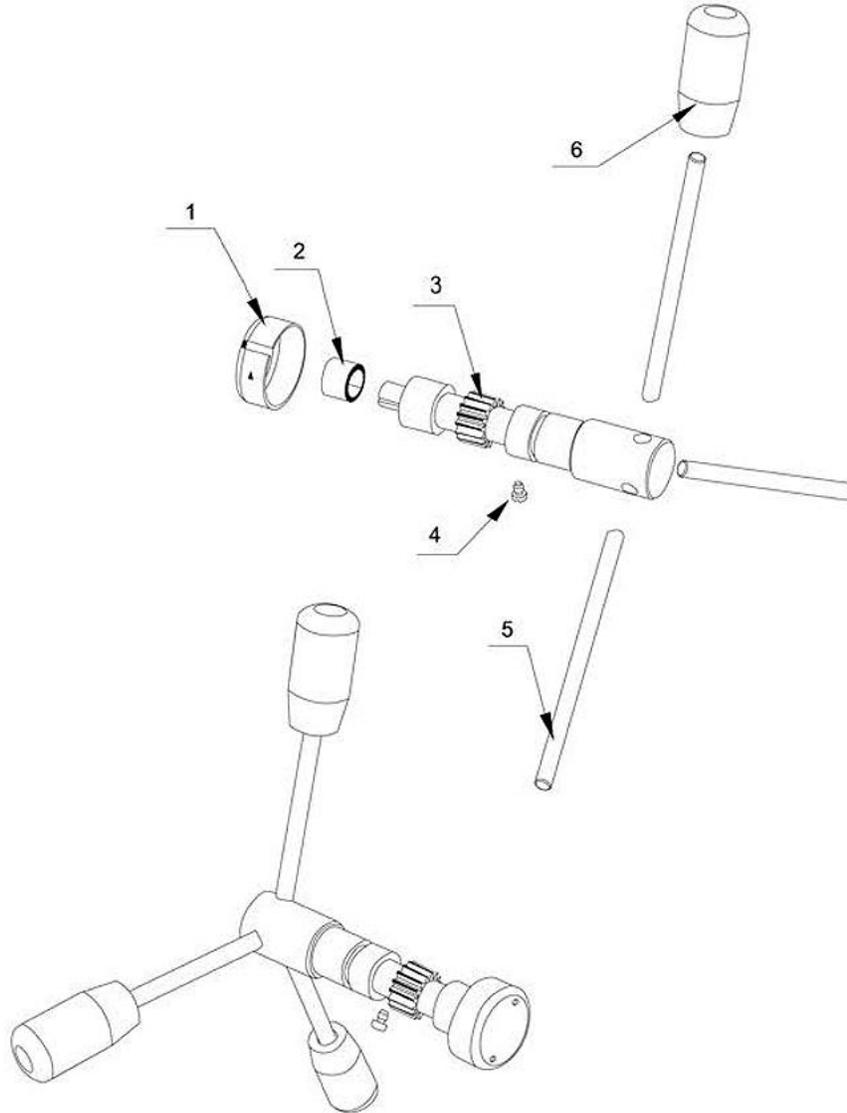


Worm Gear Box Complete Parts List – G

Item	Part No.	Ref. No.	Description
	DP1000G-G1-9	2X08720	Worm gear box Complete
1	DP1000G-G1	2N08720	Worm gear box
2	DP1000G-13	2AS1202	Shaft
3	DP1000G-12-Gear	2HS1201	Gear
4	DP1000G-11	2D20008	Spacer 20x8
5	DP1000G-10	2IS1203	Worm shaft
6	DP1000G-G6	3L00021	Washer
7	DP1000G-G7	2RS1182	Crank
8	DP1000G-G8	3RO1106	Handle
9	DP1000G-G-9	3S04444	Screw SK6SS 8x8



FEEDSHAFT DIAGRAM – H

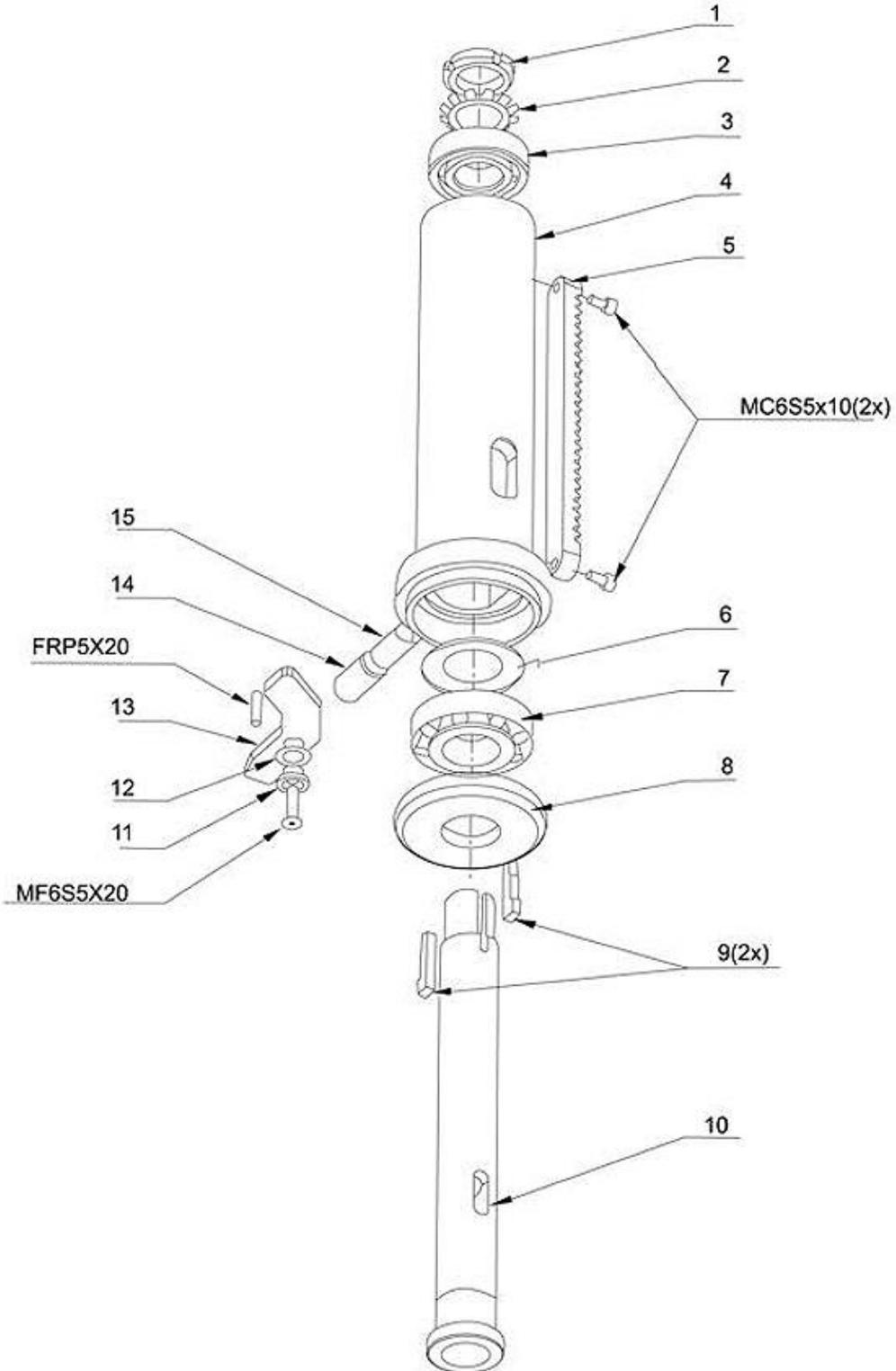


Feed Shaft Parts List – H

Item	Part No.	Ref. No.	Description
1	DP1000G-H1	4T08715	Spring housing
2	DP1000G-4C03026	4C03026	Clock Spring w/Housing
3	DP1000G-H3	2108708	Feed shaft
4	DP1000G-H-4	4S04211	Screw
5	DP1000G-H5	2E08722	Feed lever
6	DP1000G-H6	3R02003	Handle ball



SPINDLE SLEEVE DIAGRAM – I



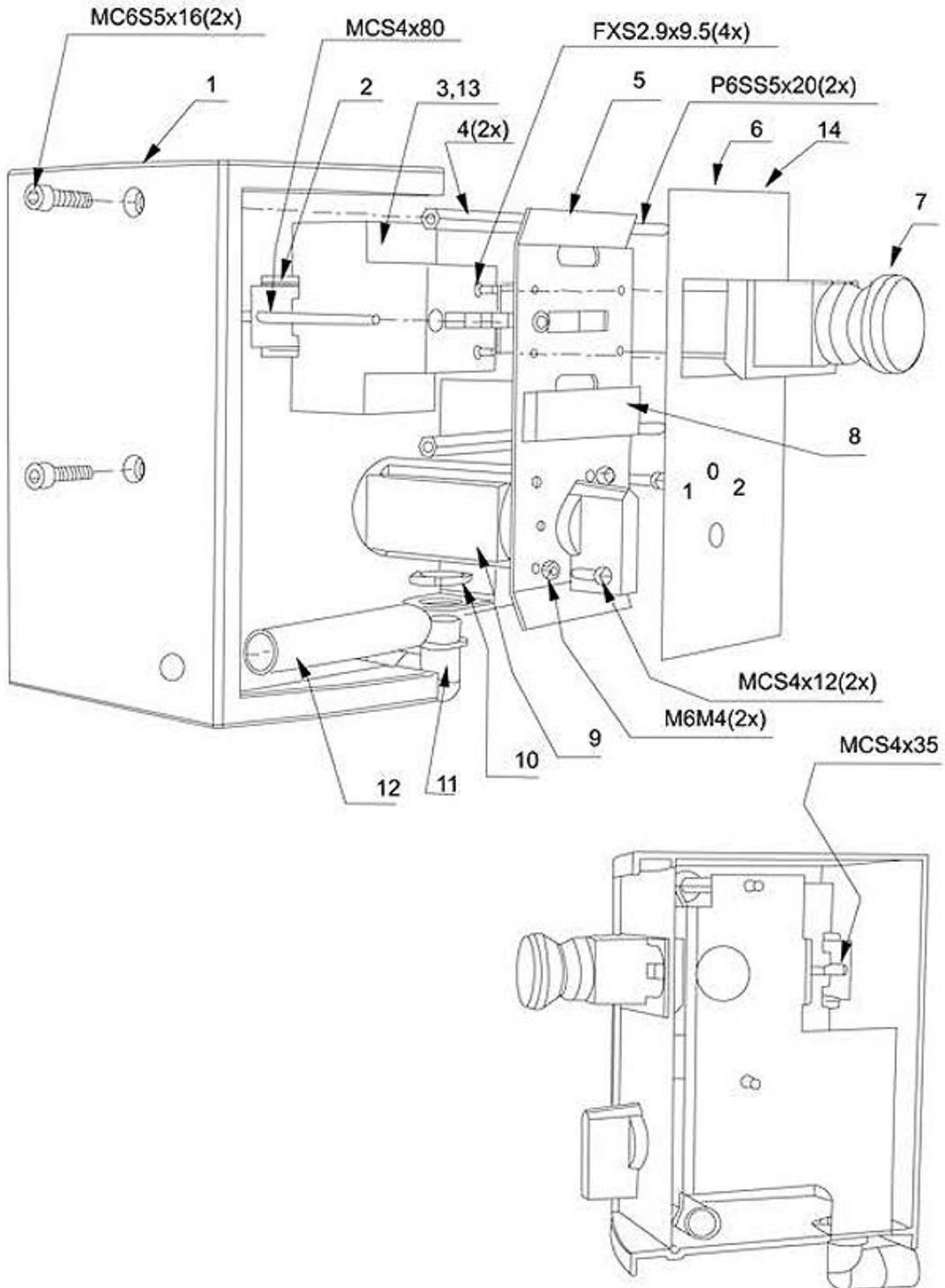


Spindle Sleeve Parts List – I

Item	Part No.	Ref. No.	Description
1	DP1000G-I1	3M06005	Nut MK5
2	DP1000G-I2	4B00155	Locking washer
3	DP1000G-I3	3L11005	Ball bearing 6205
4	DP1000G-I4	2G08709	Spindle sleeve
5	DP1000G-I5	2I08420	Rack
6	DP1000G-I6	4B03769	Washer
7	DP1000G-I7	3L51006	Taper roller bearing 30206
8	DP1000G-I8	2TS1106	Roller bearing cover
9	DP1000G-I9	2T08386	Key
10	DP1000G-I10	2A08418-1	Spindle
11	DP1000G-I11	2T08593	Spacing sleeve
12	DP1000G-I12	3B06003	Washer
13	DP1000G-I13	4T08547	Stop
14	DP1000G-I14	3S08622	Screw P6SS 16x25
15	DP1000G-I15	4T08714	Collet Jaw



ELECTRIC BOX DIAGRAM – J



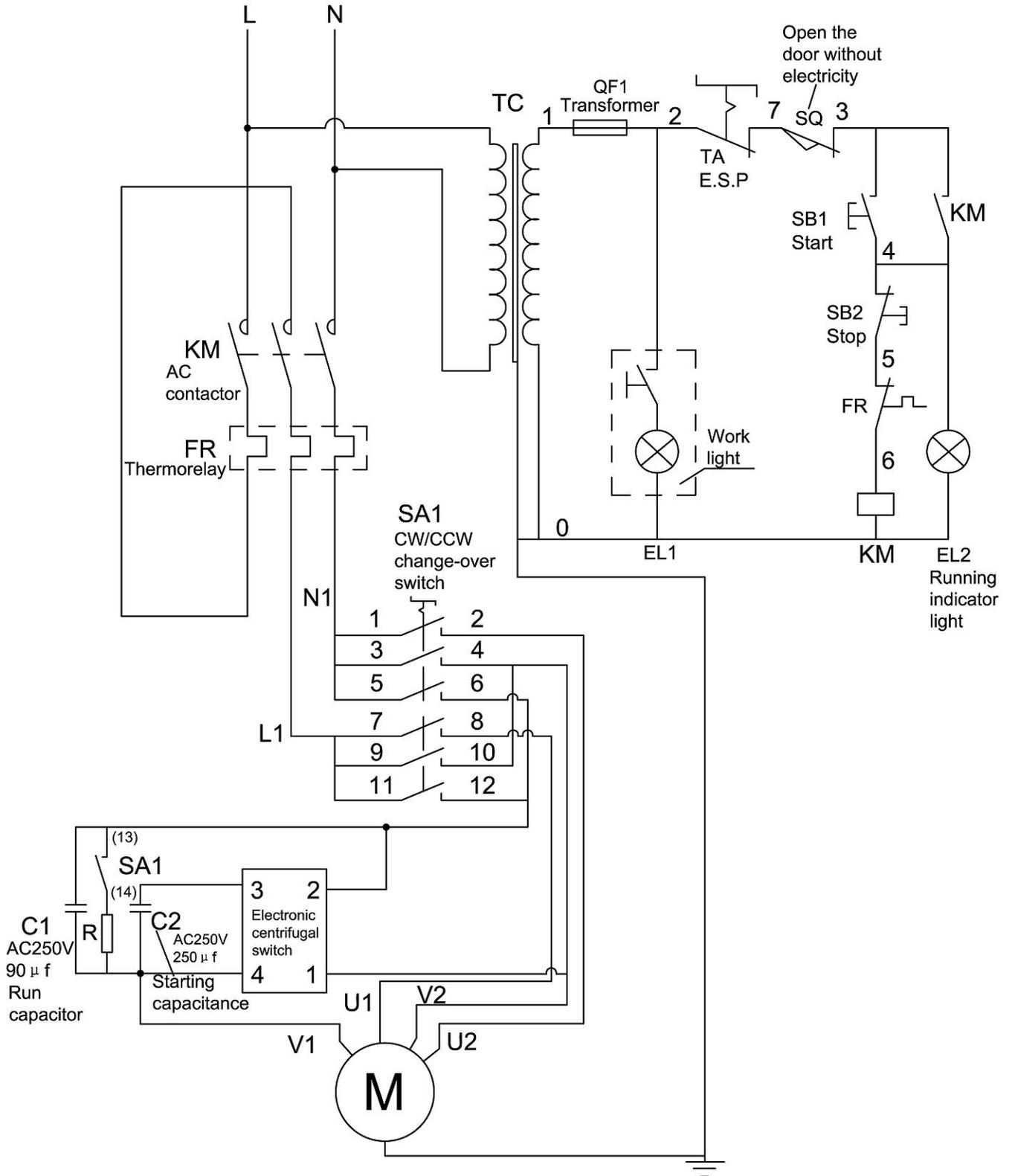


Electrical Box Parts List – J

Item	Part No.	Ref. No.	Description
1	DP1000G-J1	4U08705	Electric box cover
2	DP1000G-J2	2L08712	Rail anchor
3	DP1000G-J3	3E10604	Motor Protector 380/50
4	DP1000G-J4	2E08713	Electric box distance tube
5	DP1000G-J5	4L08706	Anchor plate
6	DP1000G-J6	4L08711-3	Electric box plate
7	DP1000G-J7	3E16227	Emergency stop
8	DP1000G-J8	3T18003	Rubber molding 15x8
9	DP1000G-J-9	3E06016	Pole reverser
10	DP1000G-J10	3E19088	Nut 1816
11	DP1000G-J11	3E19493	Angular nipple
12	DP1000G-J12	2T08735	Protection conduit
13	DP1000G-J13	3E10614	Under volt release
14	DP1000G-J14	4L08711-3	Electric box plate



ELECTRICAL SCHEMATIC





Item	Part No.	Description
KM	DP1000G-KM	Motor Contactor
FR	DP1000G-FR	Thermal Overload
TC	DP1000G-XFRMR	Transformer 60VA
TA	DP1500G-E Stop	Emergency Stop Button
SB1	DP1500VS-D-01	Push Button (Start)
SB2	DP1500VS-SB2	Push Button (Stop)
EL	DP1000G-Lamp	Work Lamp Assembly (no bulb)
	DP1000G-LED Bulb	LED Bulb
C1	DP1000G-Run Capacitor	Capacitor 90UF 250V. AC (49*102)
C2	DP1000G-Start Capacitor	Capacitor 250UF 250V. AC (50*105)
	DP1000G-Centrifugal Switch	Centrifugal Switch (Electric Style)
	DP1000G-J-9	Rotation Selector Switch



NOTES

BAILEIGH INDUSTRIAL HOLDINGS LLC
1625 DUFEK DRIVE MANITOWOC, WI 54220
PHONE: 920. 684. 4990 FAX: 920. 684. 3944
www.baileigh.com