

JET

**JDP-8BM
JDP-10BM
JDP-13FM
JDP-20FT**

DRILL PRESS

**GB
Operating Instructions**



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www.jettools.com

2017-12

**CE-Conformity Declaration
CE-Konformitätserklärung
Déclaration de Conformité CE**

Product / Produkt / Produit:

Drill Press
Säulenbohrmaschine Perceuse à
colonne

JDP-8BM/JDP-10BM/JDP-13FM/JDP-20FT

Brand / Marke / Marque:

JET

Manufacturer / Hersteller / Fabricant:

JPW (Tool) AG, Tämperlistrasse 5, CH-8117 Fällanden
Schweiz / Suisse / Switzerland

We hereby declare that this product complies with the regulations
Wir erklären hiermit, dass dieses Produkt der folgenden Richtlinie entspricht
Par la présente, nous déclarons que ce produit correspond aux directives suivantes

2006/42/EC

Machinery Directive
Maschinenrichtlinie Directive
Machines

2014/30/EU

electromagnetic compatibility
elektromagnetische Verträglichkeit
compatibilité électromagnétique

designed in consideration of the standards
und entsprechend folgender zusätzlicher Normen entwickelt wurde et été
développé dans le respect des normes complémentaires suivantes

EN ISO 12100:2010

EN 60204-1:2006+A1:2009+AC:2010

EN 61000-6-2:2007+A12011+AC2012

EN 61000-3-2:2014

EN 61000-3-3:2013

Responsible for the Documentation / Dokumentations-Verantwortung / Responsabilité de Documentation:

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2016-05-24 Alain Schmid, General Manager

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Schweiz / Suisse / Switzerland

General safety notes

Drill press can be dangerous if not used properly. Therefore the appropriate general technical rules as well as the following notes must be observed.



Read and understand the entire instruction manual before attempting assembly or operation.



Keep this operating instruction close by the machine, protected from dirt and humidity, and pass it over to the new owner if you part with the tool.

No changes to the machine may be made.

Daily inspect the function and existence of the safety appliances before you start the machine.

Do not attempt operation in this case, protect the machine by unplugging the mains cable.

Do not wear gloves while operating this machine. Remove all loose clothing and confine long hair.



Before operation the machine, remove tie, rings, watches, other jewelry, and roll up sleeves above the elbows.

Wear safety shoes; never wear leisure shoes or sandals.

Always wear the approved working outfit:

- Safety goggles
- Ear protection
- Dust protection



Install the machines so that there is sufficient space for safe operation and workpiece handling.

Keep work area well lighted.

The machine is designed to operate in closed rooms and must be placed stable on firm and levelled table surface.

Make sure that the power cord does not impede work and cause people to trip.

Keep the floor around the machine clean and free of scrap material, oil and grease.

Stay alert!

Give your work undivided attention.

Use common sense. Do not operate the machine when you are tired.

Keep an ergonomic body position.

Maintain a balanced stance at all times.

Do not operate the machine under the influence of drugs, alcohol or any medication. Be aware that medication can change your behavior.



Never reach into the machine while it is operating or running down.



Never leave a running machine unattended. Before you leave the workplace switch off the machine.

Keep children and visitors a safe distance from the work area.

Do not operate the electric tool near inflammable liquids or gases.

Observe the fire fighting and fire alert options, for example the fire extinguisher operation and place.

Do not use the machine in a damp environment and do not expose it to rain.

Metal dust is explosive and can also represent a risk to health.

Dust from some tropical woods in particular, and from hardwoods like beech and oak, is classified as a carcinogenic substance.

Always use a suitable dust collection device.

Before machining, remove any nails and other foreign bodies from the workpiece.

Make sure to guide and hold the chisel with both hands safe and tight during machining.

Work only with well sharpened tools.

Machine only stock which is chucked securely on the machine, always check before switching the machine on.

Provide workpieces with center holes before clamping between centers.

Work large and unbalanced workpieces at low spindle speed only. Workpieces with cracks may not be used.

Remove the chuck key or dowel pins before turning the machine on.

Always close the belt cover.

Specifications regarding the maximum or minimum size of the workpiece must be observed.

Test each set-up by revolving the work by hand to insure it clears the tool rest and bed. Check setup at the lowest speed before you increase to the operating speed.

Do not remove chips and workpiece parts until the machine is at a standstill.

Never stop workpiece with the hand during run out.

Do not attempt to engage the spindle lock pin until the spindle has stopped.

Never take measurement on a rotating workpiece.

Do not stand on the machine.

Connection and repair work on the electrical installation may be carried out by a qualified electrician only.



Have a damaged or worn power cord replaced immediately.

Make all machine adjustments or maintenance with the machine unplugged from the power source.



Operating Instructions

Dear Customer,

Many thanks for the confidence you have shown in us with the purchase of your new JET-machine. This manual has been prepared for the owner and operators of a **JET JDP-8BM / JDP-10BM / JDP-13FM / JDP-20FT drill press** to promote safety during installation, operation and maintenance procedures. Please read and understand the information contained in these operating instructions and the accompanying documents. To obtain maximum life and efficiency from your machine, and to use the machine safely, read this manual thoroughly and follow instructions carefully.

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1. Declaration of conformity

On our own responsibility we hereby declare that this product complies with the regulations* listed on page 2.

Designed in consideration with the standards**.

2. Warranty

The Seller guarantees that the supplied product is free from material defects and manufacturing faults. This warranty does not cover any defects which are caused, either directly or indirectly, by incorrect use, carelessness, accidental damage, repair, inadequate maintenance or cleaning and normal wear and tear.

Guarantee and/or warranty claims must be made within twelve months from the date of purchase (date of invoice). Any further claims shall be excluded.

This warranty includes all guarantee obligations of the Seller and replaces all previous declarations and agreements concerning warranties.

The warranty period is valid for eight hours of daily use. If this is exceeded, the warranty period shall be reduced in proportion to the excess use, but to no less than three months.

Returning rejected goods requires the prior express consent of the Seller and is at the Buyer's risk and expense.

Further warranty details can be found in the General Terms and Conditions (GTC). The GTC can be viewed at www.jettools.com or can be sent by post upon request.

The Seller reserves the right to make changes to the product and accessories at any time.

3. Safety

3.1 Authorized use

This drill press is designed for drilling wood and machinable metal and plastic materials only. Machining of other materials is not permitted and may be carried out in specific cases only after consulting with the manufacturer.

**Never cut magnesium-
high danger of fire!**

The workpiece must allow to safely be loaded and clamped for machining.

The proper use also includes compliance with the operating and maintenance instructions given in this manual.

The machine must be operated only by persons familiar with its operation and maintenance and who are familiar with its hazards.

The required minimum age must be observed.

The machine must only be used in a technically perfect condition.

When working on the machine, all safety mechanisms and covers must be mounted.

In addition to the safety requirements contained in these operating instructions and your country's applicable regulations, you should observe the generally recognized technical rules concerning the operation of wood- and metal-working machines.

Any other use exceeds authorization. In the event of unauthorized use of the machine, the manufacturer renounces all liability and the responsibility is transferred exclusively to the operator.

3.2 General safety notes

Wood and metalworking machines can be dangerous if not used properly. Therefore the appropriate general technical rules as well as the following notes must be observed.

Read and understand the entire instruction manual before attempting assembly or operation.

Keep this operating instruction close by the machine, protected from dirt and humidity, and pass it over to the new owner if you part with the tool.

No changes to the machine may be made.

Daily inspect the function and existence of the safety appliances before you start the machine. Do not attempt operation in this case, protect the machine by unplugging the power cord.

Remove all loose clothing and confine long hair.

Before operating the machine, remove tie, rings, watches, other jewellery, and roll up sleeves above the elbows.

Wear safety shoes; never wear leisure shoes or sandals.

Always wear the approved working outfit.

Do **not** wear gloves.

Wear goggles when working

Install the machine so that there is sufficient space for safe operation and workpiece handling.

Keep work area well lighted.

The machine is designed to operate in closed rooms and must be placed stable on a firm and levelled table surface.

Make sure that the power cord does not impede work and cause people to trip.

Keep the floor around the machine clean and free of scrap material, oil and grease.

Stay alert!

Give your work undivided attention. Use common sense. Do not operate the machine when you are tired.

Keep an ergonomic body position. Maintain a balanced stance at all times.

Do not operate the machine under the influence of drugs, alcohol or any medication. Be aware that medication can change your behaviour.

Never reach into the machine while it is operating or running down.

Never leave a running machine unattended.

Before you leave the workplace switch off the machine.

Keep children and visitors a safe distance from the work area.

Do not operate the electric tool near inflammable liquids or gases. Observe the fire fighting and fire alert options, for example the fire extinguisher operation and place.

Do not use the machine in a damp environment and do not expose it to rain.

Before machining, remove any nails and other foreign bodies from the workpiece.

Work only with well sharpened tools.

Machine only stock which rests securely on the table.

Always close the chuck guard and pulley cover before you start the machine.

Remove the chuck key and wrenches before machine operation.

Specifications regarding the maximum or minimum size of the workpiece must be observed.

Do not remove chips and workpiece parts until the machine is at a standstill.

Do not stand on the machine.

Connection and repair work on the electrical installation may be carried out by a qualified electrician only.

Have a damaged or worn power cord replaced immediately.

Make all machine adjustments or maintenance with the machine unplugged from the power source.

Never place your fingers in a position where they could contact the drill or other cutting tool if the work piece should unexpectedly shift or your hand should slip.

Secure workpiece against rotation. Use fixtures, clamps or a vice to hold the workpiece. Never hold the workpiece with your hands alone.

Whenever possible, position the work piece to contact the left side of the column. If it is too short or the table is tilted, clamp solidly to the table. Use the table slots or clamping ledge around the outside of the table.

When using a drill press vice, always fasten it to the table.

Never do any works "freehand" (hand-holding the work piece rather than supporting it on the table), except when polishing.

Securely lock the head to the column and the table bracket to the column before operating the press.

Never move the head or the table while the machine is running.

If a work piece overhangs the table such that it will fall or tip if not held, clamp it to the table or provide auxiliary support.

Do not use wire wheels, router bits, shaper cutters, circle cutters, or rotary planers on this drill press.

To avoid injury from parts thrown by the spring, follow instructions exactly as given when adjusting the spring tension of the quill.

To avoid injury from parts thrown by the spring, follow instructions exactly as given in chapter 7.5.

3.3 Remaining hazards

When using the machine according to regulations some remaining hazards may still exist.

The rotating drill bit can cause injury.

Thrown workpieces and workpiece parts can lead to injury.

Dust, chips and noise can be health hazards. Be sure to wear personal protection gear such as safety goggles and dust mask. Use a suitable dust collection system.

The use of incorrect mains supply or a damaged power cord can lead to injuries caused by electricity.

4. Machine specifications

4.1 Technical data

JDP-8BM

Spindle to column	102.5mm
Spindle travel	50mm
Spindle taper	B16
Chuck size	13mm
Column diameter	48mm
Table size	165 x 158 mm
Number of speeds	5
Range of speeds	550 - 2650 rpm

Dimensions	440x235x575mm
Weight	16 kg

Mains	230V ~1/N/PE 50Hz
Output power	0.10 kW (1/8HP) S1
Reference current	1.5 A
Extension cord (H05VV-F):	3x0.75mm ²

JDP-10BM

Spindle to column	125mm
Spindle travel	60mm
Spindle taper	MT2/B16
Chuck size	16mm
Column diameter	59.5mm
Table size	195 x 196 mm
Number of speeds	12
Range of speeds	250 - 2500 rpm

Dimensions 500x320x830mm
 Weight 39 kg
 Mains 230V ~1/N/PE 50Hz
 Output power 0.18 kW (1/4HP) S1
 Reference current 2 A
 Extension cord (H05VV-F): 3x0.75mm²

JDP-13FM

Spindle to column 168mm
 Spindle travel 80mm
 Spindle taper MT2/B16
 Chuck size 16mm
 Column diameter 73mm
 Table size Ø300mm
 Number of speeds 12
 Range of speeds 250 - 2500 rpm

Dimensions 630x400x1590mm
 Weight 55 kg

Mains 230V ~1/N/PE 50Hz
 Output power 0.375 kW (1/2 HP) S1
 Reference current 3 A
 Extension cord (H05VV-F): 3x0.75mm²

JDP-20FT:

Spindle to column 257mm
 Spindle travel 120mm
 Spindle taper MT-4/B16
 Chuck size 16mm
 Column diameter 92mm
 Table size 475 x 425 mm
 Overall height 1695 mm
 Number of speeds 12
 Range of speeds 70 - 1650 rpm

Dimensions 855x575x1695mm
 Weight 116 kg

Mains 400V ~3L/N/PE 50Hz
 Output power 0.50 kW (3/4 HP) S1
 Reference current 3 A
 Extension cord (H05VV-F): 5x0.75mm²

4.2 Noise emission

Acoustic pressure level (according to EN ISO 11202):
 Idling LpA 69,6 dB(A)
 In operation LpA 79,0 dB(A)

The specified values are emission levels and are not necessarily to be seen as safe operating levels. As workplace conditions vary, this information is intended to allow the user to make a better estimation of the hazards and risks involved only.

4.3 Content of delivery

Machine base
 Column and bracket assembly
 Head assembly
 Table
 Table bracket lock handle
 Table bracket rising handle
 3 downfeed handles
 16mm chuck
 Arbor
 Chuck guard
 Drift key
 Operating tools
 Assembly kit
 Operating manual
 Spare parts list.

5. Transport and start up

5.1 Transport and installation

The machine is designed to operate in closed rooms and must be placed stable on a firm and levelled table surface. The machine can be bolted down if required.

For packing reasons the machine is not completely assembled.

5.2 Assembly

If you notice transport damage while unpacking, notify your supplier immediately. Do not operate the machine!

Dispose of the packing in an environmentally friendly manner.

Clean all rust protected surfaces with a mild solvent.

Attach the column assembly (A, Fig 1) to the base (B) with four hex cap bolts (C).

Tighten firmly.

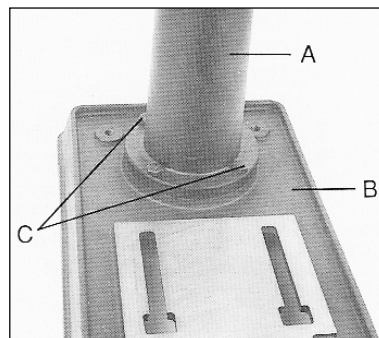


Fig 1

Thread the table bracket lock handle (A, Fig 2) into the table bracket (B).

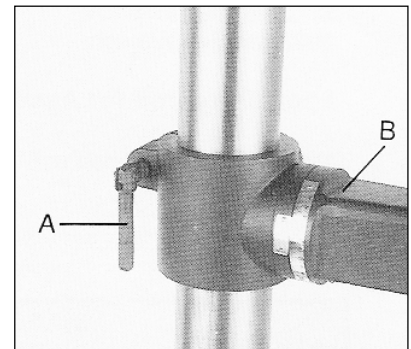


Fig 2

Slide the table bracket rising handle (B, Fig 3) onto the table bracket shaft.

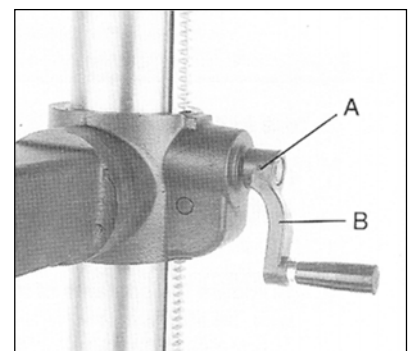


Fig 3

Turn the handle until the set screw is opposite the flat section on the shaft and tighten the set screw (A).

Insert the table into the table bracket.

Tighten the table lock handle.

With the aid of a second person, carefully lift the head onto the column top.

Caution:
The head assembly is heavy! Use care when lifting onto the column!

Rotate the head assembly until the sides of the belt cover are parallel with the sides of the base.

Tighten two set screws (A, Fig 4).

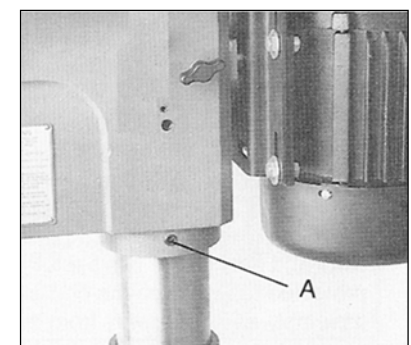


Fig 4

Install three down feed handles (A, Fig 5) into the down feed hub (B).

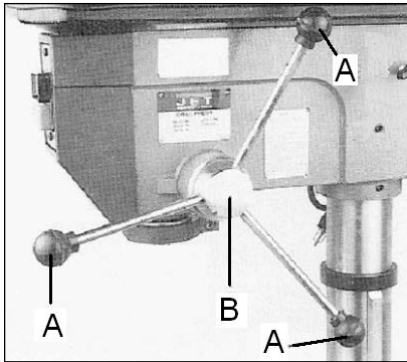


Fig 5

Chuck guard Assembly:

Remove knurled bolt (D, Fig 6)

Remove screw (A Fig 6),

Insert the chuck guard (B Fig 6),

Install screw (A Fig 6),

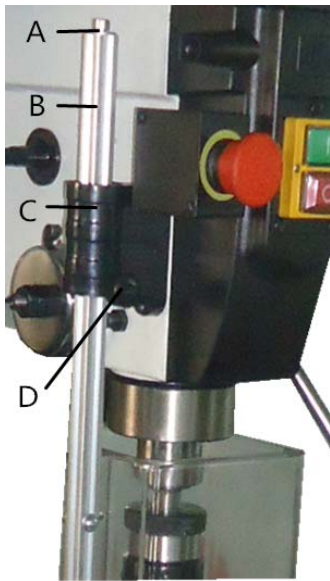


Fig 6

Install knurled bolt (D Fig 6).

Safety Note:

For machine operation, the chuck guard must always be closed and locked with screw (D).

Raise the table to approximately 200mm below the spindle assembly.

Lock the table.

Place a piece of scrap wood on the table.

Thoroughly clean the spindle opening, the arbor, and the chuck.

Important:

These three pieces must be free of any rust protection or lubricant. If they are not clean, the arbor and chuck will fail to seat in the spindle and will fall out.

Place the arbor into the chuck.

Twist the chuck to retract the chuck jaws if they are exposed.

Place the arbor and chuck assembly into the spindle.

Turn the arbor and chuck assembly until the tang on the arbor engages the slot at the end of the spindle.

Lower the down feed handle so that the chuck meets the scrap wood. Pressure on the down feed handle once the chuck meets the scrap wood seats the arbor and chuck into the spindle (see Fig 7).

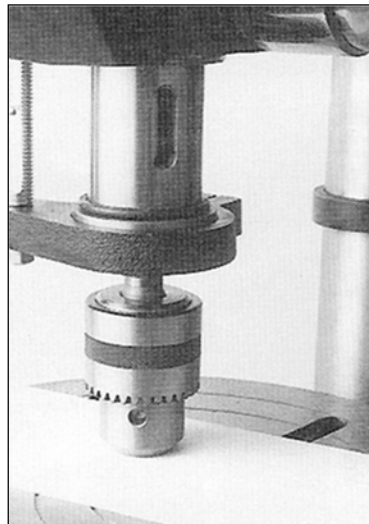


Fig 7

5.3 Mains connection

Mains connection and any extension cords used must comply with applicable regulations.

The mains voltage must comply with the information on the machine licence plate.

The mains connection must have a 10 A surge-proof fuse.

Only use power cords marked H07RN-F

Connections and repairs to the electrical equipment may only be carried out by qualified electricians.

5.4 Starting operation

You can start the machine with the green on button. The red button on the main switch stops the machine.

6. Machine operation

Always adjust the table and the depth stop to prevent drilling into the table. Use a back-up piece of scrap wood to cover the table. This protects both the table and the drill bit.

Secure workpiece to the table with clamps or a vice to prevent rotating with the drill bit.

Feed the bit into the material with only enough force to allow the drill bit to work. Feeding too slowly may cause burning of the workpiece. Feeding too quickly may cause the motor to stop and/or the drill bit to break.

Recommended speeds for a 10mm HSS drill:

Wood:	2000 RPM
Plastic:	1500 RPM
Aluminium:	1500 RPM
Brass:	1500 RPM
Cast iron:	1000 RPM
Mild steel:	800 RPM
High carbon steel:	600 RPM
Stainless steel:	300 RPM

Generally speaking, the smaller in relation the drill bit, the greater the RPM required.

Wood requires higher speeds than metal.

Metal is usually drilled at slower speeds; cutting oil is applied if necessary.

Warning:

Always keep your hands well clear of the rotating bit.

Do not remove chips and workpiece parts until the machine is at a standstill.

Always close the chuck guard and pulley cover before you start the machine.

When using a drill press vice, always fasten it to the table.

Never do any works "freehand" (hand-holding the work piece rather than supporting it on the table), except when polishing.

Support long workpieces with helping roller stands.

Do not use wire wheels, router bits, shaper cutters, circle cutters, or rotary planers on this drill press.

Never cut magnesium—high danger of fire!

7. Setup and adjustments

General note:

Setup and adjustment work may only be carried out after the machine is protected against accidental starting by pulling the mains plug.

7.1 Removing the Chuck and Arbor

Unplug the machine from the power source.

Lower the quill using the down feed handle.

Rotate the spindle to align the key in the spindle with the key hole in the quill.

Insert the drift key (A, Fig 8) into the aligned slots and tap lightly. Have another person (or a protected table) catch the chuck and arbor assembly as it falls away from the spindle.

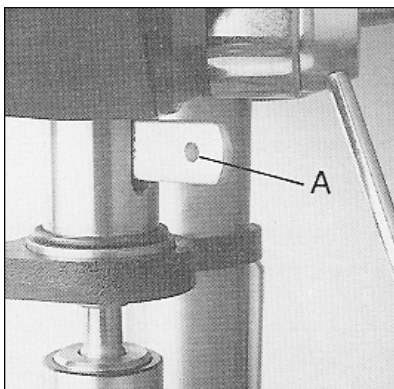


Fig 8

7.2 Adjusting the Depth Stop

To drill multiple holes at the same preset depth, use the depth stop:

With the drill bit in the chuck, lower the down feed handle to advance the chuck to the desired point.

Turn the depth scale collar (A, Fig. 9) counter-clockwise until it stops moving.

Tighten the depth scale lock (B).

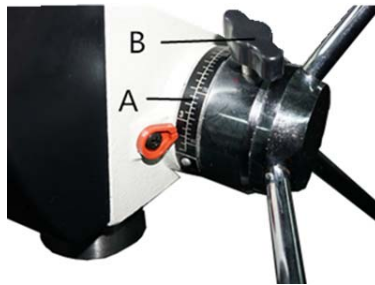


Fig 9

The drill bit will now advance only to this point.

To release, advance the nuts counterclockwise to the top of the depth stop.

7.3 Changing Spindle Speeds

Loosen the locking screw on the pulley cover, then open the cover.

A spindle speed and belt arrangement chart is found on the inside of the belt cover (A, Fig 10). Refer to this chart whenever changing speeds.

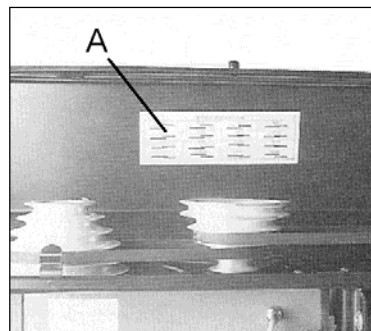


Fig 10

To change spindle speeds:

Unplug the machine from the power source.

Loosen two side bar bolts found on each side of the head assembly. (A, Fig 11).

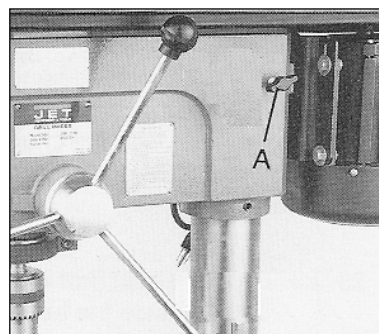


Fig 11

Bring the motor base as close to the head as possible.

Change the belts location according the speed chart and the speed you desire.

Tension the belt and tighten two slide bar bolts (A, Fig 11).

Belts are properly tensioned when finger and thumb pressure midway between the two pulleys causes approximately 10 mm deflection.

Close and lock the pulley cover.

7.4 Table Tilt Adjustment

Disconnect the machine from the power source (unplug).

Remove the alignment pin (B, Fig 12) first by turning the nut (A) clockwise.

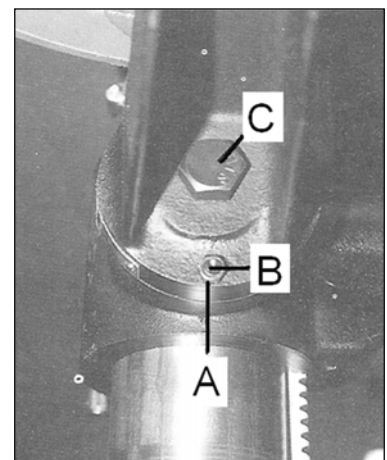


Fig 12

Loosen the hex cap bolt (C) to tilt the table.

Caution:

Only loosen the hex cap bolt slightly, otherwise the table assembly will separate from the column and fall.

Tighten the hex cap bolt.

The alignment pin only works at 90° and must be reinserted when the table is returned to 90°.

7.5 Return Spring Adjustment

Disconnect the machine from the power source (unplug).

The return spring is adjusted at the factory and should not need further adjustment. If adjustment is necessary:

Unplug the machine from the power source.

Loosen two lock nuts (A, Fig 13) approximately 6mm (do not remove).

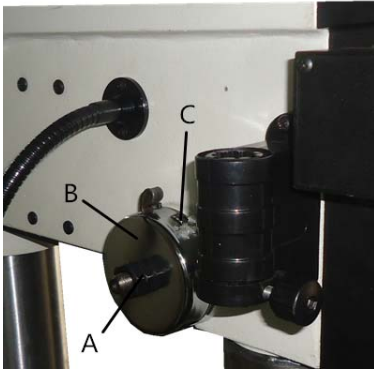


Fig 13

Firmly hold the coil spring cover (B).

Pull out the cover and rotate until the pin (C) on the return spring plate engages the next notch in the coil spring cover. Turn the cover clockwise to decrease tension and counter-clockwise to increase tension.

Tighten two lock nuts (A). Do not over-tighten. Nuts should not contact the housing when tight.

8. Maintenance and inspection

General notes:

Maintenance, cleaning and repair work may only be carried out after the machine is protected against accidental starting by pulling the mains plug.

Periodically lubricate gently with grease.

- the drive splines (grooves) in the spindle.
- the teeth of the quill.

Clean the machine regularly.

Defective safety devices must be replaced immediately.

Repair and maintenance work on the electrical system may only be carried out by a qualified electrician.

9. Trouble shooting

Motor doesn't start

- *No electricity-
check mains and fuse.
- *Defective switch, motor or cord-
consult an electrician.

Chuck will not stay on spindle

- *Oil or grease on contact surfaces-
clean the tapered surfaces of chuck and spindle.

Machine vibration

- *Incorrect belt tension-
Adjust belt tension.

*Dry spindle quill-
lubricate spindle quill.

*Spindle pulley loose-
tighten retaining nut.

*Motor pulley loose-
Tighten set screw.

*dull drill bit-
resharpen drill bit.

Drill bit burns

- *incorrect speed-
reduce speed.
- *Chips clogged-
retract drill bit frequently
- *dull drill bit-
resharpen drill bit.
- *feeding too slow-
feed faster.

Drill leads off

- *cutting lips or angle not equal-
resharpen drill bit correctly.
- *drilled hole off centre-
drill a pilot hole first.
- *bent drill bit-
use a proper drill bit.
- *drill bit not properly installed-
install drill bit correctly.

10. Environmental protection

Protect the environment.

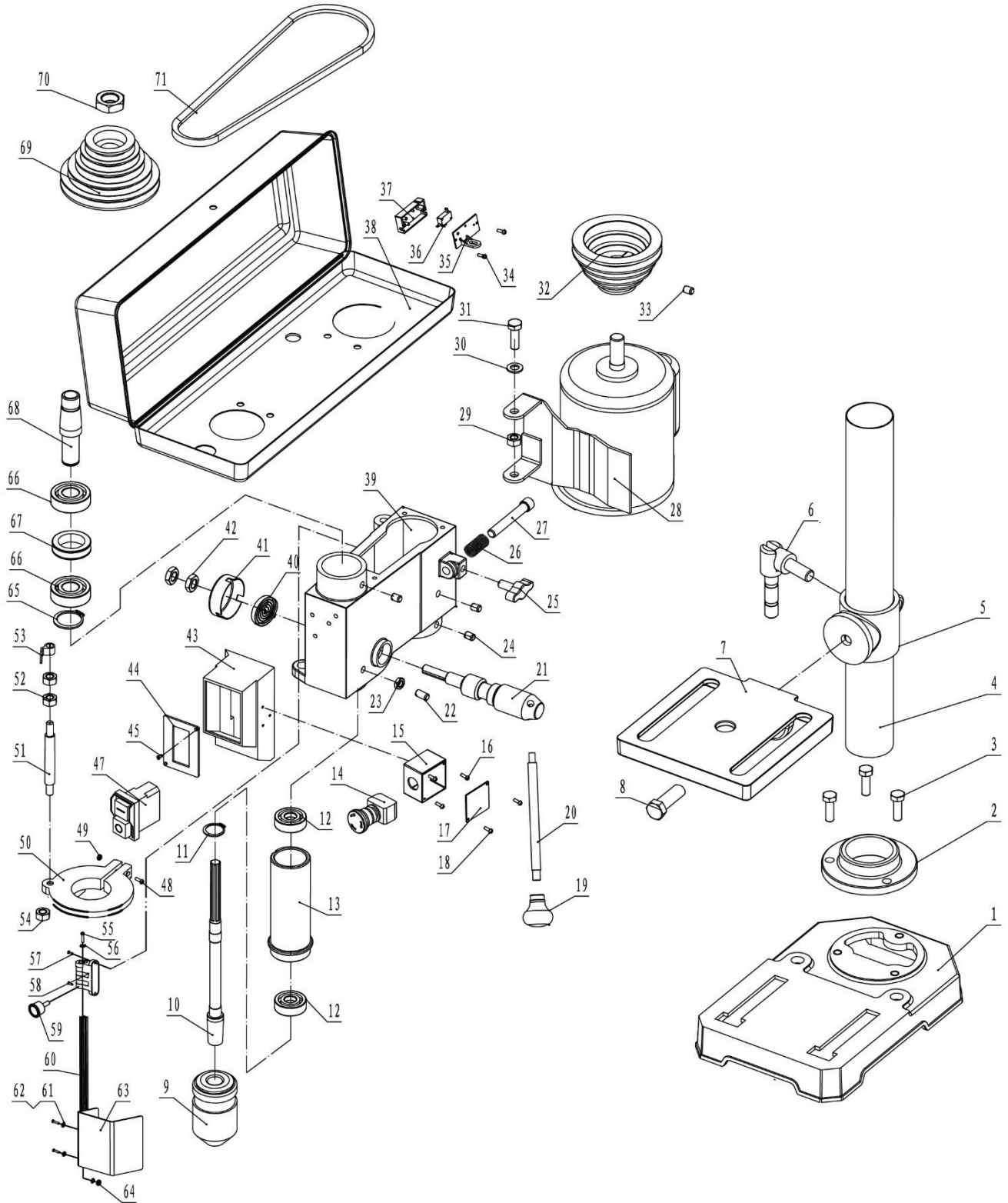
Your appliance contains valuable materials which can be recovered or recycled. Please leave it at a specialized institution.

11. Available accessories

Refer to the JET-Pricelist.

Replacement Parts

JDP-8BM Assembly Breakdown



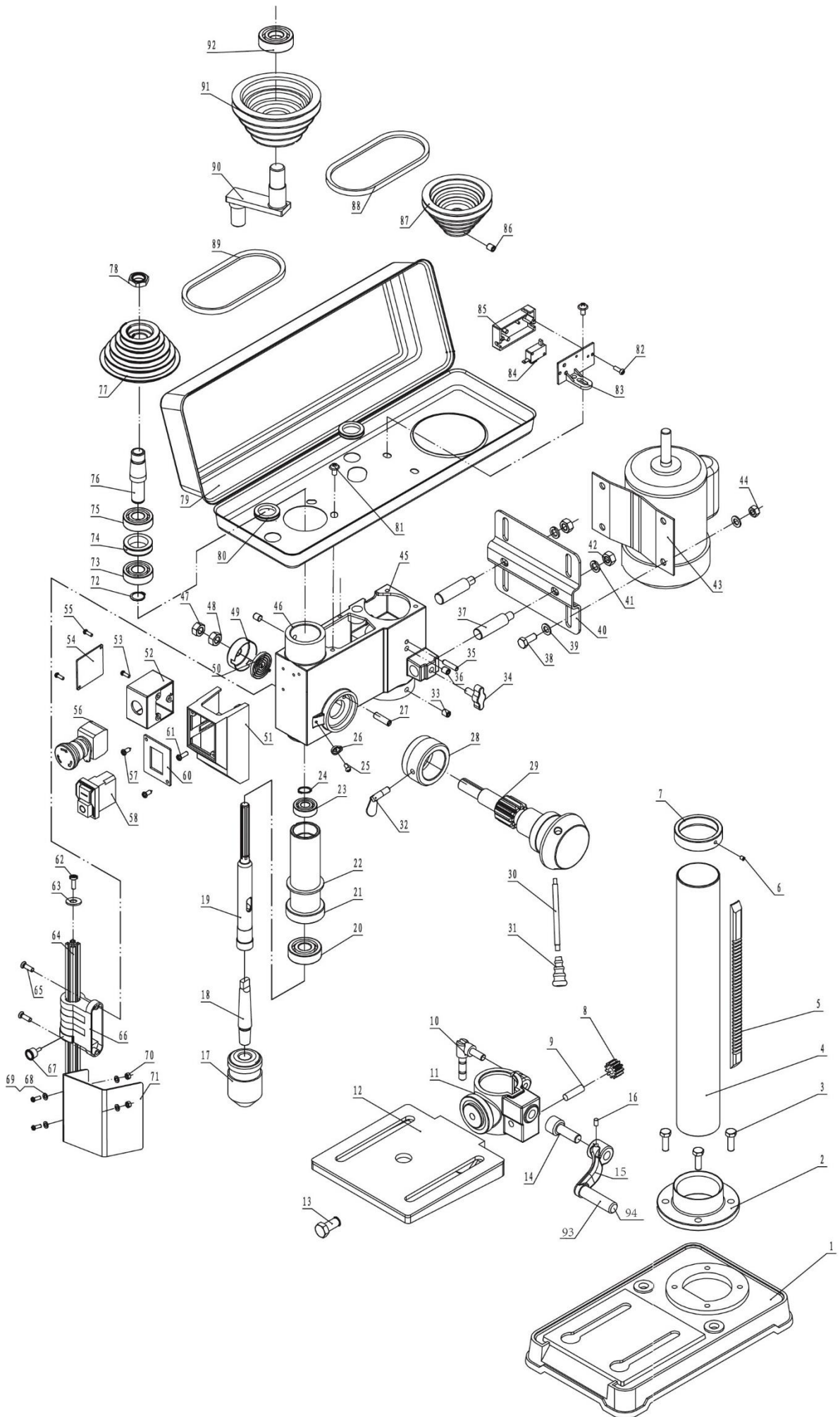
JDP-8BM Parts List for Breakdown (1/2)

Index No.	Part No.	Description	Size	Qty.
1	JDP8BM-001	Base		1
2	JDP8BM-002	Column support		1
3	JDP8BM-003	Hex Cap Screw	M8×20	3
4	JDP8BM-004	Column		1
5	JDP8BM-005	Support		1
6	JDP8BM-006	Lock handle		1
7	JDP8BM-007	Table		1
8	JDP8BM-008	Hex Cap Screw		1
9	JDP8BM-009	Chuck		1
10	JDP8BM-010	Spindle		1
11	JDP8BM-011	C-Clip	11	1
12	BB-6201ZZ	Ball Bearing	6201ZZ	2
13	JDP8BM-013	Quill		1
14	JDP8BM-014	Emergency Stop Switch		1
15	JDP8BM-015	Emergency Stop Switch Box		1
16	JDP8BM-016	Cross Pan Head Screw	M4×12	3
17	JDP8BM-017	E-Stop Switch Box Cover		1
18	JDP8BM-018	Tapping Screw	M3.5×9	2
19	JDP8BM-019	Grip		3
20	JDP8BM-020	Handle		3
21	JDP8BM-021	Handle Seat		1
22	JDP8BM-022	Screw		1
23	JDP8BM-023	Nut	M8	1
24	JDP8BM-024	Hex Socket Cap Screw	M8×8	3
25	JDP8BM-025	Locking Button		1
26	JDP8BM-026	support spring		1
27	JDP8BM-027	Tighting Pin		1
28	JDP8BM-028	Motor		1
29	JDP8BM-029	Nut-Lock	M8	2
30	JDP8BM-030	Washer	8	4
31	JDP8BM-031	Screw-Hex	M8×25	2
32	JDP8BM-032	Motor Pulley		1
33	JDP8BM-033	Hex Socket Cap Screw	M6×10	1
34	JDP8BM-034	Tapping Screw	M3.5×13	2
35	JDP8BM-035	Micro Switch Box Cover		1
36	JDP8BM-036	Micro Switch		1
37	JDP8BM-037	Micro Switch Box		1
38	JDP8BM-038	Pulley Cover Assy		1
39	JDP8BM-039	Head		1
40	JDP8BM-040	Coil Spring		1
41	JDP8BM-041	Spring Cap		1
42	JDP8BM-042	Nut	3/8" 24TPI	2
43	JDP8BM-043	Switch Box		1
44	JDP8BM-044	Switch Plate		1
45	JDP8BM-045	Cross Pan Head Screw	M5×12	4
47	JDP8BM-047	Electromagnetic Switch		1
48	JDP8BM-048	Cross Pan Head Screw	M6×25	1
49	JDP8BM-049	Nut	M6	1
50	JDP8BM-050	Set Ring		1
51	JDP8BM-051	Scale Bolt		1
52	JDP8BM-052	Nut	M10	2
53	JDP8BM-053	Pointer		1
54	JDP8BM-054	Nut	M6	1
55	JDP8BM-055	Hex Socket Cap Screw	M6×8	1
56	JDP8BM-056	Washer	6	1
57	JDP8BM-057	Cross Pan Head Screw	M5×16	2
58	JDP8BM-058	Chuck Guard Micro Switch Assy		1

JDP-8BM Parts List for Breakdown (2/2)

Index No.	Part No.	Description	Size	Qty.
59	JDP8BM-059	Shifter Bolt		2
60	JDP8BM-060	Chuck Guard Rod		1
61	JDP8BM-061	Cross Pan Head Screw	M5x40	3
62	JDP8BM-062	Washer	5	4
63	JDP8BM-063	Chuck Guard		1
64	JDP8BM-064	Nut	M5	1
65	JDP8BM-065	C-Clip	17	1
66	BB-6203ZZ	Bearing	6203ZZ	2
67	JDP8BM-067	Spacer		1
68	JDP8BM-068	Driving Sleeve		1
69	JDP8BM-069	Spindle Pulley		1
70	JDP8BM-070	Pulley Set nut		1
71	JDP8BM-071	V-Belt		1
	JDP8BM-072	Tilt Scale (Not show)		1
	JDP8BM-073	Depth Scale (Not show)		1
	JDP8BM-074	Rivet (Not show)	2.5x5	2
	JDP8BM-075	Rubber sleeve (Not show)		1

JDP-10BM Assembly Breakdown



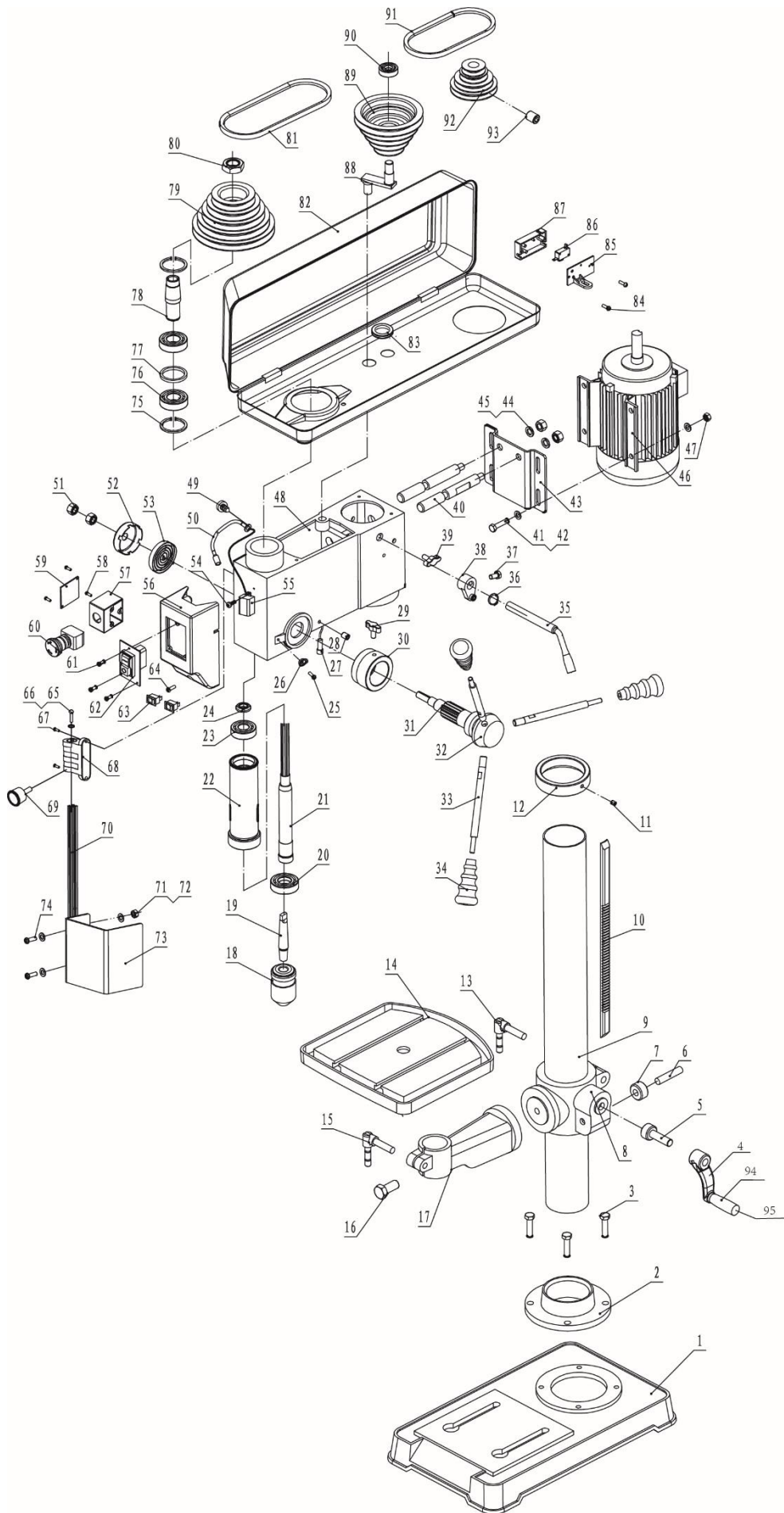
JDP-10BM Parts List for Breakdown (1/2)

Index No.	Part No.	Description	Size	Qty.
1	JDP10BM-001	Base		1
2	JDP10BM-002	Column support		1
3	JDP10BM-003	Hex Cap Screw	M8×20	4
4	JDP10BM-004	Column		1
5	JDP10BM-005	Rack		1
6	JDP10BM-006	Hex Socket Cap Screw	M6×10	1
7	JDP10BM-007	Rack Collar		1
8	JDP10BM-008	Helical Gear		1
9	JDP10BM-009	Gear Pin		1
10	JDP10BM-010	Column Lock Handle		1
11	JDP10BM-011	Table Support		1
12	JDP10BM-012	Table		1
13	JDP10BM-013	Hex Cap Screw	M12×25	1
14	JDP10BM-014	Worm Shaft		1
15	JDP10BM-015	Crank Arm Shaft		1
16	JDP10BM-016	Hex Socket Cap Screw	M6×10	1
17	JDP10BM-017	Chuck		1
18	JDP10BM-018	Arbor		1
19	JDP10BM-019	Spindle		1
20	BB-6204ZZ	Ball Bearing	6204ZZ	1
21	JDP10BM-021	Quill		1
22	JDP10BM-022	Rubber Washer		1
23	BB-6201ZZ	Ball Bearing	6201ZZ	1
24	JDP10BM-024	C-Clip		1
25	JDP10BM-025	Cross Pan Head Screw	M4×8	1
26	JDP10BM-026	Indicator		1
27	JDP10BM-027	Stop Screw		1
28	JDP10BM-028	Ring Depth Stop		1
29	JDP10BM-029	Pinion Shaft / Hub		1
30	JDP10BM-030	Handle		1
31	JDP10BM-031	Grip		1
32	JDP10BM-032	locking button		1
33	JDP10BM-033	Hex Socket Cap Screw	M8×8	3
34	JDP10BM-034	Locking Button		1
35	JDP10BM-035	Pin	6×16	1
36	JDP10BM-036	Hex Socket Cap Screw	M8×8	1
37	JDP10BM-037	Motor Rod		2
38	JDP10BM-038	Hex Cap Screw	M8×20	4
39	JDP10BM-039	Washer	8	8
40	JDP10BM-040	Motor Base		1
41	JDP10BM-041	Lock washer	10	8
42	JDP10BM-042	Nut	M10	2
43	JDP10BM-043	Motor		1
44	JDP10BM-044	Nut	M8	4
45	JDP10BM-045	Head		1
46	JDP10BM-046	Hex Socket Cap Screw	M8×8	1
47	JDP10BM-047	Nut		1
48	JDP10BM-048	Nut		1
49	JDP10BM-049	Spring Cap		1
50	JDP10BM-050	Coil Spring		1
51	JDP10BM-051	Switch Box		1
52	JDP10BM-052	Emergency stop switch box		1
53	JDP10BM-053	Cross Pan Head Screw	M4×12	3
54	JDP10BM-054	E-Stop Switch Box Cover		1
55	JDP10BM-055	Tapping Screw	M3.5×13	2
56	JDP10BM-056	Emergency Stop Switch		1

JDP-10BM Parts List for Breakdown (2/2)

Index No.	Part No.	Description	Size	Qty.
57	JDP10BM-057	Tapping Screw	M4.2x9	2
58	JDP10BM-058	Electromagnetic Switch		1
60	JDP10BM-060	Switch Plate		1
61	JDP10BM-061	Cross Pan Head Screw	M5x12	4
62	JDP10BM-062	Hex Socket Cap Screw	M6x8	1
63	JDP10BM-063	Washer	6	3
64	JDP10BM-064	Chuck Guard Rod		1
65	JDP10BM-065	Cross Pan Head Screw	M5x16	2
66	JDP10BM-066	Chuck Guard Micro Switch Assy		2
67	JDP10BM-067	Shifter Bolt		1
68	JDP10BM-068	Washer	5	4
69	JDP10BM-069	Cross Pan Head Screw	M5x40	2
70	JDP10BM-070	Nut	M5	2
71	JDP10BM-071	Chuck Guard		1
72	JDP10BM-072	C-Clip	17	1
73	BB-6203ZZ	Ball Bearing	6203ZZ	1
74	JDP10BM-074	Spacer		1
75	BB-6203ZZ	Ball Bearing	6203ZZ	1
76	JDP10BM-076	Insert Pulley		1
77	JDP10BM-077	Spindle Pulley		1
78	JDP10BM-078	Pulley Set nut		1
79	JDP10BM-079	Pulley Cover Assy		2
80	JDP10BM-080	Strain Relief		2
81	JDP10BM-081	Pan Head Screw	M6x12	4
82	JDP10BM-082	Tapping Screw	M3.5x13	2
83	JDP10BM-083	Micro Switch Box Cover		1
84	JDP10BM-084	Micro Switch		1
85	JDP10BM-085	Micro Switch Box		1
86	JDP10BM-086	Hex Socket Cap Screw	M6x10	1
87	JDP10BM-087	Motor Pulley		1
88	JDP10BM-088	V-Belt	M-20	1
89	JDP10BM-089	V-Belt	M-20	1
90	JDP10BM-090	Center Pulley Shaft		1
91	JDP10BM-091	Center Pulley		1
92	JDP10BM-092	Ball Bearing	6203ZZ	1
93	JDP10BM-093	Crank Arm Handle Grip		1
94	JDP1BM0-094	Crank Arm Handle Shaft		1
	JDP10BM-095	Scale Indicator (Not show)		1
	JDP10BM-096	Rivet (Not show)	2.5x5	5
	JDP10BM-097	Tilt Scale (Not show)		1
	JDP10BM-098	Depth Scale (Not show)		1
	JDP10BM-099	Rubber sleeve (Not show)		1
	JDP10BM-100	Rubber sleeve (Not show)		1

JDP-13FM Assembly Breakdown



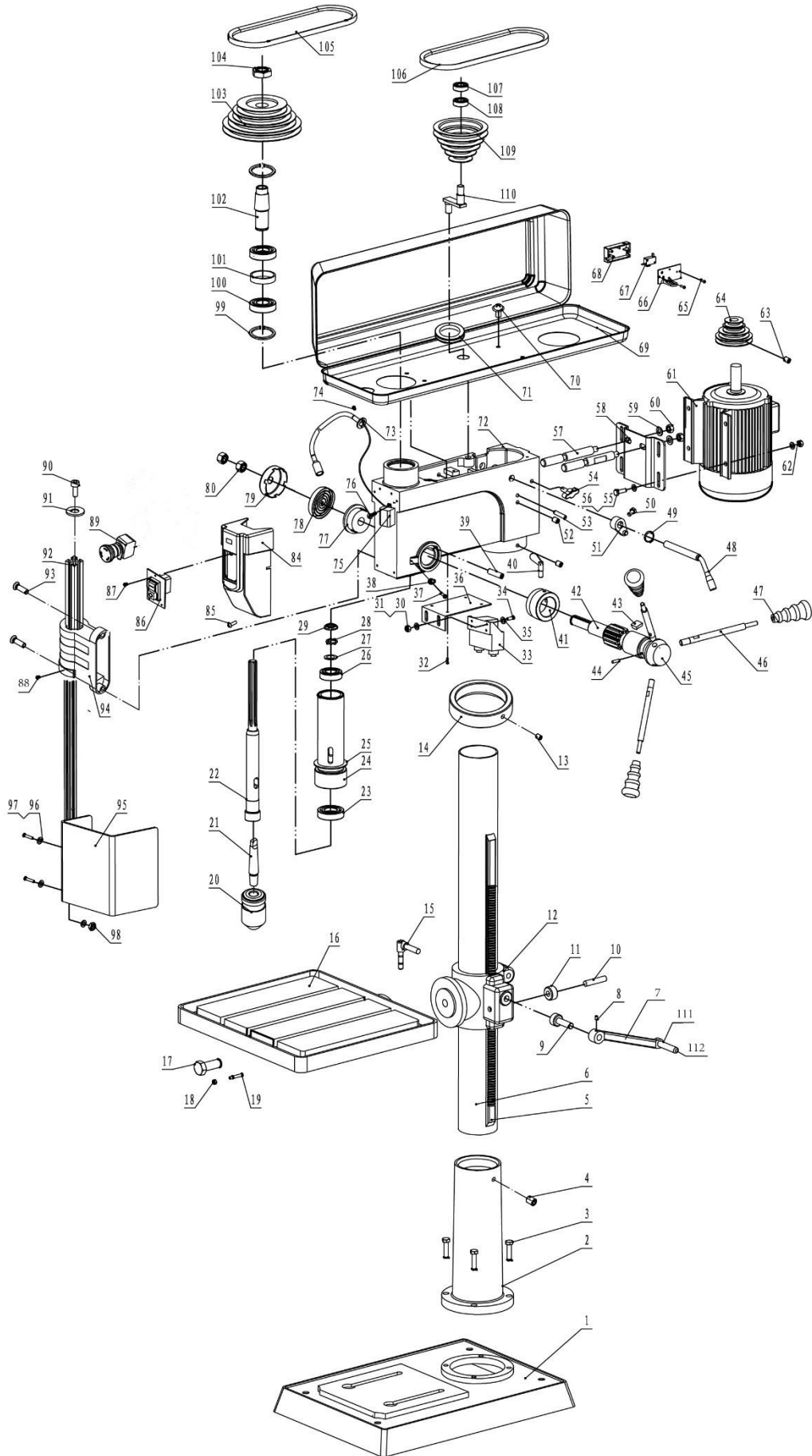
JDP-13FM Parts List for Breakdown (1/2)

Index No.	Part No.	Description	Size	Qty.
1	JDP13FM-001	Base		1
2	JDP13FM-002	Column support		1
3	JDP13FM-003	Hex Cap Screw	M10×40	4
4	JDP13FM-004	Crank Arm Shaft		1
5	JDP13FM-005	Worm Shaft		1
6	JDP13FM-006	Gear Pin		1
7	JDP13FM-007	Helical Gear		1
8	JDP13FM-008	Table Support		1
9	JDP13FM-009	Column		1
10	JDP13FM-010	Rack		1
11	JDP13FM-011	Socket Set Screw	M6×10	1
12	JDP13FM-012	Rack Collar		1
13	JDP13FM-013	Column Lock Handle		1
14	JDP13FM-014	Table		1
15	JDP13FM-015	Table Lock Handle		1
16	JDP13FM-016	Hex Cap Screw	M16×35	1
17	JDP13FM-017	Table Bracket		1
18	JDP13FM-018	Chuck		1
19	JDP13FM-019	Arbor		1
20	BB-6204ZZ	Ball Bearing	6204ZZ	1
21	JDP13FM-021	Spindle		1
22	JDP13FM-022	Quill		1
23	JDP13FM-023	Ball Bearing		1
24	JDP13FM-024	C-Clip	11	1
25	JDP13FM-025	Cross Pan Head Screw	M4×8	1
26	JDP13FM-026	Indicator		1
27	JDP13FM-027	Laser		2
28	JDP13FM-028	Socket Set Screw		2
29	JDP13FM-029	Locking Button		1
30	JDP13FM-030	Ring Depth Stop		1
31	JDP13FM-031	Pinion Shaft		1
32	JDP13FM-032	Hub		
33	JDP13FM-033	Handle		3
34	JDP13FM-034	Grip		3
35	JDP13FM-035	Handle Shifter		1
36	JDP13FM-036	C-Clip15		1
37	JDP13FM-037	Hex Cap Screw	M8×16	1
38	JDP13FM-038	Shift Fork		1
39	JDP13FM-039	Locking Button		1
40	JDP13FM-040	Motor Rod		2
41	JDP13FM-041	Hex Cap Screw	M8×25	4
42	JDP13FM-042	Flat Washer	8	8
43	JDP13FM-043	Motor Base		1
44	JDP13FM-044	Nut	M12	2
45	JDP13FM-045	Lock Washer	8	4
46	JDP13FM-046	Motor		1
47	JDP13FM-047	Nut	M8	4
48	JDP13FM-048	Head		1
49	JDP13FM-049	Cross Recessed Pan Head Screw		1
50	JDP13FM-050	LED Light		1
51	JDP13FM-051	Nut	M12	1
52	JDP13FM-052	Spring Cap		1
53	JDP13FM-053	Coil Spring		1
54	JDP13FM-054	Cross Pan Head Screw	M4×12	1
55	JDP13FM-055	Transformer		1
56	JDP13FM-056	Switch Box		1

JDP-13FM Parts List for Breakdown (2/2)

Index No.	Part No.	Description	Size	Qty.
57	JDP13FM-057	Emergency Stop Switch Box		1
58	JDP13FM-058	Cross Pan Head Screw	M4×12	2
59	JDP13FM-059	E-Stop Switch Box Lid		1
60	JDP13FM-060	Emergency Stop Switch		1
61	JDP13FM-061	Tapping Screw	M3.5×9	1
62	JDP13FM-062	Electromagnetic Switch		1
63	JDP13FM-063	Switch For Laser And LED Light		2
64	JDP13FM-064	Cross Pan Head Screw	M5×12	3
65	JDP13FM-065	Hex Socket Cap Screw	M6×8	1
66	JDP13FM-066	Washer	6	1
67	JDP13FM-067	Cross Pan Head Screw	M5×16	1
68	JDP13FM-068	Chuck Guard Micro Switch Assy		1
69	JDP13FM-069	Shifter Bolt		1
70	JDP13FM-070	Chuck Guard Rod		1
71	JDP13FM-071	Washer	5	4
72	JDP13FM-072	Nut . M5		2
73	JDP13FM-073	Chuck Guard		1
74	JDP13FM-074	Cross Pan Head Screw	M5×25	2
75	JDP13FM-075	C-Clip17		1
76	BB-6203ZZ	Ball Bearing	6203ZZ	2
77	JDP13FM-077	Spacer		1
78	JDP13FM-078	Driving Sleeve		1
79	JDP13FM-079	Spindle Pulley		1
80	JDP13FM-080	Pulley Set nut		1
81	JDP13FM-081	V-Belt	M-24	1
82	JDP13FM-082	Pulley Cover Assy		1
83	JDP13FM-083	Strain Relief		1
84	JDP13FM-084	Tapping Screw	M3.5×13	2
85	JDP13FM-085	Micro Switch Box Cover		1
86	JDP13FM-086	Micro Switch		1
87	JDP13FM-087	Micro Switch Box		1
88	JDP13FM-088	Center Pulley Shaft		1
89	JDP13FM-089	Center Pulley		1
90	BB-6202ZZ	Ball Bearing	6202ZZ	1
91	JDP13FM-091	V-Belt	M-24	1
92	JDP13FM-092	Motor Pulley		1
93	JDP13FM-093	Hex Socket Cap Screw	M10×12	1
94	JDP13FM-094	Crank Arm Handle Grip		1
95	JDP13FM-095	Crank Arm Handle Shaft		1
	JDP13FM-096	Scale Indicator (Not show)		1
	JDP13FM-097	Rivet (Not show)	2.5×5	5
	JDP13FM-098	Tilt Scale (Not show)		1
	JDP13FM-099	Depth Scale (Not show)		1
	JDP13FM-100	Rubber sleeve (Not show)		1
	JDP13FM-101	Rubber sleeve (Not show)		1

JDP-20FT Assembly Breakdown



JDP-20FT Parts List for Breakdown (1/3)

Index No.	Part No.	Description	Size	Qty.
1	JDP20FT-001	Base		1
2	JDP20FT-002	Column Support		1
3	JDP20FT-003	Hex Cap Screw	M12x40	4
4	JDP20FT-004	Socket Set Screw	M10x12	1
5	JDP20FT-005	Rack		1
6	JDP20FT-006	Column		1
7	JDP20FT-007	Crank Arm Shaft		1
8	JDP20FT-008	Socket Set Screw	M6x10	1
9	JDP20FT-009	Worm Shaft		1
10	JDP20FT-010	Gear Pin		1
11	JDP20FT-011	Helical Gear		1
12	JDP20FT-012	Table Support		1
13	JDP20FT-013	Socket Set Screw	M6x10	1
14	JDP20FT-014	Rack Collar		1
15	JDP20FT-015	Lock Handle		1
16	JDP20FT-016	Table		1
17	JDP20FT-017	Hex Cap Screw	M20x50	1
18	JDP20FT-018	Nut	M8	1
19	JDP20FT-019	Pin		1
20	JDP13FT-018	Keyless Chuck		1
21	JDP20FT-021	Arbor		1
22	JDP20FT-022	Spindle		1
23	BB-6207ZZ	Bearing	6207ZZ	1
24	JDP20FT-024	Quill		1
25	JDP20FT-025	Rubber Washer		1
26	BB-6204ZZ	Bearing	6204ZZ	1
27	JDP20FT-027	Washer		1
28	JDP20FT-028	Locking Ring		1
29	JDP20FT-029	Locking Nut	M20	1
30	JDP20FT-030	Nut	M5	2
31	JDP20FT-031	Flat Washer	5	2
32	JDP20FT-032	Cross Pan Head Screw	M4x16	1
33	JDP20FT-033	Laser	1	
34	JDP20FT-034	Cross Pan Head Screw	M5x16	1
35	JDP20FT-035	Flat Washer	5	2
36	JDP20FT-036	Connector		1
37	JDP20FT-037	Cross Pan Head Screw	M4x8	1
38	JDP20FT-038	Indicator		1
39	JDP20FT-039	Stop Screw		1
40	JDP20FT-040	Locking Button		1
41	JDP20FT-041	Ring Depth Stop		1
42	JDP20FT-042	Pinion Shaft		1
43	JDP20FT-043	Gib		1
44	JDP20FT-044	Pin	5x16	1
45	JDP20FT-045	Hub		1
46	JDP20FT-046	Handle		3
47	JDP20FT-047	Grip		3
48	JDP20FT-048	Handle Shifter		1
49	JDP20FT-049	C-Clip	15	3
50	JDP20FT-050	Hex Cap Screw	M8x16	3
51	JDP20FT-051	Shift fork		1
52	JDP20FT-052	Hex Socket Cap Screw	M10x12	2
53	JDP20FT-053	Pin	8x25	2
54	JDP20FT-054	Shifter Bolt		2
55	JDP20FT-055	Hex Cap Screw	M8x25	4
56	JDP20FT-056	Washer	8	8

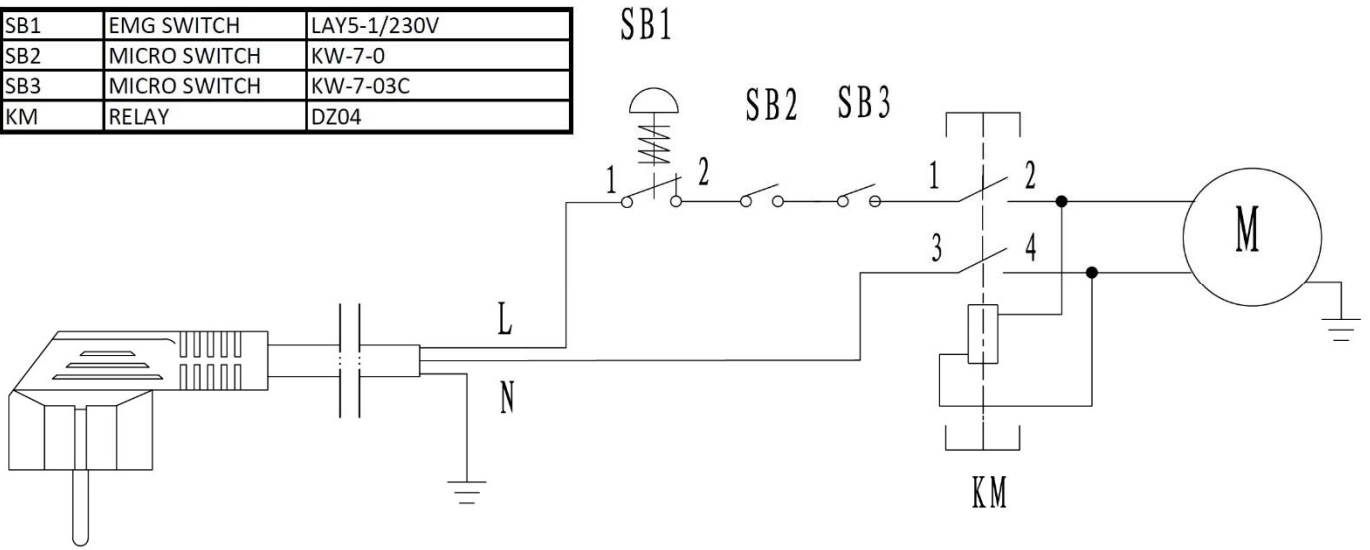
JDP-20FT Parts List for Breakdown (2/3)

Index No.	Part No.	Description	Size	Qty.
57	JDP20FT-057	Motor Rod		2
58	JDP20FT-058	Motor Base		1
59	JDP20FT-059	Lock Washer	12	2
60	JDP20FT-060	Nut	M12	2
61	JDP20FT-061	Motor		1
62	JDP20FT-062	Nut	M8	4
63	JDP20FT-063	Socket Set Screw	M8x12	1
64	JDP20FT-064	Motor Pulley		1
65	JDP20FT-065	Tapping Screw	M3.5x13	2
66	JDP20FT-066	Micro Switch Box Cover		1
67	JDP20FT-067	Micro Switch		1
68	JDP20FT-068	Micro Switch Box		1
69	JDP20FT-069	Pulley Cover Assy		1
70	JDP20FT-070	Pan Head Screw	M6x12	1
71	JDP20FT-071	Strain Relief		1
72	JDP20FT-072	Head		1
73	JDP20FT-073	LED Light		1
74	JDP20FT-074	Screw		4
75	JDP20FT-075	Transformer		1
76	JDP20FT-076	Cross Pan Head Screw	M4x8	1
77	JDP20FT-077	Spring Seat		1
78	JDP20FT-078	Coil Spring		1
79	JDP20FT-079	Spring Cap		1
80	JDP20FT-080	Nut	M12	2
84	JDP20FT-084	Switch Box		1
85	JDP20FT-085	Cross Pan Head Screw	M5x16	2
86	JDP20FT-086	Electromagnetic Switch		1
87	JDP20FT-087	Tapping Screw	M4.2x9	2
88	JDP20FT-088	Shifter Bolt		1
89	JDP20FT-089	Emergency Stop Switch		1
90	JDP20FT-090	Hex Socket Cap Screw	M6x8	1
91	JDP20FT-091	Washer	6	1
92	JDP20FT-092	Chuck Guard Rod		1
93	JDP20FT-093	Cross Pan Head Screw	M5x16	4
94	JDP20FT-094	Chuck Guard Micro Switch Assy		1
95	JDP20FT-095	Chuck Guard		1
96	JDP20FT-096	Washer	5	4
97	JDP20FT-097	Cross Pan Head Screw	M5x25	2
98	JDP20FT-098	Nut	M5	2
99	JDP20FT-099	Retaining Ring		1
100	BB-6203ZZ	Ball Bearing	6203ZZ	2
101	JDP20FT-101	Spacer		1
102	JDP20FT-102	Driving Sleeve		1
103	JDP20FT-103	Spindle Pulley		1
104	JDP20FT-104	Pulley Set nut		1
105	JDP20FT-105	V-Belt	A-29	1
106	JDP20FT-106	V-Belt	A-33	1
107	BB-6202ZZ	Ball Bearing	6202ZZ	2
109	JDP20FT-109	Center Pulley		1
110	JDP20FT-110	Center Pulley Shaft		1
111	JDP20FT-111	Crank Arm Handle Grip		1
112	JDP20FT-112	Crank Arm Handle Shaft		1
	JDP20FT-113	Scale Indicator (Not show)		1
	JDP20FT-114	Rivet (Not show)	2.5x5	5
	JDP20FT-115	Tilt Scale (Not show)		1
	JDP20FT-116	Depth Scale (Not show)		1
	JDP20FT-117	Rubber sleeve (Not show)		1

Wiring Diagrams

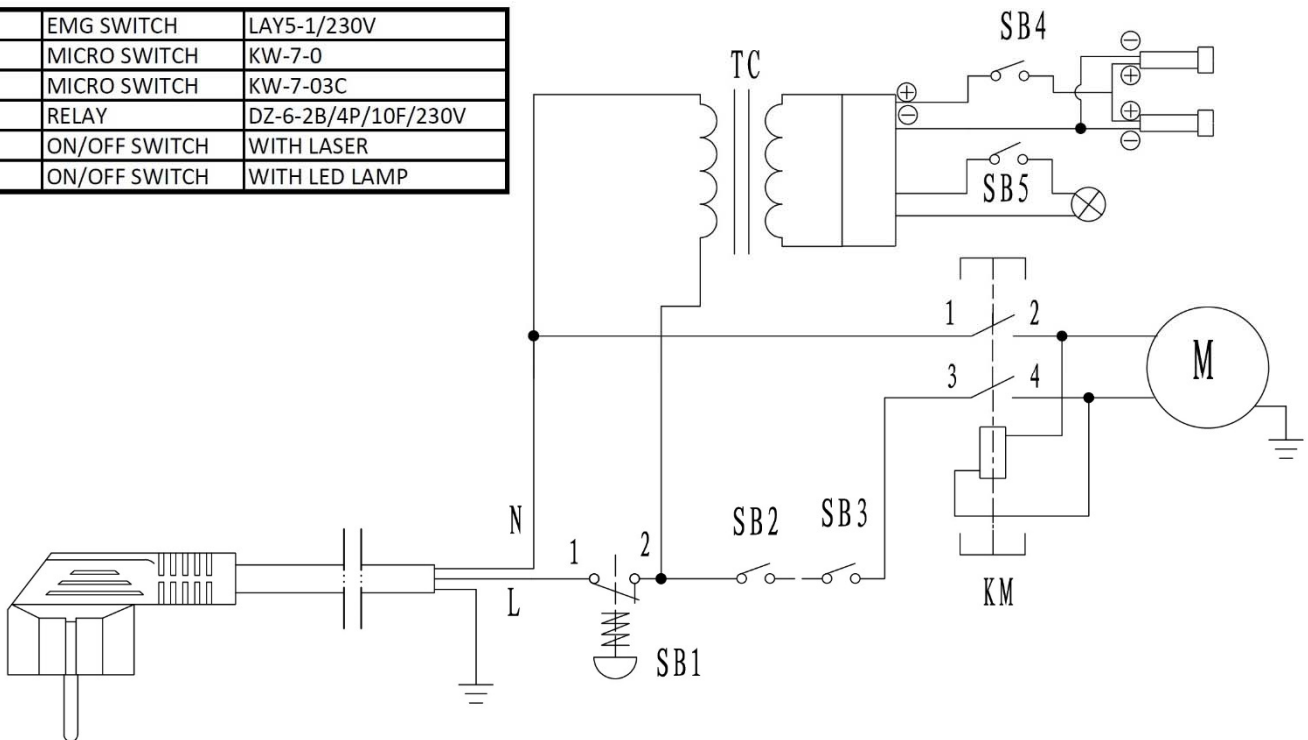
JDP-8BM, JDP-10BM1~230V, PE, 50Hz

SB1	EMG SWITCH	LAY5-1/230V
SB2	MICRO SWITCH	KW-7-0
SB3	MICRO SWITCH	KW-7-03C
KM	RELAY	DZ04

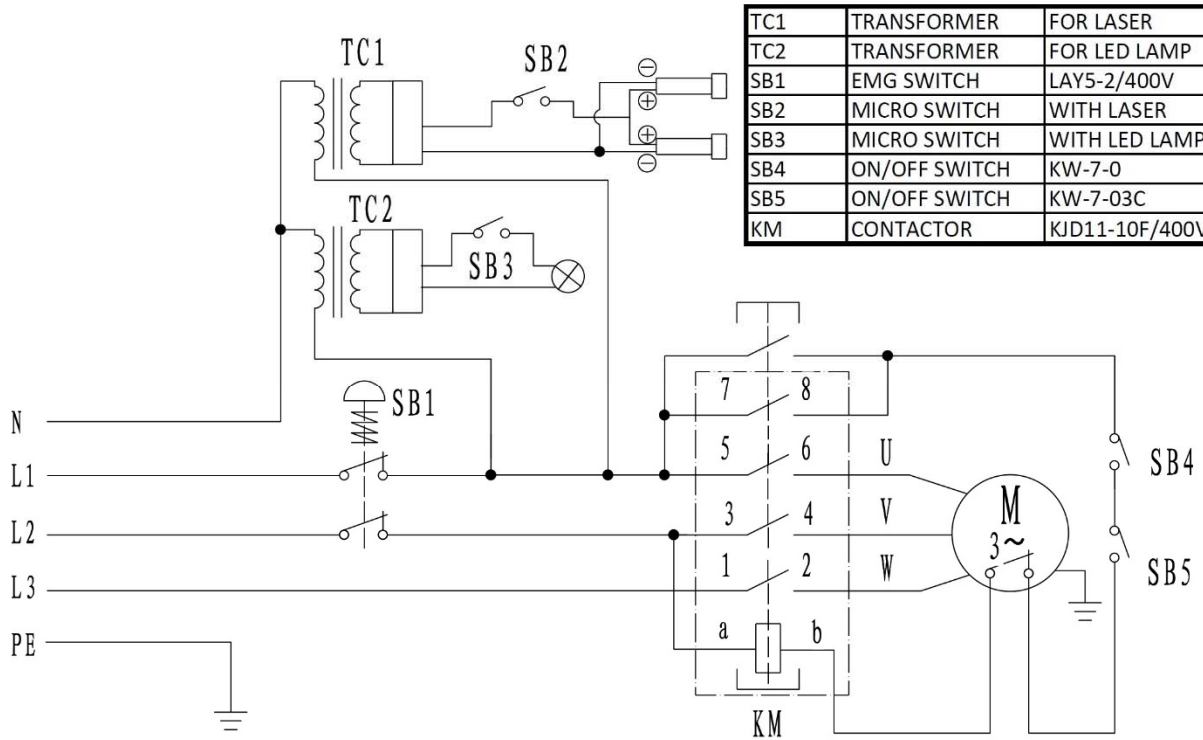


JDP-13FM1~230V, PE, 50Hz

SB1	EMG SWITCH	LAY5-1/230V
SB2	MICRO SWITCH	KW-7-0
SB3	MICRO SWITCH	KW-7-03C
KM	RELAY	DZ-6-2B/4P/10F/230V
SB4	ON/OFF SWITCH	WITH LASER
SB5	ON/OFF SWITCH	WITH LED LAMP



JDP-20FT3~400V, PE, 50Hz



TC1	TRANSFORMER	FOR LASER
TC2	TRANSFORMER	FOR LED LAMP
SB1	EMG SWITCH	LAY5-2/400V
SB2	MICRO SWITCH	WITH LASER
SB3	MICRO SWITCH	WITH LED LAMP
SB4	ON/OFF SWITCH	KW-7-0
SB5	ON/OFF SWITCH	KW-7-03C
KM	CONTACTOR	KJD11-10F/400V