



K2532

MAXI PEDESTAL DRILL PRESS

OPERATOR'S MANUAL



BEFORE USE, ENSURE EVERYONE USING THIS MACHINE READS AND UNDERSTANDS ALL SAFETY AND OPERATING INSTRUCTIONS IN THIS MANUAL .

Serial #.....

Date of Purchase.....

TRADEMASTER HEAVY DUTY DRILL PRESS - K2532

IMPORTED & DISTRIBUTED BY



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In addition to any warranties or conditions implied by applicable Statute or Regulations, Industrial Tool & Machinery Sales warrants all of its products against defective workmanship and faulty materials for a period of twelve (12) months from the date of purchase, unless otherwise stated. At our option we will repair or replace, free of charge, any item on the condition that:

- The complete machine or tool is returned, freight prepaid to ITM or one of its authorised service agents as directed by ITM, and is found to have a material or constructional defect.
- The machine or tool has not been subject to misuse, neglect or damage by accident.
- The fault is not a result of normal "wear and tear".
- Written permission has been received from ITM prior to commencement of repair.
- Repairs, tampering or modification carried out by unauthorised personnel will void all warranty.
- Consumable items such as cutting tools, pilot pins, saw blades, grinding wheels etc. are NOT covered by warranty.

Our goods come with guarantees which cannot be excluded under the Australian Consumer Law. You are entitled to replacement or refund for a major failure and to compensation for other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

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IMPORTANT SAFETY INSTRUCTIONS



WHEN USING ELECTRICAL TOOLS, BASIC SAFETY PRECAUTIONS SHOULD ALWAYS BE FOLLOWED TO REDUCE RISK OF FIRE, ELECTRIC SHOCK AND PERSONAL INJURY .

READ AND SAVE ALL INSTRUCTIONS FOR FUTURE REFERENCE.

1. Keep Work Area Clean
 - Cluttered areas and benches increase risk of injuries.
2. Consider Work Area Environment
 - Do not expose power tools to rain.
 - Do not use power tools in damp or wet locations.
 - Keep work area well lit.
 - Do not use tool in presence of flammable liquids or gases.
3. Guard Against Electric Shock
 - Prevent body contact with grounded surfaces. For example: pipes, radiators, ranges and refrigerator enclosures.
4. Keep Children Away
 - Do not let visitors contact tool or extension cord.
 - All visitors should be kept away from work area.
5. Store Idle Tools
 - When not in use, tools should be stored in a dry, high and locked-up place, out of reach of children.
6. Do Not Force Tool
 - It will do the job better and safer at the rate for which it was intended.
7. Use The Right Tool
 - Do not force a small tool or attachment to do the job of a heavy-duty tool.
 - Do not use tool for unintended purpose. For example: Do not use a circular saw for cutting tree limbs or logs.
8. Dress Properly
 - Do not wear loose clothing or jewellery. They can be caught in moving parts.
 - Rubber gloves and non-skid footwear are recommended when working outdoors.
 - Wear protective hair covering to contain long hair.
 - Always wear safety glasses
 - Use face or dust mask if necessary
 - Use hearing protection
9. Do Not Abuse Electrical Cord
 - Never carry tool by cord or yank it to disconnect from receptacle.
 - Keep cord away from heat, oil and sharp edges.
10. Secure Work
 - Use clamps or a vise to hold work. It's safer than using your hand and it frees both hands to operate tool.
11. Do Not Overreach
 - Keep proper footing and balance at all times.

IMPORTANT SAFETY INSTRUCTIONS

12. Maintain Tools With Care
 - Keep tools sharp and clean for better and safer performance.
 - Follow instructions for lubricating and changing accessories.
 - Inspect tool cords periodically and if damaged, have repaired by authorised service facility.
 - Inspect extension cords periodically and replace if damaged.
 - Keep handles dry, clean, and free from oil and grease.
13. Disconnect Tools
 - Unplug when not in use, before servicing, and when changing accessories, such as cutters.
14. Remove Adjusting Keys And Wrenches
 - Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
15. Avoid Unintentional Starting
 - Do not carry a plugged-in tool. Always disconnect from power source before moving.
 - Be sure switches are off before connecting to a power source.
16. Outdoor Use Of Extension Cords
 - When tool is used outdoors, use only extension cords intended for use outdoors and so marked.
17. Stay Alert
 - Watch what you are doing. Use common sense. Do not operate tool when you are tired.
 - Do not use when taking medications that may cause drowsiness.
18. Check Damaged Parts
 - Before further use of the tool, any damaged parts should be repaired and performance verified prior to operation.
 - Check alignment of moving parts, binding of parts, breakage of parts, mounting, and any other conditions that may affect its operation. Any part that is damaged should be properly repaired or replaced by an authorised service centre.
 - Do not use this tool if switches do not turn it on and off. Have defective switches replaced by an authorised service centre.

SPECIAL SAFETY RULES FOR DRILL PRESS

1. Caution: This drill press is intended for use with drill bits. The use of accessories may be hazardous.
2. Correct drilling speeds: Factors which determine the best speed to use in any drill press operation are: Type of material being worked, size of hole, type of drill or other cutter, and quality of cut desired. The smaller the drill, the greater the required RPM. In soft materials, the speed should be higher than for hard metals.
3. Drilling in metal: Use clamps to hold the work when drilling in metal. The work should never be held in the bare hand, the flutes of the drill may seize the work at any time, especially when breaking through the stock. If the piece is whirled out of the operator's hand, he may be injured, in any case, the drill will; be broken when the work strikes the column.
4. The work must be clamped firmly whilst while drilling: Any tilting, twisting, or shifting results not only in a rough hole, but also increases drill breakage. For flat work, lay the piece on a wooden base and clamp it firmly down against the table to prevent it from turning. If the piece is of irregular shape and cannot be laid flat on the table, it should be securely blocked and clamped.
5. The chuck shall be securely fastened to the spindle and so that it can't be separated from the spindle.
6. Remove the key from the chuck after adjustment.
7. The tool is to be disconnected from the power supply while the motor is being mounted, connected, or reconnected.
8. Secure the tool to the supporting structure if, during normal operation, there is any tendency for the tool to tip over, slide, or walk on the supporting surface.
9. The set screws of the head frame should be screwed tightly before using this machine.
10. Connect to a supply circuit protected by a circuit breaker or time delay fuse.
11. Fasten base to floor or worktable before using the drill press.

POWER SUPPLY REQUIREMENTS

Prior to use check condition of the power cord, which has to be free of any cuts, or similar damages.

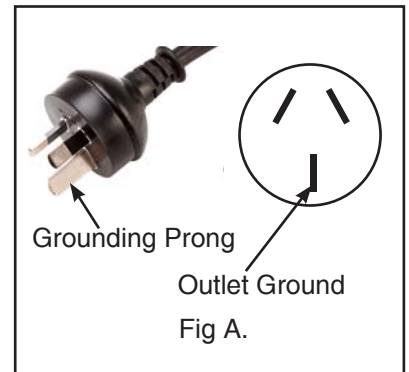
Attention!: This unit has a class one of insulation and absolutely requires the power source to be equipped with a protection circuit.

Power source should be protected with the difference-current circuit cut-out and protected with a 10A fuse - for 230V. At building sites, power should be supplied from a separation transformer such as Type AVM, with minimum power of 2000 VA and with second class protection.

GROUNDING INSTRUCTIONS

! WARNING

Improperly connecting the grounding wire can result in the risk of electrical shock. Check with a qualified electrician if you are in doubt as to whether the outlet is properly grounded. Do not modify the plug provided with tool. Never remove the grounding prong from the plug. If the cord or plug is damaged, have it repaired before using. If the plug will not fit the outlet, have a proper outlet installed by a qualified electrician. The K2532 must be plugged into an appropriate outlet, properly installed and grounded in accordance with all codes and ordinances. The plug and outlet should look similar to those in Figure A. If in doubt of proper grounding, call a qualified electrician.



! WARNING

EXTENSION CORDS

Use only 3-wire extension cords that have 3-prong grounding-type plugs and 3-pole receptacles that accept the tool's plug. Replace or repair damaged cords. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An under sized cord will cause a drop in line voltage resulting in loss of power and overheating. See table for the correct size to use depending on cord length and nameplate amperage rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

MINIMUM GAUGE FOR EXTENSION CORDS				
VOLTS	TOTAL LENGTH OF CORD IN METRES			
240V	0-15	15-30	30-60	60-90
AMPERAGE				
0-6	18	16	16	14
6-10	18	16	14	12
10-12	16	16	14	12
12-16	14	12	NOT RECOMMENDED	
RECOMMENDED WIRE GAUGE				

DRIP LOOP: To help prevent cutting fluids from travelling along power cord and contacting power source, tie a drip loop in power cord.

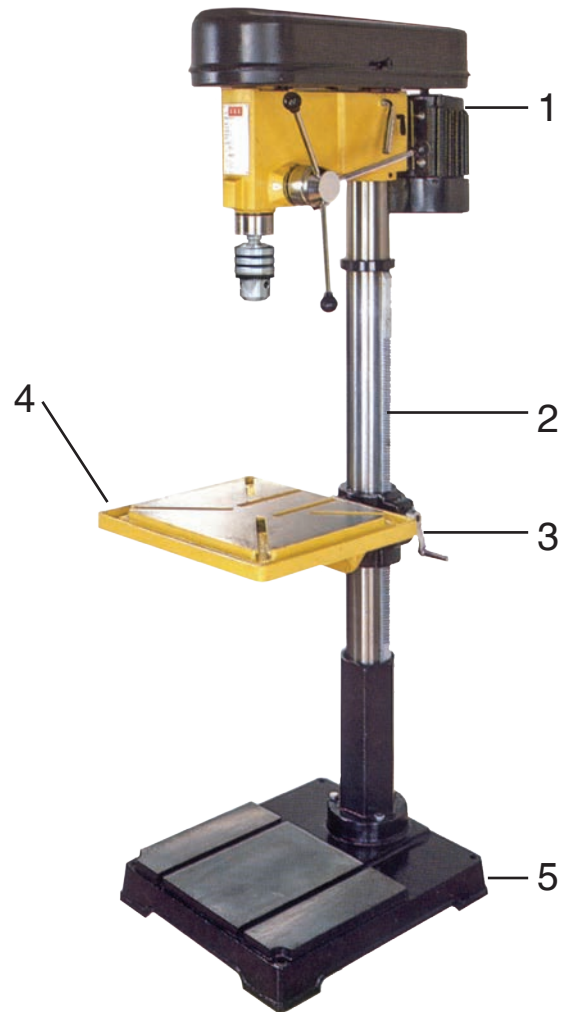
MACHINE ASSEMBLY

I. PARTS

Unpack carton, check your machine to see parts listed below:

A. Main Parts:

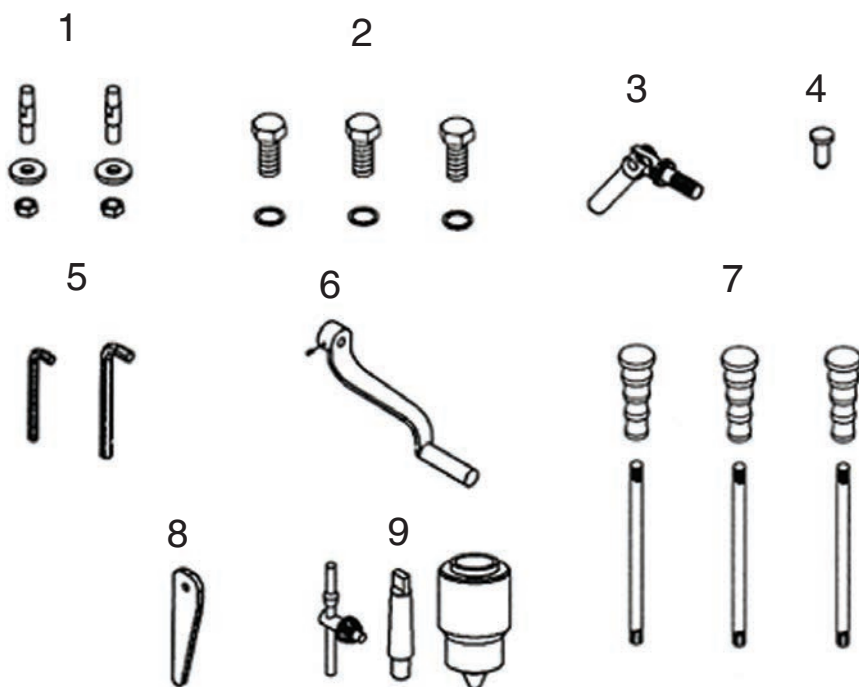
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|-----------------------------|--------|
| 1. Head assembly | 1 pc. |
| 2. Column with flange | 1 pc. |
| 3. Arm of table and bracket | 1 set. |
| 4. Table | 1 pc. |
| 5. Base | 1 pc. |



B. Accessories:

- | | |
|-----------------------------------|--------|
| 1. Screw washer nut | 2 pcs. |
| 2. Bolt & washer | 3 pc. |
| 3. Clamp bolt | 1 pc. |
| 4. Clamp handle | 1 pc. |
| 5. Hexagon socket wrench | 2 pcs. |
| 6. Height adjustment handle | 1 pc. |
| 7. Feed handle knob | 3 pcs. |
| 8. Drift | 1 pc. |
| 9. Chuck, chuck key & taper arbor | 1 set. |

Note: If you find any parts missing or damaged, contact the dealer for exchange or replacement.

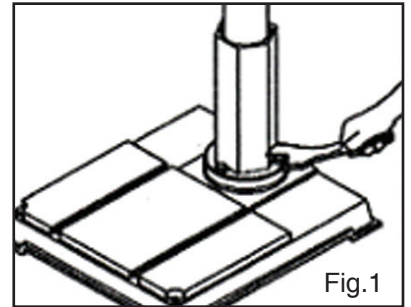


MACHINE ASSEMBLY

II. ASSEMBLY

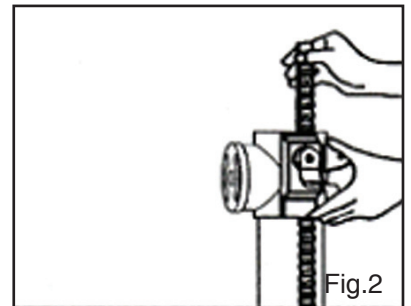
1. Assemble the column

- Place column assembly on base and align holes in column support with holes in base.
- Secure the column with three or four bolts and the washers provided.



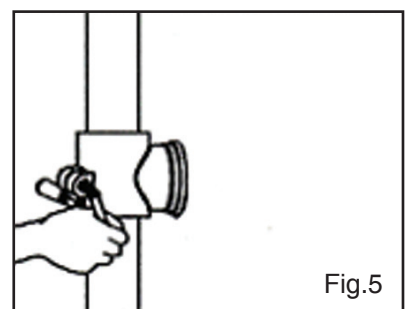
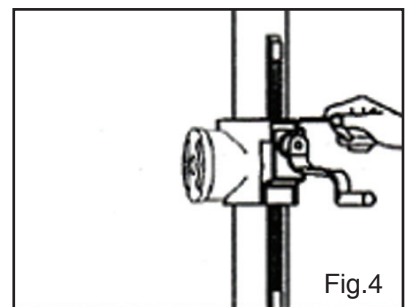
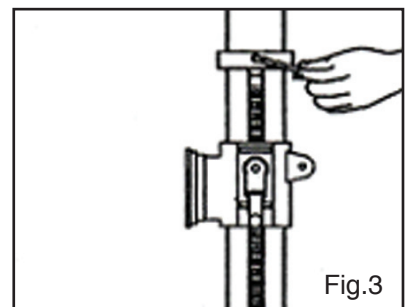
2. Install table bracket

- Take off collar and rack.
- Install table bracket together with rack. Fig. 2.
- Install collar and fix firmly. Fig. 3.



3. Install table handle and clamp bolt.

- Fix handle with attached set screw. Fig. 4.
- Install clamp bolt to fix bracket. Fig. 5.



MACHINE ASSEMBLY

4. Install table and clamp with bolt. Fig. 6.

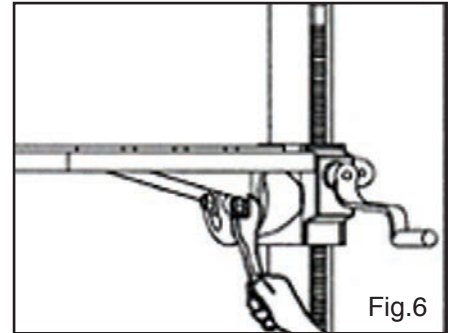


Fig.6

5. Attach the Head Assembly

- Carefully put the head assembly over the column and slide it onto the column into position. Align the head frame with the table and base.
- Fix set screws into the right side of the head to lock the head into position. Tighten the screws with the Allen wrench. Fig. 7.

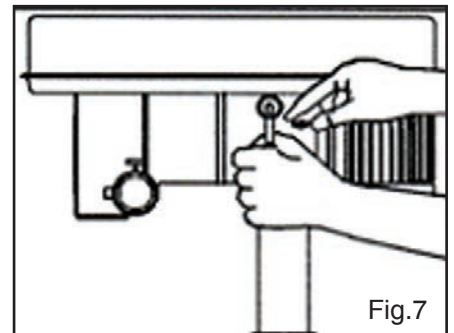


Fig.7

6. Install the Feeding Handles

- Screw knob on each feeding handle, install them into the hub of the pinion shaft. Fig. 8.

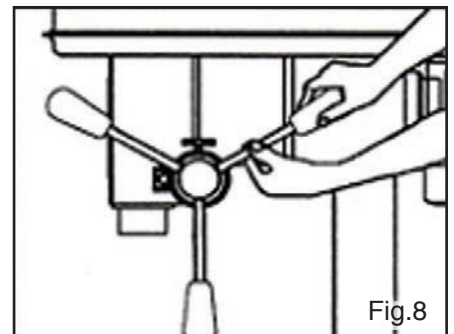


Fig.8

7. Attach the Arbor and Chuck

- Insert the arbor into the spindle first. Pull the feeding handle down to press the arbor inward. Fig. 9.
- Open chuck jaws completely by turning attached chuck key counter-clockwise to the end. Put a piece of scrap wood on the table to protect the chuck nose.
- Install the chuck to arbor tightly. Fig. 10.

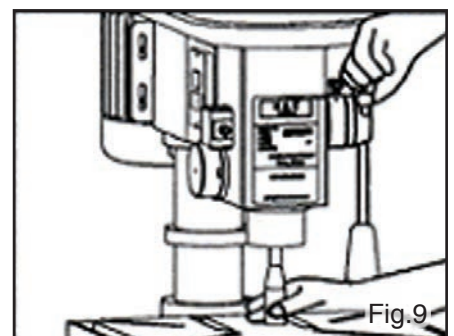


Fig.9

8. Install knob and screw of upper pulley cover. Fig. 11.

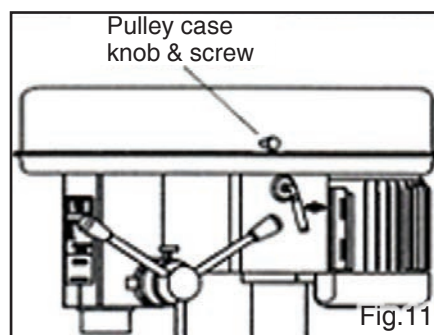


Fig.11

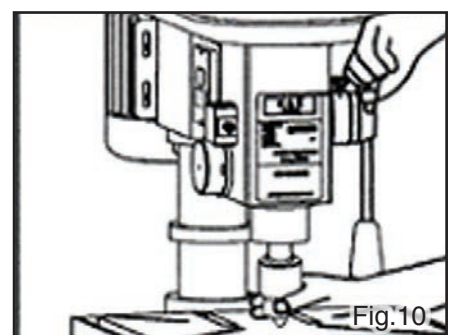


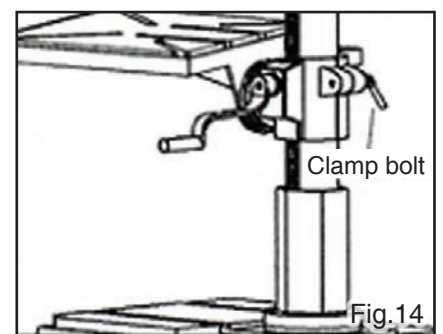
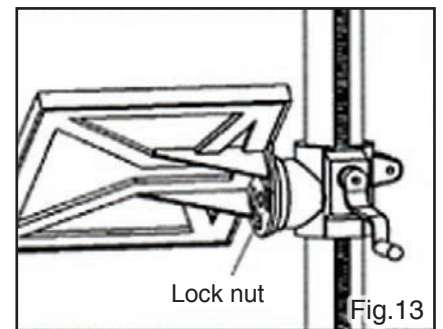
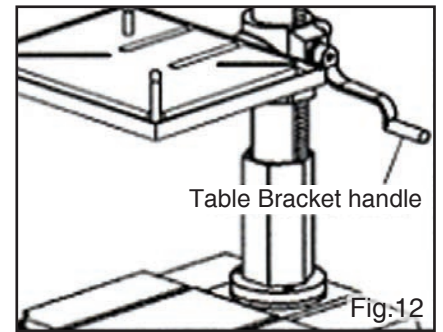
Fig.10

MACHINE ASSEMBLY

III. ADJUSTMENT

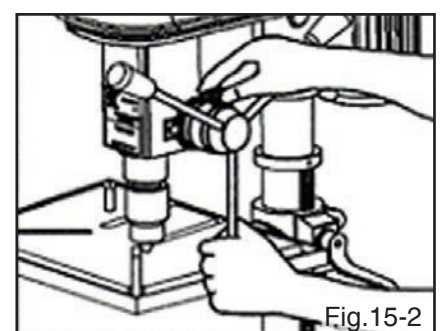
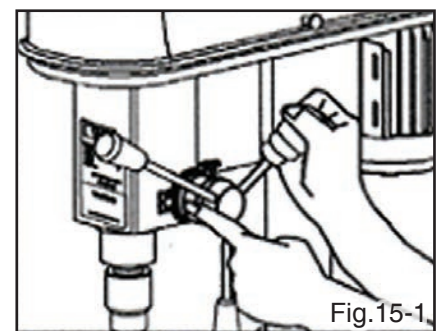
1. Table Adjustment

- Height Adjustment: To adjust up or down, loosen the clamp bolt then adjust the table to your desired position by turning the table bracket handle. Fig. 12.
- Tilting Adjustment: Loosen the table bevel lock bolt with adjustable wrench. Tilt the table to desired angle and retighten the bolt. Fig. 13.
- Swing 360°: Loosen the clamp bolt then swing the table to the appropriate position and retighten the clamp bolt. Fig. 14.



2. Feed Depth Adjustment

- Depth control scale sleeve type loosen the clamp bolt and move it to the desired depth then retighten the clamp bolt. Fig. 15-1 & 15-2.



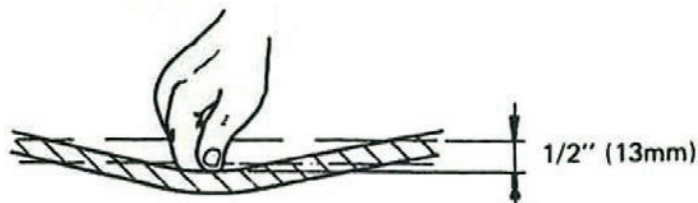
MACHINE ASSEMBLY

The proper drill speed for a given drill bit size is as on following table:

Size		Cast Steel		Tool Steel		Cast Iron		Mild Steel		Alum. & Copper	
		Cutting Speed									
Diameter		m/min	ft/min	m/min	ft/min	m/min	ft/min	m/min	ft/min	m/min	ft/min
12		40	18	60	24	80	30	100	60	200	
mm	inch	Cutting Speed RPM									
2	1/16	1910	2445	2865	3665	3820	4890	4775	6110	9550	12225
3	1/8	1275	1220	1910	1835	2545	2445	3185	3055	6365	6110
5	3/16	765	815	1145	1220	1530	1630	1910	2035	3820	4075
6	1/4	610	610	955	915	1275	1220	1590	1530	3180	3055
8	5/16	480	490	715	735	955	980	1195	1220	2390	2445
10	3/8	380	405	570	610	765	815	955	1020	1910	2035
11	7/16	350	350	520	525	700	700	870	875	1740	1745
13	1/2	300	305	440	460	590	610	735	765	1470	1530
16	5/8	240	245	360	365	480	490	600	610	1200	1220
19	3/4	190	205	285	305	380	405	480	510	955	1020

Belt Tension Adjustment

- For proper belt tension: Use 10 lbs pressure or hand pressure on the belt as shown below. The distance is 1/2" (13mm) +10%



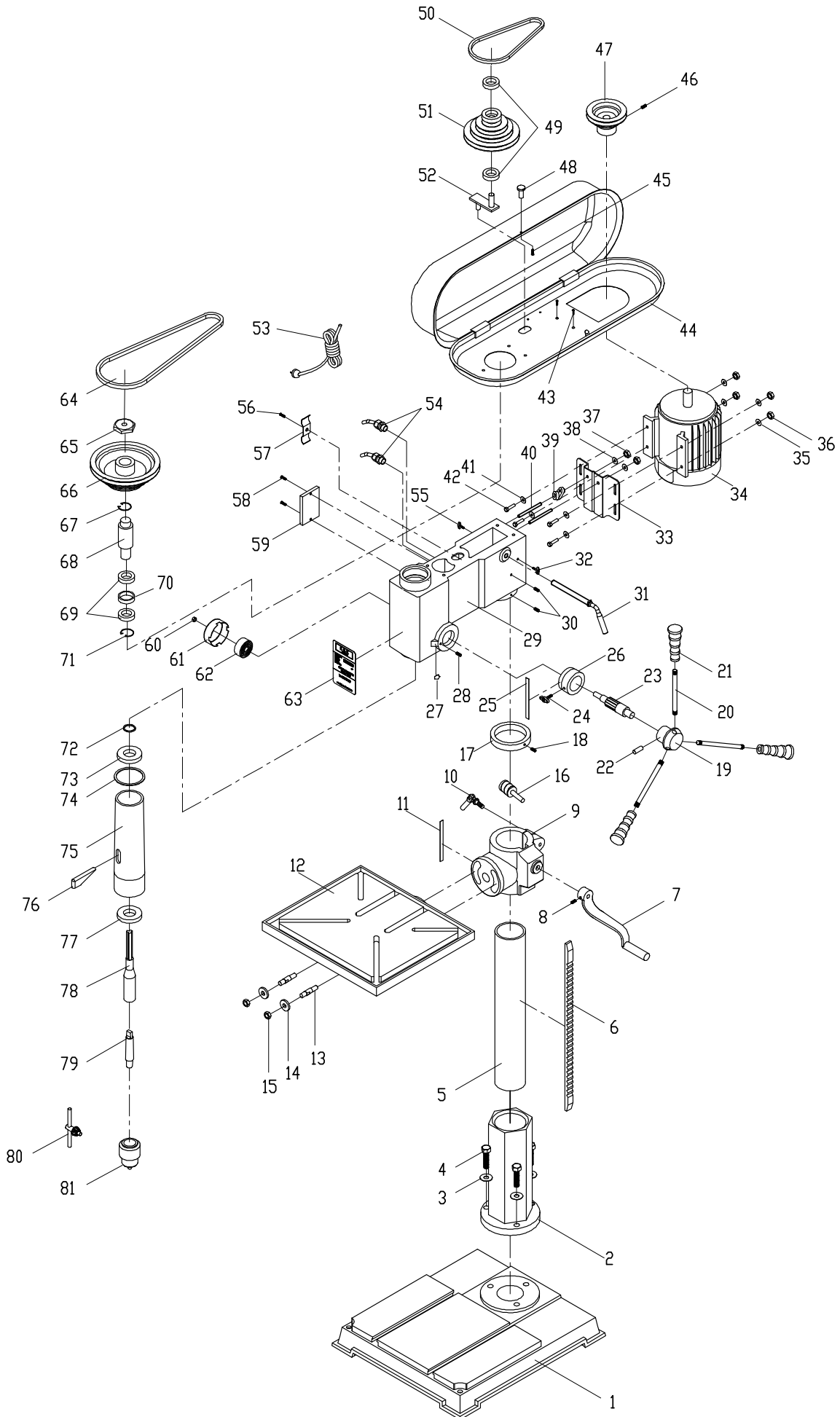
IV. MAINTENANCE

Frequently blow out any dust that may accumulate inside the motor. A coat of automobile-type wax applied to the table and column will help to keep surfaces clean. If the power cord is worn or cut, or damaged in any way, have it replaced immediately.

Lubrication

All of the ball bearings are packaged with grease at the factory. They require no further lubrication. Periodically lubricate the gear rack and the rack elevation mechanism, the splines (grooves) in the spindle, and the rack (teeth on the quill).

ASSEMBLY DIAGRAM & PARTS LIST



ASSEMBLY DIAGRAM & PARTS LIST

PARTS #	DESCRIPTION	PARTS #	DESCRIPTION
1	Base	42	Screw
2	Flange	43	Screw
3	Washer	44	Pulley Cover
4	Screw	45	Screw
5	Column	46	Set Screw
6	Rack	47	Motor Pulley
7	Shafting Rod	48	Knob
8	Set screw	49	Ball Bearing
9	Table Bracket	50	V-Belt
10	Clamp Bolt	51	Middle Pulley
11	Table Tilting Label	52	Pivot Bracket
12	Work Table	53	Power Cord
13	Screw	54	Cable Protection
14	Washer	55	Thumb Screw
15	Nut	56	Screw
16	Worm and Worm Gear	57	Wire Fixed Buckle
17	Rack Collar	58	Screw
18	Set Screw	59	Switch
19	Handle Body	60	Nylon Nut
20	Handle Body	61	Spring Cover
21	Knob	62	
22	Stop Pin	63	Name Plate
23	Feed Pinion	64	V-Belt
24	Thumb Screw	65	Nut
25	Scale	66	Spindle Pulley
26	Scale Sleeve	67	Retaining Ring
27	Zero Mark	68	Drive Taper
28	Spring Pin	69	Ball Bearing
29	Head	70	Ball Spacer
30	Set Screw	71	Retaining Ring
31	Adjusting Bolt C	72	Retaining Ring
32	Thumb Screw	73	Ball Bearing
33	Mounting Plate	74	Rubber Washer
34	Motor	75	Quill
35	Washer	76	Wedge
36	Nut	77	Ball Bearing
37	Nut	78	Spindle
38	Washer	79	Morse Taper Arbor
39	Shaft Lever	80	Chuck Key
40	Adjusting Bolt B	81	Chuck
41	Washer		