

# MANUAL

## Drill Presses



**13-1/2" 3/4 HP  
12 Speed Bench Drill Press**  
Product No. **200225**  
Mod No. **JDP-13**



**13-1/2" 3/4 HP  
12 Speed Floor Drill Press**  
Product No. **200275**  
Mod No. **JDP-13F**



**17" 1 HP  
16 Speed Floor Drill Press**  
Product No. **200278**  
Mod No. **JDP-17F**

**22" 1-1/2 HP  
12 Speed Floor Drill Press**  
Product No. **200357**  
Mod No. **JDP-22F**

# Operating Instructions

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Before operating the unit, please read this manual thoroughly, and retain it for future reference.

We thank you for your purchase of a JET Drill Press. It has been designed, engineered and manufactured to give you the best possible dependability and performance. However, we'd like to remind you that faultless running is entirely dependent upon rational use and careful maintenance, which will also spare the user time consuming delays and costly repairs.

Your drill press was designed to give you a durable, reliable and easy to use product. With proper maintenance, your JET machine will give you years of trouble-free operation.

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## Warranty Policy

JET makes every effort to assure that its products meet high quality standards and warrants to the retail consumer/purchaser of our products that each product is free from defects in material and workmanship. JET offers a **TWO-YEAR LIMITED WARRANTY** on this product. Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, repairs or alterations performed outside our facilities or to a lack of maintenance.

## Warranty Procedure

Any JET product for which there is a warranty claim should be returned PREPAID to an authorized JET distributor or service centre. Authorized Warranty Depots are found at [www.surewerx.com](http://www.surewerx.com).

## Specifications

Prod. No. Mod. No.	200225 JDP-13	200275 JDP-13F	200278 JDP-17F	200357 JDP-22F
Swing	13-1/4"	13-1/4"	17"	22"
Type	Bench	Floor	Floor	Floor
Chuck Size	1/32"-5/8" (1-16 mm)	1/32"-5/8" (1-16 mm)	(5-200 mm)	3/4"
Drilling Capacity	5/8"	5/8"	5/8"	1-1/4"
Spindle Travel	3-1/16"	3-1/4"	3-3/8"	4-1/2"
Spindle Distance to Base	24"	48-3/4"	48-3/8"	49"
Spindle Distance to Table	17-1/2"	31-1/2"	28½"	29"
Table Size	11-7/16"	11-7/16"	13-3/4"	16-1/2" x 18-3/4"
Table Tilt (R and L)	0° - 45°	0° - 45°	0° - 45°	0° - 45°
Spindle Taper	JT3	JT3	JT3	MT3
Column Diameter	2-7/8"	2-7/8"	3-1/8"	3-5/8"
Number of Spindle Speeds	12	12	16	12
Range of Spindle Speeds (RPM)	280-3,000	280-3,000	220-3,380	180-4,200
Overall Height	38-1/2"	61-5/8"	64"	69-1/4"
Base size	10" x 16-1/2"	10" x 16-1/2"	12" x 19-3/4"	19-5/8" x 22-1/2"
Motor	3/4HP, 1PH	3/4HP, 1PH	1HP, 1PH	1.5HP, 1PH
	115/230V	115/230V	115/230V	115/230V
	Prewired 115V	Prewired 115V	Prewired 115V *	Prewired 115V *
Product Weight	94 lbs.	107 lbs.	176 lbs.	353 lbs.
Shipping Weight	99 lbs.	112 lbs.	184 lbs.	373 lbs.

**Standard Equipment:** Built-in work lamp, drill chuck and key, positive depth stop.

**\* If converting to 230V power standard switch and face plate must be replaced with item PDN-JDP-1338 Switch and item PDN-JDP-1725 Face Plate**

# Safety Rules

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1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Always check to see that keys and adjusting wrenches are removed from tool before turning it on.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DON'T USE IN DANGEROUS ENVIRONMENTS.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
5. **KEEP CHILDREN AWAY.** All visitors should be kept a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **DON'T FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** Don't force tool or attachment to do a job for which it was not designed.
9. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewellery which may get caught in moving parts. Safety footwear is recommended. Wear protective hair covering to contain long hair.
10. **ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
11. **SECURE WORK.** Use clamps or a vise to hold work at all times. It's safer than using your hand and it frees both hands to operate tool.
12. **DON'T OVERREACH.** Keep proper footing and balance at all times.
13. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
14. **DISCONNECT TOOLS** before servicing (when changing accessories, such as blades, bits, cutters, and the like).
15. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in off position before plugging in.
16. **USE RECOMMENDED ACCESSORIES.** The use of improper accessories may cause risk of injury to persons.
17. **NEVER STAND ON TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
18. **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function – check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
19. **NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF.** Don't leave tool until it comes to a complete stop.
20. **WOOD DUST CREATED BY CERTAIN WOODWORKING TOOLS CAN BE HAZARDOUS TO YOUR HEALTH.** Operate machinery in a well-ventilated area. Use of a dust collection system is highly recommended.

## Additional Safety Rules for Drill Presses

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1. Operate drill presses only if you are familiar with their operation. If not, ask a qualified user.
2. Always shut off power to machine before making any adjustments.
3. Machine must be properly grounded. Be sure to check that electrical connections are compatible with machine.
4. Always check tightness of drill bit before operating. Failure to do so could cause damage to machine and/or operator.
5. Always remove chuck key from chuck before starting machine.
6. Always adjust table and/or depth stop to prevent drilling into table. It is highly recommended to use a backing piece when drilling through workpiece.
7. Secure workpiece to table with clamps or a vise to prevent rotating with the drill bit.



### WARNING

**Do not wear gloves when operating drill press; Serious injury could result.**

**Wear proper eye protection when operating this or any power tool.**

# Electrical Requirements



## WARNING

To avoid injury from unexpected start up, do not use blower or washing machine motors or any motor with an automatic reset overload protector.

Failure to properly ground this power tool can cause electrocution or serious shock, particularly when used in damp locations, or near metal plumbing. If shocked, your reaction could cause your hands to hit the cutting tool.

If power cord is worn or cut, or damaged in any way, have it replaced immediately to avoid shock or fire hazard.

## Connecting to Power Source Outlet

This machine must be grounded while in use to protect the operator from electric shock. Plug power cord into a 110-120v properly grounded type outlet protected by a 15 amp dual element time delay or circuit breaker.

**Not all outlets are properly grounded. If you are not sure that your outlet, as pictured below, is properly grounded, have it checked by a qualified electrician.**

**To avoid electric shock, do not touch the metal prongs on the plug, when installing or removing the plug to or from the outlet.**

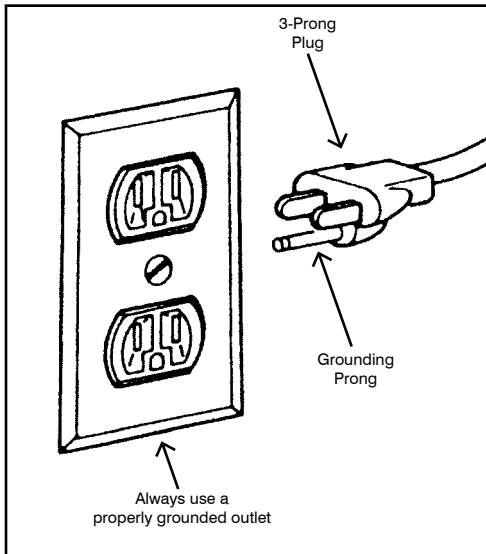
Your drill press is currently wired by the factory to operate on a 110/120v single phase circuit requiring a 15 amp breaker.

To operate on a 230v single phase circuit, please refer to the motor name plate diagram for the wiring connector for 230v.

This power tool is equipped with a 3-conductor cord and grounding type plug. The ground conductor has a green jacket and is attached to the tool housing at one end and to the ground prong in the attachment plug at the other end.

This plug requires a mating 3-conductor grounded type outlet as shown.

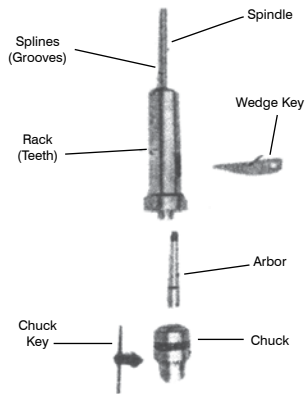
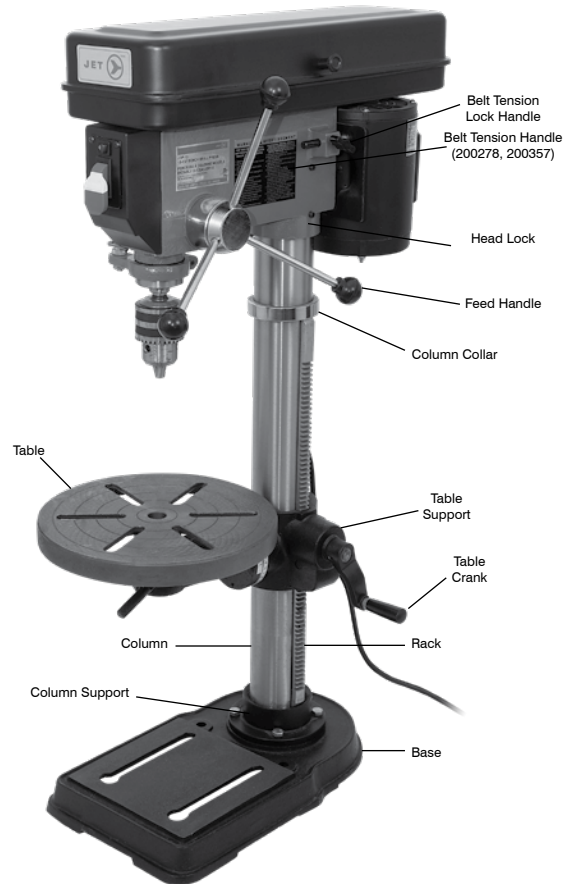
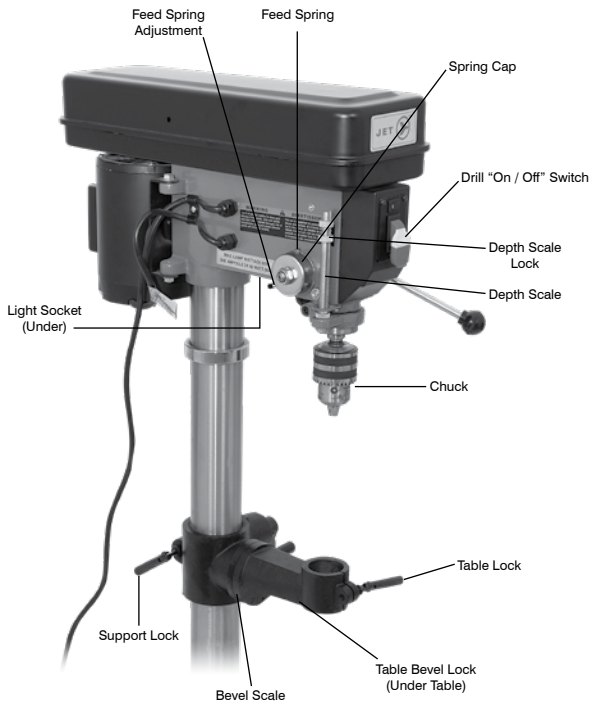
The use of any extension cord will cause some loss of power. To keep this to a minimum and to prevent overheating and motor burnout, use the table below to determine the minimum wire size (A.W.G.) extension cord. Use only 3 wire extension cords which have 3-prong grounding type plugs and 3-pole receptacles which accept the tool's plug.



### Extension Cord Length    Wire Size A.W.G.

0 - 25 feet	16
26 - 50 feet	14
51 - 100 feet	12

# Getting to Know Your Drill Press

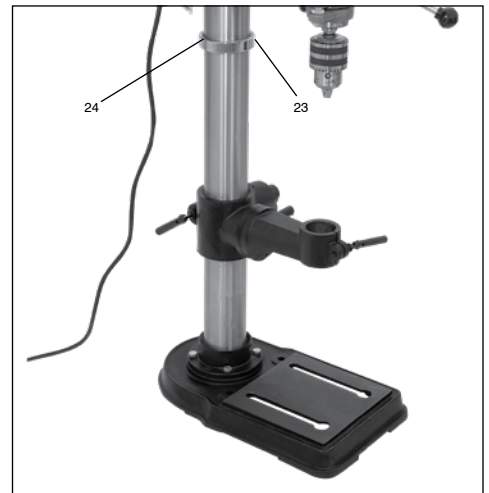
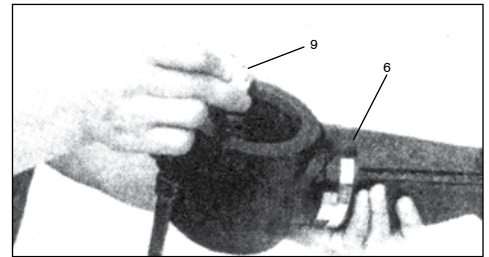
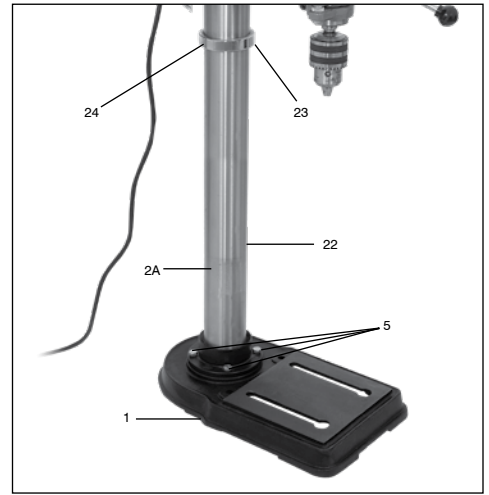


# Assembly Instructions

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Refer to parts breakdown and/or descriptive pictures for numbers indicated. Some floor models come with the table bracket support already on the column.

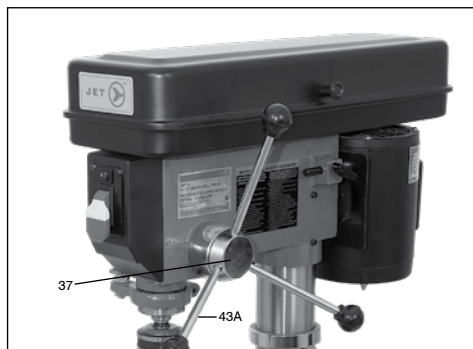
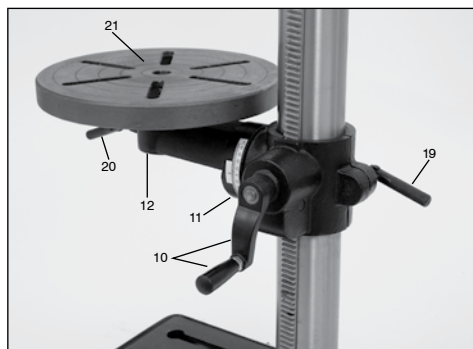
1. Place base (1) on flat and level surface.
2. Bolt column (2A) to base (1) using four hex head bolts (5) supplied (position gear rack (22) to right side of base - where applicable).
3. Remove rack ring (23) and rack (22) from column using supplied hex socket wrench.
4. Install worm pinion (9) into bracket (6) so that both gears engage smoothly.
5. Slide rack (22) into bracket (6). Then slide this unfinished assembled unit onto column (2A)(make sure unfinished portion of rack is positioned on top and that rack is seated properly in lower collar).
6. Slide rack ring (23) over column and fasten with hex socket screw (24).



7. Install crank handle (10) onto previously installed worm pinion (9) and tighten hex head bolt (11) with wrench.
8. Install column lock handle (19) through plain side of bracket (6) into threaded side and tighten.
9. Place head assembly (25) on top of column (2A).

**CAUTION! Head assembly is heavy - use two people or appropriate material handling equipment when lifting.**

10. Align head (25) to base (1) and tighten to column (2A) with two socket screws (26) found on right side of head.
11. Install three handle bars (43A) into handle body (37).
12. Install table (21) into table bracket (12) and tighten table lock handle (20).
13. Install 60 watt (max.) light bulb (not included) into receptacle on bottom of head (25).





## Installing Chuck

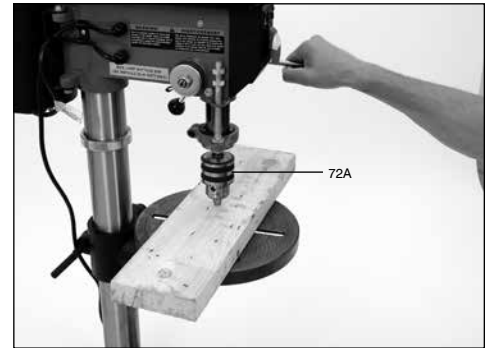
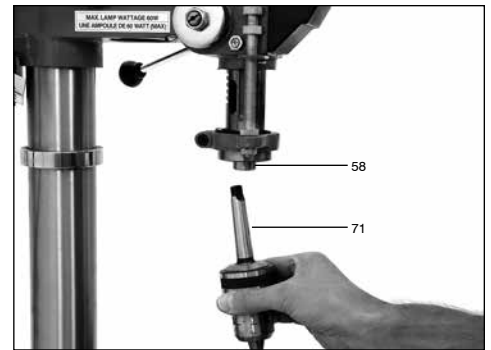
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### Unplug machine from power source

**Note:** Make sure the arbor nose is clean of any oil or rust protectant before mounting chuck. On models equipped with a Morse taper make sure all rust protectant is cleaned off before inserting arbor. You can inspect this by lowering the quill, using the down feed handles, and rotating the spindle until the knock out hole in the spindle lines up with the knock out hole in the quill.

1. Slide small end of arbor (71) into chuck (72A).
2. Place long end of arbor (71) into spindle (58). Rotate arbor to line up tang with spindle.
3. Raise table (21) to within 5 inches of chuck. Place a block of wood on table and lower chuck assembly to block of wood with handle bar assembly (43A).
4. Press firmly to set assembly in spindle.

**IMPORTANT:** Spindle, arbor, and drill chuck have to be clean of protective grease. Chuck and spindle may not seat properly if these parts are not clean.



## Removing Chuck and Arbor

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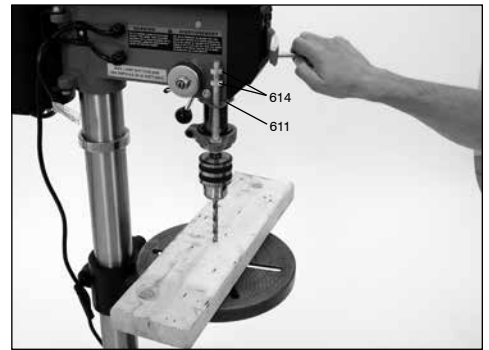
### Unplug machine from power source

1. Lower quill using handle bar assembly.
2. Align key hole in quill with key hole in spindle by rotating spindle.
3. Insert wedge directly in aligned key holes and tap lightly (place hand under chuck to catch assembly before it hits table).

## Depth Stop

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To drill multiple holes at the same preset depth, use the depth stop. To set depth stop, simply advance bit to lowest desired depth with the feed handle. Using your other hand, advance nuts (614) on depth stop until they are snug to seat (611). Spindle will now advance only to this preset depth. To release, simply advance nuts counterclockwise to top of depth stop.



## Spindle Speeds

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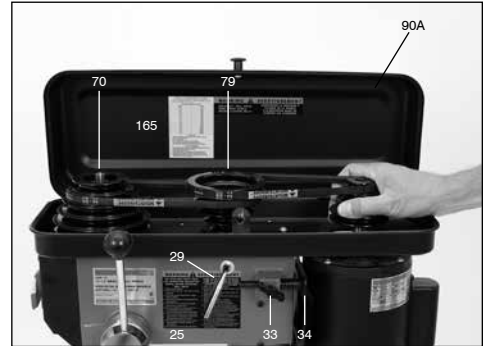
A spindle speed and corresponding belt arrangement chart can be found on the inside of the pulley guard. Refer to this chart when changing speeds.

## Changing Spindle Speeds and Tensioning Belt

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### Unplug machine from power source

1. Loosen two slide bar bolts (33).
2. Rotate tension adjuster (29) to bring motor base (34) as close as possible to head (25).
3. Change belts to desired position on motor pulley (79) and spindle pulley (70). Reference speed chart (165) on inside of pulley cover assembly (90A).
4. Rotate tension adjuster (29) to tension belt. Hold tension adjuster (29) while checking with thumb pressure for 1/2" deflection midway between pulleys.
5. Tighten two slide bar bolts (33).





## Basic Operational Hints

1. Always use a back-up piece of material (wood). This protects the bit and the table. It also prevents splintering of the workpiece.
2. Place material in such a way as to come into contact with the left side of the column. This will prevent the material from spinning.

**WARNING: If workpiece is not long enough, use a clamp or drill press vise that is securely fastened into the table. Failure to do so may cause serious injury.**

3. Feed bit into material with only enough force to allow drill bit to work. Feeding too slowly may cause burning of workpiece. Feeding too quickly may cause the motor to stop and/or the belts to slip. It may also cause the workpiece to break free from its clamps or the drill bit to break.
4. Generally speaking, the smaller the drill bit, the greater the RPM required. Wood will require higher speeds than metal. Metal is usually drilled at slow speeds.
5. In dusty environments, frequently blow out any dust that accumulates inside the motor.

## Return Spring Adjustment

The return spring is adjusted at the factory and should not need adjustment. If it does, follow these steps:

1. Disconnect drill press from power source.
2. Loosen two nuts (53, 106) approximately 1/4". Do not remove.
3. Firmly hold coil spring cover (49A); pull out and rotate until pin on return spring plate (52) engages with next notch in coil spring cover (49A). Turn counterclockwise to increase tension and clockwise to decrease tension.
4. Tighten two nuts (53, 106) to hold in place - do not overtighten. Nuts should not contact housing when tight.

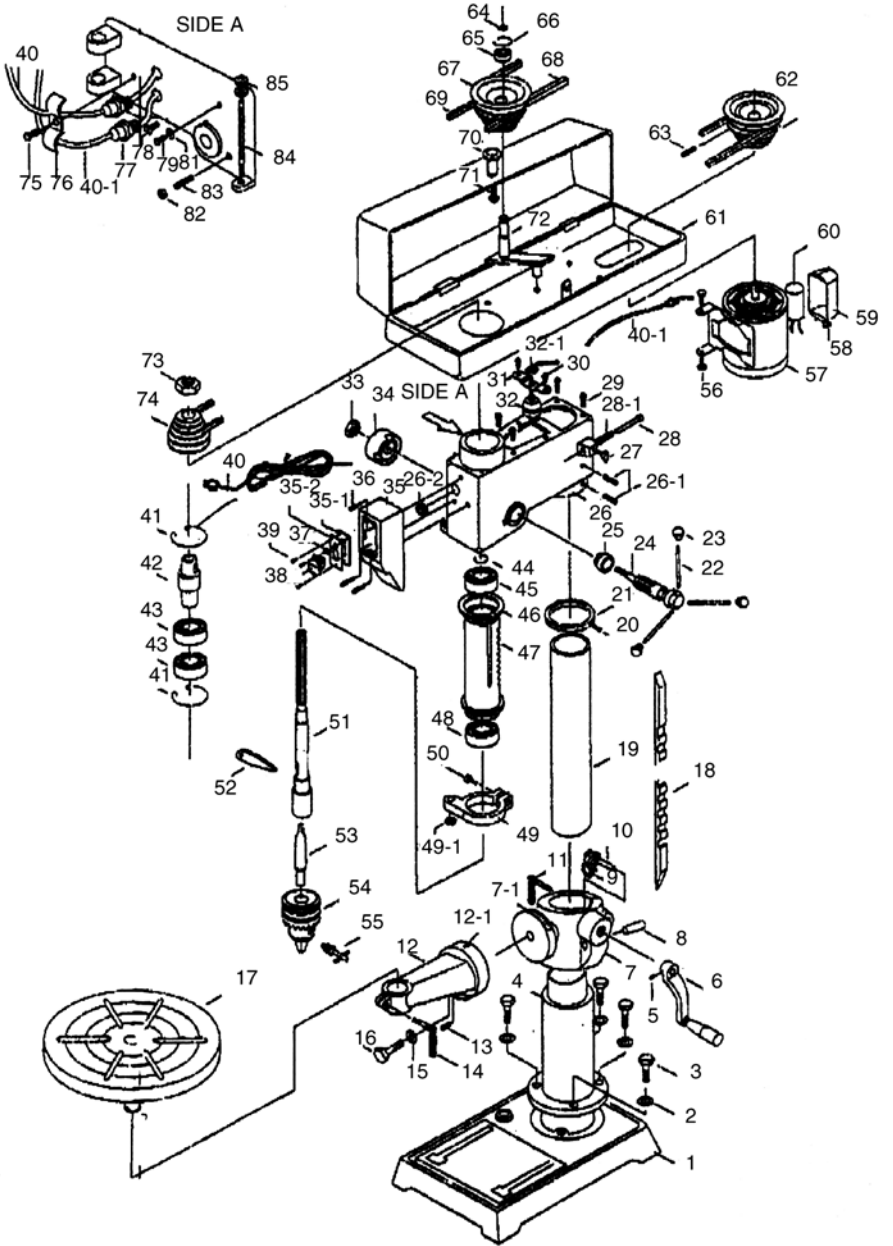
## Lubrication

All motor ball bearings are permanently lubricated. No further lubrication is necessary.

Periodically lubricate the splines (grooves) in the spindle (58) and teeth of the quill (56).

Periodically apply a light coating of grease to the column and rack (table height adjuster).

**13-1/2" 3/4 HP  
16 Speed Bench Drill Press**  
Product No. 200225  
Mod No. JDP-13



**13-1/2" 3/4 HP  
16 Speed Floor Drill Press**  
Product No. 200275  
Mod No. JDP-13F

# 13-1/2" 3/4 HP 16 Speed Bench Drill Press & 13-1/2" 3/4 HP 16 Speed Floor Drill Press

Ref.	Part No.	Description	Req.	Ref.	Part No.	Description	Req.
01	PDN-JDP-1301	Base Bench Model	1	38	PDN-JDP-1338	Power Switch	1
01	PDN-JDP-13F01	Base Floor Model	1	39	PDN-JDP-1339	Screw	3
02	PDN-JDP-1302	Washer	4	40	PDN-JDP-1340	Power Cord	1
03	PDN-JDP-1303	Bolt	4	40-1	PDN-JDP-1340-1	Motor Cord	1
04	PDN-JDP-13F04	Base Flange Floor Model	1	41	PDN-JDP-1341	Snap Ring	2
04	PDN-JDP-1304	Base Flange	1	42	PDN-JDP-1342	Driver Sleeve	1
05	PDN-JDP-1305	Set Screw	1	43	PDN-JDP-1343	Ball Bearing	2
06	PDN-JDP-1306	Table Height Adjustable Handle	1	44	PDN-JDP-1344	Snap Ring	1
07	PDN-JDP-1307	Table Bracket	1	45	PDN-JDP-1345	Ball Bearing	1
7-1	PDN-JDP-137-1	Scale	1	46	PDN-JDP-1346	Rubber Gasket	1
08	PDN-JDP-1308	Gear Shaft	1	47	PDN-JDP-1347	Quill	1
09	PDN-JDP-1309	Gear	1	48	PDN-JDP-1348	Ball Bearing	1
10	PDN-JDP-1310	Worm	1	49	PDN-JDP-1349	Depth Gauge Holder	1
11	PDN-JDP-1311	Clamp Blot	1	49-1	PDN-JDP-1349-1	Nut	1
12	PDN-JDP-1312	Table Arm	1	50	PDN-JDP-1350	Screw	1
12-1	PDN-JDP-1312-1	Zero Mark	1	51	PDN-JDP-1351	Spindle	1
13	PDN-JDP-1313	Set Screw	1	52	PDN-JDP-1352	Punch	1
14	PDN-JDP-1314	Clamp Blot	1	53	PDN-JDP-1353	Arbor	1
15	PDN-JDP-1315	Washer	1	54	PDN-JDP-1354	Chuck	1
16	PDN-JDP-1316	Bolt	1	55	PDN-JDP-1355	Key	1
17	PDN-JDP-1317	Table	1	56	PDN-JDP-1356	Bolt	2
18	PDN-JDP-13F18	Rack Floor Model	1	57	PDN-JDP-1357	Motor	1
18	PDN-JDP-1318	Rack	1	58	PDN-JDP-1358	Screw	2
19	PDN-JDP-1319	Column	1	59	PDN-JDP-1359	Capacitor Holder	1
19	PDN-JDP-13F19	Column Floor Model	1	60	PDN-JDP-1360	Capacitor	1
20	PDN-JDP-1320	Screw	1	61	PDN-JDP-1361	Pulley Guard	1
21	PDN-JDP-1321	Rack Collar	1	62	PDN-JDP-1362	Motor Pulley	1
22	PDN-JDP-1322	Feed Handle	3	63	PDN-JDP-1363	Set Screw	1
23	PDN-JDP-1323	Handle Knob	3	64	PDN-JDP-1364	Snap Ring	1
24	PDN-JDP-1324	Pinion Shaft	1	65	PDN-JDP-1365	Ball Bearing	1
25	PDN-JDP-1325	Scale Sleeve	1	66	PDN-JDP-1366	Snap Ring	1
26	PDN-JDP-1326	Head	1	67	PDN-JDP-1367	Middle Pulley	1
26-1	PDN-JDP-1326-1	Set Screw	2	68	PDN-JDP-1368	V-Belt	1
26-2	PDN-JDP-1326-2	Rubber Bushing	1	69	PDN-JDP-1369	V-Belt	1
27	PDN-JDP-1327	Set Screw	2	70	PDN-JDP-1370	Knob	1
28	PDN-JDP-1328	Belt Tension Adjustable Rod	1	71	PDN-JDP-1371	Screw	1
28-1	PDN-JDP-1328-1	Spring	1	72	PDN-JDP-1372	Middle Pulley Frame	1
29	PDN-JDP-1329	Screw	4	73	PDN-JDP-1373	Nut	1
30	PDN-JDP-1330	Screw	2	74	PDN-JDP-1374	Spindle Pulley	1
31	PDN-JDP-1331	Lamp Frame	1	75	PDN-JDP-1375	Screw	1
32	PDN-JDP-1332	Lamp Holder	1	76	PDN-JDP-1376	Cord Fixer	1
32-1	PDN-JDP-1332-1	Nut	1	77	PDN-JDP-1377	Cord Clamp	2
33	PDN-JDP-1333	Nut	1	78	PDN-JDP-1378	Screw	1
34	PDN-JDP-1334	Spring and Cap	1	79	PDN-JDP-1379	Screw	1
35	PDN-JDP-1335	Switch Box	1	81	PDN-JDP-1381	Washer	1
35-1	PDN-JDP-1335-1	Washer Pad	1	82	PDN-JDP-1382	Nut	1
35-2	PDN-JDP-1335-2	Switch Mounting Plate	1	83	PDN-JDP-1383	Set Screw	1
36	PDN-JDP-1336	Screw	3	84	PDN-JDP-1384	Depth Stick Rod	1
37	PDN-JDP-1337	Lamp Switch	1	85	PDN-JDP-1385	Nut	2

## Ordering Replacement Parts

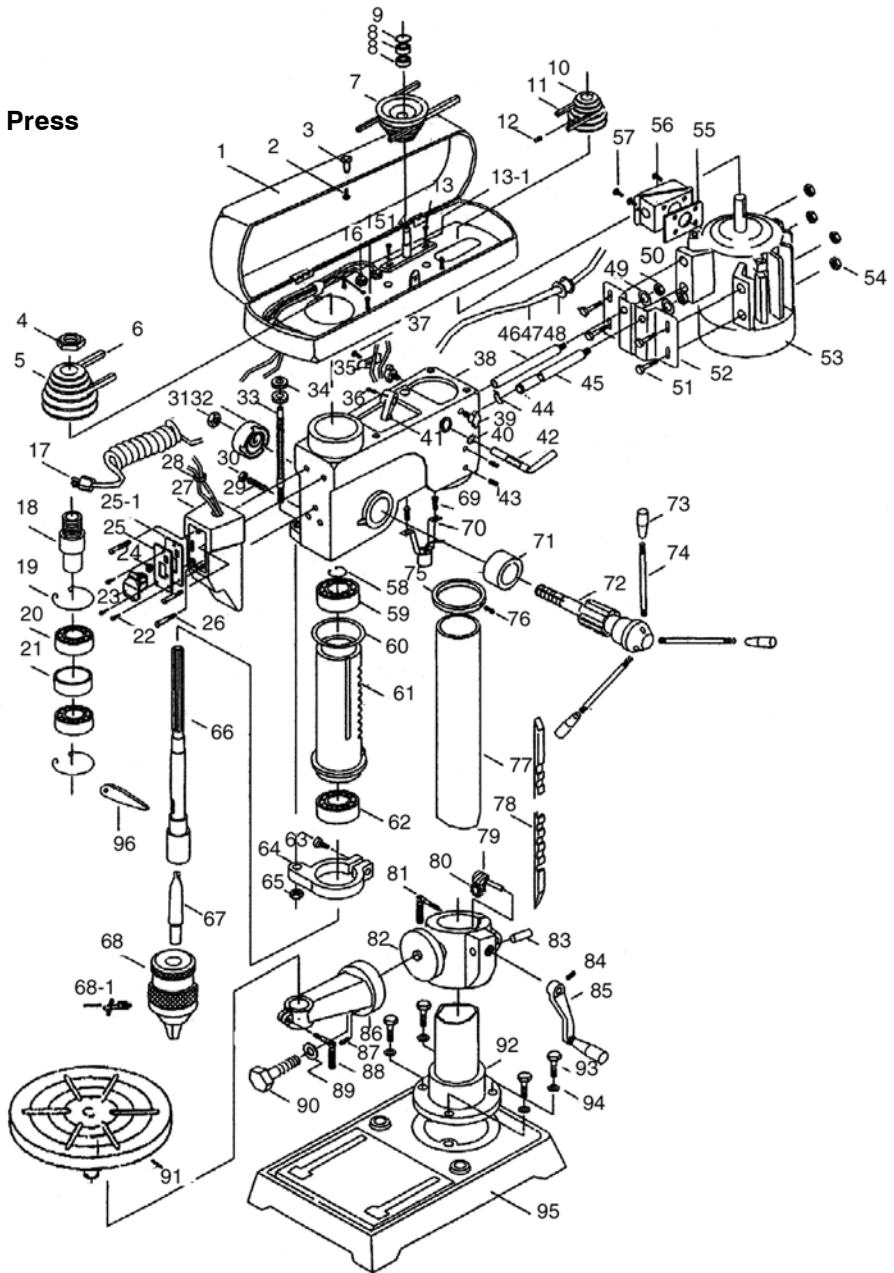
Replacement parts may be ordered from your local distributor or directly from SureWex. When ordering replacement parts always provide the following information:

1. The model number and serial number of the machine.
2. The part number.
3. The part name.
4. The desired quantity of the part.

**17" 1 HP  
16 Speed Floor Drill Press**

Product No. **200278**

Mod No. **JDP-17F**



# 17" 1 HP 16 Speed Floor Drill Press

Ref.	Part No.	Description	Req.	Ref.	Part No.	Description	Req.
01	PDN-JDP-1701	Guard Cover	1	49	PDN-JDP-1749	Spring Washer	2
02	PDN-JDP-1702	Pan Head Screw	1	50	PDN-JDP-1750	Nut	2
03	PDN-JDP-1703	Knob	1	51	PDN-JDP-1751	Hex Head Screw	4
04	PDN-JDP-1704	Nut	1	52	PDN-JDP-1752	Motor Mount	1
05	PDN-JDP-1705	Spindle Pulley	1	53	PDN-JDP-1753	Motor	1
06	PDN-JDP-1706	V-Belt	1	54	PDN-JDP-1754	Nut	4
07	PDN-JDP-1707	Middle Pulley	1	55	PDN-JDP-1755	Rubber	1
08	PDN-JDP-1708	Ball Bearing	2	56	PDN-JDP-1756	Junction Box	1
09	PDN-JDP-1709	Retaining Ring	1	57	PDN-JDP-1757	Screw	1
10	PDN-JDP-1710	Motor Pulley	1	58	PDN-JDP-1758	Retaining Ring	1
11	PDN-JDP-1711	V-Belt	1	59	PDN-JDP-1759	Ball Bearing	1
12	PDN-JDP-1712	Set Screw	1	60	PDN-JDP-1760	Rubber Washer	1
13	PDN-JDP-1713	Screw	2	61	PDN-JDP-1761	Quill	1
13-1	PDN-JDP-1713-1	Washer	2	62	PDN-JDP-1762	Thrust Bearing	1
14	PDN-JDP-1714	Pulley Support Plate	1	63	PDN-JDP-1763	Screw	1
15	PDN-JDP-1715	Screw	2	64	PDN-JDP-1764	Clamping Seat Depth Stop	1
16	PDN-JDP-1716	Cord Protector	1	65	PDN-JDP-1765	Lock Nut	1
17	PDN-JDP-1717	Electrical Cord	1	66	PDN-JDP-1766	Spindle	1
18	PDN-JDP-1718	Pulley Insert	1	67	PDN-JDP-1767	Arbor	1
19	PDN-JDP-1719	Retaining Ring	2	68	PDN-JDP-1768	Chuck	1
20	PDN-JDP-1720	Ball Bearing	2	68-1	PDN-JDP-1768-1	Key	1
21	PDN-JDP-1721	Bearing Spacer	1	69	PDN-JDP-1769	Screw	2
22	PDN-JDP-1722	Pan Head Screw	3	70	PDN-JDP-1770	Lamp Bracket	1
23	PDN-JDP-1723	Start/Stop Switch	1	71	PDN-JDP-1771	Spacer	1
24	PDN-JDP-1724	Light Switch Push Button	1	72	PDN-JDP-1772	Pinion, Feed	1
25	PDN-JDP-1725	Switch Plate	1	73	PDN-JDP-1773	Knob	3
25-1	PDN-JDP-1725-1	Rubber	1	74	PDN-JDP-1774	Handle	3
26	PDN-JDP-1726	Pan Head Screw	3	75	PDN-JDP-1775	Rack Collar	1
27	PDN-JDP-1727	Box Switch Plate	1	76	PDN-JDP-1776	Set Screw	1
28	PDN-JDP-1728	Cord Clamp	1	77	PDN-JDP-1777	Column	1
29	PDN-JDP-1729	Bolt	1	78	PDN-JDP-1778	Rack Gear	1
30	PDN-JDP-1730	Hex Nut	1	79	PDN-JDP-1779	Elevating Worm	1
31	PDN-JDP-1731	Hex Nut	1	80	PDN-JDP-1780	Gear	1
32	PDN-JDP-1732	Tension Spring Assembly	1	81	PDN-JDP-1781	Bolt Clamp	1
33	PDN-JDP-1733	Post Depth Stop	1	82	PDN-JDP-1782	Table Arm Bracket	1
34	PDN-JDP-1734	Lock Nut	2	83	PDN-JDP-1783	Gear Shaft	1
35	PDN-JDP-1735	Cord Clamp	1	84	PDN-JDP-1784	Set Screw	1
36	PDN-JDP-1736	Lock Pin	1	85	PDN-JDP-1785	Sleeve and Rod Assembly	1
37	PDN-JDP-1737	Screw	1	86	PDN-JDP-1786	Table Bracket	1
38	PDN-JDP-1738	Head	1	87	PDN-JDP-1787	Set Screw	1
39	PDN-JDP-1739	Thumb Screw	1	88	PDN-JDP-1788	Table Lock Handle	1
40	PDN-JDP-1740	Retaining Ring	1	89	PDN-JDP-1789	Washer	1
41	PDN-JDP-1741	Adjusting Lever	1	90	PDN-JDP-1790	Blot	1
42	PDN-JDP-1742	Lever Shaft Assembly	1	91	PDN-JDP-1791	Table	1
43	PDN-JDP-1743	Set Screw	2	92	PDN-JDP-1792	Flange	1
44	PDN-JDP-1744	Retaining Ring	1	93	PDN-JDP-1793	Bolt	1
45	PDN-JDP-1745	Motor Support Bracket	1	94	PDN-JDP-1794	Spring Washer	4
46	PDN-JDP-1746	Motor Support Bracket	1	95	PDN-JDP-1795	Bake	1
47	PDN-JDP-1747	Electrical Cord	1	96	PDN-JDP-1796	Drift Key	1
48	PDN-JDP-1748	Strain Relief	1				

## Ordering Replacement Parts

Replacement parts may be ordered from your local distributor or directly from SureWerx.

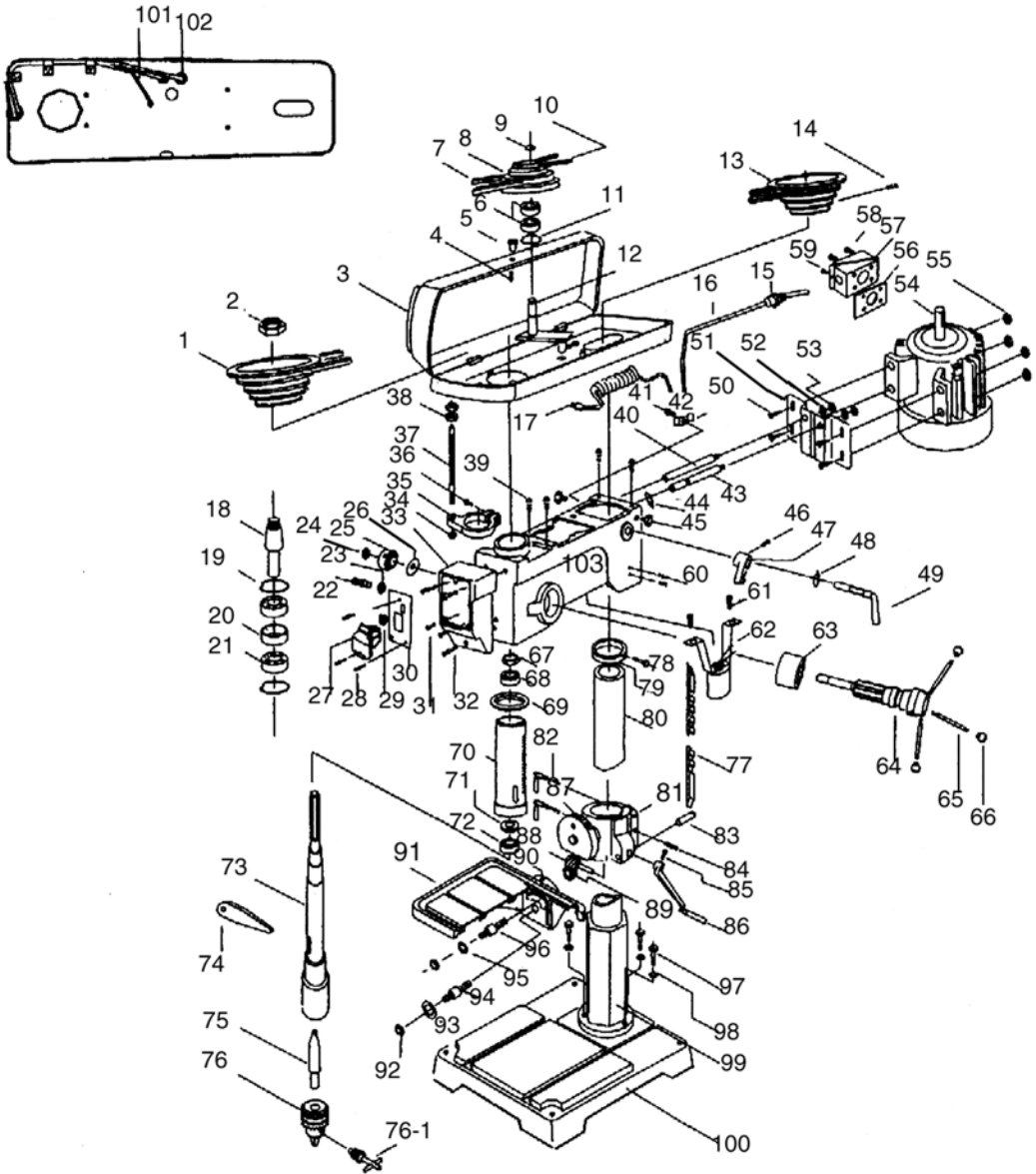
When ordering replacement parts always provide the following information:

1. The model number and serial number of the machine.
2. The part number.
3. The part name.
4. The desired quantity of the part.

**22" 1-1/2 HP  
12 Speed Drill Press**

Product No. 200357

Mod No. JDP-22F





## 22" 1-1/2 HP 12 Speed Drill Press

Ref.	Part No.	Description	Req.	Ref.	Part No.	Description	Req.
01	PDN-JDP-2201	Spindle Pulley	1	53	PDN-JDP-2253	Hex Nut	2
02	PDN-JDP-2202	Nut	1	54	PDN-JDP-2254	Motor	1
03	PDN-JDP-2203	Pulley Cover	1	55	PDN-JDP-2255	Hex Nut	4
04	PDN-JDP-2204	Screw	1	56	PDN-JDP-2256	Rubber	1
05	PDN-JDP-2205	Knob	1	57	PDN-JDP-2257	Junction Box	1
06	PDN-JDP-2206	Bearing	2	58	PDN-JDP-2258	Screw	4
07	PDN-JDP-2207	V-Belt	1	59	PDN-JDP-2259	Screw	1
08	PDN-JDP-2208	Middle Pulley	1	60	PDN-JDP-2260	Set Screw	2
09	PDN-JDP-2209	Retaining Ring	1	61	PDN-JDP-2261	Pan Screw	2
10	PDN-JDP-2210	V-Belt	1	62	PDN-JDP-2262	Lamp Bracket	1
11	PDN-JDP-2211	Retaining Ring	1	63	PDN-JDP-2263	Spacer	1
12	PDN-JDP-2212	Shaft Assembly	1	64	PDN-JDP-2264	Pinion Shaft	1
13	PDN-JDP-2213	Motor Pulley	1	65	PDN-JDP-2265	Feeding Handle	3
14	PDN-JDP-2214	Screw	1	66	PDN-JDP-2266	Knob	3
15	PDN-JDP-2215	Strain Relief	1	67	PDN-JDP-2267	Spindle Nut	1
16	PDN-JDP-2216	Motor Cord	1	68	PDN-JDP-2268	Bearing	1
17	PDN-JDP-2217	Cord With Plug	1	69	PDN-JDP-2269	Quill Gasket	1
18	PDN-JDP-2218	Pulley Insert	1	70	PDN-JDP-2270	Quill	1
19	PDN-JDP-2219	Retaining Ring	2	71	PDN-JDP-2271	Thrust Bearing	1
20	PDN-JDP-2220	Bearing Spacer	1	72	PDN-JDP-2272	Bearing	1
21	PDN-JDP-2221	Bearing	2	73	PDN-JDP-2273	Spindle	1
22	PDN-JDP-2222	Bolt	1	74	PDN-JDP-2274	Drift Key	1
23	PDN-JDP-2223	Hex Nut	1	75	PDN-JDP-2275	Arbor	1
24	PDN-JDP-2224	Hex Nut	1	76	PDN-JDP-2276	Chuck	1
25	PDN-JDP-2225	Spring and Cap	1	76-1	PDN-JDP-2276-1	Key	1
26	PDN-JDP-2226	Washer	1	77	PDN-JDP-2277	Rack	1
27	PDN-JDP-2227	Start/Stop Switch	1	78	PDN-JDP-2278	Screw	1
28	PDN-JDP-2228	Screw	3	79	PDN-JDP-2279	Rack Collar	1
29	PDN-JDP-2229	Light Switch	1	80	PDN-JDP-2280	Quill	1
30	PDN-JDP-2230	Switch Plate	1	81	PDN-JDP-2281	Table Bracket	1
31	PDN-JDP-2231	Screw	2	82	PDN-JDP-2282	Table Handle	1
32	PDN-JDP-2232	Screw	3	83	PDN-JDP-2283	Gear Shaft	1
33	PDN-JDP-2233	Switch Box	1	84	PDN-JDP-2284	Set Screw	3
34	PDN-JDP-2234	Nut	1	85	PDN-JDP-2285	Hex Head Screw	1
35	PDN-JDP-2235	Clamping Seat Depth Stop	1	86	PDN-JDP-2286	Crank Sleeve Handle	1
36	PDN-JDP-2236	Screw	1	87	PDN-JDP-2287	Tilt Scale	1
37	PDN-JDP-2237	Post Depth Stop	1	88	PDN-JDP-2288	Elevating Worm	1
38	PDN-JDP-2238	Lock Nut	2	89	PDN-JDP-2289	Helical Gear	1
39	PDN-JDP-2239	Screw	2	90	PDN-JDP-2290	Zero Scale	1
40	PDN-JDP-2240	Motor Bracket Support	1	91	PDN-JDP-2291	Table	1
41	PDN-JDP-2241	Screw	1	92	PDN-JDP-2292	Hex Nut	2
42	PDN-JDP-2242	Cord Clamp	1	93	PDN-JDP-2293	Washer	1
43	PDN-JDP-2243	Motor Bracket Support	1	94	PDN-JDP-2294	Arm Stud	1
44	PDN-JDP-2244	Retaining Ring	1	95	PDN-JDP-2295	Washer	1
45	PDN-JDP-2245	Wing Screw	2	96	PDN-JDP-2296	Arm Stud	1
46	PDN-JDP-2246	Screw	1	97	PDN-JDP-2297	Bolt Hex Head	3
47	PDN-JDP-2247	Adjusting Lever	1	98	PDN-JDP-2298	Spring Washer	3
48	PDN-JDP-2248	Retaining Ring	1	99	PDN-JDP-2299	Flange	1
49	PDN-JDP-2249	Lever Shaft	1	100	PDN-JDP-22100	Base	1
50	PDN-JDP-2250	Hex Head Screw	4	101	PDN-JDP-22101	Cord for Clamp	1
51	PDN-JDP-2251	Motor Plate	1	102	PDN-JDP-22102	Cord Protect	1
52	PDN-JDP-2252	Spring Washer	2	103	PDN-JDP-22103	Head	1

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3. The part name.
4. The desired quantity of the part.

