



Operating Instructions and Parts Manual Drill Press

Model: JDP-15M/MF



WMH TOOL GROUP

2420 Vantage Drive
Elgin, Illinois 60123
Ph.: 800-274-6848
www.wmhtoolgroup.com

Part No. M-354165

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This manual has been prepared for the owner and operators of a JDP-15M/MF Drill Press. Its purpose, aside from machine operation, is to promote safety through the use of accepted correct operating and maintenance procedures. Completely read the safety and maintenance instructions before operating or servicing the machine. To obtain maximum life and efficiency from your JET Drill Press, and to aid in using the machine safely, read this manual thoroughly and follow instructions carefully.

Warranty

The WMH Tool Group warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Repair Stations located throughout the United States can give you quick service.

In most cases, any one of these WMH Tool Group Repair Stations can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET, Performax, Wilton, or Powermatic tools.

For the name of an Authorized Repair Station in your area, please call 1-800-274-6848, or visit www.wmhtoolgroup.com

More Information

Remember, the WMH Tool Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local WMH Tool Group distributor, or visit www.wmhtoolgroup.com

WMH Tool Group Warranty

The WMH Tool Group (including Performax, Wilton and Powermatic brands) makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follow: 1 YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE. This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, repair or alterations outside our facilities, or to a lack of maintenance.

THE WMH TOOL GROUP LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD SPECIFIED ABOVE, FROM THE DATE THE PRODUCT WAS PURCHASED AT RETAIL. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. THE WMH TOOL GROUP SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an Authorized Repair Station designated by our office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product, or refund the purchase price if we cannot readily and quickly provide a repair or replacement, if you are willing to accept a refund. We will return repaired product or replacement at WMH Tool Group's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of WMH Tool Group's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights; you may also have other rights, which vary from state to state.

The WMH Tool Group sells through distributors only. Members of the WMH Tool Group reserve the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment, which they may deem necessary for any reason whatsoever.

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The specifications in this manual are given as general information and are not binding. WMH Tool Group reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.

Warnings

1. Read and understand the entire owners manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This drill press is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a drill press, do not use until proper training and knowledge have been obtained.
5. Do not use this drill press for other than its intended use. If used for other purposes, WMH Tool Group disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this drill press. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this drill press, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead based paint.
 - Crystalline silica from bricks, cement and other masonry products.
 - Arsenic and chromium from chemically treated lumber.Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.
10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
16. Make sure the drill press is firmly secured to the floor or bench before use.
17. Check damaged parts. Before further use of the machine, 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.
18. Provide for adequate space surrounding work area and non-glare, overhead lighting.
19. Keep the floor around the machine clean and free of scrap material, oil and grease.

Warnings

20. Keep visitors a safe distance from the work area. **Keep children away.**
21. Make your workshop child proof with padlocks, master switches or by removing starter keys.
22. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
23. Maintain a balanced stance at all times so that you do not fall or lean against the spindle or other moving parts. Do not overreach or use excessive force to perform any machine operation.
24. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
25. Use recommended accessories; improper accessories may be hazardous.
26. Maintain tools with care. Keep drill bits sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
27. Make sure the work piece is securely attached or clamped to the table. Never use your hand to hold the work piece.
28. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
29. Do not stand on the machine. Serious injury could occur if the machine tips over.
30. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
31. Remove loose items and unnecessary work pieces from the area before starting the machine.

Familiarize yourself with the following safety notices used in this manual:

CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

WARNING This means that if precautions are not heeded, it may result in serious injury or possibly even death.

- - SAVE THESE INSTRUCTIONS - -

Specifications

| Model Number: | JDP-15M | JDP-15MF |
|--|----------------------------|-----------------|
| Stock Number | 354165..... | 354166 |
| Swing..... | 15" | 15" |
| Type | Bench | Floor |
| Drilling Capacity | 5/8" | 5/8" |
| Chuck Size | 5/8" | 5/8" |
| Spindle Travel | 3-1/8" | 3-1/8" |
| Spindle Distance to Base | 16-1/2" | 48" |
| Spindle Distance to Table (max.) | 24" | 29" |
| Table Size (Length x Width)..... | 16-1/2" x 13" | 16-1/2" x 13" |
| Spindle Taper..... | MT-2/JT-3 | MT-2/JT-3 |
| Column Diameter | 2-7/8" | 2-7/8" |
| Number of Spindle Speeds | 16 | 16 |
| Range of Spindle Speeds (RPM)..... | 200 - 3,630 | 200 - 3,630 |
| Base Size | 10-7/8" x 18-1/2" | 11" x 19-3/4" |
| Overall Dimensions (H x W x D) | 39-1/2" x 13" x 31"..... | 63" x 13" x 31" |
| Motor | 3/4HP, 115/230V, 60Hz, 1Ph | same |
| Net Weight | 156 lbs. | 161 lbs. |
| Gross Weight | 163 lbs. | 167 lbs. |
| Carton Size (L x W x H/in):..... | 32 x 22 x 12 | 56 x 20 x 11 |

Shipping Contents

Unpack the carton and verify that all parts listed below are included.

Main Parts

- 1 ea Head Assembly
- 1 ea Table
- 1 set Column and Table Bracket Assembly
- 1 ea Base

Additional Parts

- 1. 1 set Chuck and Chuck Key
- 2. 1 pc Arbor
- 3. 1 pc Drift Key
- 4. 1 pc Table Crank Handle
- 5. 1 pc Table Lock Handle
- 6. 1 pc Column Lock Handle
- 7. 3 pcs Downfeed Handles and Knobs
- 8. 4 pcs M10 x 40 Hex Cap Screws
- 9. 1 set Hex Wrenches (3mm, 5mm, 6mm)

Other Material

- 1 ea Owner's Manual
- 1 ea Warranty Registration Card

Required Tools

- 1. 17mm Box Wrench or a 6" – 8" Adjustable Wrench
- 2. 15/16" wrench



Additional Parts

Assembly

⚠WARNING

Read and understand all assembly instructions before attempting assembly! Failure to comply may cause serious injury!

Before Assembly

1. Remove the contents from the shipping container.
2. Compare the contents of the shipping container with the list found above. Report any shortages or damage to your JET distributor.
3. Clean all rust protected surfaces with kerosene or a light solvent. Do not use lacquer thinner, paint thinner, or gasoline. These will damage plastic components and painted surfaces.

Column Assembly

Referring to Figure 1:

1. Place the base (A) on a level floor.
2. Place the column assembly (B) on the base (A) and align the holes in the column support with the holes in the base.

Note: The column shown in Figure 1 is for the JDP-15MF. While the JDP-15M column is slightly different in appearance, the assembly procedure is the same.

3. Using a 17mm wrench, secure the column (B) with four M10 x 40 hex cap screws (C) to the base.

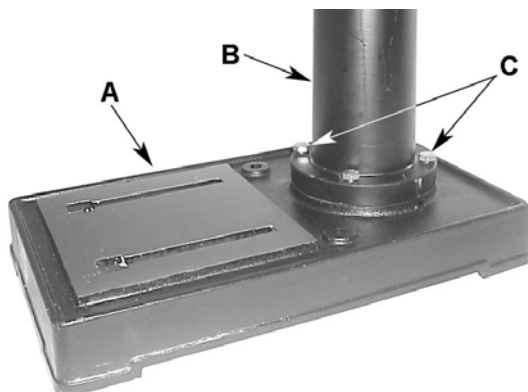


Figure 1

Table Bracket

When shipped, the *rack ring* and *rack* are bundled together with the column in plastic wrap.

Referring to Figures 2 and 3:

4. Remove the wrap and take the rack ring (D) and rack (B) off the column (C).
5. Install the table bracket (A) together with the rack (B) as shown in Figure 2.

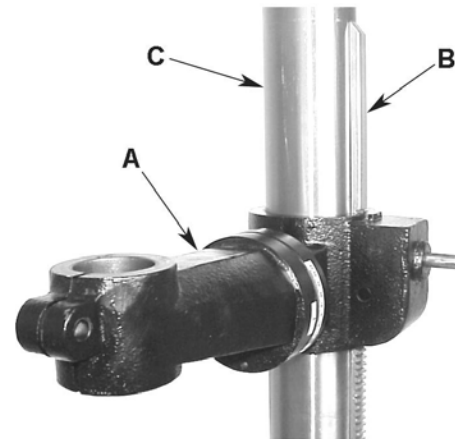


Figure 2

6. Slide the rack ring (D) over the column (C), placing it so it rests against the rack (B) as shown in Figure 3 and tighten firmly.

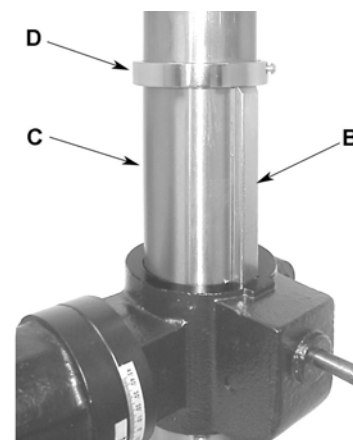


Figure 3

Crank Handle and Table Lock Handle

Referring to Figure 4 (shown already assembled):

1. Loosen the setscrew (B) on the *table crank handle* (A).
2. Slide the handle (A) onto the table bracket shaft.
3. Turn the handle until the setscrew is opposite the flat section on the shaft, and tighten the setscrew to secure the handle.
4. Install the *table lock handle* (C), but do not tighten.

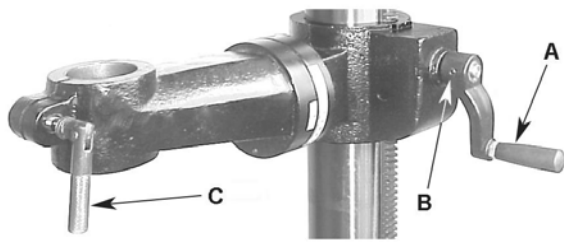


Figure 4

Column Lock Handle

Referring to Figure 5:

Thread the *column lock handle* (D) into the table bracket (E).

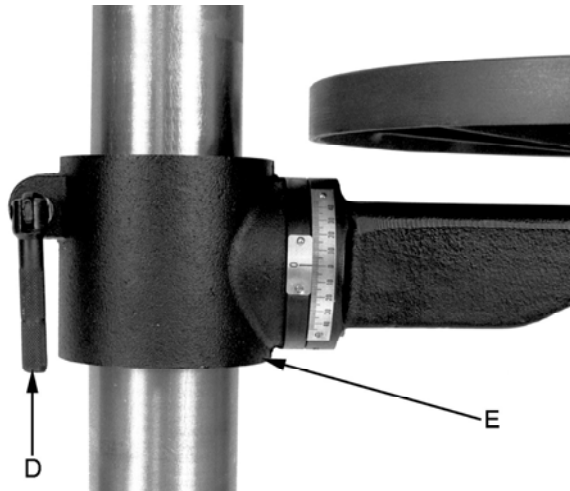


Figure 5

Table Installation

Referring to Figure 6:

1. Place the *table* (A) on the *bracket* (B).
2. Tighten the *table lock handle* (C).

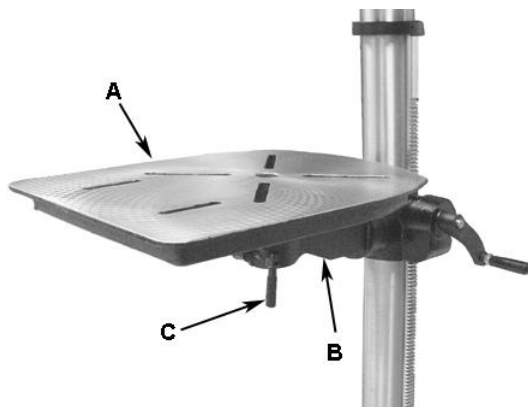


Figure 6

Head Assembly

Referring to Figure 7:

1. With the aid of a second person, carefully lift the *head* onto the column top and slide it down into position



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

2. Rotate head assembly until sides of the pulley cover are parallel with the sides of the base.
3. Tighten two setscrews (A) with a 5mm hex wrench (provided) until they are snug.



Figure 7

4. Install three *downfeed handles* (B) into the downfeed hub (C).

Chuck and Arbor Installation

Referring to Figure 8:

1. Twist the chuck (B) to retract the chuck jaws if they are exposed.
2. Install the chuck (B) to the arbor (A) tightly.
3. Insert the chuck and arbor assembly into the spindle (C). Pull the downfeed handle down to press the arbor in place.

Note: Put a piece of scrap wood (D) on the table to protect the chuck nose when pulling the downfeed handle (E) down to press into place.

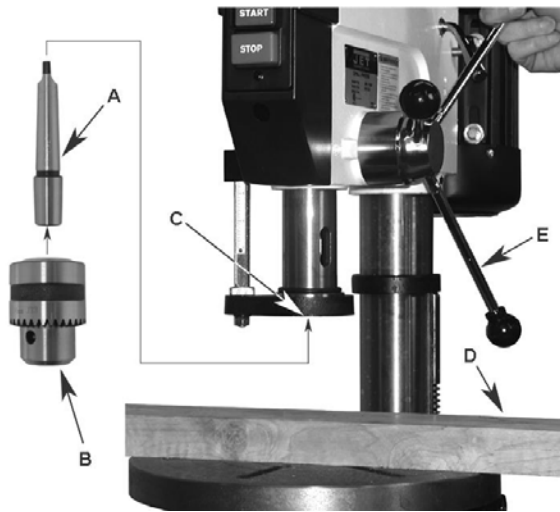


Figure 8

Chuck and Arbor Removal

Referring to Figure 9:

1. Unplug machine from the power source.
2. Raise the table until it is about seven inches below the chuck.
3. Place a piece of scrap wood on the table, and lower quill (A) using the downfeed handle.
4. Rotate spindle to align the keyhole in the spindle with the keyhole in the quill.
5. Insert the drift key (B) into the aligned slots and tap lightly. The chuck and arbor assembly should fall from the spindle.

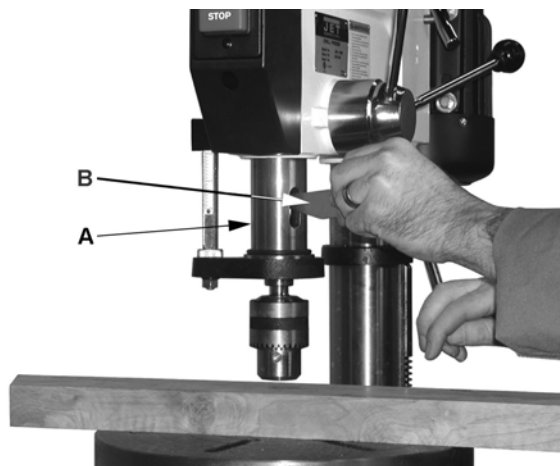


Figure 9

Adjustment

Depth Stop Adjustment

Referring to Figure 10:

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

1. Use a pencil to mark the depth the bit will drill into the workpiece.
2. With the drill bit in the chuck, lower downfeed handle to advance bit to your mark (A).
3. With your other hand, advance the lock nuts (B) on the depth stop rod until they are snug to the seat (C).
4. The drill bit will now advance to this point.
5. To release, advance the nuts counterclockwise to the top of the depth stop.

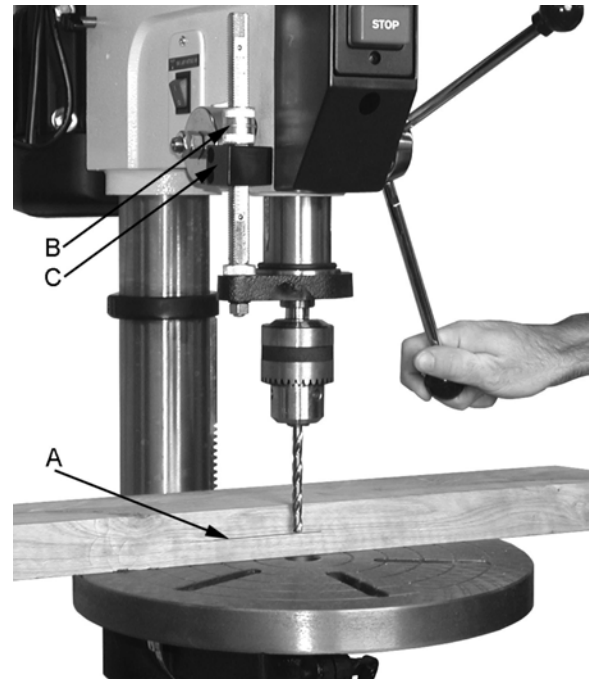


Figure 10

Changing Spindle Speeds

A spindle speed and pulley/belt arrangement chart is found on the inside of the pulley cover (D, Fig. 11). The chart is also shown in Figure 12. Refer to this chart whenever changing speeds.

To change spindle speeds:

1. Unplug the machine from the power source.
2. Loosen two bar knobs (E, Fig. 11) found on each side of the head assembly.
3. Rotate the tension adjuster clockwise (F, Fig. 11) to bring the motor base as close to the head as possible.
4. For desired speed, change the location of belts per pulley/belt arrangement chart.
5. Rotate the tension adjuster counterclockwise (F, Fig. 11) to tension the belts.

6. Tighten two bar knobs (E, Fig. 11). Belts are properly tensioned when finger and thumb pressure midway between the two pulleys causes approximately $\frac{1}{2}$ " deflection.

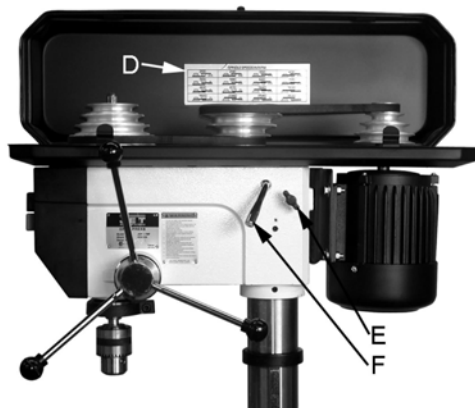


Figure 11

| SPINDLE SPEEDS IN R.P.M. | | | |
|--------------------------|------|------|------|
| 200 | 290 | 350 | 430 |
| 500 | 580 | 640 | 720 |
| 800 | 870 | 1440 | 1630 |
| 1820 | 2380 | 2540 | 3630 |

Figure 12

Return Spring Adjustment

The return spring is adjusted at the factory and should not need further adjustment. If adjustment is deemed necessary, follow the steps below while referring to Figure 13:

1. Unplug the machine from the power source.
2. Loosen two hex nuts (A). Do not remove.
3. Firmly hold the coil spring cover (B).
4. 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.
5. Tighten two hex nuts (A). Do not over-tighten. Nuts should not contact the housing when tight. The hex nuts should be tightened against each other.

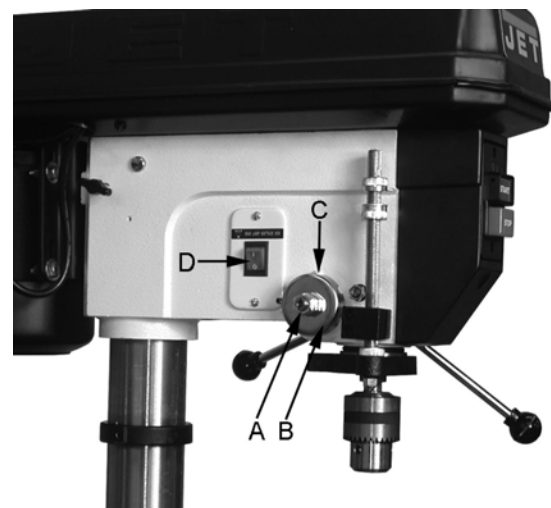


Figure 13

Work Light

Install a light bulb, no larger than 60 watts into the socket accessed from beneath the head. The rocker switch controls the light switch (D, Fig. 13).

Table Tilt Adjustment

The table tilt adjustments are made on the table bracket under the table.

To tilt the table (refer to Figures 14 and 15):

⚠CAUTION

In the following steps do not over loosen. This could result in the table assembly to separate from the column, fall and cause injury.

1. Loosen the socket head set screw (A) with a 3mm hex wrench.
2. Using a 15/16" wrench, loosen the hex cap screw (B), and tilt the table to the desired angle by aligning the arrow (C, Fig. 15) on the rotating part of the bracket to the desired angle (in degrees) displayed on the scale (D, Fig 15) at the base of the bracket.
3. Tighten the hex cap screw (B).
4. Tighten the socket head set screw (A).

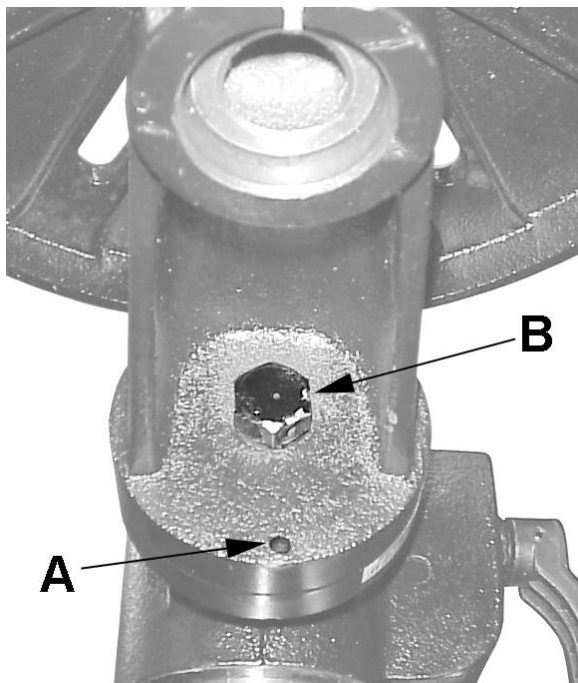


Figure 14

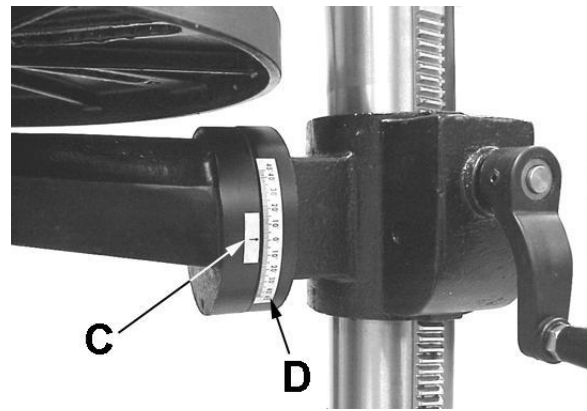


Figure 15

Operation

Installing Drills

Insert the drill into the chuck jaws about 1" (25.4mm) long. When using a small drill do not insert it so far that the jaws touch the flutes of the drill. Make sure that the drill is centered in the chuck before tightening the chuck with the key.

Positioning the Workpiece

Always place a piece of wood (or plywood) on the table. This will prevent "splintering" or making heavy burrs on the underside of the workpiece as the drill breaks through. The wood should contact the left side of the column.

Using the Vise

For the small workpiece that cannot be clamped to the table, use a drill press vise. The vise must be clamped or bolted to the table. Always use a back-up piece of scrap wood to cover the table. This protects both the table and the drill bit.

Basic Operation

Place material to be drilled in such a way as to come into contact with the left side of the column. This prevents the material from spinning.

⚠WARNING

If the work piece is not large enough to come into contact with the column, use a clamp or drill press vise that is securely fastened to the table! Failure to comply may cause serious injury!

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.

Generally speaking, the smaller the drill bit, the greater the RPM required. Wood requires higher speeds than metal. Metal is usually drilled at slower speeds.

In dusty environments, frequently blow out any dust that accumulates inside the motor.

Maintenance

⚠ WARNING

Before any intervention on the machine, disconnect it from the electrical supply by pulling out the plug or switching off the main switch! Failure to comply may cause serious injury.

A coat of automobile-type wax applied to the table and column will help to keep the surfaces clean.

If the power cord is worn, cut, or damaged in any way, have it replaced immediately.

Lubrication

All of the ball bearings are packed with grease at the factory. They require no further lubrication.

Periodically lubricate the gear, rack, table elevation mechanism, the splines (grooves) in the spindle, and the teeth of the quill with a #2 tube grease.

Electrical

115 Volt Operation

Referring to Figure 16:

As received from the factory, your drill press is ready to run at 115-volt operation. This drill press, when wired for 115 volt, is intended for use on a circuit that has an outlet and a plug that looks like the one illustrated in (A). A temporary adapter, which looks like the adapter shown in (B), may be used to connect this plug to a two-pole receptacle if a properly grounded outlet is not available. The temporary adapter should only be used until a properly grounded outlet can be installed by a qualified electrician. This adapter is not applicable in Canada. The green colored rigid ear, lug, or tab, extending from the adapter, must be connected to a permanent ground such as a properly grounded outlet box.

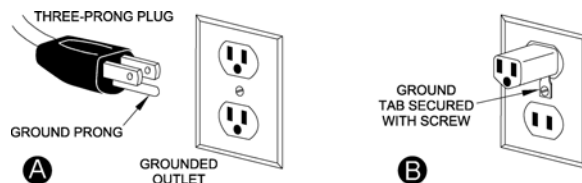


Figure 16

230 Volt Operation

Referring to Figure 17:

If 230V, single-phase operation is desired, the following instructions must be followed:

1. Disconnect the machine from the power source.
2. The JET drill press motor has four numbered leads that are factory connected for 115V operation, as shown in (A). For 230V operation reconnect the leads as shown in (B).
3. The 115V attachment plug (C), supplied with the drill press, must be replaced with a UL/CSA listed plug suitable for 230V operation (D). Contact your local Authorized JET Service Center or qualified electrician for proper procedures to install the plug. The drill press must comply with all local and national codes after the 230-volt plug is installed.
4. The drill press with a 230-volt plug should only be connected to an outlet having the same configuration as shown in (D). No adapter is available nor should be used with the 230-volt plug.

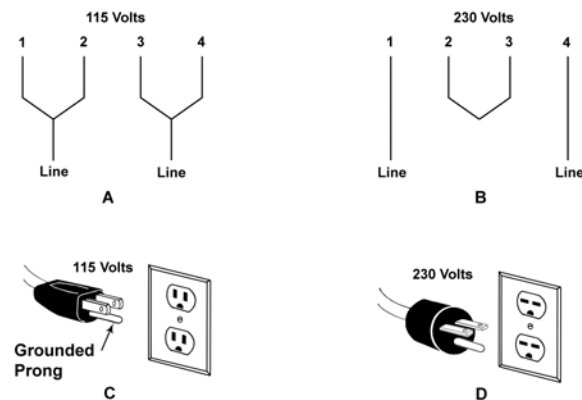


Figure 17

Grounding Instructions

⚠CAUTION

This tool must be grounded while in use to protect the operator from electric shock.

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 tool 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.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a 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 a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded. Use only three wire extension cords that have three-prong grounding plugs and three-pole receptacles that accept the tool's plug.

Repair or replace a damaged or worn cord immediately.

Extension 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 machine will draw. An undersized cord will cause a drop in the line voltage resulting in power loss and overheating. The table following shows the correct size to use depending on the cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. Remember, the smaller the gauge number, the heavier the cord.

| Length of Cord | AWG |
|----------------|-----|
| 0-25 | 16 |
| 25-50 | 14 |

The drill press with a 230-volt plug should only be connected to an outlet having the same configuration (D, Fig. 17). No adapter is available or should be used with the 230-volt plug.

Important: In all cases (115 or 230 volts), make certain the receptacle in question is properly grounded. If you are not sure, have a registered electrician check the receptacle.

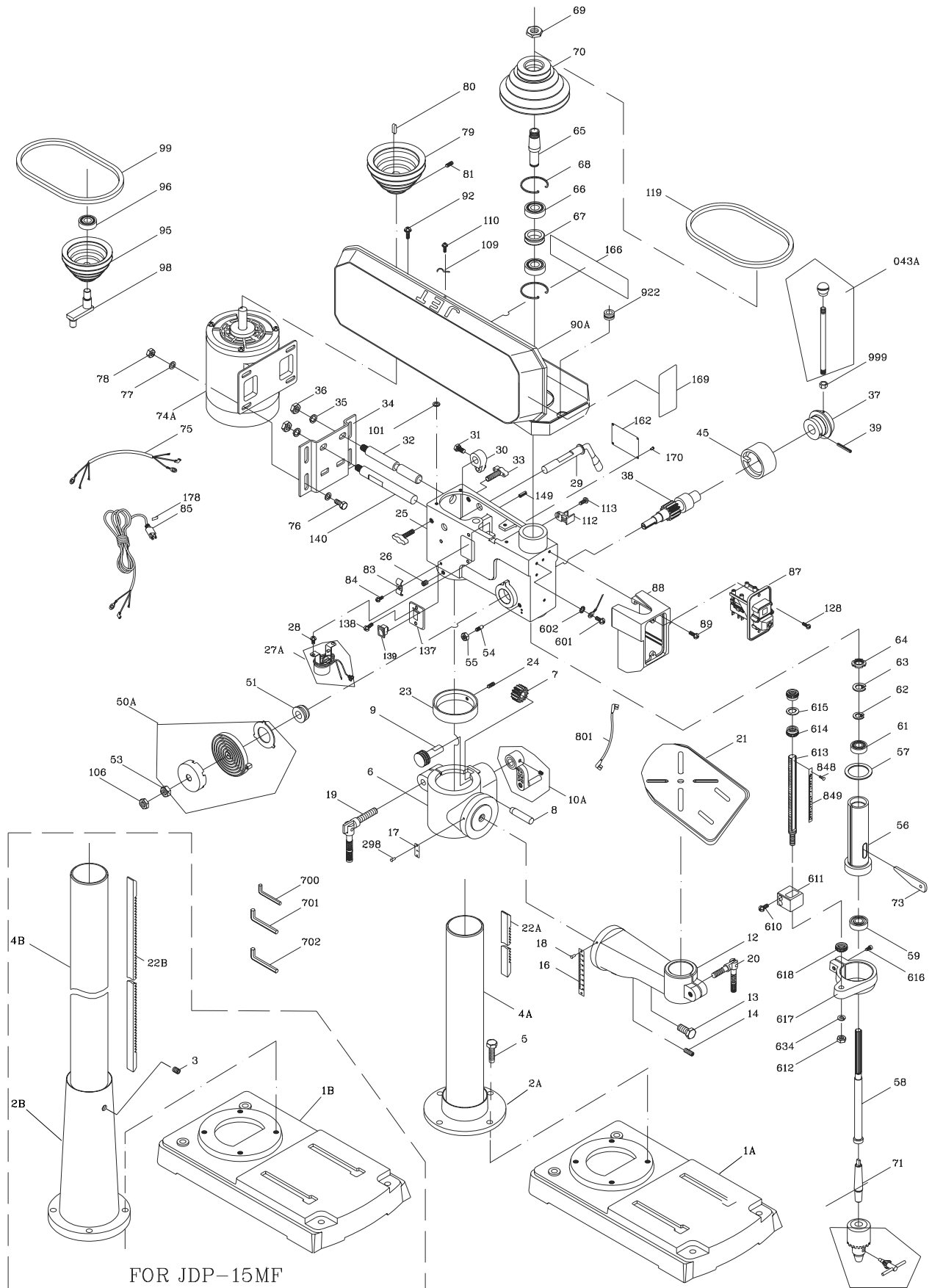
Troubleshooting

| Trouble | Probable Cause | Remedy |
|--|--|--|
| Drill press will not start. | Drill press unplugged from wall, or motor. | Check all plug connections. |
| | Fuse blown, or circuit breaker tripped. | Replace fuse, or reset circuit breaker. |
| | Cord damaged. | Replace cord. |
| | Starting capacitor bad. | Replace starting capacitor. |
| Drill press does not come up to speed. | Extension cord too light or too long. | Replace with adequate size and length cord. |
| | Low current. | Contact a qualified electrician. |
| Drill Press vibrates excessively. | Stand on uneven surface. | Adjust stand so that it rests evenly on the floor. |
| | Bad belt(s). | Replace belts. |
| Noisy Operation. | Incorrect belt tension. | Adjust belt tension. See the <i>Changing Spindle Speeds</i> section. |
| | Dry spindle. | Lubricate spindle. See the <i>Lubrication</i> section. |
| | Loose spindle pulley. | Check tightness of retaining nut on pulley, and tighten if necessary. |
| | Loose motor pulley. | Tighten setscrews in pulleys. |
| Workpiece Burns. | Incorrect Speed. | Change to appropriate speed; see the <i>Changing Spindle Speeds</i> section. |
| | Chips not clearing from hole or bit. | Retract drill bit frequently to remove chips. |
| | Dull drill bit. | Resharpen, or replace drill bit. |
| | Feeding too slowly. | Increase feed rate. |
| Drill bit wanders. | Bit sharpened incorrectly. | Resharpen bit correctly. |
| | Bent drill bit. | Replace drill bit. |
| | Bit, or chuck not installed properly. | Reinstall the chuck, or bit properly. |
| Wood splinters on the underside. | No backing board used. | Place a scrap board underneath the workpiece to prevent splintering. |
| Drill bit binds in workpiece. | Workpiece pinching the bit. | Support or clamp workpiece. |
| | Excessive feed rate. | Decrease feed rate. |
| | Chuck jaws not tight. | Tighten chuck jaws. |
| | Improper belt tension. | Adjust belt tension. See the <i>Changing Spindle Speeds</i> section. |

Troubleshooting (cont.)

| Trouble | Probable Cause | Remedy |
|--|--|---|
| Excessive drill bit runout, or wobble. | Bent drill bit. | Replace drill bit. |
| | Worn spindle bearings. | Replace spindle bearings. |
| | Bit, or chuck not properly installed. | Reinstall the bit, or chuck properly. |
| Quill returns too slow, or too fast. | Spring has improper tension. | Adjust spring tension. See the <i>Return Spring Adjustment</i> section. |
| Chuck or arbor does not stay in place. | Dirt, grease, etc on arbor, chuck, or spindle. | Clean all mating surfaces thoroughly with a cleaner degreaser. |

Exploded View Drawing JDP-15M/MF



Parts List JDP-15M/MF

| Index No. | Part No. | Description | Size | Qty |
|-----------|-------------|---|----------------|-----|
| 1A | 10600110 | Base for JDP-15M | | 1 |
| 1B | 10800101 | Base for JDP-15MF | | 1 |
| 2A | JDP15-1002A | Column Holder for JDP-15M | | 1 |
| 2B | 10600204 | Column Holder for JDP-15MF | | 1 |
| 3 | TS-2279121 | Hex Socket Set Screw | M10-12 | 3 |
| 4A | JDP15-1004A | Body Column for JDP-15M | | 1 |
| 4B | JDP15-1004B | Body Column for JDP-15MF | | 1 |
| 5 | TS-2229403 | Hex Head Bolt | M10x40 | 4 |
| 6 | 10600604 | Table Bracket | | 1 |
| | JDP15-1006 | Table Bracket Assy (includes #6 thru #18) | | 1 |
| 7 | 10600702 | Gear | | 1 |
| 8 | 10600802 | Gear Shaft | | 1 |
| 9 | 10600902 | Worm | | 1 |
| 10A | 10601009A1 | Crank Handle Assy | | 1 |
| 12 | JDP15-1012 | Table Bracket | | 1 |
| 13 | TS-0071011 | Hex Head Bolt | 5/8-11 x 1-1/2 | 1 |
| 14 | TS-2276101 | Hex Socket Set Screw | M6-10 | 1 |
| 16 | 10601601 | Tilting Scale | | 1 |
| 17 | JDP15-1017 | Centering Scale | | 1 |
| 18 | JDP15-1018 | Drive Screw | Φ 2.3-5 | 2 |
| 19 | 10601901 | Column Lock Handle | M12*1.75-35 | 1 |
| 20 | 10602001 | Table Lock Handle | M10*1.5 | 1 |
| 21 | JDP15-1021 | Table | | 1 |
| 22A | 10602204 | Rack for JDP-15M | | 1 |
| 22B | 10602205 | Rack for JDP-15MF | | 1 |
| 23 | 10602304 | Rack Ring | Φ 73.5 | 1 |
| 24 | TS-2276081 | Hex Socket Set Screw | M6-8 | 1 |
| 25 | JDP15-1025 | Head | | 1 |
| 26 | TS-2279121 | Hex Socket Set Screw | M10-12 | 2 |
| 27 | JDP15-1027 | Lamp Socket | | 1 |
| 28 | TS-1534042 | Cr. Re. Pan Head Screw | M6-12 | 2 |
| 29 | 10602901 | Handle Shifter | | 1 |
| 30 | 10603002 | Motor Bar Shifter | | 1 |
| 31 | TS-2228161 | Hex Head Bolt | M8-16 | 1 |
| 32 | 10603206 | Motor Rod | | 1 |
| 33 | 10603301 | Shifter Bolt | M10-33 | 2 |
| 34 | 10603416 | Motor Base | 75*125 | 1 |
| 35 | 2502NBC412 | Spring Washer | Φ1/2" | 1 |
| 36 | TS-1540081 | Hex Nut | M12 | 2 |
| 37 | 10603704 | Hub | | 1 |
| 38 | 10603807 | Feed Shaft | | 1 |
| | JDP15-1038 | Feed Shaft Assy (includes #37 thru #39) | | 1 |
| 39 | TS-209402 | Roll Pin | M5-16 | 1 |
| 43A | JDP15-1043 | Handle Bar | | 1 |
| 45 | 10604505 | Scale Ring | | 1 |
| 50A | JDP15-1050 | Spring Cap | | 1 |
| 51 | 10605115 | Shaft Seat | | 1 |
| 53 | TS-0561052 | Hex Nut | 1/2-20 | 1 |
| 54 | 10605403 | Quill Set Screw | M10-28 | 1 |
| 55 | TS-1540071 | Hex Nut | M10 | 1 |
| 56 | 10605608 | Quill | MT2 | 1 |
| | JDP15-1056 | Quill and Spindle Assy (includes #56 thru # 64) | | 1 |
| 57 | 10605702 | Rubber Washer | | 1 |
| 58 | 10605822 | Spindle | MT2 | 1 |

Parts List JDP-15M/MF

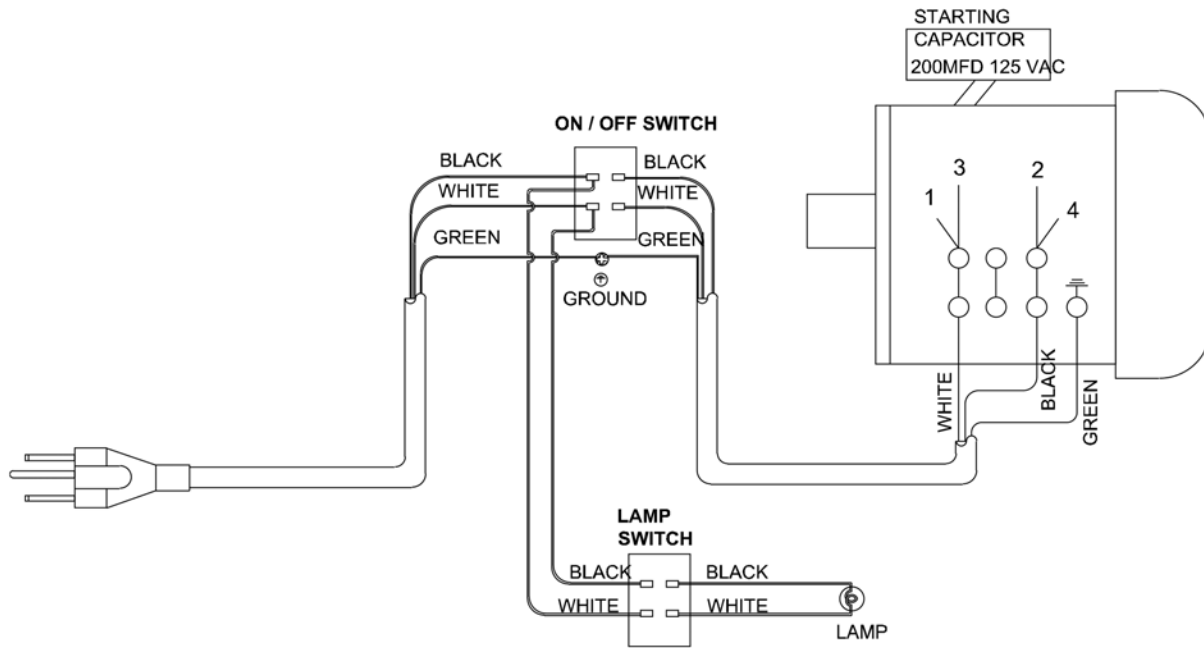
| Index No. | Part No. | Description | Size | Qty |
|-----------|-------------|---|-----------|-----|
| 59 | 2001ZZ6204 | Ball Bearing | | 1 |
| 61 | 2001ZZ6203 | Ball Bearing | | 1 |
| 62 | TS-2360161 | Washer | M16 | 1 |
| 63 | 10606301 | Nut Lock | | 1 |
| 64 | 10606401 | Spindle Nut | | 1 |
| 65 | 10606505 | Driving Sleeve | | 1 |
| | JDP15-1065 | Driving Sleeve Assy (includes #65 thru #67) | | 1 |
| 66 | 2001ZZ6204 | Ball Bearing | | 2 |
| 67 | 10606703 | Rack ring | Φ 45 T=4 | 1 |
| 68 | 10606801 | Retaining Ring | | 2 |
| 69 | 10606904 | Pulley Set Nut | | 1 |
| 70 | JDP15-1070 | Spindle Pulley | | 1 |
| 71 | 21015M2J30 | Drilling Arbor | MT2*JT3 | 1 |
| 72A | JDP15-1072 | Chuck Assy | | 1 |
| 73 | 10607303 | Wedge Shifter | | 1 |
| 74 | JDP15-1074 | Motor | | 1 |
| | JDP15-1074A | Centrifugal Switch (not shown) | | 1 |
| | JDP15-1074B | Capacitor (not shown) | | 1 |
| 75 | JDP15-1075 | Motor Wire | | 1 |
| 76 | TS-2208201 | Hex. Hd. Screw | M8-20 | 4 |
| 77 | TS-1550061 | Flat Washer | M8 | 8 |
| 78 | TS-1540061 | Hex Nut | M8 | 4 |
| 79 | JDP15-1079 | Motor Pulley | | 1 |
| 80 | 2571MNC307 | Parallel Key | 5*5-20 | 1 |
| 81 | TS-1504021 | Hex Socket Set Screw | M8-12 | 1 |
| 83 | JDP15-1083 | Strain Relief | | 1 |
| 84 | TS-1534042 | Cr. Re. Pan Head Screw | M6-12 | 1 |
| 85 | JDP15-1085 | Power Cable | | 1 |
| 87 | JDP15-1087 | Rocker Switch | | 1 |
| 88 | JDP15-1088 | Switch Box | | 1 |
| 89 | TS-1533042 | Cr. Re. Pan Head Screw | M5-12 | 3 |
| 90A | JDP15-1090 | Pulley Cover Assy | | 1 |
| | JDP15-1090A | U Shaped Protecting Rubber (not shown) | | 1 |
| 92 | JDP15-1092 | Cr. Re. Round Washer Hd. Screw | M6*1.0-12 | 4 |
| 95 | JDP15-1095 | Center Pulley | | 1 |
| | JDP15-1095A | Center Pulley Assy (includes #95 thru #98) | | 1 |
| 96 | JDP15-1096 | Ball Bearing | | 2 |
| 98 | 10609801 | Center Pulley Shaft | | 1 |
| 99 | VB-A28 | V-Belt | A-28 | 1 |
| 101 | TS-0680021 | Flat Washer | 1/4 | 4 |
| 106 | TS-0561052 | Hex Nut | 1/2-20 | 1 |
| 109 | JDP15-1109 | Clamp-Cord | | 3 |
| 110 | 2668BBDA23 | Cr. Re. Pan Head Screw | M5-8 | 3 |
| 112 | 10611201 | Chuck Key Holder | | 1 |
| 113 | TS-2286122 | Cr. Re. Round Washer Hd. Screw | M6-12 | 1 |
| 119 | VB-A26 | V-Belt | A-26 | 1 |
| 128 | TS-2285162 | Cr. Re. Truss Hd. Tapping Screw | M5-16 | 2 |
| 137 | JDP15-1137 | Switch Cover | | 1 |
| 138 | TS-1533042 | Cr. Re. Pan Head Screw | M5-12 | 2 |
| 139 | JDP15-1139 | Rocker Switch | | 1 |
| 140 | 10614001 | Motor Rod | | 1 |
| 149 | 2536MBE616 | Roll Pin | 6-25 | 2 |
| 162 | 10916202 | Warning Label | | 1 |

Parts List JDP-15M/MF

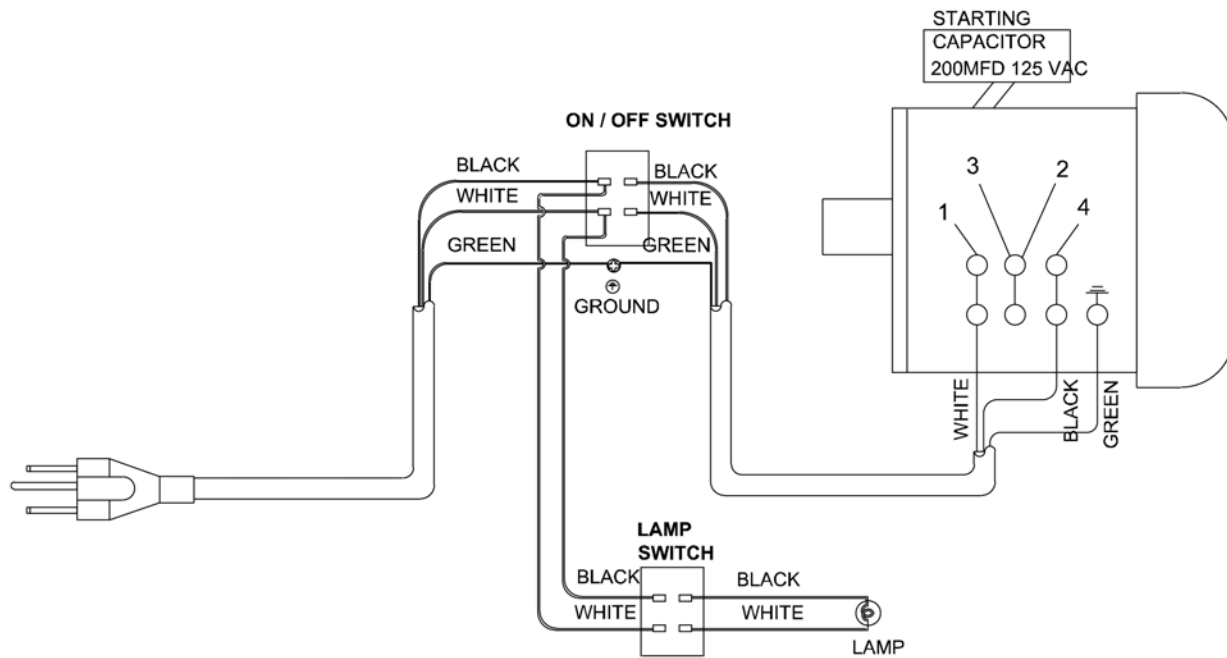
| Index No. | Part No. | Description | Size | Qty |
|-----------|------------|---|---------|-----|
| 166 | JDP15-1166 | Speed Diagram | | 1 |
| 169 | JDP15-1169 | Trade-Mark Label | | 1 |
| 170 | 2658MZDU36 | Drive Screw | Φ 2.3-5 | 6 |
| 601 | TS-2245082 | Cr. Re. Pan Head Screw | M5-8 | 4 |
| 602 | TS-0733031 | External Tooth Lock Washer | No 10 | 2 |
| 610 | TS-1534692 | Cr. Re. Pan Head Screw | M6-35 | 2 |
| 611 | JDP15-1611 | Cr. Re. Pan Head Screw | | 1 |
| 612 | TS-1540071 | Hex Nut | M10 | 1 |
| 613 | 10661301 | Set Bolt | | 1 |
| | JDP15-1613 | Set Bolt Assy (includes #613, 848, 849) | | 1 |
| 614 | 13005701 | Nut | M16 | 2 |
| 615 | 13005601 | Washer | Φ24 | 1 |
| 616 | TS-1502081 | Hex. Soc. Hd. Cap Blot | M5-35 | 1 |
| 617 | JDP15-1617 | Set Ring | | 1 |
| 618 | 10661801 | Circular Nut | | 1 |
| 634 | 2502ABC410 | Spring Washer | Φ10 | 1 |
| 700 | TS-152704 | Wrench Hex | | 1 |
| 701 | TS-152706 | Wrench Hex | | 1 |
| 702 | TS-152707 | Wrench Hex | | 1 |
| 801 | JDP15-1801 | Lead Wire Assy | | 1 |
| 848 | JDP15-1848 | Drive Screw | Φ 2.3-5 | 2 |
| 849 | JDP15-1849 | Scale | | 1 |
| 922 | 2801ABRF04 | Strain Relief | Φ 20 | 2 |
| 999 | TS-1540081 | Hex Nut | M12x10 | 3 |

Wiring Diagram

JDP – 15M/MF – 115V



JDP – 15M/MF – 230V



NOTES

NOTES



WMH Tool Group
2420 Vantage Drive
Elgin, Illinois 60123
Phone: 800-274-6848
www.wmhtoolgroup.com