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Drill Press Bohrmaschinen Perceuses

JDT-4024



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CE-Conformity Declaration CE-Konformitätserklärung Déclaration de Conformité CE

Product / Produkt / Produit:

JDT-4024

Drill Press / Bohrmaschinen / Perceuses

Brand / Marke / Marque:

PROMAC

Manufacturer / Hersteller / Fabricant:

TOOL FRANCE SARL 9 Rue des Pyrénées, 91090 LISSES, France

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 13128:2001+A1:2006 EN+ A2:2009 EN 12717:2001 + A1:2009 + AC:2010 EN 60204-1:2006/AC2010 EN 61000-6-2:2005 EN 61000-6-4:2007/A1:2011

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TOOL FRANCE SARL

2019-05-05 Christophe SAINT SULPICE, General Manager

TOOL FRANCE SARL 9 Rue des Pyrénées, 91090 LISSES, France

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Dear end-user,

Thank you very much for choosing our products. Please let us have the model of your machine, series number, as well as the name, address and correspondence method of your company in order to facilitate us to let you have a good service.

Important notice:

- 1. Please immediately contact your dealer in case the machine, accessories or documents are not in conformity with those indicated in the packing list after the machine package is opened.
- 2. Please carefully read this Operation Manual particularly the electric part of this documents before installation, testing and running the machine.
- 3. Removing grease on the machine (particularly on the column) and checking lubrication oil in each place is well filled. Running the machine without lubrication oil is strictly forbidden. Lubrication of the machine as per the stipulation of this documents is required.
- 4. Ground wire of the machine shall be well connected. When test running, push jog button in slow spindle speed to check if direction of spindle revolution is correct.
- 5. Machine must be stopped if spindle speed or feed rate change is necessary.
- 6. Please check if cutting tool or work piece is well clamped before machining
- 7. The red mushroom push button located in front of the spindle box is an emergence push button for emergency purpose only. Familiar with its position and its use are necessary.
- 8. Professional electric service engineer is required for electric maintenance.
- 9. The machine must be stopped when you need removing away the cutting material around the drill. Moving the cutting material by hand or by hook is definitely forbidden.
- 10. Correct use and daily maintenance of the machine are required in order to keep machine accuracy and its lifetime in long time.
- 11. We will much appreciate if you could solve some problems of the machine. In order to facilitate us for the service, please let us know the details regarding the places and phenomenon of the troubles if you could not solve problems.

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1. Main use and features of the machine:

JDT series vertical drilling machines are our new products designed and developed by our-self based on our accumulated experience in so many years in this field. It is really a multi-function universal machine which could be widely used for small and middle sizes of work pieces for drilling, spot facing, reaming, tapping, Milling Plane, slot-milling, angular mill etc. Besides, some machine tool accessories could also be used on this machine. The machines are suitable for the machining workshop, maintenance workshop and production line etc.

Features:

1.1 Good in appearance, easy in operation, convenience in maintenance and well consideration in safety protection

1.2 Double speed motor is to be used for the main drive system with sufficient driving power but saving energy. Wide spindle speed range is adopted driven by gears.

1.3 Oil lubrication both for the main driving system and for the feed driving system could be supplied automatically by a new type of trochoid pump when it is working in forward and reverse revolution.

1.4 The spindle features good rigidity and good wear resisting and equipped with tool disassembly and balancing device.

1.5 The worktable could be turned round the column center line or worktable center line itself or horizontal shaft centerline by manual and could be moving up and down by manual or automatically.

1.6 Main operation levers and push buttons could be reached easily that makes you comfortable when you operate the machine.

1.7 Spindle feed both in mechanical and in electrical with micro feed structure is available in this series machines.

1.8 A locking device for the spindle quill is available for the purpose of milling job. There is a screw hole located at the end of the main spindle for the clamping of different kinds of milling cutters

1.9 Spindle feed both in mechanical and in electrical with micro feed structure is available in this series machines.

1.10 Superior quality material with special treatment for the wear-resisting purpose has been used for transmission parts such as gears, worm and worm shaft, rack, lead screw etc as well as for some key parts like spindle and spindle quill.

1.11 An adjustable safety protection clutch in the spindle feed device is available in order to prevent the machine and tools from damage when overloaded.

1.12 A safety protection guard under the spindle box is available as it is not only prevent coolant splash while cutting but also could observe the machining status.

The guard is interlocked with the spindle, so when the guard is opened, the spindle could not be running until the protection guard keeps his position.

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2. Main technical data:

2.1 Main technical data

No.	Name of the items	Unit	Data
1	Max. dilling diameter (teel)	mm	40
2	Max. tapping diameter (steel)	mm	M24
3	Distance between spindle center line to the center line of column	mm	340
4	Max. distance between spindle end to the surface of the worktable (automatic)	mm	590
5	Max. distance between spindle end to the worktable surface of the base	mm	1175
6	Max. stroke of the spindle	mm	200
7	Spindle taper	Morse	MT.4
8	Number of speed steps of the spindle	Step	12
9	Spindle speed range	r/min	55-2120
10	Feed steps of the spindle	Step	4
11	Feed range of the spindle	mm/r	0.1~0.4
12	Max. stroke of worktable and its bracket	mm	530 (410)
13	Rotation degree of worktable and its bracket in cross direction	degree	$\pm 45^{\circ}$
14	Working area of the worktable (L x W)	mm	580×460
15	Working area of the worktable of the base (L x W)	mm	445×435
16	Numbers and width of the T slots both for worktable and worktable of base	mm	2-T14, 2-T14
17	Diameter of column	mm	ф 180
18	Power and speed of the main motor	kW, rpm	1.3/1.8; 960/1440
19	Power and speed of the worktable up and down motor.	kW, rpm	0.25/1440
20	Power and flow rate of the coolant pump motor	kW, L/min	0.18/6
21	Machine dimension (L x W x H)	mm	960×680×2280
22	Weight of the machine (Net weight/Gross weight)	kg	620

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2.2 For the machine appearance and its main technical data, see diagram 1.

3. Brief description of the driving system and its structure:

The machine consists of spindle box, column, machine base, worktable and its bracket, electric cabinet, coolant device and machine accessories, total seven component parts. Spindle revolution is main motion of the machine. During drilling and milling processing, spindle movement along with its axis is a feed motion, movement of worktable in longitudinal or cross directions or rotation of the worktable is also a feed motion. Worktable up and down movement and worktable turn round itself is an auxiliary motion. To those big or higher work piece that could be clamped on the worktable of the base. The worktable and its bracket should turn round the column to a proper area far away from the machining area.

Double-speed vertical motors realize machine transmission. A special pump supplies coolant water.

Operating lever in the front of spindle box could make changes for the spindle speed in 12 steps. Run the lever position drive planar cam then could drive a triple gear and a dual gear moving along with axis direction results the speed change. The lever has an idle position that is for the spindle rotation by manual for loading and unloading of tool cutters as well as for the adjustment of work piece only. Adjustment of the feed rate could be realized by shifting a set of gears controlled by changing a lever position in the right corner of spindle box. It also has an idle position for disengaging power feed transmission of the spindle for the micro adjustment of the spindle by manual.

Up and down movement of the worktable and its bracket is completed by a vertical speed reduction motor. Of cause, little adjustment for the height of the worktable could also be made by manual.

Two kinds of lubrication, auto or manual, of the machine are available. Auto lubrication system consists of a filter (located inside of a tank under spindle box), a lubrication oil pump (located on the middle of spindle box), a visual window and an oil nozzle etc. Please refer to the diagram 2 for the transmission system of the machine.

For the gear, worm and worm shaft, rack and pinion etc, please see table 1. For the details of roller bears to be used on the machine, please refer to the diagram 3 and for a list of roller bears, please refer to the table 2.





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4.1 list of	f gear, wo	rm wheel	,worm an	d rack					table (1)
Number on the drawing	1	2	3	4	5	6		7	8	9
Part drawing NO.	11016/ ZY5050	12013/ ZY5050	12011/ ZY5050	12012/ ZY5050	32004/ Z40	310013/ Z40	32 ZY	003/ 5040	32030/ Z40	32041/ ZY5050
Number of teeth and starts	40	26	30	30	15	70		32	1	36
Module	2	1.5	1.5	2	2.5	2	2	2.5	2	1.75
Direction of helical angle						Left			Left	
Class of Accuracy	9	9	9	9	8-7-7	8		8	9	8-7-7
Material		45	45	45	40 Cr	QT400		45	45	45
Heat treatment and hardness		T235	T235	T235	T235		HV:	500		G48
Number on the drawing	10	11	12	13	14	15		16	17	18
Part drawing NO.	32042/ ZY5050	32043/ ZY5050	32059/ZY 5050	32058/ZY 5050	32057/ZY 5050	32056/ZY 5050	3204 5	44/ZY 050	32045/ZY 5050	32013/ZY 5050
Number of teeth and starts	26	17	22	32	41	26		32	43	15
Module	1.75	1.75	1.75	1.75	1.75	1.75	1	.75	1.75	1.75
Direction of helical angle										
Class of Accuracy	8-7-7	8-7-7	8-7-7	8-7-7	8-7-7	8-7-7	8-	7-7	8-7-7	8-7-7
Material	45	45	45	45	45	45		45	45	45
Heat treatment and hardness	G48	G48	G48	G48	G48	G48	C	648	G48	G48

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4.1 list o	f gear, wo	orm whee	el,worm a	nd rack					table	(1)
Number on the drawing	19	20	21	22	23	24	25		26	27
Part drawing NO.	32052/ ZY5050	32002/ Z40	32003/ZY5 040A-2	32001/ Z40	32009/ZY5 040A-2	32005/ZY5 040A-2	32006/Z 040A-	2 ¥ 5 3	32002/ZY5 040A-2	32001/ZY5 040A-2
Number of teeth and starts	60	25	19	54	17	33	25		61	25
Module	1.75	1.75	2.5	2.5	2.5	2.5	2.5		2	2
Direction of helical angle										
Class of Accuracy	8-7-7	8-7-7	7-6-6	7-6-6	7-6-6	7-6-6	7-6-6	5	7-6-6	7-6-6
Material	45	48	40Cr	40Cr	40Cr	40Cr	40Cr	r	40Cr	40Cr
Heat treatment and hardness	G52	G48	G52	G52	G52	G52	G52	(352	G52
Number on the drawing	28	29	30	31	32	33	34		35	36
Part drawing NO.	32007/ ZY5040A	32008/ZY5 040A-2	32010/ZY5 040A-1	32010/ZY5 040A-2	320012/ZY 5040A-1	32073/ ZY5035	35001 ZY503	/ 35	12004/ ZY5050	12015/ ZY5050
Number of teeth and starts	42	58	15	41	59	21	28		77	14
Module	2.5	2.5	2.5	2.5	2.5	2	2		2.5	2.5
Direction of helical angle										
Class of Accuracy	7-6-6	7-6-6	7-6-6	7-6-6	7-6-6	8	8		9	7-6-6
Material	40Cr	40Cr	40Cr	40Cr	40Cr	45	Nyloi	n	40Cr	40Cr
Heat treatment and hardness	G52	G52	G52	G52	G52			(352	G52



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		Roller bearing table			
			1	Tal	ole (2)
No.	Model	Name	Specification	Q'ty	Accuracy
1	GB276;7000102	Deep groove ball bearing	15×32×8	1	
2	GB301;8104	Flat thrust ball bearing	20×35×10	1	
3	GB276;104	Deep groove ball bearing	20×42×12	1	
4	GB276;1180909K	Sealed deep groove ball bearing	45×68×12	1	
5	GB276;D7000110	Deep groove ball bearing	50×80×10	2	D
6	GB301;8110	Flat thrust ball bearing	50×70×14	1	
7	GB276;1180909K	Sealed deep groove ball bearing	45×68×12	1	
8	GB301;8102	Flat thrust ball bearing	15×28×9	2	
9	GB276;102	Deep groove ball bearing	15×32×9	1	
10	GB276;303	Deep groove ball bearing	17×47×14	1	
11	GB277;50302	bearing	15×42×13	1	
12	GB276;D1000909	Deep groove ball bearing	45×68×12	1	D
13	GB297;2007107E	Tapered roller bearing	35×62×18	1	
14	GB277;50303	bearing	17×47×14	1	
15	GB277;50302	bearing	15×42×13	1	
16	GB276;7000103	Deep groove ball bearing	17×38×8	2	
17	GB276;106	Deep groove ball bearing	30×55×13	1	
18	GB277;50204	bearing	20×47×14	2	
19	GB277;50205	bearing	25×52×15	1	
20	GB277;50203	bearing	17×40×12	1	
21	GB276;204	Deep groove ball bearing	20×47×14	2	

4. Electrical system

4.1 Brief description

The machine with foreign advanced single chip and superior quality electric element is controlled by electric system, the software system not only realize all kinds movement control ,but also has many protective function with catenation, the capability of this system is very good ,and the movement of this system is jarless and reliable. the move and stop of the main motor function are used by electric circuitry, and it improved the accuracy of machine's drilling.

4.2 Explanation of the circuit

When using the machine, breaker QF1,QF2,QF3 which positioned electric box B1(drawing 4) must be closed, it can be opened when examined and repaired. The three breakers separately protect short circuit, over loading and short phase of spindle motor, pump motor and lifting motor. when close the chief switch QS1, the system is entering working state and the single lamp HL1 light up ,when break the chief electric source, the lamp crush out and working stopped.

4.3 Tapping operation:

Electric Element for the tapping control mainly contactors KM1 and KM2, selection switch SX1 and limit switches SQ2 and SQ3 for tapping depth control. Put the selection switch SX1 into the "1"("0" is for hole drilling only),arrange the spindle revolution in clockwise direction KM1 engaged), put the spindle manual operation lever in down position until touches work piece, tapping job noe is starting. When required depth is reached , the limit switch SQ3 works, the spindle immediately runs in counter clockwise direction (KM2 engaged), the tap returns out of the work piece, when spindle returns to the up highest position ,the limit switch SQ2 works, spindle runs in clockwise direction, now one tapping job is finished. If tapping stop is required, push the button (SB4) on the lever end , the spindle motor will immediately run in count clockwise direction, that's all.

If the selection switch SX1 is in the "0" position, normal drilling work starts.

Attention: As the spindle motor works frequently during tapping, the motor will be hot quickly ,so the tapping job could not be down for a long time, eight times of tapping per minutes maximum is recommended as the motor needs cool when it is hot otherwise it will be burned.

4.4 Auto feed operation:

When auto feed, moving spindle down 5-6mm, press a push button at the end of either one of the three levers, now feed clutch is engaged and indicator HL2 on the panel is lighted auto feed job is started.

When required drilling depth is reached ,the limited switch will be pressed, then spindle returns automatically. Press the push button of the lever once again, auto feed will be stopped and the spindle will return back to the original place.



4.5 Emergency stop operation:

If emergency stop is necessary during operation, press emergency push button SB1, so the machine is completely stopped .After eliminating the breakdown ,release the lock of the push button then restart the machine.

4.6 Coolant pump

Revolving the switch of coolant pump right, then the coolant pump is moving and working with the spindle. When the spindle stopped, the coolant pump stopped too.

4.7 Lifting motor

The clamping handle 22 must be opened when the worktable lifting, turn the push button SX3 at required position.

4.8 Installation of the main motor:

Insert the key of the main motor into the solt position of the spline shaft then fixed by $4-M10 \times 35$ hex screw bolts. Connect three phases and one ground wires to the power supply as per the electrical Diagram(5) of the machine.(please note the direction of main revolving).

4.9 Sheet metal guard:

The sheet metal guard of this machine has a safety protection function, when it is opened The spindle can't working, until it is closed when the spindle is working now, it immediately stopped if The sheet metal guard is opened.

4.10 Maintenance of the electric equipment:

Turn off the electric power before maintenance of the electric equipment starts. The electric equipment must keep on clean condition. Therefore, regularly cleaning is necessary. However .liquid such as kerosene, gasoline and detergent etc. is not be allowed for the cleaning. Wave of power supply shall not be over $\pm 5\%$ required by the electric motor. Maintenance of electric equipment is absolutely important in order to keep machine works well. The power supply of this machine is three-phase four-wire system, and three phase lines are 3-ac400v. The other one is ground wire





	Tot	al 26			
	ectric components list:				
Electric compone	ents list:			Table (3)	
Code of elements	Name	Specification	Q'ty	Remark	
QF1	Breaker	GV2-ME10	1		
QF2	Breaker	GV2-ME03	1		
QF3	Breaker	GV2-ME06	1		
QS1	Instruction switch	JCH13-20	1		
SX1,2	Selection switch	C2SS2-10B-10	2		
SB1	Emergency stop button	CE4T-10R-02	1		
SB2,5	Push button	GQ22-11E/G/24V/S	2		
SB6	Push button	GQ22-11E/W/24V/S	1		
SB3	Push button	GQ22-11E/R/24V/S	1		
HL1	Single lamp	GQ16T-D/L/W/24V/S	1		
HL2	Single lamp	GQ16T-D/L/G/24V/S	1		
SB4	Push button	Homedade	3		
SX3	Selection push button	C3SS2-10B-20	1		
SQ1	Micro switch	ZCP29+ZCPEP16+ZCE10	1		
SQ5,SQ6	Micro switch	E62-10A	2		
SQ2,SQ3	Adjacent switch	TL-Q5MC1	2		
SQ4	Micro switch	XCKN2102P20C	1		
KM1-10	Contactor	LC1-D12B7 (AC24V)	10		
	Secondary contact	LAD-N20	5		
SQ8	Micro switch	E2E-X2ME1、12to24VDC	1		
EL1	Illuminating light	AC24V;25W	1		
T1	Transformer	JBK5-160TH ,400/24,24,24,9	1		
T2	Transformer	JBK5-300TH 400V/0V,24V,45V	1		
R1	Resistor	RT 2W62 Ω	1		
V1	Diode	IN5404	1		
U1	Control panel	WJ1-10/12F	1		
QL1	Bridge wiring	QL5A 200V	1		
QL2	Bridge wiring	QL10A 200V	1		
RVP1	Tachometer	RSD-44	1		
SO7	Door switch	JWM6-11A	1		

5.Lubrication and coolant system:

5.1 Lubrication system:

Parts and bearings inside of the spindle box are all automatically lubricated. Oil level shall be a little bit higher than the centerline of the oil window when you fill lubrication oil. Too much oil filling will cause overflowing. Oil release plug and a filter device are in the same unit located at left side down of the spindle box. Please pay attention that when fastening your oil release plug, don't forget to put the oil absorption pipe inside of the filter, otherwise no filtered oil will be available. The filter needs to be washed once every two weeks.

For lubrication places and its requirements by manual. Please refer to the diagram 6.

5.2 Coolant system:

A special pump will supply coolant both for tool cutter and for work piece during machining. Coolant liquid is stored in a compartment located at the backside of the machine base. Flow rate of the coolant could be adjusted by a ball valve. Regularly washing for the coolant system is necessary and coolant water shall be exchanged as per actual condition.

6. Hoisting and installation:

6.1 Hoisting:

The machine is strongly fixed inside of the crate. When hoisting the machine, please pay close attention to the sign outside of the crate (where the wire cable shall be placed and where the gravity center is).

The crate must not be reversed or inclined and must not be strongly stroked when lift up the machine.

Considering small size of the bottom and higher size of the height of the machine package, therefore, moving the machine by roller is forbidden. Lifting by a crane or by forklift is recommended.

Please refer to the diagram 7 for the machine lifting. A soft pad between machine and wire cable is necessary in order to avoid paint damage of the machine. Lifting must be slow at beginning to see if the gravity center is correct.

6.2 Installation:

Working area of the machine shall be the size when the worktable rounds its column in one cycle. Its diameter is about Ø2000mm. Further more, space for the work pieces, toolbox, and machine accessories as well as operating and maintenance space must be considered.

The machine should be placed on a solid ground. No foundation construction is required if ground of workshop is solid enough. However, we suggest that you'd better to make a foundation as per the attached drawing 8 and shall consider some space for foundation screw bolts use.





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When the foundation is completely dry, the machine could be laid down on the adjustable pad. Concrete could be filled when screw bolts are placed. Fastening screw bolts after concrete is completely dry. Leveling the machine first, required tolerance should not be over 0.04/1000mm both in horizontal and cross plane. Checking all items of the accuracy as per the table sheet of the certificate. Accuracy value for each checked item must not be over the required value.

6.3 Preparation before machine running:

A strict checking, testing and try cutting of the machine have been made before machine delivery. No adjustment of the machine itself is necessary. Before machine running, clean all surfaces of the machine first by using cloth with kerosene or gasoline, checking all lubrication points then turn the main switch of the machine to the "on" position, running the machine with middle or slow speed and checking all revolution direction is correct, operating levers are in a correct position, checking machine noise and working temperature are all ok. The machine should be running for a certain period of time, then it could be used if no any un-normal condition happened.

7. Use and operation of the machine:

7.1 For the operating levers, handles and buttons, please refer to the diagram 1 and diagram 4. Handle, Button, Switch table

No	Description	No	Description
1	Table Lifting Handle	12	Spindle inching Button
2	Scale Adjusting Handle	13	Handel for Speed Adjust of Spindle
3	Micro Hand wheel	14	Clamping & Releasing Tool Handle
4	Feed Lever	15	Emergency Stop
5	Feed Variation Lever	16	Drilling/Tapping Switch
6	Table Lifting Button	17	Cooling Pump Switch
7	Spindle clamp grip	18	Main AC switch
8	Working light switch	19	Coolant flow control switch
9	Main shaft covers handle	20	Lever lock handle
10	Spindle reversal button	21	Working Table Clamping Handle
11	Spindle stop button	22	Bracket Clamping Handle

7.2 Mounting and dismounting of tool cutters:

The machine equipped with a tool dismounting device to be controlled by a nob (15). Push forward the nob (15) to the spindle box direction when tool mounting is required. As for dismounting tool cutters, pull out the nob (15), hold the tool cutter by left hand, meanwhile, turn the feed lever (4) by right hand, then the spindle quill goes up rapidly, the tool cutter will fall down until tool taper shank strokes the shaft of spindle.



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In case too tight mesh between tool shank and spindle taper and the to down after several strokes, then you have to use the normal way by u dismounting the tool cutter.	ol cutter coul ising a taper	d not fall wedge to
If milling cutter is used, be sure to take away the screw on the tool hole of the spindle, the milling cutter then could be easily dismounted. Warning: The nob (15)must not be pulled out while tool mounting Running, otherwise, the spindle will goes up quickly whi	der screwed o or machine ich results to	n the end
cutter falls down. It is really dangerous.		

7.3 Changes for the spindle speed and feed rate:

Spindle speed change could be made by moving the levers (14) located in the front of the spindle box. Relations between spindle speed revolution position is indicated at the dial. Meanwhile, the digital meter indicates the actual spindle revolution.

As mounting or dismounting tool cutter or adjustment of work piece needs spindle rotation by manual, therefore, the lever shall be in the "idle" position, so spindle rotation could be easily obtained.

Changes of the feed rate could be realized by using the lever (5) in the upper right side position of the spindle box. As micro manual feed needs disengagement of the auto feed, therefore, the lever shall also be in the "idle" position.

7.4 Selection and operation of the spindle feed:

There are three types of spindle feed selections for your choice as per the requirement of your machining:

- Manual feed: Simply moving the feed lever(4)at the right side of the spindle box, the spindle will move down if turned the lever in counter clockwise and the spindle will move up if turned the lever in clockwise.
- Auto feed: There are three levers(4),at the end of each lever equipped with a push button. Push one of any three buttons(SB4), auto feed could be realized as per your required pre-set feed rate. Push one of any three buttons(SB4) once again, the auto feed will be stopped immediately.

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Manual micro feed: Spindle micro feed needs two steps. First, put the feed rate lever(5) in the "idle" position. Secondly, push button (SB4), then push up the micro feed hand wheel(3) and make sure that the clutch is engaged, now the micro feed hand wheel could be turned and micro feed of the spindle works.

7.5 Cutting depth control:

For the batch production, you need control cutting depth. A scale in front of spindle box could meet your requirements. Loosening knurled screw (20) by turning nob (2), moving the scale to the required depth, then fastening the knurled screw(20). Now the machining depth could be controlled.

7.6 Application of the digital scale:

A small round battery is fixed on the right side position of the spindle box for digital readout. With this scale, moving distance of the spindle could be easily readout. Except the battery switch, a "reset" push button and an "English or Metric" converter push button are available. Cutting depth could be readout at any time and cutting depth could also be set in advance. This function will be helpful for small batch or single work piece machining.

7.7 Tapping:

Put the "Selection Switch"(17) on the tapping position first, turn the feed lever(4) and let the tap approaches the work piece, a proper manpower force (based on the size of screw) shall be exerted in order to let the tap comes into the hole. The spindle will be rotated in reverse when the screw depth is reached, and the tap comes out.

Suppose, tapping job needs stop, push button (SB4) of the hand lever(4) then spindle will have reverse revolution. and tap returns back.

7.8 Milling

With the requirements and the shapes of the tasks, select the Milling cutter and accessories, both face mill cutter and end mill cutter can be attached with shank, chuck to the spindle, after attachments has been attached and clamped, rotate the working table led the base round pin close to the right hand side of the column, then use latch segments clamp round pin and set screw, clamp the handle (22) and (23).

For the milling operation, manual feed or auto feed using lever(4) is not permitted. The best way is to use micro feed hand wheel(3). Lock spindle by turning a clamping rod(7) if required cutting depth is reached.

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7.8 Adjustment of worktable position:	
Symbols multi-use and convenience of the machine also reflects worktable. Except its normal manual and auto up and down function around the table itself, around the column and tilt in $\pm 45^{\circ}$ in horizon	multi function of itan, it can also be turned n, it position.
Operation method for the table tilting Using a special tool to take out the taper pin and loosening four scra and manually turn the worktable to the required position then fastenin now the work piece can be machined as per your tilting angle. When the job is finished, keep the worktable in the original position mentioned on the above. Be sure do not forget to push the pin in its po	ew nuts on the bracke ng the four screw nuts by using the same way osition.
8. Machine adjustment:	
8.1 Spindle balance force adjustment:	
Balance of spindle is realized through a springiness from a coil sprin left side of the spindle box. Balance force shall be adjusted to the together with its tool shall not go down itself when spindle stops. (go much better).Over springiness or less needs adjustment. Simply loosening the screw box, turn the spring box cover, the spring could be either fastening of screw on the cover if the balance force is ok	g device located at the point that the spindle o up a little bit shall be o on the cover of spring or loosening. Fastening
8.2 Adjustment for the feed safety clutch:	
Feed safety clutch is mounted on lower side of the warm shaft. If to force is occurred, the feed safety clutch will be automatically slipped heard) in order to protect machine driving system not to be damaged. C	bo much feed resisting d (sound "Ka" will be lutch appearance could

be seen when opening the cover located on the middle of the feed change label. Using a tool to turn a slotted nut in clockwise, this will increase the feed resisting force, meanwhile, the counter clockwise will reduce the feed resisting force. The max. feed resisting force of this machine is 8000N, Over feed resisting force will cause un-safety, be sure to lock it by screw bolt or nut after adjustment.

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9 Machine use and maintenance:

- 9.1 Before running the machine, carefully read the Operation Manual first, fully understand the structure of the machine and its performance and needs to familiar with locations for all levers and buttons.
- 9.2 Lubrication of the machine is very important. Daily lubrication work as per the equirements of the operation manual is necessary. Filter should be cleaned once every two weeks otherwise pump, transmission parts and bearings will be damaged.
- 9.3 Max. spindle torque of this machine is 125Nm. Max. feed resisting force in the driving system is8000N. Over permitted cutting feed range is not allowed. High spindle speed with big cutting feed is not good to the machine.
- 9.4 As standard drill with118 degree angle features big cutting force but quick wear-out, so diameter and roughness of holes is not so ideal after drilling, therefore, regrinding its edges particularly for the big diameter drills is necessary. It is better to use two different angles for the machining of cast iron material (Second angle could be 70°).
- 9.5 Spot facer with three edges is proffered for the spot facing machining, using a normal drill for spot facing job will cause vibration. However, it will have a better result for the spot facing machining if reducing the rear angle of the normal drill with two different angles and going down the cutting speed and feed rate.
- 9.6 Temperature of motor will be increased so quickly when tapping due to frequently Motor direction be changed. Therefore, rapid and continuous taping shall be avoided. Max. eight times per minutes of tapping is recommended. The machine shall be stopped for cooling if the motor is too hot.
- 9.7 A proper cutting force is required when milling. As this is not a milling machine although it has a milling function. Too big milling force will cause worktable moving round the column, therefore, clamping the worktable strongly is required when milling and a reasonable cutting feed rate for milling job is necessary.
- 9.8 Please turn off the coolant valve when mounting and dismounting tools, clamping or adjusting work piece or measuring work piece, as coolant is not necessary during this period. Stop coolant pump if these job takes more than ten minutes.
- 9.9 As gears are to be used for spindle and feed system, so it is not allowed to change spindle speed or change cutting feed rate when machine running, otherwise it will damage gears, shafts or relevant parts.

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- 9.10 Do not extend spindle quill too much, instead, a proper working table height is suggested .Clean the spindle taper hole and tool taper shank first before tool mounting. Unqualified or rusted or damaged taper shank is forbidden to use.
- 9.11 Dry agent inside of the electric box and regularly removing dustiness are necessary. It is forbidden to us gasoline or kerosene or diesel oil to clean electric components. We suggest to use those no erosion and not be easily burned liquid such as carbon tetrachloride etc.

11. Machine accessories:

No.	Description	Specification/standard	Q'ty	Remark
1	Drill check with spanner	1-13/G86087	1	
2	Adapter for drill check		1	
3	Adaptor	4-3/JB3477	1	
4	Adaptor	4-2/JB3477	1	
5	Adaptor	3-1/JB3477	1	
6	Taper wedge for flat shape quill	Wedge 1/JB3482	1	
7	Taper wedge for flat shape quill	Wedge 3/JB3482	1	
8	Wrench	21×24/GB4388	1	
9	Battery	SR44	1	
10	Fuse	φ5×25 3Α/1Α/10Α	2 for each	
11	Fuse	φ5×25 5A	2	

				Total 1
		_		
			page 1	
Case N Dimens Gross	[o.: 1/1 sion (L ×W × H): 110 weight:660kg ight: 630kg	×67 ×225 CM		
No.	Name	Specification and marks	Q'ty	Remark
1	Machine		1 piece	
2	Drill chuck with lever	1-13: GB6087	1 piece	
3	Drill chuck adaptor		1 piece	
		4-3: JB3477	1 piece	
4		4-2: JB3477	1 piece	
4	Tool shank adaptor	3-1: JB3477	1 piece	
_		Wedge 1: JB3482	1 piece	
5	Taper wedge for shank	Wedge 3: JB3482	1 piece	
6	Wrench	21×24/GB4388	1	
7	Battery	SR44	1	
8	Fuse	φ5×25 3A/1A/5A/10A	2 for each	
	Operation manual		1 piece	
	Quality certificate		1 piece	
17	Packing list		1 piece	-
	Inspe	ctor of he pæking:	Date:	





No.	Part no.	Descirption	Size	Qty.
1	JDT4024-1-001	Knurled screw7bolt		1
2	JDT4024-1-002	Knurled knob		1
3	JDT4024-1-003	Taper pins	3x26	1
4	JDT4024-1-004-1	Scaled screw		1
4	JDT4024-1-004-2	Retaining ring	20	1
5	JDT4024-1-005	Scaled nut		1
6	JDT4024-1-006	Support for7The vernier		1
7	JDT4024-1-007	Slotted cheese head screws	M3X6	1
8	JDT4024-1-008	Scaled7Indicator sheet		1
	JDT4024-1-009-1	Cross7Recess Head Screw		2
9	JDT4024-1-009-2	Flat Washer		2
4.0	JDT4024-1-010-1	Ruler chuck		1
10	JDT4024-1-010-2	Hexagon7socket head cap7screws	M8X35	1
	JDT4024-1-011-1	Spindle		1
11	JDT4024-1-011-2	spline housing		1
12	JDT4024-1-012	Bearing cover		1
13	JDT4024-1-013	Deep groove ball bearings		1
14	JDT4024-1-014	Washer		1
15	JDT4024-1-015	Deep groove ball bearings		1
16	JDT4024-1-016	Washer		1
17	JDT4024-1-017	Flat bottomed thrust ball bearing		1
18	JDT4024-1-018	Deep groove ball bearings		1
19	JDT4024-1-019	Tab Washers For Round Nut		1
20	JDT4024-1-020	Round Nut		2
21	JDT4024-1-021	Spindle quill		1
22	JDT4024-1-022	Drive Shaft		1
23	JDT4024-1-023	Taper Roller		1
	JDT4024-1-024-1	bearing block		1
24	JDT4024-1-024-2	Rubber covered rotary shaft7lipseals		1
24	JDT4024-1-024-3	O-RING	75X2.65	1
	JDT4024-1-024-4	Hexagon7socket head cap7screws		7
25	JDT4024-1-025	Deep groove ball bearings		1
	JDT4024-1-026-1	Feed Gear		1
26	JDT4024-1-026-2	Кеу		1
	JDT4024-1-026-3	retaining ring		3
27	JDT4024-1-027	Gear		1
	JDT4024-1-028-1	Gear		1
28	JDT4024-1-028-2	retaining ring		1
	JDT4024-1-028-3	Key		2
29	JDT4024-1-029	Bearing		1
20	JDT4024-1-030-1	Round Nut		1
30	JDT4024-1-030-2	Tab Washers For Round Nut		1
31	JDT4024-1-031	Cover		1
32	JDT4024-1-032	Hexagon7socket head cap7screws	M5X12	3
33	JDT4024-1-033	Ellipse Handle		3
34	JDT4024-1-034	Handle lever		3
	JDT4024-1-035-1	Handle seat		1
35	JDT4024-1-035-2	Slotted set7screws with cone point	M6X12	1
	JDT4024-1-035-3	Slotted flat end screw	M6X10	1

Part List for JDT-4024 DRILL PRESS

No.	Part no.	Descirption	Size	Qty.
	JDT4024-1-036-1	indicator dial		1
	JDT4024-1-036-2	Slotted set7screws with cone point	M5X12	1
36	JDT4024-1-036-3	Positioning screw		1
	JDT4024-1-036-4	cylindrical helical compressionspring		1
	JDT4024-1-036-5	Ball	6	1
	JDT4024-1-037-1	Positioning screw		1
37	JDT4024-1-037-2	Ball	6	1
	JDT4024-1-037-3	cylindrical helical compressionspring		1
20	JDT4024-1-038-1	Cam		1
30	JDT4024-1-038-2	retaining ring		1
39	JDT4024-1-039	Ball Bearing		2
40	JDT4024-1-040	ball bearing		2
	JDT4024-1-041-1	Lever		1
41	JDT4024-1-041-2	straight pin		1
	JDT4024-1-041-3	Slotted set7screws with cone point	M5X12	1
42	JDT4024-1-042-1	Fixed Mount		1
42	JDT4024-1-042-2	Hexagon7socket head cap7screws	M6x20	3
43	JDT4024-1-043	Taper		1
44	JDT4024-1-044	guide pillar		1
45	JDT4024-1-045	Guide Fork		1
46	JDT4024-1-046	Spring Bracket		1
47	JDT4024-1-047-1	Spring Bracket		1
	JDT4024-1-047-2	tension spring		1
48	JDT4024-1-048-1	connecting rod (A)		1
40	JDT4024-1-048-2	Taper pins with7internal thread	6X30	1
10	JDT4024-1-049-1	Support		1
	JDT4024-1-049-2	Hexagon7socket head cap7screws	M6X20	2
50	JDT4024-1-050	Shaft		1
	JDT4024-1-051-1	Support		1
51	JDT4024-1-051-2	Hexagon7socket head cap7screws	M6X20	3
	JDT4024-1-051-3	Taper pins with7internal thread	6X24	2
52	JDT4024-1-052	Lever block		1
	JDT4024-1-053-1	Lever		1
53	JDT4024-1-053-2	Slotted set7screws with cone point	M6X12	1
	JDT4024-1-053-3	Hexagon7socket head cap7screws	M6X25	2
	JDT4024-1-053-4	Slotted flat end screw	M6X16	1
54	JDT4024-1-054-1	Torsion spring hanger		1
04	JDT4024-1-054-2	hexagon thin nut	M12	2
55	JDT4024-1-055	torsional spring		1
56	JDT4024-1-056-1	Torsion spring fixing sleeve		1
	JDT4024-1-056-2	retaining ring		1
	JDT4024-1-057-1	supporting block for location		1
	JDT4024-1-057-2	Slotted set screws with dog point	M5X10	1
57	JDT4024-1-057-3	Slotted7countersunk head screws	M4X10	4
	JDT4024-1-057-4	registration mast		1
1	IJDT4024-1-057-5	Icvlindrical helical compressionspring		1 1

Part List for JDT-4024 DRILL PRESS

No.	Part no.	Descirption	Size	Qty.
	JDT4024-1-058-1	Stop Pin		1
50	JDT4024-1-058-2	Hex Nut	M4	2
58	JDT4024-1-058-3	Flat Washer	4	2
	JDT4024-1-058-4	Slotted set screws with dog point	M5X12	1
	JDT4024-1-059-1	Holder		1
59	JDT4024-1-059-2	cylindrical helical compressionspring		1
	JDT4024-1-059-3	Slotted7countersunk head screws	M4X10	2
60	JDT4024-1-060	Panel label		1
61	JDT4024-1-061	Slotted7countersunk head screws	M5X10	3
62	JDT4024-1-062	Positioning block		1
63	JDT4024-1-063	Spindle box		1
	JDT4024-1-064-1	Cover		1
64	JDT4024-1-064-2	oil leveler	M27X1.5	1
	JDT4024-1-064-3	Hexagon7socket head cap7screws	M5X16	4
65	JDT4024-1-065	Ellipse Handle		1
66	JDT4024-1-066	Handle lever		1
67	JDT4024-1-067	Handle seat		1
68	JDT4024-1-068	Eccentric cover		1
69	JDT4024-1-069	Washer for7adjusting		1
70	JDT4024-1-070	Locked screw		1
71	JDT4024-1-071	Locked sleeve (I)		1
72	JDT4024-1-072-1	Quill		1
12	JDT4024-1-072-2	Taper pins with7internal thread	3X20	1
73	JDT4024-1-073	Locked sleeve(II)		1
74	JDT4024-1-074-1	Stop Ring		1
74	JDT4024-1-074-2	Taper pins with7internal thread	6X20	1
75	JDT4024-1-075-1	Locating shaft		1
73	JDT4024-1-075-2	Кеу		1
76	JDT4024-1-076	Sleeve		1
77	JDT4024-1-077	Slotted7countersunk head screws	M3X6	1
78	JDT4024-1-078	Embossed handle		1
79	JDT4024-1-079	Bearing		1
80	JDT4024-1-080	Spline shaft(II)		1
81	JDT4024-1-081	Gear		1
82	JDT4024-1-082	Gear		1
83	JDT4024-1-083	Gear		1
84	JDT4024-1-084	Gear		1
85	JDT4024-1-085	Gear		1
86	JDT4024-1-086	Deep groove ball bearings		1
87	JDT4024-1-087-1	Spindle box cover		1
07	JDT4024-1-087-2	Hexagon7socket head cap7screws	M8X30	7
	JDT4024-1-088-1	Gear		1
88	JDT4024-1-088-2	Кеу		1
	JDT4024-1-088-3	retaining ring		1
89	JDT4024-1-089	Bearing		1
90	JDT4024-1-090	Spline shaft		1
91	JDT4024-1-091-1	Gear		1
	JDT4024-1-091-2	retaining ring		1
92	JDT4024-1-092	Gear		1

Part List for JDT-4024 DRILL PRESS

Part I	List f	for JD	T-4024	DRILL	. PRESS
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No.	Part no.	Descirption	Size	Qty.
02	JDT4024-1-093-1	Gear		1
93	JDT4024-1-093-2	Кеу		2
04	JDT4024-1-094-1	Gear		1
94	JDT4024-1-094-2	retaining ring		1
95	JDT4024-1-095	Deep groove ball bearings		1
96	JDT4024-1-096	Motor		1
07	JDT4024-1-097-1	Motor Gear		1
97	JDT4024-1-097-2	retaining ring		1
00	JDT4024-1-098-1	Bearing		1
98	JDT4024-1-098-2	round head screw		3
99	JDT4024-1-099	Oil Pump Gear		1
100	JDT4024-1-100-1	Small shaft		1
100	JDT4024-1-100-2	Кеу		1
	JDT4024-1-101-1	Oil Pump Mount		1
101	JDT4024-1-101-2	Hexagon7socket head cap7screws	M6X16	3
	JDT4024-1-101-3	Hexagon7socket head cap7screws	M6X25	3
400	JDT4024-1-102-1	Oil Pump		1
102	JDT4024-1-102-2	right-angle connector		1
103	JDT4024-1-103	Round Nut		2
104	JDT4024-1-104	Belleville spring		2
105	JDT4024-1-105	Feed Gear		1
106	JDT4024-1-106	Washer		1
107	JDT4024-1-107	Deep groove ball bearings		1
108	JDT4024-1-108	Bearing seat		1
109	JDT4024-1-109	Hexagon7socket head cap7screws	M5X16	3
110	JDT4024-1-110	Deep groove ball bearings		1
111	JDT4024-1-111	Feed Gear		1
112	JDT4024-1-112	Small shaft		1
113	JDT4024-1-113	Кеу		1
114	JDT4024-1-114	Bearing		1
115	JDT4024-1-115	Washer		1
116	JDT4024-1-116	Spline shaft (Ⅲ)		1
117	JDT4024-1-117	Feed Gear		1
118	JDT4024-1-118	Feed Gear		1
119	JDT4024-1-119	Feed Gear		1
120	JDT4024-1-120	Feed Gear		1
121	JDT4024-1-121	Feed Gear		1
122	JDT4024-1-122	Bearing		1
123	JDT4024-1-123	retaining ring		1
124	JDT4024-1-124	Small ripple handwheel		1
125	JDT4024-1-125	Taper pins		1
126	JDT4024-1-126	Hexagon7socket head cap7screws	M5X20	4
127	JDT4024-1-127	Worm Cover		1
128	JDT4024-1-128	Slotted flat end screw	M6X8	1
129	JDT4024-1-129	cylindrical helical compressionspring		1
130	JDT4024-1-130	Ball	5	1
131	JDT4024-1-131	Shaft		1
	JDT4024-1-132-1	Clutch		1
132	JDT4024-1-132-2	retaining ring	12	1
	JDT4024-1-132-3	Key		1

Part Lis	t for .	JDT-4024	DRILL	PRESS
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No.	Part no.	Descirption	Size	Qty.
133	JDT4024-1-133	Round Nut	M14X1.5	1
134	JDT4024-1-134	Tab Washers For Round Nut		1
135	JDT4024-1-135	Flat bottomed thrust ball bearing		1
136	JDT4024-1-136	Bearing Seat		1
137	JDT4024-1-137	O-RING	55X3.1	1
138	JDT4024-1-138	O-RING	19X2.4	1
139	JDT4024-1-139	Flat bottomed thrust ball bearing		1
140	JDT4024-1-140	Washer		1
141	JDT4024-1-141	Deep groove ball bearings		1
142	JDT4024-1-142	Washer		1
143	JDT4024-1-143	Rubber covered rotary shaft7lipseals		1
144	JDT4024-1-144	Worm shaft		1
145	JDT4024-1-145	Key		1
146	JDT4024-1-146	joining sleeve		1
147	JDT4024-1-147	Deep groove ball bearings		1
148	JDT4024-1-148	Kev		1
149	JDT4024-1-149	Spline shaft (IV)		1
150	JDT4024-1-150	Feed Gear		1
151	JDT4024-1-151	Feed Gear		1
	JDT4024-1-152-1	Feed Gear		1
152	JDT4024-1-152-2	Kev		1
	JDT4024-1-153-1	Feed Gear		1
153	JDT4024-1-153-2	retaining ring		1
154	JDT4024-1-154	retaining ring		1
155	JDT4024-1-155	Bearing		1
156	JDT4024-1-156	retaining ring		1
157	JDT4024-1-157	round head screw		3
158	JDT4024-1-158	Lever block		1
159	JDT4024-1-159	Fork Lever		1
160	JDT4024-1-160	O-RING	15X1.9	1
	JDT4024-1-161-1	Small shaft		1
161	JDT4024-1-161-2	Taper pins		1
162	JDT4024-1-162	O-RING		1
163	JDT4024-1-163	Feeding Cover		1
164	JDT4024-1-164	Hexagon7socket head cap7screws	M5X25	4
165	JDT4024-1-165	Positioning block		1
166	JDT4024-1-166	Slotted cheese head screws	M4X8	1
167	JDT4024-1-167	Ball	8	1
168	JDT4024-1-168	cylindrical helical compressionspring	•	1
	JDT4024-1-169-1	Handle seat		1
169	JDT4024-1-169-2	Taper pins with7internal thread		1
170	JDT4024-1-170	Handle lever		1
171	JDT4024-1-171	Ellipse Handle		1
172	JDT4024-1-172	Slotted cheese head screws	M5X12	10
	JDT4024-1-173-1	Cover		1
173	JDT4024-1-173-2	Spring Pin		1
174	.IDT4024-1-174	Flat Spring		1
175	JDT4024-1-175	Slotted cheese head screws		3
176	IDT4024-1-176	Bearing Box		1
170	0014024-1-170			

No.	Part no.	Descirption	Size	Qty.
177	JDT4024-1-177	retaining ring		1
178	JDT4024-1-178	Internal Circlips		1
179	JDT4024-1-179	Adjusting Washer		1
180	JDT4024-1-180	Deep groove ball bearings		1
181	JDT4024-1-181	Adjusting Washer		1
182	JDT4024-1-182	Cross shaft		1
183	JDT4024-1-183	Deep groove ball bearings		1
184	JDT4024-1-184	Washer		1
185	JDT4024-1-185	Hexagon7socket head cap7screws	M5X30	3
186	JDT4024-1-186	Worm wheel		1
187	JDT4024-1-187	Sleeve		1
188	JDT4024-1-188	Hexagon7socket head cap7screws	M5X12	3
189	JDT4024-1-189	Rubber covered rotary shaft7lipseals		1
190	JDT4024-1-190	Internal Circlips		1
191	JDT4024-1-191	Deep groove ball bearings		1
192	JDT4024-1-192	Feeding Cover		1
193	JDT4024-1-193	Hexagon7socket head cap7screws	M6X45	4
194	JDT4024-1-194	Handle seat		1
195	JDT4024-1-195	Adjusting Washer		1
196	JDT4024-1-196	retaining ring		1
197	JDT4024-1-197	Cover		1
198	JDT4024-1-198	Slotted cheese head screws		3
100	JDT4024-1-199-1	Lever		3
199	JDT4024-1-199-2	retaining ring		3
200	JDT4024-1-200	Handle Lever		3
201	JDT4024-1-201	Konb		3
202	JDT4024-1-202	Core bar		3

Part List for JDT-4024 DRILL PRESS



Part List for JDT-4024	DRILL	PRESS
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No.	Part no.	Descirption	Size	Qty.
1	JDT4024-2-01	Base		1
2	JDT4024-2-02	Cover		1
3	JDT4024-2-03	Column		1
4	JDT4024-2-04	Rack		1
5	JDT4024-2-05	Water strainer		1
6	JDT4024-2-06	Plate		1
7	JDT4024-2-07	Slotted countersunk head screw	M6X10	4
8	JDT4024-2-08	Pipe joint		1
9	JDT4024-2-09	Hose		1
10	JDT4024-2-10	Pipe joint		1
11	JDT4024-2-11	Coolant pump	0.18kW	1
12	JDT4024-2-12	Slotted cheese head screw	M6X25	1
13	JDT4024-2-13	Hose clamp		4
14	JDT4024-2-14	Hose		1
15	JDT4024-2-15	Pipe joint		1
16	JDT4024-2-16	Connector		1
17	JDT4024-2-17	Stop ring		1
18	JDT4024-2-18	Up and down device of bracket		1
19	JDT4024-2-19	Crust		1
20	JDT4024-2-20	Long lever guill		1
21	JDT4024-2-21	Hand lever		1
22	JDT4024-2-22	Double end bolt		1
23	JDT4024-2-23	Hand lever seat		1
24	JDT4024-2-24	Thin hexagon nut	M10	3
25	JDT4024-2-25	Cap nut	M10	3
26	JDT4024-2-26	Bracket seat		1
27	JDT4024-2-27	T type screw bolt		4
28	JDT4024-2-28	Positioning shaft		1
29	JDT4024-2-29	Worktable		1
30	JDT4024-2-30	Small shaft		1
31	JDT4024-2-31	Worm shaft		1
32	JDT4024-2-32	Sleeve		1
33	JDT4024-2-33	Gear		1
34	JDT4024-2-34	Washer		1
35	JDT4024-2-35	Side cover for lifting		1
36	JDT4024-2-36	Warm shaft for lifting		1
37	JDT4024-2-37	Ball bearing		1
38	JDT4024-2-38	Taper gear		1
39	JDT4024-2-39	Washer for adjusting		1
40	JDT4024-2-40	Taper gear		1
41	JDT4024-2-41	Bearing seat		1
42	JDT4024-2-42	Ball bearing of depth chimb		1
43	JDT4024-2-43	Connecting end		1
44	JDT4024-2-44	Connecting end		1
45	JDT4024-2-45	Lever for lifting		1
46	JDT4024-2-46	Lever for turning		1
47	JDT4024-2-47	motor	0.25Kw	1
48	JDT4024-2-48	Hexagon headed bolt		6
49	JDT4024-2-49	Up connection seat		1
<u> </u>	1		1	

No.	Part no.	Descirption	Size	Qty.
50	JDT4024-2-50	Hexagon socket head cap screws	M12X30	10
51	JDT4024-2-51	Double end bolt		2
52	JDT4024-2-52	Main nut for clamping board		1
53	JDT4024-2-53	Connecting board for bracket		1
54	JDT4024-2-54	Hand lever		1
55	JDT4024-2-55	Long hand quill		1
56	JDT4024-2-56	Nut for clamping board		1

Part List for JDT-4024 DRILL PRESS



Warranty / Garantie

TOOL FRANCE SARL guarantees that the supplied product(s) is/are 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, damage due to accidents, repairs or inadequate maintenance or cleaning as well as normal wear and tear.

Further details on warranty (e.g. warranty period) can be found in the General Terms and Conditions (GTC) that are an integral part of the contract.

These GTC may be viewed on the website of your dealer or sent to you upon request.

TOOL FRANCE SARL reserves the right to make changes to the product and accessories at any time.

TOOL FRANCE SARL garantiert, dass das/die von ihr gelieferte/n Produkt/e frei von Material- und Herstellungsfehlern ist.

Diese Garantie deckt keinerlei Mängel, Schäden und Fehler ab, die - direkt oder indirekt - durch falsche oder nicht sachgemäße Verwendung, Fahrlässigkeit, Unfallschäden, Reparaturen oder unzureichende Wartungs- oder Reinigungsarbeiten sowie durch natürliche Abnutzung durch den Gebrauch verursacht werden.

Weitere Einzelheiten zur Garantie können den allgemeinen Geschäftsbedingungen (AGB) entnommen werden. Diese können Ihnen auf Wunsch per Post oder Mail zugesendet werden.

TOOL FRANCE SARL behält sich das Recht vor, jederzeit Änderungen am Produkt und am Zubehör vorzunehmen.

TOOL FRANCE SARL garantit que le/les produit(s)fourni(s) est/sont exempt(s) de défauts matériels et de

défauts de fabrication.

Cette garantie ne couvre pas les défauts, dommages et défaillances causés, directement ou indirectement, par l'utilisation incorrecte ou inadéquate, la négligence, les dommages accidentels, la réparation, la maintenance ou le nettoyage incorrects et l'usure normale.

Vous pouvez trouver de plus amples détails sur la garantie dans les conditions générales (CG).

Les CG peuvent être envoyées sur demande par poste ou par e-mail .

TOOL FRANCE SARL se réserve le droit d'effectuer des changements sur le produit et les accessoires à tout moment.

