

CLARKE®



DRILL PRESS

MODEL NO: CDP10B

PART NO: 6550020

OPERATION & MAINTENANCE INSTRUCTIONS



GC0514

INTRODUCTION

Thank you for purchasing this CLARKE Drill Press. Before attempting to use this product, please read this manual thoroughly and follow the instructions carefully. In doing so you will ensure the safety of yourself and that of others around you, and you can look forward to your purchase giving you long and satisfactory service.

IMPORTANT

Please read all of the safety and operating instructions carefully before using this product. Please pay particular attention to all sections of these instructions that display warning symbols and notices.



WARNING: THIS SYMBOL IS USED THROUGHOUT THE INSTRUCTIONS WHENEVER THERE IS A RISK OF PERSONAL INJURY. ENSURE THAT THESE WARNINGS ARE READ AND UNDERSTOOD AT ALL TIMES.

GUARANTEE

This product is guaranteed against faulty manufacture for a period of 12 months from the date of purchase. Please keep your receipt which will be required as proof of purchase. This guarantee is invalid if the product is found to have been abused or tampered with in any way, or not used for the purpose for which it was intended.

Faulty goods should be returned to their place of purchase, no product can be returned to us without prior permission. This guarantee does not effect your statutory rights.

ENVIRONMENTAL PROTECTION



Through purchase of this product, the customer is taking on the obligation to deal with Waste Electrical/Electronic Equipment (WEEE) in accordance with the WEEE regulations in relation to the treatment, recycling & recovery and environmentally sound disposal of the WEEE. In effect, this means that this product must not be disposed of with general household waste. It must be disposed of according to the laws governing Waste Electrical and Electronic Equipment (WEEE) at a recognised disposal facility.

GENERAL SAFETY RULES



WARNING: WHEN USING ELECTRIC TOOLS, BASIC SAFETY PRECAUTIONS SHOULD ALWAYS BE FOLLOWED TO REDUCE THE RISK OF FIRE, ELECTRIC SHOCK AND PERSONAL INJURY INCLUDING THE FOLLOWING. READ ALL THESE INSTRUCTIONS BEFORE ATTEMPTING TO OPERATE THIS PRODUCT AND SAVE THESE INSTRUCTIONS FOR FUTURE REFERENCE.

GENERAL SAFETY IN THE WORKPLACE

1. Always ensure that air can circulate around the machine and that the air vents are unobstructed.
2. Always keep work area clean & tidy. Cluttered work areas and benches invite accidents.
3. Never over-reach. Keep proper footing and balance at all times.
4. Never store equipment in a wet/damp environment or expose to rain.
5. Keep other persons away. Do not let persons, especially children, not involved in the work, touch the tool or extension cable and keep them away from the work area.
6. Never operate a machine when under the influence of alcohol, drugs or medication.
7. Always ensure the workplace is well lit. Ensure that lighting is placed so that you will not be working in your own shadow.
8. Do not use tools in the presence of flammable liquids or gasses.
9. Stay alert, watch what you are doing, use common sense and do not operate the tool when you are tired.

CARE OF POWER TOOLS

1. Read this manual carefully. Learn the machines applications and limitations, as well as the specific potential hazards peculiar to it.
2. Always keep guards in place and in working order. A guard or other part that is damaged should be properly repaired or replaced by an authorised service centre, unless otherwise indicated in this instruction manual.
3. Remove any adjusting keys or wrenches before starting. Form the habit of checking to ensure that keys, wrenches and tools are removed from the machine.
4. Don't force the machine and use the correct tool. It will do the job better and safer, at the rate for which it was intended.

5. Always disconnect the machine from the power supply before carrying out any servicing or changing of accessories.
6. Before further use of the tool, it 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 or other condition that may affect its operation.
7. Have defective switches repaired by an authorised service centre. Do not use a tool if the switch does not turn it on and off.
8. Always check for any damage or any condition that could affect the operation of the machine. Damaged parts should be properly repaired.
9. Never remove the cover panel unless the machine is disconnected from the power supply, and never use the machine with cover panels removed.
10. Have your tool repaired by a qualified person. This tool complies with the relevant safety rules. Repairs should only be carried out by qualified persons using original spare parts, otherwise this may result in considerable danger to the user.
11. Never use this product for any other purpose than that described in this booklet.
12. Never abuse the power cable by yanking the cable to disconnect it from the socket. Keep the cable away from heat, oil or sharp edges.
13. Guard against electric shock. Avoid body contact with earthed or grounded surfaces.
14. If the tool should be used outdoors, use only extension cables intended for outdoor use and marked accordingly.
15. Avoid accidental starting by making sure the power switch is off before plugging in the power cable.

ADDITIONAL SAFETY RULES FOR DRILL PRESSES



CAUTION: AS WITH ALL MACHINERY, THERE ARE CERTAIN HAZARDS INVOLVED WITH THEIR OPERATION AND USE. EXERCISING RESPECT AND CAUTION WILL CONSIDERABLY LESSEN THE RISK OF PERSONAL INJURY. HOWEVER, IF NORMAL SAFETY PRECAUTIONS ARE OVERLOOKED, OR IGNORED, PERSONAL INJURY TO THE OPERATOR, OR DAMAGE TO PROPERTY MAY RESULT.

1. **IMPORTANT:** You should not operate this machine unless you are thoroughly familiar with drilling machines and drilling techniques. If there is any doubt whatsoever you should consult a qualified person.
2. Never operate the machine until it is completely assembled and you have read and understood this entire manual.

3. Always use clamps or a drill vice bolted to the table, to hold the work. It should never be held with bare hands.
4. Always shut off the power & remove drill bit before leaving the machine.
5. Always make all adjustments with the power off.
6. Always use the correct drilling speeds for the drill size and the type of material being drilled.
7. Never leave the drill unattended whilst it is running. Turn the machine OFF and do not leave until it has come to a complete stop.
8. Always remove and store the drill bits when you have finished work.
9. Never attempt to drill into a workpiece that does not have a flat surface unless a suitable support is used.
10. Always stop the drill before removing workpieces, work supports or swarf from the table.
11. Keep drills sharp and clean for best and safest performance. Follow instructions for changing accessories.
12. Adjust the table or depth stop to avoid drilling into the table surface.
13. Always be sure that the drill bit is securely locked in the chuck.
14. Never assemble or set up any work on the table while the drill is running.
15. Always ensure the table lock is tight before starting the drill.
16. Keep handles dry, clean and free from oil and grease.
17. Always keep hands and fingers away from the drill bit.



WARNING: DUST GENERATED FROM CERTAIN MATERIALS CAN BE HAZARDOUS TO YOUR HEALTH. ALWAYS OPERATE THE DRILL IN A WELL VENTILATED AREA. USE A DUST COLLECTION SYSTEM IF POSSIBLE.

WARNING: THE USE OF ANY ACCESSORY OR ATTACHMENT OTHER THAN ONE RECOMMENDED IN THIS INSTRUCTION MANUAL MAY PRESENT A RISK OF PERSONAL INJURY.

PROTECTIVE CLOTHING

1. Dress properly. Loose clothing or other jewellery may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
2. Always wear safety glasses. (Everyday glasses are not safety glasses.)
3. Wear a face mask if drilling into any material which produces dust.

ELECTRICAL CONNECTIONS



WARNING! Read these electrical safety instructions thoroughly before connecting the product to the mains supply.

Before switching the product on, make sure that the voltage of your electricity supply is the same as that indicated on the rating plate. This product is designed to operate on 230VAC 50Hz. Connecting it to any other power source may cause damage.


This product may be fitted with a non-rewireable plug. If it is necessary to change the fuse in the plug, the fuse cover must be refitted. If the fuse cover becomes lost or damaged, the plug must not be used until a suitable replacement is obtained.

If the plug has to be changed because it is not suitable for your socket, or due to damage, it should be cut off and a replacement fitted, following the wiring instructions shown below. The old plug must be disposed of safely, as insertion into a mains socket could cause an electrical hazard.

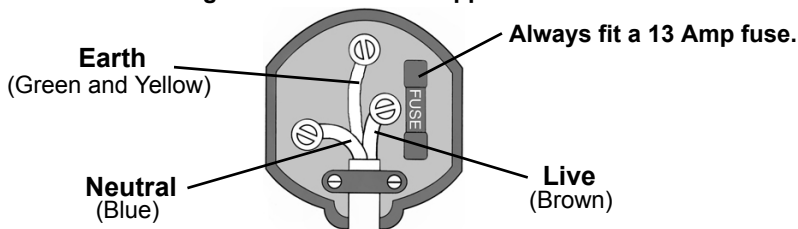


**WARNING! The wires in the power cable of this product are coloured in accordance with the following code:
Blue = Neutral Brown = Live Yellow and Green = Earth**

If the colours of the wires in the power cable of this product do not correspond with the markings on the terminals of your plug, proceed as follows.

- The wire which is coloured **Blue** must be connected to the terminal which is marked **N** or coloured **Black**.
- The wire which is coloured **Brown** must be connected to the terminal which is marked **L** or coloured **Red**.
- The wire which is coloured **Yellow and Green** must be connected to the terminal which is marked **E** or  or coloured **Green**.

Plug must be BS1363/A approved.

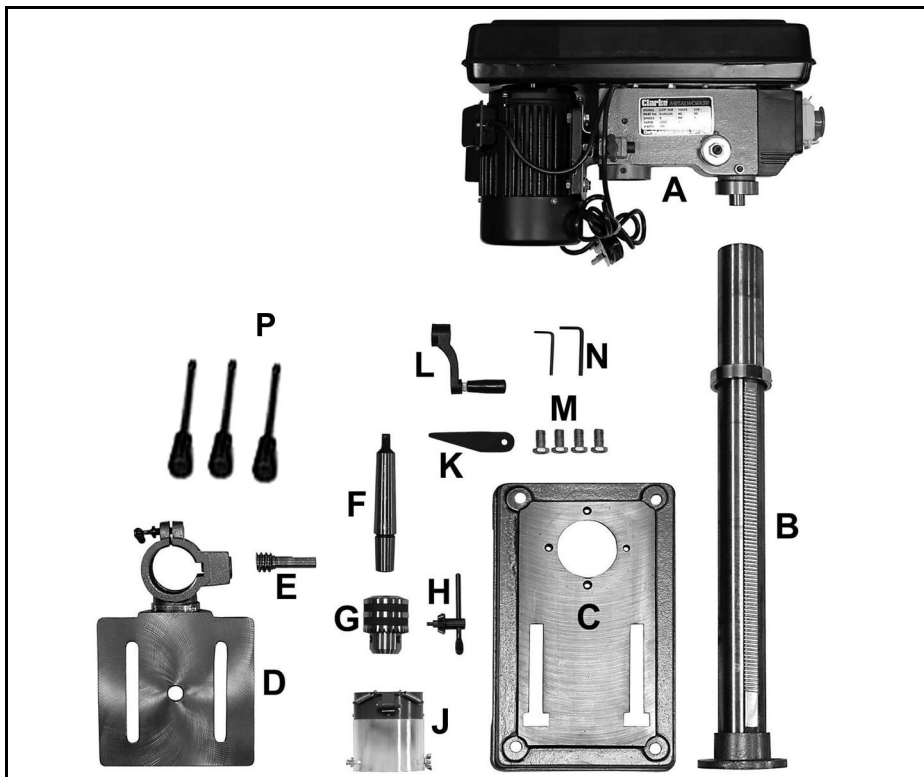


Ensure that the outer sheath of the cable is firmly held by the clamp

We strongly recommend that this machine is connected to the mains supply via a Residual Current Device (RCD)

If in any doubt, consult a qualified electrician. DO NOT attempt any repairs yourself.

PARTS INVENTORY



A	Head Assembly
B	Column c/w Rack
C	Base
D	Table
E	Worm Drive
F	Arbor
G	Chuck

H	Chuck Key
J	Chuck Guard Assembly
K	Drift Wedge
L	Crank Handle
M	Bolts M10 x 25
N	Hex Keys
P	Feed Handles (x 3)

UNPACKING

The drill press is delivered with the components shown on page 7.

Check the parts against the list. Should there be any deficiencies or damage, you should contact your CLARKE dealer immediately where the product was originally purchased. Do not discard the packaging until the machine is assembled. The packaging consists of cardboard and appropriately marked materials which can be sent to a re-cycling facility.

To protect the machine parts from moisture, a protective coating of light machine oil will have been applied to the outside surfaces. Remove any excess with a paper towel.

Take care when lifting the head assembly, considering its weight.

Before use, the machine must be mounted, and securely bolted, to a strong, heavy workbench, of sufficient height that you will be standing upright when working.

Ensure the work place is adequately lit, and that you will not be working in your own shadow.

ASSEMBLY

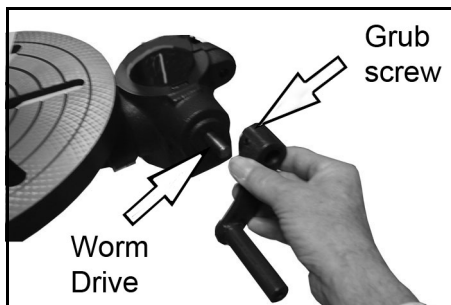
COLUMN TO BASE

1. Bolt the column assembly to the base with the four bolts provided.

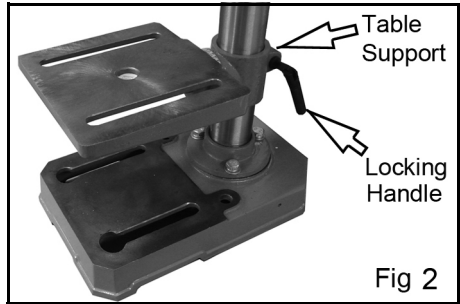
NOTE: Ideally, the base with column attached, should be firmly bolted to the workbench, prior to the assembly of other components.

TABLE TO COLUMN

1. From the loose parts, locate the worm and install it in the gear housing of the table support, liberally greased and pushed fully home.
2. Push the crank on to the worm spigot, protruding from the gear housing, as far as it will go and tighten the crank's grub screw on to the flat of the spigot using a hex key.



3. Slacken the grub screw securing the collar to the column and pull collar and rack off the column.
4. Slide the rack through the slot in the table support with the long, smooth end uppermost, so that the rack teeth engage with the worm, as shown in Fig 2, and holding in this position, slide the table support, with rack, onto the column.



5. Lower the assembly so that the end of the rack sits fully into the groove at the base of the column support, then replace the collar on to the column, with the groove facing downwards to grip the rack.

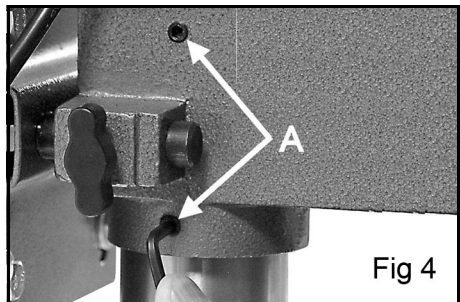


6. With the rack sitting snugly in the grooves, top and bottom, tighten the collar grub screw with a hex key, as shown in Fig 3, ensuring there is sufficient clearance to allow the complete table assembly to move around the column.
7. Check to ensure the table moves smoothly from top to bottom of the rack by turning the handle. If necessary ease off the rack collar by slackening the grub screw and repositioning the collar to achieve a good movement.

HEAD TO COLUMN

NOTE: It may be necessary to unscrew the head lock set screws (A in fig.4), to ensure they do not protrude internally, as this would prevent the head from sliding fully into position.

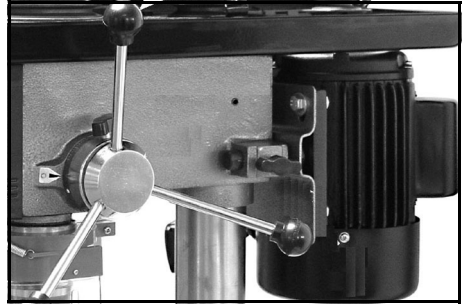
1. With the help of an assistant, raise the head assembly, and locate it on top of the column, ensuring it slides home fully.
2. Align the head with the base, and tighten down the head lock set screws using the wrench (key) provided as shown in Fig 4.



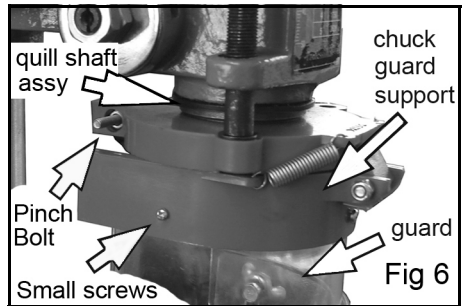
3. Locate the three feed handles, and screw them firmly into the hub of the feed shaft as shown in Fig.5.

CHUCK GUARD ASSEMBLY

NOTE: This task should be carried out before the chuck is installed.



1. Assemble the transparent guard to the guard support using the small bolt/nut and the two small screws provided. (A small x-head screwdriver will be required.)
2. Slide the Chuck Guard over the Quill Shaft and nip up the pinch bolt, temporarily, with the pinch bolt facing the front (see fig 6). Ensure the Quill Shaft/Spindle is at the top of its travel.



INSTALLING THE CHUCK

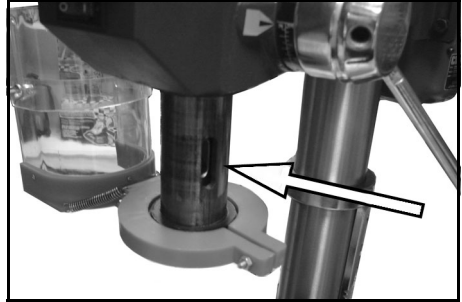
1. Open the jaws of the chuck to their maximum, using the chuck key supplied. Ensure the tapered hole in the chuck is clean and connect the arbor to the chuck using the grub-screw and tighten securely.
2. Slacken the chuck guard pinch bolt and turn the chuck guard so the pinch bolt is towards the rear and tighten the pinch bolt.
3. Ensuring the arbor is clean and burr free. Seat the arbor into the quill shaft till it bears against the drive spindle and tap the chuck firmly with a rubber mallet until the tapered end of the arbor engages with the spindle.



CAUTION: IF A RUBBER MALLET IS NOT AVAILABLE, PROTECT THE CHUCK WITH A BLOCK OF SCRAP TIMBER BEFORE STRIKING WITH A HAMMER. ALWAYS ENSURE THE CHUCK JAWS ARE FULLY CLOSED BEFORE STRIKING THE CHUCK

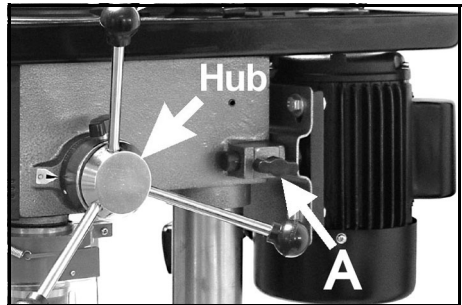
REMOVING THE CHUCK

1. Turn the lower feed handles to lower the chuck to its lowest position.
2. Insert a tapered drift key into the corresponding slot in the quill assembly and tap sharply with a mallet to release the tapered chuck arbor.
3. Take care to catch the chuck and arbor as it falls.



BELT TENSIONING

1. Slacken the two belt tension locking screws (A Fig 9), then lever the motor, on its bracket, away from the head, so that tension is applied to the belt.
2. Tension is correct when the belt deflects by approx. 1/2" at the centre of its run when using reasonable thumb pressure. Lock the motor in this position by tightening the two locking screws (A).



NOTE: If the belt should slip whilst drilling, adjust the belt tension.

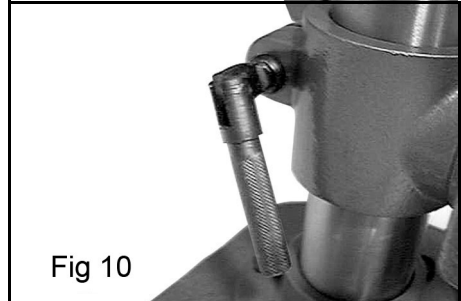
CHECKING THE OPERATION OF THE MICROSWITCH

When closing the cover, check the operation of the micro-switch. It is important that it operates immediately the cover is pulled open, in order to prevent the machine from operating.....NOT when the cover is opened sufficiently for fingers to be inserted. If necessary, bend the actuating tab, which is attached to the cover, to ensure this.

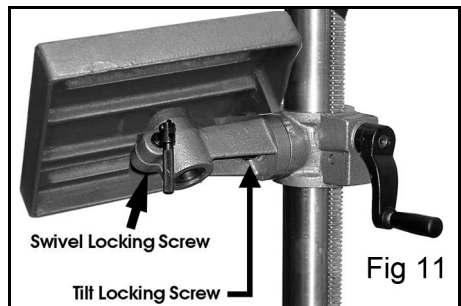
SETTINGS AND ADJUSTMENTS

TABLE

The table may be raised, lowered or swivelled about the column, by slackening off the table support locking handle, adjusting the table position accordingly and re-tightening the handle.

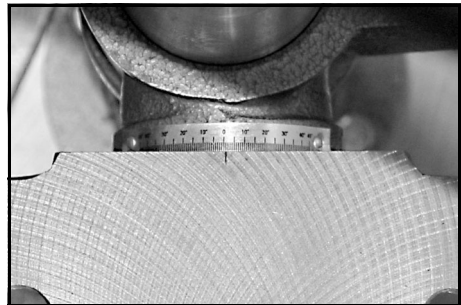


It may also be tilted by loosening the screw which secures the table to its mount beneath the table, tilting the table to the required position and re-tightening the bolt shown in Fig 11.



A bevel scale is provided on the table mounting, (measured in degrees), to assist in setting the required angle. However, for greater accuracy the use of a protractor is recommended.

For all normal operations, the table should be set to 0°. This should be checked with a set-square.



To check to ensure the drill is entirely perpendicular to the table, install a large drill bit in the chuck, place a square on the table, and bring it up to the drill. Adjust the table tilt if necessary, so that the table is perfectly square.

SPINDLE DEPTH STOP

Located around the spindle feed shaft is a depth stop collar carrying a graduated scale (A, Fig.13). The collar is capable of turning about the shaft and may be locked in place by locking screw B. The graduations are metric (mm).

To set a drilling depth:

With the drill bit installed and tightened securely, lower it...WITH THE POWER OFF, so that it lightly contacts the work, and hold in that position with one hand whilst slackening the locking screw (B) and rotating the scale (A) ANTICLOCKWISE until it stops.

The zero mark should now be opposite the pointer (C).

To check to ensure the table is square to the drill, insert a piece of straight round bar in the chuck, place a square on the table and bring it up to the round bar. Adjust the table tilt if necessary so that the table is correctly aligned

Maintaining a light pressure on the drill bit, back off the scale ring until the value of the desired depth of cut (mm), is opposite the pointer, then tighten the locknut (B).

The drill is now set to drill holes to your desired depth. i.e. Providing your workpiece is level and flat, you may drill a series of holes, each to the same depth, quickly and accurately.

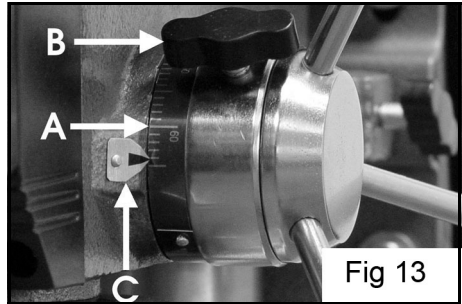
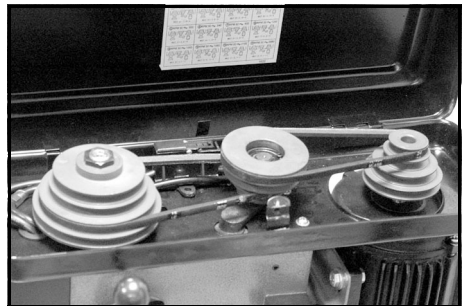


Fig 13

CHANGING DRILL (SPINDLE) SPEED

Before changing the speeds, ensure the machine is switched OFF, and disconnected from the power supply.

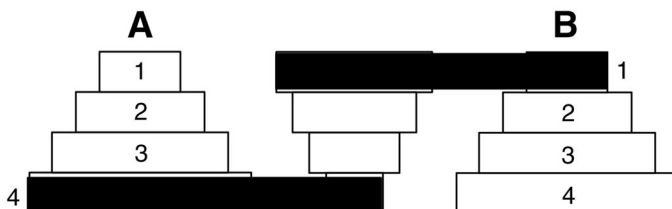
1. Open the pulley cover.
2. Slacken off the belt tension locking screw, to relieve any tension on the drive belt.
3. Consult the chart inside the pulley cover, and position the belt on the pulley's according to the spindle speed required.
4. When the belt has been correctly positioned, re-tension by levering the motor away from the head, until the belt deflects by approx. $\frac{1}{2}$ " at its centre when using reasonable thumb pressure. Lock the motor in this position with the belt tension locking screws.



DRILL OPERATING SPEEDS

The table below gives the belt arrangement for given drill speeds.

A similar chart is also located on the inside of the pulley cover.



The diagram shows the belts fitted to step 4 of the spindle pulley and step 1 of the motor pulley, giving a speed of 210rpm.

	SPINDLE PULLEY A	MOTOR PULLEY B	DRILL SPEED RPM
1	4	1	210
2	4	2	280
3	3	1	320
4	2	1	420
5	3	2	500
6	4	3	540

	SPINDLE PULLEY A	MOTOR PULLEY B	DRILL SPEED RPM
7	1	2	830
8	2	3	1290
9	3	4	1350
10	1	3	1580
11	2	4	2180
12	1	4	2580

OPERATION

1. Insert the drill into the jaws of the chuck by approx 1", ensuring that the jaws do not touch the flutes of the drill. Before tightening the chuck, ensure that the drill is centred within the jaws.
2. Ensure the table height and position is set, so that drill travel is sufficient for the job in hand.
3. Ensure the work is securely clamped or held in a drill vice, bolted to the table. Never hold it with bare hands. Personal injury may be caused if the workpiece is whipped out of the operator's hand, and damage to the machine incurred if the work strikes the column.

If the workpiece is of irregular shape and cannot be laid flat on the table, it should be securely blocked and clamped.

Any tilting, twisting, or shifting, results not only in a rough hole, but also increases drill bit breakage.

4. For small workpieces that cannot be clamped to the table, use a drill press vice. The vice must be clamped or bolted to the table.
5. When drilling completely through wood, always position a piece of scrap wood between the workpiece and the table to prevent splintering on the underside of the workpiece as the drill breaks through. The scrap piece of wood must make contact with the left side of the column as shown in Fig 15 to prevent it moving.

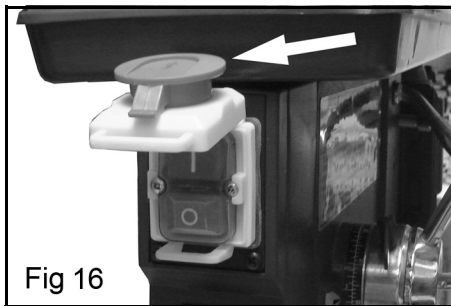


6. In addition, set the depth of drill travel, so that the drill cannot possibly come into contact with the table, or align the table so that the hole in its centre is in line with the drill bit.
7. When completely satisfied that the setup is sound, lower the chuck guard into place, and switch the machine ON by pushing the 'I' button. To switch OFF, push the 'O' button, see Fig 16.

NOTE: As a safety feature, the ON/OFF switch is a 'No Volt Release' type. Therefore, if the power is interrupted whilst the machine is switched ON, it will not automatically start when the power is restored.

Form the habit of checking to see that the chuck key is removed from the machine before turning it on.

A micro switch is provided within the pulley cover, which prevents the machine from operating unless the pulley cover is fully closed.



CUTTING SPEEDS

Factors which determine the best speed to use in any drill press operation are:

- Type of material being worked
- Size of hole
- Quality of cut desired
- Type of drill

Generally, the smaller the drill, the greater the required RPM. In soft material, the speed should be higher than for hard metals.

As a guide, the drill speed for a given drill bit size, is according to the table below:

Speed Range	(rpm)	2180 - 2580	1580	1290 - 1350	830	500 - 540	320- 420	210- 280
Wood	inches mm	1/4 6.4	3/8 9.5	5/8 16	- -	- -	- -	- -
Zinc Diecast	inches mm	3/16 4.8	1/4 6.4	3/8 9.5	1/2 12.5	5/8 16	- -	- -
Alum & Brass	inches mm	1/8 3.2	3/16 4.8	3/8 9.5	1/2 12.5	11/16 17.5	- -	- -
Plastic	inches mm	1/8 3.2	3/16 4.8	5/16 7.9	7/16 11	1/2 12.5	5/8 16	- -
Cast Iron & Bronze	inches mm	3/32 2.4	1/8 3.2	1/4 6.4	11/32 8.75	1/2 12.5	5/8 16	- -
Mild Steel & Malleable	inches mm	1/16 1.6	3/32 2.4	5/32 4	1/4 6.4	3/8 9.5	1/2 12.5	- -
Cast Steel & Med Carbon	inches mm	3/64 1.2	1/16 1.6	1/8 3.2	3/16 4.8	5/16 7.9	7/16 11	9/16 14.5
Stainless & Tool Steel	inches mm	1/32 0.8	3/64 1.2	1/16 1.6	1/8 3.2	1/4 6.4	3/8 9.5	1/2 12.5

DRILL PRESS VICES

In order to secure the workpiece to the table, a complete range of Drill Press vices, Cross Vices and Clamps, is available from your Clarke dealer.

MAINTENANCE

For maximum performance, it is essential that the machine is properly maintained. Always inspect it before use. Any damage should be repaired, and faults rectified. Always remove the plug from the power supply before carrying out any adjustment, servicing or maintenance.

Please refer to the trouble shooting chart on page 19. If you are unable to rectify any faults, please contact your local dealer or Clarke International for assistance.

MONTHLY (IF IN CONSTANT USE)

1. Check tightness of mounting bolts and head and column securing set screws.
2. Check the drive belt for wear, and replace if frayed or damaged.
3. Blow out with compressed air, or vacuum clean out, any dust that may have accumulated in the motor fan vents.
4. Apply a thin coat of wax paste or light oil to the table and column, for lubrication, and to help prevent corrosion.

If the mains lead is damaged in any way, it should be replaced immediately.

LUBRICATION

All bearings are packed with grease at the factory and require no further lubrication.

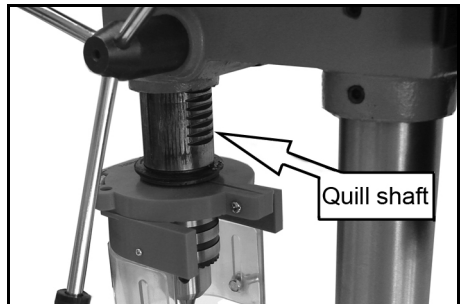
Occasionally, lubricate the quill shaft assembly with light oil if required.

AFTER USE

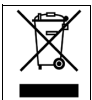
Remove all swarf from the machine and thoroughly clean all surfaces.

Components should be kept dry, with machined surfaces lightly oiled.

Always remove drill bits and store in a safe place.



ENVIRONMENTAL PROTECTION



Recycle unwanted materials instead of disposing of them as waste. Any tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment.

TROUBLESHOOTING

PROBLEM	PROBABLE CAUSE	REMEDY
Noisy operation (under load).	<ul style="list-style-type: none"> a. Incorrect belt tension. b. Dry spindle. c. Loose pulley. d. Loose belt. e. Worn bearing. 	<ul style="list-style-type: none"> a. Adjust tension. b. Remove spindle and quill assembly and lubricate. c. Tighten pulley. d. Adjust belt tension. e. Replace bearing.
Excessive drill wobble.	<ul style="list-style-type: none"> a. Loose chuck. b. Worn spindle or bearing. c. Worn chuck. d. Bent drill bit. 	<ul style="list-style-type: none"> a. Tighten by pressing chuck down on to a block of wood against the table. b. Replace spindle shaft or bearing. c. Replace chuck. d. Renew drill bit.
Motor won't start.	<ul style="list-style-type: none"> a. Power supply. b. Motor connection. c. NVR switch connection faulty. d. Faulty switch. e. Motor windings burned. f. Pulley cover not closed. g. Micro switch on cover not operating. 	<ul style="list-style-type: none"> a. Check power cord/fuse. b. Check motor connections. c. Check switch connections. d. Replace switch. e. Replace motor. f. Close pulley cover. g. Check operation of micro switch, and renew/adjust as necessary. (Consult your Clarke dealer for advice).
Drill binds in work-piece.	<ul style="list-style-type: none"> a. Excessive feed pressure. b. Loose belt. c. Loose drill. d. Incorrect bit speed. e. Drill angles incorrect for type of material. 	<ul style="list-style-type: none"> a. Apply less pressure. b. Check belt tension. c. Tighten drill with key. e. Refer to Cutting Speed chart and adjust drill speed accordingly. e. Consult a technical manual dealing with materials, drills and cutting angles, and sharpen drill accordingly.

Drill bit burns or smokes.	a. Incorrect speed. b. Swarf is not discharging c. Dull drill or not proper clearance for material. d. Needs coolant. e. Excessive feed pressure	a. Refer to Cutting Speed chart & adjust drill speed accordingly. b. Clean drill. c. Check sharpness & taper. d. Use coolant whilst drilling. e. Apply less pressure.
Table difficult to raise.	a. Needs lubrication. b. Table lock tightened.	a. Lubricate with light oil. b. Loosen clamp.

SUITABLE ACCESSORIES

Drill Press Vices available from your Clarke dealer include:

Model	Jaw Width	Max Opening	Depth	Weight	Part No
CDV30C	76 mm	78 mm	19 mm	2 kg	6504019
CDV40C	102 mm	97 mm	28 mm	3 kg	6504020
CDV50C	127 mm	125 mm	37 mm	5 kg	6504021
CDV60C	152 mm	150 mm	38 mm	6 kg	6504022



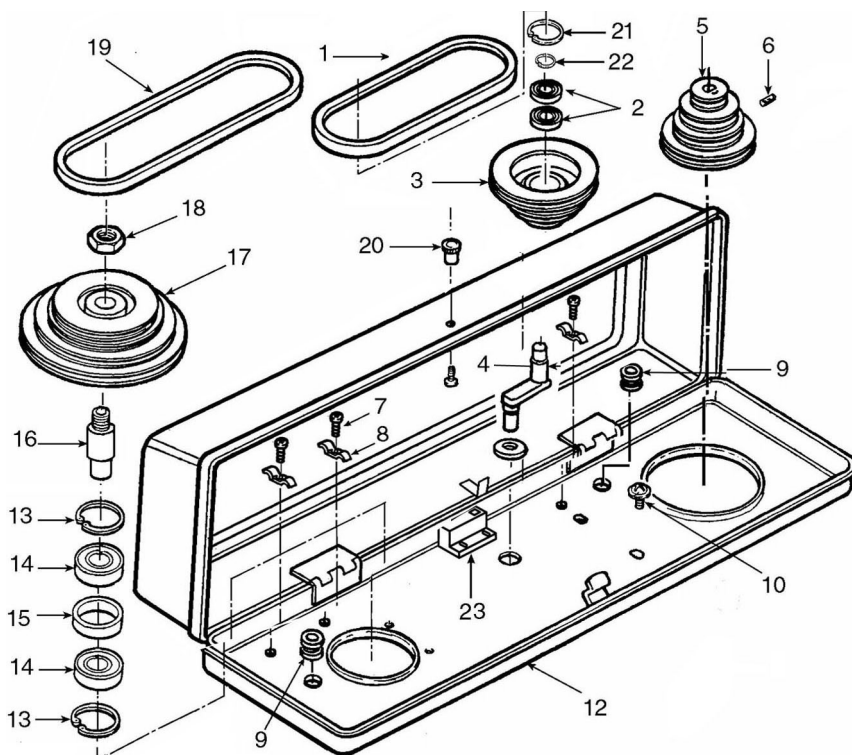
Table Clamps available from your Clarke dealer include:

Model	Size	Max Clamp Height	Part No
CVC6	152 mm	38 mm	6501920
CVC9	229 mm	95 mm	6501925

SPECIFICATION

Overall Height	840 mm
Column to Chuck Centre	127 mm
Table Dimensions	200 x 200 mm
Base Dimensions	210 x 340 mm
Column Dia	60 mm
Chuck Capacity	16 mm
Max Chuck to Table Distance	350 mm
Max Chuck to Base Distance	465 mm
Spindle Speed Range	210 - 2580 rpm
No of Speeds	12
Spindle Taper	MT2
Max Spindle Travel	60 mm
Belt Type	K550
Product Weight	42 kg
Motor supply	230Vac/50Hz/1 ph
Power Rating	370 W
Current Rating	1.3A
Machine Speed	210-2580rpm

COMPONENT PARTS - PULLEY ASSEMBLY

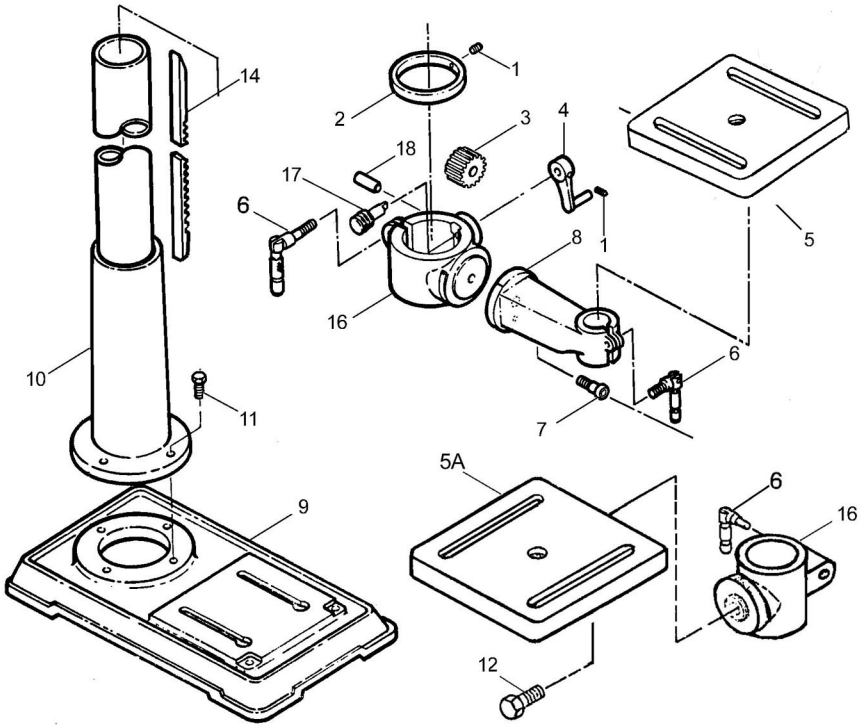


No	Description
1	Belt
2	Bearing
3	Idler Pulley
4	Idler Shaft
5	Motor Pulley
6	Grub Screw
7	Screw
8	Cable Clamp
9	Grommet
10	Screw

No	Description
12	Pulley Cover
13	Circlip
14	Bearing
15	Spacer
16	Shaft
17	Pulley
18	Securing Screw
20	Cover Knob
21	Circlip
22	Circlip

All items please ref: QBCDP10BP01-22

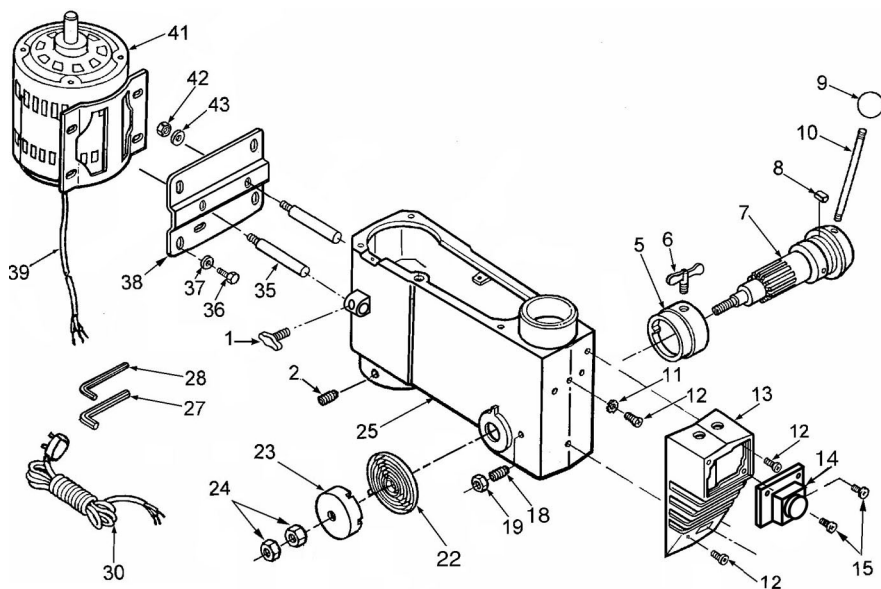
COMPONENT PARTS - BASE ASSEMBLY



No	Description
1	Grubscrew
2	Rack Collar
3	Pinion
4	Handle Assembly
5A	Square Table
6	Clamp
7	Base

No	Description
10	Column
11	Bolt M8
12	Table Tilt Bolt
14	Rack
16	Table Trunnion
17	Worm
18	Pinion Pin
All items please ref: QBCDP10BB01 onwards	

COMPONENT PARTS -HEAD ASSEMBLY

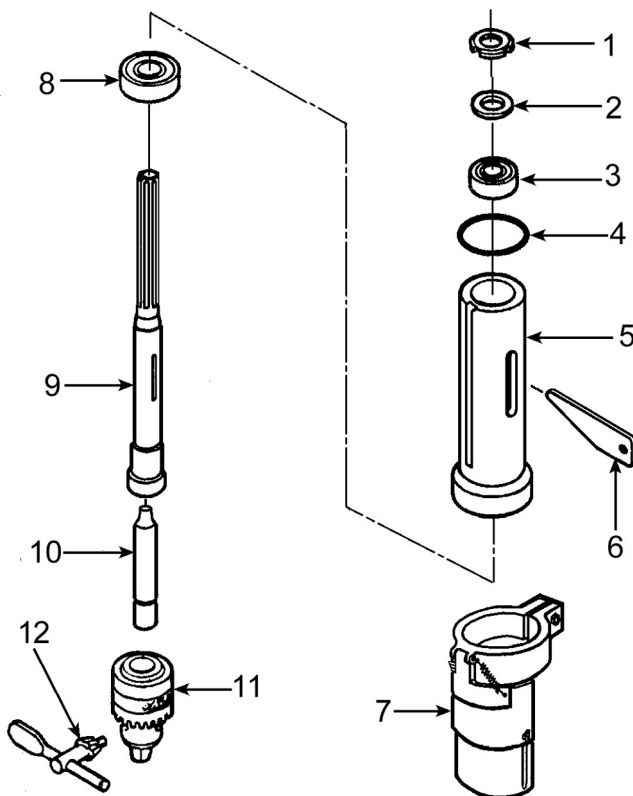


No	Description
1	Locking Screw
2	Grub Screw
3	Collar
4	Shaft
5	Screw
6	Knob
7	Handle
8	Washer
9	Screw
10	Plastic Cover
11	Switch Assembly
12	Screw
13	Grub Screw
19	Locknut
22	Spring

No	Description
23	Spring Cover/Adjuster
24	Nut
25	Head Assembly
27	Allen Key
28	Allen Key
30	Cable Assembly
35	Adjuster Bar
36	Bolt
37	Washer
38	Motor Adjuster Plate
39	Motor Cable
41	Motor Assembly
42	Nut
43	Washer

All items please ref: QBCDP10HB01 on

COMPONENT PARTS - QUILL ASSEMBLY



No	Description
1	Lock Nut
2	Flat Washer
3	Bearing
4	O-Ring
5	Quill Shaft
6	Wedge Drift

No	Description
7	Chuck Guard Assembly
8	Bearing
9	Spindle
10	Arbor
11	Chuck
12	Chuck Key

When ordering spare parts, please quote the reference QBCDP10QB01 onwards.

DECLARATION OF CONFORMITY

ClarkeTM
INTERNATIONAL



DECLARATION OF CONFORMITY

We declare that this product complies to the following standards/directives:

- **73/23/EEC**
- **EN 60/335**
- **89/336/EEC**

Product Description: **DRILL PRESS**
Model Number: **CDP 10B and CDP15F**

Signed  _____

Clarke[®] **INTERNATIONAL**
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NOTES

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