

# 1/3 HP 5 SPEED DRILL PRESS WITH REDEYE®

DP250LS  
INSTRUCTION MANUAL



# GMC®

**GLOBAL MACHINERY COMPANY**

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Code: DP250LS

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Date: 071120

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## Warranty Power Tools

Whilst every effort is made to ensure your complete satisfaction with this tool, occasionally, due to the mass manufacturing techniques, a tool may not live up to our required level of performance and you may need the assistance of our service department.

This product is warranted for a 2-year period for home domestic use from the date of the original purchase. If found to be defective in materials or workmanship, the tool or the offending faulty component will be repaired or replaced free of charge with another of the same item. A small freight charge may apply. Proof of purchase is essential. We reserve the right to reject any claim where the purchase cannot be verified.

This warranty does not include damage or defects to the tool caused by or resulting from abuse, accidents, alterations or commercial or business use. It also does not cover any bonus items or included accessories. Only the power tool is covered under this warranty.

With continuing product development, changes may have occurred which render the product received slightly different to that shown in this instruction manual.

Please ensure that you store your receipt in a safe place.

Conditions apply to the above warranty. For full details of the warranty terms and conditions please refer to our website – [www.gmcompany.com](http://www.gmcompany.com)

For prompt service we suggest you log your service request online - [www.gmcservice.com.au](http://www.gmcservice.com.au), should you not have access to the internet, please contact our service department on 1300 880 001 (Australia) or 0800 445 721 (New Zealand).

## Introduction

Your new GMC power tool will more than satisfy your expectations. It has been manufactured under stringent GMC Quality Standards to meet superior performance criteria.

You will find your new tool easy and safe to operate, and, with proper care, it will give you many years of dependable service.

**CAUTION.** Carefully read through this entire Instruction Manual before using your new GMC Power Tool. Take special care to heed the Cautions and Warnings.

Your GMC power tool has many features that will make your job faster and easier. Safety, performance, and dependability have been given top priority in the development of this tool, making it easy to maintain and operate.

## Environmental protection



Recycle unwanted materials instead of disposing of them as waste. All tools, hoses and packaging should be sorted, taken to the local recycling centre and disposed of in an environmentally safe way.

## WARNING

1. It may be more difficult to see the laser line in conditions of bright sunshine and on certain surfaces.

## Description of symbols

The rating plate on your tool may show symbols. These represent important information about the product or instructions on its use.



Wear hearing protection.

Wear eye protection.

Wear breathing protection.



N380

Conforms to relevant standards for electromagnetic compatibility.

## Specifications

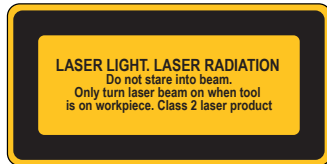
Voltage:	230–240Vac ~ 50Hz
Input Power:	250W
Speeds:	5
No Load Speed:	500, 890, 1400, 1900, 2500 RPM
Chuck Size:	13mm
Chuck Type:	Keyed
Drilling Capacity:	13mm
Stroke Length:	50mm
Laser Class:	II
Laser Wavelength:	650nm
Laser Output Power:	≤1mW

## Safety rules for laser lights

The laser light/laser radiation used in the GMC REDEYE® system is Class 2 with maximum 1mW power and 650nm wavelengths. These lasers do not normally present an optical hazard, although staring at the beam may cause flash blindness.

**WARNING.** Do not stare directly at the laser beam. A hazard may exist if you deliberately stare into the beam, please observe all safety rules as follows;

- The laser shall be used and maintained in accordance with the manufacturer's instructions.
- Never aim the beam at any person or an object other than the work piece.



- The laser beam shall not be deliberately aimed at personnel and shall be prevented from being directed towards the eye of a person for longer than 0.25s.
- Always ensure the laser beam is aimed at a sturdy work piece without reflective surfaces. i.e. wood or rough coated surfaces are acceptable. Bright shiny reflective sheet steel or the like is not suitable for laser use as the reflective surface could direct the beam back at the operator.
- Do not change the laser light assembly with a different type. Repairs must only be carried out by the laser manufacturer or an authorised agent.

**CAUTION.** Use of controls or adjustments or performance of procedures other than those specified herein may result in hazardous radiation exposure.

Please refer to the relevant Australian standards, AS 2397 and AS/NZS2211 for more information on Lasers.

## General safety instructions

To use this tool properly, you must observe the safety regulations, the assembly instructions and the operating instructions to be found in this Manual. All persons who use and service the machine have to be acquainted with this Manual and must be informed about its potential hazards. Children and infirm people must not use this tool. Children should be supervised at all times if they are in the area in which the tool is being used. It is also imperative that you observe the accident prevention regulations in force in your area. The same applies for general rules of occupational health and safety.

**WARNING.** When using power tools, basic safety precautions should always be taken to reduce the risk of fire, electric shock and personal injury. Also, please read and heed the advice given in the additional important safety instructions.

- 1. Keep the work area clean and tidy.** Cluttered work areas and benches invite accidents and injury.
- 2. Consider the environment in which you are working.** Do not use power tools in damp or wet locations. Keep the work area well lit. Do not expose power tools to rain. Do not use power tools in the presence of flammable liquids or gases.
- 3. Keep visitors away from the work area.** All visitors and onlookers, especially children and infirm persons, should be kept well away from where you are working. Do not let others in the vicinity make contact with the tool or extension cord.
- 4. Store tools safely.** When not in use, tools should be locked up out of reach.
- 5. Do not force the tool.** The tool will do the job better and safer working at the rate for which it was designed.
- 6. Use the correct tool for the job.** Do not force small tools or attachments to do the job best handled by a heavier duty tool. Never use a tool for a purpose for which it was not intended.

- 7. Dress correctly.** Do not wear loose clothing or jewellery. They can be caught in moving parts. Rubber gloves and non-slip footwear are recommended when working outdoors. If you have long hair, wear a protective hair covering.
- 8. Use safety accessories.** Safety glasses and earmuffs should always be worn. A face or dust mask is also required if the sanding operation creates dust.
- 9. Do not abuse the power cord.** Never pull the cord to disconnect the tool from the power point. Keep the cord away from heat, oil and sharp edges.
- 10. Secure the work piece.** Use clamps or a vice to hold the work piece. It is safer than using your hand and frees both hands to operate the tool.
- 11. Do not overreach.** Keep your footing secure and balanced at all times.
- 12. Look after your tools.** Keep tools sharp and clean for better and safer performance. Follow the instructions regarding lubrication and accessory changes. Inspect tool cords periodically and, if damaged, have them repaired by an authorised service facility. Inspect extension cords periodically and replace them if damaged. Keep tool handles dry, clean and free from oil and grease.
- 13. Disconnect idle tools.** Switch off the power and disconnect the plug from the power point before servicing, when changing accessories and when the tool is not in use.
- 14. Remove adjusting keys and wrenches.** Check to see that keys and adjusting wrenches are removed from the tool before switching on.
- 15. Avoid unintentional starting.** Always check that the switch is in the OFF position before plugging in the tool to the power supply. Do not carry a plugged in tool with your finger on the switch.
- 16. Use outdoor rated extension cords.** When a tool is used outdoors, use only extension cords that are intended for outdoor use and are so marked.
- 17. Stay alert.** Watch what you are doing. Use common sense. Do not operate a power tool when you are tired.
- 18. Check for damaged parts.** Before using a tool, check that there are no damaged parts. If a part is slightly damaged, carefully determine if it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, proper mounting and any other conditions that may affect the operation of the tool. A part that is damaged should be properly repaired or replaced by an authorised service facility, unless otherwise indicated in this Instruction Manual. Defective switches must be replaced by an authorised service facility. Do not use a tool if the switch does not turn the tool on and off correctly.
- 19. Guard against electric shock.** Prevent body contact with grounded objects such as water pipes, radiators, cookers and refrigerator enclosures.
- 20. Use only approved parts.** When servicing, use only identical replacement parts. Use an authorised service facility to fit replacement parts.

### Additional safety rules for drill presses

**WARNING.** For your own safety, do not try to use your drill press or plug it in until it is completely assembled and installed according to the instructions and until you have read and understood the following:

1. Your drill press must be bolted securely to a workbench. In addition, if there is any tendency for your drill press to move during certain operations, bolt the workbench to the floor.
2. This drill press is intended for use in dry conditions and indoor use only.
3. Always wear safety goggles which comply to a recognised standard. Use a face or dust mask along with safety goggles if the drilling operation is dusty. Use ear protectors, especially during extended periods of operation.
4. Do not try to drill material too small to be securely held. Do not drill material that does not have a flat surface unless it is clamped securely.

5. Always keep hands out of the path of the drill bit. Avoid awkward hand positions where a sudden slip could cause your hand to move into the drill bit.
6. Do not install or use any drill bit that exceeds 175mm (7 inches) in length or extends more than 150mm (6 inches) below the chuck jaws. They can suddenly bend outwards or break.
7. Do not use wire wheels, router bits, shaper cutters, circle (fly) cutters or rotary planers on this drill press.
8. When cutting a large piece of material make sure it is fully supported at the table height.
9. Do not perform any operation freehand. Always hold the workpiece firmly against the table so it will not rock or twist. Use clamps or a vice for unstable workpieces.
10. Make sure there are no nails or foreign objects in the part of the workpiece to be drilled.
11. Whenever possible, position the workpiece to contact the left side of the column; if it is too short or the table is tilted, clamp solidly to the table.
12. If the workpiece overhangs the table such that it will fall or tip if not held, clamp it to the table or provide auxiliary support.
13. Set the drill press to a speed appropriate to the job.
14. Do not start the drill press while the drill bit is touching the workpiece.
15. When using a drill press vice, always fasten it to the table.
16. Make sure all clamps and locks are firmly tightened before drilling.
17. Securely lock the head and table support to the column, and the table to the table support before operating your drill press.
18. Never turn your drill press on before clearing the table of all objects (tools, scraps of wood etc.)
19. Before starting the operation, jog the motor switch to make sure the drill bit does not wobble or vibrate.
20. Let the spindle reach full speed before starting to drill. If your drill press makes an unfamiliar noise or if it vibrated excessively, stop immediately, turn the drill press off and unplug it. Do not restart until the problem is corrected.
21. Do not perform layout assembly or setup work on the table while the drill press is in operation.
22. Do not exceed the rpm stated on the bit or accessory. See the instructions that come with the accessory.
23. When drilling large diameter holes, clamp the workpiece firmly to the table. Otherwise, the bit may grab and spin the workpiece at high speed. Do not use fly cutters or multiple-part cutters, as they can come apart or become unbalanced in use.
24. Make sure the spindle has come to a complete stop before touching the workpiece.
25. To avoid injury from accidental starting, always turn the switch off and unplug the drill press before installing or removing any accessory attachment or making any adjustment.

**CAUTION!** Do not expose to rain or use in damp locations.

**WARNING!** For your own safety read instruction manual before operating drill press. Wear eye protection, do not wear gloves, necktie or loose clothing, clamp workpiece or brace against column to prevent rotation, use recommended speed for drill accessory and workpiece material.

## Unpacking

Due to modern mass production techniques, it is unlikely that your GMC Power Tool is faulty or that a part is missing. If you find anything wrong, do not operate the tool until the parts have been replaced or the fault has been rectified. Failure to do so could result in serious personal injury.

## Required tools

The following tools are required to assemble the drill press:

- 3mm, 4mm, 5mm Hex Keys (Supplied)
- Wrench (Not Supplied)
- Phillips Head Screwdriver (Not Supplied)

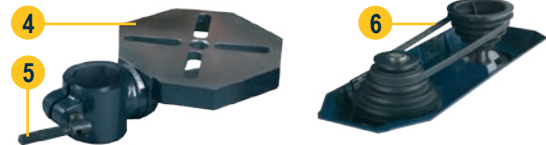
## Assembly time

The DP250LS drill press will take approximately 10-15 minutes to assemble.

## Components

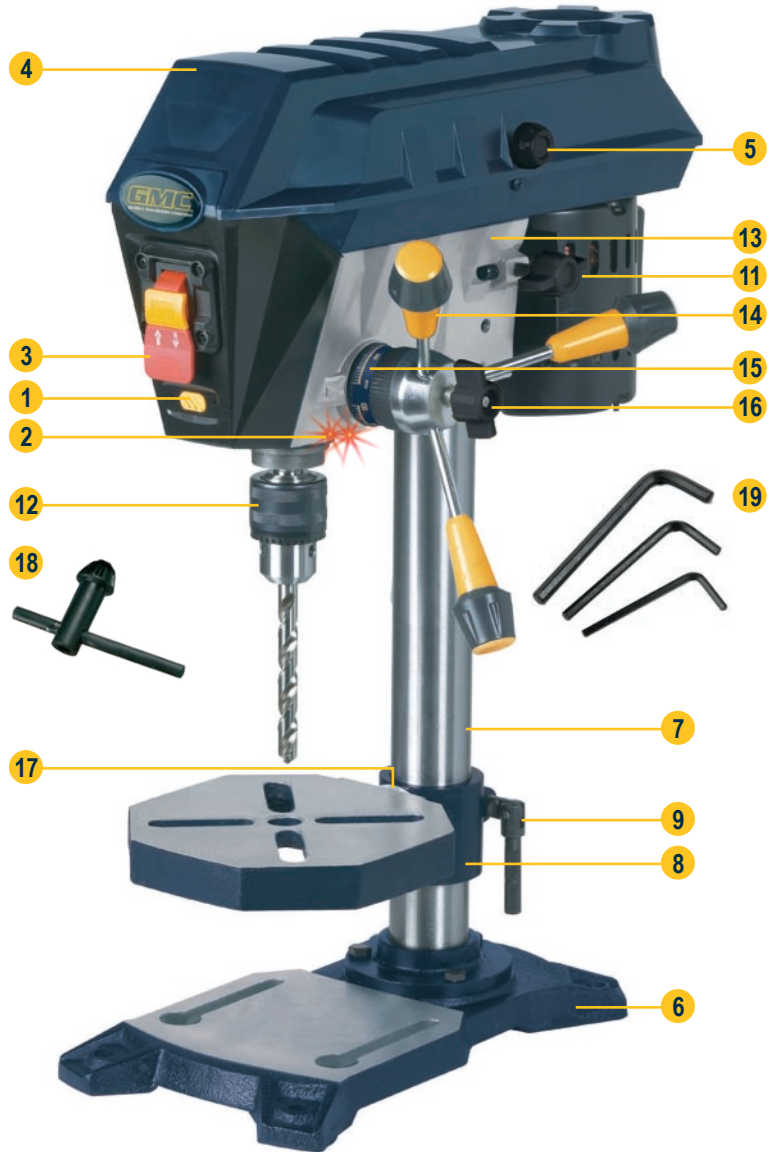
The DP250LS drill press is supplied with the following components:

1. Motor Head
2. Base
3. Column
4. Table
5. Table Lock (fitted)
6. Belt (fitted)
7. Handle Rods (x3)
8. Keyed Chuck
9. Chuck Key
10. Hex Keys (x3)
11. Bolts for attaching column to base (x3)
12. Instruction manual



## Know your product

1. Laser light on/off switch
2. Laser aperture (x2)
3. On/off switch
4. Pulley cover
5. Pulley cover knob
6. Base
7. Column
8. Table/Support Assembly
9. Table Lock
10. Belt (x1)
11. Belt Tension Knob
12. Keyed Chuck
13. Motor Head
14. Feed Handle
15. Depth Scale
16. Depth Locking Knob
17. Bevel Scale
18. Chuck Key
19. Hex Keys (3mm, 4mm, 5mm)





## Assembly

1. Place base (6) on floor.
2. Place column assembly (7) on base and align the 3 holes in the column assembly with the holes in the base.



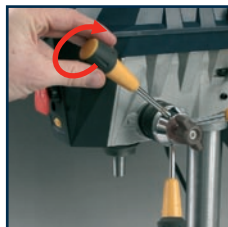
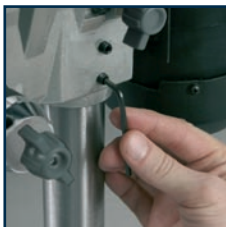
3. Using the 3 bolts secure the column support to the base and tighten with a 13mm wrench.



4. Fit the table (8) over the column and secure to the column using the table lock (9).



5. Fit the motor head (13) to the top of the column and tighten the 2 grub screws using the 4mm hex key. This will secure the head on the column.



6. Fit the 3 handle rods to the handle hub on the drill press head, attach them by rotating each handle in a clockwise direction.

7. Fit the chuck (12) onto the spindle and secure it by pushing it and giving it a sharp tap.



**Note.** Ensure both surfaces are clean before putting the chuck on the spindle.

## Adjusting the table height

**CAUTION.** Always ensure that the drill press is switched off and the plug is removed from the power point before making any adjustments.

1. Loosen the table lock (9).
2. Raise or lower the table to the required height



3. Tighten the table lock to secure the table.

## Adjusting the table angle

**CAUTION.** Always ensure that the drill press is switched off and the plug is removed from the power point before making any adjustments.

1. Loosen the screw under the table by rotating it in an anti-clockwise direction using a 19mm wrench.



- Tilt the table to the desired angle as indicated on the bevel scale.
- Tighten the screw under the table by rotating it in a clockwise direction.

**Note.** When the table is tilted the workpiece should be clamped to the table.

## Installing and removing drill bits

**CAUTION.** Always ensure that the drill press is switched off and the plug is removed from the power point before making any adjustments.

- Using chuck key (18) loosen the chuck jaws by rotating the chuck key in an anti-clockwise direction.
- Fit the drill bit into the chuck (12) and ensure it is fully inserted.
- Rotate the top collar by hand in an anti-clockwise direction to grab hold of the drill bit.



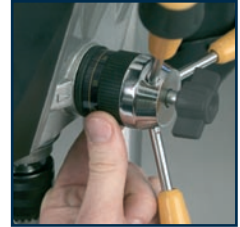
- Using the chuck key tighten all 3 holes to secure the drill bit. Tighten the holes by rotating the chuck key in a clockwise direction.



## Setting the drilling depth

**CAUTION.** Always ensure that the drill press is switched off and the plug is removed from the power point before making any adjustments.

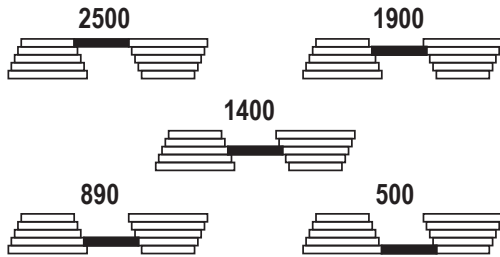
- Loosen the handle screw half a turn using the depth locking knob (16).
- Ensuring the drill bit is tight in the chuck use the feed wheel to lower the spindle until the drill bit just touches the workpiece.
- Holding the handle in that position rotate the depth scale (15) to the desired drilling depth.
- Tighten the depth locking knob (16) firmly to secure the handle in position.
- Lift the handle up and then proceed with the drilling operation.
- To disable the depth lock loosen the depth locking knob and rotate the depth scale to the maximum depth.
- Tighten the depth locking knob firmly to secure the handle in position.



**Note.** If the depth locking knob needs to be tighter use the 5mm hex key supplied to tighten the hex screw on the inside of the depth locking knob.

## Changing the speed of the drill press

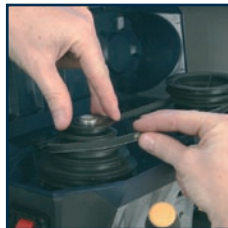
The speed of the drill press is determined by the size of the pulley steps that the belt is attached to. Using a smaller pulley step on the front pulley means a faster drill speed; using a larger pulley step on the front pulley means a slower drill speed. The below table indicates the speed of the drill in the various belt positions.



1. Remove the plug from the mains socket.
2. Loosen and remove the pulley cover knob (5) and lift the pulley cover (4).
3. Loosen the belt tension knob (11) and push the motor housing towards the front of the drill press to make belt changes easier.



4. To select a faster drill speed, move the belt up to a smaller step on the front pulley. Then move it up to the equivalent step on the rear pulley. Rotating the pulleys and “rolling” the belt onto the larger pulley will make this easier.



5. To select a slower drill speed, move the belt down to a smaller step on the rear pulley. Then move it down to a larger step on the front pulley. Rotating the pulleys and “rolling” the belt onto the larger pulley will make this easier.

**Note.** The belt should always be on the same relative step on the front and rear pulleys, for example if it is on the top step of the front pulley then it should also be on the top step of the rear pulley.

6. Tighten the belt tension knob (11) to secure the motor in position
7. Rotate the pulley by hand to ensure everything is aligned and correct.
8. Lower the pulley cover and replace the pulley cover knob. Tighten the pulley cover knob to secure the pulley cover in the closed position.

**Note.** The drill press features a micro switch that disables the on/off switch if the cover is not in the fully closed position.

## Turning on and off

1. Insert the switch disabling insert and ensure the switch (3) is in the OFF position.
2. Ensure the pulley cover is in the fully closed position.
3. Lift the switch to the ON position (I) to turn on and operate the drill press.
4. Push the switch down to the OFF position (0) to turn off the drill press.



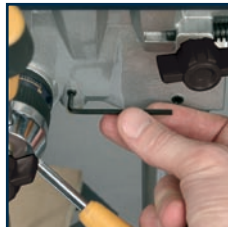
## Turning on the REDEYE® laser line generator

1. The REDEYE® laser line generator emits two intense narrow beams of pure red light that intersect at the drilling point.
2. The intersection is clearly visible and will not be obscured by dust. It improves operator drilling vision, enables faster set-up, increases accuracy and improves safety.
3. To turn the laser line on press the laser light on/off switch (1).
4. To turn off the laser line press the laser light on/off switch (1).

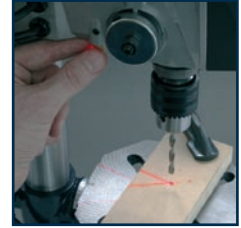


## Adjusting the laser

1. Clamp a scrap piece of material to the table.
2. Insert a drill bit into the chuck jaws.
3. Turn on the drill press.
4. Using the feed handle lower the spindle and make a small mark in the workpiece.
5. Turn on the laser line generator.
6. If the laser is not aligned with the mark in the workpiece, adjust as follows.
7. Using the 3mm hex key loosen the set screw that secures the laser light assembly.



8. Rotate the laser beam until it intersects the mark in the workpiece.
9. Repeat the process for the opposite side.



## Operation

**CAUTION.** Always ensure that the drill press is switched off and the plug is removed from the power point before making any adjustments.

**CAUTION.** For through drilling always ensure that the hole in the centre of the table is aligned with the drill bit.

**WARNING.** On start-up over-tightening the belt may prevent the drill press from starting.

**WARNING.** Don't force the drill, allow the drill bit to do the work.

1. Adjust the table height, table angle, drilling depth and speed as required for the application.
2. Insert the drill bit required for the application.
3. Mark the drilling points on the workpiece.
4. Switch on the laser line and line up the drilling point with the intersection point of the two beams.
5. Where possible secure the workpiece in position with vice or clamps.
6. Turn on the drill press using the on/off switch.
7. Rotate the feed wheel to bring the drill bit down to the workpiece.
8. Apply pressure to the feed wheel and slowly drill through the workpiece. Don't force the drill, allow the drill bit to do the work.
9. After drilling the hole release the feed wheel and allow the spindle to return to its original position.
10. Turn off the drill press.
11. Turn off the laser line generator.

## Wood drilling

- For maximum performance, use high speed steel bits for wood drilling.
- Secure the workpiece to prevent it from turning when drilling.
- When drilling through holes, place a block of wood behind the workpiece to prevent ragged or splintered edges on the back side of the hole.

## Metal drilling

- For maximum performance, use high speed steel bits for metal or steel drilling.
- Use a centre punch to mark the hole location on the workpiece.
- Maintain a speed and pressure which allows cutting without overheating the bit. Applying too much pressure will:
  - Overheat the drill
  - Wear the bearings
  - Bend or burn bits
  - Produce off-centre or irregular shaped holes
- When drilling large holes in metal it is recommended to drill with a small bit at first, then finish with a larger bit. Also, lubricate the bit with oil to improve drilling action and increase bit life.

## Maintenance

**WARNING.** Always ensure that the tool is switched off and the plug is removed from the power point before making and adjustments or maintenance procedures.

## Power cord maintenance

If the supply cord needs replacing, the task must be carried out by the manufacturer, the manufacturer's agent, or an authorised service centre in order to avoid a safety hazard.

## Cleaning

1. Keep the tool's air vents unclogged and clean at all times.
2. Remove dust and dirt regularly. Cleaning is best done with a soft brush or a rag.
3. Re-lubricate all moving parts at regular intervals.
4. Never use caustic agents to clean plastic parts.

**CAUTION.** Do not use cleaning agents to clean the plastic parts of the tool. A mild detergent on a damp cloth is recommended.

## General inspection

Regularly check that all the fixing screws are tight. They may vibrate loose over time.

## Trouble shooting

**WARNING.** Turn the on/off switch to the off position and unplug the tool from the power supply before performing trouble shooting procedures.

Trouble shooting		
Problem	Cause	Solution
Drill press will not start	Power cord not plugged in	Ensure that the cord is connected to the power supply
	Power fault, fuse or circuit breaker tripped	Check the power supply
	Cord damaged	Use authorised service centre to repair or replace
	Faulty switch	Use authorised service centre to repair or replace
	Faulty motor	Use authorised service centre to repair or replace the motor
Noisy operation	Incorrect belt tension	Adjust tension as required
Drill bit burns	Incorrect speed	Change speed, refer to the "Changing the speed" section
	Chips not coming out of hole	Retract drill bit frequently to clear holes
	Dull drill bit	Resharpen or replace drill bit
Excessive drill bit wobble	Bent drill bit	Replace with new drill bit
	Drill bit not properly installed in chuck	Install drill bit properly and ensure it is secure
	Chuck not properly installed	Install chuck properly
Wood splinters under workpiece	No "packing" material below workpiece	Use "packers" below the workpiece
Workpiece torn from hand	Workpiece not supported or clamped properly	Support the workpiece or clamp it
Drill bit binds in workpiece	Improper belt tension	Adjust the belt tension



# GMC customer assist

Attach Your  
Receipt Here

**If your product needs repairing, replacing, technical service or you simply need help or advice, please contact us on our Customer Assist Line 1300 880 001 (Australia) or 0800 445 721 (New Zealand).**

For prompt service we suggest you log your service request online at [www.gmcservice.com.au](http://www.gmcservice.com.au). Should you not have access to the Internet, please contact our service department on **1300 880 001 (Australia) or 0800 445 721 (New Zealand)**.  
7am – 7pm, 7 days a week (AEST).

**Please note that if repair or replacement is required, you must provide a valid original purchase receipt.**

You will need the following details at hand to log your service request;

**Personal details:** First & Last name, address, pick up address, contact phone numbers, email address

**Product details:** Product number, date of purchase, retailer bought from, State & postcode, receipt number, reason for the request, copy of official purchase receipt

Attach your purchase receipt and save with this Manual for future reference.

Please refer to our website [www.gmcompany.com](http://www.gmcompany.com) for full GMC warranty Terms and Conditions.

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