Operating Instructions and Parts Manual
Drill Press
Models: J-2500, J-2530, J-2550

J-2530 *J-2500* *J-2550*

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Part No. M-354400
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Warranty and Service

Walter Meier (Manufacturing), Inc., warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Service Centers located throughout the United States can give you quick service. In most cases, any of these Walter Meier Authorized Service Centers can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET® tools. For the name of an Authorized Service Center in your area call 1-800-274-6848.

MORE INFORMATION
Walter Meier is consistently adding new products to the line. For complete, up-to-date product information, check with your local Walter Meier distributor, or visit waltermeier.com.

WARRANTY
JET products carry a limited warranty which varies in duration based upon the product. (MW = Metalworking, WW = Woodworking)

90 DAY WARRANTY

- Lathe Accessories
- Machine Accessories
- Mobile Bases
- Safety Equipment
- Specialty Items
- Vise Accessories

1 YEAR WARRANTY

- Air Tools-Contractor
- Air Tools-Industrial
- Air Tools-Light Industrial
- Lubrication

2 YEAR WARRANTY

- Body Repair Kits
- Bottle Jacks
- Cable Pullers
- Cold Saws
- Hoists-Air
- Hoists-Electric
- Metal forming
- Mill/Drills
- Milling Machines
- MW Bandsaws
- MW Drill Presses
- MW Finishing Equipment
- MW Lathes
- MW Precision Vises
- Palet Trucks
- Rigging Equip.
- Service Jacks
- Stackers
- Surface Grinders
- Tapping
- Trolleys-Air
- Trolleys-Electric
- Web Slings
- Winches-Electric

3 YEAR WARRANTY

- WW Benchtop Tools

5 YEAR WARRANTY

- Beam Clamps
- Chain Hoist-Manual
- Lever Hoists
- Pullers-JCH Models
- Scissor Lift Tables
- Screw Jacks
- Trolleys-Geared
- Trolleys-Plain
- Winches-Manual
- WW Air Filtration
- WW Bandsaws
- WW Buffers
- WW Drill Presses
- WW Dust Collectors
- WW Dust Filters
- WW Dust Fittings
- WW Jointers
- WW Lathes
- WW Planers
- WW Sanders
- WW Shapers
- WW Tablesaws

LIFE LIFETIME WARRANTY

- Fastening Tools
- Mechanics Hand Tools
- Striking Tools
- Vises (no -precision)
- Clamps

Warranty reverts to 1 Year Warranty if woodworking (WW) products listed above are used for industrial or educational purposes.

WHAT IS COVERED?
This warranty covers any defects in workmanship or materials subject to the exceptions stated below. Cutting tools, abrasives and other consumables are excluded from warranty coverage.

WHO IS COVERED?
This warranty covers only the initial purchaser of the product.

WHAT IS THE PERIOD OF COVERAGE?
The general JET warranty lasts for the time period specified in the product literature of each product.

WHAT IS NOT COVERED?
Five Year Warranties do not cover woodworking (WW) products used for commercial, industrial or educational purposes. Woodworking products with Five Year Warranties that are used for commercial, industrial or education purposes revert to a One Year Warranty. This warranty does not cover defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair or alterations, or lack of maintenance.

HOW TO GET SERVICE
The product or part must be returned for examination, postage prepaid, to a location designated by us. For the name of the location nearest you, please call 1-800-274-6848.

You must provide proof of initial purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will repair or replace the product, or refund the purchase price, at our option.

We will return the repaired product or replacement at our expense unless it is determined by us that there is no defect, or that the defect resulted from causes not within the scope of our warranty in which case we will, at your direction, dispose of or return the product. In the event you choose to have the product returned, you will be responsible for the shipping and handling costs of the return.

HOW STATE LAW APPLIES
This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

LIMITATIONS ON THIS WARRANTY
WALTER MEIER (MANUFACTURING), INC., LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

WALTER MEIER SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

Walter Meier sells through distributors only. The specifications in Walter Meier catalogs are given as general information and are not binding. Members of Walter Meier reserve the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by Walter Meier.

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Warnings

1. Read and understand the entire owners manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This drill press is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a drill press, do not use until proper training and knowledge have been obtained.
5. Do not use this drill press for other than its intended use. If used for other purposes, Walter Meier (Manufacturing), Inc., disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this drill press. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this drill press, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead based paint.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.

10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
16. Make sure the drill press is firmly secured to the floor or bench before use.
17. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
18. Provide for adequate space surrounding work area and non-glare, overhead lighting.
19. Keep the floor around the machine clean and free of scrap material, oil and grease.
20. Keep visitors a safe distance from the work area. **Keep children away.**
21. Make your workshop child proof with padlocks, master switches or by removing starter keys.

Warnings

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

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

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

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

- - SAVE THESE INSTRUCTIONS - -

Introduction

The JET 15-Inch 16-Speed Drill Presses and 20-Inch 12-Speed Drill Presses, Models J-2500, J-2530 and J-2550, feature rugged cast iron design with ground-steel columns for drilling accuracy in metal, wood, and plastic. The head casting features a ball bearing spindle assembly, supported by four permanently-lubricated, heavy duty ball bearings that are mounted in an enclosed quill for extended life.

Specifications

Model	**J-2500**	**J-2530**	**J-2550**
Stock Number	354400	354401	354402
Model Type	15-Inch Floor	15-Inch Bench	20-Inch Floor
Drilling Capacity			
Cast Iron	Up to 5/8 In.	Up to 5/8 In.	Up to 3/4 In.
Steel	Up to 1/2 In.	Up to 1/2 In.	Up to 5/8 In.
Drill to Center	15 Inches	15 Inches	20 Inches
Motor			
Rating	3/4 hp, 1-Phase	3/4 hp, 1-Phase	1 hp, 1-Phase
RPM	1725	1725	1725
Voltage	115/230V (prewired 115V)	115/230V (prewired 115V)	115/230V (prewired 115V)
Column Diameter	2-7/8 In.	2-7/8 In.	3-5/8 In.
Quill			
Diameter	1-7/8 In.	1-7/8 In	2-1/4 In.
Travel	3-1/8 In.	3-1/8 In.	4-3/4 In.
Table			
Overall	11-1/2 x 11-1/2 In.	11-1/2 x 11-1/2 In.	18-1/2 x 16-1/2 In.
Working Surface	9-1/2 x 9-1/2 In.	9-1/2 x 9-1/2 In.	15-1/2 x 13-1/2
Travel	24 In.	15-1/2 In.	21-1/2 In.
Base			
Size	11 x 19-1/2 In.	10-1/2 x 18 In.	22-3/4 x 17-3/4 In.
Working Surface	7 x 7-1/2	8 x 8	13 x 14-1/2
Chuck Size	5/8-In., Key Chuck	5/8-In., Key Chuck	5/8-In, Key Chuck
Overall Dimensions			
Length	31 In.	31 In.	33-1/2 In.
Width	13 In.	13 In.	18-1/2 In.
Height	63 In.	39-1/2 In.	67 In.
Spindle to Table (Max.)	24 In.	15-1/2 In.	24 In.
Spindle to Column (Max.)	7-1/2 In.	7-1/2 In.	10-1/2 In.
Spindle			
To Base	48	24	43-1/2
Taper	MT-2	MT-2	MT-3
Number of speeds	16	16	12
RPM	200, 290, 350, 430 500, 580, 640, 720 800, 870, 1440, 1630 1820, 2380, 2540, 3630	200, 290, 350, 430 500, 580, 640, 720 800, 870, 1440, 1630 1820, 2380, 2540, 3630	150, 260, 300, 440, 490, 540, 1150, 1550, 1840, 2220, 2950, 4200
Shipping Weight	185 pounds	157 pounds	321 pounds

Shipping Contents

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

Main Parts

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

Additional Parts

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

Other Material

1 ea Owner's Manual
1 ea Warranty Registration Card

Required Tools

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

Additional Parts

Assembly

⚠WARNING

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

Before Assembly

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

Column Assembly

Referring to Figure 1:

1. Place the *base* (A) on a level floor.
2. Place the *column assembly* (B) on the *base* (A) and align the holes in the column support with the holes in the base.
3. **Note:** The column shown in Figure 1 is for the JDP-15MF. While the JDP-15M column is slightly different in appearance, the assembly procedure is the same.
4. Using a 17mm wrench, secure the *column* (B) with four M10 x 40 *hex cap screws* (C) to the base.

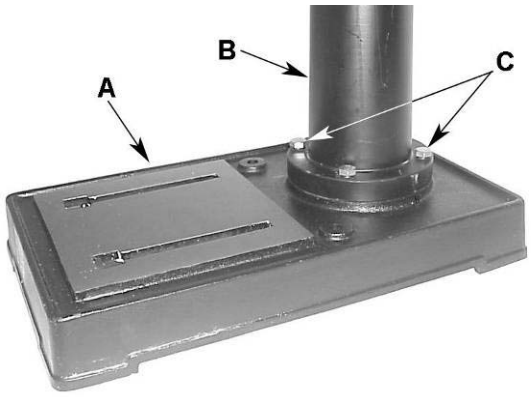


Figure 1

Table Bracket

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

Referring to Figures 2 and 3:

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

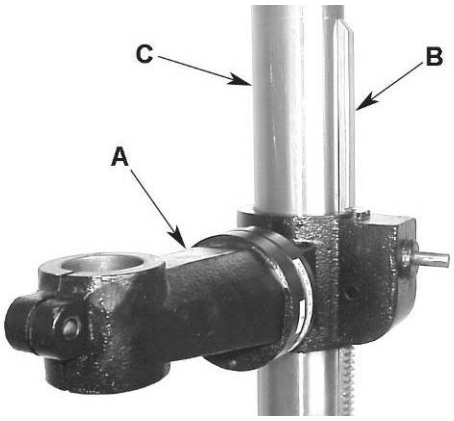


Figure 2

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

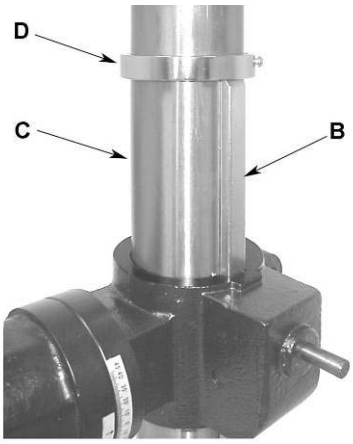


Figure 3

Crank Handle and Table Lock Handle

Referring to Figure 4 (shown already assembled):

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

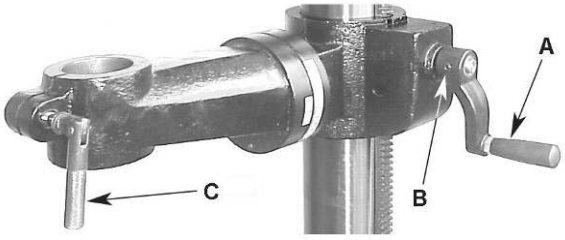


Figure 4

Column Lock Handle

Referring to Figure 5:

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

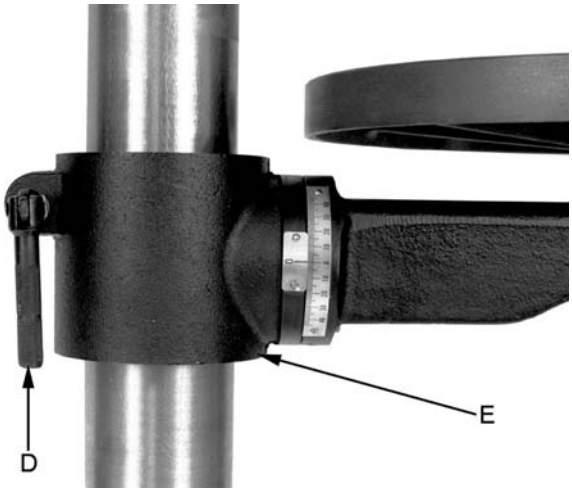


Figure 5

Table Installation

Referring to Figure 6:

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

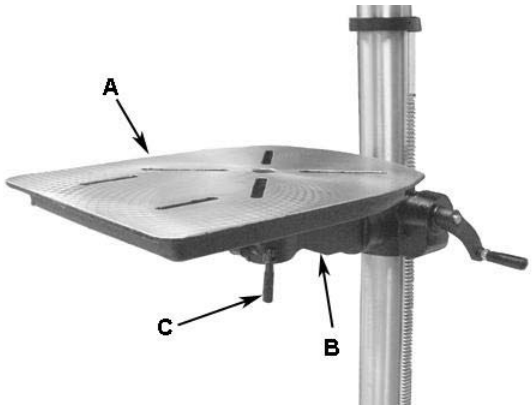


Figure 6

Head Assembly

Referring to Figure 7:

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

⚠CAUTION

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

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

Figure 7

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

Chuck and Arbor Installation

Referring to Figure 8:

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

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

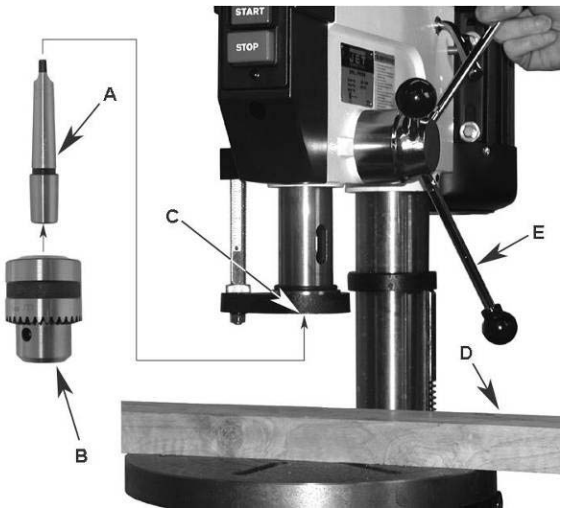


Figure 8

Chuck and Arbor Removal

Referring to Figure 9:

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

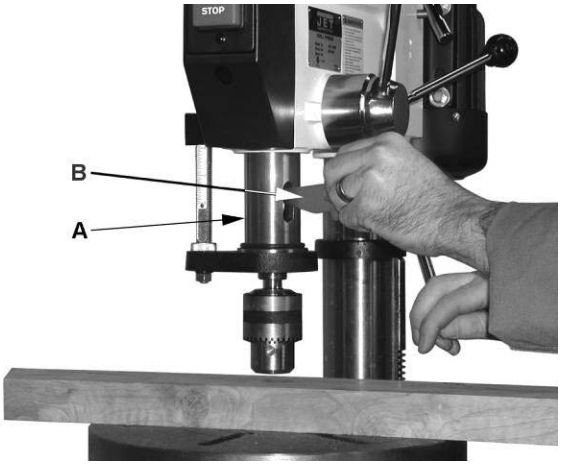


Figure 9

Adjustment

Depth Stop Adjustment

Referring to Figure 10:

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

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

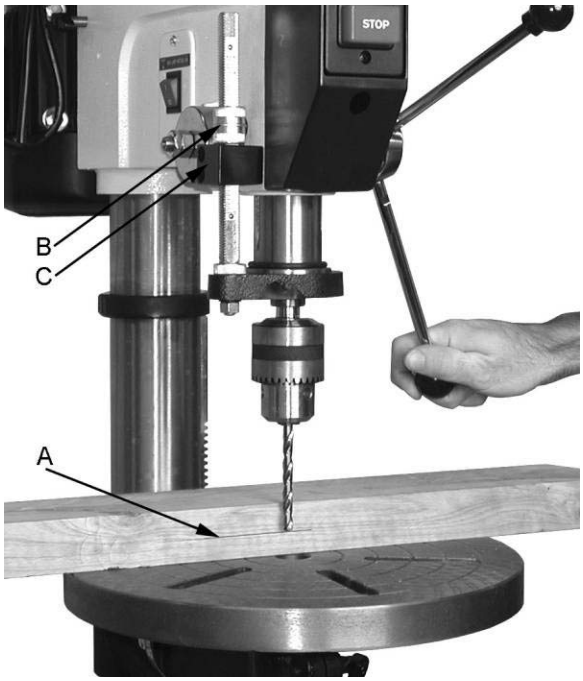


Figure 10

Changing Spindle Speeds

A spindle speed and pulley/belt arrangement chart for all models is found on the inside of the *pulley cover* (D, Fig. 11). Refer to this chart whenever changing speeds.

Note: The chart in Figure 12 is for models J-2500 and J-2530 only.

To change spindle speeds:

1. Unplug the machine from the power source.
2. Loosen two *bar knobs* (E, Fig. 11) found on each side of the head assembly.
3. Rotate the *tension adjuster* (F, Fig. 11) clockwise to bring the motor base as close to the head as possible.
4. For desired speed, change the location of belts per pulley/belt arrangement chart.
5. Rotate the *tension adjuster* (F. Fig. 11) counterclockwise to tension the belts.
6. Tighten two *bar knobs* (E, Fig. 11). Belts are properly tensioned when finger and thumb pressure midway between the two pulleys causes approximately ½" deflection.

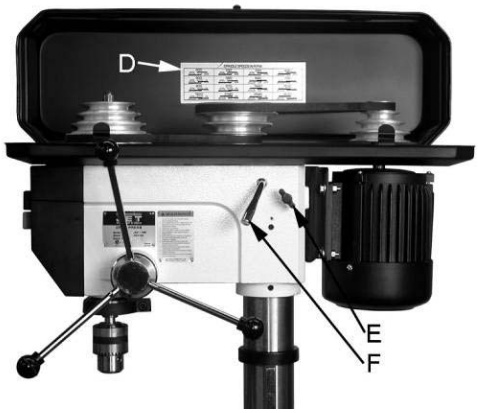


Figure 11

SPINDLE SPEEDS IN R.P.M.

200	290	350	430
500	580	640	720
800	870	1440	1630
1820	2380	2540	3630

Figure 12 – Spindle Speed Chart for J-2500, J-2530

Return Spring Adjustment

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

1. Unplug the machine from the power source.
2. Loosen two *hex nuts* (A). Do not remove.
3. Firmly hold the *coil spring cover* (B).
4. Pull out the cover and rotate until the *pin* (C) on the return spring plate engages the next notch in the coil spring cover. Turn the cover clockwise to decrease tension and counter-clockwise to increase tension.
5. Tighten two *hex nuts* (A). Do not over-tighten. Nuts should not contact the housing when tight. The hex nuts should be tightened against each other.

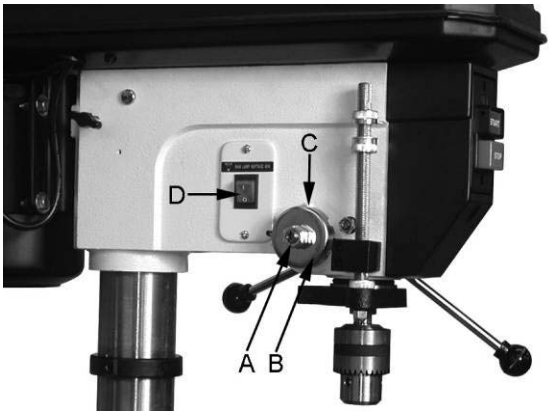


Figure 13

Work Light (J-2500 and J-2530 only)

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

Table Tilt Adjustment

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

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

⚠CAUTION

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

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

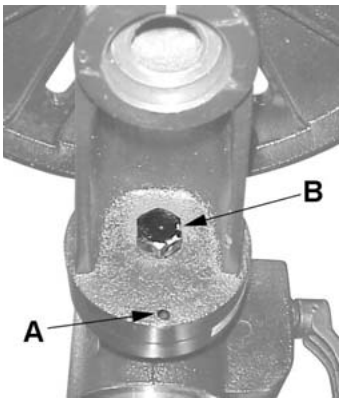


Figure 14

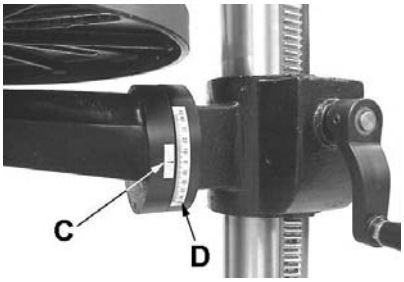


Figure 15

Operation

Installing Drills

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

Positioning the Workpiece

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

Using the Vise

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

Basic Operation

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

⚠WARNING

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

Feed the bit into the material with only enough force to allow the drill bit to work. Feeding too slowly may cause burning of the workpiece. Feeding too quickly may cause the motor to stop and/or the drill bit to break.

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

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

Maintenance

⚠WARNING

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

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

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

Lubrication

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

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

Electrical

Grounding Instructions

⚠CAUTION

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

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

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

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor, with insulation having an outer surface that is green with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

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

Repair or replace a damaged or worn cord immediately.

115 Volt Operation

Referring to Figure 16:

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

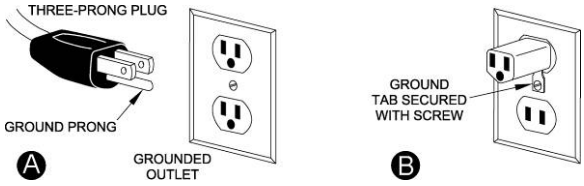


Figure 16

230 Volt Operation

Referring to Figure 17:

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

Disconnect the machine from the power source.

The JET drill press motor has four numbered leads that are factory connected for 115V operation, as shown in (A). For 230V operation reconnect the leads as shown in (B).

The 115V attachment plug (C), supplied with the drill press, must be replaced with a UL/CSA listed plug suitable for 230V operation (D). Contact your local Authorized JET Service Center or qualified electrician for proper procedures to install the plug. The drill press must comply with all local and national codes after the 230-volt plug is installed.

The drill press with a 230-volt plug should only be connected to an outlet having the same configuration as shown in (D). No adapter is available nor should be used with the 230-volt plug.

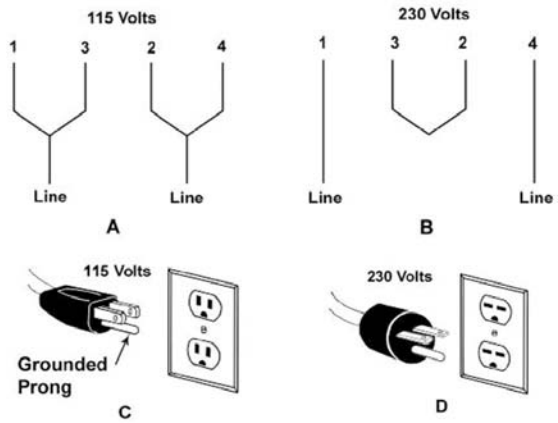


Figure 17

Extension Cords

Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw. An undersized cord will cause a drop in the line voltage resulting in power loss and overheating. The table following shows the correct size to use depending on the cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. Remember, the smaller the gauge number, the heavier the cord.

Length of Cord	AWG
0 – 25 Feet	16
25 – 50 Feet	14

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

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

Troubleshooting

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

Parts

Replacement Parts

To order parts or reach our service department, call 1-800-274-6848 Monday through Friday (see our website for business hours, www.waltermeier.com). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Parts List – J-2500, J-2530

Index No.	Part No.	Description	Size	Qty
1A	10600110	Base for J-2530 / JDP-15M		1
1B	10800101	Base for J-2500 / JDP-15MF (not shown)		1
2A	JDP15-1002A	Column Holder for J-2530 / JDP-15M		1
2B	10600204	Column Holder for J-2500 / JDP-15MF		1
3	TS-2279121	Hex Socket Set Screw	M10-12	3
4A	JDP15-1004A	Body Column for J-2530 / JDP-15M		1
4B	JDP15-1004B	Body Column for J-2500 / JDP-15MF		1
	10600404A1	Column Assy for J-2530 / JDP-15M (includes #2A and #4A)		1
	10400401A1	Column Assy for J-2500 / JDP-15MF (includes #2B, #3 and #4B)		1
5	TS-2229403	Hex Head Bolt	M10x40	4
6	10600604	Table Bracket		1
	JDP15-1006	Table Bracket Assy (includes #6 thru #18)		1
7	10600702	Gear		1
8	10600802	Gear Shaft		1
9	10600902	Worm		1
10A	10601009A1	Crank Handle Assy		1
12	JDP15-1012	Table Bracket		1
13	TS-0071011	Hex Head Bolt	5/8-11 x 1-1/2	1
14	TS-2276101	Hex Socket Set Screw	M6-10	1
16	10601601	Tilting Scale		1
17	JDP15-1017	Centering Scale		1
18	JDP15-1018	Drive Screw	Φ 2.3-5	2
19	10601901	Column Lock Handle	M12 x 1.75-35	1
20	10602001	Table Lock Handle	M10 x 1.5	1
21	J-5625221	Table		1
22A	10602204	Rack for J-2530 / JDP-15M		1
22B	10602205	Rack for J-2500 / JDP-15MF		1
23	10602304	Rack Ring	Φ 73.5	1
24	TS-2276081	Hex Socket Set Screw	M6-8	1
25	JDP15-1025	Head		1
26	TS-2279121	Hex Socket Set Screw	M10-12	2
27	JDP15-1027	Lamp Socket		1
28	TS-1534042	Cr. Re. Pan Head Screw	M6-12	2
29	10602901	Handle Shifter		1
30	10603002	Motor Bar Shifter		1
31	TS-2228161	Hex Head Bolt	M8-16	1
32	10603206	Motor Rod		1
33	10603301	Shifter Bolt	M10-33	2
34	10603416	Motor Base	75 x 125mm	1
35	2502NBC412	Spring Washer	Φ1/2"	1
36	TS-1540081	Hex Nut	M12	2
37	10603704	Hub		1
38	10603807	Feed Shaft		1
	JDP15-1038	Feed Shaft Assy (includes #37 thru #39)		1
39	TS-209402	Roll Pin	M5-16	1
43A	JDP15-1043	Handle Bar		1

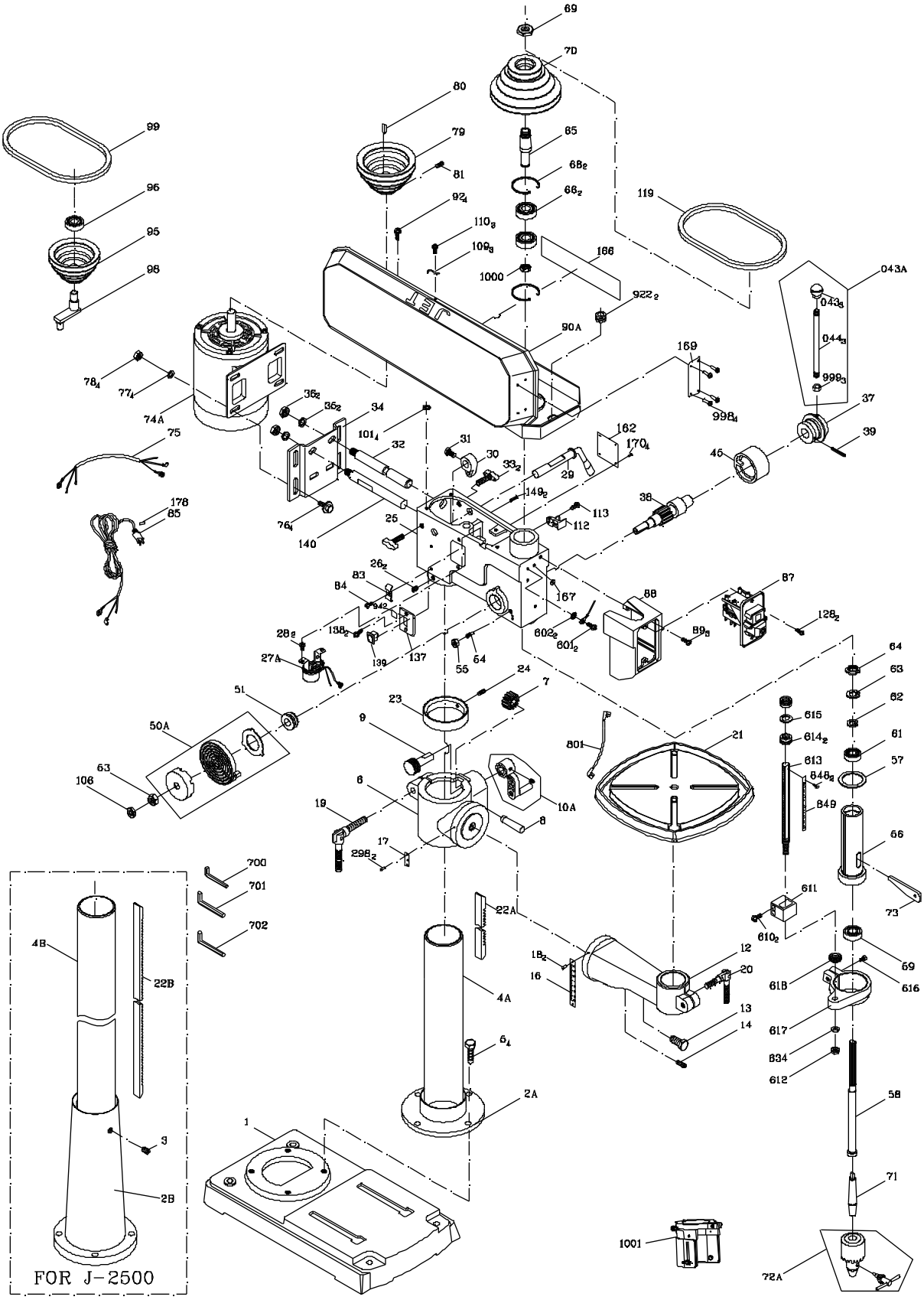
Parts List – J-2500, J-2530

Index No.	Part No.	Description	Size	Qty
45	10604505	Scale Ring		1
50A	JDP15-1050	Spring Cap		1
51	10605115	Shaft Seat		1
53	TS-0561052	Hex Nut	1/2"-20	1
54	10605403	Quill Set Screw	M10-28	1
55	TS-1540071	Hex Nut	M10	1
56	10605608	Quill	MT2	1
	JDP15-1056	Quill and Spindle Assy (includes #56 thru # 64)		1
57	10605702	Rubber Washer		1
58	10605822	Spindle	MT2	1
59	2001ZZ6204	Ball Bearing		1
61	2001ZZ6203	Ball Bearing		1
62	TS-2360161	Washer	M16	1
63	10606301	Nut Lock		1
64	10606401	Spindle Nut		1
65	10606505	Driving Sleeve		1
	JDP15-1065	Driving Sleeve Assy (includes #65 thru #67)		1
66	2001ZZ6204	Ball Bearing		2
67	10606703	Rack ring	Φ 45 T=4	1
68	10606801	Retaining Ring		2
69	10606904	Pulley Set Nut		1
70	JDP15-1070	Spindle Pulley		1
71	21015M2J30	Drilling Arbor	MT2*JT3	1
72A	JDP15-1072	Chuck Assy		1
73	10607303	Wedge Shifter		1
74	JDP15-1074	Motor		1
	JDP15-1074A	Centrifugal Switch (not shown)		1
	JDP15-1074B	Start Capacitor (not shown)	200MFD 125VAC	1
75	JDP15-1075	Motor Wire		1
76	TS-2208201	Hex. Hd. Screw	M8-20	4
77	TS-1550061	Flat Washer	M8	8
78	TS-1540061	Hex Nut	M8	4
79	JDP15-1079	Motor Pulley		1
80	2571MNC307	Parallel Key	5 x 5-20	1
81	TS-1504021	Hex Socket Set Screw	M8-12	1
83	JDP15-1083	Strain Relief		1
84	TS-1534042	Cr. Re. Pan Head Screw	M6-12	1
85	JDP15-1085	Power Cable		1
87	JDP15-1087	Rocker Switch		1
88	JDP15-1088	Switch Box		1
89	TS-1533042	Cr. Re. Pan Head Screw	M5-12	3
90A	JDP15-1090	Pulley Cover Assy		1
	JDP15-1090A	U Shaped Protecting Rubber (not shown)		1
92	JDP15-1092	Cr. Re. Round Washer Hd. Screw	M6 x 1.0-12	4
95	JDP15-1095	Center Pulley		1
	JDP15-1095A	Center Pulley Assy (includes #95 thru #98)		1
96	JDP15-1096	Ball Bearing		2
98	10609801	Center Pulley Shaft		1
99	VB-A28	V-Belt	A-28	1
101	TS-0680021	Flat Washer	1/4"	4
106	TS-0561052	Hex Nut	½”-20	1
109	JDP15-1109	Clamp-Cord		3
110	2668BBDA23	Cr. Re. Pan Head Screw	M5-8	3
112	10611201	Chuck Key Holder		1
113	TS-2286122	Cr. Re. Round Washer Hd. Screw	M6-12	1
119	VB-A26	V-Belt	A-26	1

Parts List – J-2500, J-2530

Index No.	Part No.	Description	Size	Qty
128	TS-2285162	Cr. Re. Truss Hd. Tapping Screw	M5-16	2
137	JDP15-1137	Switch Cover		1
138	TS-1533042	Cr. Re. Pan Head Screw	M5-12	2
139	JDP15-1139	Rocker Switch		1
140	10614001	Motor Rod		1
149	2536MBE616	Roll Pin	6-25	2
162	10916202	Warning Label		1
166	JDP15-1166	Speed Diagram		1
169	JDP15-1169	Trade-Mark Label		1
170	2658MZDU36	Drive Screw	Φ 2.3-5	6
601	TS-2245082	Cr. Re. Pan Head Screw	M5-8	4
602	TS-0733031	External Tooth Lock Washer	No 10	2
610	TS-1534692	Cr. Re. Pan Head Screw	M6-35	2
611	JDP15-1611	Cr. Re. Pan Head Screw		1
612	TS-1540071	Hex Nut	M10	1
613	10661301	Set Bolt		1
	JDP15-1613	Set Bolt Assy (includes #613, 848, 849)		1
614	13005701	Nut	M16	2
615	13005601	Washer	Φ24	1
616	TS-1502081	Hex. Soc. Hd. Cap Blot	M5-35	1
617	JDP15-1617	Set Ring		1
618	10661801	Circular Nut		1
634	2502ABC410	Spring Washer	Φ10	1
700	TS-152704	Wrench Hex		1
701	TS-152706	Wrench Hex		1
702	TS-152707	Wrench Hex		1
801	JDP15-1801	Lead Wire Assembly		1
848	JDP15-1848	Drive Screw	Φ 2.3-5	2
849	JDP15-1849	Scale		1
922	2801ABRF04	Strain Relief	Φ 20	2
999	TS-1540081	Hex Nut	M12x10	3
1000	100633Y8	Plastic Sleeve		1
1001	10810401A1	Chuck Guard Assembly		1

Exploded View – J-2500, J-2530



Parts List – J-2550

Index No.	Part No.	Description	Size	Qty
1	J-5627751	Base		1
2	J-5627761	Collar, Column		1
3	5626231	Set Screw	M10 x 40 mm	1
4	5627771	Column		1
5	5627781	Screw, Hex Head	M12 x 40 mm	4
6	J-5627791	Bracket, Table		1
7	5625071	Gear, Pinion		1
8	5625081	Shaft, Gear		1
9	5625091	Worm		1
10	5627811	Handle, Lowering/Raising		1
11	5626251	Screw, Hex Head	M6 x 12 mm	1
13	5627821	Screw, Hex Head	5/8” x 2”	1
14	5627831	Pin, Location		1
15	5627841	Nut, Hex	1/4" x 20”	1
16	5627851	Scale, Tilting		1
17	5625181	Scale, Angle		1
18	5625191	Set Screw	Ø2.3x 5 mm	3
19	5625211	Handle, Lock	M12 x 180 mm	1
21	J-5627861	Table	18-3/4” x 16-3/4”	1
22	5627871	Rack		1
23	J-5627881	Retainer, Rack		1
24	5627061	Screw Set, Hex Socket	M6 x 10mm	1
25	J-5627891	Head		1
26	5627021	Screw Set, Hex Socket	M10 x 12mm	2
28	5627911	Screw, Pan Head, Cr.-Re.	M6 x 12mm	2
29	5627121	Lever, Tension Adjustment		1
30	5627131	Cam		1
31	5627141	Screw, Hex Head	M8 x 16 mm	1
32	5627921	Shaft, Motor Base		1
33	5627931	Lock, Motor Bar		2
34	J-5627941	Base, Motor		1
35	5627181	Washer, Spring	Ø1/2”	2
36	5627191	Nut, Hex	M12	2
37	5627211	Hub		1
38	5627951	Shaft, Feed Pinion		1
38A	5627961	Shaft Assembly, Feed Pinion		1
39	5627971	Pin, Roll		1
40	5627241	Pin, Scale Set		1
41	5627981	Wedge, Scale Locking		1
42	5627991	Screw, Depth Lock	M8 x 17 mm	1
43	5629011	Handle		3
43A	5629021	Bar Assembly, Handle		3
44	5627271	Grip		3
45	5629031	Housing, Spindle Depth		1
46	5629041	Scale		1
47	5625481	Pointer		1
48	5626551	Screw, Drive		3
49	5629051	Coil		1
50	5629061	Housing, Spring		1
50A	5629071	Housing Assembly, Spring		1
51	5629081	Seat, Spring		1
53	5629091	Nut, Hex	1/2"-20	2
54	5627321	Screw, Set, Quill	M10 x 27mm	1
55	5627331	Nut, Hex	M10	1
56	5629111	Quill		1
56A	5629121	Quill Assembly (includes #56 thru 64)		1

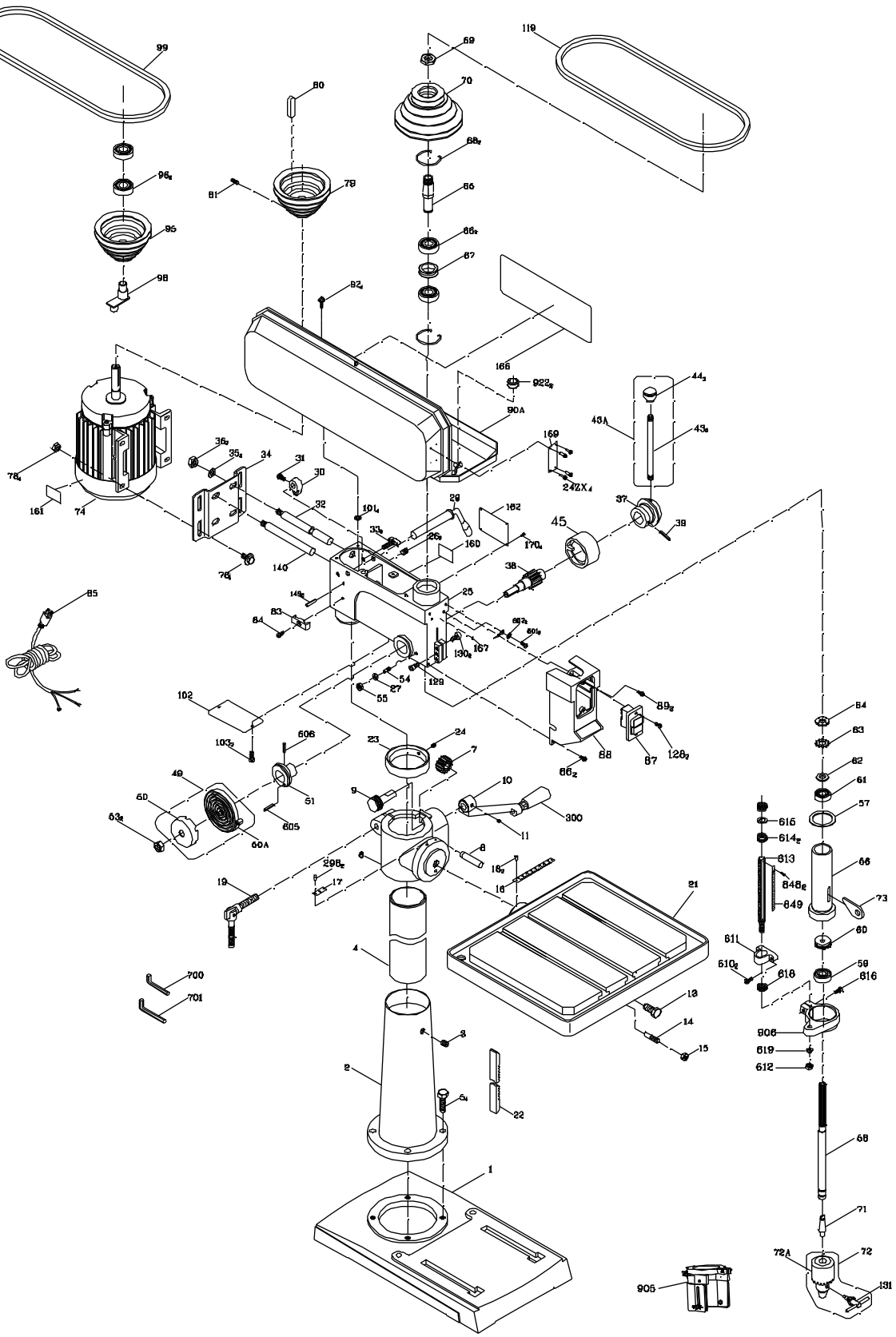
Parts List – J-2550

Index No.	Part No.	Description	Size	Qty
57	5629131	Washer, Rubber		1
58	5629141	Spindle	MT3, Ø34	1
59	5629151	Bearing, Ball	6206ZZ	1
60	5629161	Bearing, Ball, Thrust	2906	
61	5635271	Bearing, Ball	6204Z	1
62	5629171	Washer		1
63	5629181	Lock, Washer		1
64	5629191	Lock, Nut		1
65	5629211	Lock, Driving		1
66	5629221	Bearing, Ball	6206Z	2
67	5629231	Collar		1
68	5629241	Ring, Retaining		2
69	5629251	Nut, Pulley Lock		1
70	5629261	Pulley, Spindle		1
71	5624641	Arbor	MT3 x JT3	1
72	5628931	Chuck	RJ3 - 16L	1
72A	5627401	Chuck and Key		1
73	5624671	Wedge, Taper		1
74	J-5629271	Motor		1
76	5629291	Screw, Hex Head	M8 x 25 mm	4
77	5627511	Washer, Flat	5/16”	4
78	5625821	Nut, Hex	M8	4
79	5629311	Pulley, Motor		1
80	5629321	Key		1
81	5629331	Screw, Set	M8 x 8 mm	1
83	5627551	Clamp		2
84	5626841	Screw, Pan Head	M5 x 8 mm	2
85	5629341	Cord, Power		1
87	JDP15-1087	Push-Button Switch		1
88	5629361	Cover, Switch		1
89	5626871	Screw, Pan Head	M5 x 12 mm	2
92	5627591	Washer, Round Head Screw	M6 x 12 mm	4
93	5629381	Screw, Truss Head Tapping	M4 x 12 mm	1
94	5627611	Knob		1
95	5629391	Pulley, Center		1
96	5621681	Bearing, Ball	6202Z	2
98	5629411	Shaft, Pulley		1
99	5624701	V-Belt	A-30	1
101	5627641	Washer, Flat	1/4"	4
119	5637541	V-Belt	A-32	1
128	TS-2285162	Screw, Machine	M5 x 16 mm	2
129	5629421	Screw, Socket Head Cap	M8 x 30 mm	2
130	5629431	Screw, Socket Head Cap	M8 x 25 mm	1
131	5629441	Key, Chuck		1
140	5629451	Shaft, Motor Base		1
149	5629461	Pin, Roll		2
601	5629471	Screw, Pan Head	M4 x 12 mm	1
602	5629481	Washer, External Tooth Lock	Ø4	2
605	5629491	Pin, Roll		1
606	5629511	Pin, Roll	Ø2.5 x 10 mm	1
610	5513738	Screw		2
611	5513739	Block, Depth Stop		1
612	5513740	Nut		1
613	5513741	Rod, Depth Stop Adjustment	2550 Only	1
614	5513742	Nut, Adjustment Lock		1
615	5513743	Washer		1

Parts List – J-2550

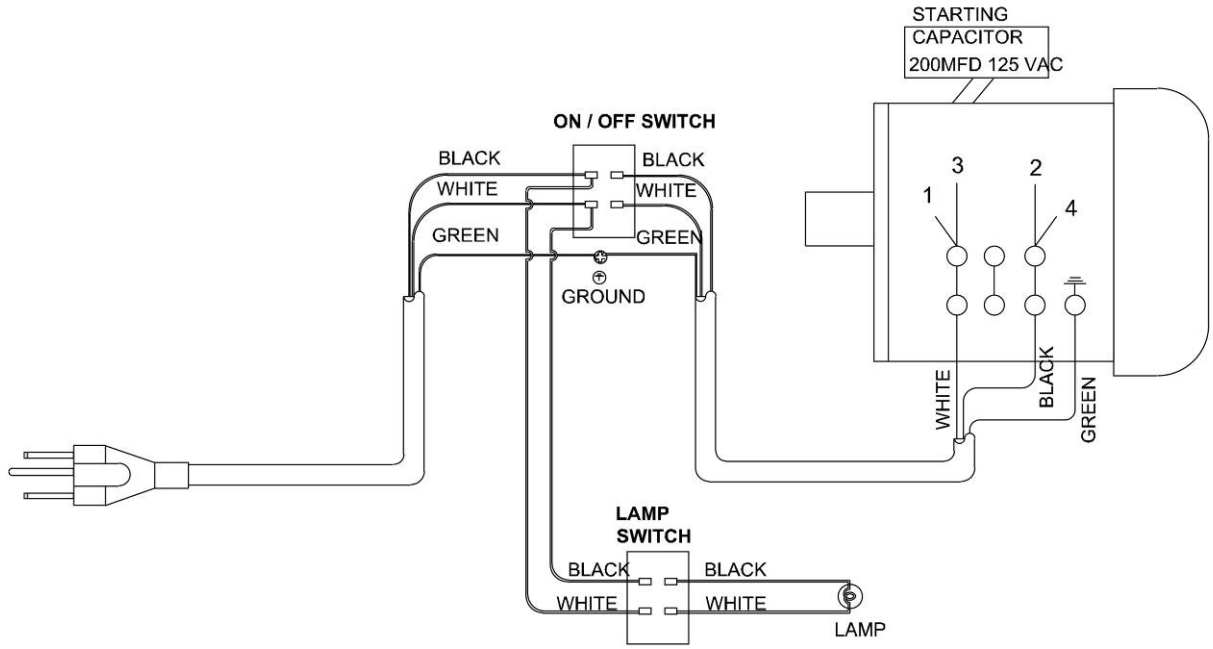
Index No.	Part No.	Description	Size	Qty
616	5513744	Screw, Clamping		1
617	J-5518233	Clamp, Depth Stop support		1
618	5513746	Nut		1
700	5627711	Wrench, Allen	3 mm	1
701	5629521	Wrench, Allen	5 mm	1
903	5627721	Grommet		2
904	J-5629371	Cover Assembly, Pulley		1
905	10810402A1	Chuck Guard Assembly		1
906	11361702	Set Ring		1

Exploded View – J-2550

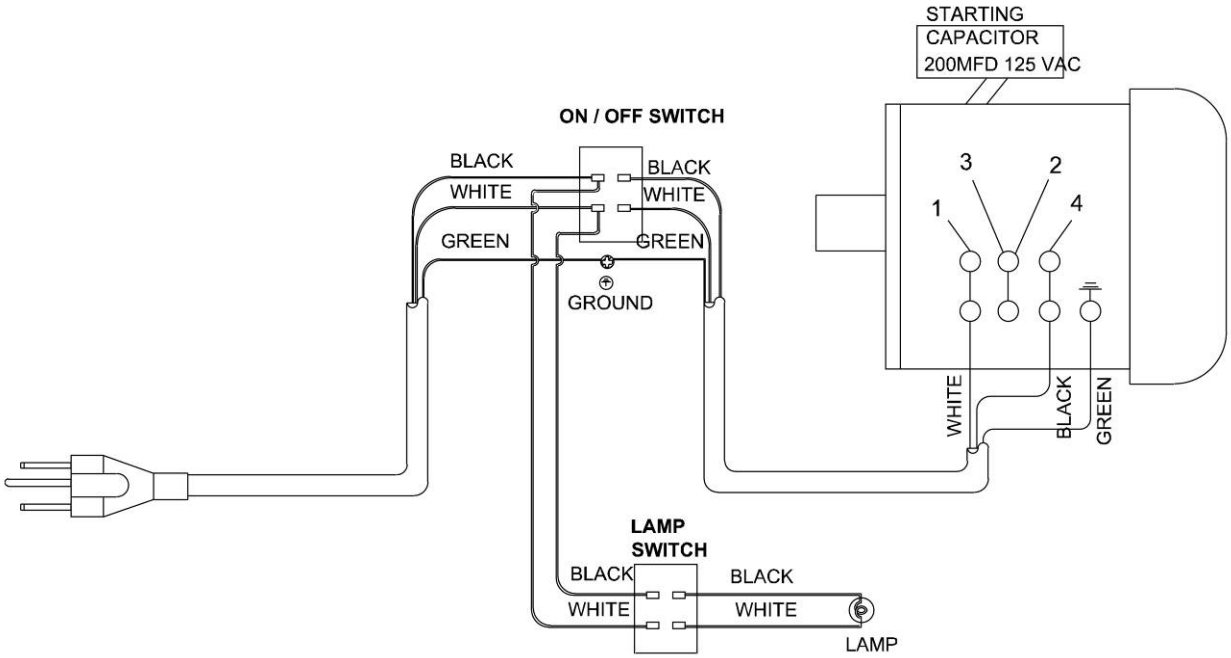


Wiring Diagram

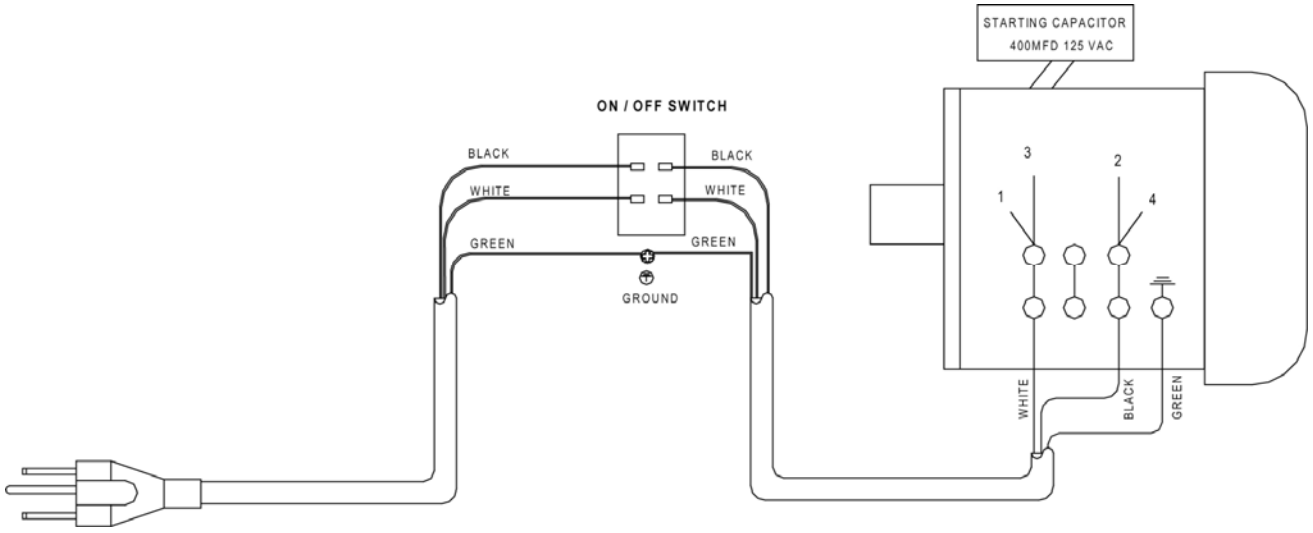
J-2500/J-2530 – 115V



J-2500/J-2530 – 230V



J-2550 – 115V



J-2550 – 230V