



Operating Instructions and Parts Manual 12" Variable Speed Drill Press

Model: JDP-12



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Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

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JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves 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 JPW Industries, Inc.

Product Listing with Warranty Period

90 Days – Parts; Consumable items; Light-Duty Air Tools
1 Year – Motors; Machine Accessories; Heavy-Duty Air Tools; Pro-Duty Air Tools
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

Table of Contents

Warranty and Service	2
Table of Contents	3
Warnings	4
Introduction.....	6
Specifications	6
Unpacking	7
Contents of the Shipping Container	7
Hardware	7
Assembly.....	8
Base and Column Assembly.....	8
Table and Rack.....	8
Table Height Adjust and Column Lock Handles	8
Mounting the Head.....	9
Downfeed Handles.....	9
Installing the Chuck and Arbor.....	9
Electrical.....	10
Grounding Instructions	10
115 Volt Operation Only	10
Extension Cords.....	10
Adjustments.....	11
Removing the Chuck and Arbor.....	11
Adjusting the Depth Stop.....	11
Spindle Speed Adjust	11
Return Spring Adjustment.....	12
Laser Adjustment	12
Features and Controls	13
Lubrication.....	13
Basic Operation	13
Troubleshooting.....	14
Parts.....	15
Ordering Replacement Parts	15
Parts List.....	15
Assembly Drawing.....	18
Wiring Diagram.....	19

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

Warnings

1. Read and understand the entire owners' manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This drill press is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a drill press, do not use until proper training and knowledge have been obtained.
5. Do not use this drill press for other than its intended use. If used for other purposes, JET 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. Don't use in dangerous environment. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
21. Keep visitors a safe distance from the work area. **Keep children away.**
22. Make your workshop child proof with padlocks, master switches or by removing starter keys.
23. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.

Warnings

24. 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.
25. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
26. Use recommended accessories; improper accessories may be hazardous.
27. Maintain tools with care. Keep drill bits sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
28. Disconnect tools before servicing; when changing accessories, such as blades, bits, cutters and the like.
29. Make sure the work piece is securely attached or clamped to the table. Never use your hand to hold the work piece.
30. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
31. Do not stand on the machine. Serious injury could occur if the machine tips over.
32. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
33. 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.

Introduction

This manual is provided by JET covering the safe operation and maintenance procedures for the JET JDP-12 Drill Press with Digital Readout. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or JET. JET can also be reached at our web site: www.jettools.com.

Specifications

Model Number.....	JDP-12
Stock Number.....	707300
Swing	12"
Type	Bench Top
Drilling Capacity.....	5/8"
Chuck Size	5/8"
Spindle Travel.....	3-1/8"
Spindle Distance to Base	23-1/2"
Spindle Distance to Table (max.)	17"
Table Size Diameter (width x depth).....	9-1/2" x 9-1/2"
Table Tilt.....	+ or - 45°
Spindle Taper	MT-2
Column Diameter.....	2-1/2"
Number of Spindle Speeds	Variable
Range of Spindle Speeds	530-3000 RPM
Light Bulb	40W max.
Overall Height.....	37"
Base Size	11-1/2" x 16-1/2"
Motor	115V only, 1/3HP, 1 Ph, 5A
Net Weight (approx.).....	88 lb.
Shipping Weight (approx.).....	93 lb.

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

⚠WARNING Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!

Unpacking

Separate all parts from the packing material. Check each part against the *Contents of the Shipping Container* and make certain that all items are accounted for before discarding any packing material.

Contents of the Shipping Container

- A Head Assembly (1)
- B Table(1)
- C Bracket Assembly (1)
- D Base (1)
- E Column and Rack Assembly (1)
- F Downfeed Handle (3)
- G Arbor (1)
- H Drift Key (1)
- J Chuck Key (1)
- K Column Lock Handle (1)
- L Table Lock Handle (1)
- Owner's Manual (1)
- Warranty Registration Card

Hardware

- O M10 x 30 Hex Cap Screws (4)
- P Chuck (1)
- Q Table Extension Lock Knob (2)
- R Table Height Adjust Handle (1)

Tools Supplied for Assembly

- M 3mm Hex Wrench
- N 5mm Hex Wrench

Tools Required for Assembly

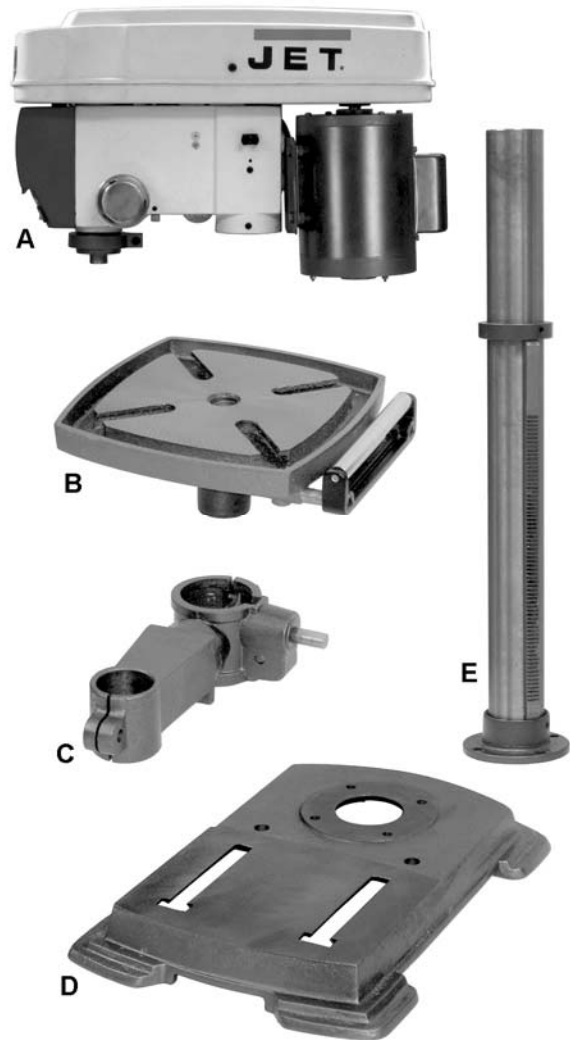
17mm Box Wrench or a 6"-8" Adjustable Wrench

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

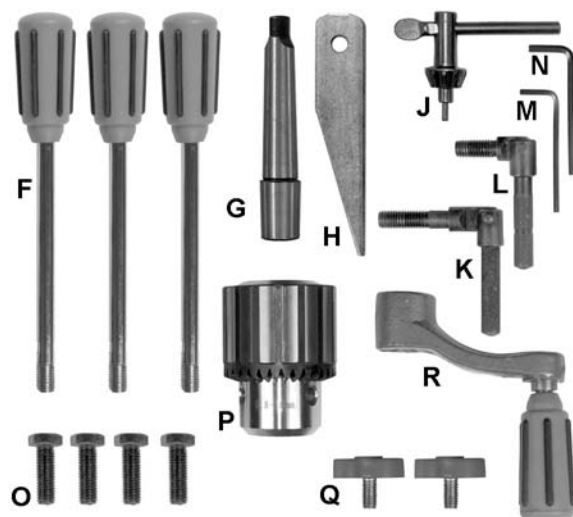
Before Assembly

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.



Contents of Shipping Container



Hardware

Assembly

Base and Column Assembly

Referring to Figure 1:

1. Place the *base* (D) on a level floor.
2. Place the *column assembly* (E) on the *base* (D) and align the holes in the column support with the holes in the base.
3. Using a 5/8-in wrench, secure the *column* (E) with four M10 x 30 *hex cap screws* (O) to the base.

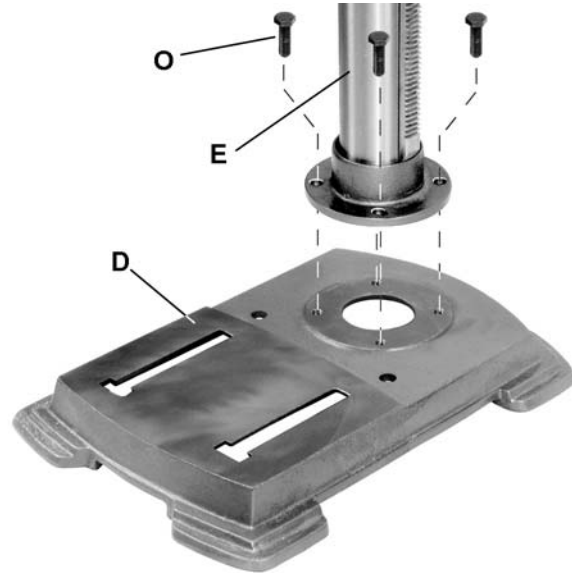


Figure 1

Table and Rack

Referring to Figure 2:

When shipped, the *rack ring* (E₁) and *rack* (E₃) are bundled together with the *column* (E) in plastic wrap.

1. Remove the wrap and take the *rack ring* (E₁) and *rack* (E₃) off the *column* (E). Note which end of the *rack* is up. It must be reinstalled later with the same side up.
2. Place the *rack* (E₃) inside the *table bracket* (C) such that the teeth of the *rack* (E₃) mesh with the pinion gear on the end of the *table crank handle shaft* (C₁).
3. Slide the *bracket assembly* (C) together with the *rack* (E₃) onto the *column* (E) as shown.
4. Place the *rack ring* (E₁) onto the *column* (E), sliding it down so it rests against the *rack* (E₃) as shown and tighten the *setscrew* (E₂) with a 3mm hex wrench (provided).
5. Place the *table* (B) onto the *table bracket* (C), positioning it as shown in Figure 2. Secure table with *table lock handle* (L).
6. Secure the table extension (B₁) with two *table extension lock knobs* (Q).

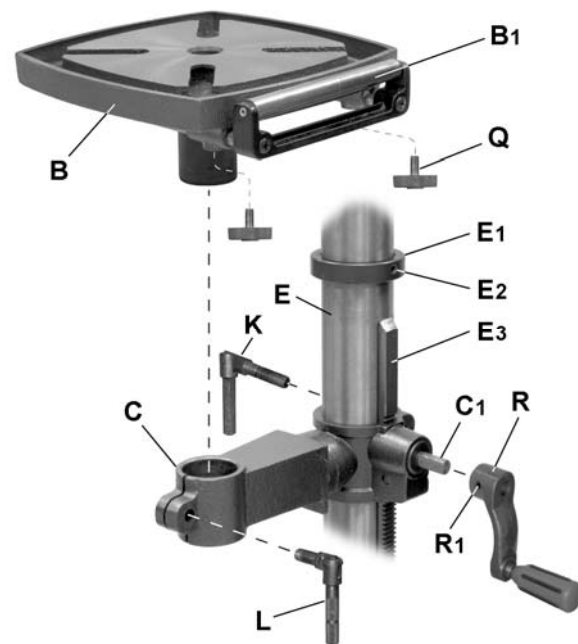


Figure 2

Table Height Adjust and Column Lock Handles

Referring to Figure 2:

1. Loosen the *setscrew* (R₁) on the *table height adjust handle* (R).
2. Slide the *handle* (R) onto the *table bracket shaft* (C₁).
3. Turn the *handle* (R) until the *setscrew* (R₁) is on the flat section of the *shaft* (C₁) and tighten the *setscrew* (R₁) with a 3mm hex wrench to secure the handle.
4. Thread the *column lock handle* (K) into the back side of the *table bracket* (C) opposite the *height adjust handle* (R).

Mounting the Head

1. With the aid of a second person, carefully lift the *head* onto the *column top* (Figure 3).

CAUTION The head assembly is heavy! To avoid injury and/or damage to equipment, lift the head onto the column only with additional assistance!

2. Rotate head assembly until sides of the *belt cover* (E) are parallel with the sides of the *base* (D, Fig. 1).
3. Tighten two *set screws* (A, Fig. 3) with a 5mm wrench until they are snug.

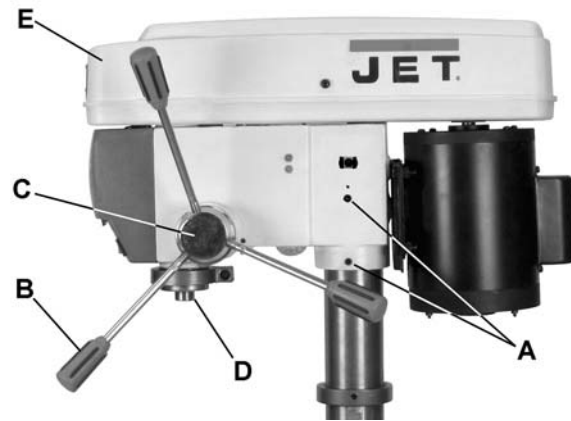


Figure 3

Downfeed Handles

Referring to Figure 3:

Install three *downfeed-handles* (B) into the *downfeed-hub* (C) as shown.

Installing the Chuck and Arbor

1. Adjust the position of the table to approximately seven inches below the *spindle assembly* (D, Fig. 3) and lock in place.

Referring to Figure 4:

2. Thoroughly clean *spindle* (A), *arbor* (C), and *chuck* (D).

Important: These three pieces must be free of any rust protection, or lubricant. If they are not clean and dry, the arbor and chuck will fail to seat in the spindle.

3. Place *arbor* (C) into the *chuck* (D).
4. Open chuck all the way to completely retract the chuck jaws.
5. Place arbor and chuck assembly into the *spindle* (A).
6. Rotate the arbor and chuck assembly until the *tang* (B) on the *arbor* (C) engages the slot at the end of the spindle.
7. Place a scrap board against the bottom of the chuck, and firmly tap the board two or three times with a mallet or hammer, to seat the arbor.

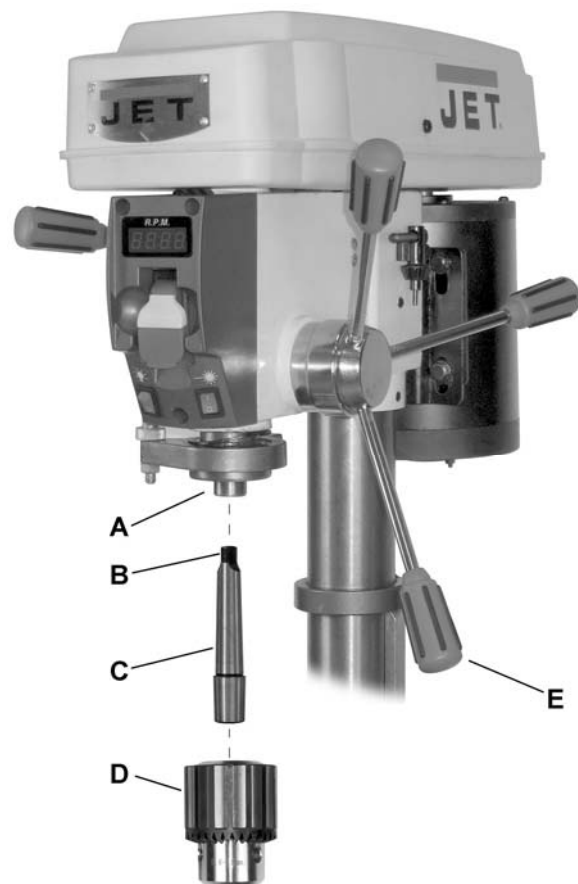


Figure 4

Electrical

Grounding Instructions

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 3-wire extension cords that have 3-prong grounding plugs and 3-pole receptacles that accept the tool's plug.

Repair or replace damaged or worn cord immediately.

115 Volt Operation Only

Referring to Figure 5:

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.

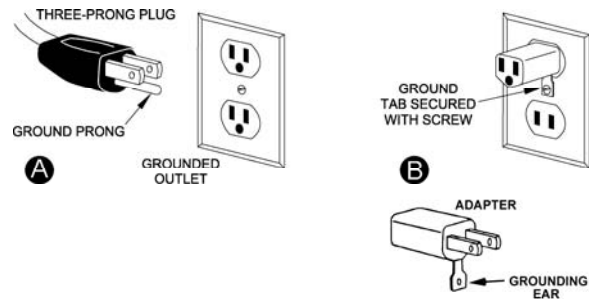


Figure 5

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 below 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.

Cord Length	AWG
0 – 25ft	16
5 – 50ft	14

Important: Make certain the receptacle in question is properly grounded. If you are not sure, have a registered electrician check the receptacle.

Adjustments

Removing the Chuck and Arbor

Referring to Figure 7:

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* (E) using the *downfeed handle* (A, C).
4. Still maintaining the lowered quill position, rotate spindle to align the key hole in the spindle with the key hole in the *quill* (E).
5. Insert the *drift key* (D) into the aligned slots and tap lightly. The chuck and arbor assembly should fall from the spindle.

CAUTION Prepare to catch the chuck and arbor as it drops. Striking the floor could damage tool.

Adjusting the Depth Stop

Referring to Figure 8:

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

1. Use a pencil to *mark* (A) the depth the bit will drill into the workpiece.
2. With the drill bit in the chuck, lower *downfeed handle* (B) to advance bit to your *mark* (A).
3. With your other hand, advance the *lock nut* (D) on the depth stop rod until they are snug to the *seat* (C). Tighten E against D.
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.

Spindle Speed Adjust

Referring to Figure 8:

Adjust spindle speed by changing the position of the *spindle speed adjust lever* (G). The actual speed is shown on the *LED display* (F).

The drill press must be turned on when making this adjustment. Moving the *lever* (G) towards the front increases the spindle speed while moving the lever back will decrease speed from a range of 500 RPM to 3000 RPM.

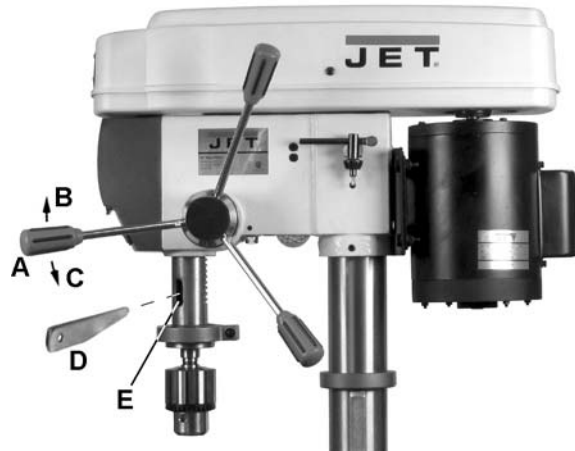


Figure 7

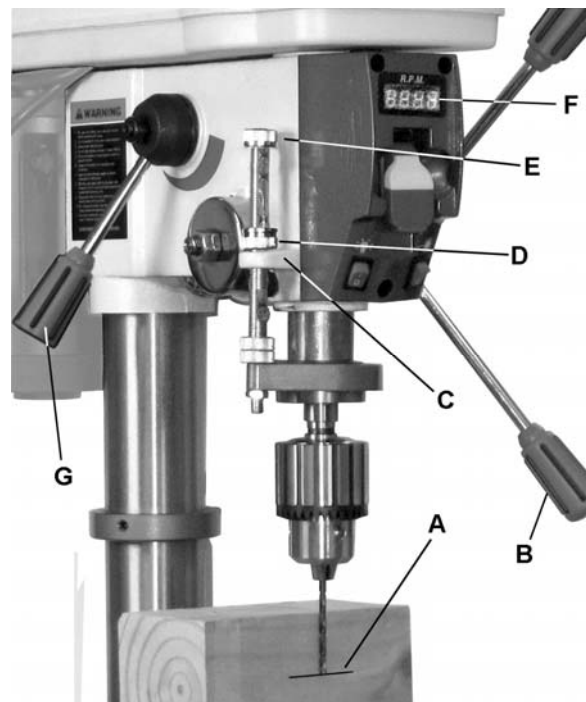


Figure 8

Return Spring Adjustment

The *return spring* is located opposite the *downfeed handle hub* and sets the tension for the downfeed handle. It is adjusted at the factory and should not need further adjustment.

If adjustment is deemed necessary:

1. Unplug the machine from the power source.

Referring to Figure 9:

2. Loosen the *jam nuts* (A) and *hex nut* (B). Do not remove.
3. Pull out slightly the *coil spring cover* (C) while firmly holding it. DO NOT allow the coil spring cover to turn freely in your hand, or the spring will unwind.
4. Rotate the coil spring cover (C) until the notch on the cover engages with the *tab* (E) on the head casting. Turn the cover clock-wise to decrease tension and counter-clockwise to increase tension.
5. Tighten *hex nut* (B) firmly by hand against the cover (C), then secure by tightening the *jam nut* (A) against the hex nut (B).

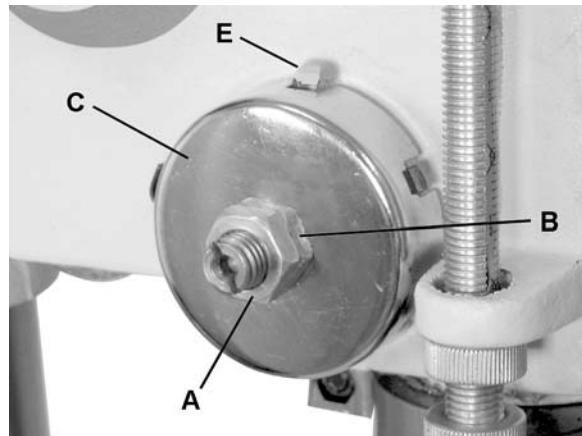


Figure 9

Laser Adjustment

The Laser Assembly has been installed and preset at the factory. It should, however, be checked and any adjustments made before operating the drill press. It should also be rechecked periodically, as constant machine use may cause it to become misaligned.

To align (refer to Figure 10):

1. Place a small *drill bit* (D) in the *chuck* (C), then place *board* (F) flat on the table. Do not allow the board to move from this position; use clamps if needed.

Important: The drill press table should be in horizontal position and locked.

2. Bring the bit down until it leaves a *slight perforation* in the board (E) then raise it back up.
3. Connect power to the drill press, and turn on the laser using the button at the front of the drill press head.
4. Using a 3mm hex wrench, loosen *setscrews* (A) on both laser assemblies (only the left side laser assembly is shown in Figure 10).
5. Adjust (B) so the *laser line* (G) crosses the perforation (O). Tighten *setscrew* (A).

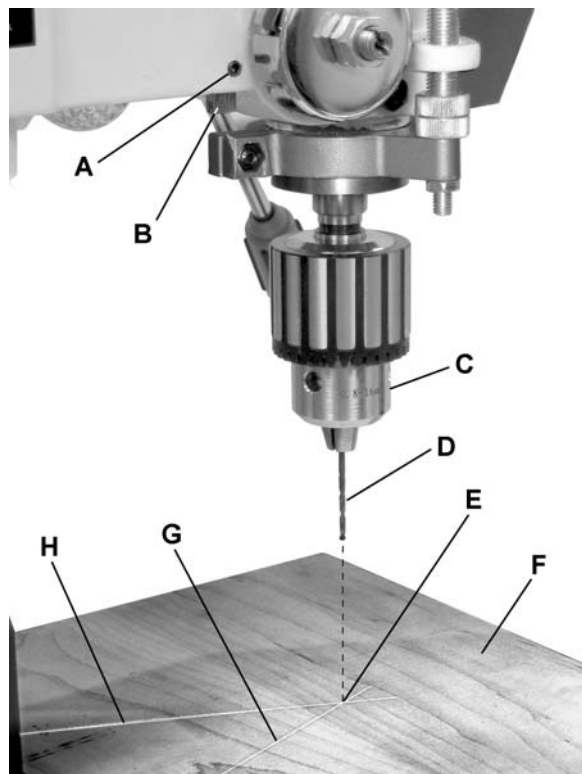


Figure 10

6. Adjust the other laser assembly in the same manner until both laser lines form *cross-hairs* (G, H) exactly over the *perforation* (E) in the board.
7. Tighten both *setscrews* (A).

The laser is now calibrated properly and the location of your holes can be centered at the crosshairs for accurate drilling.

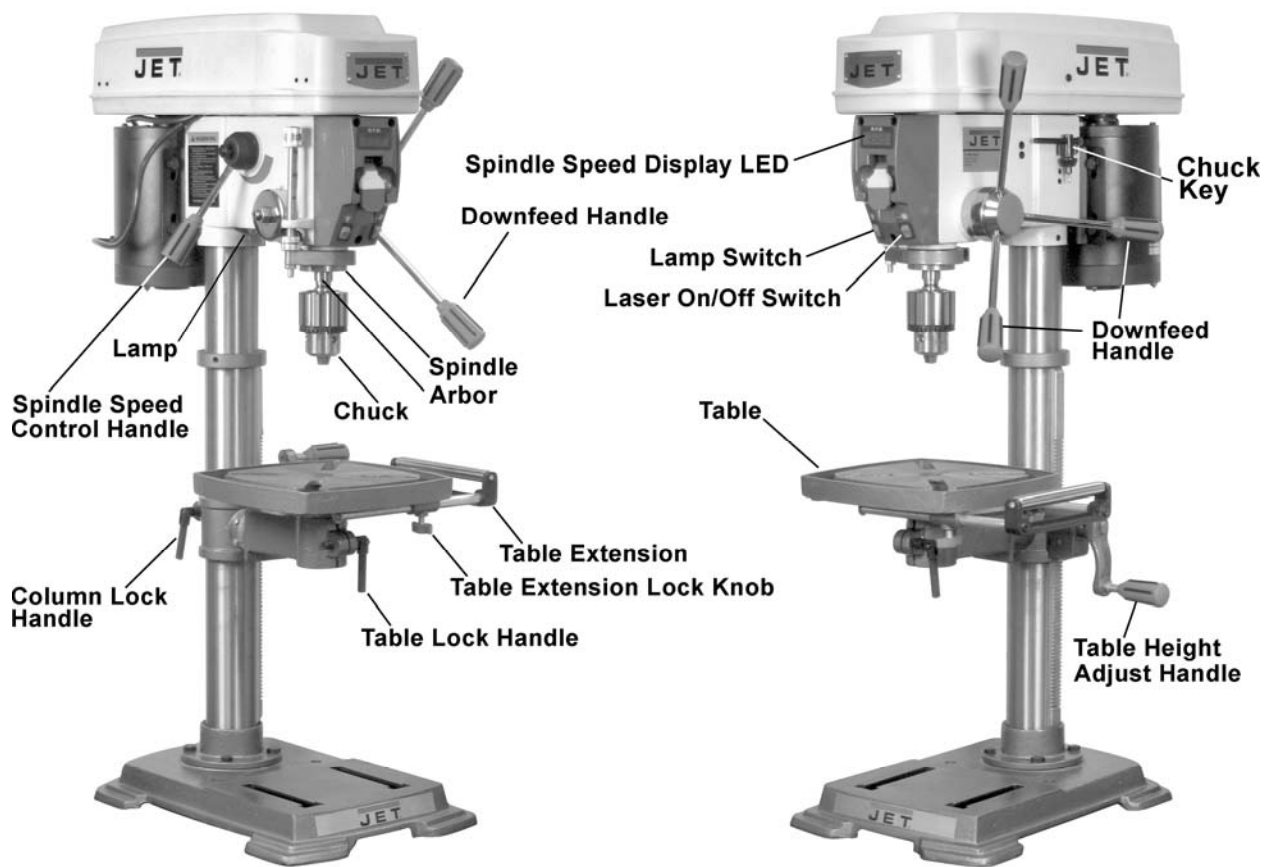


Figure 11

Features and Controls

Refer to Figure 11:

Downfeed Handle – Lower and raise drill.

Lamp Switch – Turns lamp on and off.

Laser Switch – Turns laser on and off.

Spindle Speed Adjustment Handle – Used to set spindle speed from 500 to 3000RPM. Machine must be on when making adjustment.

Start/Stop Switch – Pull switch to start; push to stop. Removing key (yellow) will prevent machine from being started. Key can be removed while machine is in operation, but machine will not restart until key is reinserted.

Table Height Adjust Handle – Raises and lowers table; column lock handle must be unlocked.

Table Lock Handle – Unlocking permits rotation of table.

Lubrication

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

Basic Operation

- Always use a back-up piece of scrap wood to cover the table. This protects both the table and the drill bit.
- Place material to be drilled in such a way as to come into contact with the left side of the column. This prevents the material from spinning.

⚠WARNING If the work piece is not large enough to come into contact with the column, use a clamp or drill press vise that is securely fastened to the table!

Failure to comply may cause serious injury!

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

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

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

Troubleshooting

Trouble	Probable Cause	Remedy
Drill press will not start.	<ol style="list-style-type: none"> 1. Drill press unplugged from wall or motor. 2. Fuse blown or circuit breaker tripped. 3. Cord damaged. 4. Starting capacitor bad. 	<ol style="list-style-type: none"> 1. Check all plug connections. 2. Replace fuse or reset circuit breaker. 3. Replace cord. 4. Replace starting capacitor.
Drill press does not come up to speed.	<ol style="list-style-type: none"> 1. Extension cord too light or too long. 2. Low current. 	<ol style="list-style-type: none"> 1. Replace with adequate size and length cord. 2. Contact a qualified electrician.
Drill Press vibrates excessively.	<ol style="list-style-type: none"> 1. Stand on uneven surface. 2. Bad belt(s). 	<ol style="list-style-type: none"> 1. Adjust stand so that it rests evenly on the floor. 2. Replace belts.
Noisy Operation.	<ol style="list-style-type: none"> 1. Incorrect belt tension. 2. Dry spindle. 3. Loose spindle pulley. 4. Loose motor pulley. 	<ol style="list-style-type: none"> 1. Adjust belt tension. See <i>Changing Spindle Speeds</i> on page 12. 2. Lubricate spindle. See <i>Lubrication</i> on page 15. 3. Check tightness of retaining nut on pulley and tighten if necessary. 4. Tighten set screws in pulleys.
Workpiece Burns.	<ol style="list-style-type: none"> 1. Incorrect Speed. 2. Chips not clearing from hole or bit. 3. Dull drill bit. 4. Feeding too slowly. 	<ol style="list-style-type: none"> 1. Change to appropriate speed – see speed and pulley chart on page 13. 2. Retract drill bit frequently to remove chips. 3. Resharpen, or replace drill bit. 4. Increase feed rate.
Drill bit wanders.	<ol style="list-style-type: none"> 1. Bit sharpened incorrectly. 2. Bent drill bit. 3. Bit or chuck not installed properly. 	<ol style="list-style-type: none"> 1. Resharpen bit correctly. 2. Replace drill bit. 3. Reinstall the chuck, or bit properly.
Wood splinters on the underside.	<ol style="list-style-type: none"> 1. No backing board used. 	<ol style="list-style-type: none"> 1. Place a scrap board underneath the workpiece to prevent splintering.
Drill bit binds in workpiece.	<ol style="list-style-type: none"> 1. Workpiece pinching the bit. 2. Excessive feed rate. 3. Chuck jaws not tight. 4. Improper belt tension. 	<ol style="list-style-type: none"> 1. Support or clamp workpiece. 2. Decrease feed rate. 3. Tighten chuck jaws. 4. Increase belt tension (page 12).
Excessive drill bit run out, or wobble.	<ol style="list-style-type: none"> 1. Bent drill bit. 2. Worn spindle bearings. 3. Bit or chuck not properly installed. 	<ol style="list-style-type: none"> 1. Replace drill bit. 2. Replace spindle bearings. 3. Reinstall the bit, or chuck properly.
Quill returns too slow, or too fast.	<ol style="list-style-type: none"> 1. Spring has improper tension. 	<ol style="list-style-type: none"> 1. Adjust "Return Spring Tension," page 14.
Chuck or arbor do not stay in place.	<ol style="list-style-type: none"> 1. Dirt, grease, etc on arbor, chuck, or spindle. 	<ol style="list-style-type: none"> 1. Clean all mating surfaces thoroughly with a cleaner degreaser.

Parts

Ordering 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.jettools.com). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

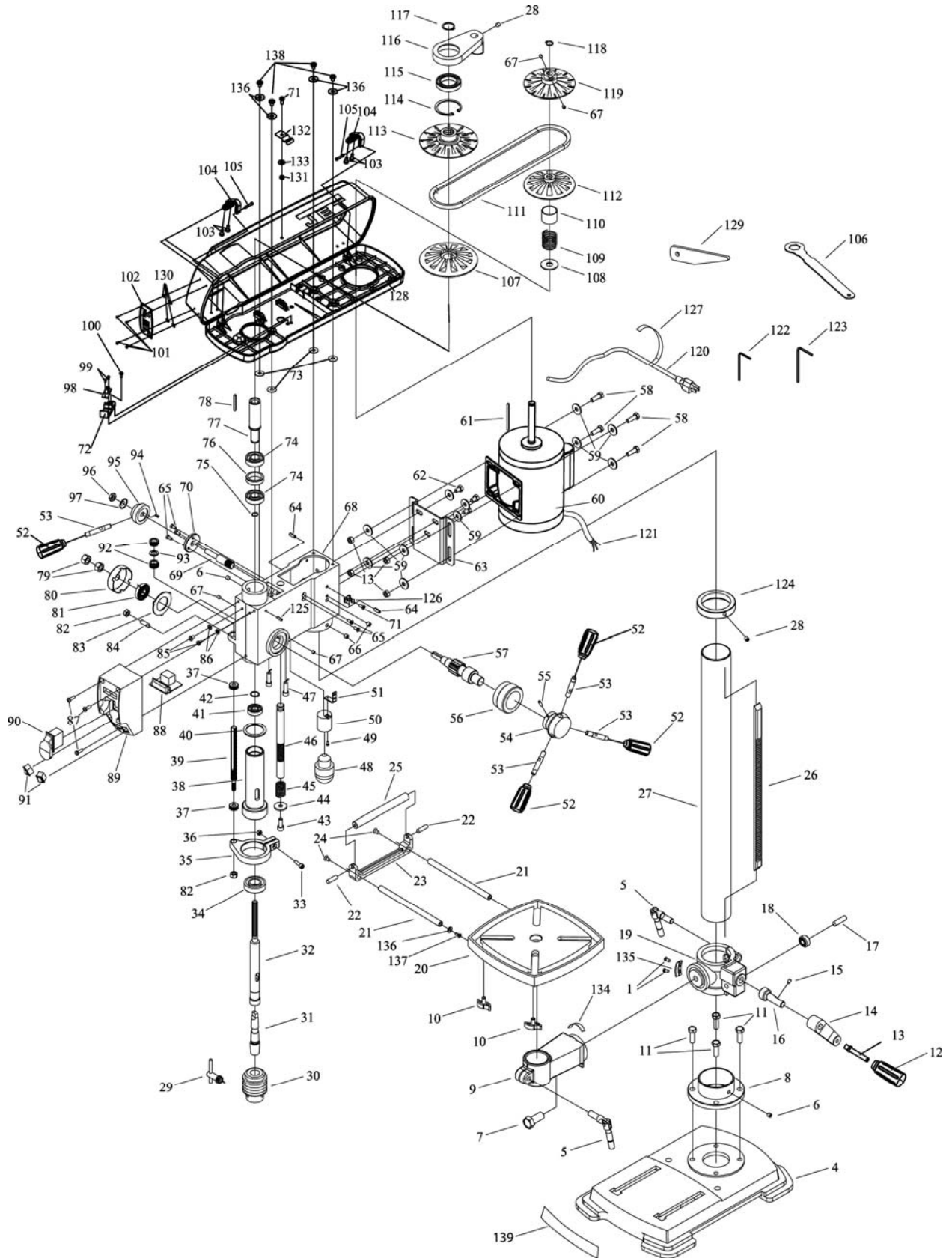
Parts List

Index No	Part No	Description	Size	Qty
1.....	TS-2284082.....	Pan Head Machine Screw	M4x8.....	2
2.....	TS-1482011.....	Hex Cap Screw	M6x10.....	1
3.....	TS-2286252.....	Pan Head Machine Screw	M6x25.....	4
4.....	JDP12-4.....	Base.....		1
5.....	JDP12-5.....	Lock Handle		2
6.....	TS-1524011.....	Set Screw.....	M8x8.....	4
7.....	TS-2213351.....	Hex Cap Screw	M16x35.....	1
8.....	JDP12-8.....	Column Support		1
9.....	JDP12-9.....	Table Arm.....		1
10.....	JDP12-10.....	Locking Knob.....		2
11.....	TS-1491041.....	Hex Cap Screw	M10x30.....	4
12.....	JDP12-12.....	Crank Arm Handle Grip		1
13.....	JDP12-13.....	Crank Arm Shaft.....		1
14.....	JDP12-14.....	Crank Arm.....		1
15.....	TS-1523031.....	Set Screw.....	M6x10.....	1
16.....	JDP12-16.....	Worm Shaft.....		1
17.....	JDP12-17.....	Gear Pin.....		1
18.....	JDP12-18.....	Helical Gear		1
19.....	JDP12-19.....	Table Support.....		1
20.....	JDP12-20.....	Table.....		1
21.....	JDP12-21.....	Guide Bar.....		2
22.....	JDP12-22.....	Screw		2
23.....	JDP12-23.....	Roller Support		1
24.....	TS-1534032.....	Pan Head Machine Screw	M6x10.....	2
25.....	JDP12-25.....	Roller		1
26.....	JDP12-26.....	Rack.....		1
27.....	JDP12-27.....	Column.....		1
28.....	TS-1524021.....	Set Screw.....	M8x10.....	2
29.....	JDP12-29.....	Chuck Key.....		1
30.....	JDP12-30.....	Chuck.....		1
31.....	JDP12-31.....	Chuck Arbor		1
32.....	JDP12-32.....	Spindle.....		1
33.....	TS-1534052.....	Pan Head Machine Screw	M6x16.....	1
34.....	BB-6204ZZ.....	Ball Bearing.....	80204 / 6204ZZ.....	1
35.....	JDP12-35.....	Lock Collar		1
36.....	TS-1540041.....	Hex Nut.....	M6.....	1
37.....	JDP12-37.....	Nut		2
38.....	JDP12-38.....	Quill.....		1
39.....	JDP12-39.....	Depth Stop Bolt		1
40.....	JDP12-40.....	Quill Gasket.....		1
41.....	JDP12-41.....	Ball Bearing.....	60201.....	1
42.....	JDP12-42.....	Retaining Ring.....	11.....	1
43.....	TS-1490031.....	Hex Cap Screw	M8x20.....	1
44.....	JDP12-44.....	Washer.....		1
45.....	JDP12-45.....	Spring.....		1
46.....	JDP12-46.....	Shaft.....		1
47.....	JDP12-47.....	Laser		2

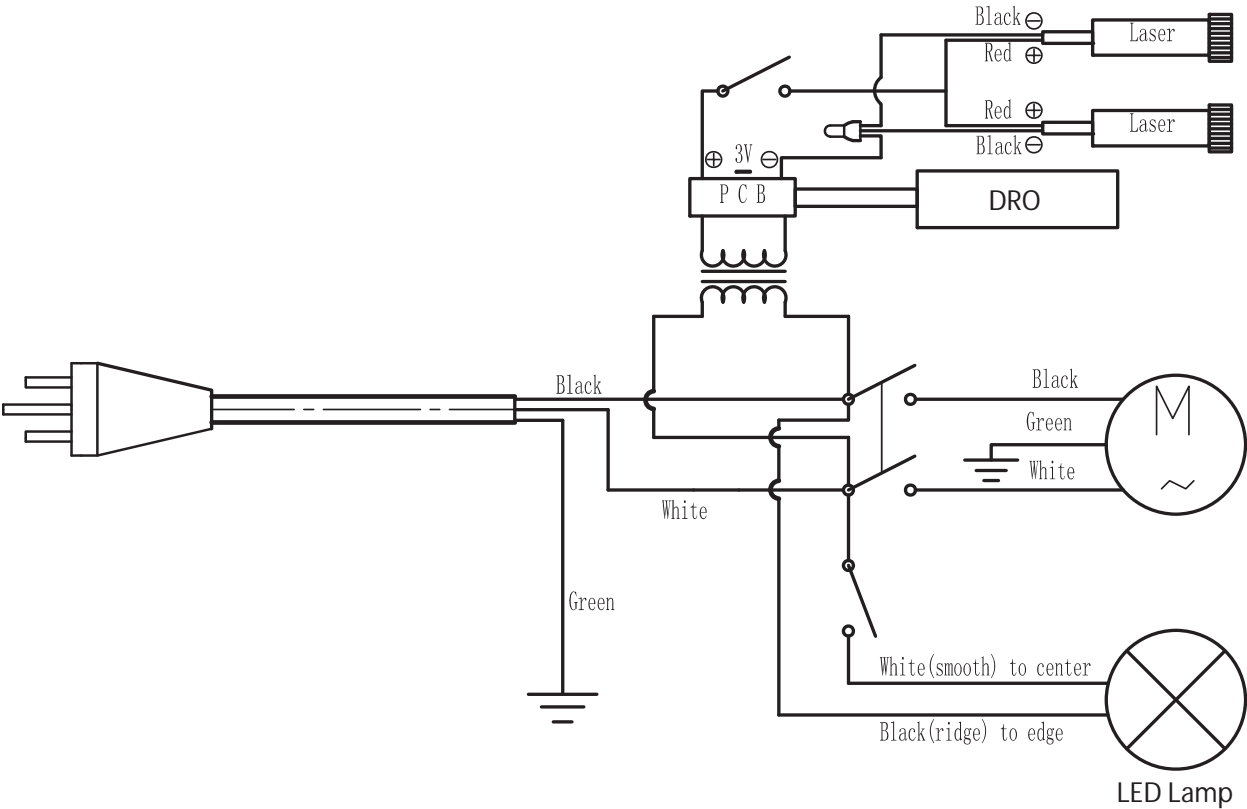
Index No	Part No	Description	Size	Qty
48	JDP12-48	LED Bulb		1
49	TS-1531022	Pan Head Machine Screw	M3x8	1
50	JDP12-50	Bulb Socket		1
51	JDP12-51	Socket Support		1
52	JDP12-52	Handle Grip		4
53	JDP12-53	Feed Handle		3
	JDP12-PHA	Pinion and Hub Assembly (includes #54,55,57)		1
54	JDP12-54	Hub		1
55	JDP12-55	Pin	Ø5x16	1
56	JDP12-56	Ring		1
57	JDP12-57	Pinion Shaft		1
58	TS-1490041	Hex Cap Screw	M8x25	4
59	TS-1550061	Flat Washer	M8	11
60	JDP12-60	Motor	1/3HP, 1Ph, 120V	1
	JDP12-60MC	Capacitor	145-174MFD, 125V	1
61	JDP12-61	Key	4x76	1
62	TS-1490011	Hex Cap Screw	M8x12	3
63	JDP12-63	Motor Mount		1
64	JDP12-64	Pin	Ø6x16	2
65	TS-2285121	Flat Head Machine Screw	M5x12	5
66	TS-1550041	Flat Washer	M6	4
67	TS-1523021	Set Screw	M6x8	4
68	JDP12-68	Head		1
69	JDP12-69	Shaft		1
70	JDP12-70	Shaft Plate		1
71	TS-1533032	Pan Head Machine Screw	M5x10	2
72	JDP12-72	Receiver Seat		1
73	JDP12-73	Foam Washer		4
74	JDP12-74	Ball Bearing	60203 / 6203Z	2
75	JDP12-75	Retaining Ring	17	1
76	JDP12-76	Spacer		1
77	JDP12-77	Pulley Shaft		1
78	JDP12-78	Key	4x60	1
79	JDP12-79	Hex Jam Nut	M12	2
80	JDP12-80	Spring Cap		1
81	JDP12-81	Coil Spring		1
82	TS-1540061	Hex Nut	M8	2
83	JDP12-83	Spring Retainer		1
84	JDP12-84	Set Screw		1
85	JDP12-85	Pan Head Screw	M5x6	2
86	JDP12-86	Washer		2
87	JDP12-87	Pan Head Screw	M5x14	3
88	JDP12-88	Digital Read Out		1
89	JDP12-89	Switch Box		1
90	JDP12-90	On/Off Switch		1
90-1	JDP12-90-1	Switch Safety Key		1
91	JDP12-91	Switch		2
92	JDP12-92	Depth Stop Adjustment Nut		2
93	JDP12-93	Washer		1
94	JDP12-94	Key	3x6	1
95	JDP12-95	Hub		1
96	JDP12-96	Self-Lock Nut		1
97	JDP12-97	Bowed Washer		1
98	JDP12-98	Receiver		1
99	JDP12-99	Self-Tapping Screw	ST2.2x6.5	4
100	TS-2284252	Pan Head Machine Screw	M4x25	1
101	JDP12-101	Rivet		4
102	JDP12-102	JET Nameplate		1

Index No	Part No	Description	Size	Qty
103	JDP12-103	Self-Tapping Screw	ST4.2x10	4
104	JDP12-104	Hinge		2
105	JDP12-105	Hinge Pin		2
106	JDP12-106	Wrench		1
107	JDP12-107	Spindle Pulley, Lower		1
108	JDP12-108	Spring Seat		1
109	JDP12-109	Motor Pulley Spring		1
110	JDP12-110	Spring Cover		1
111	JDP12-111	Belt	O-885	1
112	JDP12-112	Motor Pulley, Lower		1
113	JDP12-113	Spindle Pulley, Upper		1
114	JDP12-114	Retaining Ring	55	1
115	JDP12-115	Ball Bearing	61907ZZ / 6907ZZ	1
116	JDP12-116	Bracket		1
117	JDP12-117	Retaining Ring	24	1
118	JDP12-118	Retaining Ring	14	1
119	JDP12-119	Motor Pulley, Upper		1
120	JDP12-120	Power Cord		1
121	JDP12-121	Motor Cord		1
122	TS-152704	Hex Wrench	3mm	1
123	TS-152705	Hex Wrench	4mm	1
124	JDP12-124	Rack Collar		1
125	JDP12-125	Pin	Ø2.5x12	1
126	JDP12-126	Chuck Key Holder		1
127	JDP12-127	Cord Wrap		1
128	JDP12-128	Pulley Cover		1
129	JDP12-129	Drift Key		1
130	TS-1550011	Flat Washer	M3	4
131	TS-1540031	Hex Nut	M5	1
132	JDP12-132	Cover Clip		1
133	TS-1550031	Flat Washer	M5	1
134	JDP12-134	Tilt Scale		1
135	JDP12-135	Scale Indicator Bracket		1
136	JDP12-136	Speed Handle		1
137	TS-1540061	Hex Nut	M8	4
138	JDP12-138	Washer		1
139	JDP12-139	JET label (on base)		1

Assembly Drawing



Wiring Diagram





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