

PALMGREN®



25" GEAR HEAD DRILL PRESS 9680248, 230V WITH FOOT REVERSE 9680249, 460V WITH FOOT REVERSE



Read carefully and follow all safety rules and operating instructions before first use of this product.

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INTRODUCTION

Palmgren and Machinery Scandinavia / Arboga have entered into a joint venture to offer the Arboga gear head drilling machines throughout North America. Combining the strengths of both companies we can advance our resources of staff and technologies to offer our customers the very best drilling machines available today.

Arboga drill presses will continued to be manufactured in Sweden and supplied exclusively to Palmgren. Palmgren will provide all sales, technical support and service for Arboga as well as any other brand of Swedish gear head drilling machines.

Arboga gear head drilling machines are sold exclusively by Palmgren a C. H. Hanson Company brand. For parts, service or technical support please contact Palmgren at:

C. H. Hanson
 2000 North Aurora Road
 Naperville, Illinois 60563
 (800) 827-3398
 sales@chhanson.com

GENERAL

This manual is for models 9680248 and 9680249 drill presses. It has been prepared for those using the machine or who are responsible for its maintenance and service and should therefore be made readily available for all those concerned.

Read through the manual carefully before installing and starting up the machine. The machine is of simple design and robustly built, but we cannot guarantee perfect function if it is not correctly handled.

It is therefore necessary to make yourself thoroughly acquainted with its functions and to carry out practical tests on the various parts of the control system and the machine settings. Once these are mastered, the properties of the machine can be fully utilized and the component parts will give maximum service life.

Every machine is tested for accuracy and capacity at the factory. Experienced staff checks both the mechanical and electrical functions according to a standardized program, meaning that we can guarantee workmanship of the highest and most consistent quality.

By following our directions and your own good judgement, we are convinced that your new machine will give you every satisfaction. However, should any problems arise, please do not hesitate to contact our dealer or us.

CE-LABELLING AND DECLARATION OF CONFORMITY

An “EC Declaration of Conformity” accompanies machines delivered within the European Union (CE-labelled machines).

The declaration of conformity is valid only if the chuck guard (see figure 2) is used.

SAFETY

SAFETY MESSAGES

Safety messages in this manual are accompanied by a safety alert symbol and a signal word. The safety alert symbol is used to alert the reader about a potential risk of personal injury or damage on the equipment.

SAFETY REGULATIONS

Used correctly, your machine is one of the best concerning design and safety. However, any machine which is used incorrectly can be a safety risk.

It is very important, that those who use the machine are informed how to handle it correctly. They should read and understand these instructions, as well as all signs on the machine. Neglecting to follow the safety regulations can cause an accident.

! WARNING: Using the machine incorrectly can cause serious accidents. The machine has to be installed, used and maintained correctly.

All machines with rotating tools or details can cause accidents. It is therefore important that you as an operator are aware of those risks for any accident and that you avoid all possibilities for accidents.

! PROPOSITION 65 WARNING: Some dust created by using power tools contain chemicals known to the state of California to cause cancer, birth defects or other reproductive harm.

Some examples of these chemicals are:

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

Your risk from these exposures 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. Always wear **OSHA/NIOSH** approved, properly fitting face mask or respirator when using such tools.

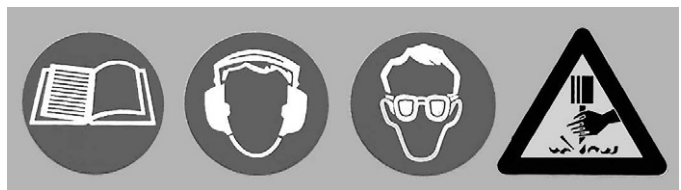


Figure 1 - Warning symbols on the machine.

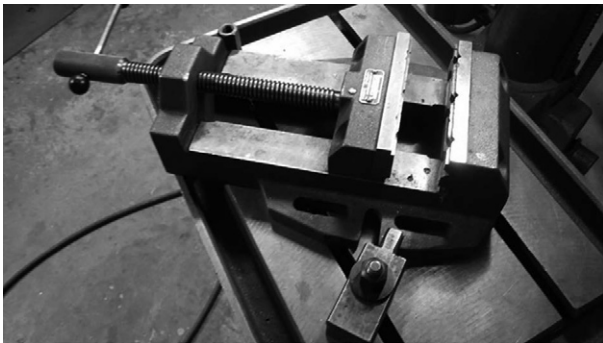
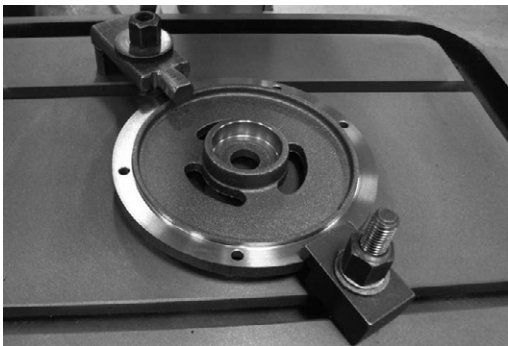
- Always use appropriate clothes and personal equipment, so that you cannot get caught by rotating tools. Avoid using protective gloves if possible. Use hairnet if necessary.
- Always use eye protection, if there is a risk for chips or splashes from the coolant. Follow local instructions if existing.
- Never use the machine if it lacks necessary protection.
- The chuck guard (figure 2a) must always be used. For safety reasons, the chuck guard is equipped with a micro switch.

SAFETY (CONTINUED)**Figure 2a - Chuck guard (for machines within the EU).****Figure 2b - Depth gauge (3).**

- Depth gauge and Depth gauge rod (3) must never be removed from the machine.
- Keep clean around the machine to avoid stumbling against rotating tools.
- Make sure that the work piece is securely fastened at the table, see the examples in figure 3 and 4.



WARNING: Never use your hand to hold the work piece.

**Figure 3 - Fastening the table vice on the table, example.****Figure 4 - Fastening the work piece on the table, example.**

- Make sure that the switch is in position "0" when changing tools or when cleaning the machine. Never brush away chips while the machine is operating.
- Never stretch yourself over the machine when it is running.
- Always stop the machine when not in use.
- Use faultless tools and the correct speed and feed for the tool. Make sure that the tool is the correct one for your operation.
- Make sure that the drill head, table arm and table are thoroughly fastened before starting up the machine.

DESIGN AND FUNCTION**Figure 5 - Drilling machines.**

1. Drill head
2. Feed shaft with handle
3. Table
4. Crank for worm gear (2 pcs)
5. Base plate
6. Lock handle (3 pcs)

The gearbox is built according to our experienced methods for highest possible torque.

Helical gears combined with steel gears against reinforced fiber gears in the main gear

box ensure higher operation efficiency, a more powerful drive mechanism and smooth operation.

Both the drill head and the table arm are adjustable 360° around the column and can be raised and lowered.

DESIGN AND FUNCTION (CONTINUED)

DRILL HEAD - MANUAL FEED

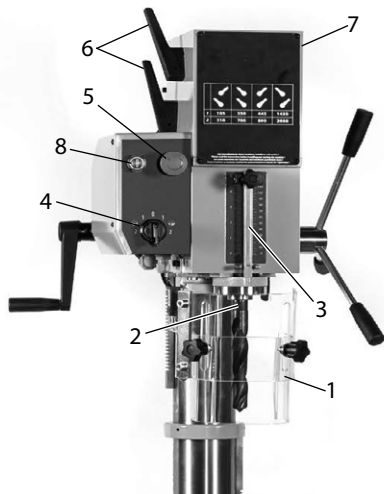


Figure 6 - Drill head, example.

1. Chuck guard
2. Spindle quill
3. Depth gauge rod
4. Switch/speed selector
5. Emergency stop push button
6. Gear lever (2 pcs)
7. Gearbox
8. Start button

EMERGENCY STOP

See the location of the emergency stop push button (5) in figure 6. The emergency stop shall be used in case of emergency to stop the machine as fast as possible.

INSTALLATION

SET-UP

Consider the following during set-up of the machine:

- The machine must be installed on a firm foundation. The base plate must be levelled with washers on the foundation bolts, to prevent harmful stresses when the nuts are tightened.
- Do not install the machine in a humid, dirty or badly illuminated environment.
- All bright parts of the machine are treated with rust prevention. By removing this, be careful not to use too strong cleaning compound. The paint might then get damaged.
- Make sure that the boring tool cone is well-cleaned.
- Be sure that the machine is equipped with all necessary protections to comply with the CE directives.
- 9680248 and 9680249 arrive without oil, see "Oil Filling, Feed Gear Box" on page 6.

ELECTRIC INSTALLATION

NOTE: Electric installations have to be performed by a qualified electrician.

1. Make sure that the correct voltage is supplied to the machine.
2. Set up the electrical connections according to the attached circuit diagram.
3. Make sure that the drilling spindle has the correct rotation direction.

SPECIFICATIONS

	9680248	9680249
Swing	25"	25"
Column	4.13"	4.13"
Max drill size	1.25"	1.25"
Max tap size	3/4", 7/8"	3/4", 7/8"
Arbor	MT3	MT3
Chuck	3/4", JT4	3/4", JT4
Spindle travel	6"	6"
Max workpiece height	31.25"	31.25"
RPMs	90-190, 320-640, 530-1060, 1790-3610	90-190, 320-640, 530-1060, 1790-3610
Voltage	230V	460V
Amps	6.5	3.25
HP	2	2
kW	1.1-1.5 kW	1.1-1.5 kW
Phase	3	3
Table	19.70" x 15.75"	19.70" x 15.75"
T-slot dimensions	A: 5/16", B: 1/2", C: 1" D: 15/32	A: 5/16", B: 1/2", C: 1" D: 15/32
Table T-slot distance	3.94" center to center	3.94" center to center
Base	18.7" x 26.4"	18.7" x 26.4"
Overall dimensions	21.5" x 26.5" x 75.5"	21.5" x 26.5" x 75.5"
Weight	573 lbs	573 lbs

ACCESSORIES

This machine includes:

- Drill press vise (SKU: 9612401) x1
- Forward/reverse foot pedal (SKU: 964848401) x1
- Chuck, 3/4", JT4, w/ key (P/N 964848301) x1
- Arbor MT3/JT4 (P/N 964848201) x1

HANDLING

MANUAL FEED

⚠ WARNING: Use the lock handles to lock the drill head, table arm and the table. Make sure that the work piece is securely fastened at the table. Carefully read through the safety instructions in this manual before using the machine.

DRILLING

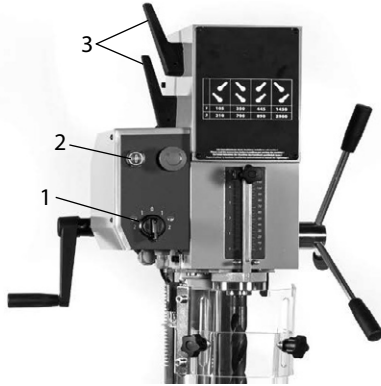


Figure 9 - Set-up

NOTE: The machine can not be shifted during operations.

NOTE: Always start single-phase machines in position "1". When the machine has reached its top speed, the switch can be turned to position "2".

1. Set the switch (1) to position "0". Press the Start button (2) to set the machine ready for operation (the light in the button lights up). You can now drive forward / reverse and 2 speeds via the switch/speed selector (1).
2. At triggered Emergency Stop - Reset the emergency stop and proceed according to step 1.
3. At triggered overcurrent relay - Reset automatically, proceed according to step 1.
4. At triggered drill protection - Fold back the cover and proceed according to step 1.

THREADING, - MANUAL FEED

When using different courses of thread, it is not allowed to exceed the recommendation shown in the table below. Otherwise, the depth stop bottoms or gets displaced, or - in worst case - the quill collar might break off. See the table:

Threads	Rotation Speed 60 Hz Max.
0 - 0.5 mm	530 RPM
0.5 - 1.0 mm	320 RPM
1.0 - 2.0 mm	190 RPM

The maximum number of reversals is 5 per minute. In order to get better quality threading, we recommend using a floating tap wrench. See figure 9.

- 1) Depending on the thread depth, the spindle speed should be set differently. See the table above.
 - Select the spindle speed using the two gear levers (1) on the left side of the gearbox. See the sign on the front side of the machine.
 - If any of the gears are difficult to get into position, rotate the spindle nose manually.

NOTE: The machine cannot be shifted during operations.

- 2) There are 2 different ways to reverse the spindle rotation of the machine
 - Reversing using the switch/speed selector (2), see "Reversing by using the switch/speed selector".
 - Automatic reversing using the level switch. The desired drill depth is set with the drill depth stop (3), see "Automatic reversing by using the drill depth stop (optional)".

REVERSING BY USING THE SWITCH/SPEED SELECTOR

- 1) Follow the steps in "Drilling", page 4.
- 2) Set the drill depth stop in the upper position.
- 3) Turn the switch/speed selector to position "1" or "2"; see the table above or the sign on the front side of the machine.
- 4) Feed the spindle manually downwards with the feed lever.
- 5) At the desired drill depth, turn the selector anti-clockwise to position "1" or "2".
- 6) Feed the spindle manually upwards with the feed lever. Turn the selector clockwise to position "0".

MANUAL DRILLING

Note! Make sure the claw coupling is inserted.

1. Feed the spindle down to the desired drill depth.
2. Set the stop on the depth gauge rod in the desired position or else, set the stop in the upper position.

DRILL EJECTOR

The machine is equipped with an automatic drill ejector. Between the nose of the spindle sleeve and the spindle case, there is a stopper that prevents the spindle from reaching its upper position.

NOTE: When ejecting the boring tool from a machine with automatic feed, the claw coupling must be inserted.

AUTOMATIC EJECTION

To eject the drill:

- 1) Bend out the stopper (see the arrow in figure 14).
- 2) Grip the tool and hit the spindle sleeve to its upper position with the feed lever. The boring tool should be pushed out.



Figure 14 - Automatic drill ejection.

- 3) Bend the stopper back.
- 4) Mount a new tool to the spindle.

DRILL EJECTOR (CONTINUED)

EXPELLER WEDGE

The boring tool may become stuck in the spindle, e.g., via hard drilling pressure and heat changes in the spindle. In this case, we recommend using an expeller wedge instead of the automatic drill ejector, see figure 15.



Figure 15 - Expeller wedge.

MAINTENANCE

OIL FILLING, FEED GEAR BOX

The machine is not supplied with oil in the power feed gearbox.

- The feed gear box's worm gear sits in an oil bath. Add oil via the filling hole (1) up to the middle of the level indicator (2), see figure 16. Approx. 0.3 liters should be kept available to cover the need.

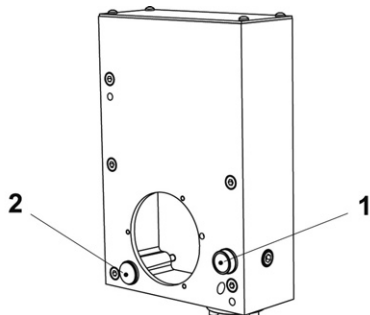


Figure 16 - Oil filling and level indicator, feed gear box

OIL RECOMMENDATIONS

Proper oil should have a viscosity of 5 °E at 50 °C.

NOTE: The guarantee of the machine is based on the use of these oils - at normal temperatures.

Oil company	Oil type
OK Petroleum	Delta Oil 68
BP	BP Maccurant 68, BP Bartran 68
Castrol	Castrol Hyspin AWS 68
Texaco	Texaco HD 68
Statoil	Nuto H68
Mobil	Mobil DTE 26, Mobil Vactra Oil No 2
Shell	Shell Tellus Oil 68, Shell X-100 10W/30

CLEANING

- Always make sure that the boring tool tongue and cone are well cleaned and not damaged. This to avoid unnecessary wear and tear of the drilling spindle and/or the boring tool getting caught in the spindle.
- Keep the table and work piece free from chips. Use a brush, not compressed air.

LUBRICATION

All ball bearings and gear wheels are lubricated at the factory. For other lubrication; check levels regularly and apply grease, if necessary, see figure 17 and figure 18.

DRILL HEAD

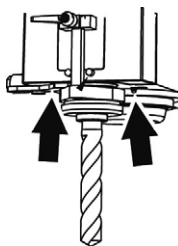


Figure 17 - Grease nipples, drill head.

WORM GEAR BOX

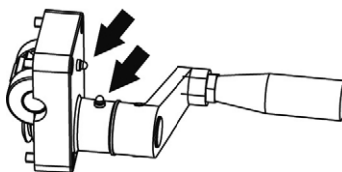


Figure 18 - Grease nipples, worm gear box.

REPAIR

For parts, service or technical support please contact Palmgren at:

C. H. Hanson
 2000 North Aurora Road
 Naperville, Illinois 60563
 (800) 827-3398
 sales@chhanson.com

CORRECTIVE MAINTENANCE

GENERAL



WARNING: Disconnect the machine from the external mains before any dismantling takes place.

On reassembly, see to it that all surfaces are clean and that any burrs, which may have been made during disassembly, are first removed.

ADJUST THE TAPER BEARING PLAY

The spindle is journaled in the quill by a taper roller bearing at the bottom and by a radial ball bearing at the top. At the top end of the spindle, there is a nut, with which the play in the taper bearing can be adjusted. This nut can be reached, when the quill is removed from the machine as follows:

- 1) Remove the depth stop rod, see figure 19.



Figure 19 - Removing the depth stop rod.

- 2) Feed out the complete quill with the feed handle. Hold the quill, so that it doesn't fall out and gets damaged.
- 3) Loosen the spring pressure by letting the feed handle slowly return.
- 4) Adjust the play at the top end of the quill by turning the nut clockwise. Make sure it does not turn heavily, see figure 20.



Figure 20 - Nut for adjusting the play of the quill.

- 5) Turn the feed handle about two turns for counter balancing the quill.
- 6) Put back the quill and make sure the keys on the spindle coincide with the key ways in the spindle shaft and that the teeth of the feed shaft get the grip of the quill feed rack.
- 7) Let the quill return to the top position. Check the position of the feed handle and adjust by the feed shaft teeth grip another rack position.
- 8) If necessary, feed out the quill and turn the feed handle to further counter balance the quill as described in "Counter Balancing the Spindle" on page 7.
- 9.) Re-assemble the depth stop rod.

COUNTER BALANCING THE SPINDLE

Counter balance the spindle by tightening the spring in the spring housing as follows:

- 1) Remove the depth stop rod and feed out the complete quill, see "Adjust the Taper Bearing Play" on page 7.
- 2) Increase the return speed (the spring is tightened) by turning the feed handle 1/4 turn clockwise. Reduce the return speed by turning the feed handle 1/4 turn anti-clockwise.
- 3) Put back the quill and re-assemble the depth stop rod, see "Adjust The Taper Bearing Play" on page 7.

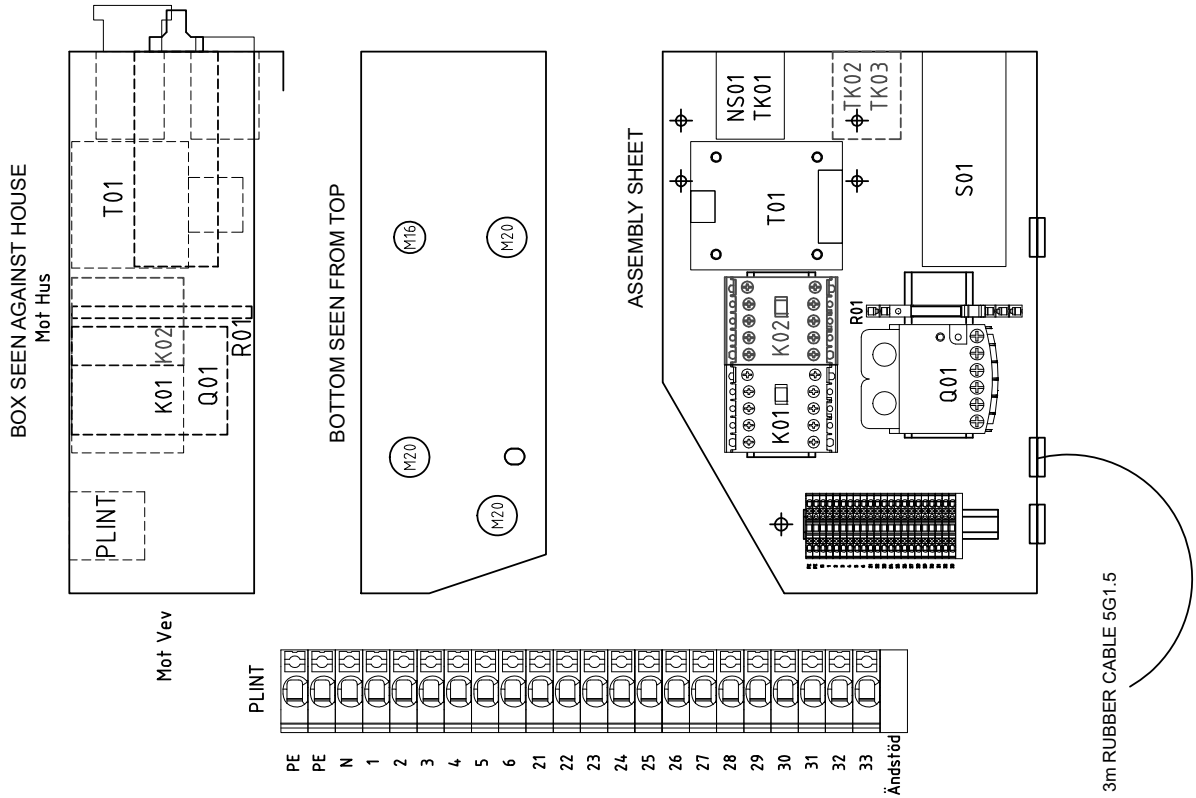
MOTOR

In case of motor failure, please contact Palmgren for further information.

GEARBOX

In case of gearbox failure, please contact Palmgren for further information.

ELECTRICAL SCHEMATICS



FUNCTION:

1. SET SWITCH TO MODE "0"
PRESS TK01 FOR MACHINE READY TO OPERATE
THE LAMP IN THE BUTTON LIGHTS ON
NOW YOU CAN DRIVE FORWARD / BACK AND 2
SPEEDS VIA S01
2. TRIGGERED EMERGENCY STOP
RESET THE EMERGENCY STOP
FOLLOW STEPS ABOVE, IN #1
3. TRIGGERED OVERCURRENT RELAY
RESETS AUTOMATICALLY
FOLLOW STEPS ABOVE, IN #1
4. TRIGGERED DRILL GUARD (OPTIONAL)
FOLD BACK THE DRILL GUARD
FOLLOW STEPS ABOVE, IN #1
5. FOOT CURRENT SWITCH
FOLLOW STEPS ABOVE, IN #1
START / STOP ALSO VIA THE FOOT POWER SWITCH
6. FOOT REVERSAL
FOLLOW STEPS ABOVE, IN #1
FRAM-O-BACK ALSO VIA FOOT REVERSION SWITCH

AUTOMATIC REVERSAL (OPTIONAL)
ON / OFF VIA LAMP PUSH BUTTON TK03

SETTING Q01

PROTECTION Q01 IS BASICLY WINDED THREE TIMES
THIS MEANS THAT THE SCALING WILL BE 1-10A
INSTEAD OF M3-30A
FOR A MOTOR OF 5A, Q01 SHOULD BE SET OF 15A
(3X5 = 15)

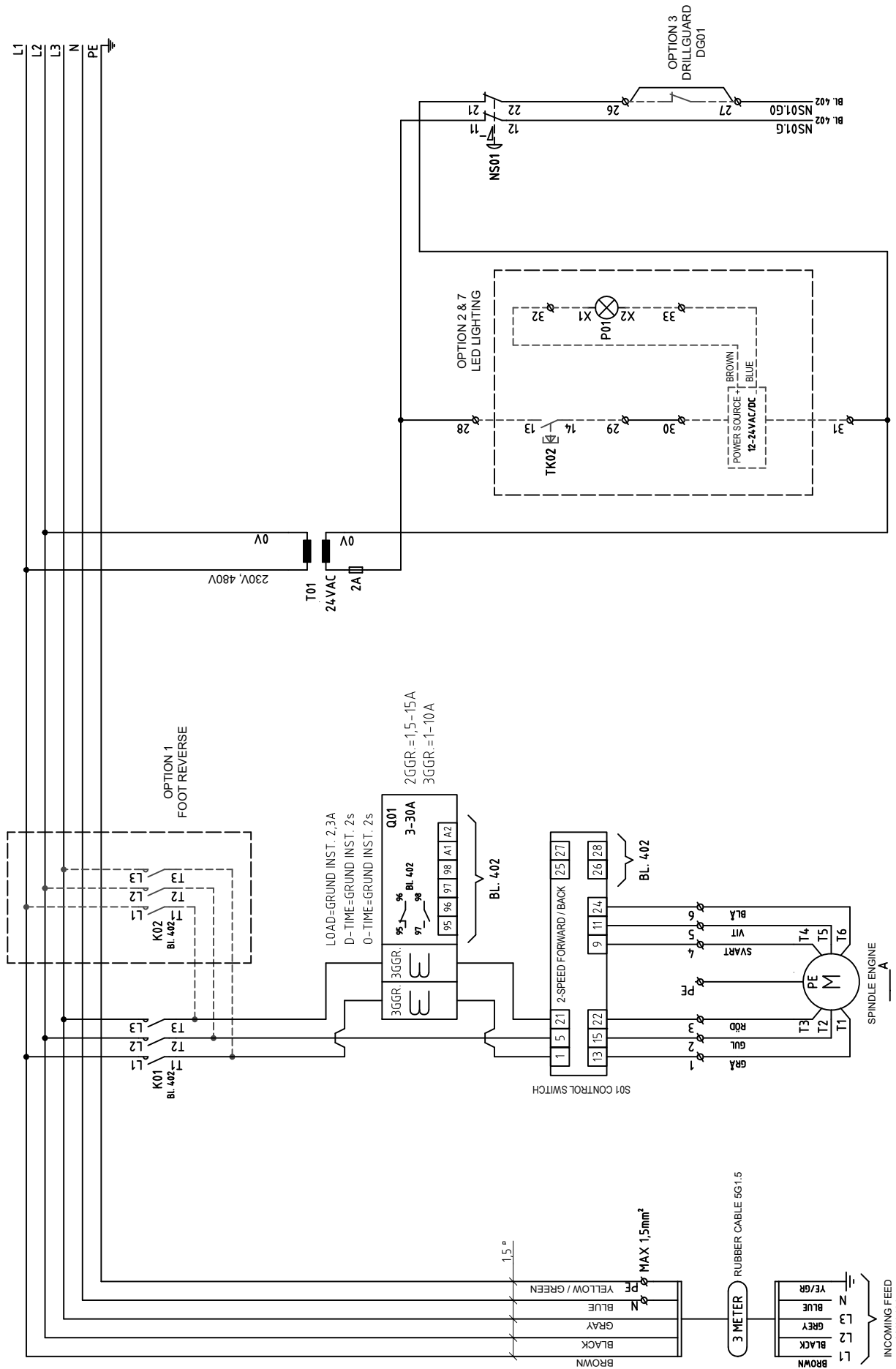
ELECTRICAL PARTS LIST

Ref. No.	Designation	Make	Type/No.	Data	Sheet
FRS01	FRONT SIGN	INFOSERVICE	SEE TEMPLATE		202
K01	MINI CONTACTOR	SCHNEIDER ELECTRIC	LC1-K0910B7	24VAC/9A 4kW	402
NS01	CONNECTOR 2NC	SCHNEIDER ELECTRIC	ZB5AZ1045	2br BLADE SPRING CONNECTION	401
NS01	EMERGENCY STOP BUTTON	SCHNEIDER ELECTRIC	ZB5AS844	TRIGGER ACTION	401
Q01	ELECTR. OVERCURRENT RELAY	SCHNEIDER ELECTRIC	LT4730B5	3-30A 24VAC/DC	401
R01	RELAY MODULE	PHOENIX	PLC-RPT- 24UC/21 / 2900300	24VAC/DC 1vxl	402
S01	CONTROL SWITCH	SONTHEIMER	WAH2119/13ZM/X99/Z20	DAHLANDER 2 Hast.Fram/Back	401
T01	Transformer	NORATEL	CUSTOMIZED 24VAC/2A	0-230-400-440-480-575V / 24V	401
TK01	CONNECTORS 1NO	SCHNEIDER ELECTRIC	ZB5AZ1015	15L BLADE SPRING. CONNECTION	402
TK01	LAMP PRESSURE RE-FJ.	SCHNEIDER ELECTRIC	ZB5-2001HC5ZO	GREEN "1"	402
TK01	LAMP BLOCK GREEN LED	SCHNEIDER ELECTRIC	ZBVB35	24V BLADE SPRING. CONNECTION	402
X01 (19)	MINIPLINT PUSH-IN	PHOENIX CONTACT	MPT 1,5/S	0,14 mm ² - 1,5 mm ²	
X01 (1)	MINIPLINT PUSH-IN	PHOENIX CONTACT	MPT 1,5/S BU	0,14 mm ² - 1,5 mm ²	
X01 (2)	MINIPLINT PUSH-IN	PHOENIX CONTACT	MPT 1,5/S-PE	0,14 mm ² - 1,5 mm ²	

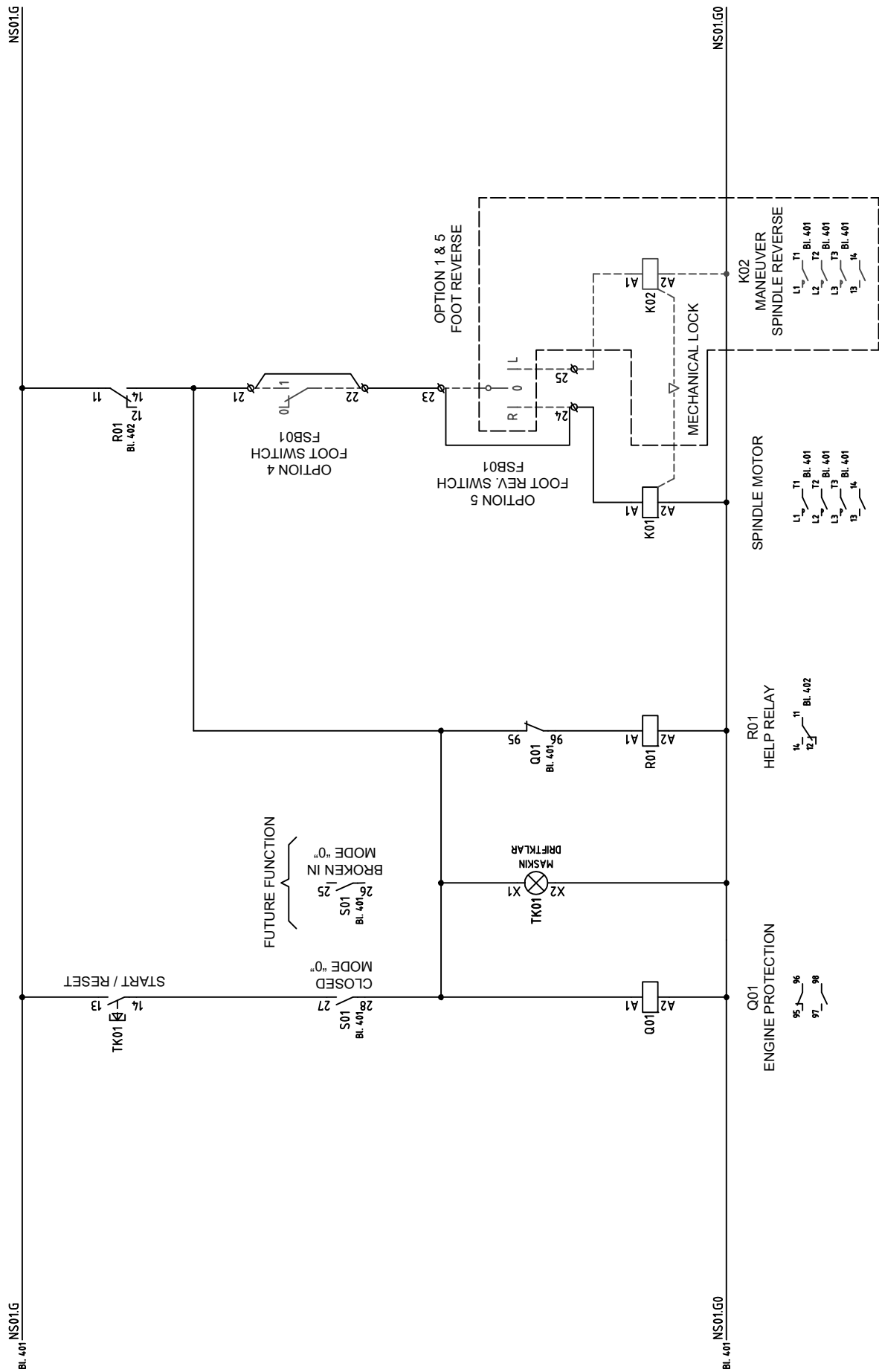
ELECTRICAL PARTS LIST

Ref. No.	Designation	Make	Type/No.	Data	Sheet
<OPT.1> K02	FRONT/BACK CONTACTOR	SCHNEIDER ELECTRIC	LC2K0910B7	24VAC/9A 4kW	402
<OPT.2> TK02 TK02	Push-button CONNECTORS 1NO	SCHNEIDER ELECTRIC SCHNEIDER ELECTRIC	ZB5-2001HC55T ZB5AZ1015	PRESS-TAP WITH LAMP SYMBOL 15L BLADE SPRING. CONNECTION	401 401
<OPT.3> DG01	BOUNDARY POSITION DRILL PROTECTION		COMEPI	EP1G14	401
<OPT.4> FSB01	FOOT CURRENT SWITCH	Art. 3E02007		15L + 1BR CONNECTOR	402

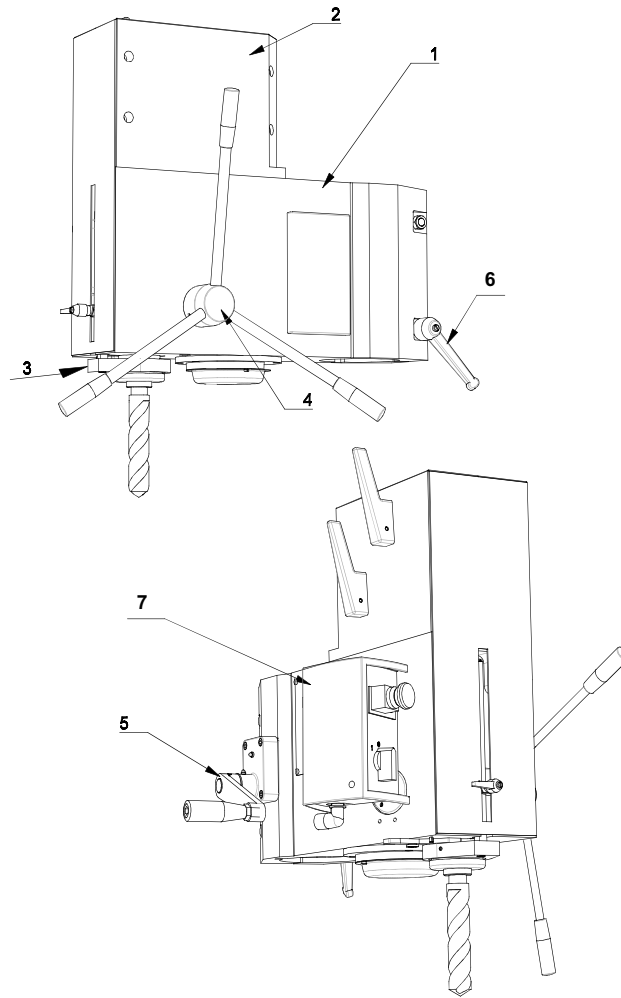
ELECTRICAL SCHEMATICS



ELECTRICAL SCHEMATICS

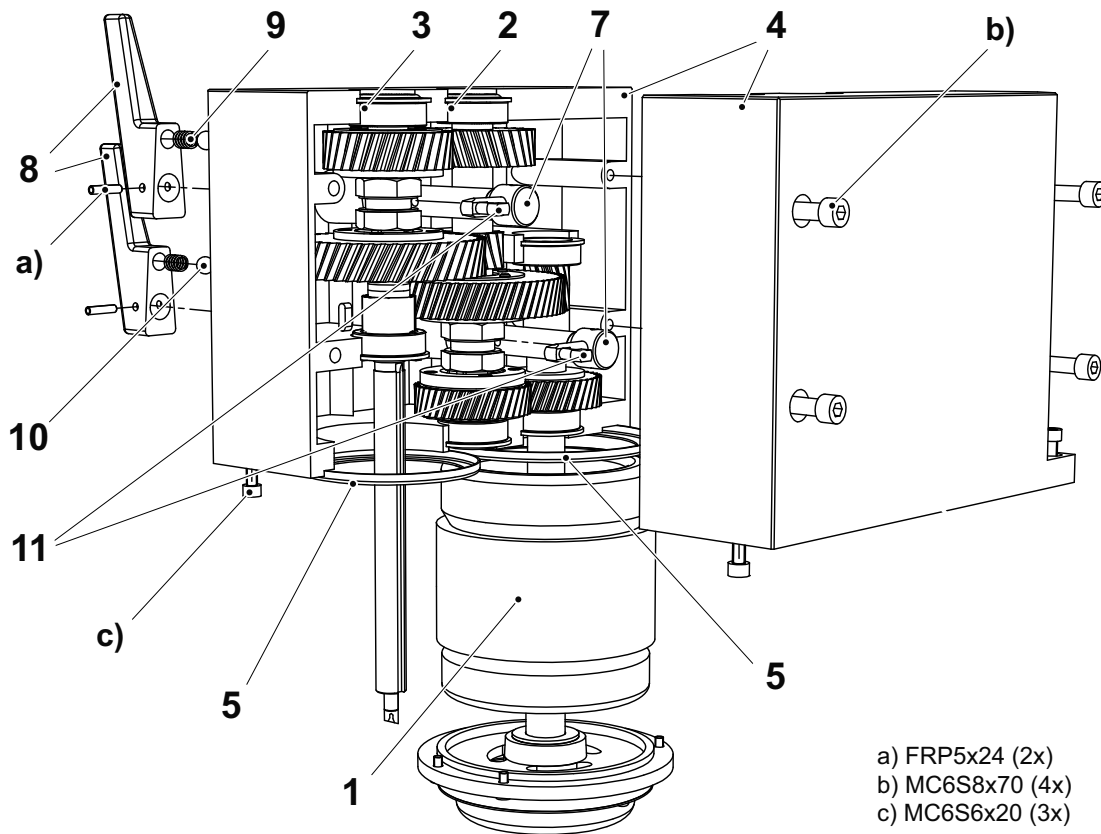


PARTS FOR DRILL HEAD



Ref. No.	Part Number	Description	Note
1	2V08522	Spindle housing	
2	2X08506B	Gear box	
3	2X08529R	Spindle sleeve	
4	2X08752R	Feed shaft complete	
5	2X087201R	Worm gear unit	
6	3R000141	Lock handle	
7	2X087911	Electric box compl.	

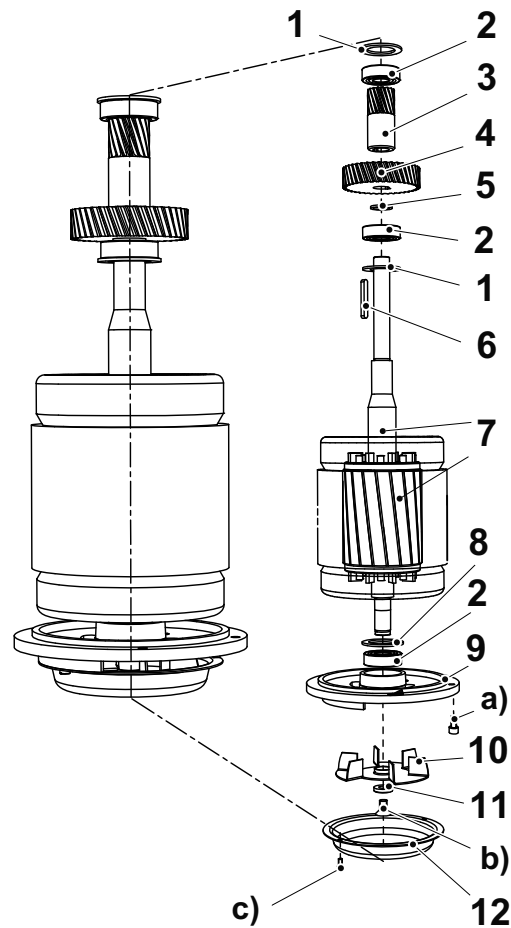
PARTS FOR GEAR BOX



- a) FRP5x24 (2x)
- b) MC6S8x70 (4x)
- c) MC6S6x20 (3x)

Ref. No.	Part Number	Description	Note
1	2X08561B	Motor shaft complete	
2	2X08570R	2:nd shaft complete	
3	2X08580R	3:rd shaft complete	
4	2X08523	Gear box complete	
5	4B00174	Ring	2x
7	2X08536	Gear selector arm	2x
8	2RS06531	Gear lever	Kompl. 2XS0653-1
9	4C02921	Gear	2x
10	3T04028	Steel ball	2x
11	4T04168	Shift pin	2x

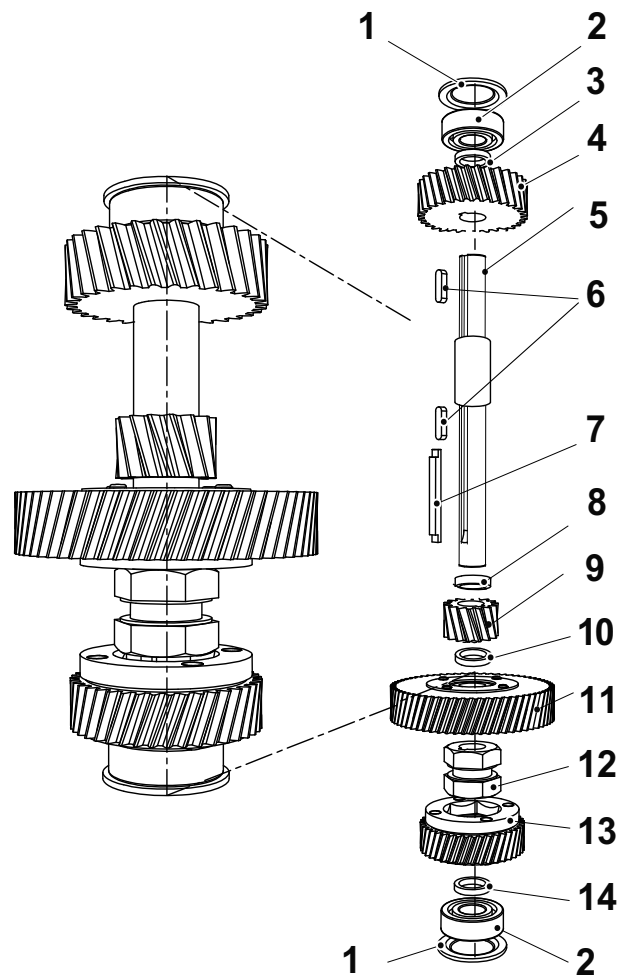
PARTS FOR ENGINE SHAFT



- a) MC6S5x10 (4x)
- b) MF6S8x14
- c) MC6S4x8 (2x)

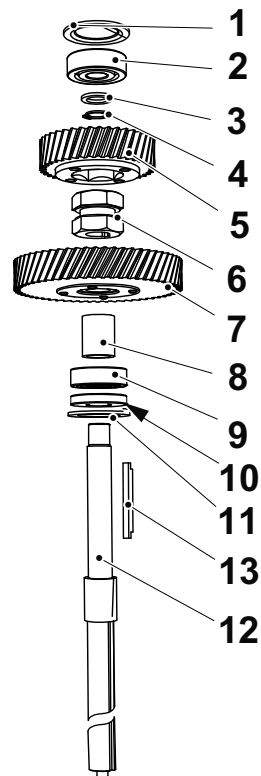
Ref. No.	Part Number	Description	Note
1	4B00137	Washer	
2	3L15003	Ball bearing	6203-2RS (3x)
3	2H08562	Gear	17-1,5
4	2H08563	Gear	40-2
5	2D00008	Spacing sleeve	17x6,5
6	3K01196	Key	RKh9 5x5x42
7	3E80083R	Stator + rotorshaft Stator 80/2-24-100	400 - 440 V
8	4F06203	Washer	
9	2N01889	Bearing cover	
10	4B00175	Fan	
11	2B03449	Washer	
12	4B01890	Fan cover	

PARTS FOR SECOND SHAFT



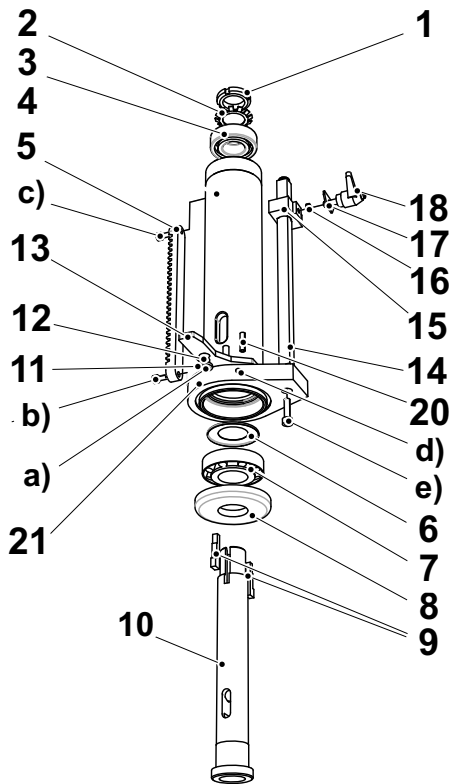
Ref. No.	Part Number	Description	Note
1	4B00138	Cover	2x
2	3L15003	Ball bearing	6203-2RS (2x)
3	2D00002	Spacing sleeve	17x2,5
4	2H08572	Gear	34-2
5	2A04871	2:nd shaft	C-4871
6	3K01187	Key	RK 5x5x20 (2x)
7	2T06615	Key	C-6615
8	3B11005	Washer	17x24x1
9	2H08573	Gear	15-2
10	2D17004	Spacing sleeve	17x4
11	2X08574R	Gear compl.	79-1,5 (fiber)
12	2T04254	Clutch	C-4254
13	2X08575R	Gear compl.	33-2 (fiber)
14	2D00008	Spacing sleeve	17x6,5

PARTS FOR THIRD SHAFT



Ref. No.	Part Number	Description	Note
1	4B08584	Cover	C-138
2	3L15002	Ball bearing	6302-2RS
3	3B01184	Ring	15x22x1
4	3C01117	Circlip	SgA 15
5	2X08582R	Gear compl.	39-2 (fiber)
6	2T04254	Clutch	C 4254
7	2X08583R	Gear compl.	58-2 (fiber)
8	2D00007	Spacing sleeve	17x28,5
9	3L15003	Ball bearing	6203-2RS
10	2D17038	Spacing sleeve	17x38
11	4B00137	Washer	C-137
12	2T06615	Key	C-6615
13	2A08531	Spindle shaft	

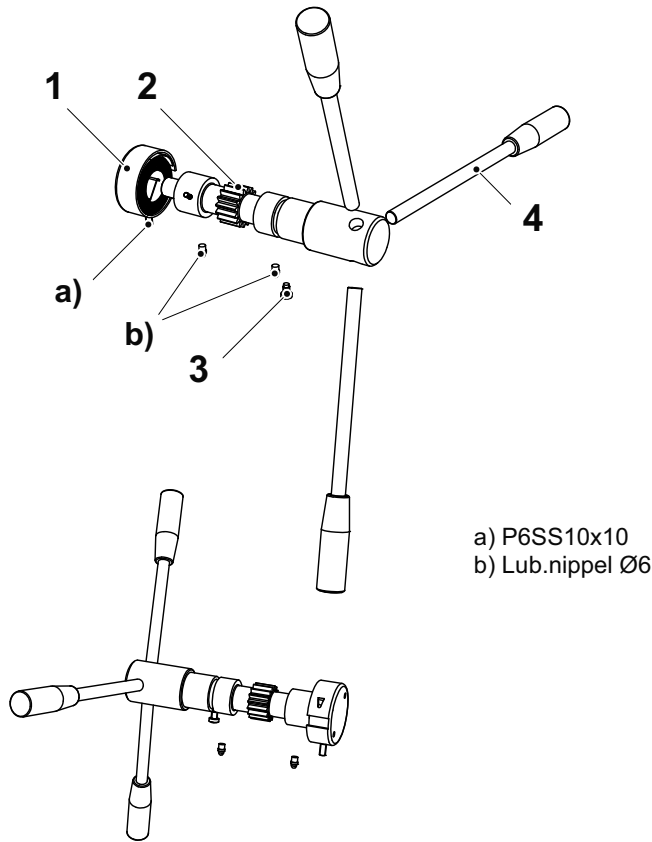
PARTS FOR SPINDLE SLEEVE



- a) MF6S5x20
- b) MC6S5x10 + FBB 5.1
- c) MC6LS5x10 + FBB 5.1
- d) SK6SS 6x8 (3x)
- e) MC6S6x20 Esloc

Ref. No.	Part Number	Description	Note
	2X08529R	Spindle sleeve compl.	
1	3M06005	Nut	KM5
2	3B07005	Locking washer	
3	3L15005	Ball bearing	6205
4	2G08529	Quill	
5	4I08754	Rack	
6	4B03769	Washer	
7	3L51006	Taper roll bearing	30206
8	2TS2019	Bearing cover	
9	2T08518	Key for spindle	
10	2A08517R	Spindle	MK3
11	3B06003	Washer	10,5x18x0,8
12	2T08593	Spacer	
13	4T08547	Drill ejector lever	
14	2A087561R	Depth gauge rod	
15	2T08759	Stop	Kompl. 2X08759R
16	4CSB140046	Spring	
17	4L08626	Indicator	
18	3R00003	Handle	43-M6x16
20	3P12308	Pin	FRP 5x20
21	2N08551R	Quill collar	

PARTS FOR FEED SHAFT

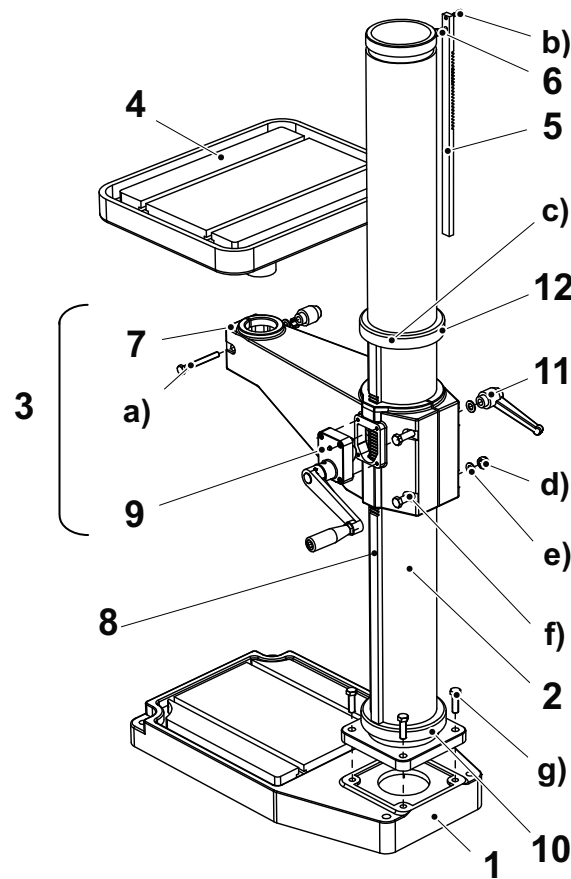


Ref. No.	Part Number	Description	Note
1	4XS2150R	Return spring	
2	2I08752	Feed shaft	
3	4S04211	Guide screw	
4	4E08758R	Feed lever	3x

ACCESSORIES

Part Number	Description	Notes
9612401	Milling vise	Not shown
964848401	Foot pedal	Not shown
964848201	Arbor, MT3/JT4	Not shown
964848301	Chuck w/key, 3/4", JT4	Not shown

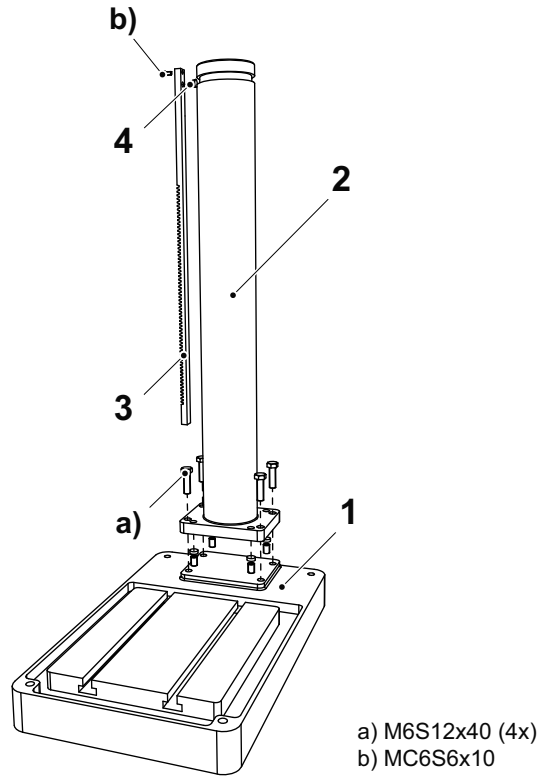
PARTS FOR COLUMN



- a) MC6S12x90
- b) MC6S6x10
- c) SK6SS6x12 (3x)
- d) Locknut M12
- e) BRB13x24x2 (3x)
- f) M6S12x130 (2x),
- g) M6S12x40 (4x)

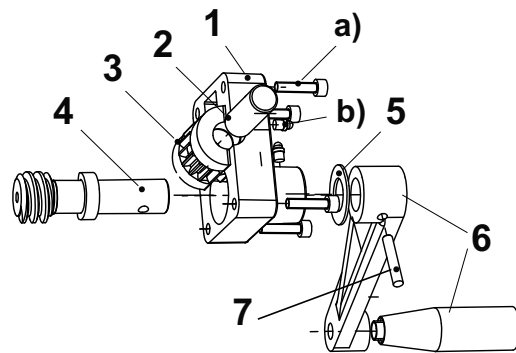
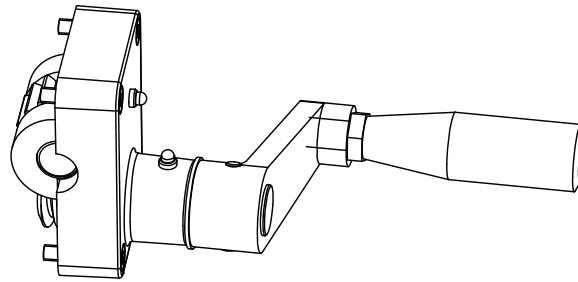
Ref. No.	Part Number	Description	Note
1	4W03040	Base plate	
2	9X08543	Column	
3	2X08730R	Table arm compl.	
4	2X07842R	Table compl.	500x400
5	2X08445	Rack	
6	2T07146	Pin	
7	2Y08730	Table arm	
8	4I03598	Rack table arm	
9	2X087201R	Worm gear compl.	
10	2N08568R	Lower ring	
11	3R000141	Lock handle	GN300S108-M12
12	2N08567R	Upper ring	

PARTS FOR COLUMN BENCH TYPE DRILL



Ref. No.	Part Number	Description	Note
1	4W03040	Base plate	
2	4X085431	Column	
3	2X08545	Rack	
4	2T07146	Pin	

PARTS FOR WORM GEAR BOX COMPLETE



a) MC6S6x25 (4x)
 b) Lub.nipple Ø6 (2x)

Ref. No.	Part Number	Description	Note
1	2N08720R	Worm gear box	
2	2A08725	Shaft	
3	4HS1201	Gear	
4	2IS12032	Worm shaft	
5	3L00027	Washer	AS 2035
	3L00025		AXK 2035
	3L00028		EPO 20 EMO
6	3R01182	Crank compl. with handle	
7	3P06035	Pin	

PALMGREN WARRANTY

C.H. Hanson / Palmgren warrants their products to be free of defects in material or workmanship. This warranty does not cover defects due directly or indirectly to misuse, abuse, normal wear and tear, failure to properly maintain the product, heated, ground or otherwise altered, or used for a purpose other than that for which is was intended.

The warranty does not cover expendable and/or wear part (i.e. v-belts, screws, abrasives, jaws), damage to tools arising from alteration, abuse or use other than their intended purpose, packing and freight. The duration of this warranty is expressly limited to the terms noted below beginning from the date of delivery to the original user.

The Palmgren branded items carry the following warranties on parts:

All vises, clamps, positioning tables, arbor presses, tombstones, jack screws and vise accessories - LIFETIME.

All bench grinders, drill presses, tapping machines, band saws, lathes, milling machines, abrasive finishing machines and work stands - 3 YEARS.

All non-wear parts for the Arboga drill presses - 5 YEARS.

The obligation of C.H. Hanson / Palmgren is limited solely to the repair or replacement, at our option, at its factory or authorized repair agent of any part that should prove inoperable. Purchaser must lubricate and maintain the product under normal operating conditions at all times. Prior to operation become familiar with product and the included materials, i.e. warnings, cautions and manuals.

Failure to follow these instructions will void the warranty.

This warranty is the purchaser's exclusive remedy against C.H. Hanson for any inoperable parts in its product. Under no circumstances is C.H. Hanson liable for any direct, indirect, incidental, special or consequential damages including loss of profits in any way elated to the use or inability to use our products. This warranty gives you specific legal rights which may vary from state to state.

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