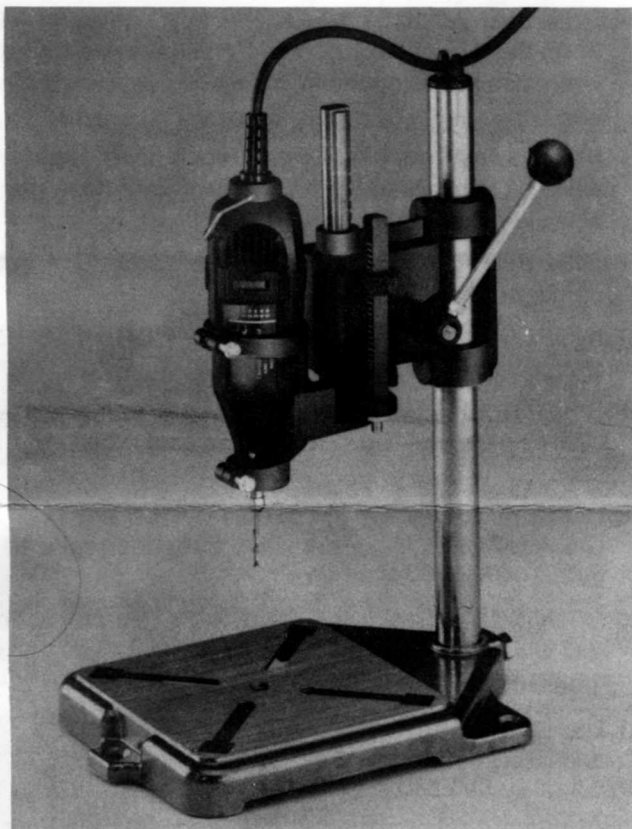


## MODEL 212

# DRILL PRESS STAND

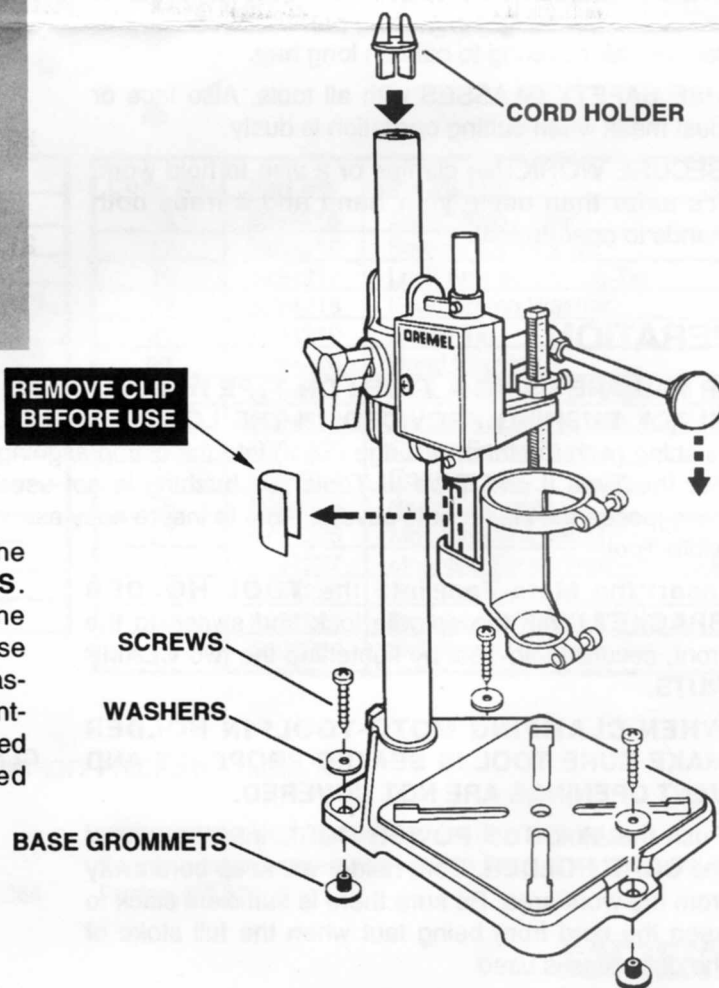
FOR USE WITH MODELS 275, 285 & 395 MOTO-TOOL®



### ATTENTION:

Read entire instruction manual carefully before using your Dremel Drill Press Stand. Retain instructions for future reference. Your Dremel Drill Press Stand will convert models 395, 285 and 275 Moto-Tools to a Drill Press for drilling accuracy. Moto-Tools can be assembled to or removed from the tool holder in seconds.

Metal clip around gear rack, between head housing and tool holder bracket is for packaging only.



### ASSEMBLY:

The Drill Press comes assembled except for the **CORD HOLDER** and **BASE GROMMETS**. Assemble cord holder into top of column and the three grommets into **MOUNTING HOLES** of base (as shown). **SCREWS** and **WASHERS** are for fastening the base to a workbench. Tighten the mounting screws until the three grommets are compressed a little. (The grommets should be compressed equally.)

# WARNING!

**READ ALL INSTRUCTIONS—FAILURE TO FOLLOW THE SAFETY RULES LISTED BELOW AND THE PRECAUTIONS GIVEN IN YOUR MOTO-TOOL® OWNER'S MANUAL MAY RESULT IN SERIOUS PERSONAL INJURY.**

1. **KNOW YOUR POWER TOOL**—Read Moto-Tool owner's manual carefully. Learn its applications and limitations as well as the specific potential hazards peculiar to this tool.
2. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
3. **AVOID DANGEROUS ENVIRONMENT.** Don't use power tool in damp or wet locations or expose to rain. Keep work area well lit.
4. **KEEP CHILDREN AWAY.** All visitors should be kept a safe distance from work area. Do not let visitors contact tool or extension cord.
5. **STORE IDLE TOOLS.** When not in use, remove Moto-Tool® from stationary fixture and store in secure place - out of the reach of children.
6. **DON'T FORCE TOOL.** It will do the job better and safer at the rate for which it was designed. Use recommended speed for drill accessory and work-piece material.
7. **USE RIGHT TOOL.** Don't force small tool or attachment to do the job of a heavy duty tool. Don't use tool for purpose not intended.
8. **WEAR PROPER APPAREL.** No loose clothing or jewelry to get caught in moving parts. Also, wear protective hair covering to contain long hair.
9. **USE SAFETY GLASSES** with all tools. Also face or dust mask when cutting operation is dusty.
10. **SECURE WORK.** Use clamps or a vise to hold work. It's safer than using your hand and it frees both hands to operate tool.
11. **DON'T OVERREACH.** Keep proper footing and balance at all times.
12. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp at all times, and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
13. **UNPLUG POWER CORD.** When not in use, before servicing, or when changing attachments, blades, bits, cutters, etc., unplug power cord.
14. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
15. **KEEP HANDS AWAY FROM DRILLING AREA.** Keep hands away from bits. Do not reach underneath work while bit is rotating. Do not attempt to remove material while bit is rotating.
16. **INSPECT TOOL CORDS PERIODICALLY** and if damaged, have them repaired.
17. **INSPECT EXTENSION CORDS PERIODICALLY** and replace if damaged.
18. **STAY ALERT.** Watch what you are doing and use common sense. Do not operate tool when you are tired.
19. **DO NOT USE TOOL IF SWITCH DOES NOT TURN IT ON AND OFF.** Have defective switches replaced by authorized service center.
20. **DRUGS, ALCOHOL, MEDICATION.** Do not operate tool while under the influence of drugs, alcohol or any medication.
21. Use only with Dremel Moto-Tool® models 275, 285 and 395.

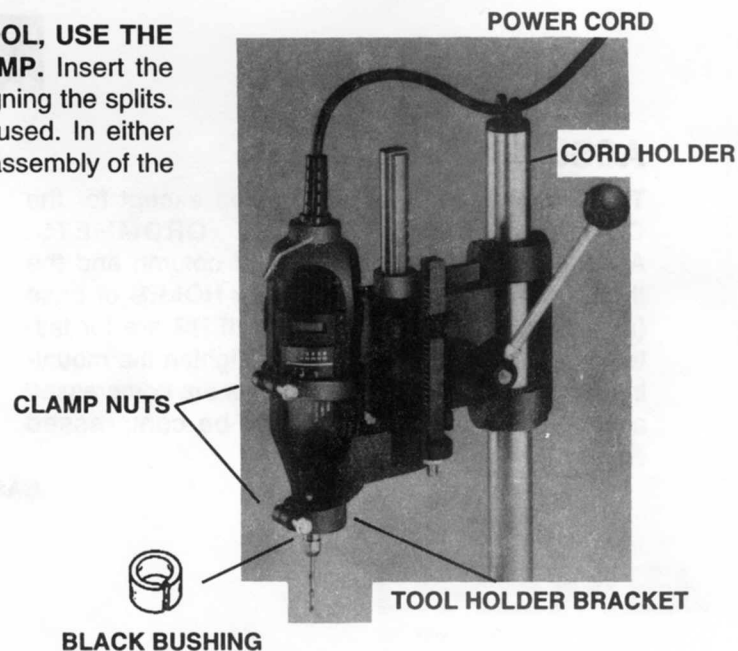
## OPERATION

**IF YOU ARE USING A TYPE I OR TYPE IV MOTO-TOOL, USE THE BLACK BUSHING PROVIDED, IN THE LOWER CLAMP.** Insert the bushing (with the internal ledge down) into the clamp aligning the splits. For the Type II and Type III Tools this bushing is not used. In either case loosen the clamp nuts several turns to insure easy assembly of the Moto-Tool.

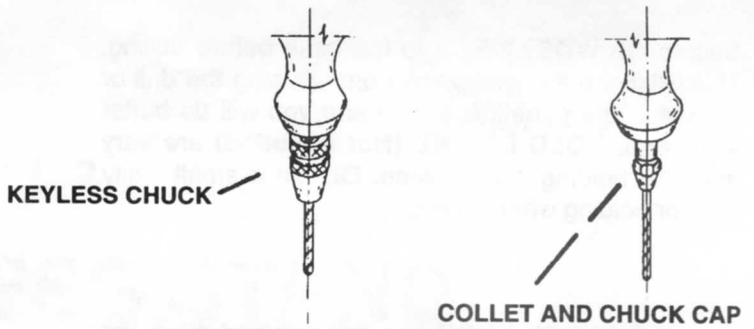
1. Insert the Moto-Tool into the **TOOL HOLDER BRACKET**. With the spindle lock and switch to the front, secure Moto-Tool by tightening the two **CLAMP NUTS**.

**WHEN CLAMPING MOTO-TOOL® IN HOLDER MAKE SURE TOOL IS SEATED PROPERLY AND VENT OPENINGS ARE NOT COVERED.**

2. Push the Moto-Tool **POWER CORD** into the vee of the **CORD HOLDER**. Cord holder will keep cord away from the work area. Be sure there is sufficient slack to keep the cord from being taut when the full stroke of the drill press is used.



3. Place the drill bit you will use in the chuck or collet and secure. (A minimum of 1/2" of the drill shank should be up in the collet.) Keyless chuck will hold drills up to 1/8" diameter. Chuck is more flexible on size than collets. Dremel collets are available in 1/32", 3/32" and 1/8" diameters.

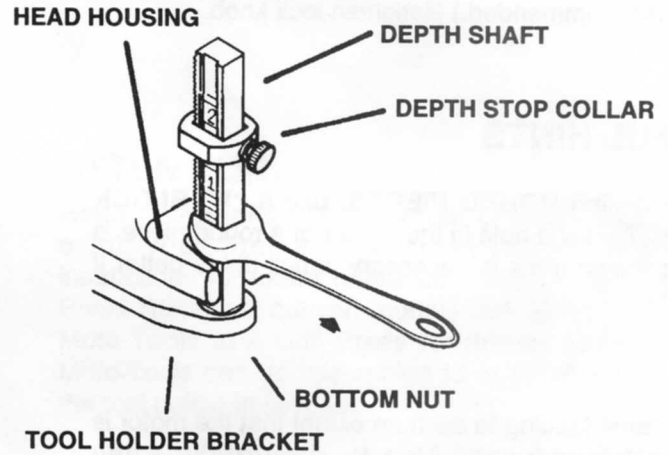


DRILL SIZE	RECOMMENDED DRILLING SPEED BY SWITCH (DIAL) SETTINGS					
	ALUM, WOOD, BRASS		MILD STEEL		VERY HARD MATERIALS	
	*1	*2	1	2	1	2
1/64 & #80 to #74	4	4-5	3	3-4	2	3
1/32 & #73 to #61	4	4-5	3	3-4	2	3
1/16 & #57 to #50	3-4	4	2-3	3	2	3
5/64 & #49 to #45	3-4	4	2-3	3	2	2-3
3/32 & #44 to #39	3	3-4	2-3	3	1-2	2-3
7/64 & #38 to #34	3	3-4	2-3	3	1-2	2-3
1/8 & #37 to #33	3	3-4	2	2-3	1-2	2-3

- \* 1 Switch setting on Model 395 Variable Speed Moto-Tool.
- \*\* 2 Dial setting on Cat. No. 219 Speed Control Attachment with Model 275 Single Speed Moto-Tool..

NOTE: If Model 285 2-speed Moto Tool is being used, all drilling applications should be performed at the low speed.

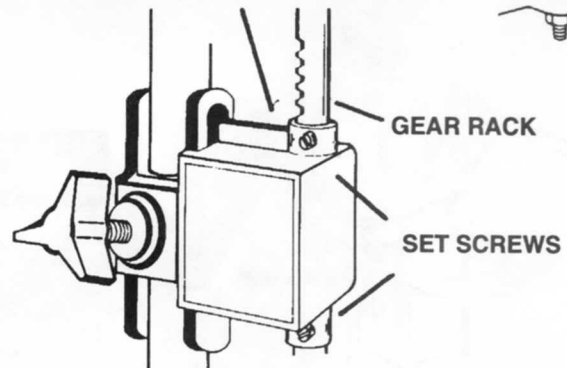
Remember, this chart is only to be used as a guide. The indicated settings are only approximate. The best option for determining speed is to experiment with a scrap piece of the material being used. Use a speed that works for you.



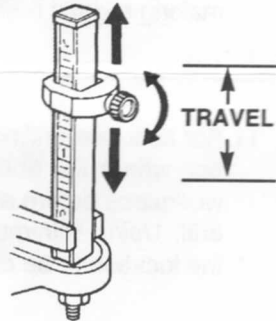
4. To eliminate side play in the **TOOL HOLDER BRACKET**, loosen the **BOTTOM NUT** on depth shaft. Turn depth shaft slightly (as shown) and retighten nut. All side play can be eliminated. Do not turn to the extent that you create excess friction between depth shaft and **HEAD HOUSING**.

Use the **DEPTH STOP COLLAR** when you wish to drill holes to a measured depth. A scale on the **DEPTH SHAFT** is provided for your convenience. Depth stop collar will insure that you can drill several holes to the same depth.

HEAD HOUSING



5. **SET SCREWS** are provided at top and bottom of the **HEAD HOUSING** for adjusting to a sliding feel of the **GEAR RACK**. Adjust them to the desired tension. If they are too tight, the return spring will not return the Moto-Tool to its up position. In this case, back them off **SLIGHTLY**. (1/16 of a turn will be .002)



6. Layout hole locations on the workpiece and **CENTER PUNCH** at these locations. Center punching will prevent walking of the drill point and insure proper hole location. The benefits of center punching are less drill breakage and better hole size tolerance.

