



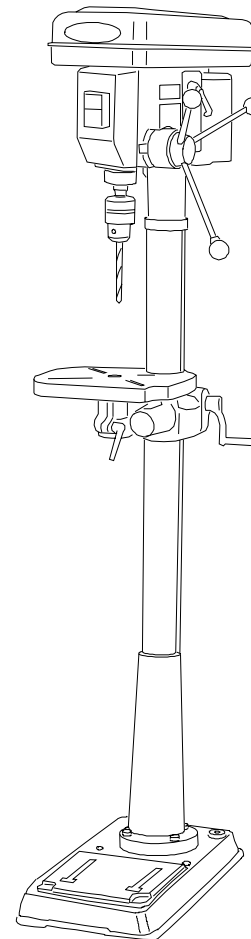
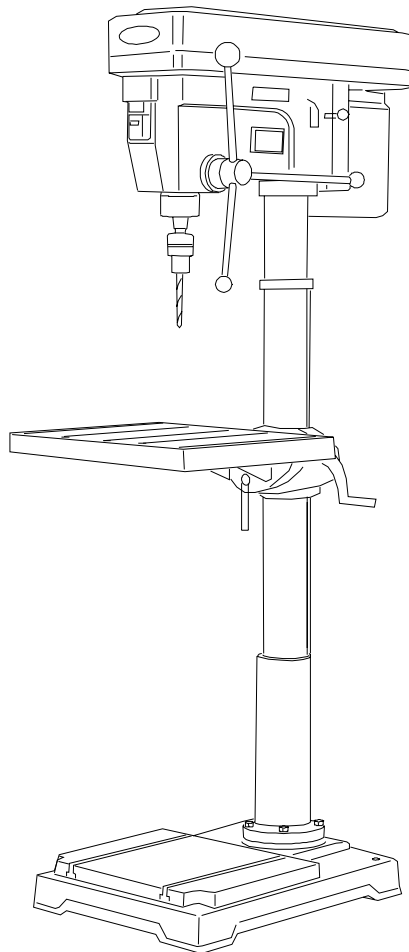
This Manual Is Bookmarked

Operating Instructions and Parts Manual

15-Inch and 20-Inch 12-Speed Drill Presses

Models: 2500 & 2530 (15-Inch) / Model 2550 (20-Inch)

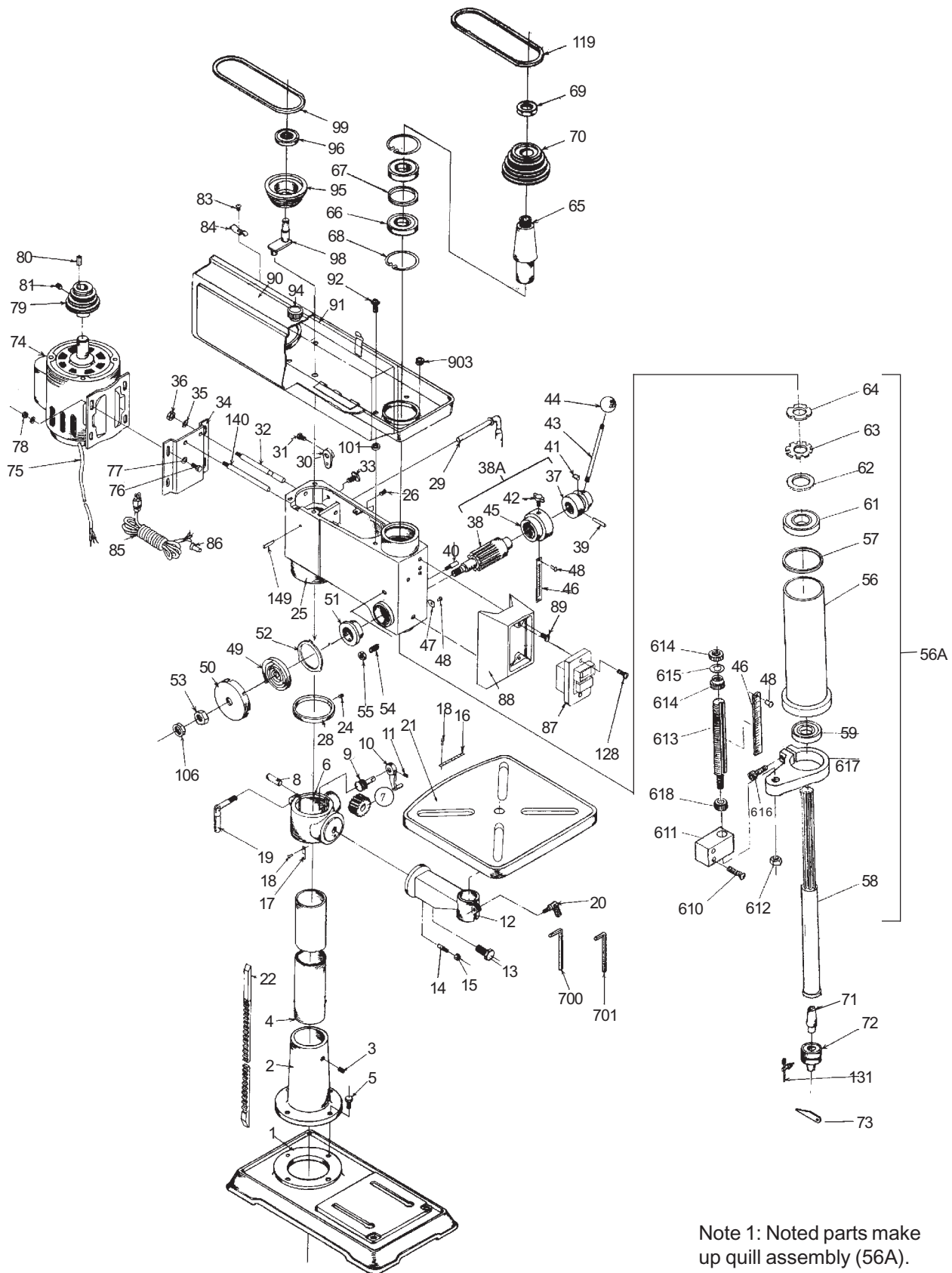
Manufactured after Serial no. 946001



WHM TOOL GROUP
2420 Vantage Drive
Elgin, Illinois 60123
Ph.: 800-274-6848
www.wmhtoolgroup.com

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Exploded View — 15-Inch Drill Presses — Models 2500/2530



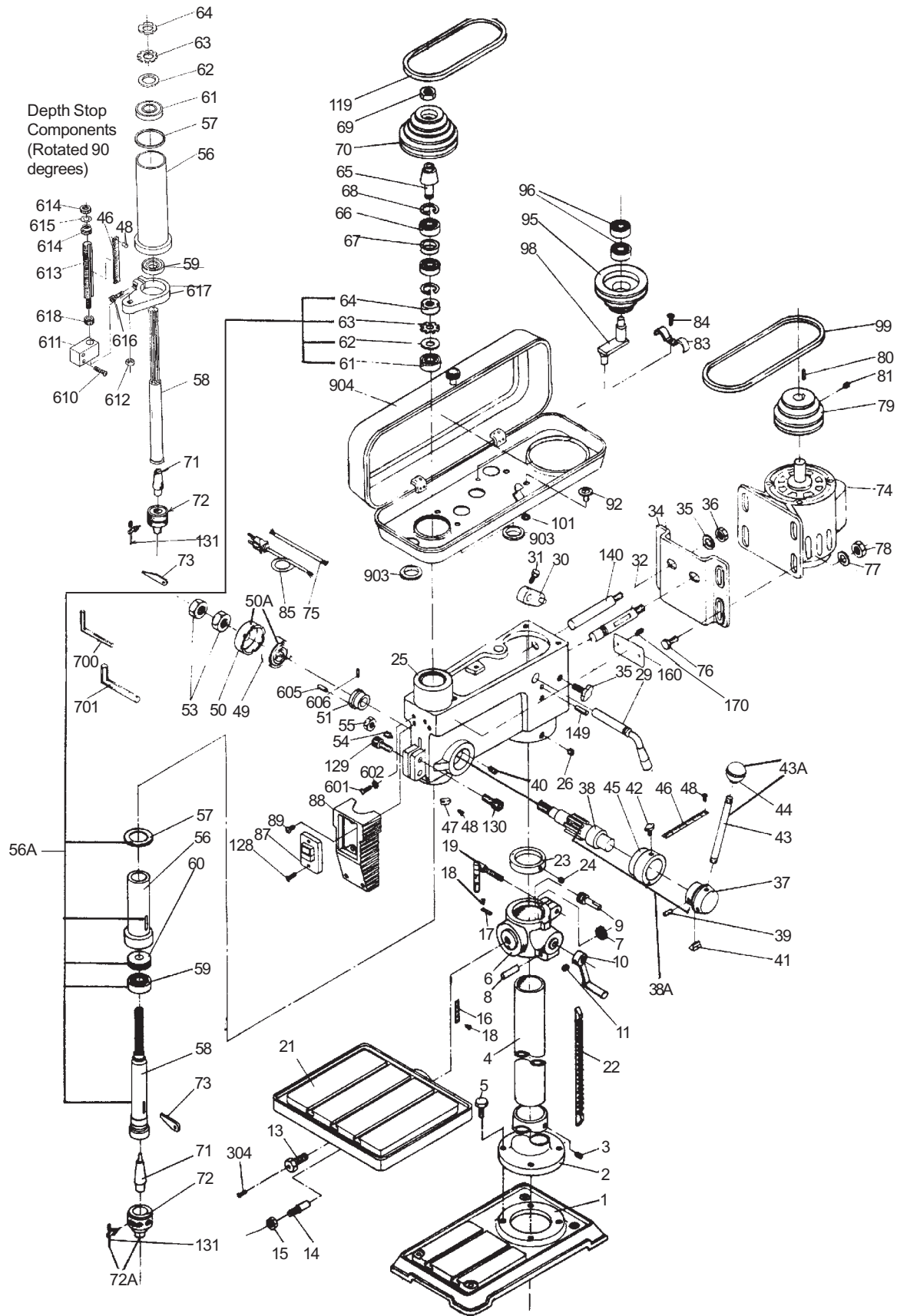
Note 1: Noted parts make up quill assembly (56A).

Parts Listing — 15-Inch Drill Presses — Models 2500/2530

Ref No.	Part Number	Description	Qty	Ref No.	Part Number	Description	Qty
1	5625011	Base, Floor Model (19-5/8 x 11-1/8)	1	56A	5626181	Quill Assembly	1
1A	5626131	Base, Bench Model (18 x 10-5/8 In.)	1	57	5625591	Washer, Rubber (Note 1)	1
2	5625021	Holder, Column (Floor Model)	1	58	5625611	Spindle, Shaft (Note 1)	1
2A		Holder, Column (Bench Model)	1	59	5625621	Bearing, Ball (6203ZZ) (Note 1)	1
3	5625031	Set Screw (Floor Model)	1	61	5635631	Bearing, Ball (6203Z) (Note 1)	1
4	5625041	Column, Floor Model (43-7/8 In.)	1	62	5625641	Washer (Note 1)	1
4A	5626141	Column, Bench Model (31 In.)	1	63	5625651	Ring, Locking (Note 1)	1
5	5625051	Screw, Hex Head (M10 x 35 mm)	4	64	5625661	Nut, Lock (Note 1)	1
6	5625061	Bracket, Table	1	65	5625671	Sleeve, Driving	1
7	5625071	Gear, Pinion	1	66	5625681	Bearing, Ball (6204Z)	2
8	5625081	Shaft, Gear	1	67	5625691	Collar	1
9	5625091	Worm, Pinion	1	68	5625711	Ring, Retaining	2
10	5625111	Handle, Crank	1	69	5625721	Nut, Pulley Lock	1
11	5625121	Screw, Hex Head (M6 x 10 mm)	1	70	5625731	Pulley, Spindle	1
12	5625131	Arm (for Bracket)	1	71	5625741	Arbor	1
13	5625141	Screw, Hex Head (5/8-11 x 1/4 In.)	1	72	5625751	Chuck (RJ33 – 13L)	1
14	5625151	Pin, Locator	1	73	5625761	Wedge	1
15	5625161	Nut, Hex (1/4-20)	1	74	5625771	Motor (115/230 Volt, 1/2-HP)	1
16	5625171	Scale, Angle	1	76	5625791	Screw, Hex Head (M8 x 20 mm)	4
17	5625181	Scale, Centering	1	77	5625811	Washer, Flat (5/16 In.)	4
18	5625191	Drive Screw (Ø2.3x 5 mm)	3	78	5625821	Nut, Hex (M8)	4
19	5625211	Handle, Column Lock	1	79	5625831	Pulley, Motor	1
20	5626191	Handle, Table Lock	1	80	5625841	Key	1
21	5625221	Table (10-1/4 x 10-1/4 Inches)	1	81	5625851	Screw, Set (M6 x 6 mm)	1
22	5625231	Rack (Floor Model) (31-3/4 In.)	1	83	5625861	Clamp	2
22A	5626151	Rack (Bench Model) (21-1/2 In.)	1	84	5625871	Screw, Pan Head (M5 x 10 mm)	2
23	5625241	Retainer, Rack	1	85	5629341	Cord, Power	1
24	5625251	Screw Set, Hex Socket (M6 x 10mm)	1	87	5625911	Switch, ON/OFF, Pushbutton	1
25	5625261	Head	1	88	5625921	Cover, Switch	1
26	5625271	Screw Set, Hex Socket (M10x12mm)	2	89	5625931	Screw, Pan Head (M5 x 16 mm)	2
29	5625281	Lever, Cam	1	90	5625941	Cover Assembly, Pulley	1
30	5625291	Cam	1	92	5625951	Screw, Round Head with Washer (M6 x 16 mm)	4
31	5625311	Screw, Hex Head (M8 x 16 mm)	1	94	5625961	Knob, Cover	1
32	5625321	Bar, Slide	1	95	5625971	Pulley, Center	1
33	5625331	Bolt, Slide Bar	2	96	5625981	Bearing, Ball (6202Z)	2
34	5625341	Base, Motor	1	98	5625991	Shaft, Center Pulley	1
35	5625351	Washer (Ø1/2)	2	99	5626011	V-Belt (M-23)	1
36	5625361	Nut, Hex (M12)	2	101	5626021	Washer, Flat (1/4Ø)	4
37	5625371	Hub	1	106	5626031	Nut, Hex (1/2-20)	1
38	5625381	Shaft, Feed Pinion	1	119	5626041	V-Belt (M-25)	1
38A	5626161	Shaft Assembly, Feed Pinion	1	128		Screw, Machine, (M4 x 25 mm)	2
39	5625391	Pin, Roll (ØM5 x 16 mm)	1	131	5626061	Key, Chuck	1
40	5625411	Pin, Roll (ØM6 x 20 mm)	1	140	5626071	Shaft, Motor Base	1
41	5625421	Wedge, Scale Locking	1	149	5626081	Pin, Roll	2
43	5625441	Handle	3	610	5513738	Screw	2
44	5625451	Grip	3	611	5513739	Block, Depth Stop	1
45	5625461	Housing, Spindle Depth	1	612	5513740	Nut	1
46	5625471	Scale	1	613	5513741	Rod, Depth Stop Adjustment (2500/2530 Only)	1
48	5625491	Screw, Drive (Ø2.5 x 5 mm)	3	614	5513742	Nut, Adjustment Lock	1
49	5625511	Spring, Coil	1	615	5513743	Washer	1
50	5625521	Cover, Spring	1	616	5513744	Screw, Clamping	1
50A	5626171	Cover Assembly, Spring	1	617	5513745	Clamp, Depth Stop Support	1
51	5625531	Seat, Spring	1	618	5513746	Nut	1
52	5625541	Retainer, Spring	1	700	5626091	Wrench, Allen (3 mm)	1
53	5625551	Nut, Hex (1/2-20)	2	701	5626111	Wrench, Allen (7 mm)	1
54	5625561	Screw, Set (M10 x 27mm)	1	903	5626121	Strain Relief, Wire	2
55	5625571	Nut, Hex (M10)	1				
56	5625581	Quill (Note 1)	1				

Note 1: Noted parts make up quill assembly (56A).

Exploded View — 20-Inch Drill Press — Model 2550



Parts Listing — 20-Inch Drill Press — Model 2550

Ref. No.	Part Number	Description	Qty
1	5627751	Base	1
2	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	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 In.)	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	5627861	Table (18-3/4 x 16-3/4 Inches)	1
22	5627871	Rack	1
23	5627881	Retainer, Rack	1
24	5627061	Screw Set, Hex Socket (M6 x 10mm)	1
25	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	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 (Note 1)	1
56A	5629121	Quill Assembly	1
57	5629131	Washer, Rubber (Note 1)	1
58	5629141	Spindle, MT3, Ø34) (Note 1)	1
59	5629151	Bearing, Ball (6206ZZ) (Note 1)	1
60	5629161	Bearing, Ball, Thrust 2906 Note	1

Ref. No.	Part Number	Description	Qty
61	5635271	Bearing, Ball (6204Z) (Note 1)	1
62	5629171	Washer (Note 1)	1
63	5629181	Lock, Washer (Note 1)	1
64	5629191	Lock, Nut (Note 1)	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	5629271	Motor	1
76	5629291	Screw, Hex Head (M8 x 25 mm)	4
77	5627511	Washer, Flat (5/16 In.)	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
85	5629341	Cord, Power	1
84	5626841	Screw, Pan Head (M5 x 8 mm)	2
87	5629351	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 m)	4
119	5637541	V-Belt (A-32)	1
128		Screw, Machine, (M4 x 25 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
616	5513744	Screw, Clamping	1
617	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	5629371	Cover Assembly, Pulley	1



WHM TOOL GROUP
2420 Vantage Drive
Elgin, Illinois 60123
Ph.: 800-274-6848
www.wmhtoolgroup.com