



IFL Training Shift 04-1: Drill Press

Basic run through of the training for the drill press and the mill in the shop

Written By: Dakshay Vishal Mehta



Step 1 — IFL Daily Responsibilities



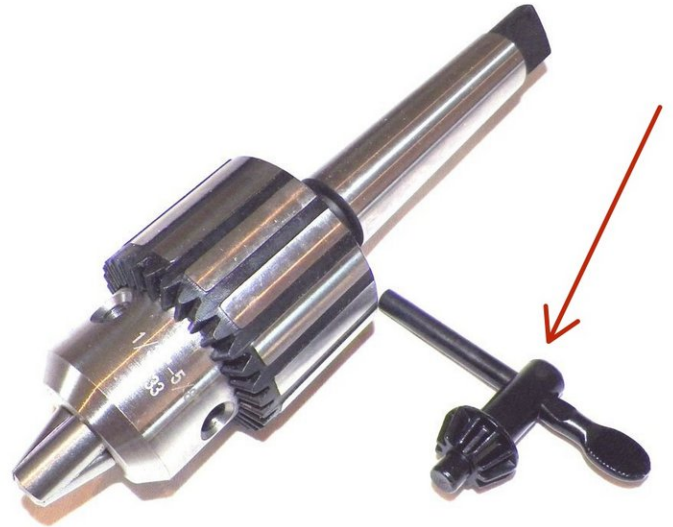
- Make sure to complete the LM Daily Responsibilities upon entering/using/leaving the space.
- [IFL LM Daily Responsibilities](#)

Step 2 — Getting started



- Make sure the trainee is wearing a closed-toed shoe and also has safety glasses on.
- Run through the daily checklist
- Review the previous shift (Bandsaw)
- Show them where the drill press is located in the lab (Image 1)

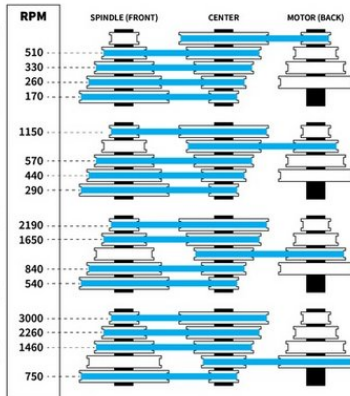
Step 3 — General Information on the drill press



- On/off switch (as shown in the pic)
- Explain what the chuck is, and what it does(as shown in pic 2)
- Explain the basic components on the machine, and also explain the emergency stop, and where it is located

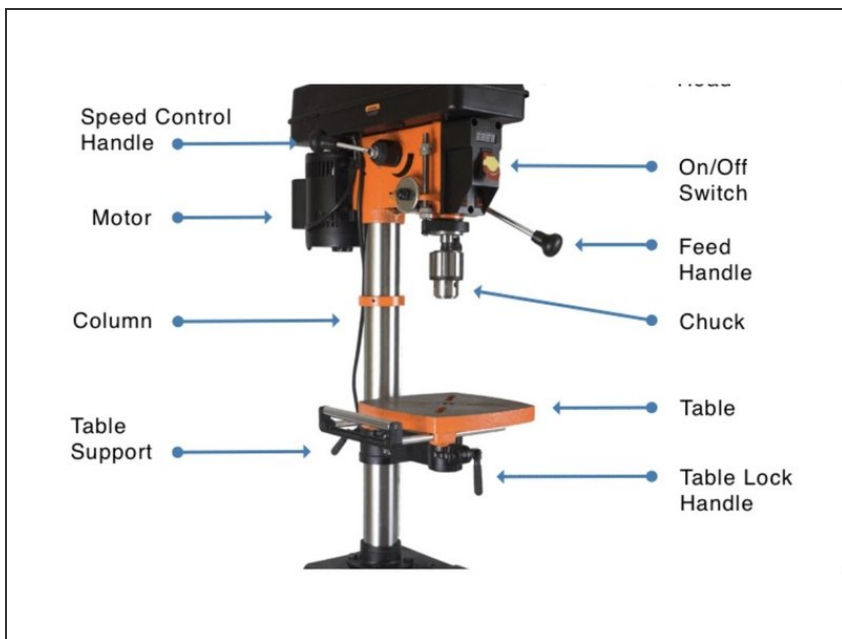
Step 4 — Allowed Materials

Accessory	Softwood	Hardwood	Acrylic	Brass	Aluminum	Steel
Twist Drill Bits						
1/16" - 3/16" (1.6 - 4.8 mm)	3000	3000	2260	3000	3000	3000
1/4" - 3/8" (6.4 - 9.5 mm)	3000	1460	2190	1150	2260	1150
7/16" - 5/8" (11.1 - 15.9 mm)	1460	840	1460	840	1460	540
11/16" - 1" (17.5 - 25.4 mm)	840	510	NR	440	1150	330
Brad-Point Bits						
1/8" (3.2 mm)	1650	1150	1460	NR	NR	NR
1/4" (6.4 mm)	1650	1150	1460	NR	NR	NR
3/8" (9.5 mm)	1650	840	1460	NR	NR	NR
1/2" (12.7 mm)	1650	840	1150	NR	NR	NR
5/8" (15.9 mm)	1650	540	840	NR	NR	NR
3/4" (19.1 mm)	1460	260	840	NR	NR	NR
7/8" (22.2 mm)	1150	260	540	NR	NR	NR
1" (25.4 mm)	1150	260	260	NR	NR	NR
Forstner Bits						
1/4" - 3/8" (6.4 - 9.5 mm)	2260	750	NR	NR	NR	NR
1/2" - 5/8" (12.7 - 15.9 mm)	2260	540	260	NR	NR	NR
3/4" - 1" (19.1 - 25.4 mm)	1460	540	260	NR	NR	NR
1 1/8" - 1 1/4" (28.6 - 31.8 mm)	1150	260	260	NR	NR	NR
1 3/8" - 2" (34.9 - 50.8 mm)	540	260	NR	NR	NR	NR
Hole Saws						
1" - 1 1/2" (25.4 - 38.1 mm)	540	330	NR	260	260	NR
1 5/8" - 2" (41.3 - 50.8 mm)	540	260	NR	170	260	NR
2 1/8" - 2 1/2" (54 - 63.5 mm)	260-540	NR	NR	170	260	NR
Spade Bits						
1/4" - 1/2" (6.4 - 12.7 mm)	2190	1460	NR	NR	NR	NR
5/8" - 1" (15.9 - 25.4 mm)	1650	1460	NR	NR	NR	NR
1 1/8" - 1 1/2" (28.6 - 38.1 mm)	1460	1150	NR	NR	NR	NR



- No flexible materials are allowed
- Explain the different RPM's for each material (as shown in the pic)
- Show them the location of the different drill bits in the shop

Step 5 — Using the drill press



- Demonstrate how to secure/remove drill bit from chuck using the key
- Demonstrate how to hold stock in place (clamps/vise)
- Demonstrate how to move platform up and down
- Demonstrate how to change RPM