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Bill Krier  
Editor  
WOOD® magazine

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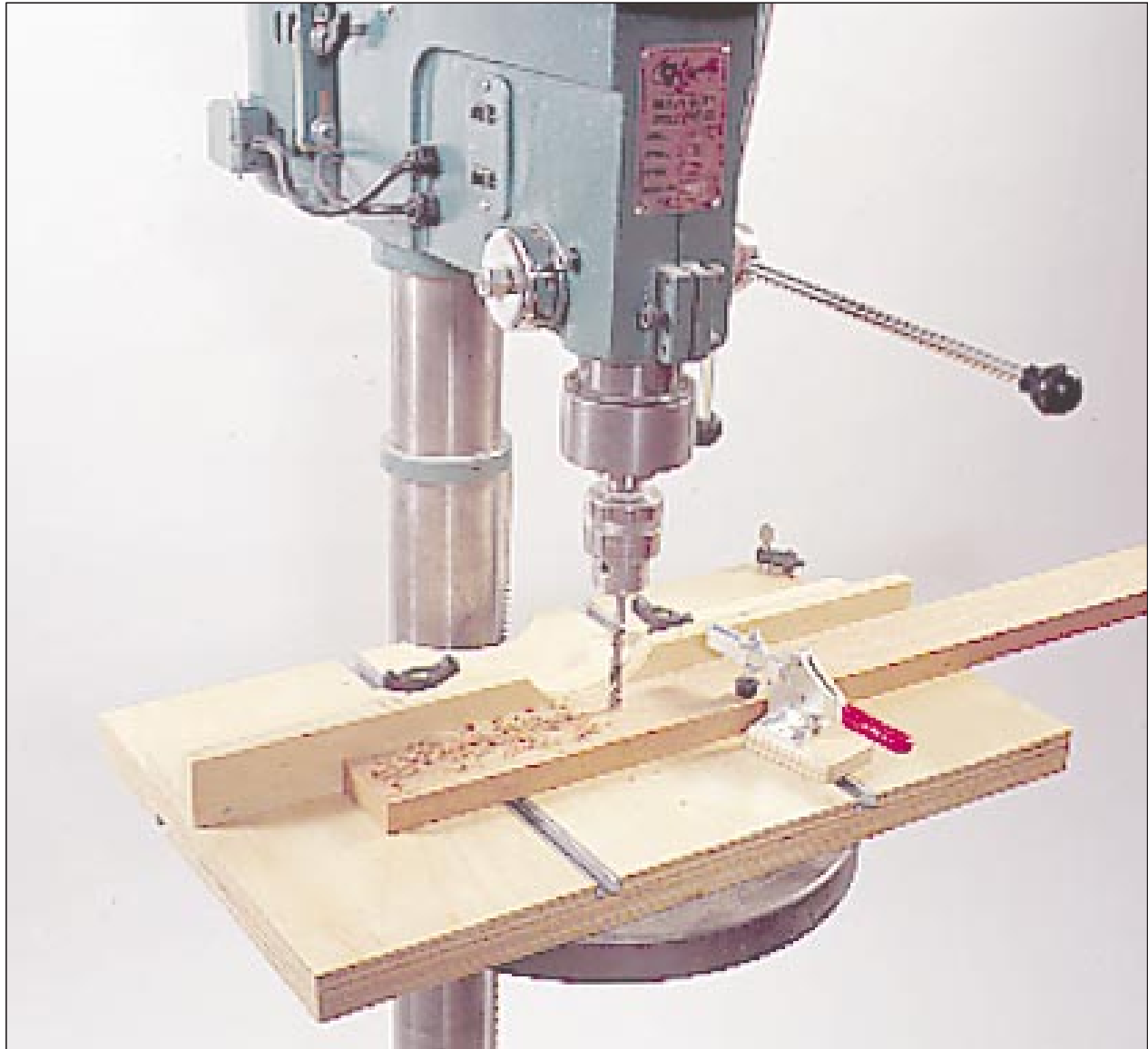
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*An Add-On for Accuracy*

## DRILL-PRESS TABLE



Quality workmanship depends in large part on the accuracy of your tools. With this in mind, we set out to make your already hardworking drill press into the ultimate precision-machining center. This setup will allow you to perform numerous machining processes with impressive precision.

## Start with the horizontal table pieces

**1** Cut the horizontal table (A) to the size listed in the Bill of Materials. (Due to its stability and strength, we used 3/4" Baltic birch plywood as sourced in the Buying Guide.)

**2** Cut the horizontal tabletops (B, C) to size. (After using the drill-press table awhile, the center piece will get several holes drilled into it. For ease in replacing the tabletop center C, we constructed the tabletop out of three pieces rather than one.)

**3** Using a hacksaw, crosscut three pieces of metal mini channel to the lengths listed on the Exploded View drawing. (We used B-Line Systems B72 mini channel. See the Buying Guide for our source.) Drill countersunk mounting holes at 4" intervals through the mini channel for screwing to the plywood tables later.

**4** Mark the location of the groove on the bottom surface of the horizontal table (A). Position the table on the top of your metal drill-press table. Looking through the slots on your drill-press table, verify that the marked groove crosses at least two of the grooves in your metal table. If not, adjust the position of the groove.

**5** Using a dado blade in your tablesaw, cut a 13/16" dado and rabbets (wide enough to house the mini channel just cut) in parts A and B, where dimensioned on the Exploded View and Front View drawings.

**6** Position and clamp the tabletops (B, C) onto the horizontal table (A) where shown on the Exploded View drawing. Drill countersunk holes through the bottom side of A to secure B and C in place. Remove the clamps, and glue and screw both Bs in place. Then, just screw (no glue) part C in place.

**7** Cut a 2 1/2" radius centered on the back edge of A/C.

**8** Screw the three pieces of mini channel in place.

## Build the fence for precision alignment

**1** Cut the horizontal fence pieces (D, E) to size. Mark a 2 1/2" radius on each where shown on the Horizontal Fence drawing, and bandsaw and drumsand the radii to shape. The radius centered on E allows the drill-press chuck to come closer to the workpiece, which is especially helpful when using a small bit in the chuck. The radius in the fence base (D) allows the fence to be moved closer to the drill-press column when drilling into wide stock.

**2** Mark a pair of hole centerpoints on the fence base (D). Before drilling the holes, verify that the marked points are centered over the dadoes opening in the tabletop. Improperly located, the carriage bolts will bind in the mini channel. Adjust if necessary, and drill the 3/8" holes.

**3** Drill the countersunk mounting holes, and screw part E to D, checking for square.

**4** To mount the fence to the table, start by grinding two opposing edges of four 3/8" carriage bolts until the bolt heads slide easily in the metal mini channel. See the Carriage Bolt details accompanying the Front View drawing for reference. Then, insert the bolts through the fence piece D through flat washers and into the plastic wing nuts (knobs). The fence should slide back and forth in the table easily, but without slop.

## The hold-downs come next

**1** Cut the clamp hold-down base (F) to size from 5/8" stock. (We resawed some of the 3/4" plywood we used for the other pieces.) For holding 3/4"-thick stock later, the base must be less than 3/4" thick. Cut or sand a 1/4" radius on each corner of F.

**2** Drill a 1/2" hole 5/16" deep in the top of the hold-down base. Now, drill a 5/16" hole, centered through the middle of the counterbore.

**3** Insert a 5/16" carriage bolt into the bottom surface of the hold-down base. (For ease in using the hold-down clamp, we found that the hold-down base must swivel on the tops of the tables. To do this, we had to use a 5/16" carriage bolt instead of the 3/8" bolts used on the fences.)

**4** Grind the threaded end of the four #12x5/8" panhead sheet-metal screws until the threaded end is 1/2" long. Then, drill pilot holes, and secure the hold-down clamp to F with the four screws.

Bill of Materials					
Part	Finished Size*			Mati.	Qty.
	T	W	L		
TABLE ASSEMBLY					
A horizontal table	3/4"	15"	24 3/4"	BP	1
B tabletop sides	3/4"	8 1/2"	15"	BP	2
C tabletop center	3/4"	7 3/4"	15"	BP	1
FENCE AND HOLD-DOWN					
D horizontal fence base	3/4"	3"	24 3/4"	BP	1
E horizontal table fence	3/4"	2"	24 3/4"	BP	1
F hold-down base	5/8"	2 1/4"	3 1/4"	BP	1

**Material Key:** BP—Baltic birch plywood

**Supplies:** #6x5/8", #8x1 1/4", #8x1 1/2" flathead wood screws; 4-3/8x1 1/2" and 1-5/16x1" carriage bolts; 1-5/16" locknut; 4-5/16" flat washers; 2-5/16" plastic wing nut; 2-3/8" oval-tapered knob; 2-2"-reach hold-down clamp; 1-3/8x1 3/16x24 3/4" mini channel (available at most electrical supply outlets); 2-3/8x1 3/16x15" mini channel; 4-#12x5/8" panhead sheet-metal screws; clear finish.

**Buying Guide**  
**Hardware kit.** Three pieces of 3/8x1 3/16" mini channel cut to length; one 2"-reach hold-down (toggle) clamp; two plastic wing nuts (knobs), two 3/8"-long oval-tapered knobs, four 3/8" carriage bolts 1 1/2" long, and one 5/16" carriage bolt 1" long, plus the screws, washers, and locknuts listed above. WOOD KIT SDPT1, \$42.95 plus \$3.75 shipping. Schlabaugh and Sons Woodworking, 720 14th Street, Kalona, IA 52247 or call 800/346-9663 to order. (Contact via e-mail: schsons@kctc.net)

**Easy-to-assemble kit.** All the pieces listed in the hardware kit above, plus all the Baltic birch plywood pieces listed in the Bill of Materials cut to size and shape with predrilled holes. WOOD KIT SDPT2, \$99.95 plus shipping (call for shipping charges). Schlabaugh and Sons Woodworking, address and phone number above.

### Here's how to secure the assembly to your drill press

**1** Sand all the parts. Mask off the metal mini channel and apply a clear finish to the wood parts (we used an aerosol lacquer).

**2** Secure the wooden drill-press table to the metal table with a pair of  $\frac{3}{8}$ " carriage bolts (with the edges of the head ground as previously explained and shown on the Carriage Bolt details), flat washers, and tapered knobs. (We found the long tapered knobs easy to grab and the table easier to relocate when needed.) Slide the fence with knobs attached onto their mating mini channel. The slot configuration on drill-press tables varies from model to model. If your drill press has a round table with

radial slots (X shaped), you'll need to put the positioning bolts and mating tapered knobs in the back two slots in your metal table. To achieve infinite positioning of the wooden table you can do three things: (1) rotate the metal table in the drill-press support arm, (2) rotate the support arm, (3) rotate the drill-press head. Caution: Before rotating the drill-press head, make sure the drill press is securely bolted down. Rotating the head changes the weight distribution, and can cause the drill press to tip over.♣

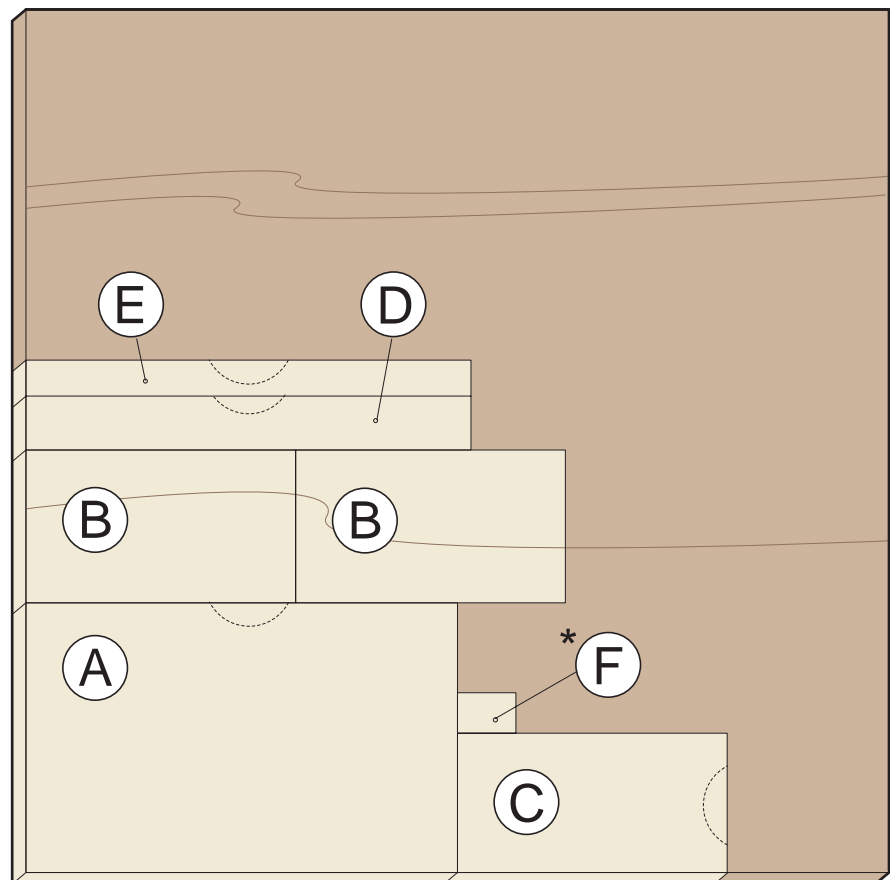
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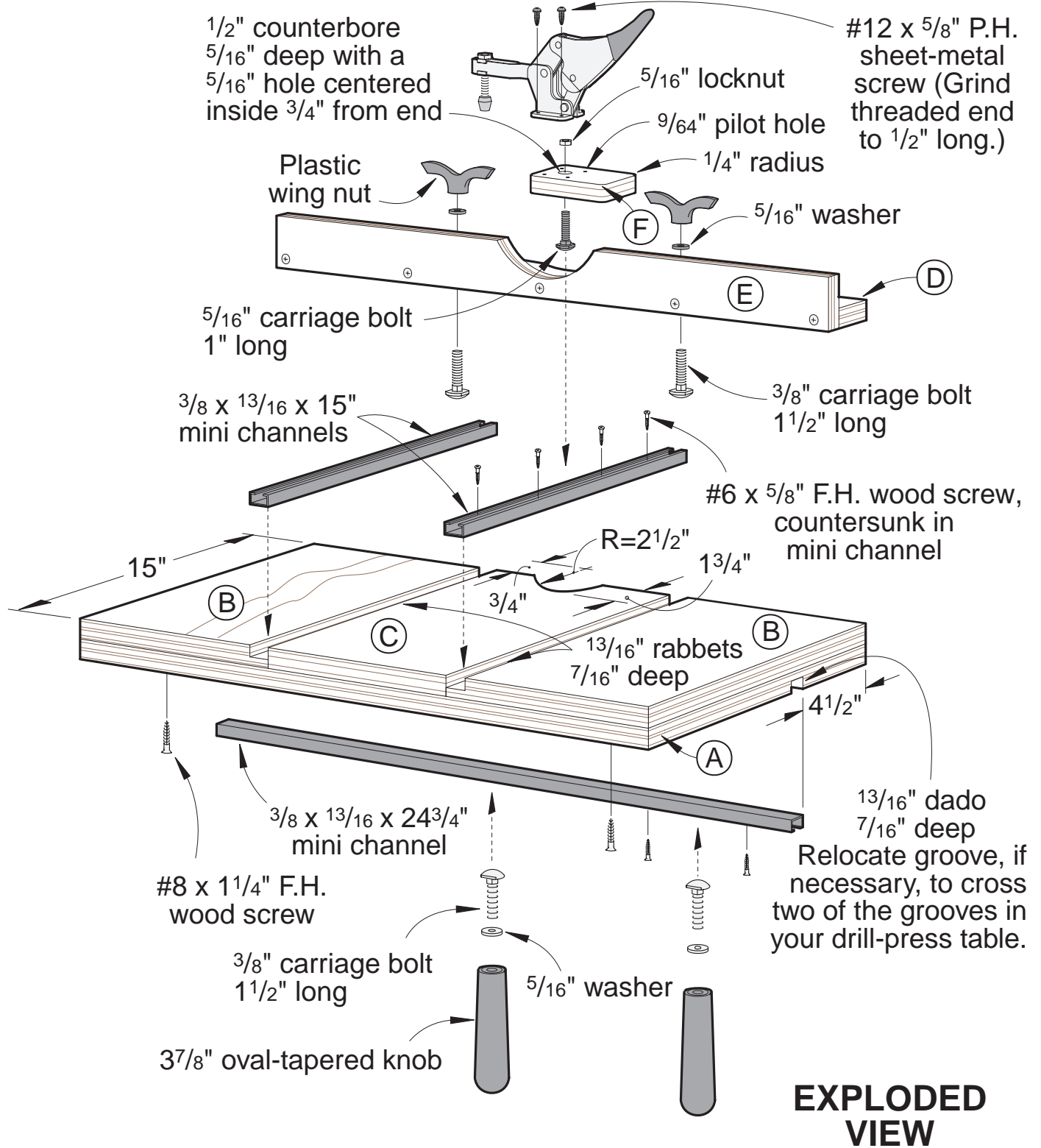
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## CUTTING DIAGRAM

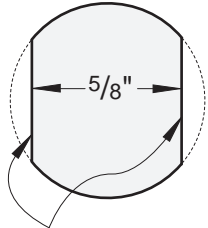
\*Plane or resaw to thickness listed in the Bill of Materials.



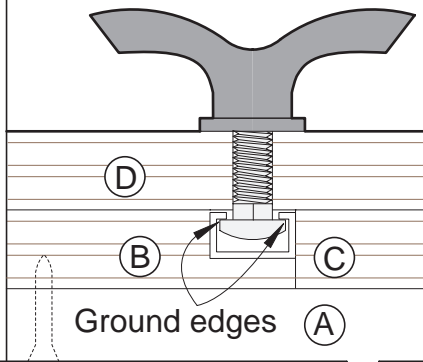
$\frac{3}{4}$  x 48 x 48" Birch plywood



## CARRIAGE BOLT DETAILS

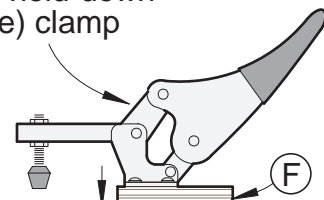


Grind edges of all  $\frac{3}{8}$ " carriage-bolt heads to fit mini channel.

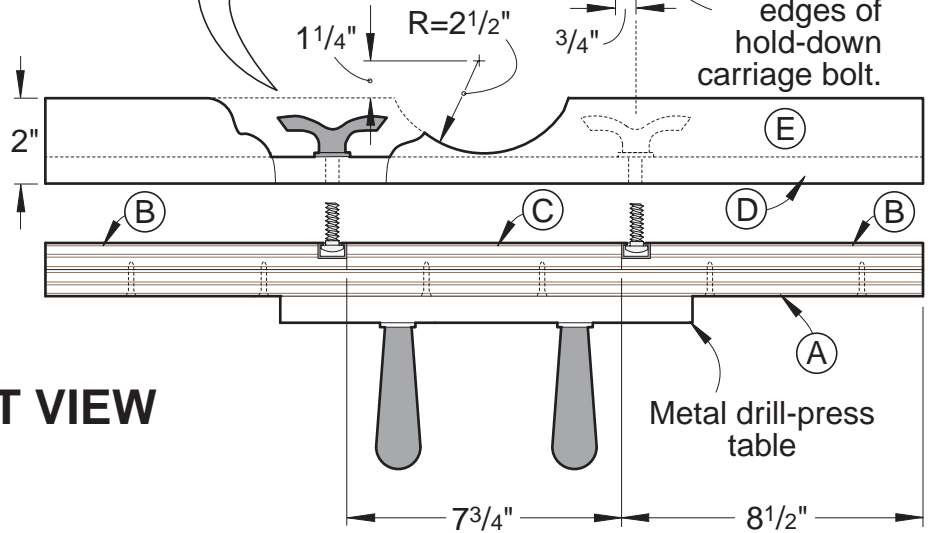


Ground edges (A)

2"-reach hold-down (toggle) clamp



Do not grind edges of hold-down carriage bolt.



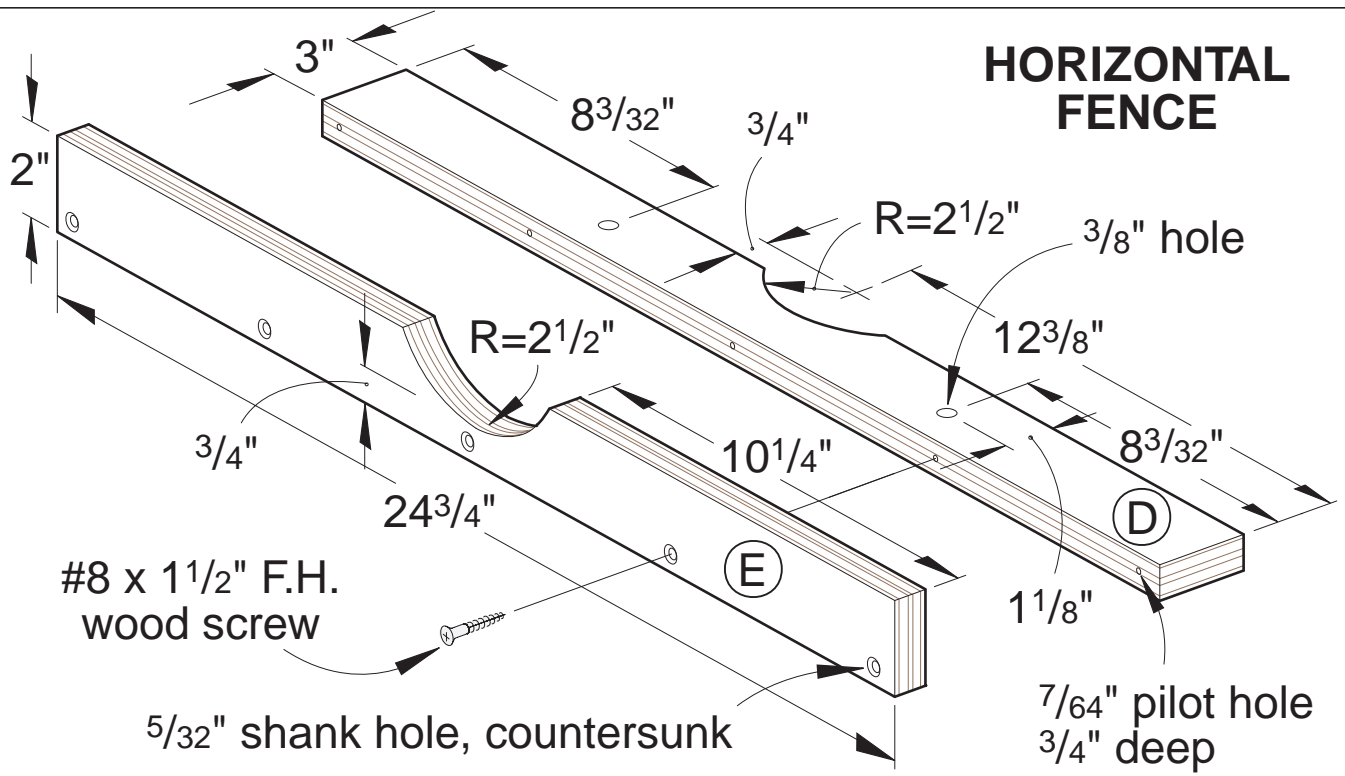
FRONT VIEW

Metal drill-press table

$7\frac{3}{4}$ "

$8\frac{1}{2}$ "

## HORIZONTAL FENCE

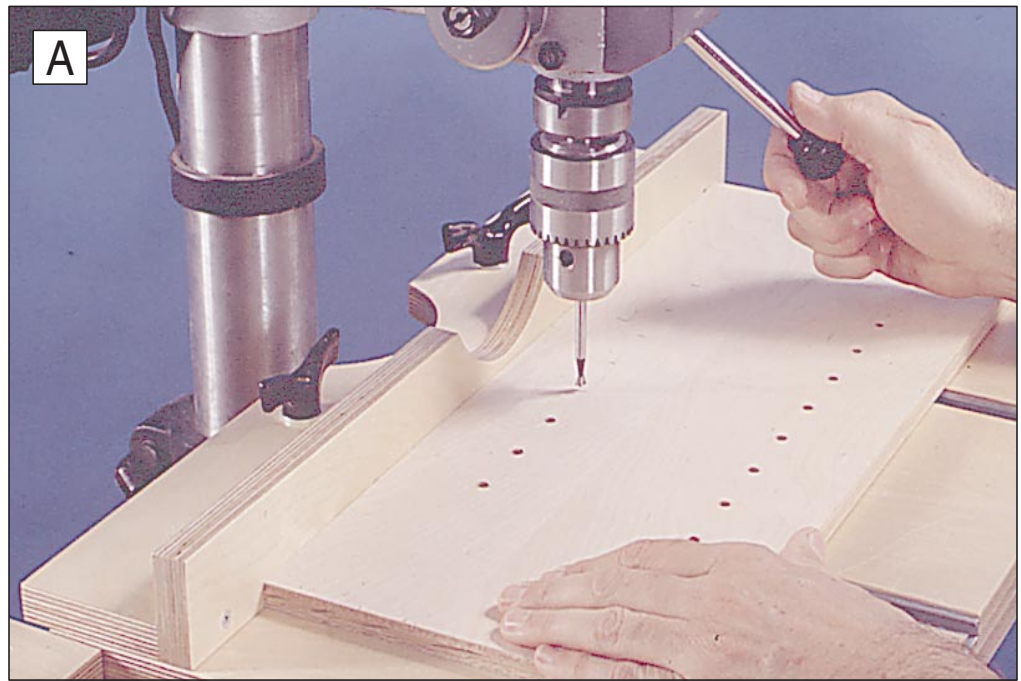


#8 x  $1\frac{1}{2}$ " F.H. wood screw

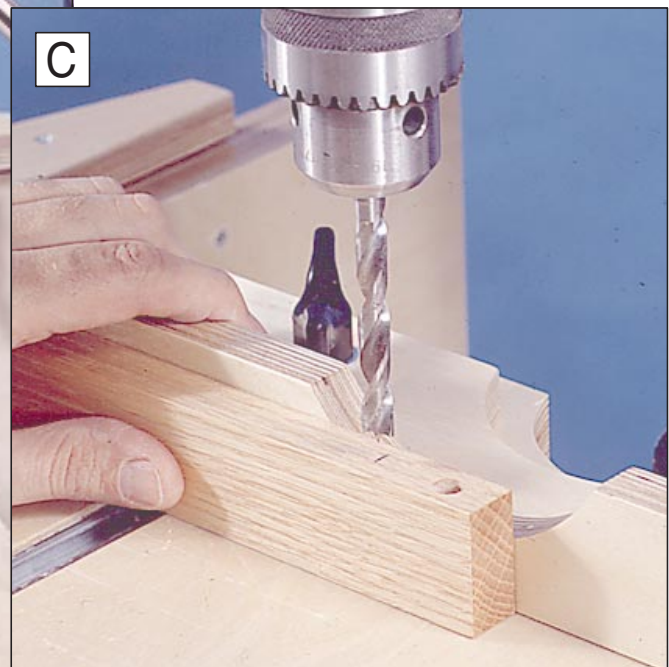
$\frac{5}{32}$ " shank hole, countersunk

$\frac{7}{64}$ " pilot hole  $\frac{3}{4}$ " deep

▷ Drilling numerous holes all in a straight line is easy using the horizontal table and fence. For instance, if you need holes exactly 2" from the edge of a piece of stock, position the inside edge of the fence exactly 2" from the center of the bit. Now, just move the stock along the fence and all the holes will be drilled exactly 2" from the edge of the stock as shown in *Photo A*.



▽ Making round-cornered mortises and the mating tenons is easy to accomplish using our fence system. As shown in *Photo B*, drill a hole with a Forstner bit to form the mortise.



△ You can use this same setup for drilling holes in the edge of a piece of stock as shown in *Photo C*. This setup is especially useful for drilling dowel holes in the edge of stiles.

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