



Operating Instructions and Parts Manual Drill Press

Models: J-2500, J-2530, J-2550



J-2530



J-2500



J-2550

JET
427 New Sanford Road
LaVergne, Tennessee 37086
Ph.: 800-274-6848
www.jettools.com

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Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

Product Listing with Warranty Period

| |
|--|
| 90 Days – Parts; Consumable items |
| 1 Year – Motors; Machine Accessories |
| 2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes |
| 5 Year – Woodworking Machinery |
| Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools |

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

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The specifications in this manual are given as general information and are not binding. JET reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.



Warnings

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This drill press is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a drill press, do not use until proper training and knowledge have been obtained.
5. Do not use this drill press for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this drill press. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this drill press, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead based paint.
 - Crystalline silica from bricks, cement and other masonry products.
 - Arsenic and chromium from chemically treated lumber.Your risk of exposure 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, such as face or dust masks that are specifically designed to filter out microscopic particles.
10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
16. Make sure the drill press is firmly secured to the floor or bench before use.
17. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
18. Provide for adequate space surrounding work area and non-glare, overhead lighting.
19. Keep the floor around the machine clean and free of scrap material, oil and grease.
20. Keep visitors a safe distance from the work area. **Keep children away.**
21. Make your workshop child proof with padlocks, master switches or by removing starter keys.



Warnings

22. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
23. Maintain a balanced stance at all times so that you do not fall or lean against the spindle or other moving parts. Do not overreach or use excessive force to perform any machine operation.
24. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
25. Use recommended accessories; improper accessories may be hazardous.
26. Maintain tools with care. Keep drill bits sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
27. Make sure the work piece is securely attached or clamped to the table. Never use your hand to hold the work piece.
28. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
29. Do not stand on the machine. Serious injury could occur if the machine tips over.
30. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
31. Remove loose items and unnecessary work pieces from the area before starting the machine.

Familiarize yourself with the following safety notices used in this manual:

CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

WARNING This means that if precautions are not heeded, it may result in serious injury or possibly even death.

- - SAVE THESE INSTRUCTIONS - -

Introduction

The JET 15-Inch 16-Speed Drill Presses and 20-Inch 12-Speed Drill Presses, Models J-2500, J-2530 and J-2550, feature rugged cast iron design with ground-steel columns for drilling accuracy in metal, wood, and plastic. The head casting features a ball bearing spindle assembly, supported by four permanently-lubricated, heavy duty ball bearings that are mounted in an enclosed quill for extended life.

Specifications

| Model | J-2500 | J-2530 | J-2550 |
|--------------------------------|--|--|--|
| Stock Number | 354400 | 354401 | 354402 |
| Model Type | 15-Inch Floor | 15-Inch Bench | 20-Inch Floor |
| Drilling Capacity | | | |
| Cast Iron | Up to 5/8 In. | Up to 5/8 In. | Up to 3/4 In. |
| Steel | Up to 1/2 In. | Up to 1/2 In. | Up to 5/8 In. |
| Drill to Center | 15 Inches | 15 Inches | 20 Inches |
| Motor | | | |
| Rating | 3/4 hp, 1-Phase | 3/4 hp, 1-Phase | 1 hp, 1-Phase |
| RPM | 1725 | 1725 | 1725 |
| Full Load Amperage | 9.0/4.5 | 9.0/4.5 | 14/7 |
| Voltage | 115/230V (prewired 115V) | 115/230V (prewired 115V) | 115/230V (prewired 115V) |
| Column Diameter | 2-7/8 In. | 2-7/8 In. | 3-5/8 In. |
| Quill | | | |
| Diameter | 1-7/8 In. | 1-7/8 In. | 2-1/4 In. |
| Travel | 3-1/8 In. | 3-1/8 In. | 4-3/4 In. |
| Table | | | |
| Overall | 11-1/2 x 11-1/2 In. | 11-1/2 x 11-1/2 In. | 18-1/2 x 16-1/2 In. |
| Working Surface | 9-1/2 x 9-1/2 In. | 9-1/2 x 9-1/2 In. | 15-1/2 x 13-1/2 In. |
| Travel | 24 In. | 15-1/2 In. | 21-1/2 In. |
| Base | | | |
| Size | 11 x 19-1/2 In. | 10-1/2 x 18 In. | 22-3/4 x 17-3/4 In. |
| Working Surface | 7 x 7-1/2 In. | 8 x 8 In. | 13 x 14-1/2 In. |
| Chuck Size | 5/8-In., Key Chuck | 5/8-In., Key Chuck | 5/8-In., Key Chuck |
| Overall Dimensions | | | |
| Length | 31 In. | 31 In. | 33-1/2 In. |
| Width | 13 In. | 13 In. | 18-1/2 In. |
| Height | 63 In. | 39-1/2 In. | 67 In. |
| Spindle to Table (Max.) | 24 In. | 15-1/2 In. | 24 In. |
| Spindle to Column (Max.) | 7-1/2 In. | 7-1/2 In. | 10-1/2 In. |
| Spindle | | | |
| To Base | 48 | 24 | 43-1/2 |
| Taper | MT-2 | MT-2 | MT-3 |
| Number of speeds | 16 | 16 | 12 |
| RPM | 200, 290, 350, 430, 500, 580, 640, 720, 800, 870, 1440, 1630 | 200, 290, 350, 430, 500, 580, 640, 720, 800, 870, 1440, 1630 | 150, 260, 300, 440, 490, 540, 1150, 1550, 1840, 2220, 2950, 4200 |
| Shipping Weight | 168 pounds | 163 pounds | 304 pounds |

Shipping Contents

Unpack the carton and verify that all parts listed below are included.

Main Parts

- 1 ea Head Assembly
- 1 ea Table
- 1 set Column and Table Bracket Assembly
- 1 ea Base

Additional Parts

- 1. 1 set Chuck and Chuck Key
- 2. 1 pc Arbor
- 3. 1 pc Drift Key
- 4. 1 pc Table Crank Handle
- 5. 1 pc Table Lock Handle
- 6. 1 pc Column Lock Handle
- 7. 3 pcs Downfeed Handles and Knobs
- 8. 4 pcs M10 x 40 Hex Cap Screws
- 9. 1 set Hex Wrenches (3mm, 5mm, 6mm)

Other Material

- 1 ea Owner's Manual
- 1 ea Warranty Registration Card

Required Tools

- 1. 17mm Box Wrench or a 6" – 8" Adjustable Wrench
- 2. 15/16" wrench



Additional Parts

Assembly

⚠WARNING

Read and understand all assembly instructions before attempting assembly! Failure to comply may cause serious injury!

Before Assembly

1. Remove the contents from the shipping container.
2. Compare the contents of the shipping container with the list found above. Report any shortages or damage to your JET distributor.
3. Clean all rust protected surfaces with kerosene or a light solvent. Do not use lacquer thinner, paint thinner, or gasoline. These will damage plastic components and painted surfaces.

Column Assembly

Referring to Figure 1:

1. Place the *base* (A) on a level floor.
2. Place the *column assembly* (B) on the *base* (A) and align the holes in the column support with the holes in the base.
3. **Note:** The column shown in Figure 1 is for the JDP-15MF. While the JDP-15M column is slightly different in appearance, the assembly procedure is the same.
4. Using a 17mm wrench, secure the *column* (B) with four M10 x 40 *hex cap screws* (C) to the base.

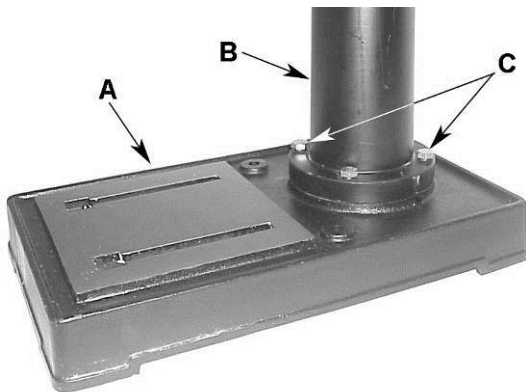


Figure 1

Table Bracket

When shipped, the *rack ring* and *rack* are bundled together with the column in plastic wrap.

Referring to Figures 2 and 3:

1. Remove the wrap and take the *rack ring* (D) and *rack* (B) off the *column* (C).

2. Install the table bracket (A) together with the rack (B) as shown in Figure 2.

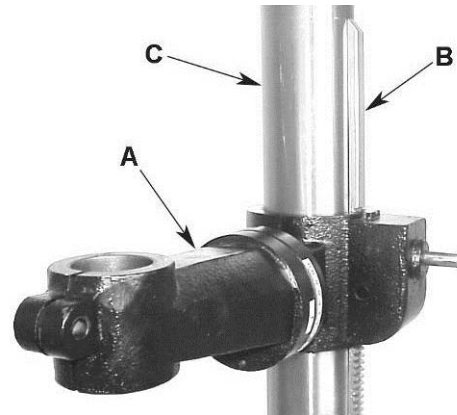


Figure 2

3. Slide the *rack ring* (D) over the *column* (C), placing it so it rests against the *rack* (B) as shown in Figure 3 and tighten firmly.

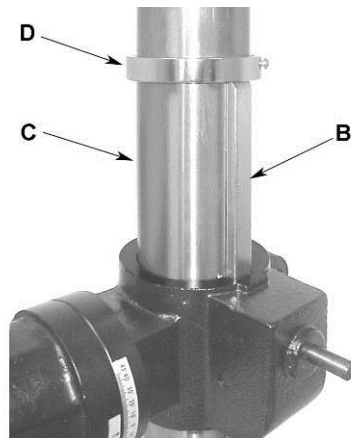


Figure 3

Crank Handle and Table Lock Handle

Referring to Figure 4 (shown already assembled):

1. Loosen the *setscrew* (B) on the *table crank handle* (A).
2. Slide the *handle* (A) onto the table bracket shaft.
3. Turn the handle until the setscrew is opposite the flat section on the shaft, and tighten the setscrew to secure the handle.
4. Install the *table lock handle* (C), but do not tighten.

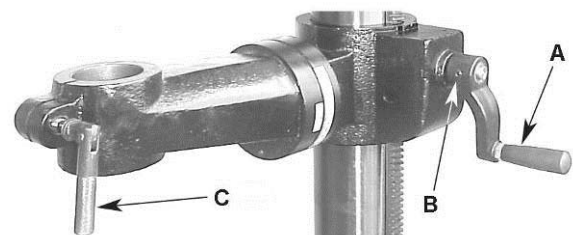


Figure 4

Column Lock Handle

Referring to Figure 5:

Thread the *column lock handle* (D) into the table bracket (E).

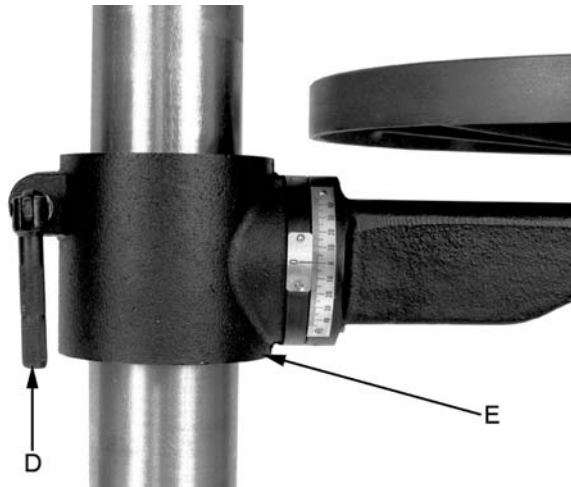


Figure 5

Table Installation

Referring to Figure 6:

1. Place the *table* (A) on the *bracket* (B).
2. Tighten the *table lock handle* (C).

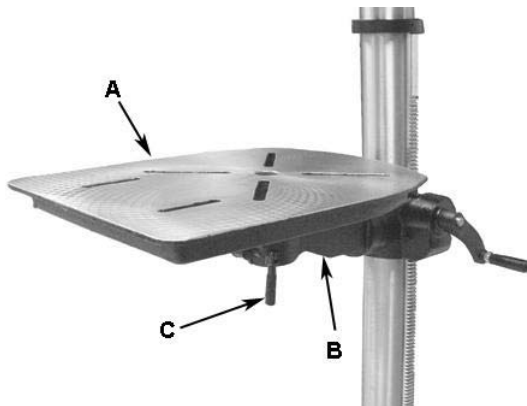


Figure 6

Head Assembly

Referring to Figure 7:

1. With the aid of a second person, carefully lift the *head* onto the column top and slide it down into position

CAUTION The head assembly is heavy! Use care when lifting onto the column!

2. Rotate head assembly until sides of the pulley cover are parallel with the sides of the base.

3. Tighten two *setscrews* (A) with a 5mm hex wrench (provided) until they are snug.



Figure 7

4. Install three *downfeed handles* (B) into the downfeed hub (C).

Chuck and Arbor Installation

Referring to Figure 8:

1. Thoroughly clean *arbor* (A), *chuck* (B) and spindle (C). Any grease or residue in these areas can cause the pieces to separate and create a safety hazard as well as damage to the tool.
2. Twist the *chuck* (B) to retract the chuck jaws if they are exposed.
3. Push chuck (B) by hand onto the arbor (A), and slide assembly firmly up into the spindle (C).
4. Turn the arbor and chuck assembly until the *tang* (B) on the *arbor* (C) engages the slot at the end of the spindle.

Use a single tap from a rubber mallet, or a hammer and a block of wood, against the bottom of the chuck to seat the chuck securely onto the arbor.

CAUTION Do not use a steel hammer directly against the chuck, as this may damage the chuck.

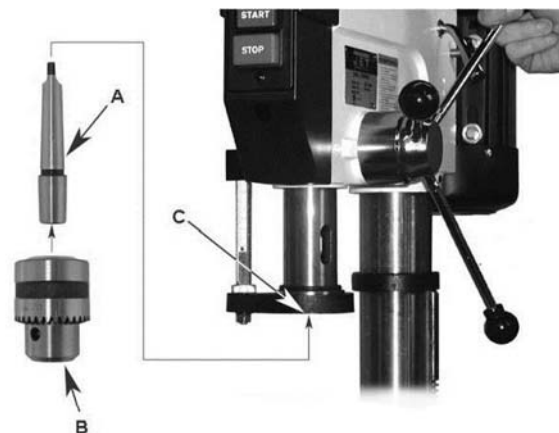


Figure 8

Chuck and Arbor Removal

Referring to Figure 9:

1. Unplug machine from the power source.
2. Raise the table until it is about seven inches below the chuck.
3. Place a piece of scrap wood on the table, and lower *quill* (A) using the downfeed handle.
4. Rotate spindle to align the keyhole in the spindle with the keyhole in the quill.
5. Insert the *drift key* (B) into the aligned slots and tap lightly. The chuck and arbor assembly should fall from the spindle.

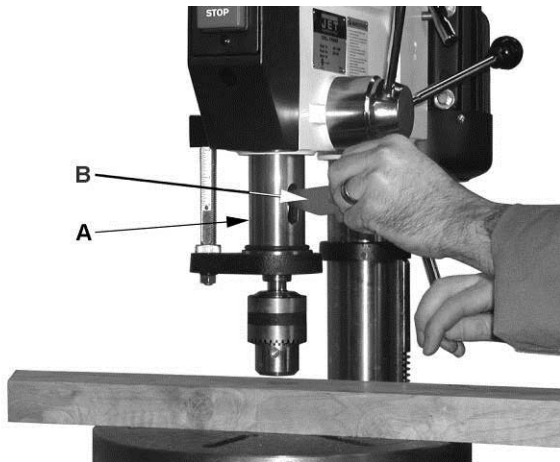


Figure 9

Adjustment

Depth Stop Adjustment

Referring to Figure 10:

To drill multiple holes at the same preset depth, use the depth stop:

1. Use a pencil to mark the depth the bit will drill into the workpiece.
2. With the drill bit in the chuck, lower downfeed handle to advance bit to your *mark* (A).
3. With your other hand, advance the *lock nuts* (B) on the depth stop rod until they are snug to the *seat* (C).
4. The drill bit will now advance to this point.
5. To release, advance the nuts counter-clockwise to the top of the depth stop.

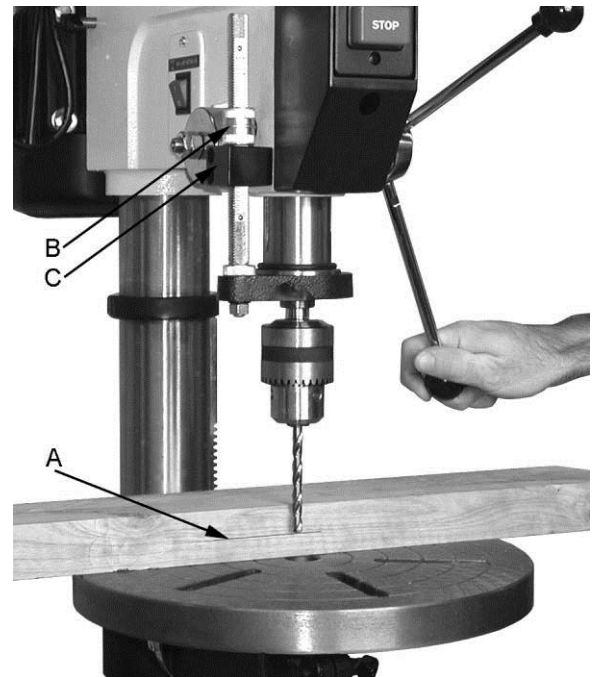


Figure 10

Changing Spindle Speeds

A spindle speed and pulley/belt arrangement chart for all models is found on the inside of the *pulley cover* (D, Fig. 11). Refer to this chart whenever changing speeds.

Note: The chart in Figure 12 is for models J-2500 and J-2530 only.

To change spindle speeds:

1. Unplug the machine from the power source.
2. Loosen two *bar knobs* (E, Fig. 11) found on each side of the head assembly.
3. Rotate the *tension adjuster* (F, Fig. 11) clockwise to bring the motor base as close to the head as possible.
4. For desired speed, change the location of belts per pulley/belt arrangement chart.
5. Rotate the *tension adjuster* (F, Fig. 11) counterclockwise to tension the belts.

6. Tighten two *bar knobs* (E, Fig. 11). Belts are properly tensioned when finger and thumb pressure midway between the two pulleys causes approximately $\frac{1}{2}$ " deflection.

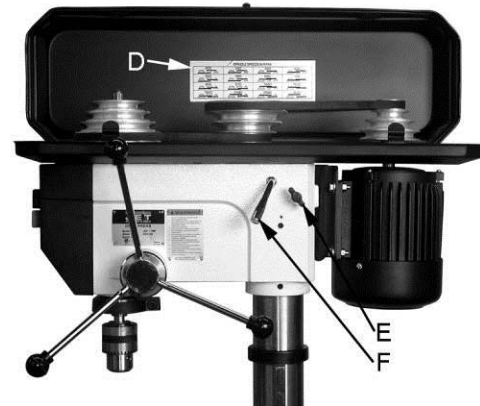


Figure 11

| SPINDLE SPEEDS IN R.P.M. | | | |
|--------------------------|------|------|------|
| 200 | 290 | 350 | 430 |
| 500 | 580 | 640 | 720 |
| 800 | 870 | 1440 | 1630 |
| 1820 | 2380 | 2540 | 3630 |

Figure 12 – Spindle Speed Chart for J-2500, J-2530

Return Spring Adjustment

The return spring is adjusted at the factory and should not need further adjustment. If adjustment is deemed necessary, follow the steps below while referring to Figure 13:

1. Unplug the machine from the power source.
2. Loosen two *hex nuts* (A). Do not remove.
3. Firmly hold the *coil spring cover* (B).
4. Pull out the cover and rotate until the *pin* (C) on the return spring plate engages the next notch in the coil spring cover. Turn the cover clockwise to decrease tension and counter-clockwise to increase tension.
5. Tighten two *hex nuts* (A). Do not over-tighten. Nuts should not contact the housing when tight. The hex nuts should be tightened against each other.

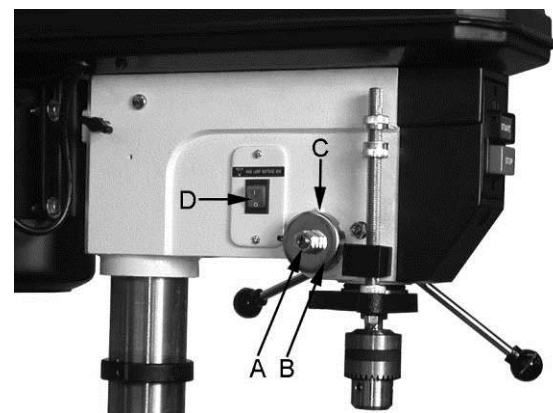


Figure 13

Work Light (J-2500 and J-2530 only)

Install a light bulb, no larger than 60 watts into the socket accessed from beneath the head. The rocker switch controls the *light switch* (D, Fig. 13).

Table Tilt Adjustment

The table tilt adjustments are made on the table bracket under the table.

To tilt the table (refer to Figures 14 and 15):

CAUTION

In the following steps do not over loosen. This could result in the table assembly to separate from the column, fall and cause injury.

1. Loosen the *socket head set screw* (A) with a 3mm hex wrench.
2. Using a 15/16" wrench, loosen the *hex cap screw* (B), and tilt the table to the desired angle by aligning the *arrow* (C, Fig. 15) on the rotating part of the bracket to the desired angle (in degrees) displayed on the *scale* (D, Fig 15) at the base of the bracket.
3. Tighten the *hex cap screw* (B).
4. Tighten the *socket head set screw* (A).

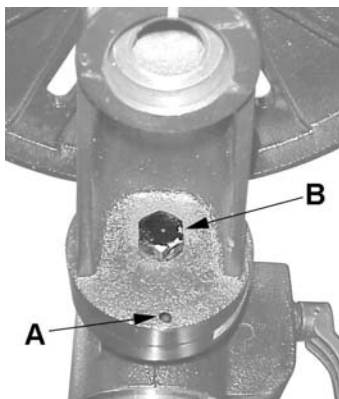


Figure 14

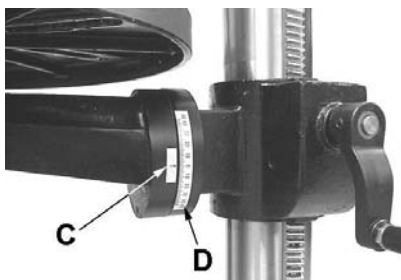


Figure 15

Operation

Installing Drills

Insert the drill into the chuck jaws about 1" (25.4mm) long. When using a small drill do not insert it so far that the jaws touch the flutes of the drill. Make sure that the drill is centered in the chuck before tightening the chuck with the key.

Positioning the Workpiece

Always place a piece of wood (or plywood) on the table. This will prevent "splintering" or making heavy burrs on the underside of the workpiece as the drill breaks through. The wood should contact the left side of the column.

Using the Vise

For the small workpiece that cannot be clamped to the table, use a drill press vise. The vise must be clamped or bolted to the table. Always use a back-up piece of scrap wood to cover the table. This protects both the table and the drill bit.

Basic Operation

Place material to be drilled in such a way as to come into contact with the left side of the column. This prevents the material from spinning.

WARNING

If the work piece is not large enough to come into contact with the column, use a clamp or drill press vise that is securely fastened to the table! Failure to comply may cause serious injury!

Feed the bit into the material with only enough force to allow the drill bit to work. Feeding too slowly may cause burning of the workpiece. Feeding too quickly may cause the motor to stop and/or the drill bit to break.

Generally speaking, the smaller the drill bit, the greater the RPM required. Wood requires higher speeds than metal. Metal is usually drilled at slower speeds.

In dusty environments, frequently blow out any dust that accumulates inside the motor.

Maintenance

WARNING

Before any intervention on the machine, disconnect it from the electrical supply by pulling out the plug or switching off the main switch! Failure to comply may cause serious injury.

A coat of automobile-type wax applied to the table and column will help to keep the surfaces clean.

If the power cord is worn, cut, or damaged in any way, have it replaced immediately.

Lubrication

All of the ball bearings are packed with grease at the factory. They require no further lubrication.

Periodically lubricate the gear, rack, table elevation mechanism, the splines (grooves) in the spindle, and the teeth of the quill with a #2 tube grease.

Electrical

Grounding Instructions

CAUTION

This tool must be grounded while in use to protect the operator from electric shock.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor, with insulation having an outer surface that is green with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded. Use only three wire extension cords that have three-prong grounding plugs and three-pole receptacles that accept the tool's plug.

Repair or replace a damaged or worn cord immediately.

115 Volt Operation

Referring to Figure 16:

As received from the factory, your drill press is ready to run at 115-volt operation. This drill press, when wired for 115 volt, is intended for use on a circuit that has an outlet and a plug that looks like the one illustrated in (A). A temporary adapter, which looks like the adapter shown in (B), may be used to connect this plug to a two-pole receptacle if a properly grounded outlet is not available. The temporary adapter should only be used until a properly grounded outlet can be installed by a qualified electrician. This adapter is not applicable in Canada. The green colored rigid ear, lug, or tab, extending from the adapter, must be connected to a permanent ground such as a properly grounded outlet box.

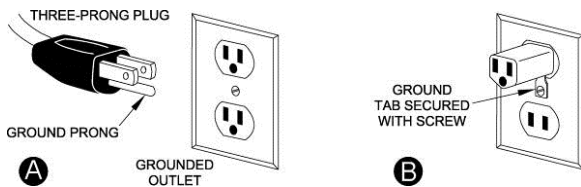


Figure 16

230 Volt Operation

Referring to Figure 17:

If 230V, single-phase operation is desired, the following instructions must be followed:

Disconnect the machine from the power source.

The JET drill press motor has four numbered leads that are factory connected for 115V operation, as shown in (A). For 230V operation reconnect the leads as shown in (B).

The 115V attachment plug (C), supplied with the drill press, must be replaced with a UL/CSA listed plug suitable for 230V operation (D). Contact your local Authorized JET Service Center or qualified electrician for proper procedures to install the plug. The drill press must comply with all local and national codes after the 230-volt plug is installed.

The drill press with a 230-volt plug should only be connected to an outlet having the same configuration as shown in (D). No adapter is available nor should be used with the 230-volt plug.

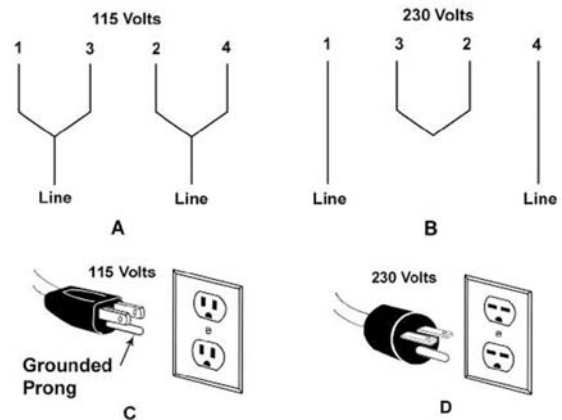


Figure 17

Extension Cords

Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw. An undersized cord will cause a drop in the line voltage resulting in power loss and overheating. The table following shows the correct size to use depending on the cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. Remember, the smaller the gauge number, the heavier the cord.

| Length of Cord | AWG |
|----------------|-----|
| 0 – 25 Feet | 16 |
| 25 – 50 Feet | 14 |

The drill press with a 230-volt plug should only be connected to an outlet having the same configuration (D, Fig. 17). No adapter is available or should be used with the 230-volt plug.

Important: In all cases (115 or 230 volts), make certain the receptacle in question is properly grounded. If you are not sure, have a registered electrician check the receptacle.

Troubleshooting

| Trouble | Probable Cause | Remedy |
|--|--|--|
| Drill press will not start. | Drill press unplugged from wall, or motor. | Check all plug connections. |
| | Fuse blown, or circuit breaker tripped. | Replace fuse, or reset circuit breaker. |
| | Cord damaged. | Replace cord. |
| | Starting capacitor bad. | Replace starting capacitor. |
| Drill press does not come up to speed. | Extension cord too light or too long. | Replace with adequate size and length cord. |
| | Low current. | Contact a qualified electrician. |
| Drill Press vibrates excessively. | Stand on uneven surface. | Adjust stand so that it rests evenly on the floor. |
| | Bad belt(s). | Replace belts. |
| Noisy Operation. | Incorrect belt tension. | Adjust belt tension. See the <i>Changing Spindle Speeds</i> section. |
| | Dry spindle. | Lubricate spindle. See the <i>Lubrication</i> section. |
| | Loose spindle pulley. | Check tightness of retaining nut on pulley, and tighten if necessary. |
| | Loose motor pulley. | Tighten setscrews in pulleys. |
| Workpiece Burns. | Incorrect Speed. | Change to appropriate speed; see the <i>Changing Spindle Speeds</i> section. |
| | Chips not clearing from hole or bit. | Retract drill bit frequently to remove chips. |
| | Dull drill bit. | Resharpen, or replace drill bit. |
| | Feeding too slowly. | Increase feed rate. |
| Drill bit wanders. | Bit sharpened incorrectly. | Resharpen bit correctly. |
| | Bent drill bit. | Replace drill bit. |
| | Bit, or chuck not installed properly. | Reinstall the chuck, or bit properly. |
| Wood splinters on the underside. | No backing board used. | Place a scrap board underneath the workpiece to prevent splintering. |
| Drill bit binds in workpiece. | Workpiece pinching the bit. | Support or clamp workpiece. |
| | Excessive feed rate. | Decrease feed rate. |
| | Chuck jaws not tight. | Tighten chuck jaws. |
| | Improper belt tension. | Adjust belt tension (<i>Changing Spindle Speeds</i>) |
| Excessive drill bit runout, or wobble. | Bent drill bit. | Replace drill bit. |
| | Worn spindle bearings. | Replace spindle bearings. |
| | Bit, or chuck not properly installed. | Reinstall the bit, or chuck properly. |
| Quill returns too slow, or too fast. | Spring has improper tension. | Adjust spring tension. See the <i>Return Spring Adjustment</i> section. |
| Chuck or arbor does not stay in place. | Dirt, grease, etc on arbor, chuck, or spindle. | Clean all mating surfaces thoroughly with a cleaner degreaser. |

Parts

Replacement Parts

To order parts or reach our service department, call 1-800-274-6848 Monday through Friday (see our website for business hours, www.jettools.com). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Parts List – J-2500, J-2530

| Index No. | Part No. | Description | Size | Qty |
|-----------|-------------|--|----------------|-----|
| 1A | 10600110 | Base for J-2530 / JDP-15M | | 1 |
| 1B | 10800101 | Base for J-2500 / JDP-15MF (not shown) | | 1 |
| 2A | JDP15-1002A | Column Holder for J-2530 / JDP-15M | | 1 |
| 2B | 10600204 | Column Holder for J-2500 / JDP-15MF | | 1 |
| 3 | TS-2279121 | Hex Socket Set Screw | M10-12 | 3 |
| 4A | JDP15-1004A | Body Column for J-2530 / JDP-15M | | 1 |
| 4B | JDP15-1004B | Body Column for J-2500 / JDP-15MF | | 1 |
| | 10600404A1 | Column Assy for J-2530 / JDP-15M (includes #2A and #4A) | | 1 |
| | 10400401A1 | Column Assy for J-2500 / JDP-15MF (includes #2B, #3 and #4B) | | 1 |
| 5 | TS-2229403 | Hex Head Bolt | M10x40 | 4 |
| 6 | 10600604 | Table Bracket | | 1 |
| | JDP15-1006 | Table Bracket Assy (includes #6 thru #18) | | 1 |
| 7 | 10600702 | Gear | | 1 |
| 8 | 10600802 | Gear Shaft | | 1 |
| 9 | 10600902 | Worm | | 1 |
| 10A | 10601009A1 | Crank Handle Assy | | 1 |
| 12 | JDP15-1012 | Table Bracket | | 1 |
| 13 | TS-0071011 | Hex Head Bolt | 5/8-11 x 1-1/2 | 1 |
| 14 | TS-2276101 | Hex Socket Set Screw | M6-10 | 1 |
| 16 | 10601601 | Tilting Scale | | 1 |
| 17 | JDP15-1017 | Centering Scale | | 1 |
| 18 | JDP15-1018 | Drive Screw | Φ 2.3-5 | 2 |
| 19 | 10601901 | Column Lock Handle | M12 x 1.75-35 | 1 |
| 20 | 10602001 | Table Lock Handle | M10 x 1.5 | 1 |
| 21 | J-5625221 | Table | | 1 |
| 22A | 10602204 | Rack for J-2530 / JDP-15M | | 1 |
| 22B | 10602205 | Rack for J-2500 / JDP-15MF | | 1 |
| 23 | 10602304 | Rack Ring | Φ 73.5 | 1 |
| 24 | TS-2276081 | Hex Socket Set Screw | M6-8 | 1 |
| 25 | JDP15-1025G | Head | | 1 |
| 26 | TS-2279121 | Hex Socket Set Screw | M10-12 | 2 |
| 27 | JDP15-1027 | Lamp Socket | | 1 |
| 28 | TS-1534042 | Cr. Re. Pan Head Screw | M6-12 | 2 |
| 29 | 10602901 | Handle Shifter | | 1 |
| 30 | 10603002 | Motor Bar Shifter | | 1 |
| 31 | TS-2228161 | Hex Head Bolt | M8-16 | 1 |
| 32 | 10603206 | Motor Rod | | 1 |
| 33 | 10603301 | Shifter Bolt | M10-33 | 2 |
| 34 | 10603416 | Motor Base | 75 x 125mm | 1 |
| 35 | 2502NBC412 | Spring Washer | Φ1/2" | 1 |
| 36 | TS-1540081 | Hex Nut | M12 | 2 |
| 37 | 10603704 | Hub | | 1 |
| 38 | 10603807 | Feed Shaft | | 1 |
| | JDP15-1038 | Feed Shaft Assy (includes #37 thru #39) | | 1 |
| 39 | JDP12-55 | Roll Pin | M5x16 | 1 |
| 43A | J-2500-43A | Handle Bar Assembly | | 1 |

Parts List – J-2500, J-2530

| Index No. | Part No. | Description | Size | Qty |
|-----------|-------------|---|---------------|-----|
| 45 | 10604505 | Scale Ring | | 1 |
| 50A | JDP15-1050 | Spring Cap | | 1 |
| 51 | 10605115 | Shaft Seat | | 1 |
| 53 | TS-0561052 | Hex Nut | 1/2"-20 | 1 |
| 54 | 10605403 | Quill Set Screw | M10-28 | 1 |
| 55 | TS-1540071 | Hex Nut | M10 | 1 |
| 56 | 10605608 | Quill | MT2 | 1 |
| | JDP15-1056 | Quill and Spindle Assy (includes #56 thru # 64) | | 1 |
| 57 | 10605702 | Rubber Washer | | 1 |
| 58 | 10605822 | Spindle | MT2 | 1 |
| 59 | 2001ZZ6204 | Ball Bearing | | 1 |
| 61 | 2001ZZ6203 | Ball Bearing | | 1 |
| 62 | TS-2360161 | Washer | M16 | 1 |
| 63 | 10606301 | Nut Lock | | 1 |
| 64 | 10606401 | Spindle Nut | | 1 |
| 65 | 10606505 | Driving Sleeve | | 1 |
| | JDP15-1065 | Driving Sleeve Assy (includes #65 thru #67) | | 1 |
| 66 | 2001ZZ6204 | Ball Bearing | | 2 |
| 67 | 10606703 | Rack ring | Φ 45 T=4 | 1 |
| 68 | 10606801 | Retaining Ring | | 2 |
| 69 | 10606904 | Pulley Set Nut | | 1 |
| 70 | JDP15-1070 | Spindle Pulley | | 1 |
| 71 | 21015M2J30 | Drilling Arbor | MT2*JT3 | 1 |
| 72A | JDP15-1072 | Chuck Assy | | 1 |
| 73 | 10607303 | Wedge Shifter | | 1 |
| 74 | JDP15-1074 | Motor | | 1 |
| | JDP15-1074A | Centrifugal Switch (not shown) | | 1 |
| | JDP15-1074B | Start Capacitor (not shown) | 200MFD 125VAC | 1 |
| 75 | JDP15-1075 | Motor Wire | | 1 |
| 76 | TS-2208201 | Hex. Hd. Screw | M8-20 | 4 |
| 77 | TS-1550061 | Flat Washer | M8 | 8 |
| 78 | TS-1540061 | Hex Nut | M8 | 4 |
| 79 | JDP15-1079 | Motor Pulley | | 1 |
| 80 | 2571MNC307 | Parallel Key | 5 x 5-20 | 1 |
| 81 | TS-1504021 | Hex Socket Set Screw | M8-12 | 1 |
| 83 | JDP15-1083 | Strain Relief | | 1 |
| 84 | TS-1534042 | Cr. Re. Pan Head Screw | M6-12 | 1 |
| 85 | JDP15-1085 | Power Cable | | 1 |
| 87 | JDP15-1087 | Rocker Switch | | 1 |
| 88 | JDP15-1088 | Switch Box | | 1 |
| 89 | TS-1533042 | Cr. Re. Pan Head Screw | M5-12 | 3 |
| 90A | JDP15-1090G | Pulley Cover Assy | | 1 |
| | JDP15-1090A | U Shaped Protecting Rubber (not shown) | | 1 |
| 92 | JDP15-1092 | Cr. Re. Round Washer Hd. Screw | M6 x 1.0-12 | 4 |
| 95 | JDP15-1095 | Center Pulley | | 1 |
| | JDP15-1095A | Center Pulley Assy (includes #95 thru #98) | | 1 |
| 96 | JDP15-1096 | Ball Bearing | | 2 |
| 98 | 10609801 | Center Pulley Shaft | | 1 |
| 99 | VB-A28 | V-Belt | A-28 | 1 |
| 101 | TS-0680021 | Flat Washer | 1/4" | 4 |
| 106 | TS-0561052 | Hex Nut | 1/2"-20 | 1 |
| 109 | JDP15-1109 | Clamp-Cord | | 3 |
| 110 | 2668BBDA23 | Cr. Re. Pan Head Screw | M5-8 | 3 |
| 112 | 10611201 | Chuck Key Holder | | 1 |
| 113 | TS-2286122 | Cr. Re. Round Washer Hd. Screw | M6-12 | 1 |
| 119 | VB-A26 | V-Belt | A-26 | 1 |

Parts List – J-2500, J-2530

| Index No. | Part No. | Description | Size | Qty |
|-----------|-------------|---|---------|-----|
| 128 | TS-2285162 | Cr. Re. Truss Hd. Tapping Screw | M5-16 | 2 |
| 137 | JDP15-1137G | Switch Cover | | 1 |
| 138 | TS-1533042 | Cr. Re. Pan Head Screw | M5-12 | 2 |
| 139 | JDP15-1139 | Rocker Switch | | 1 |
| 140 | 10614001 | Motor Rod | | 1 |
| 149 | 2536MBE616 | Roll Pin | 6-25 | 2 |
| 162 | 10916202 | Warning Label | | 1 |
| 166 | JDP15-1166 | Speed Diagram | | 1 |
| 169 | JET-92 | JET Logo Plaque | 92x38mm | 1 |
| 170 | 2658MZDU36 | Drive Screw | Φ 2.3-5 | 6 |
| 601 | TS-2245082 | Cr. Re. Pan Head Screw | M5-8 | 4 |
| 602 | TS-0733031 | External Tooth Lock Washer | No 10 | 2 |
| 610 | TS-1534692 | Cr. Re. Pan Head Screw | M6-35 | 2 |
| 611 | 10661102 | Depth Stop Block | | 1 |
| 612 | TS-1540071 | Hex Nut | M10 | 1 |
| 613 | 10661301 | Set Bolt | | 1 |
| | JDP15-1613 | Set Bolt Assy (includes #613, 848, 849) | | 1 |
| 614 | 13005701 | Nut | M16 | 2 |
| 615 | 13005601 | Washer | Φ24 | 1 |
| 616 | TS-1502081 | Hex. Soc. Hd. Cap Blot | M5-35 | 1 |
| 617 | JDP15-1617 | Set Ring | | 1 |
| 618 | 10661801 | Circular Nut | | 1 |
| 634 | 2502ABC410 | Spring Washer | Φ10 | 1 |
| 700 | TS-152704 | Wrench Hex | | 1 |
| 701 | TS-152706 | Wrench Hex | | 1 |
| 702 | TS-152707 | Wrench Hex | | 1 |
| 801 | JDP15-1801 | Lead Wire Assembly | | 1 |
| 848 | JDP15-1848 | Drive Screw | Φ 2.3-5 | 2 |
| 849 | JDP15-1849 | Scale | | 1 |
| 922 | 2801ABRF04 | Strain Relief | Φ 20 | 2 |
| 999 | TS-1540081 | Hex Nut | M12x10 | 3 |
| 1000 | 100633Y8 | Plastic Sleeve | | 1 |
| 1001 | 10810401A1 | Chuck Guard Assembly | | 1 |

Parts List – J-2550

| Index No. | Part No. | Description | Size | Qty |
|-----------|------------|---------------------------------------|-------------------|-----|
| 1 | J-5627751 | Base | | 1 |
| 2 | J-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 | J-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" | 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 | J-5627861 | Table | 18-3/4" x 16-3/4" | 1 |
| 22 | 5627871 | Rack | | 1 |
| 23 | J-5627881 | Retainer, Rack | | 1 |
| 24 | 5627061 | Screw Set, Hex Socket | M6 x 10mm | 1 |
| 25 | J-5627891G | 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 | J-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 | J-2550-43A | 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 | | 1 |
| 56A | 5629121 | Quill Assembly (includes #56 thru 64) | | 1 |

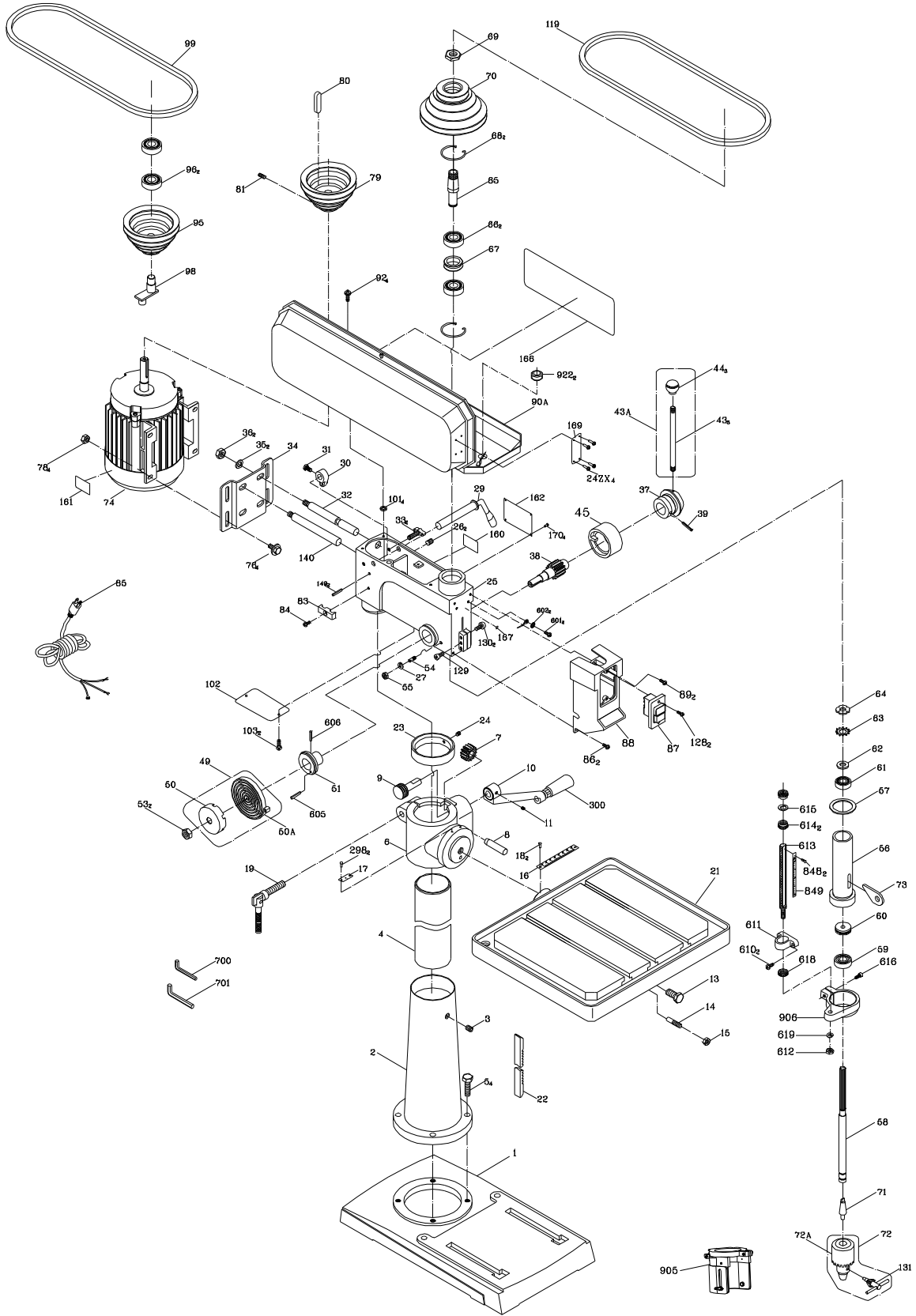
Parts List – J-2550

| Index No. | Part No. | Description | Size | Qty |
|-----------|------------|---------------------------------|--------------|-----|
| 57 | 5629131 | Washer, Rubber | | 1 |
| 58 | 5629141 | Spindle | MT3, Ø34 | 1 |
| 59 | 5629151 | Bearing, Ball | 6206ZZ | 1 |
| 60 | 5629161 | Bearing, Ball, Thrust | 2906 | 1 |
| 61 | 5635271 | Bearing, Ball | 6204Z | 1 |
| 62 | 5629171 | Washer | | 1 |
| 63 | 5629181 | Lock, Washer | | 1 |
| 64 | 5629191 | Lock, Nut | | 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 | J-5629271 | Motor | | 1 |
| 76 | 5629291 | Screw, Hex Head | M8 x 25 mm | 4 |
| 77 | 5627511 | Washer, Flat | 5/16" | 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 |
| 84 | 5626841 | Screw, Pan Head | M5 x 8 mm | 2 |
| 85 | 5629341 | Cord, Power | | 1 |
| 87 | JDP15-1087 | Push-Button Switch | | 1 |
| 88 | 5629361 | Cover, Switch | | 1 |
| 89 | 5626871 | Screw, Pan Head | M5 x 12 mm | 2 |
| 90A | 5629371G | Pulley Cover Assembly | | 1 |
| 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" | 4 |
| 102 | J2550-102 | Cover Plate | | 1 |
| 103 | 5712561 | Phillips Pan Head Machine Screw | M5-0.8 x 8 | 2 |
| 119 | 5637541 | V-Belt | A-32 | 1 |
| 128 | TS-2285162 | Screw, Machine | M5 x 16 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 |
| 169 | JET-113 | JET Logo Plaque | 113x47mm | 1 |
| 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 |

Parts List – J-2550

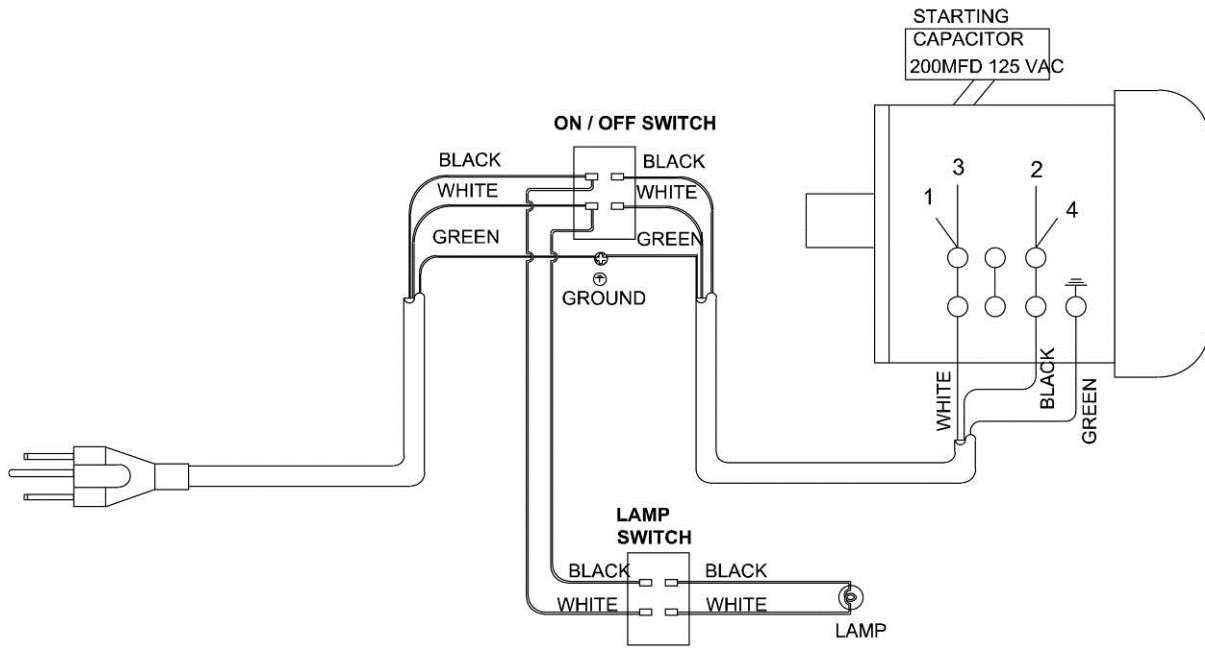
| Index No. | Part No. | Description | Size | Qty |
|-----------|------------|----------------------------|-----------|-----|
| 612 | 5513740 | Nut | | 1 |
| 613 | 5513741 | Rod, Depth Stop Adjustment | 2550 Only | 1 |
| 614 | 5513742 | Nut, Adjustment Lock | | 1 |
| 615 | 5513743 | Washer | | 1 |
| 616 | 5513744 | Screw, Clamping | | 1 |
| 617 | J-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 | J-5629371 | Cover Assembly, Pulley | | 1 |
| 905 | 10810402A1 | Chuck Guard Assembly | | 1 |
| 906 | 11361702 | Set Ring | | 1 |

Exploded View – J-2550

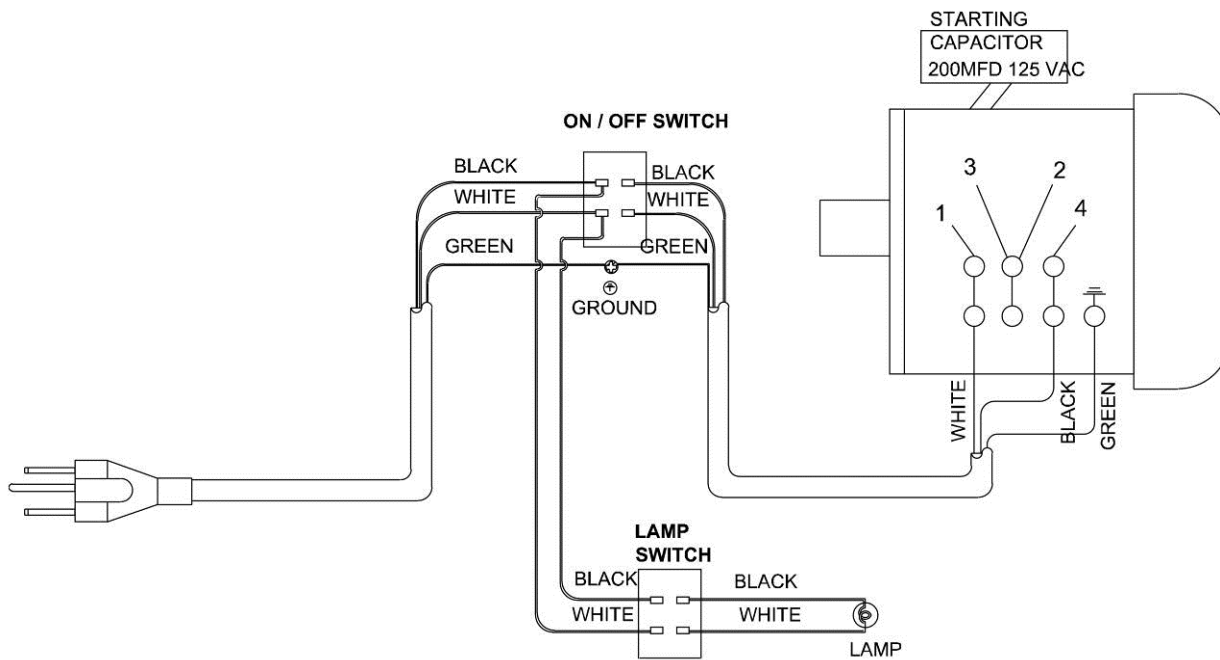


Wiring Diagram

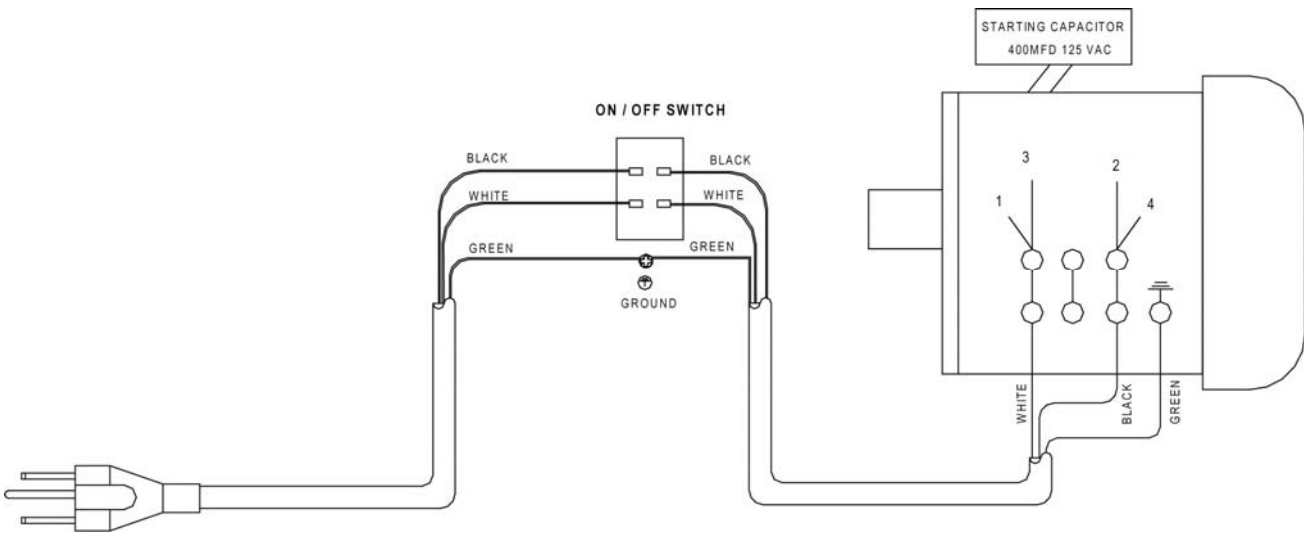
J-2500/J-2530 – 115V



J-2500/J-2530 – 230V



J-2550 – 115V



J-2550 – 230V

