I. ASSEMBLING RED DP-TRACK TO THE TABLE

AT THIS POINT YOU WILL NEED:

- (1) Table (36” or 48”)
- (12) 1/4-20 x 3/4” Flathead Phillips Screw
- (12) 1/4 x 20 Oval Nut
- (2) Red Scale Track

1. Push (12) A-1 Flathead Phillips Screws through the holes on the underside of the Table. Thread the Flathead Phillips Screws to the A-2 Oval Nuts just enough to hold them together. **FIGURE 1.**

2. Slide the (2) Red Tracks into the Table’s channels. Slide the Red Track so it captures the Oval Nuts. **FIGURE 2.** Slide the Red Track until it stops tight to the front of the channel and is flush to the back of the Table. **FIGURE 3.**

3. Tighten the (12) Flathead Phillips Screws underneath for the Table/Red Track. **DO NOT OVER TIGHTEN THE SCREWS.**
II. ASSEMBLING BRACKETS FOR SIDE EXTENSIONS
AT THIS POINT YOU WILL NEED:
③  (4) Shaft Bracket
B-4  (8) Shaft Grommet
B-3  (16) #10 Panhead Phillips Wood Screw

1. Squeeze to collapse the B-4 Shaft Grommets then insert them into each end of the ③ Shaft Bracket side holes. Do this for all four Shaft Brackets. **Figures 4/4-1.**

2. Locate the mounting holes for the Shaft Bracket on the underside of the ① Table. Screw down the 4 Shaft Brackets to the table using the (16) B-3 Panhead Phillips Wood Screws. **Figure 5. DO NOT OVER TIGHTEN SCREWS.**

III. ASSEMBLING THE STAINLESS STEEL SHAFTS TO BRACKETS
AT THIS POINT YOU WILL NEED:
⑤  (2) Stainless Steel Shaft (2 Hole)
⑦  (2) Stainless Steel Shaft (1 Hole)
B-5  (4) Retaining Snap Ring

1. Slide the (2) ⑤ Stainless Steel Shafts (2 holes) through the front ③ Shaft Bracket holes. The holes on the Stainless Steel Shafts should be facing outward from the ① Table, the grooves on the end of the Stainless Steel Shafts should be toward the middle of the Table. **Figure 6.**

2. Slide the (2) ⑦ Stainless Steel Shafts (1 hole) through the rear ③ Shaft Bracket holes. The holes on the Stainless Steel Shafts should be facing outward from the Table, the grooves on the end of the Stainless Steel Shafts should be toward the middle of the Table. **Figure 7.**

3. Snap the (4) B-5 Retaining Snap Rings on the grooved end of the Stainless Steel Shafts. **Figures 7/7-1.**
IV. ASSEMBLING THREAD STUDS TO SIDE EXTENSIONS
AT THIS POINT YOU WILL NEED:
(2) Table Extension
(6) Threaded Stud
(1) 1/8" Allen Key

1. Screw the (6) B-1 Threaded Studs to the (2) Table Extensions. 
   **NOTE:** One side uses the first sets of holes (A) and the other uses the 
   second sets of holes (B). **Figure 8.**

2. Thread the Threaded Studs into the holes on the Table Extensions 
   with the B-6 Allen Wrench. **NOTE:** Do not install the Threaded Studs 
   too deep. Thread them to about 1-1/8".

V. ASSEMBLING SIDE EXTENSIONS TO SHAFTS
AT THIS POINT YOU WILL NEED:
(12) 1/4-20 Hex Nut

1. Putting the (1) Table and (2) Table Extensions together on a flat surface 
   will aid in the installation. Install a B-2 Hex Nut onto B-1 Threaded Stud. 
   Thread them down to the bottom of the Threaded Stud just touching the 
   black surface of the Table Extension. **DO NOT TIGHTEN THEM.** **Figure 9.**

2. Raise the Table up and slide the Table Extension with Threaded Studs into 
   to correct Stainless Stee Shaft holes. The Table Extension will fit flush with 
   the back end of the Table. **NOTE:** When the Table Extension is laying next to 
   the Table you will see which Threaded Studs line up with the holes in the 
   Stainless Steel Shaft. **Figure 10.**

3. Install another Hex Nut onto the Threaded Studs until it stops against the 
   Stainless Steel Shaft, finger-tight. **Figure 11.**

4. Turn the bottom Hex Nut counter-clockwise until it stops against the 
   Stainless Steel Shaft, finger-tight. **Figure 11-1.**

   **NOTE:** After the Drawer Base is installed and the Table is turned right-side 
   up, the Table Extensions can be checked to see if they are coplanar with the 
   Table. Adjustments can be made by loosening and tightening these hex nuts.
VI. DRAWER ASSEMBLY
AT THIS POINT YOU WILL NEED:
- C-1 (12) 8-32 x 1/8” Panhead Screw
- C-2 (2) Drawer Slide (includes Drawer Slide Extension)
- C-3 (1) Drawer Base
- C-4 (1) Drawer Extension

1. Remove the C-2 Drawer Slide Extension by flexing the end of the Black Plastic Release up or down in direction and pulling away from the Drawer Slide. Figure 12.

2. Using (3) C-1 Pan Head Screws, attach the Drawer Slide Extension to the Drawer. NOTE: Use only the round holes on the Drawer Slide Extension.) Figure 13.

3. Repeat steps 1 & 2 for the other side of the Drawer.

4. Attach the C-2 Drawer Slide to the C-3 Drawer Base using the (3) C-1 Pan Head Screws. The back of the Drawer Slide has a Black Bumper at the end. The Black Bumper end of the Drawer Slide should be at the back side of the Drawer Base. NOTE: Use only the round holes on the Drawer Slide.) Figures 14/14-1.

5. Repeat step 4 for the other side of the Drawer Base.

VII. DRAWER BASE ASSEMBLY
AT THIS POINT YOU WILL NEED:
- C-3 (6) #10 Panhead Phillips Wood Screw

1. Attach the C-3 Drawer Base to the underside of the C-1 Table/C-2 Table Extensions Assembly using (3) Panhead Phillips Wood Screws through each side of the Drawer Base into the Table. NOTE: Be certain the back of the Drawer Base is at the rear of the Table. Figures 15.
VIII. FENCE INSTALLATION
AT THIS POINT YOU WILL NEED:
12. (1) Fence (24", 36" or 48")
13. (1) Dust Collection Elbow 2-1/4"
14. (1) Dust Collection Center Chuck Fitting
1. (1) End Cap
2. (2) Knob
3. (2) 1/4-20 x 3-3/4" Screw
4. (2) Red Tube
5. (4) Nylon Washer
6. (4) 10/32 x 1/2 Pan Head Torx Screw

1. The 13 Dust Collection Elbow and E-1 End Cap can be secured to either end of the 12 Fence using the (4) E-6 Pan Head Torx Screws. **Figure 16.**

2. Push the E-3 Screw up through the bottom of the Fence.

3. Then assemble the E-5 Nylon Washer, E-4 Red Tube and the E-5 Nylon Washer onto the Screw (in that order) securing with the E-2 Knob. **Figure 16-1.**

3. The Fence installs to the 12 Red Track/Table assembly with the E-3 Screw head lined up in the Red Track slot. **Figure 17.**

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**USING THE KNUCKLE CLAMP ③**

**T-TRACK COMPATIBILITY:** The Knuckle Clamp is designed to be used with standard 1/4-20 hex head bolts. In the illustration shown, the head of the bolt is captured in a matching aluminum T-track. However, the clamp can also be installed in any table with any other 1/4-20 bolt with or without T-track.

For instance in a workbench, a 1/4" carriage bolt can be pushed up through the bench top and used in the same manner. As long as the bolt is secure enough to not pull out, the clamp can do its job. Do not tighten the clamp with anything other than the included Woodpeckers Multi-Knob or similarly sized knob. Do not use a wrench to tighten the clamp. This will destroy the clamp. Hand pressure only.

**Each Pivoting Foot has a Non-Slip Pad molded to it. This Non-Slip Pad prevents marking of softer wood species and greatly reduces movement of the work piece being clamped.**

**The purpose of the Height Knob and Spring is to allow the Knuckle Clamp to rest at a height just above the work piece when clamping pressure is removed. Thus making it easy to slide work under the foot.**

**Use the Location Knob to keep the screw vertically oriented and stable. No more than finger pressure is required to keep it in place.**

Although the Bridge has seven different Knuckle locations, only the center five are typically used. A good rule of thumb is to use the one closest to the piece being clamped. This will allow for maximum clamping pressure. Maximum clamping capacity, about 2".

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**USING THE DP-PRO FLIP STOPS ③**

Position the Flip Stop along the Fence anywhere you want to repeat a drill position on multiple workpieces.

The position of the Flip Stop can be fine tuned with the thumbwheel micro-adjuster.
IX. MOUNTING

AT THIS POINT YOU WILL NEED:

- D-1 (4) 5/16-18 Large Rectangular Nut
- D-2 (4) 5/16-18 x 3/4" Hex Bolt
- D-3 (4) 5/16-18 x 1-1/4" Hex Bolt
- D-4 (4) 5/16-18 Hex Nut
- D-5 (4) 5/16 Washer
- D-6 (4) 1/4-20 Rectangular Nut
- D-7 (4) 1/4-20 x 3/4" Hex Bolt

The DP-PRO Drawer Base has several slots in the Base. The pattern is designed to intersect with virtually any pattern of slots in a factory drill press table. Figure 18.

1. The DP-PRO Table has a 1/4" hole at the optimum position for location of the center of the press. Chuck a 1/4" drill bit in your chuck and adjust the table so the drill bit aligns with the hole in the table.

2. Find the outermost points where the slots in the Drawer Base align with the slots in your factory table. These are the optimum points for securing the Drawer Base to your factory table.

3. A variety of hardware has been supplied to attach your DP-PRO table to your factory drill press table. We have supplied two sizes of rectangular nuts.
   A. In tables with through-slots, the larger (5/16"-18) should bridge across the slot as shown. Figure 18/19.
   B. In drill press tables with T-slots, one size or the other should fit the slot as shown. Figure 20/21.

IX. ATTACHING THE FILLER BLOCK

AT THIS POINT YOU WILL NEED:

- 1 (1) MDF Filler Block
- D-8 (4) #10 x 3/8" Phillips Flathead Wood Screw

1. Install D-8 (4) Phillips Flathead Wood Screw as leveling screws in the table cut-out. Adjust them just about the surface of the machined area. Figure 22.

2. Install the Filler Block.

3. Adjust the leveling screws up or down as needed to position the Filler Block flush with the table surface.
With certain short drill bits you may encounter interference between the quill feed handle and the DP-PRO fence. This is highly variable depending on the brand of drill press, fence position, material thickness, chuck design and several other unlisted factors.

There are a few different approaches to working around the problem. The easiest and most effective is to temporarily remove one feed handle. You can also raise your material higher by placing a piece of scrap below it, allowing you to lower the table and eliminate the interference.