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MODEL T32710 DRILL PRESS TABLE w/ FLIP-STOP FENCE INSTRUCTIONS

Introduction

The Model T32710 Drill Press Table can be installed on your drill press for greater workpiece support and increased accuracy.

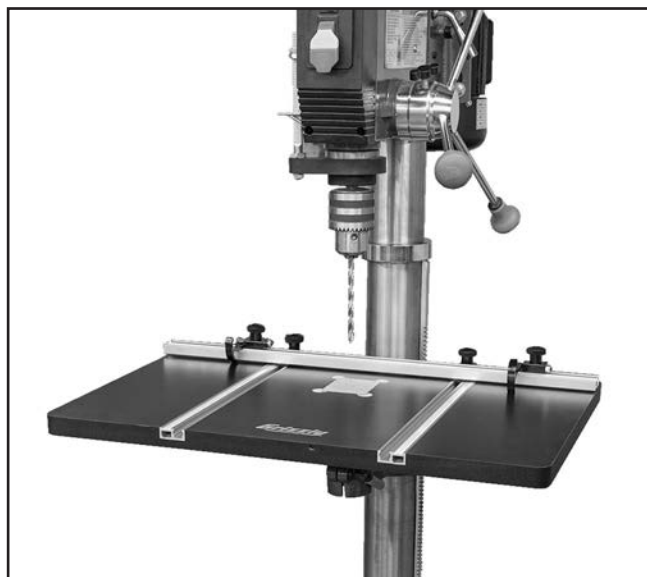
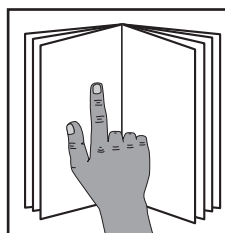


Figure 1. Model T32710 Drill Press Table w/Flip-Stop Fence installed on drill press.



!WARNING

To reduce your risk of serious injury, read this entire manual **BEFORE** using machine.

Specifications

Minimum Distance from Spindle to Column.. 4½"
Table Size..... 23¾" W x 15¾" D x 1" T
Fence Size..... 23¾" W x 1¼" D x ½" H
T-Slots ½" W x ⅜" H
Weight 14 lbs.

Inventory

Box Contents (Figure 2)	Qty
A. Table.....	1
B. Table Insert.....	1
C. Fence.....	1
D. Flip-Stop Assemblies	2
E. Fence Brackets	2
F. Flat Head Screws 10-24 x ½"	2
G. T-Bolts ¼"-20 x 1¼"	2
H. Fence Lock Knobs	2
I. Wing Knob Bolts ⅜"-16 x 1"	4
J. Flanged Inserts ⅜"-16, ⅞" x ½"	4
K. Hex Wrench 10mm.....	1

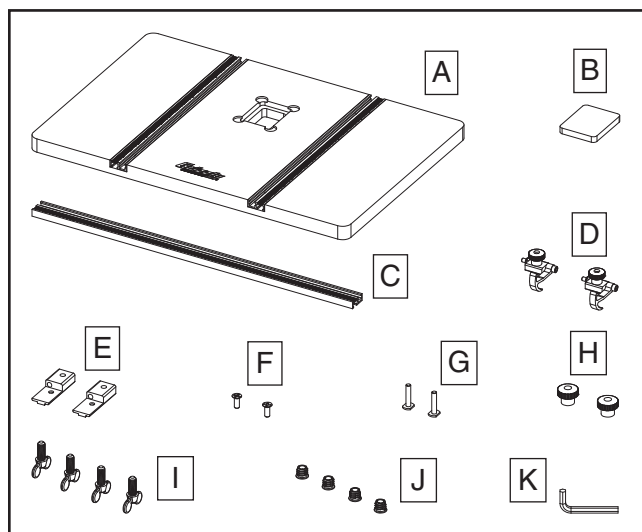


Figure 2. Inventory.

NOTICE

If you cannot find an item on this list, carefully check around/inside the machine and packaging materials. Often, these items get lost in packaging materials while unpacking or they are pre-installed at the factory.

Through-Slot Installation

Use the following steps to install the Model T32710 on your through-slot drill press table like the one shown in **Figure 3**.



Figure 3. Example of through-slot drill press table.



WARNING
Wear safety glasses during the entire setup process!

Items Needed	Qty
File/Deburring Tool	1
Drill Press	1
Cleaner/Degreaser	As Needed
Shop Rags.....	As Needed
Pencil.....	1
Drill Bit 1/2"	1

To install on through-slot table:

1. DISCONNECT MACHINE FROM POWER!
2. File down any nicks or burrs in drill press table and clean surface.

3. Remove table insert, flip-stops, and fence from Model T32710 table and place table upside down on workbench or table (see **Figure 4**).

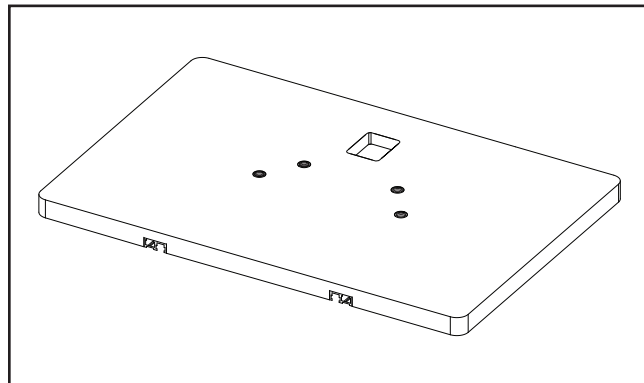


Figure 4. Model T32710 table ready for installation.

4. Remove drill press table from drill press and place it facedown on top of Model T32710 table.
5. Line up center of drill press table with center of Model T32710 table insert hole (see **Figure 5**).

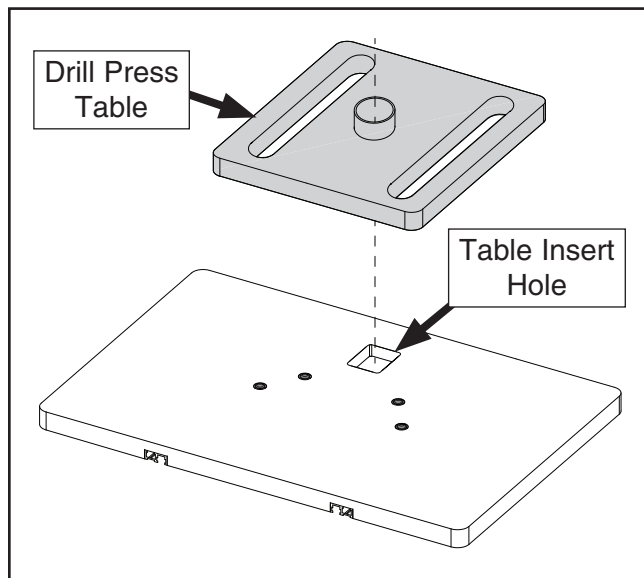


Figure 5. Drill press table centered on Model T32710 table.



6. Check if any pre-installed inserts in Model T32710 are visible through slots in drill press table (see **Figure 6**). A circular drill press table may need to be rotated.

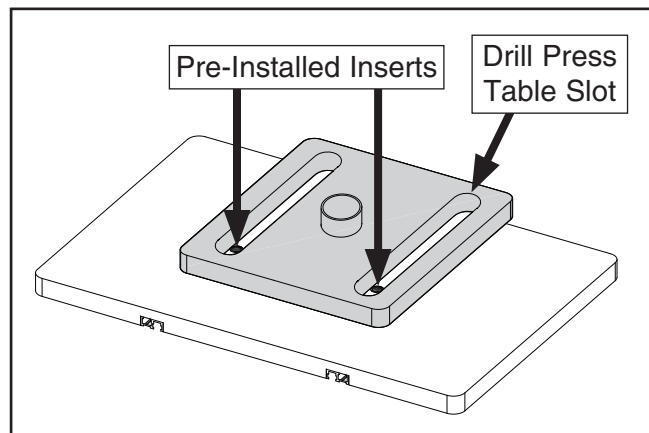


Figure 6. Model T32710 inserts viewed through drill press table slots.

- If at least (2) inserts *are* visible through drill press table holes when tables are centered, install $\frac{3}{8}$ "-16 x 1" knob bolts in all visible inserts to secure Model T32710 table to drill press table (see **Figure 7**). If desired, use **Steps 7–10** to install additional inserts for added stability, otherwise proceed to **Step 11**.

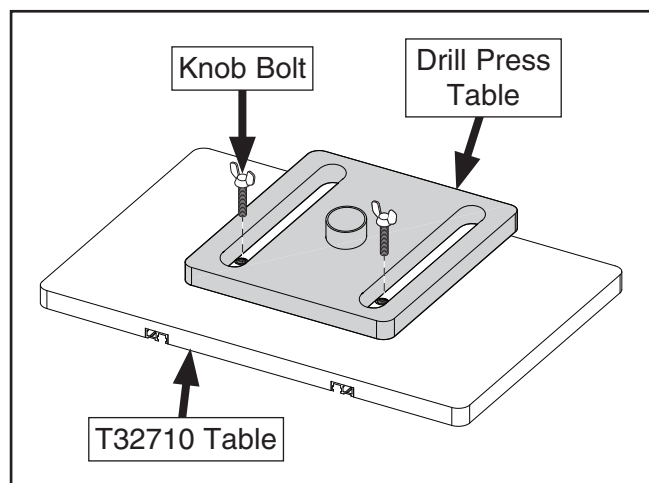


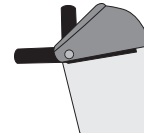
Figure 7. Model T32710 table secured to drill press table with knob bolts.

- If at least (2) inserts *are not* visible through drill press table slots when tables are centered, proceed to **Step 7**.

7. Mark (4) mounting locations through drill press table slots. Marks should not interfere with pre-installed inserts or table insert hole.

! WARNING

To reduce risk of eye or face injury from flying chips, always wear approved safety glasses and a face shield when operating a drill press or drill.



8. Drill (4) $\frac{1}{2}$ " diameter, $\frac{1}{2}$ " deep holes at locations marked in **Step 7**.
9. Install (4) $\frac{3}{8}$ "-16, $\frac{9}{16}$ " x $\frac{1}{2}$ " flanged inserts in holes so they are flush with table surface (see **Figure 8**).

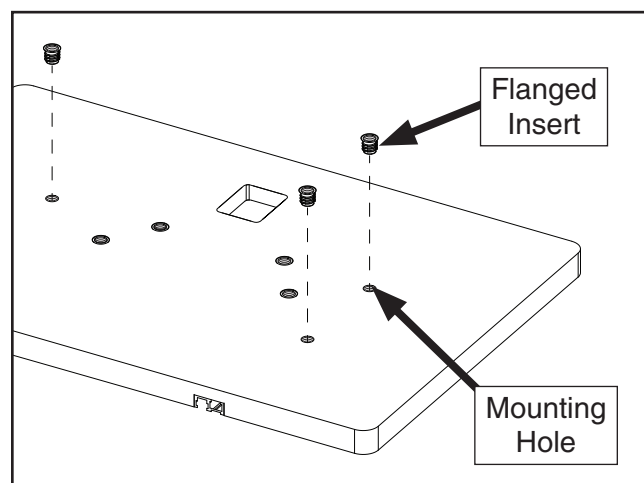


Figure 8. Flanged inserts installed in mounting holes.

10. Use (4) $\frac{3}{8}$ "-16 x 1" knob bolts to secure Model T32710 table to drill press table (see **Figure 7**).
11. Install drill press table on drill press.



T-Slot Installation

Use the following steps to install the Model T32710 on a T-slot drill press table like the ones shown in **Figure 9**.

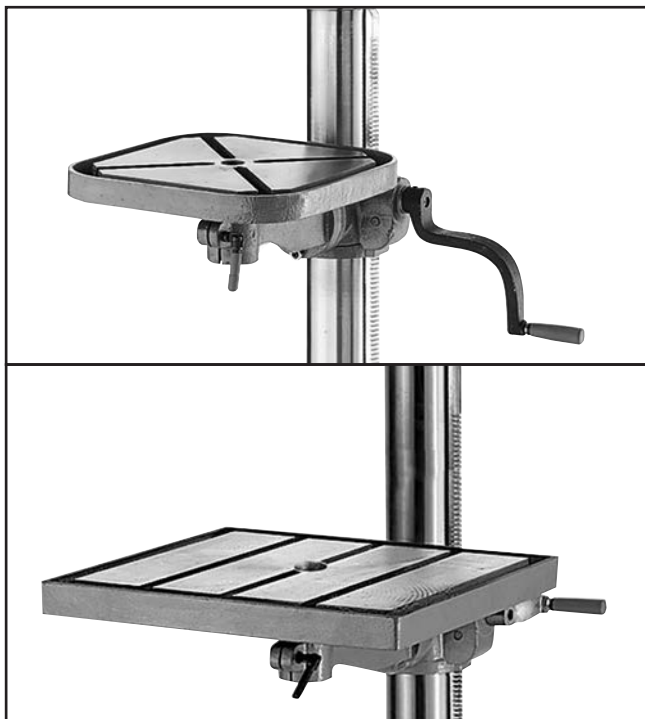
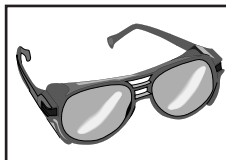


Figure 9. Examples of T-slot drill press tables.

Because T-slots vary in size, you will need to obtain (4) T-nuts that fit your drill press table T-slots and (4) matching bolts that are 1" long.



! WARNING
Wear safety glasses during the entire setup process!

Items Needed	Qty
File/Deburring Tool	1
Drill Press	1
Cleaner/Degreaser	As Needed
Shop Rags.....	As Needed
Plywood 23 ³ / ₄ " x 15 ³ / ₄ " x ³ / ₄ "	1
Pencil	1
Drill Bits ⁹ / ₁₆ ", ¹ / ₂ ", Bits for Countersinking	1 Ea.
T-Nuts	4
Mounting Bolts (1" Length)	4

To install on T-slot table:

1. DISCONNECT MACHINE FROM POWER!

2. File down any nicks or burrs in drill press table and clean surface.
3. Adjust drill press table so it is centered under headstock.
4. Remove table insert, flip-stops, and fence from Model T32710 table (see **Figure 10**).

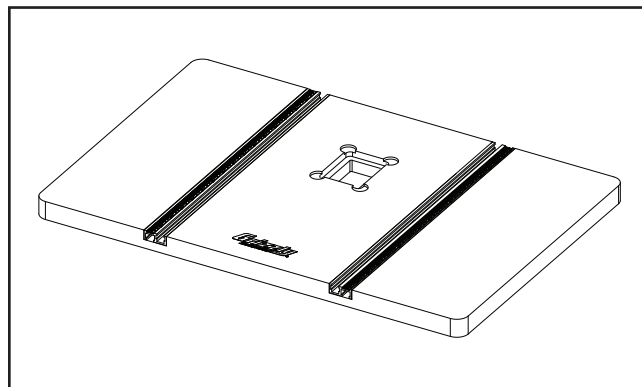


Figure 10. Model T32710 table ready for installation.

5. Stack Model T32710 table on 23³/₄" x 15³/₄" x ³/₄" plywood and place both on drill press table.
6. Install drill bit in drill press and adjust Model T32710 table and plywood together until bit aligns with center of table insert hole (see **Figure 11**).

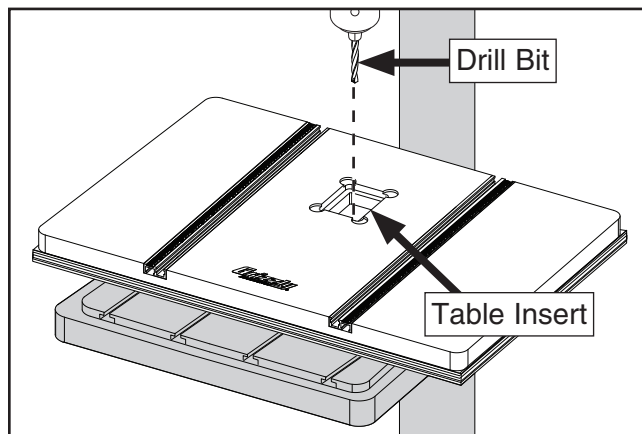


Figure 11. Using drill bit to center Model T32710 table.



7. Remove Model T32710 and use T-slots in drill press table to mark (4) mounting hole locations on plywood (see **Figure 12**).

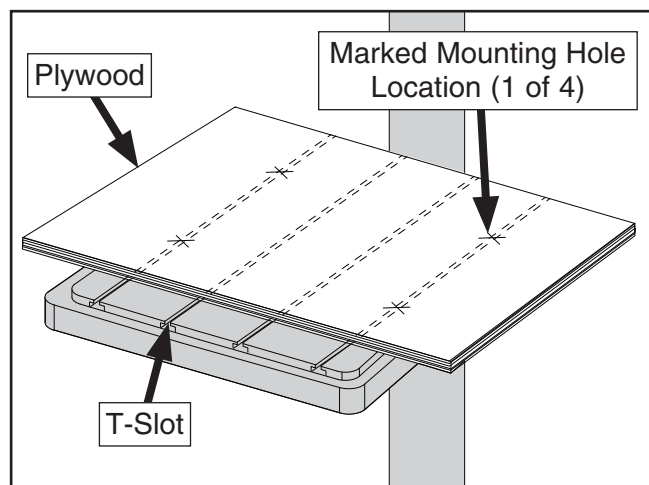
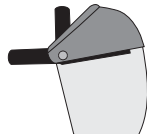


Figure 12. Drill press table mounting holes marked on plywood.

! WARNING

To reduce risk of eye or face injury from flying chips, always wear approved safety glasses and a face shield when operating a drill press or drill.



8. Drill countersunk mounting holes at locations marked in **Step 7** (see **Figure 13**).

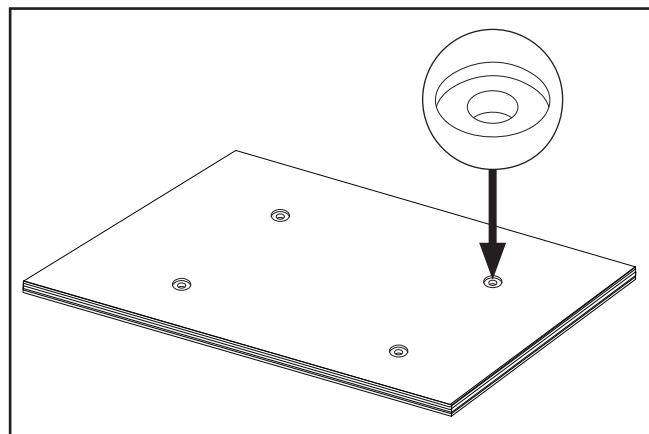


Figure 13. Countersunk mounting holes drilled in plywood.

Note: Drilling these holes is a two-step process. Drill first holes all the way through board with a diameter slightly larger than shaft of mounting screw or bolt. Drill second holes halfway through board with a diameter slightly larger than screw head. Drill these second holes deep enough that screw heads will be well below surface of board.

9. Attach plywood to drill press table with (4) bolts and T-nuts, as shown in **Figure 14**.

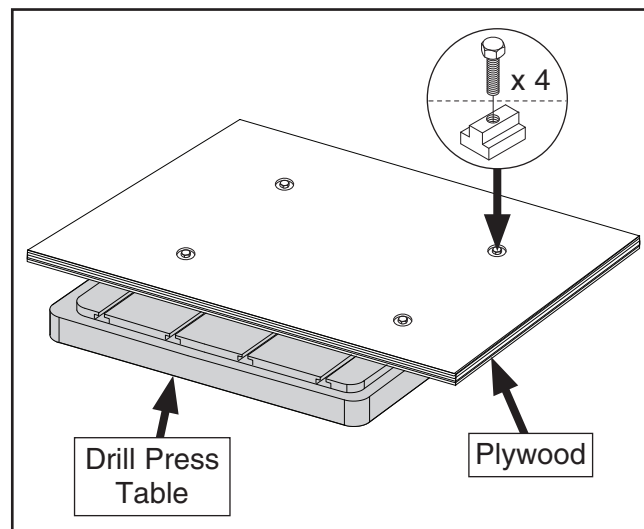


Figure 14. Plywood attached to drill press table.

10. Remove drill press table from drill press and place it facedown on plywood on workbench or table (see **Figure 15**).
11. Mark and drill (4) $\frac{9}{16}$ " mounting holes through plywood around edges of drill press table (see **Figure 15**).

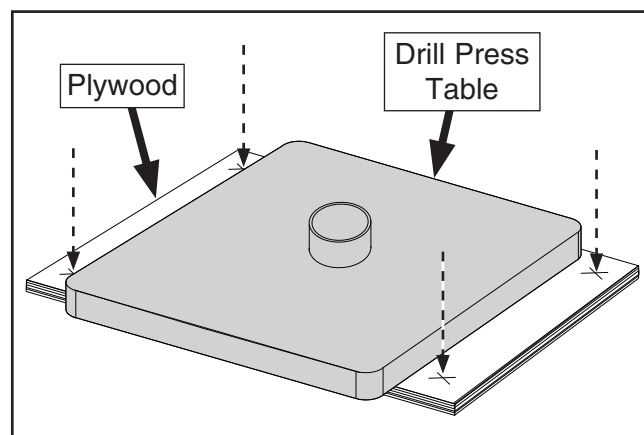


Figure 15. Model T32710 table mounting hole locations on plywood.



12. Place Model T32710 table upside down and under plywood.
13. Line up edges of plywood with Model T32710 table and use holes drilled in **Step 11** to mark and drill $\frac{1}{2}$ " diameter, $\frac{1}{2}$ " deep mounting holes in Model T32710 table (see **Figure 16**).

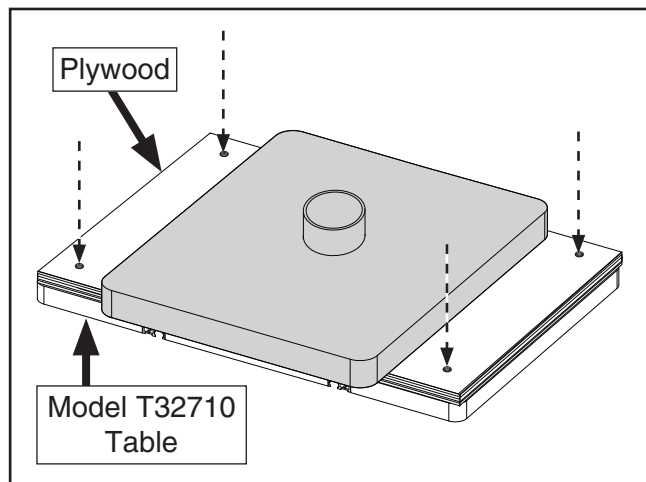


Figure 16. Model T32710 table mounting hole locations.

14. Install (4) $\frac{3}{8}$ "-16, $\frac{9}{16}$ " x $\frac{1}{2}$ " flanged inserts in holes so they are flush with table surface (see **Figure 17**).

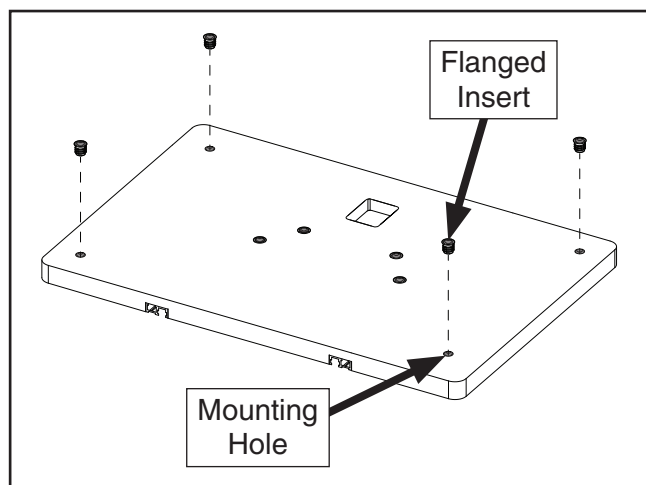


Figure 17. Flanged inserts installed in mounting holes.

15. Use (4) $\frac{3}{8}$ "-16 x 1" knob bolts to secure Model T32710 table to plywood (see **Figure 18**).

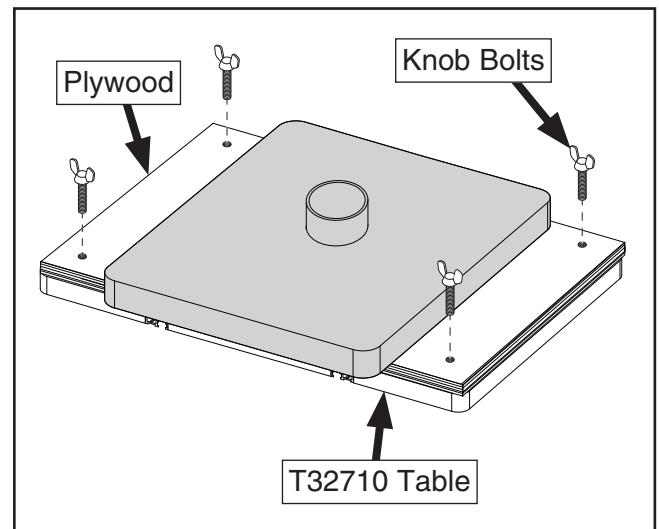


Figure 18. Model T32710 table secured to plywood with knob bolts.

16. Install drill press table on drill press.

Installing Fence

1. Insert (1) $\frac{1}{4}$ "-20 x $\frac{1}{4}$ " T-bolt through hole in each fence bracket and secure with (1) fence lock knob (see **Figure 19**).
2. Secure each fence bracket to fence using (1) 10-24 x $\frac{1}{2}$ " flat head screw (see **Figure 19**).
3. Insert T-bolts into T-slots on table (see **Figure 19**).

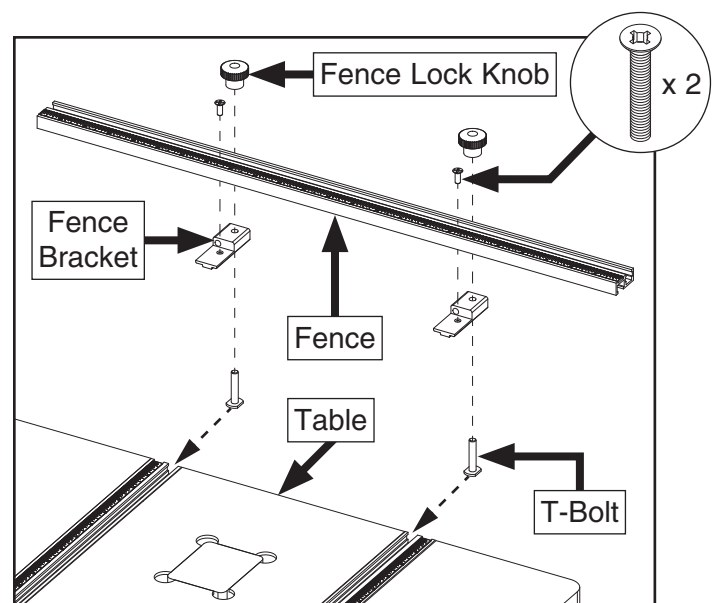


Figure 19. Assembling fence locks on fence.



Installing Flip-Stops

1. Loosen flip-stop lock knob and insert flip-stop T-bolt into T-slot on fence (see **Figure 20**).
2. Pivot flip-stop to side of fence that workpiece will contact, then adjust flip-stop position along fence (see **Figure 20**).

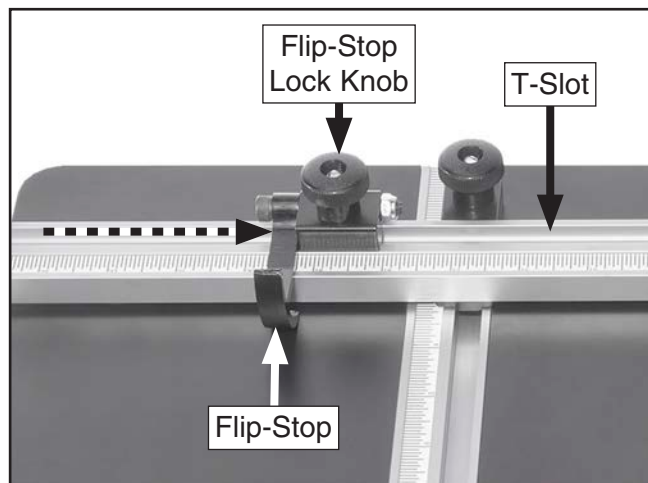


Figure 20. Flip-stop adjustment components.

3. Tighten flip-stop lock knob to secure.

Adjusting Fence

1. Loosen (2) fence lock knobs shown in **Figure 21**.

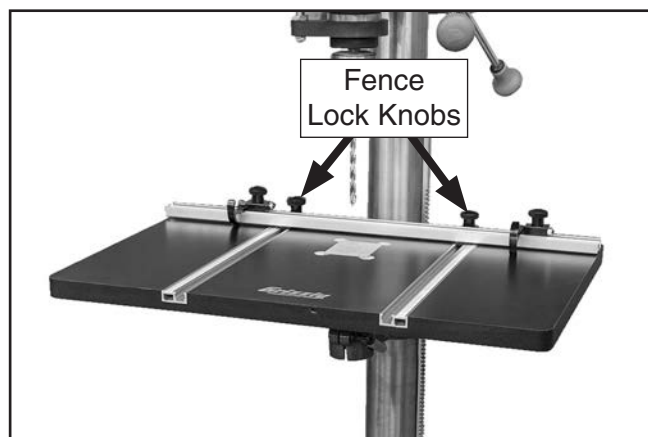


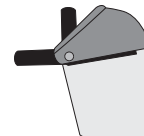
Figure 21. Location of fence lock knobs.

2. Adjust fence to desired position, then tighten fence lock knobs to secure.

Operation Tips

WARNING

To reduce risk of eye or face injury from flying chips, always wear approved safety glasses and a face shield when operating a drill press.



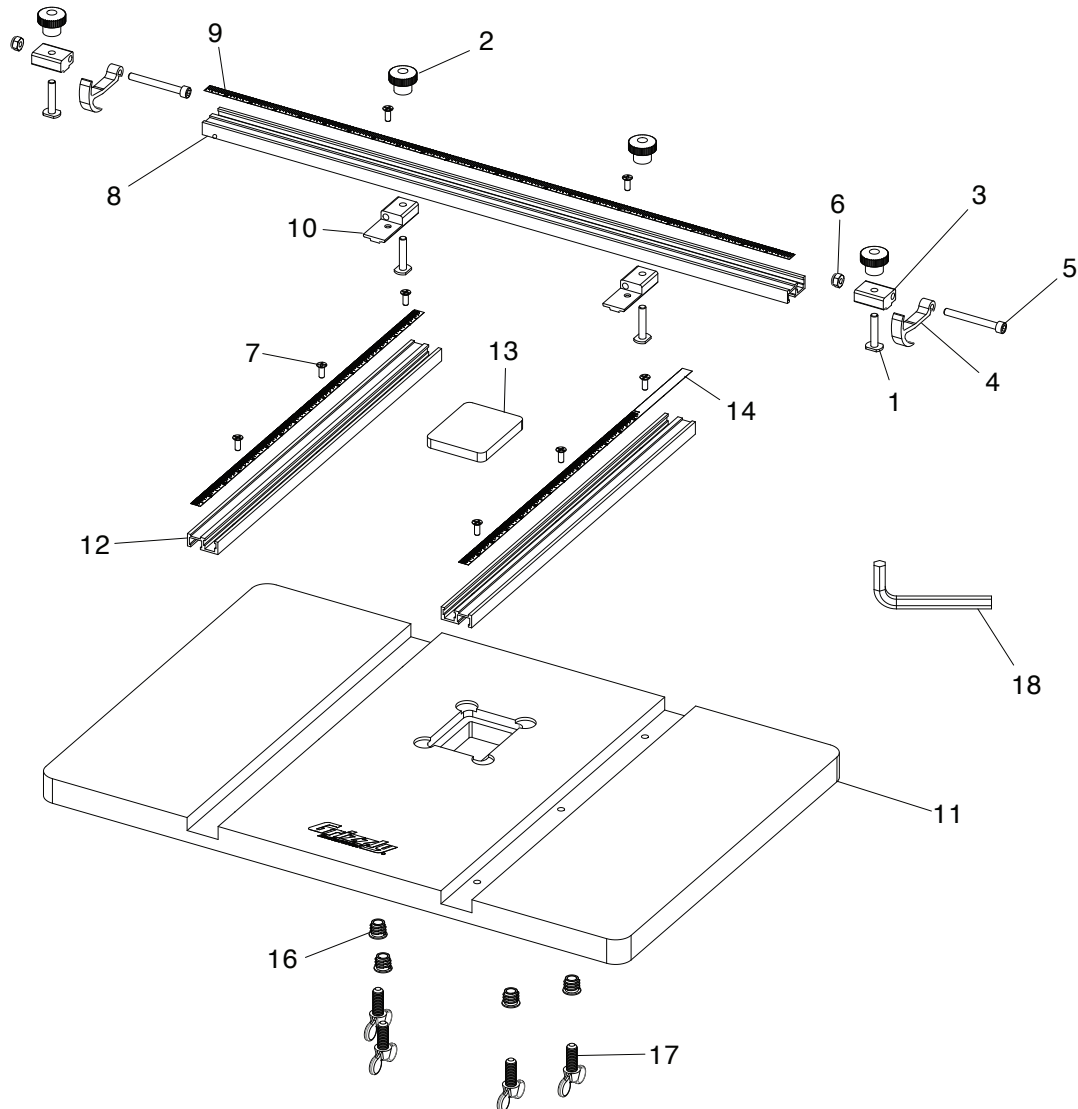
- Periodically verify that the knob bolts used to attach the Model T32710 to the drill press table are snug.
- To avoid drilling in the table, make sure that the drill press depth stop and drill bit alignment are correct.
- Use the table only in dry environments.
- Wipe down workpieces to ensure they are free of debris that may scratch the table.
- The table insert can be removed from the table if you need to perform a through-drilling operation, but it will also minimize tear-out if left in place.

Maintenance

- To avoid condensation and rust forming on your drill press table, do not leave the Model T32710 mounted on the drill press table for long periods of time.
- Clean the Model T32710 by vacuuming out T-slots when finished and wiping down table and fence with any good household glass cleaner.



T32710 Parts Breakdown & List



REF	PART #	DESCRIPTION
1	PT32710001	T-BOLT 1/4-20 X 1-1/4
2	PT32710002	KNOB 1/4-20, 8-LOBE, D1-1/2
3	PT32710003	FLIP-STOP BRACKET
4	PT32710004	FLIP-STOP
5	PT32710005	CAP SCREW M6-1 X 50
6	PT32710006	LOCK NUT M6-1
7	PT32710007	FLAT HD SCR 10-24 X 1/2
8	PT32710008	T-TRACK 604MM
9	PT32710009	FENCE SCALE

REF	PART #	DESCRIPTION
10	PT32710010	FENCE BRACKET
11	PT32710011	TABLE
12	PT32710012	T-TRACK 400MM
13	PT32710013	TABLE INSERT
14	PT32710014	TABLE SCALE
16	PT32710016	FLANGED TAP INSERT 3/8-16, 9/16 X 1/2
17	PT32710017	KNOB BOLT 3/8-16 X 1, D1, WING
18	PT32710018	HEX WRENCH 10MM

Please Note: We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call (800) 523-4777 or visit our online parts store at www.grizzly.com to check for availability.

