

AXMINSTER

PROfessional

Code 111890

Original Instructions

AP25FDVS

Variable Speed Pillar Drill



Fully read manual and safety instructions before use. Save this manual for future reference.



Eye protection should be worn



Ear protection should be worn



Dust mask should be worn



Hazard

The symbols above advise the correct safety procedures when using this machine.

CE
UK
CA



The packaging is suitable for recycling. Please dispose of it in a responsible manner.



EU Countries Only
Do not dispose of electric tools together with household waste material. By law they must be collected and recycled separately.

AT: 29/9/2025
Book Version: 03

Operating Instructions

Dear Customer,

Many thanks for the confidence you have shown in us with the purchase of your new machine. This manual has been prepared for the owner and operators of a **VS drilling machine** to promote safety during installation, operation and maintenance procedures. Please read and understand the information contained in these operating instructions and the accompanying documents. To obtain maximum life and efficiency from your machine, and to use the machine safely, read this manual thoroughly and follow instructions carefully.

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1. Warranty

TOOL guarantees that the supplied product(s) is/are free from material defects and manufacturing faults.

This warranty does not cover any defects which are caused, either directly or indirectly, by incorrect use, carelessness, damage due to accidents, repairs or inadequate maintenance or cleaning as well as normal wear and tear.

2 Safety

2.1 Warnings

- Misuse of this machine can cause serious injury.
- For safety, machine must be set up, used and serviced properly.
- Read, understand and follow instructions in the Operating Instructions and Parts Manual which was shipped with your machine.

When setting up machine:

- Always avoid using machine in damp or poorly lighted work areas.
- Always be sure the machine support is securely anchored to the floor or the work bench.

When using machine:

- Always wear safety glasses with side shields
- Never wear loose clothing or jewelry.
- Never overreach—you may slip and fall.

When servicing machine:

- Always disconnect the machine from its electrical supply while servicing.
- Always follow instructions in Operating Instructions and Parts Manual when changing accessory tools or parts.
- Never modify the machine without consulting .

You—the stationary power tool user—hold the key to safety.

Read and follow these simple rules for best results and full benefits from your

machine. Used properly, machinery is among the best in design and safety. However, any machine used improperly can be rendered inefficient and unsafe. It is absolutely mandatory that those who use our products be properly trained in how to use them correctly. They should read and understand the Operating Instructions and Parts Manual as well as all labels affixed to the machine. Failure in following all of these warnings can cause serious injuries.

2.2 Machinery General Safety Warnings

1. Always wear protective eye wear when operating machinery. Eye wear shall be impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specifications. Use of eye wear which does not comply with ANSI Z87.1 specifications could result in severe injury from breakage of eye protection.
2. Wear proper apparel. No loose clothing or jewelry which can get caught in moving parts. Rubber soled footwear is recommended for best footing.
3. Do not overreach. Failure to maintain proper working position can cause you to fall into the machine or cause your clothing to get caught, pulling you into the machine.
4. Keep guards in place and in proper working order. Do not operate the machine with guards removed.
5. Avoid dangerous working environments. Do not use stationary machine tools in wet or damp locations. Keep work areas clean and well lit.
6. Avoid accidental starts by being sure the start switch is "OFF" before plugging in the machine.
7. Never leave the machine running while unattended. Machine shall be shut off whenever it is not in operation.

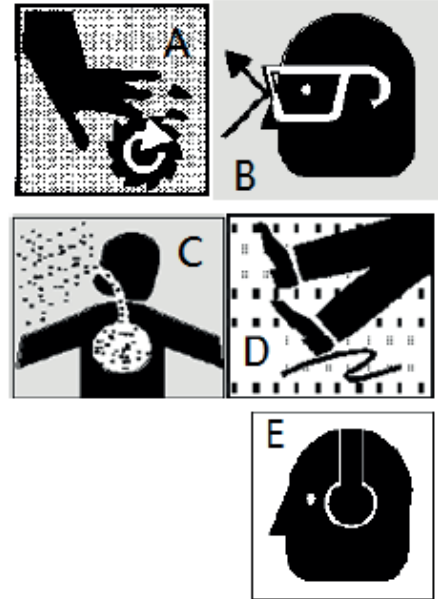
8. Disconnect electrical power before servicing. Whenever changing accessories or general maintenance is done on the machine, electrical power to the machine must be disconnected before work is done.
9. Maintain all machine tools with care. Follow all maintenance instructions for lubricating and the changing of accessories. No attempt shall be made to modify or have makeshift repairs done to the machine. This not only voids the warranty but also renders the machine unsafe.
10. Machinery must be anchored to the floor.
11. Secure work. Use clamps or a vise to hold work, when practical. It is safer than using your hands and it frees both hands to operate the machine.
12. Never brush away chips while the machine is in operation.
13. Keep work area clean. Cluttered areas invite accidents.
14. Remove adjusting keys and wrenches before turning machine on.
15. Use the right tool. Don't force a tool or attachment to do a job for which it was not designed.
16. Use only recommended accessories and follow manufacturer's instructions pertaining to them.
17. Keep hands in sight and clear of all moving parts and cutting surfaces.
18. All visitors should be kept at a safe distance from the work area. Make workshop completely safe by using padlocks, master switches, or by removing starter keys.
19. Know the tool you are using — its application, limitations, and potential hazards.

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 or even fatal injury.

1. All work shall be secured using either clamps or a vise to the drill press table. It is unsafe to use your hands to hold any workpiece being drilled.
2. Drill press head and table shall be securely locked to the column before operating the drill press. This must always be checked prior to starting the machine.
3. Always use the correct tooling. Tooling shall always be maintained and properly sharpened. All tooling must be run at the proper speeds and feeds as they apply to the job. Use only recommended accessories and follow those manufacturer's instructions pertaining to them. Tooling shall not be forced in to any work piece but fed according to the proper specifications. Failure to follow these instructions will not only ruin the tooling as well as the machine, but can cause serious injury.
4. Never brush away any chips while the machine is in operation. All clean up should be done when the machine is stopped.
5. Keep hands in sight. Do not put hands or fingers around, on, or below any rotating cutting tools. Leather safety gloves should be used when handling any sharp objects or cutting tools. See Figure A.
6. Always wear protective eye wear when operating, servicing or adjusting machinery. Eyewear shall be impact resistant, protective safety glasses with side shields. Figure B.
7. When drilling in material which causes dust, a dust mask shall be worn. See Figure C.
8. Avoid contact with coolant, especially guarding the eyes.
9. Non-slip footwear and safety shoes are recommended. See Figure D.
10. Wear ear protectors (plugs or muffs) during extended periods of operation. See Figure E.



3.3 Safety Instructions for Drill Presses

3. Machine specifications

3.1 Technical data

ZS1720B-VS:

Drilling Capacity Mild Steel	20mm
Tapping Capacity Mild Steel	M12
Chuck Size...B16	1-16mm
Spindle Travel	100mm
Distance Spindle to Base	540mm
Distance Spindle to Table (max)	300mm
Table Size	283×248mm
Table Travel	224mm
Table Tilt	± 45 °
Work Table Weight Capacity	60kg
Head Travel	345mm
Spindle Taper	MT-2
Column Diameter/ Material	Ø70mm / Cast Iron
Number of Spindle Speeds	Variable
Pulleys Material	Cast Iron
Spindle Speeds Range	0-2100RPM
Base Size	345×520mm
Base Work Area	258×275mm
Spindle Distance to Column	203mm
Net weight	96 kg
Mains	400V ~3L/PE 50Hz
Output power	0,55 kW S1
Reference current	1,8A
Extension cord :	4G0.75mm ²
Installation fuse protection	10A

ZS1725F-VS:

Drilling Capacity Mild Steel	25mm
Tapping Capacity Mild Steel	M12
Chuck Size...B16	1-16mm
Spindle Travel	100mm
Distance Spindle to Base	1160mm
Distance spindle to Table (max)	850mm
Table Size	320×320mm
Work Table Weight Capacity	60kg
Spindle Taper	MT-2
Column Diameter/ Material	Ø80mm / Steel Tube
Number of Spindle Speeds	Variable
Pulleys Material	Cast Iron
Spindle Speeds Range	50-2100RPM
Base Size	600×385mm
Spindle Distance to Column	196mm
Net weight	115 kg
Mains	400V ~3L/PE 50Hz
Output power	0,55 kW S1
Reference current	1.8A
Extension cord (H07RN-F):	4G1,0mm ²
Installation fuse protection	10A

3.2 Noise emission

Acoustic pressure level (EN 11202):

Idling at maximum speed 75 dB (A)

The specified values are emission levels and are not necessarily to be seen as safe operating levels.

As workplace conditions vary, this information is intended to allow the user to make a better estimation of the hazards and risks involved only.

3.3 Content of delivery

B16 1-16mm drill chuck with arbor
Head rising crank and handle
Operating tools
Operating manual
Spare parts list.

4. Transport and start up

4.1 Transport and installation

The machine will be delivered in a reliable carton

For transport use a forklift or hoist.

Make sure the machine does not tip or fall off during transport.

Danger of tipping due to high gravity center!

During handling, the machine shall be lifted only in vertical direction.

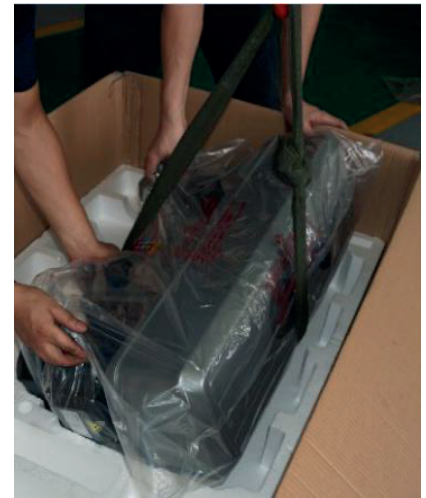
Please refer to instruction manual in specification and machine weight to arrange handling manner. Be sure to use capable fork - lifter or hoist to lift of machine. The handling and transportation shall be carried out by qualified persons. Fork - lift or hoist can be used in handling and shall be operated by qualified driver.

Before handling, make sure all movable parts are secured in their position and all movable accessories should be removed from machine. The steel rope should average pull the machine head, table and column tightly.

Keep all the processes in a carefully and slightly condition. Bump or crash are strictly prohibited. It will cause precision shift and electronic controller damaged.

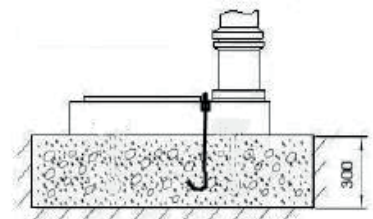
4.2 Positioning the Machine

- Owing the machine is heavy, please use crane to pull it out from the carton box.



- The head and the worktable of the machine can be rotated 360°, so choose a location with enough space and solid foundation.
- Clean all rust protected surfaces with a mild solvent e.g. petroleum.

4.3 Anchoring the Machine



Assure the sufficient load capacity and proper condition of your lifting devices.

- Position the machine on a firm and level concrete floor.

- II. A minimum distance of 800mm towards a rear wall must be kept (for access to the electrical box).
- III. Anchor the machine to the ground, as shown in the diagram, using screws and expansion plugs or sunken tie rods that connect through holes in the base.

4.4 Minimum Requirement for Housing the Machine

Please comply with the following terms to maximize the life and performance of the machine and its components.

The Main voltage and frequency complying with the requirements for the machine's motor.

Environment temperature from -10°C to +50°C.

Relative humidity not over 90%.

4.5 Assembling Loose Parts

Attach Riser handle to the necessary crankshaft, and use Hex-wrench to tighten/loosen the machine head lock nut.

4.6 Electrical Connection of the Machine

Make sure whether the voltage 400V matches the requirement for the machine, prior to connection to power supply. If the machine cannot be operated after wires have been connected, please check the following items:

- I. Is the Emergency switch released?
- II. Is the door of the electrical cabinet properly closed and switched ON (locked) position?
- III. Is the safety guard in the proper position (closed)?

5. Machine operation

Warning:

Setup work may only be carried out after the machine is protected against accidental starting.

With pressed emergency stop button.

Never place your fingers in a position where they could contact any rotating tool, chuck or cutting chips.

Remove cutting chips with the aid of an appropriate chip hook when the machine is at a standstill only.

Never stop the rotating chuck or tool with your hands.

Always close the chuck guard and pulley cover before you start the machine.

Secure workpiece to the table with clamps or a vice to prevent rotating with the drill bit.

When using a vice, always fasten it to the table.

Check the save clamping of the workpiece, chuck and tools before starting the machine.

Never do any works "freehand" (hand-holding the work piece rather than supporting it on the table).

Support long workpieces with helping roller stands.

Always adjust the depth stop to prevent drilling into the table or into the worholding device.

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

Do not use wire wheels or grinding wheels on this machine.

Never cut magnesium-
high danger to fire!

Measurements and adjustments may be carried out when the machine is at a standstill only.

In case of danger push the emergency stop button.

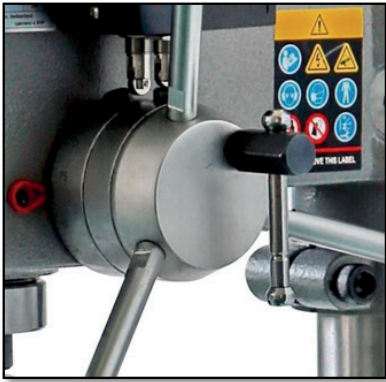
6.1 Controls



- A. Spindle ON Switch: Starts the motor.
- B. Spindle OFF Switch: Stops the motor. As the power still exists, pressing ON restarts the machine.
- C. Emergency Stop Switch: Stops the machine. Turn the switch clockwise to unlock the switch before starting the machine.
- D. Drilling/Tapping Selector: Selects the mode of operation
- H. RPM Display: Displays the rate of spindle rotation in RPM.
- F.Speed control button: Change the speed of the spindle.
- I. Laser light (optional accessory)
- L. LED light (optional accessory)
- J. Indicator light

Change speeds only while the machine is running. Then spindle speed can be adjusted to the proper cutting RPM by using the spindle speed handle (F in figure). The spindle speed ranges is from 100 to 2100 rpm.

5.2 Depth Indicator



A drilling depth indicator is provided on the side of the drill head. The lock knob is provided at the side, on the top of quill lever.

Before starting the motor:

- I. Set the depth to zero by lowering and holding the cutting tools to the surface of the work piece. Use quill lever to lower the spindle.
- II. Unlock the depth scale by turning the lock knob.
- III. Set the depth stop by rotating the depth stop stud to the desired depth.
- IV. Lock the depth scale by turning the lock knob.

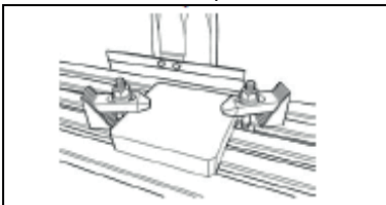
5.3 Operation Cycle

Safety chuck guard must be in position, electric box must be closed and locked, and unlock emergency stop switch (C) by turning the red cap of the switch clockwise to start machine. In a critical condition, stop machine by hitting emergency stop switch or Spindle OFF switch (B) to stop machine.

1. Check if the head is secured.

Failure to secure the head can result in damage of the machine and personal injury.

2. Secure the work piece to the table.



3. Use crankshaft to adjust the table to the desired height.



4. Use lock-lever to secure the table.
5. Use the spindle/quill feed lever to bring the drill or tapping tip down to the surface of the work piece and hold.
6. Set the depth indicator/stop to required depth.



7. Back the drill or tapping tip off the work piece a bit.
8. Select drilling or tapping mode.
9. Press Spindle ON switch to begin spindle rotation.

In Drilling Mode



10. Use the depth handle to bring the tip of the drill bit to the surface of the work piece hold.
11. The required depth is set by previous steps 5 and 6.
12. Select proper speed.
13. Begin drilling by using the quill feed lever.

In Tapping Mode



In general, speeds for tapping require low speed which is lower than 200 rpm.

14. Use the depth handle to bring the tip of the tapping bit to the surface of the work piece and hold.
15. The required depth is set by previous steps 5 and 6.
16. Select the spindle speed.
17. Begin tapping by using the quill feed levers.
18. At the end of a tapping or drilling operation, press the stop button switch to turn off the machine.

Note: While tapping, pause spindle down feed at the bottom of operation to allow the breaking and reversal of rotation of the spindle.

In general, use low speeds for tapping. Tapping at high speed will tap more quickly, **but there is a danger of damage to work piece and tool.**

Tapping requires an accurate setting for the depth stop to allow the machine to switch tapping direction and the removal of the tapping bit.

6.4 Choosing the spindle speed

The correct spindle speed depends on the type of machining, the workpiece material as well as the tool diameter and material.

The speed recommendations apply to a tool diameter of 10mm and a machining with a high-speed steel (HSS) tool (e.g. spiral drill).

Aluminum, brass 1500 rpm

Grey cast iron: 1000 rpm

Steel (C15): 800 rpm

Steel (C45): 600 rpm

Stainless steel: 300 rpm

When using a carbide (HM) tool, approx. 5 times the speed is permissible.

Generally speaking:

In proportion, the larger the rotation diameter, the lower the possible speed.

For example:

Steel (C15) with 20mm diameter allows a speed of

400 rpm with HSS tool

2000 rpm with HM tool

6. Machine Adjustment

6.1 Adjusting the table & Rack Height

The table can be raised, lowered, and tilted with desired angles to accommodate the work piece.

To raise or lower the table, loosen the lever-locks behind the table bracket, then use the hand crank to move the table to the desired height. Then lock the table in position.



Note: Only the work table of ZS1720B-VS and ZS2025B-VS has tilting function.

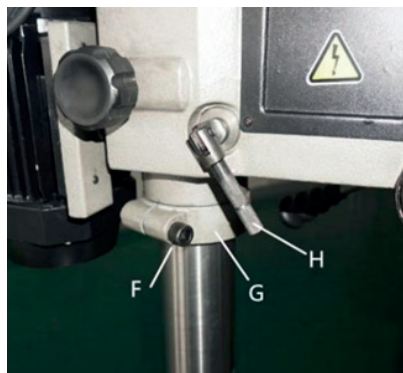
To tilt the table, loosen the nut first to adjust the table to desired angle, then lock the table in position.



6.2 Adjusting the Headstock Height

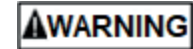
Note: Only ZS1720B-VS and ZS2025B-VS has headstock height adjusting function.

1. Cut off the power before this operation.
2. Open the pulley cover.
3. If the machinery object is out of loading ability of work table, it can be set on the base. Then adjust the headstock height along the column to make sure the working range of machinery be proper.



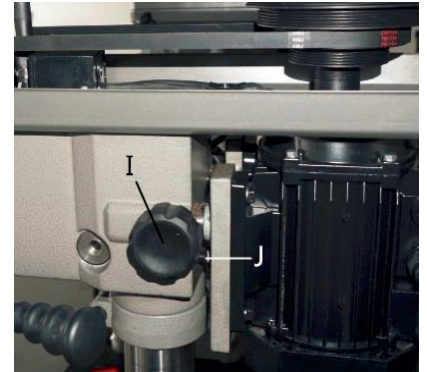
4. Please make sure the handle (H) is tightened.
5. Loose the tightening bolt (F) first, and adjust the retaining ring (G) to preferred height, then go tighten the bolt again.
6. Carefully loose the handle (H) to let the headstock slowly come down to be against the retaining ring, then tightened the handle (H) again.
7. If the headstock need to be at higher position, please carefully lift it up because the severe heaviness after loosening the locking handle (H). And make sure the retaining ring (G) be settled to be against the headstock properly.

6.3 Radial Head Position Adjustment



Change the radial position of the drill head only if the drill press base is secured to the floor. Swinging the drill head without the base being secured to the floor will cause the drill press to become unstable and tip over resulting in injury and/or damage to the machine.

7.4 Belt adjustment



1. Cut off the power before this operation.
2. Open the pulley cover.
3. Loosen "I" and "J" to free the motor.
4. Change the location of the belt based on the speed chart.
5. Manually push/pull out the motor along the motor rods then tighten the bolts (J) to be against the motor bracket to tension the belt.

Note: Belt tension should be loose enough to allow 5-10mm movement when pushing the belt from the side.

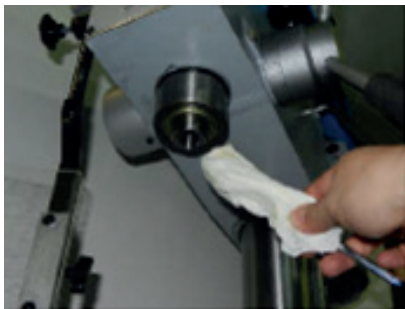


6. Put back the pulley cover then tighten the fastening bolt.

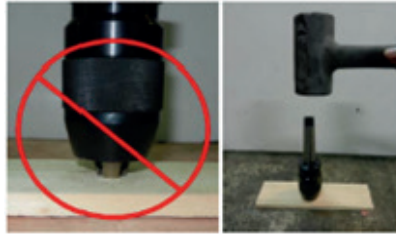
6.5 Tool installation and Uninstallation



1. Clean the drill chuck, arbor and spindle taper thoroughly before installation. Any insufficient cleaning on mating surfaces may cause drill loosen as operating and unsafe conditions.



2. Place a thin wood plank on the worktable to protect the surface of the worktable and chuck drill. Draw back the chuck nose into chuck body and slightly hit the arbor onto the chuck by rubber hammer.



3. Slide the assembled drill chuck and arbor into spindle taper, and slightly hit them by rubber hammer to fit in.



4. Sequentially tighten "K" and "L"



5. Lower the spindle about 100 mm.
6. Place the drift key into the aperture of the quill and tap the end of the drift key with a hammer until the bit or chuck arbor falls down.

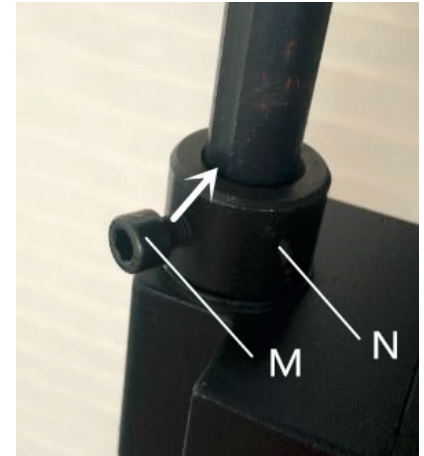


6.6 The Spindle Shield

This clear plastic shield should be used whenever conducting a drilling or tapping operation. Clean the safety guard periodically to provide a clear view of the work piece. Adjustments can be done as follows.

1. Adjust the internal cover shield to have better range protection.
2. If both internal and external shields cannot provide enough protection, loosen locking bolt (M) to shift setting ring (N) in proper position.

Note: make sure the bolt (M) aligning to the groove (aimed by the arrow), otherwise the Interlock switch would not be triggered when the shields being opened.



7. Operating Precautions

The following operating and safety precautions must be observed in order to avoid harm to the operator or damage to the drill press.

1. Make sure the power voltage is for the machine. Before connecting the plug to socket, it is necessary to check the power spec. to avoid any damage occurring.
2. If the machine is not used for a long time, the plug should be disconnected.
3. Never put the power cable near the fire or water environment, to break or press the power cable is not allowed.
4. The head assembly must be locked to the column so the thrust produced by drilling will not force the head assembly up the column.
5. The work table must be locked to the column so it will not be forced down the column.
6. Before drilling, release the quill lock nut to permit free travel of the quill.
7. Be sure the belt is tightened to the proper tension.
8. DO NOT start to drill the work piece until making certain the work piece is held down securely.

9. Make sure the power being off when changing the belt for shifting speed.
10. Point of operation protection is required for maximum safety. This remains the responsibility of the user/purchaser since conditions differ between jobs.
11. Make sure the drill is secured in the spindle or chuck before attempting to use the drill press.
12. Make sure the spindle taper is clean and free of burrs, scoring, and galling to assure maximum gripping.
13. Lock the quill in position when using any side-loaded tool.

8. Maintenance

Lubrication and Routine Maintenance

Apply oils to the driving parts of the machine prior to operation and supply coolant during operation to ensure stability of cutters and the object being processed. Please refer to the lubrication as below for more details about use oil. To extend your machine life, please make a maintenance schedule daily, weekly, monthly or semi-annual and annual. Neglecting the machine maintenance will result in premature wear and poor performance.

1. **Lubrication**
 - I. Lubricate - Column, Quill. Use machine tool oil with light film of oil.
 - II. Grease - Rack on the column so that the worktable can move up/down smoothly. Use SAE 20 oil. To clean rack with kerosene before applying oil.
2. **Daily Maintenance**

Make a general cleaning by removing dust and shavings from the machine.

Check that the shields and emergency stops are in good working order.

After daily use, disconnect machine from power source or press emergency stop switch to shut off the power completely. Do not keep the machine connected over 24 hours, it may cause damage to the machine.

3. **Weekly Maintenance**
Clean the machine.
4. **Monthly Maintenance**
Lubricate machine column, spindle and rack devices.
Check that all screws on the motor and the guard are tight and secured on the right position.
5. **Annual Maintenance**
Replace the driving belt by using: 530J
6. **Oils for Lubricating Coolant**
Considering the vast range of products in the market, the user can choose the one most suited to their own requirements, using as reference the type SHELL LUTEM OIL ECO.
The minimum percentage of oil diluted in water is 8~10%.
7. **Oil Disposal**
Oil products must be disposed in a proper manner following local regulations.
8. **Special Maintenance**
Special maintenance operations must be carried out by skilled personnel. However, we advise contacting dealer and/or importer the term special maintenance also covers the resetting of protection and safety equipment and devices.

9. Environmental protection

Protect the environment.

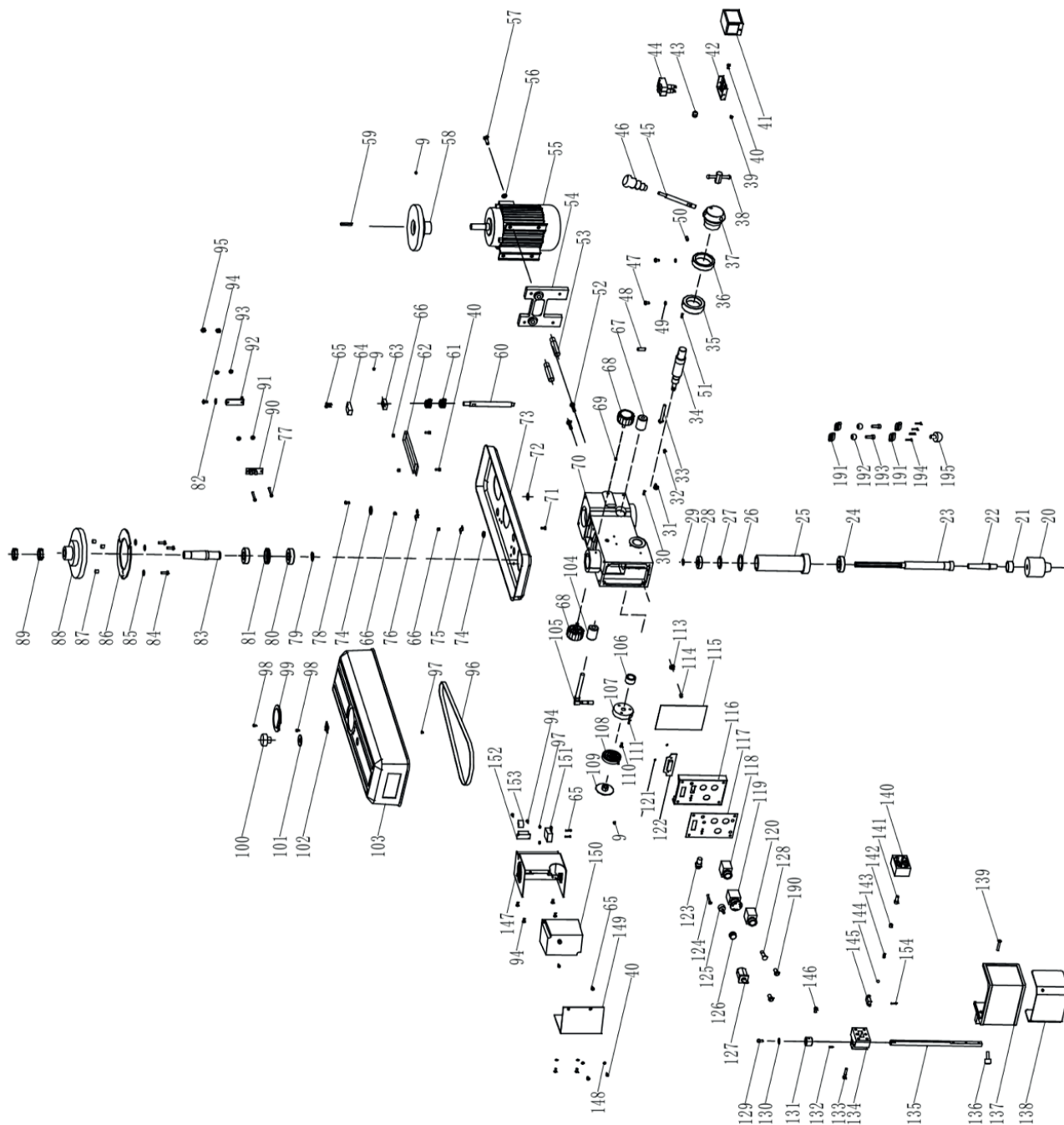
Your appliance contains valuable materials which can be recovered or recycled. Please leave it at a specialized institution.



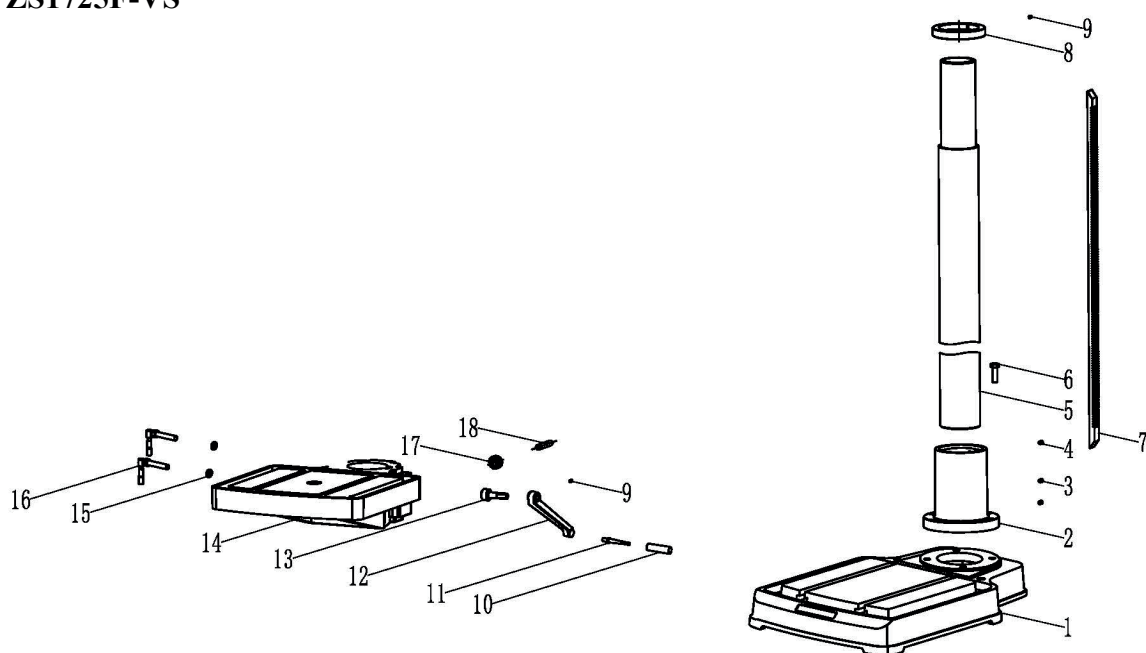
This symbol indicates separate collection for electrical and electronic equipment required under the WEEE Directive (Directive 2012/19/EC) and is effective only within the European Union.

10. Available accessories

Refer to the Pricelist for various accessories.



ZS1725F-VS



Parts List for Breakdown – (1/4)

Index No.	Part No.	Description	Qty.
1.....	S2001001	Base.....	1
2.....	S1601002-03.....	Column support	1
3.....	PIN8X30GB879.1B	Pin	1
4.....	M8X10GB80B.....	Hexagon socket setting screws	2
5.....	S1601003-03.....	Column (#98)	1
6.....	M12X40GB5781B.....	Hexagon bolt	4
7.....	S1601010	Rack.....	1
8.....	S1601011	Rack collar	1
9.....	M6X8GB80B.....	Hexagon socket setting screws	5
10.....	1501009-2.....	Crank arm handle grip.....	1
11.....	1501009-3.....	Crank arm handle shaft.....	1
12.....	1901009-1.....	Crank arm shaft.....	1
13.....	1901008.....	Worm shaft	1
14.....	S1601014-01	Table.....	1
15.....	BRG51102GB301	Thrust bearing.....	2
16.....	S1401012	Bracket locking handle assembly	2
17.....	1501006.....	Helical gear.....	1
18.....	S1601019	Gear pin.....	1
20.....	1-16mm ZB16	Chuck.....	1
21.....	S1603004	Arbor locking nut.....	1
22.....	MT2-B16-T	Arbor	1
23.....	S1603001	Spindle.....	1
24.....	BRG6205-2RSGB276	Bearing.....	1
25.....	S1603002	Quill	1
26.....	1703006.....	Washer.....	1
27.....	D40GB7590B.....	Spring washer.....	1
28.....	BRG6203-2RSGB276	Bearing.....	1
29.....	CLP20GB894.1B	Shaft ring.....	1
30.....	PIN4X16GB879.1.....	Pin	1
31.....	1506003-01.....	Pointer.....	1
32.....	M4X8GB818B.....	Cross pan head screw.....	1
33.....	S1604012	Locking bolt	1
34.....	S1604002	Gear shaft.....	1
35.....	S1604003G.....	Collar Depth stop	1
36.....	S1604014G.....	Locking ring	1
37.....	S1604001G.....	Hub.....	1
38.....	S1604004	Fixed depth locking assembly	1
39.....	ST4.2X9.5GB845Z.....	Self-tapping screw.....	2
40.....	M5X12GB973Z.....	Cross recessed oval head screw.....	2
41.....	S2002013	Travel switch cover	1
42.....	S2002012	Travel switch base.....	1
43.....	S1609030	Protective rubber sleeve	1
44.....	YBLXW-5/11Q1	Travel switch	2
45.....	S1604005G.....	Handle.....	3
46.....	1504011-03.....	Ball knob.....	3
47.....	S1607005	Depth pin.....	2
48.....	PIN8X35GB879.1B	Pin	1
49.....	S1609031	O Ring.....	1
50.....	M5X6GB80B.....	Hexagon socket set screw	1
51.....	PIN4X16GB119.1B	Cylinder pin	1
52.....	M10X35GB5781B.....	Hexagon bolt	2
53.....	S1602003	Motor rod.....	2

Parts List for Breakdown – (2/4)

Index No.	Part No.	Description	Qty.
54.....	S1602007	Motor base.....	1
55.....	T-0.55-380/220-80-6P	Motor	1
56.....	WSH8GB97.1B	Washer	4
57.....	M8X30GB5781B.....	Hexagon bolt	4
58.....	S1605005-01	Motor pulley	1
59.....	PIN8x7x45GB1096	Pin	1
60.....	S1607002	Rod	1
61.....	S1609010	Cramp.....	2
62.....	110W 400 Ω	Resistance	1
63.....	S1606014	Magnetic switch base.....	1
64.....	LIC1-3/24	Magnetic switch	1
65.....	M4X16GB818B.....	Cross pan head screw.....	8
66.....	M5GB6170B.....	Nut	6
67.....	S1602005	Right clamp block.....	1
68.....	S1609007	Motor locking button	2
69.....	M6X10GB80B.....	Hexagon socket set screw	1
70.....	S1602001-VS.....	Headstock.....	1
71.....	M5X16GB973Z.....	Cross recessed oval head screw	4
72.....	0805009	Foam pad	6
73.....	S1605002-01	Cover	1
74.....	1905010	Line protecting	4
75.....	1502014	Cable clamp.....	3
76.....	1502014-02.....	Cable clamp.....	3
77.....	M3X14GB818B.....	Cross recess pan head screw.....	2
78.....	M5X12GB9074D1Z	Cross pan head with cushion screw	6
79.....	CLP30GB894.1B	Shaft ring.....	1
80.....	BRG6205-2RSGB276	Bearing	2
81.....	S1602023	bearing spacer.....	1
82.....	WSH4GB93B	Spring washer.....	1
83.....	S1602022	Splined.....	1
84.....	M6X16GB973Z.....	Cross recessed oval head screw	3
85.....	WSH6GB93B	Spring washer.....	3
86.....	S1604015	Digital display chuck.....	1
87.....	1009005	Padding block.....	3
88.....	S1605009-01	Spindle pulley.....	1
89.....	M24X1.5GB810B.....	Small round nut.....	2
90.....	CB07-5L.....	Sensor	1
91.....	1308004	Heighten block	2
92.....	1304019	Speed measuring base	1
93.....	WSH3GB97.1B	Washer	2
94.....	M4X12GB973Z.....	Cross recessed oval head screw	1
95.....	M3GB6170Z.....	Nut	2
96.....	460J.....	Poly V belt	1
97.....	M4GB6170Z.....	Nut	6
98.....	M4X12GB973Z.....	Cross recessed oval head screw	4
99.....	S1605003	Cover plate	1
100.....	S1605008	Round handle	1
101.....	WSH12GB96.1B	Washer	1
102.....	S1605004	Hinge	1
103.....	S1605001	Cover	1
104.....	S1602004	Left clamp block	1
105.....	S1602015	Headstock locking handle assembly.....	1
106.....	S1604006	Supporting sleeve.....	1
107.....	S1604008-01	Spring cover	1
108.....	S1604009	Coil spring.....	1
109.....	S1604007-01	Spring cover	1

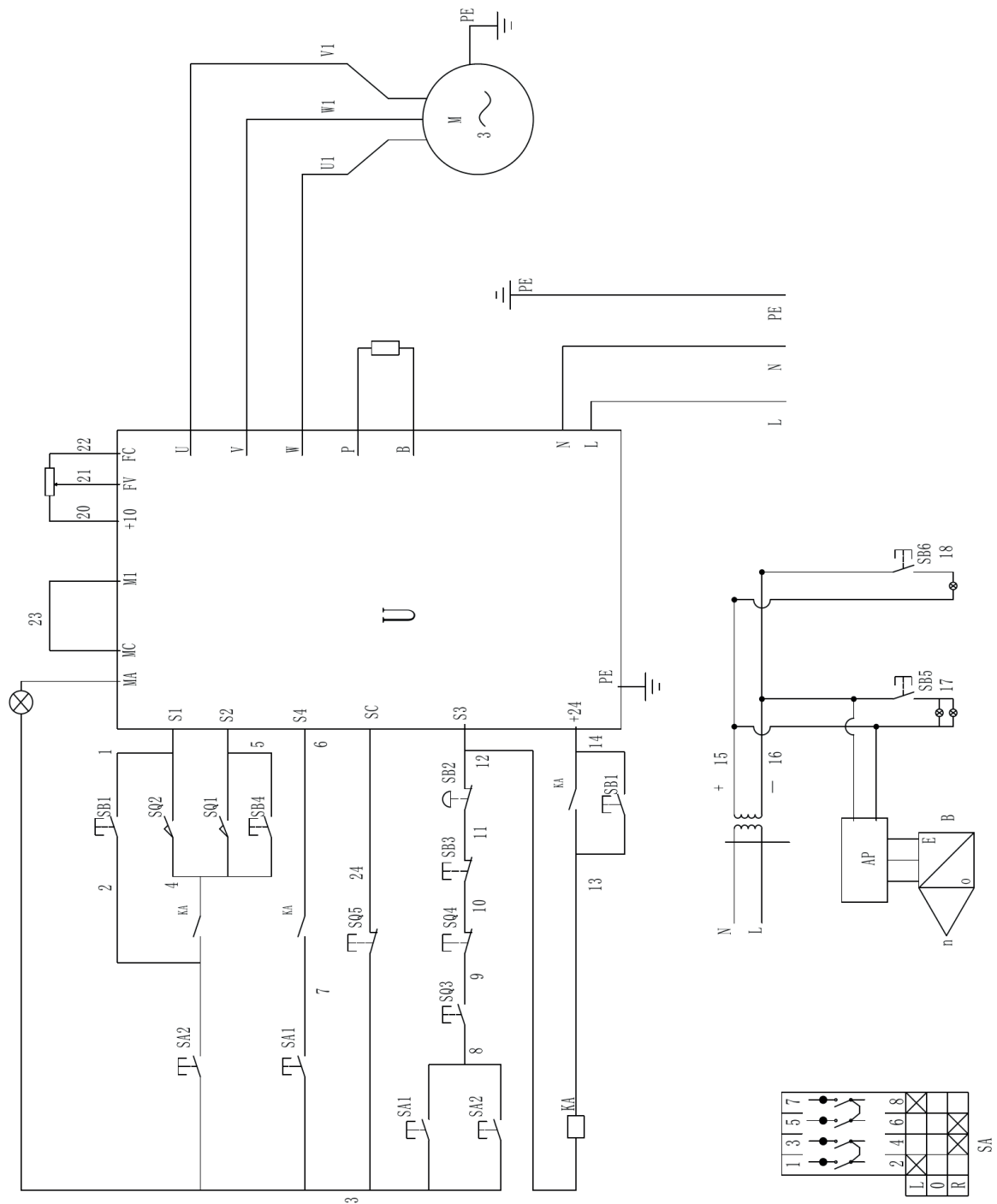
Parts List for Breakdown – (3/4)

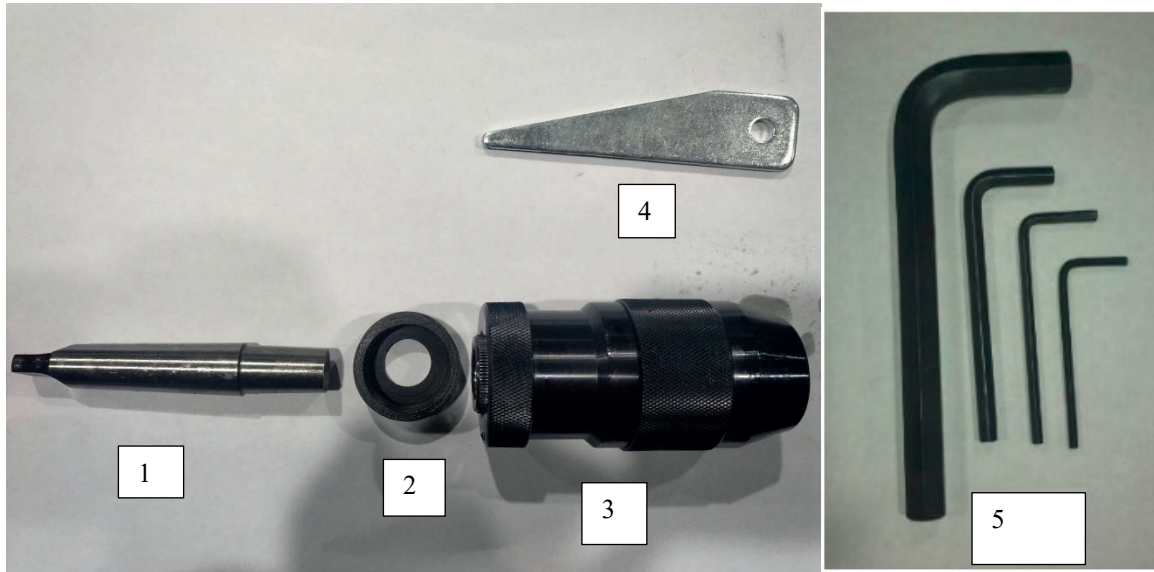
Index No.	Part No.	Description	Qty.
110.....	M5X12GB973Z.....	Cross recessed oval head screw.....	3
111.....	PIN6X10GB879.1.....	Pin.....	1
113.....	M8GB6172B.....	Thin nut.....	1
114.....	M8X16YJT4023B.....	Hex socket bead set screw.....	1
115.....	S1602011.....	Insulation paper.....	1
116.....	S1602008-03.....	Switch panel (gray).....	1
117.....	S1606101-03.....	Switch position plate.....	1
118.....	LA115-A5-100BN.....	Start switch (double row).....	1
119.....	LA115-A5-01ZS.....	Emergency stop switch.....	1
120.....	LA115-A5-01BN.....	Stop switch.....	1
121.....	ST2.2X4.5GB845.....	Self-tapping screw.....	2
122.....	CB07-12B.....	Digital readout.....	1
123.....	K16-211.....	Button switch.....	1
124.....	M5X40GB973Z.....	Cross recessed oval head screw.....	4
125.....	B103-Y.....	Potentiometer (cylinder).....	1
126.....	B103-M.....	Potentiometer cap.....	1
127.....	LW26-10.....	Transfer switch.....	1
128.....	ZSD24VDC-G.....	Indicator green DC.....	1
129.....	M6X12GB70.1B.....	hexagon socket cap screws.....	1
130.....	WSH6GB96.1B.....	Wasjer.....	1
131.....	S1607003.....	Chuck guard lock knob.....	1
132.....	PIN3X10GB879.1B.....	Pin.....	1
133.....	M6x35GB70D1B.....	hexagon socket cap screws.....	4
134.....	S1609004.....	Chuck guard micro switch base.....	1
135.....	S1607004.....	Chuck guard rod.....	1
136.....	1509006.....	Chuck guard lock bolt.....	2
137.....	S1609000.....	External Chuck guard.....	1
138.....	S1609000-01.....	Internal Chuck guard.....	1
139.....	M6X40GB819.1Z.....	Cross countersunk screw.....	4
140.....	S1609005.....	Padding block.....	1
141.....	M8X20GB70.1B.....	hexagon socket cap screws.....	2
142.....	M10X8GB8B.....	Hexagon socket setting screws.....	2
143.....	Φ 1x6x15.75GB2089B.....	Spring.....	2
144.....	Φ 8GB17445.....	Steel ball.....	2
145.....	KW7-03B.....	Micro switch.....	1
146.....	M6X12GB70.1B.....	hexagon socket cap screws.....	1
147.....	S1604016.....	Frequency converter base.....	1
148.....	WSH5GB93B.....	Spring washer.....	4
149.....	S1604017.....	Frequency converter cover.....	1
150.....	LSD-C7400-0.75KW.....	Frequency converter.....	1
151.....	B26-7B.....	Transformer.....	1
152.....	F11A-E 11P.....	Relay base.....	1
153.....	YJ3N-GS 24VDC.....	Relay.....	1
154.....	M3X14GB818Z.....	Cross pan head screw.....	2
155.....	S1601001.....	Base.....	1
156.....	S1601003-01A/B.....	Column.....	1
157.....	S1601023.....	Cone gear shaft.....	1
158.....	BRG51102GB301.....	Thrust bearing.....	1
159.....	S1601012.....	Cover.....	1
160.....	M5X12GB70.1B.....	Hexagon socket cap screws.....	4
161.....	M6X6GB80B.....	Hexagon socket set screw.....	1
162.....	S1601009.....	Crank arm handle assembly.....	1
163.....	CLP15GB894.1B.....	C-clip.....	1
164.....	Φ 6JB7940D4.....	Oil cup.....	1
165.....	M4X12GB819D1Z.....	Cross countersunk head screw.....	4
166.....	S1607001.....	Cover.....	1

Parts List for Breakdown – (4/4)

Index No.	Part No.	Description	Qty.
167.....	S1607006	Lead screw shaft sleeve	1
168.....	BRG51102GB301	Thrust bearing	1
169.....	PIN6GB117.....	Pin	1
170.....	CLP20GB894.1B	C-clip	1
171.....	S1601005	Cone gear	1
172.....	BRG6204-2RSGB276	Bearing	1
173.....	S1601006	Lead screw	1
174.....	S1601015	Nut	1
175.....	S1601011-01	Rack collar	1
176.....	M12X60GB70.1B.....	Hexagon socket cap screws.....	1
177.....	M16GB6170B.....	Nut	1
178.....	WSH16GB97D1Z	Washer	1
179.....	S1601016	Double end bolt	1
180.....	M12GB6177.1B.....	Nut	1
181.....	WSH12GB96.1Z.....	Washer	1
182.....	M12X60GB35Z	Bolt	1
183.....	S1601014	Table.....	1
184.....	S1601004	Table support	1
185.....	S1401012	Column lock handle.....	1
186.....	RDV2D2.5GB12618D1.....	Rivet	1
187.....	S1606001	Tilt scale	1
188.....	WSH12GB97.1B	Washer	1
189.....	M12X40GB5781B.....	Hexagon bolt	1
190.....	YL12S-C11GZ.....	Self - locking button	2
191.....	0402205	Laser light fixing base	4
192.....	0402204	Laser light locking ring	2
193.....	JGD-DC3V.....	Laser light	2
194.....	M3X16GB818Z	Cross pan head screw.....	4
195.....	1309050	LED light	1

Wiring Diagram **220V&110V with Foot pedal switch**





Index	Description	Size	Qty.
1	Arbor (B16-MT2)	B/F	1
	Arbor (B16-MT2)	B/F	1
2	Nut	B/F	1
3	Chuck	B/F	1
4	Slant Wedge	B/F	1
5	L Hex Wrench 3 mm	B/F	1
	L Hex Wrench 4 mm	B/F	1
	L Hex Wrench 5 mm	B/F	1
	L Hex Wrench 10mm	B	1

Object of the Declaration: Axminster Professional AP25FDV Floor Drill 111890

UK:

Supply of Machinery (Safety) Regulations
2008 as amended
Electromagnetic Compatibility Regulations
2016 as amended
Directive 2011/65/EU (RoHS 2)
Restriction of the Use of Certain Hazardous
Substances in Electrical and Electronic
Equipment Regulations 2012

EU:

Machinery Directive 2006/42/EC
EMC Directive 2014/35/EU
Directive 2011/65/EU (RoHS 2)
Restriction of the Use of Certain Hazardous
Substances in Electrical and Electronic
Equipment Regulations 2012

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Standards used or references to the other technical specifications in relation to which conformity is declared:

EN 12717:2001+A1:2009, EN 60204-1:2018+A1:2025

IEC 55014-1:2021, IEC 55014-2:2021, IEC 61000-3-2:2019+A1:2021,
61000-3-3:2013+A1:2019+A2:2021

Date: 7/4/2025

Place: Axminster



I.V. Styles

Ian Styles
Product Director



The packaging is suitable for recycling.
Please dispose of it in a responsible manner.



EU Countries Only

Do not dispose of electric tools together with household waste material.
By law they must be collected and recycled separately.



Axminster Tools, Axminster Devon EX13 5PH

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