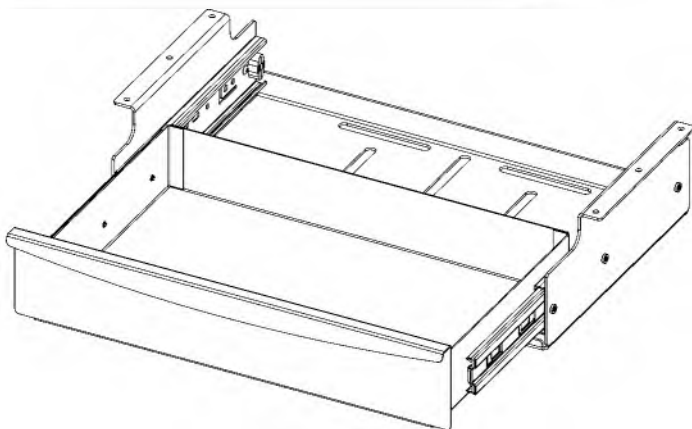
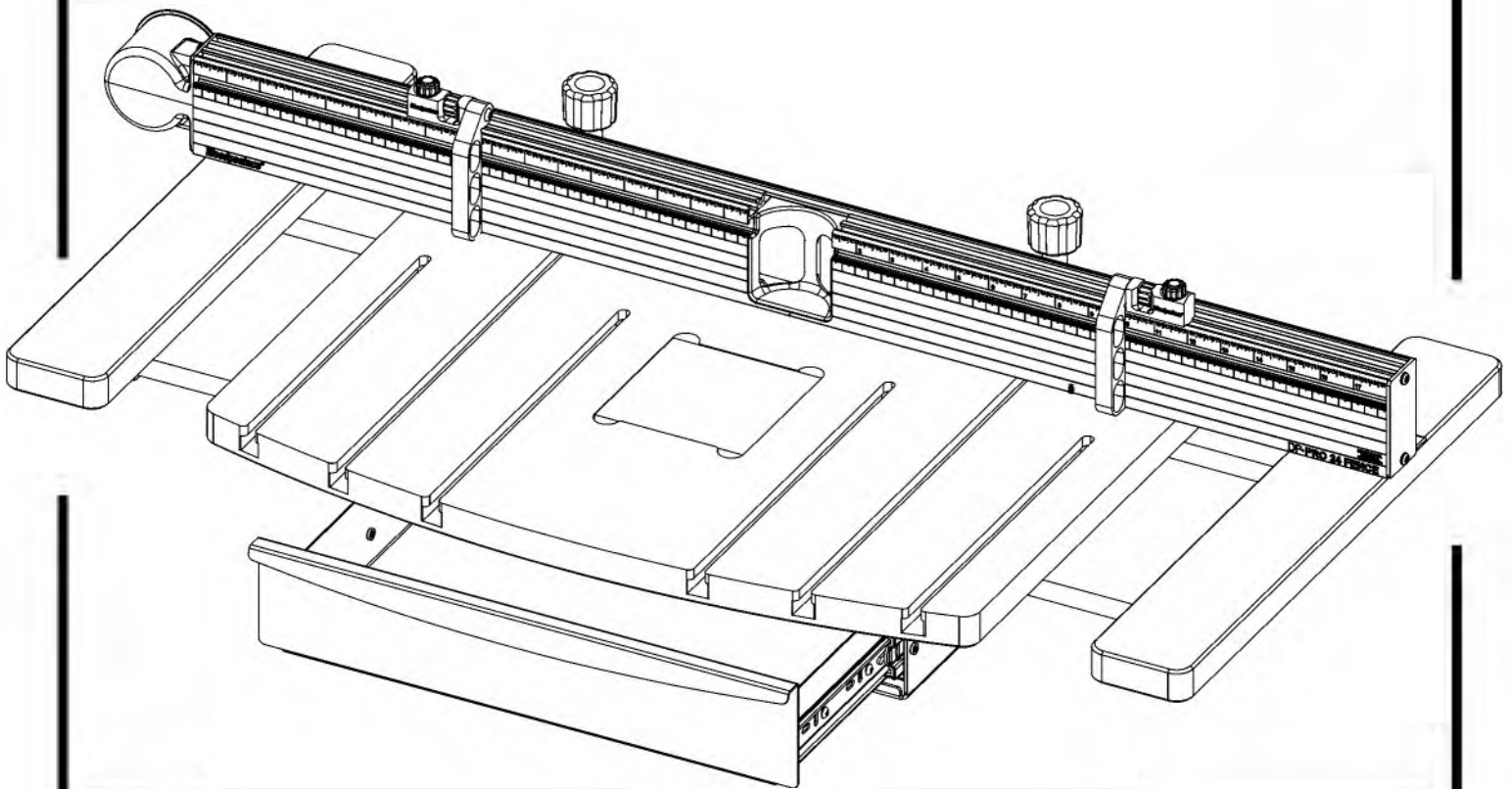


# Woodpeckers®

## DP-PRO TCS DRILL PRESS TABLE SYSTEM

O W N E R ' S M A N U A L



NOTE: Above shown  
with optional

- DP-PRO Drawer Base
- DP-PRO Table  
Extension Wings

Sold separately at  
[woodpeck.com](http://woodpeck.com)



Scan the QR code above  
to watch the video  
or visit [woodpeck.com](http://woodpeck.com)  
under the video tab towards  
the bottom of the product page.

If you think you're missing anything, email us at [mailroom@woodpeck.com](mailto:mailroom@woodpeck.com).  
You can also call us at 800-752-0725 from 9:00 a.m. to 4:00 p.m. EST Monday - Friday.

DIAGRAM NUMBER	(QTY)	PART NAME
①	(1)	Table (23-3/4" wide)
②	(1)	MDF Filler Block <i>(Replacement 3-Packs also sold on woodpeck.com)</i> w/ (4) Phillips Flathead Wood Screw, #10 x 3/8"
③	(2)	DP-PRO Flip Stop

**\*DRAWER BASE** *Included with SKU DPPROT-B and also sold separately.*

④	(1)	Drawer Base
⑤	(1)	Drawer

**\*HARDWARE BAG A** Drawer Base & Drawer Slides *Included with SKU DPPROT-B and also sold separately.*

A-1	(12)	Panhead Screw, 8-32 x 3/16"
A-2	(2)	Drawer Slide (includes Drawer Slide Extension)
A-3	(6)	Panhead Phillips Wood Screw, #10

DIAGRAM NUMBER	(QTY)	PART NAME
<b>*HARDWARE BAG B</b> <small>NOT SHOWN</small> Drawer Base Mounting to a Drill Press		
B-1	(4)	Rectangular Nut, 5/16-18
B-2	(4)	Hex Bolt, 5/16-18 x 3/4"
B-3	(4)	Hex Bolt, 5/16-18 x 1-1/4"
B-4	(4)	Hex Nut, 5/16-18
B-5	(4)	Washer, 5/16
B-6	(4)	Rectangular Nut, 1/4-20
B-7	(4)	Hex Bolt, 1/4-20 x 3/4"

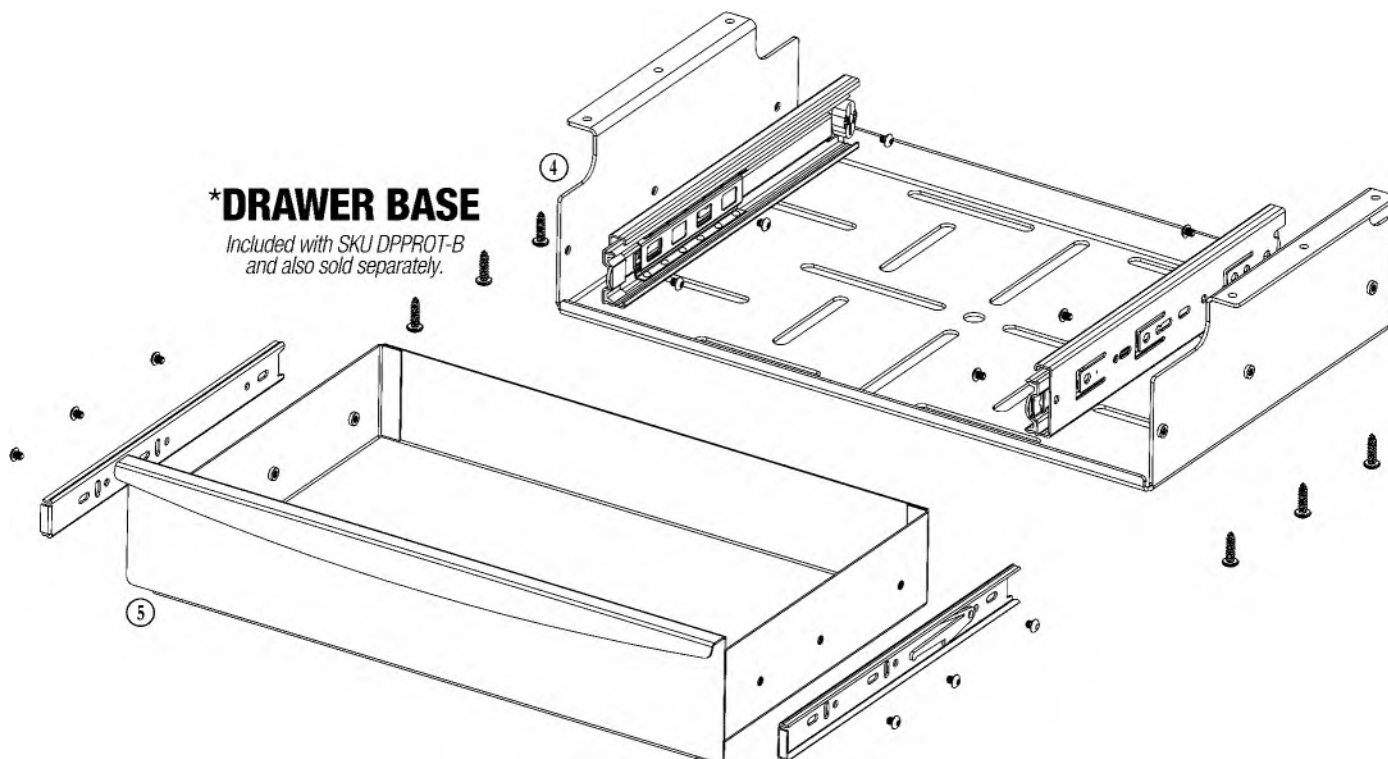
**FENCE**

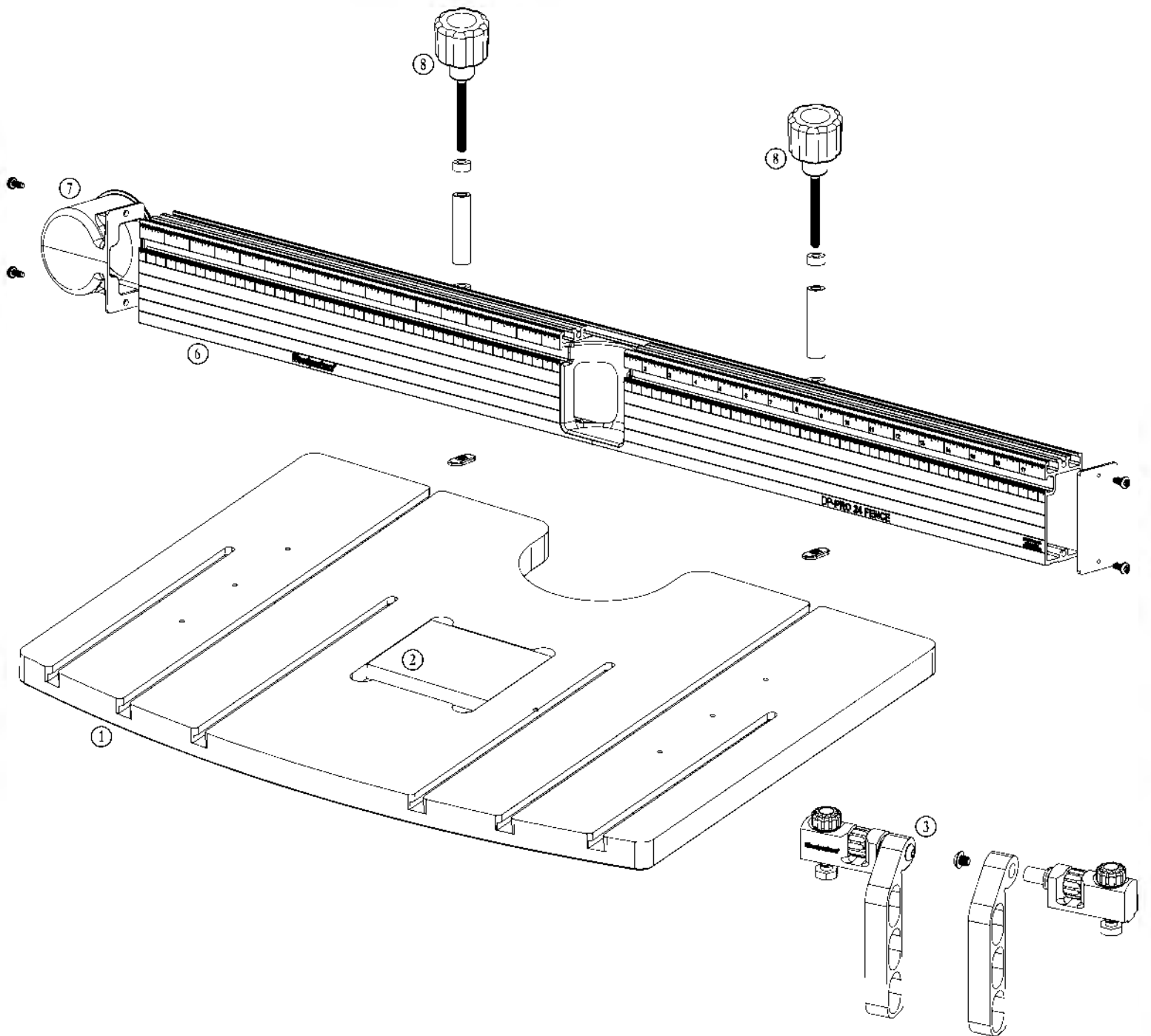
⑥	(1)	Fence 36" Assembly w/ Dust Collection Center Chuck Fitting
⑦	(1)	Dust Collection Elbow, 2-1/4"

**HARDWARE BAG C** Fence

⑧	(2)	Knob Assembly w/ Screw, 1/4-20 x 3-3/4"
C-1	(1)	End Cap
C-2	(2)	Red Tube
C-3	(4)	Nylon Washer
C-4	(4)	Pan Head Torx Screw, 10/32 x 1/2
C-5	(2)	Oval Nut, 1/4 x 20

**\*NOTE:** Not all the items listed may come with your purchase.



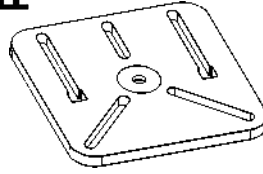


**NOTE:** The DP-PRO TCS can be adapted to virtually any drill press. Fundamentally, there are two types of drill press tables, those with through-slots and those with T-Slots. **Section I.** details installing directly to through slots. **Section II.** details installing with an interface board on a T-Slot table. And **Section III.** (page 5) details installing on either style using the DP-PRO Drawer Base. Take a look at your drill press table and proceed with the appropriate Section.

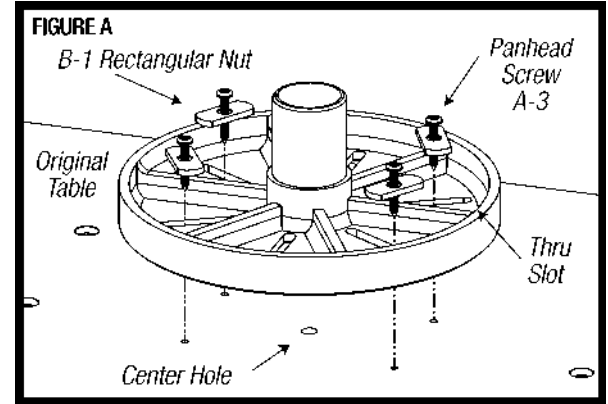
## I. MOUNTING DIRECTLY TO A THROUGH-SLOT TABLE

### AT THIS POINT YOU WILL NEED:

- ① (1) Table (23-3/4" wide)
- A-3 (6) Panhead Phillips Wood Screw, #10
- B-1 (4) Rectangular Nut, 5/16-18



**1A. If the main table of your drill press is easily removed,** set your DP-PRO TCS Table face down on a work surface. Remove the original table from your drill press. Set it face down onto your DP-PRO TCS Table. Center the original table over the 1/8" hole in the DP-PRO TCS Table. **FIGURE A.**



**2A.** Pick (4) locations that are well away from the filler recess on the opposite side and as widely distributed as possible. Mark the locations on the DP-PRO TCS Table ①. Remove the main drill press table and drill 5/32" pilot holes at the (4) locations to a depth of approximately 3/4".

**3A.** Secure the tables together by installing (4) Panhead Screws A-3. Rectangular Nuts B-1 are provided to bridge over large slots in the main drill press table.

**1B. If your main drill press table is not easily removed,** locate the DP-PRO TCS Table ① on the main drill press table, centering the indexing hole of the DP-PRO TCS with the center hole of the main drill press table.

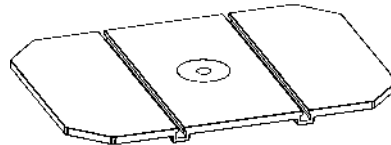
**2B.** Reach under the table and mark (4) locations through the table slots, well away from the filler recess. Remove the DP-PRO TCS Table, turn it over and drill 5/32" pilot holes at the (4) locations to a depth of approximately 3/4".

**3B.** Secure the tables together by installing (4) Panhead Screws A-3. Rectangular Nuts B-1 are provided to bridge over large slots in the main drill press table.

## II. MOUNTING TO A T-SLOTTED TABLE WITH INTERFACE BOARD

### AT THIS POINT YOU WILL NEED:

- ① (1) Table (23-3/4" wide)
- A-3 (6) Panhead Phillips Wood Screw, #10
- B-1 (4) Rectangular Nut, 5/16-18



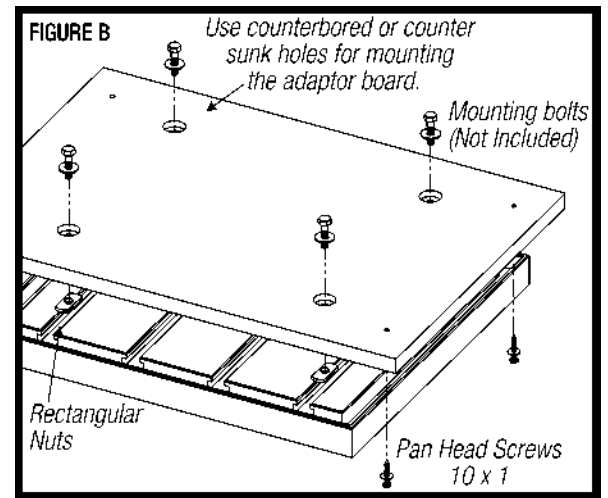
**1.** If your drill press table has T-Slots, you'll need to make an interface board at least 1-1/2" wider than your main drill press table, approximately the same depth as your main drill press table and preferably 3/4" thick. *MDF and Baltic Birch plywood are popular choices for the material.*

**2.** The included Rectangular Nuts B-1 will likely fit the T-slots in your table. *Given the wide range of table sizes and thicknesses, no bolts are provided.* Determine the proper length and purchase (4) 5/16-18 bolts. The bolt heads must be mounted flush with or below the face of the interface board. Hex head bolts will need to be counter-bored or flathead machine screws will need to be counter-sunk.

**3.** Select four locations for mounting bolts. They should be the outermost points of the fit between the main drill press table and the interface board. Mark the locations ensuring that they are centered on the T-slots.

**4.** If using hex head bolts, counter-bore the holes the appropriate size and depth to accommodate any washers and the bolt heads. Drill 3/8" diameter through holes. **FIGURE B** shows counter bored holes. If using flathead machine screws, drill 3/8" diameter through holes and counter-sink to appropriate depth. Mount the interface board to the main drill press table.

**5.** Align the DP-PRO TCS table on the interface board so the indexing hole in the table aligns with drill chuck. Clamp the DP-PRO TCS table to the interface board and drill (4) pilot holes outside the edge of the main drill press table. Use Panhead Screws A-3 screws to fasten the DP-PRO TCS table to the interface board



### III. MOUNTING WITH THE OPTIONAL DRAWER BASE

#### AT THIS POINT YOU WILL NEED:

- ① (1) Table (23-3/4" wide)
- ④ (1) Drawer Base
- A-2 (2) Drawer Slide (includes Drawer Slide Extension)

The DP-PRO Drawer Base ④ has several slots in the Base. The pattern is designed to intersect with virtually any pattern of slots in a factory drill press table. Before installing the Drawer Slides A-2 and Table ①, set the Drawer Base on your main drill press table with the center holes aligned and 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. It's a bit easier to decide where you want to locate your fasteners before the table top is on. FIGURES G & H (page 6).

**NOTE:** If you purchased the Extension Wing option, you should install the wings onto the DP-PRO TCS Table before proceeding further with the installation. Directions for installing the wings are included with the Extension Wing Kit.

### IV. DRAWER ASSEMBLY *Included with SKU DPPROT-B and also sold separately.*

#### AT THIS POINT YOU WILL NEED:

- A-1 (12) Panhead Screw, 8-32 x 3/16"
- A-2 (2) Drawer Slide (includes Drawer Slide Extension)
- ④ (1) Drawer Base
- ⑤ (1) Drawer

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

2. Using (3) Panhead Screws A-1, attach the Drawer Slide Extension to the Drawer ⑤.

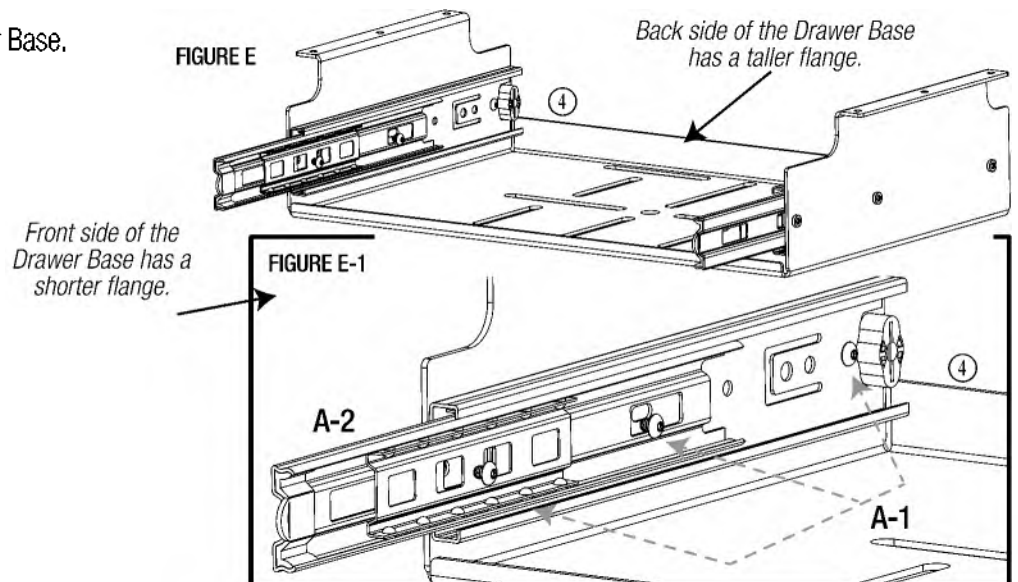
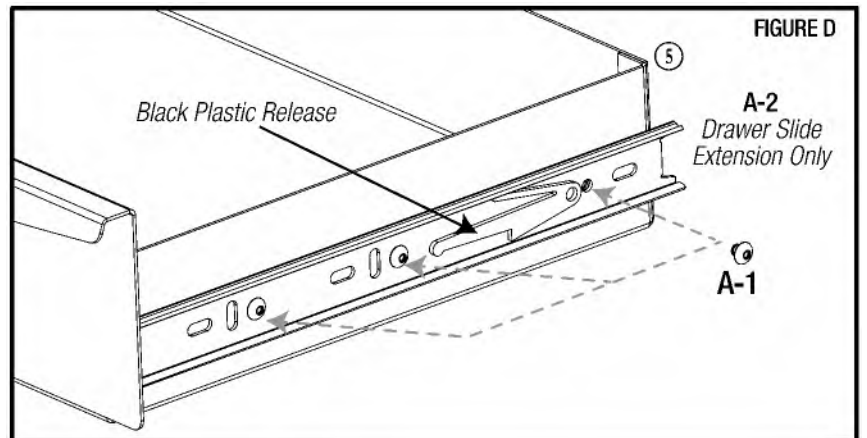
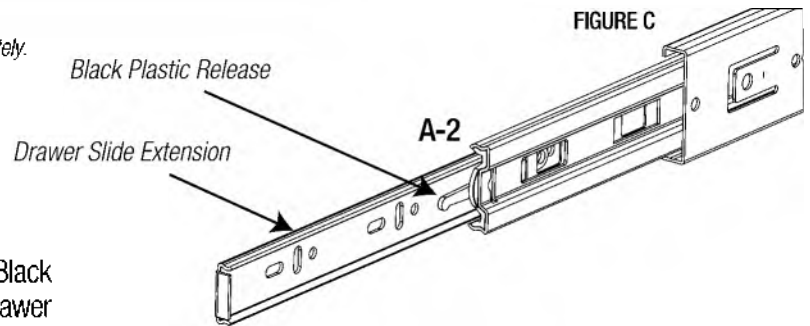
**NOTE:** Use only the round holes on the Drawer Slide Extension. FIGURE D.

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

4. Attach the Drawer Slide to the Drawer Base using (3) Panhead Screws A-1. 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 E / E-1.

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



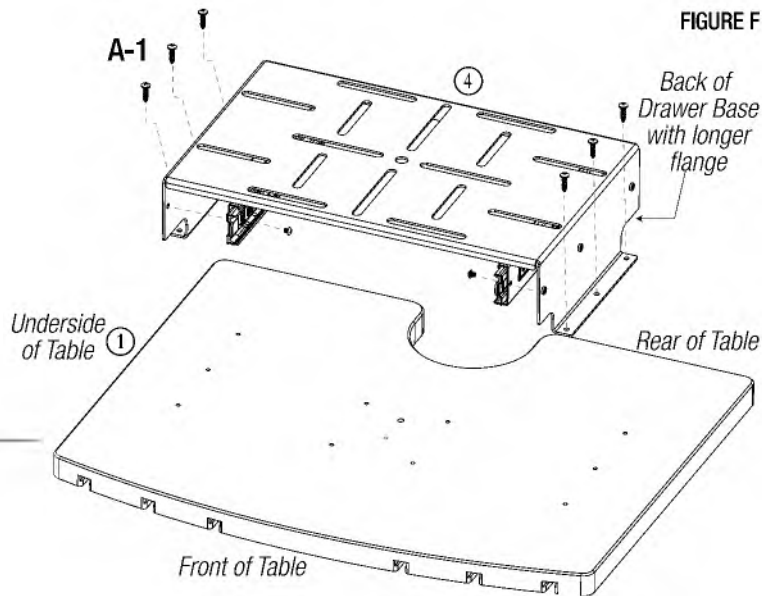
## V. DRAWER BASE ASSEMBLY

### AT THIS POINT YOU WILL NEED:

- A-1 (12) Panhead Screw, 8-32 x 3/16"
- ④ (1) Drawer Base
- ① (1) Table (23-3/4" wide)

1. Attach the Drawer Base ④ to the underside of the Table using (3) Panhead Screws A-1 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. **FIGURE F.**



## VI. ASSEMBLED TCS INSTALLATION

### AT THIS POINT YOU WILL NEED:

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

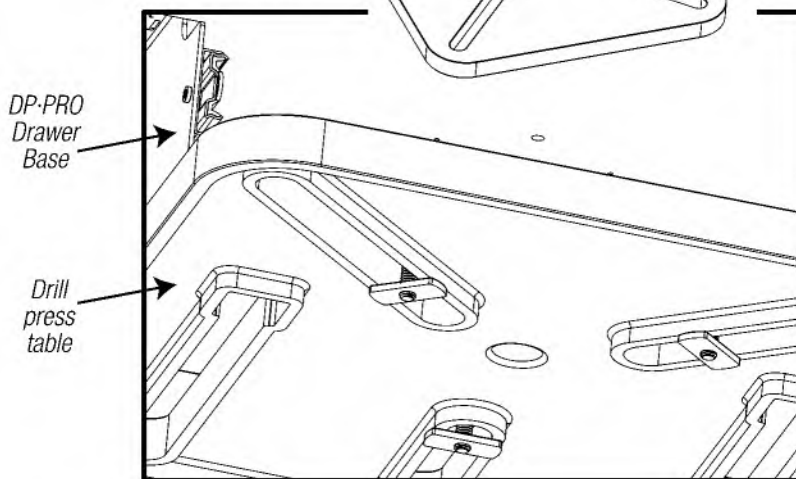
1. The DP-PRO TCS Table has a 1/8" hole at the optimum location for the drill press chuck. Align a 1/8" drill bit in the chuck with the hole in the TCS table. Make sure the main drill press table and the drawer base are squared up to each other and properly aligned.

2. A variety of hardware has been supplied to attach your DP-PRO TCS Table to your factory drill press table. We have supplied two sizes of Rectangular Nuts B-1 and B-6.

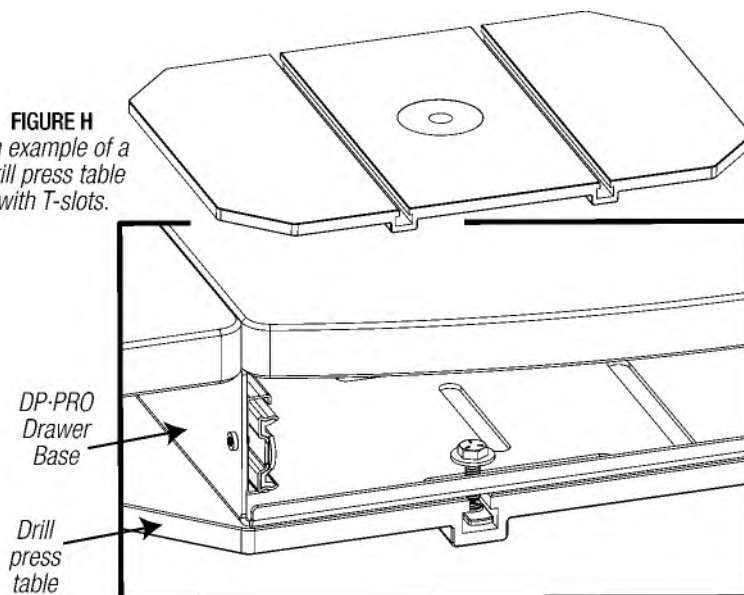
**A. In tables with through-slots,** the larger (5/16"-18) should bridge across the slot as shown. **Figure G.**

**B. In drill press tables with T-slots,** one size or the other should fit the slot as shown. You may need to purchase different length bolts, depending on the depth of your T-Slot. **Figure H.**

**FIGURE G**  
An example of a drill press table with thru slots.



**FIGURE H**  
An example of a drill press table with T-slots.



## VII. FENCE INSTALLATION

### AT THIS POINT YOU WILL NEED:

- ⑥ (1) Fence 36" Assembly  
w/ Dust Collection Center Chuck Fitting
- ⑦ (1) Dust Collection Elbow, 2-1/4"
- ⑧ (2) Knob Assembly w/ Screw,  
1/4-20 x 3-3/4"
- C-1 (1) End Cap
- C-2 (2) Red Tube
- C-3 (4) Nylon Washer
- C-4 (4) Pan Head Torx Screw, 10/32 x 1/2
- C-5 (2) Oval Nut, 1/4 x 20

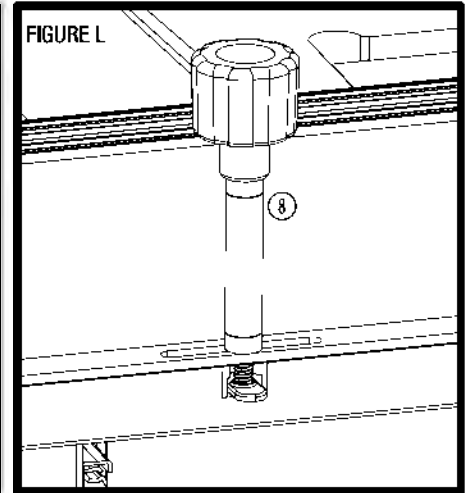
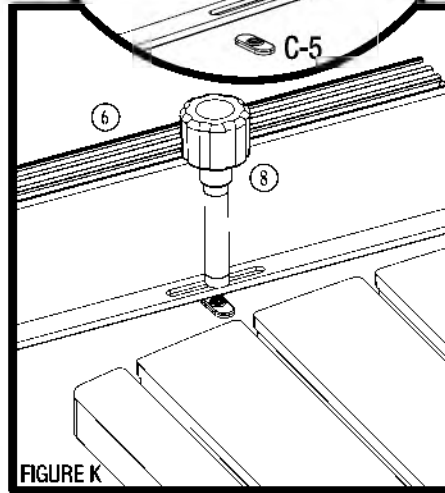
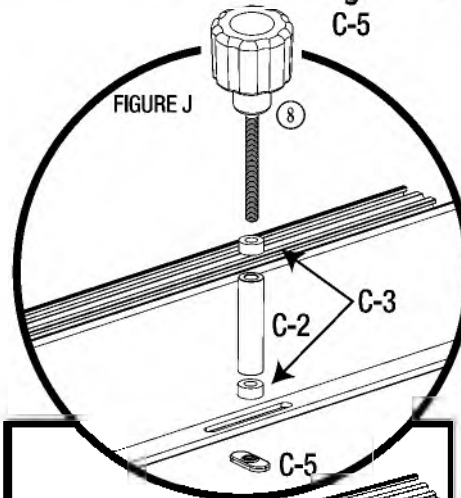
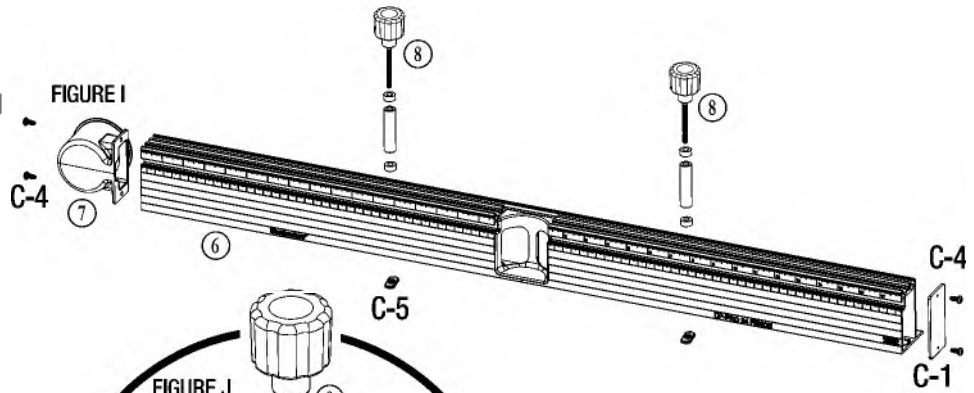
1. The Dust Collection Elbow ⑦ and End Cap C-1 can be secured to either end of the Fence ⑥ using the (4) Pan Head Torx Screws C-4.

**NOTE:** *The screws are self-tapping.* Install the Pan Head Torx Screws into the Fence first by themselves, then remove them and install with the Dust Collection Elbow and the End Cap. It is best to install them with a hand screwdriver rather than a powered drill/driver. If you use a power driver be extremely cautious.

FIGURE I.

2. Assemble a Nylon Washer C-3, Red Tube C-2 and a Nylon Washer C-3 onto the Screw of the Knob ⑧ (in that order) and into the Oval Nut C-5 securing with the Knob. FIGURES I & J.

3. The Fence installs to the T-slots milled completely through the table from front to back. FIGURES K & L.



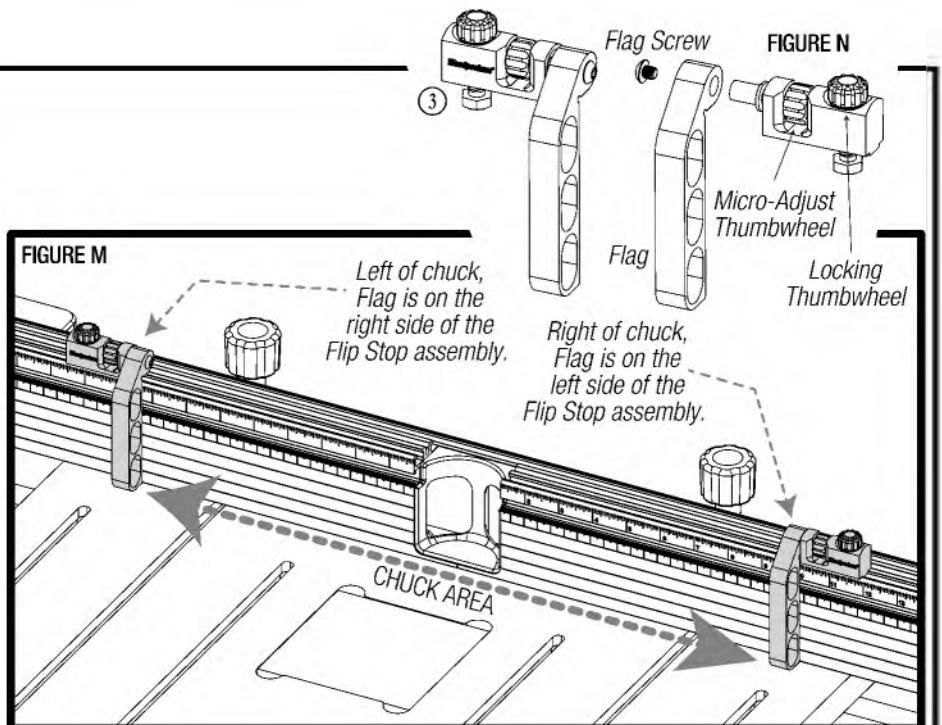
## VIII. USING THE DP-PRO FLIP STOPS ③

- The Flag of the Flip Stop should always be on the chuck side of the stop. Stops to the left of the chuck should have the Flag on the right side of the Flip Stop assembly. Stops to the right of the chuck should have the Flag on the left side of the Flip Stop assembly. Figure M.

- To reverse a Flip Stop for use on the other side of the chuck, remove the Flag Screw, reverse the Flag and re-install it. Figure N.

- Loosen the Locking Thumbwheel and position the stop approximately where you need it. Tighten the Locking Thumbwheel.

- The precise position of the Flag can be fine-tuned using the Micro-Adjust Thumbwheel.



## IX. ATTACHING THE FILLER BLOCK

AT THIS POINT YOU WILL NEED:

- ② (1) MDF Filler Block  
(Replacement 3-Packs also sold on [woodpeck.com](http://woodpeck.com))  
w/ (4) Phillips Flathead Wood Screw, #10 x 3/8"

1. Install (4) Phillips Flathead Wood Screw (from the MDF Filler Block ②) as leveling screws in the table cut-out. Adjust them just about the surface of the machined area. **Figure O.**

2. Install the Filler Block ②.

3. Adjust the leveling screws up or down as needed to position the Filler Block flush with the table surface.

Phillips Flathead  
Wood Screws

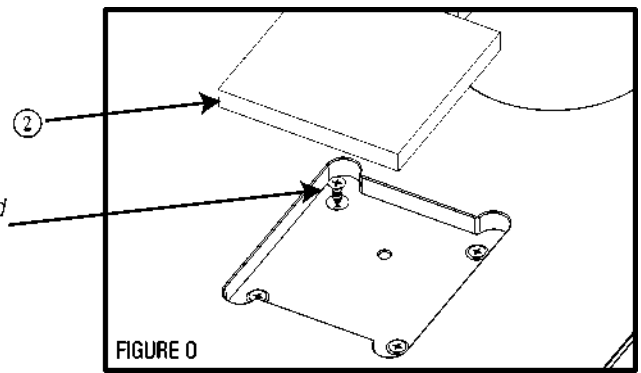


FIGURE O

## X. USING TRACK CLAMPS WITH THE DP-PRO TCS

1. Slide any brand or style of track saw track clamp into the grooves of the DP-PRO TCS Table. Depending on the style of clamp and the size of your workpiece you may need to feed the shaft end in first or last. **Figure P.**

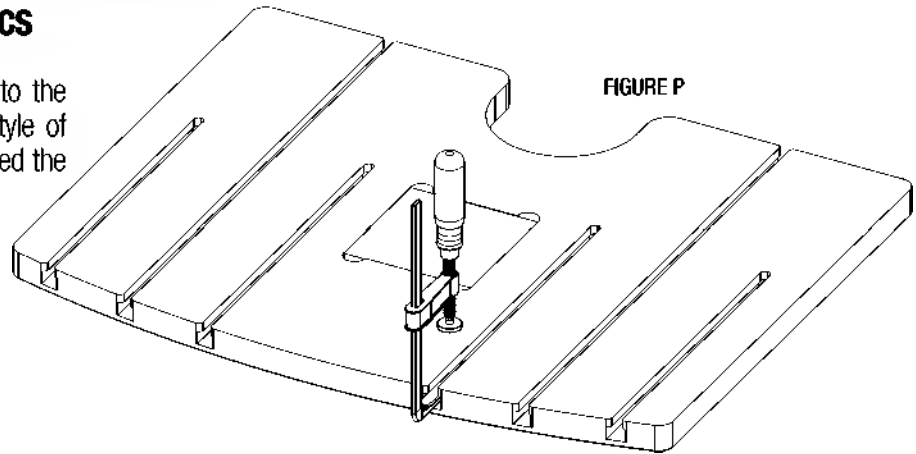


FIGURE P

# Woodpeckers®

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### WARNING!

This product can expose you to chemicals, including chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)



**WARNING!** To reduce the risk of injury keep hands away from moving parts. Refer to your drill press manual for proper setup and use.



**WARNING!** To reduce the risk of injury, wear safety goggles or glasses with side shields, ear protection & a dust mask.