DEWALT®

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DCD1623

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Fig. A

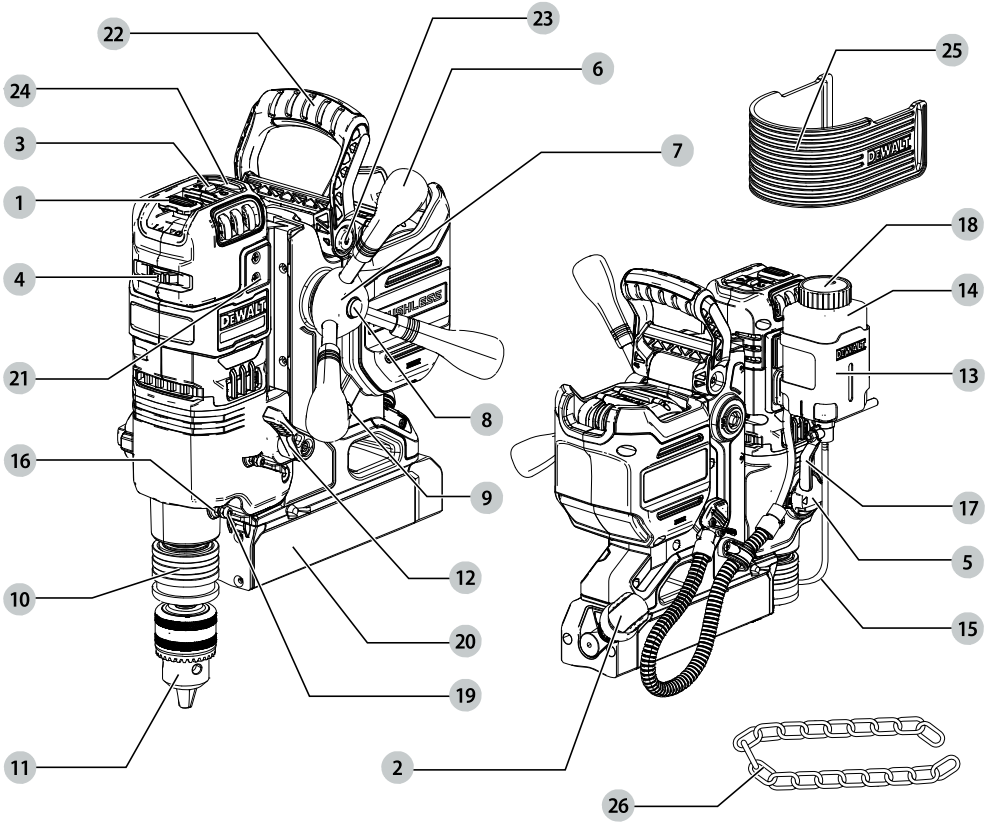

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Fig. B

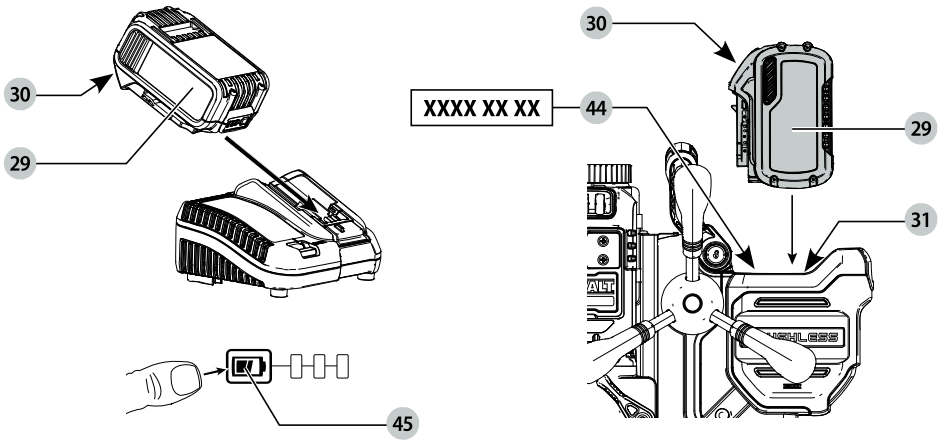

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Fig. C

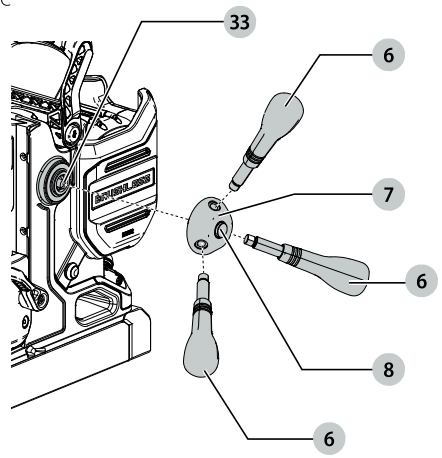


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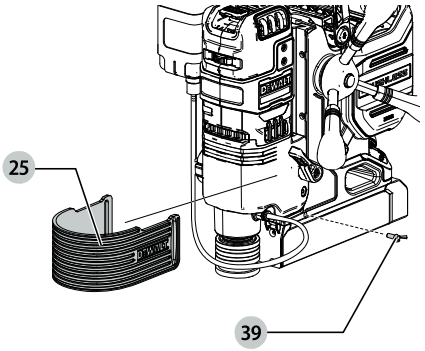
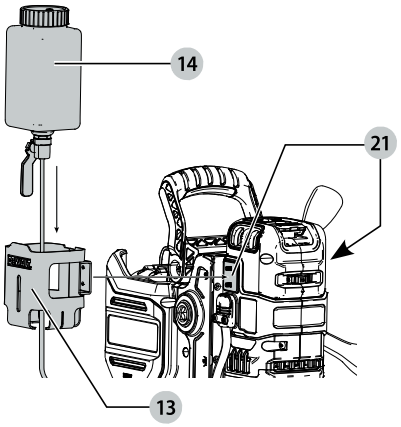


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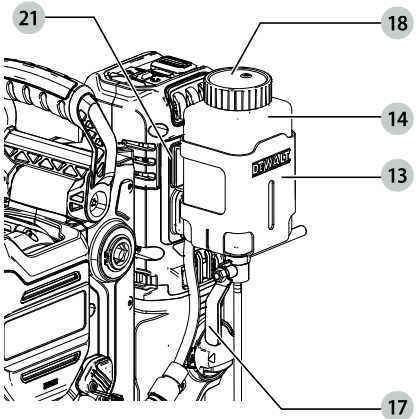
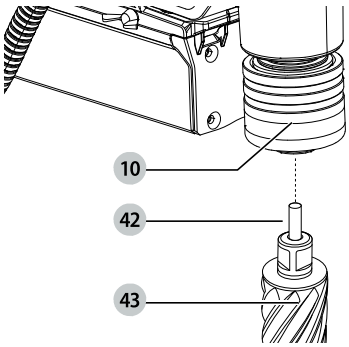


Fig. F



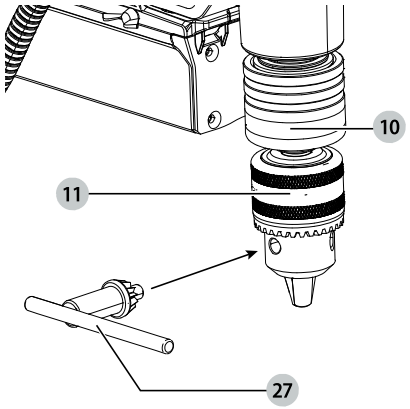


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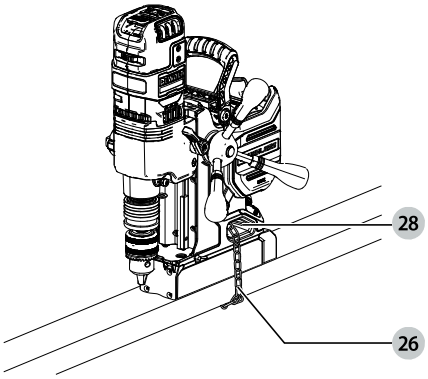


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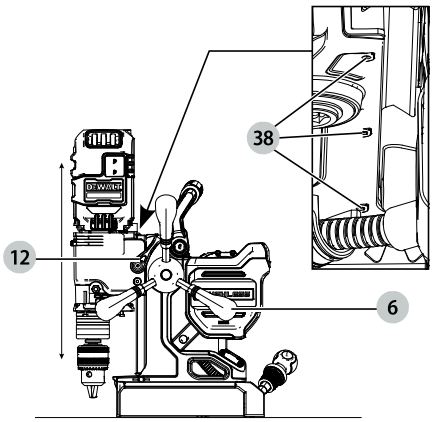


Fig. I

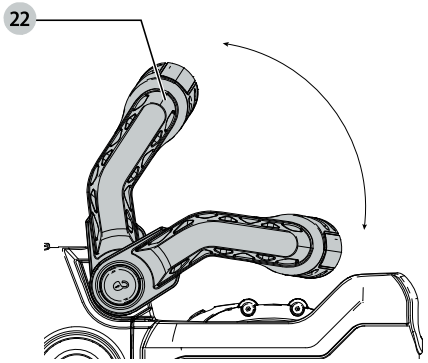


Fig. J

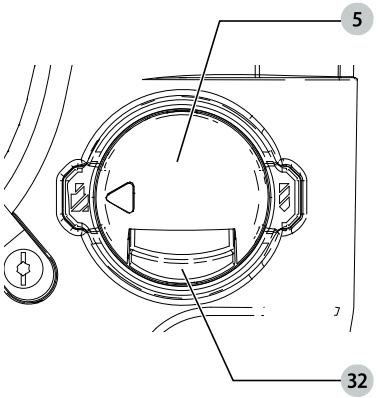


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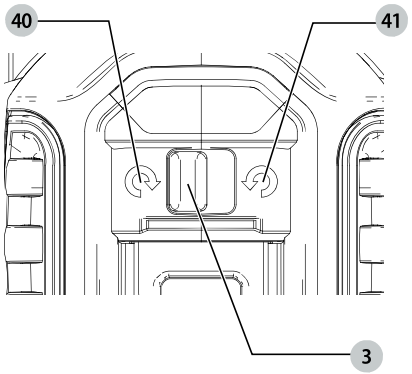


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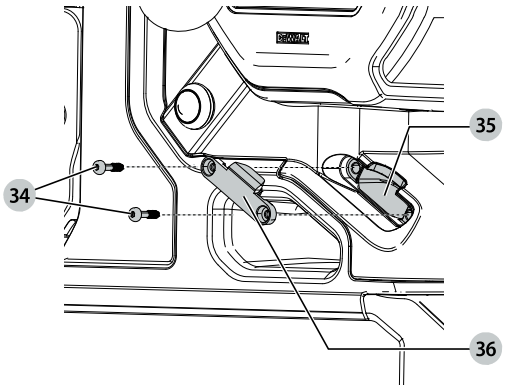
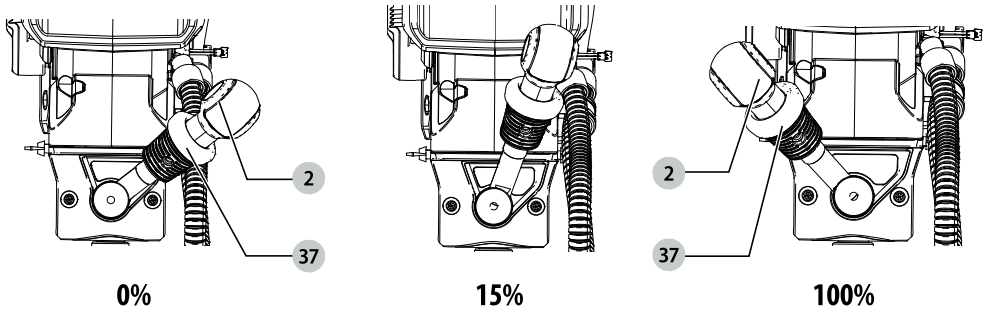


Fig. M



MAGNETIC DRILL PRESS
DCD1623

Congratulations!

You have chosen a DEWALT tool. Years of experience, thorough product development and innovation make DEWALT one of the most reliable partners for professional power tool users.

Technical Data

		DCD1623
Voltage	V_{DC}	18
Type		1
Max.power output w/ 9Ah battery	W	1100
No load speed forward		
Low gear	min-1	130–420
High gear	min-1	250–810
No load speed reverse		
Low gear	min-1	350
High gear	min-1	680
Max. drill diameter with twist drill bit	mm	16
Max. drill diameter with annular cutter	mm	50
Max. Taping		M14
Max. cutting depth in steel	mm	50
Tool holder (flat shank)	mm	19
Weight	kg	14.4

Noise values and/or vibration values (triax vector sum) according to EN62841-1:		
L_{PA} (emission sound pressure level)	dB(A)	85
L_{WA} (sound power level)	dB(A)	94
K (uncertainty for the given sound level)	dB(A)	3

The vibration and/or noise emission level given in this information sheet has been measured in accordance with a standardised test given in EN62841 and may be used to compare one tool with another. It may be used for a preliminary assessment of exposure.

WARNING: *The declared vibration and/or noise emission level represents the main applications of the tool. However if the tool is used for different applications, with different accessories or poorly maintained, the vibration and/or noise emission may differ. This may significantly increase the exposure level over the total working period.*

An estimation of the level of exposure to vibration and/or noise should also take into account the times when the tool is switched off or when it is running but not actually doing the job. This may significantly reduce the exposure level over the total working period.

Identify additional safety measures to protect the operator from the effects of vibration and/or noise such as: maintain the tool and the accessories, keep the hands warm (relevant for vibration), organisation of work patterns.

EC-Declaration of Conformity

Machinery Directive

CE

Magnetic Drill Press
DCD1623

DEWALT declares that these products described under ***Technical Data*** are in compliance with:
2006/42/EC, EN62841-1:2015.

These products also comply with Directive 2014/30/EU and 2011/65/EU. For more information, please contact DEWALT at the following address or refer to the back of the manual.

The undersigned is responsible for compilation of the technical file and makes this declaration on behalf of DEWALT.



Markus Rompel
Vice-President Engineering, PTE-Europe
DEWALT, Richard-Klinger-Straße 11,
65510, Idstein, Germany
29.04.2022

DECLARATION OF CONFORMITY
THE SUPPLY OF MACHINERY (SAFETY) REGULATIONS 2008

UK CA

Magnetic Drill Press
DCD1623

DEWALT declares that these products described under "technical data" are in compliance with:

EN62841-1:2015.

These products conform to the following UK Regulations

The Supply of Machinery (Safety) Regulations, 2008, S.I. 2008/1597 (as amended).

Electromagnetic Compatibility Regulations, 2016, S.I.2016/1091 (as amended).

The Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations 2012, S.I. 2012/3032 (as amended).

For more information, please contact DEWALT at the following address or refer to the back of the manual.

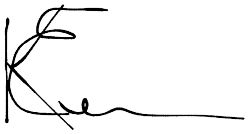
The undersigned is responsible for compilation of the technical file and makes this declaration on behalf of DEWALT.

Batteries				Chargers/Charge Times (Minutes)***									
Cat #	V_{DC}	Ah	Weight (kg)	DCB104	DCB107	DCB112	DCB113	DCB115	DCB116	DCB117	DCB118	DCB132	DCB119
DCB547G	18/54	9.0/3.0	1.46	75*	420	270	220	135*	110*	60	75*	135*	X
DCB184G	18	5.0	0.62	75/50**	240	150	120	75	75/60**	75/50**	75/50**	75	150

**Date code 201811475B or later*

***Date code 201536 or later*

***Battery charge times matrix provided for guidance only; charge times will vary depending on temperature and condition of batteries.*



Karl Evans
Vice President Professional Power Tools EANZ GTS
270 Bath Road, Slough
Berkshire, SL1 4DX
England

29.04.2022

WARNING: *To reduce the risk of injury, read the instruction manual.*

Definitions: Safety Guidelines

The definitions below describe the level of severity for each signal word. Please read the manual and pay attention to these symbols.

DANGER: *Indicates an imminently hazardous situation which, if not avoided,* ***will*** *result in* ***death or serious injury****.*

WARNING: *Indicates a potentially hazardous situation which, if not avoided,* ***could*** *result in* ***death or serious injury****.*

CAUTION: *Indicates a potentially hazardous situation which, if not avoided,* ***may*** *result in* ***minor or moderate injury****.*

NOTICE: *Indicates a practice* ***not related to personal injury*** *which, if not avoided,* ***may*** *result in* ***property damage****.*

Denotes risk of electric shock.

Denotes risk of fire.

GENERAL POWER TOOL SAFETY WARNINGS

WARNING: Read all safety warnings, instructions, illustrations and specifications provided with this power tool. *Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.*

SAVE ALL WARNINGS AND INSTRUCTIONS FOR FUTURE REFERENCE

The term "power tool" in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

1) Work Area Safety

a) ***Keep work area clean and well lit.*** *Cluttered or dark areas invite accidents.*

b) ***Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.*** *Power tools create sparks which may ignite the dust or fumes.*

c) ***Keep children and bystanders away while operating a power tool.*** *Distractions can cause you to lose control.*

2) Electrical Safety

a) ***Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.*** *Unmodified plugs and matching outlets will reduce risk of electric shock.*

b) ***Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators.*** *There is an increased risk of electric shock if your body is earthed or grounded.*

c) ***Do not expose power tools to rain or wet conditions.*** *Water entering a power tool will increase the risk of electric shock.*

d) ***Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.*** *Damaged or entangled cords increase the risk of electric shock.*

e) ***When operating a power tool outdoors, use an extension cord suitable for outdoor use.*** *Use of a cord suitable for outdoor use reduces the risk of electric shock.*

f) ***If operating a power tool in a damp location is unavoidable, use a residual current device (RCD) protected supply.*** *Use of an RCD reduces the risk of electric shock.*

3) Personal Safety

a) ***Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.*** *A moment of inattention while operating power tools may result in serious personal injury.*

b) ***Use personal protective equipment. Always wear eye protection.*** *Protective equipment such as a dust mask, non-skid safety shoes, hard hat or hearing protection used for appropriate conditions will reduce personal injuries.*

c) ***Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power***

source and/or battery pack, picking up or carrying the tool. *Carrying power tools with your finger on the switch or energising power tools that have the switch on invites accidents.*

d) ***Remove any adjusting key or wrench before turning the power tool on.*** *A wrench or a key left attached to a rotating part of the power tool may result in personal injury.*

e) ***Do not overreach. Keep proper footing and balance at all times.*** *This enables better control of the power tool in unexpected situations.*

f) ***Dress properly. Do not wear loose clothing or jewellery. Keep your hair and clothing away from moving parts.*** *Loose clothes, jewellery or long hair can be caught in moving parts.*

g) ***If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.*** *Use of dust collection can reduce dust-related hazards.*

h) ***Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles.*** *A careless action can cause severe injury within a fraction of a second.*

4) Power Tool Use and Care

a) ***Do not force the power tool. Use the correct power tool for your application.*** *The correct power tool will do the job better and safer at the rate for which it was designed.*

b) ***Do not use the power tool if the switch does not turn it on and off.*** *Any power tool that cannot be controlled with the switch is dangerous and must be repaired.*

c) ***Disconnect the plug from the power source and/ or remove the battery pack, if detachable, from the power tool before making any adjustments, changing accessories, or storing power tools.*** *Such preventive safety measures reduce the risk of starting the power tool accidentally.*

d) ***Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.*** *Power tools are dangerous in the hands of untrained users.*

e) ***Maintain power tools and accessories. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use.*** *Many accidents are caused by poorly maintained power tools.*

f) ***Keep cutting tools sharp and clean.*** *Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.*

g) ***Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed.*** *Use of the power tool for operations different from those intended could result in a hazardous situation.*

h) ***Keep handles and grasping surfaces dry, clean and free from oil and grease.*** *Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.*

5) Battery Tool Use and Care

a) ***Recharge only with the charger specified by the manufacturer.*** *A charger that is suitable for one type of battery pack may create a risk of fire when used with another battery pack.*

b) ***Use power tools only with specifically designated battery packs.*** *Use of any other battery packs may create a risk of injury and fire.*

c) ***When battery pack is not in use, keep it away from other metal objects, like paper clips, coins, keys, nails, screws or other small metal objects, that can make a connection from one terminal to another.*** *Shorting the battery terminals together may cause burns or a fire.*

d) ***Under abusive conditions, liquid may be ejected from the battery; avoid contact. If contact accidentally occurs, flush with water. If liquid contacts eyes, additionally seek medical help.*** *Liquid ejected from the battery may cause irritation or burns.*

e) ***Do not use a battery pack or tool that is damaged or modified.*** *Damaged or modified batteries may exhibit unpredictable behaviour resulting in fire, explosion or risk of injury.*

f) ***Do not expose a battery pack or tool to fire or excessive temperature.*** *Exposure to fire or temperature above 130 °C may cause explosion.*

g) ***Follow all charging instructions and do not charge the battery pack or tool outside the temperature range specified in the instructions.*** *Charging improperly or at temperatures outside the specified range may damage the battery and increase the risk of fire.*

6) Service

a) ***Have your power tool serviced by a qualified repair person using only identical replacement parts.*** *This will ensure that the safety of the power tool is maintained.*

b) ***Never service damaged battery packs.*** *Service of battery packs should only be performed by the manufacturer or authorized service providers.*

Additional Specific Safety Rules for Drill Presses

- *Keep your hands out of the drilling area while the tool is running. Contact with rotating parts or chips may result in personal injury.*
- *Always use the drill guard. Before turning on machine ensure the guard is closed securely.*
- *Always use the safety chain.*
- *The magnetic stand is suitable for use on steel with a thickness starting from 10 mm, with zero air gap between the magnet core surface and the mounting surface. Curvature, coats of paint and surface irregularities will create an air gap. Keep the air gap to a minimum.*
- *Always place the machine on a flat surface. Do not clamp the stand on small or irregularly shaped objects.*

- *Always place the machine on a surface that is clear of shavings, chips, swarf and surface dirt.*
- *Keep the magnet clean and free of debris and swarf.*
- *Do not turn on the machine until it has been mounted and installed according to these instructions.*
- *Do not turn on the machine before having checked that the magnetic stand has been tightened firmly to the mounting surface.*
- *Adjust the table so cutter does not extend into the workpiece before drilling. Do not perform any design, assembly or construction activities on the workpiece while the machine is turned on.*
- *Before turning on the machine, make sure the accessory has been mounted correctly.*
- *Always use the recommended speed for the accessories and the material.*
- *Do not use the machine on the same workpiece on which electric welders are being used.*
- *Use only an appropriate cutting fluid. Use a general metal cutting coolant diluted with water.*
- *Do not use liquid cutting fluids while drilling vertically or overhead. Dip the cutter in cutting paste or apply an appropriate spray for these applications.*
- *Do not pour cutting fluid into the reservoir while it is mounted in the bracket. Do not allow cutting fluid to enter the drill motor.*
- *Before use, ensure movable chuck guard operates properly.*
- *Ensure that metal chips or resinous residue cannot lead to blockage of the function.*
- *In case of jammed cutter disconnect the machine from the power supply, remove the reason for the jam before turning on the machine again.*

Residual Risks

In spite of the application of the relevant safety regulations and the implementation of safety devices, certain residual risks cannot be avoided. These are:

- *Impairment of hearing.*
- *Risk of personal injury due to flying particles.*
- *Risk of burns due to accessories becoming hot during operation.*
- *Risk of personal injury due to prolonged use.*

SAVE THESE INSTRUCTIONS

Chargers

DEWALT chargers require no adjustment and are designed to be as easy as possible to operate.

Electrical Safety

The electric motor has been designed for one voltage only. Always check that the battery pack voltage corresponds to the voltage on the rating plate. Also make sure that the voltage of your charger corresponds to that of your mains.

Your DEWALTcharger is double insulated in accordance with EN60335; therefore no earth wire is required.

If the supply cord is damaged, it must be replaced only by DEWALT or an authorised service organisation.

Mains Plug Replacement (U.K. & Ireland Only)

If a new mains plug needs to be fitted:

- *Safely dispose of the old plug.*
- *Connect the brown lead to the live terminal in the plug.*
- *Connect the blue lead to the neutral terminal.*

WARNING: *No connection is to be made to the earth terminal.*

Follow the fitting instructions supplied with good quality plugs. Recommended fuse: 3 A.

Using an Extension Cable

An extension cord should not be used unless absolutely necessary. Use an approved extension cable suitable for the power input of your charger (see ***Technical Data***). The minimum conductor size is 1 mm^2; the maximum length is 30 m.

When using a cable reel, always unwind the cable completely.

Important Safety Instructions for All Battery Chargers

SAVE THESE INSTRUCTIONS: This manual contains important safety and operating instructions for compatible battery chargers (refer to ***Technical Data***).

- *Before using charger, read all instructions and cautionary markings on charger, battery pack, and product using battery pack.*

WARNING: *Shock hazard. Do not allow any liquid to get inside charger. Electric shock may result.*

WARNING: *We recommend the use of a residual current device with a residual current rating of 30mA or less.*

CAUTION: *Burn hazard. To reduce the risk of injury, charge only DEWALT rechargeable batteries. Other types of batteries may burst causing personal injury and damage.*

CAUTION: *Children should be supervised to ensure that they do not play with the appliance.*

NOTICE: *Under certain conditions, with the charger plugged into the power supply, the exposed charging contacts inside the charger can be shorted by foreign material. Foreign materials of a conductive nature such as, but not limited to, steel wool, aluminum foil or any buildup of metallic particles should be kept away from charger cavities. Always unplug the charger from the power supply when there is no battery pack in the cavity. Unplug charger before attempting to clean.*

- ***DO NOT attempt to charge the battery pack with any chargers other than the ones in this manual.*** *The charger and battery pack are specifically designed to work together.*
- ***These chargers are not intended for any uses other than charging DEWALT rechargeable batteries.*** *Any other uses may result in risk of fire, electric shock or electrocution.*
- ***Do not expose charger to rain or snow.***

- ***Pull by plug rather than cord when disconnecting charger.*** *This will reduce risk of damage to electric plug and cord.*
- ***Make sure that cord is located so that it will not be stepped on, tripped over, or otherwise subjected to damage or stress.***
- ***Do not use an extension cord unless it is absolutely necessary.*** *Use of improper extension cord could result in risk of fire,electric shock, or electrocution.*
- ***Do not place any object on top of charger or place the charger on a soft surface that might block the ventilation slots and result in excessive internal heat.*** *Place the charger in a position away from any heat source. The charger is ventilated through slots in the top and the bottom of the housing.*
- ***Do not operate charger with damaged cord or plug—*** *have them replaced immediately.*
- ***Do not operate charger if it has received a sharp blow, been dropped, or otherwise damaged in any way.*** *Take it to an authorised service centre.*
- ***Do not disassemble charger; take it to an authorised service centre when service or repair is required.*** *Incorrect reassembly may result in a risk of electric shock, electrocution or fire.*
- *In case of damaged power supply cord, the supply cord must be replaced immediately by the manufacturer, its service agent or similar qualified person to prevent any hazard.*
- ***Disconnect the charger from the outlet before attempting any cleaning. This will reduce the risk of electric shock.*** *Removing the battery pack will not reduce this risk.*
- ***NEVER*** *attempt to connect two chargers together.*
- ***The charger is designed to operate on standard 230V household electrical power. Do not attempt to use it on any other voltage.*** *This does not apply to the vehicular charger.*

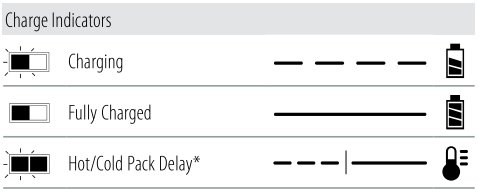
Charging a Battery (Fig. B)

1. Plug the charger into an appropriate outlet before inserting battery pack.
2. Insert the battery pack **29** into the charger, making sure the battery pack is fully seated in the charger. The red (charging) light will blink repeatedly indicating that the charging process has started.
3. The completion of charge will be indicated by the red light remaining ON continuously. The battery pack is fully charged and may be used at this time or left in the charger. To remove the battery pack from the charger, push the battery release button **30** on the battery pack.

NOTE: To ensure maximum performance and life of lithium-ion battery packs, charge the battery pack fully before first use.

Charger Operation

Refer to the indicators below for the charge status of the battery pack.



*The red light will continue to blink, but a yellow indicator light will be illuminated during this operation. Once the battery pack has reached an appropriate temperature, the yellow light will turn off and the charger will resume the charging procedure.

The compatible charger(s) will not charge a faulty battery pack. The charger will indicate faulty battery by refusing to light.

NOTE: This could also mean a problem with a charger.

If the charger indicates a problem, take the charger and battery pack to be tested at an authorised service centre.

Hot/Cold Pack Delay

When the charger detects a battery pack that is too hot or too cold, it automatically starts a Hot/Cold Pack Delay, suspending charging until the battery pack has reached an appropriate temperature. The charger then automatically switches to the pack charging mode. This feature ensures maximum battery pack life.

A cold battery pack will charge at a slower rate than a warm battery pack. The battery pack will charge at that slower rate throughout the entire charging cycle and will not return to maximum charge rate even if the battery pack warms.

The DCB118 charger is equipped with an internal fan designed to cool the battery pack. The fan will turn on automatically when the battery pack needs to be cooled. Never operate the charger if the fan does not operate properly or if ventilation slots are blocked. Do not permit foreign objects to enter the interior of the charger.

Electronic Protection System

XR Li-Ion tools are designed with an Electronic Protection System that will protect the battery pack against overloading, overheating or deep discharge.

The tool will automatically turn off if the Electronic Protection System engages. If this occurs, place the lithium-ion battery pack on the charger until it is fully charged.

Wall Mounting

These chargers are designed to be wall mountable or to sit upright on a table or work surface. If wall mounting, locate the charger within reach of an electrical outlet, and away from a corner or other obstructions which may impede air flow. Use the back of the charger as a template for the location of the mounting screws on the wall. Mount the charger securely using drywall screws (purchased separately) at least 25.4 mm long with a screw head diameter of 7–9 mm, screwed into wood to an optimal depth leaving approximately 5.5 mm of the screw exposed. Align the slots on the back of the charger with the exposed screws and fully engage them in the slots.

Charger Cleaning Instructions

WARNING: Shock hazard. Disconnect the charger from the AC outlet before cleaning*. Dirt and grease may be removed from the exterior of the charger using a*

cloth or soft non-metallic brush. Do not use water or any cleaning solutions. Never let any liquid get inside the tool; never immerse any part of the tool into a liquid.

Battery Packs

Important Safety Instructions for All Battery Packs

When ordering replacement battery packs, be sure to include catalogue number and voltage.

The battery pack is not fully charged out of the carton. Before using the battery pack and charger, read the safety instructions below. Then follow charging procedures outlined.

READ ALL INSTRUCTIONS

- ***Do not charge or use battery in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.*** *Inserting or removing the battery from the charger may ignite the dust or fumes.*
- ***Never force battery pack into charger. Do not modify battery pack in any way to fit into a non-compatible charger as battery pack may rupture causing serious personal injury.***
- *Charge the battery packs only in DEWALT chargers.*
- ***DO NOT*** *splash or immerse in water or other liquids.*
- ***Do not store or use the tool and battery pack in locations where the temperature may fall below 4 ˚C (39.2 ˚F) (such as outside sheds or metal buildings in winter), or reach or exceed 40 ˚C (104 ˚F) (such as outside sheds or metal buildings in summer).***
- ***Do not incinerate the battery pack even if it is severely damaged or is completely worn out.*** *The battery pack can explode in a fire. Toxic fumes and materials are created when lithium-ion battery packs are burned.*
- ***If battery contents come into contact with the skin, immediately wash area with mild soap and water.*** *If battery liquid gets into the eye, rinse water over the open eye for 15 minutes or until irritation ceases. If medical attention is needed, the battery electrolyte is composed of a mixture of liquid organic carbonates and lithium salts.*
- ***Contents of opened battery cells may cause respiratory irritation.*** *Provide fresh air. If symptoms persists, seek medical attention.*



WARNING: *Burn hazard. Battery liquid may be flammable if exposed to spark or flame.*



WARNING: *Never attempt to open the battery pack for any reason. If battery pack case is cracked or damaged, do not insert into charger. Do not crush, drop or damage battery pack. Do not use a battery pack or charger that has received a sharp blow, been dropped, run over or damaged in any way (i.e., pierced with a nail, hit with a hammer, stepped on). Electric shock or electrocution may result. Damaged battery packs should be returned to service centre for recycling.*



WARNING: Fire hazard. Do not store or carry the battery pack so that metal objects can contact exposed battery terminals. *For example, do not place the battery pack in aprons, pockets, tool boxes, product kit boxes, drawers, etc., with loose nails, screws, keys, etc.*



CAUTION: When not in use, place tool on its side on a stable surface where it will not cause a tripping or falling hazard. *Some tools with large battery packs will stand upright on the battery pack but may be easily knocked over.*

Transportation



WARNING: Fire hazard. *Transporting batteries can possibly cause fire if the battery terminals inadvertently come in contact with conductive materials. When transporting batteries, make sure that the battery terminals are protected and well insulated from materials that could contact them and cause a short circuit.* ***NOTE:*** *Lithium-ion batteries should not be put in checked baggage.*

DEWALT batteries comply with all applicable shipping regulations as prescribed by industry and legal standards which include UN Recommendations on the Transport of Dangerous Goods; International Air Transport Association (IATA) Dangerous Goods Regulations, International Maritime Dangerous Goods (IMDG) Regulations, and the European Agreement Concerning The International Carriage of Dangerous Goods by Road (ADR). Lithium-ion cells and batteries have been tested to section 38.3 of the UN Recommendations on the Transport of Dangerous Goods Manual of Tests and Criteria.

In most instances, shipping a DEWALT battery pack will be excepted from being classified as a fully regulated Class 9 Hazardous Material. In general, only shipments containing a lithium-ion battery with an energy rating greater than 100 Watt Hours (Wh) will require being shipped as fully regulated Class 9. All lithium-ion batteries have the Watt Hour rating marked on the pack. Furthermore, due to regulation complexities, DEWALT does not recommend air shipping lithium-ion battery packs alone regardless of Watt Hour rating. Shipments of tools with batteries (combo kits) can be air shipped as excepted if the Watt Hour rating of the battery pack is no greater than 100 Wh.

Regardless of whether a shipment is considered excepted or fully regulated, it is the shipper's responsibility to consult the latest regulations for packaging, labeling/marking and documentation requirements.

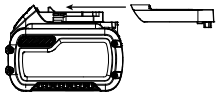
The information provided in this section of the manual is provided in good faith and believed to be accurate at the time the document was created. However, no warranty, expressed or implied, is given. It is the buyer's responsibility to ensure that its activities comply with the applicable regulations.

Transporting the FLEXVOLT™ Battery

The DEWALT FLEXVOLT™ battery has two modes: **Use** and **Transport**.

Use Mode: When the FLEXVOLT™ battery stands alone or is in a DEWALT 18V product, it will operate as an 18V battery. When the FLEXVOLT™ battery is in a 54V or a 108V (two 54V batteries) product, it will operate as a 54V battery.

Transport Mode: When the cap is attached to the FLEXVOLT™ battery, the battery is in Transport mode. Keep the cap for shipping.



When in Transport mode, strings of cells are electrically disconnected within the pack resulting in 3 batteries with a lower Watt hour (Wh) rating as compared to 1 battery with a higher Watt hour rating. This increased quantity of 3 batteries with the lower Watt hour rating can exempt the pack from certain shipping regulations that are imposed upon the higher Watt hour batteries.

For example, the Transport Wh rating might indicate 3 x 36 Wh, meaning 3 batteries of 36 Wh each. The Use Wh rating might indicate 108 Wh (1 battery implied).

Example of Use and Transport Label Marking



Storage Recommendations

1. The best storage place is one that is cool and dry away from direct sunlight and excess heat or cold. For optimum battery performance and life, store battery packs at room temperature when not in use.
2. For long storage, it is recommended to store a fully charged battery pack in a cool, dry place out of the charger for optimal results.

NOTE: Battery packs should not be stored completely depleted of charge. The battery pack will need to be recharged before use.

Labels on Charger and Battery Pack

In addition to the pictographs used in this manual, the labels on the charger and the battery pack may show the following pictographs:



Read instruction manual before use.



See ***Technical Data*** for charging time.



Do not probe with conductive objects.



Do not charge damaged battery packs.



Do not expose to water.



Have defective cords replaced immediately



Charge only between 4 °C and 40 °C.



Only for indoor use.



Discard the battery pack with due care for the environment.



Charge battery packs only with designated DEWALT chargers. Charging battery packs other than the designated DEWALT batteries with a DEWALT charger may make them burst or lead to other dangerous situations.



Do not incinerate the battery pack.



USE (without transport cap). Example: Wh rating indicates 108 Wh (1 battery with 108 Wh).



TRANSPORT (with built-in transport cap). Example: Wh rating indicates 3 x 36 Wh (3 batteries of 36 Wh).

Battery Type

The following tools operate on a 18 volt battery pack: DCD1623

These battery packs may be used: DCB184G, DCB547G. Refer to ***Technical Data*** for more information.

Package Contents

The package contains:

1 Magnetic drill press
1 16 mm Keyed chuck attachment
1 Chuck key
1 Coolant bottle with tube
1 Chip guard
1 Safety chain
2 Ejection pins
1 Feed handle set
1 Coolant bottle bracket
1 Allen key
1 Wrench
2 Wing bolts
1 Kitbox
1 Instruction manual

NOTE: Battery packs and chargers are not included with N models. Battery packs and chargers are not included with NT models. B models include Bluetooth® battery packs.

NOTE: The Bluetooth® word mark and logos are registered trademarks owned by the Bluetooth®, SIG, Inc. and any use of such marks by DEWALT is under license. Other trademarks and trade names are those of their respective owners.

- *Check for damage to the tool, parts or accessories which may have occurred during transport.*
- *Take the time to thoroughly read and understand this manual prior to operation.*

Markings on Tool

The following pictograms are shown on the tool:



Read instruction manual before use.



Wear ear protection.


Wear eye protection


Visible radiation. Do not stare into light.


Do not use this tool if you or any bystanders have a cardiac pacemaker or other medical implants.


Always use the safety chain. Secure the tool on the workpiece.

Date Code Position (Fig. B)

The date code **44**, which also includes the year of manufacture, is etched on the inside of battery port.

Example:

2022 XX XX

Year and Week of Manufacture

Description (Fig. A)

WARNING: *Never modify the power tool or any part of it. Damage or personal injury could result.*

1 ON/OFF switch
2 Magnet engagement lever
3 Forward/reverse switch
4 Speed selector
5 Gear selector
6 Feed handle
7 Feed handle hub
8 Feed handle release button
9 LED button
10 19 mm Weldon quick-change chuck
11 16 mm Keyed chuck
12 Motor height adjustment lever
13 Coolant bottle bracket
14 Coolant bottle
15 Coolant tube
16 Coolant coupling connector
17 Coolant flow regulator
18 Coolant bottle cap
19 Coupler nut
20 Magnetic base
21 Magnetic coolant bottle attachment point
22 Carry handle
23 Handle release button
24 Magnet engagement and gyro protection indicator
25 Chip guard
26 Safety chain

Intended Use

Your DCD1623 magnetic drill press has been designed for drilling holes in steel construction surfaces. Do not drill into non-ferrous metal.

DO NOT use under wet conditions or in the presence of flammable liquids or gases.

This drill press is a professional power tool.

DO NOT let children come into contact with the tool. Supervision is required when inexperienced operators use this tool.

- **Young children and the infirm.** This appliance is not intended for use by young children or infirm persons without supervision.
- This product is not intended for use by persons (including children) suffering from diminished physical, sensory or mental abilities; lack of experience, knowledge or skills unless they are supervised by a person responsible for their safety. Children should never be left alone with this product.

ASSEMBLY AND ADJUSTMENTS

WARNING: To reduce the risk of serious personal injury, turn tool off and disconnect battery pack before making any adjustments or removing/ installing attachments or accessories. *An accidental start-up can cause injury.*

WARNING: *Use only DEWALT battery packs and chargers.*

Transporting the Drill (Fig. A)

WARNING: To reduce the risk of serious personal injury, turn tool off, and remove the battery pack, before transporting, making any adjustments, cleaning, repairing, or removing/installing attachments or accessories. *An accidental start-up can cause injury.*

In order to conveniently carry the tool from place to place, a carry handle **22** has been included on the top of the tool.

Installing the Machine (Fig. A, G)

1. Assemble the feed handle.
2. Install the chip guard.
3. Fit the lubrication system as necessary.
4. This machine features a concave base making it possible to install on a solid surface, or a pipe with a diameter of no less than 101 mm and a thickness of no less than 9.5 mm. Remove any particles that will obstruct full contact between the magnetic base **20** and the mounting surface.
5. Fit and tighten the safety chain **26**.

Assembling the Feed Handle (Fig. C)

The quick-release feed handle can be mounted in one simple operation both to the left and the right of the machine.

1. Screw the handles **6** into the hub **7**. Ensure that the handles are secure.
2. Keep the hub realease button **8** depressed while inserting the hub shaft into the hole **33**.
3. Release the button.

Assemble the Chip Guard (Fig. D)

WARNING: *Always use the chip guard.*

1. Hold the chip guard **25** in front of the tool holder, aligning the slots in the chip guard with the holes in the machine.
2. Fit the wing bolts **39** (from the accessories bag) into the holes located in the front of the frame.

Lubrication System (Fig. A, E)

Filling the Coolant Bottle

WARNING: Do not pour cutting fluid into the bottle while mounted in the bracket. Do not allow cutting fluid to enter the drill motor. *Electric shock may result.*

WARNING: Do not allow cutting fluid to enter the battery port or come in contact with the battery pack.

NOTE: If battery comes in contact with cutting fluid wipe it off immediately. The cutting fluid used with this drill may compromise certain battery pack housings. It is highly recommended that battery packs with oil resistant housings (glass filled nylon, designated by a G suffix in the model number) be used.

NOTE: The lubrication system is designed for dispensing cutting fluids specifically intended for drilling. Other liquids may damage the system.

1. Turn the flow regulator **17** counterclockwise to close.
2. Remove coolant bottle **14** from magnetic coolant bottle bracket **13**.
3. Unscrew the cap **18**.
4. Fill the container with cutting coolant diluted with water.
5. Screw the cap back on.
6. Place coolant bottle into magnetic coolant bottle bracket **13**.

Fitting the Lubrication System (Fig. A, E)

WARNING: *Do not use the lubrication system in vertical surfaces or overhead drilling applications.*

Only use the lubrication system for horizontal drilling applications, as shown in Figure A.

1. Place coolant bottle **14** into the magnetic coolant bottle bracket **13**, then slide the magnetic coolant bottle bracket onto the either side of the magnetic coolant bottle attachment point **21**.
2. Attach the coolant tube **15** to the coupling connector **16** on the gearbox.
   a. Unscrew the nut **19** by the wrench first, and place the nut through the end of the coolant tube **15** .
   b. Press the coolant tube onto the coupling connector **16** first, then use a wrench to tighten the nut.
   c. To remove, unscrew the nut and then pull the coolant tube from the coupling connector.
   NOTE: After the coolant tube has been removed, tighten the nut on the coupling connector to prevent losing it.

In order to use the lubrication system, the coolant bottle **14** must be filled with a sufficient amount of cutting fluid.

Lubrication in Horizontal Applications (Fig. A, E)

1. Adjust the fluid flow as required using the flow regulator **17**.
2. Add more cutting fluid if the shavings become blue.

Lubrication in Vertical and Overhead Applications

Dip the cutter in cutting paste or apply an appropriate spray.

Fitting the Safety Chain (Fig. G)

WARNING: *Always use the safety chain.*

WARNING: *Never attach the safety chain through the carry handle.*

Feed the provided safety chain **26** through the safety chain opening **28** of unit and around the workpiece and secure in place.

Inserting and Removing an Accessory (Fig. F)

The tool holder accepts annular cutters with a Weldon 19 mm shank with two flats.

CAUTION: Laceration hazard. *The cutter teeth are sharp.*

1. Slide the pilot pin **42** through the hole in the center of the cutter shank.
2. Push up on the 19 mm Weldon quick-change chuck **11**.
3. Insert the cutter **43** with pilot pin and turn until the flat meets the locking pin. When the flat meets the locking pin the collar will snap down.
4. Check that the cutter is securely held in the arbor.
5. Lift the 19 mm Weldon quick-change chuck to release the cutter.

Three-Jaw Chuck (Fig. F)

A 3-jaw chuck **11** can be installed to fit the drill press for various bit sizes. Refer to ***Inserting and Removing an Accessory*** for installation instructions.

1. Place chuck key **27** in each of the three holes, and tighten in clockwise direction. It's important to tighten chuck with all three holes to prevent slippage.
2. To release bit, turn chuck key counterclockwise in just one hole, then loosen the chuck by hand.

NOTE: It may be necessary to adjust the motor position when chuck is installed. Please refer to ***Adjusting the Motor Height*** for instructions.

Refer to the ***Accessories*** section for further information on appropriate accessories.

Magnet Engagement Lever (Fig. M)

The magnetic strength can be switched by using the magnet engagement lever **2**.

Moving the magnet engagement lever towards the middle position increases the magnetic power to 15%. This is a feature to provide some user assistance while securing the unit into place.

Moving the magnet engagement lever to the left position increases the magnet power to 100%.

With the magnet engagement lever positioned to the right the magnetic power is turned off. When moving the handle from the left to the right the collar **37** on the handle must be lifted to move out of either 100% engaged or 15% engaged.

NOTE: The unit will not turn on until the magnet engagement lever is in the left position at 100%.

Gear Selector (Fig. J)

CAUTION: *Do not change gears while motor is running.*

The machine is equipped with a two-gear selector to vary the speed/torque ratio.

1. Press in the gear selector button 32 and rotate the gear selector dial 5 into the desired mode.
2. **LOW SPEED AND HIGH TORQUE**: Rotate the gear selector to the left for low speed and high torque.
   HIGH SPEED AND LOW TORQUE: Rotate the gear selector to the right for high speed and low torque.

	1	2	3	4	5
	250	370	500	660	810
	130	190	260	340	420

Speed Selection (Fig. A)

The tool features five speed settings for greater versatility.

1. To select a higher RPM setting, rotate the speed selector 4 to a higher number.
2. To select a lower RPM setting, rotate the speed selector to a lower number.

If the tool does not change speeds, confirm that the speed selection switch is completely engaged in the forward or back position.

Refer to the ***Speed (RPM) and Drill Settings*** chart at the back of this section for speed and cutter size recommendations.

Forward/Reverse Button (Fig. K)

A forward/reverse control button 3 determines the direction of bit rotation.

NOTE: The reverse feature of this tool is used for tapping screw holes. Reverse speed will be 350 rpms in low gear and 680 rpm in high gear regardless of variable speed.

To select forward rotation, release the ON/OFF switch 1 and switch the forward/reverse control button towards the forward icon 40.

To select reverse, switch the forward/reverse control button towards the reverse icon 41.

Adjusting the Motor Height (Fig. H)

The motor height can be adjusted to accommodate the need for more or less bit clearance over the workpiece.

1. Loosen the motor slide lever 12.
2. Position the motor to the desired height.
3. Tighten the motor slide lever firmly to secure the motor in position.
   NOTE: There are three set screws 38 along the side of the frame that can be tigthened or loosened to adjust how easily the motor housing moves with the feed handle 6.

OPERATION

Instructions for Use

WARNING: *Always observe the safety instructions and applicable regulations.*

WARNING: To reduce the risk of serious personal injury, turn tool off and disconnect battery pack before making any adjustments or removing/ installing attachments or accessories. *An accidental start-up can cause injury.*

Carry handle (Fig. I)

This carry handle has two functions:

- Carry the tool when it is in vertical position.
- Protect the battery from dropping off in its folded position for tool's upside down application.

Installing and Removing the Battery Pack (Fig. B)

WARNING: *Ensure the tool/appliance is in the off position before inserting the battery pack.*

WARNING: *Keep cutting fluid away from the battery pack. Contact with cutting fluid may cause the battery housing to crack. If battery comes in contact with cutting fluid, clean the battery immediately.*

NOTE: It is highly recommended that battery packs with oil resistant housings (glass filled nylon, designated by a G suffix in the model number) be used. For best results, make sure your battery pack is fully charged.

To install the battery pack 29 into the battery port 31 press and hold the carry handle release button 8 and move the carry handle 22 into the vertical position. Align the battery pack with the rails inside the battery port and slide it in until the battery pack is firmly seated in the tool and ensure that it does not disengage.

To remove the battery pack from the tool, press and hold the carry handle release button 8 and move the carry handle 22 into the vertical position. Press the release button 30 and firmly pull the battery pack out of the battery port. Insert it into the charger as described in the charger section of this manual.

NOTE: If the battery is still difficult to remove with the carry handle in the vertical position, press and hold the carry handle release button and push the carry handle a little further towards the front of the tool to create more space for the battery to be removed.

Fuel Gauge Battery Packs (Fig. B)

Some DEWALT battery packs include a fuel gauge which consists of three green LED lights that indicate the level of charge remaining in the battery pack.

To actuate the fuel gauge, press and hold the fuel gauge button 45. A combination of the three green LED lights will illuminate designating the level of charge left. When the level of charge in the battery is below the usable limit, the fuel gauge will not illuminate and the battery will need to be recharged.

NOTE: The fuel gauge is only an indication of the charge left on the battery pack. It does not indicate tool functionality and is subject to variation based on product components, temperature and end-user application.

Prior to operation

WARNING: *Inspect the chain before each use, for wear or damage. Replace if necessary.*

Try a few simple projects using scrap material until you develop a "feel" for the machine.

Switching On and Off (Fig. A)

In order to operate properly, the machine has to be switched following the procedure as described below.

Switching the power on and off

WARNING: *In a vertical or upside down application, the tool will drop off from the workpiece if the magnet engagement lever is* ***NOT*** *at the 100% position.*

Push the power switch 1 up **(I)** to run the tool.
NOTE: The tool will not run unless magnet is at 100% engagement. An orange light will illuminate indicating the magnet is not fully engaged.

Press the switch down **(0)** to shut down the tool.

E-Clutch® System and Low Voltage Indicator LED (Fig. A)

The DCD1623 is equipped with the DEWALT E-Clutch® system. This feature senses the motion of the tool and shuts the tool down if necessary. The E-Clutch® indicator 24 will illuminate red to indicate status.

The working LED on the front of the magnetic base 20 will flash to alert the user of low voltage conditions.

INDICATOR	DIAGNOSIS	SOLUTION
OFF	Tool is functioning normally	Follow all warnings and instructions when operating the tool.
RED SOLID	E-Clutch® System has been activated (ENGAGED)	With the tool properly supported, release trigger. The tool will function normally when the trigger is depressed again and the indicator light will go out.
ORANGE SOLID	The magnet engagement lever is not in the 100% position with the power switch on.	Move the magnet engagement lever to the 100% position.
WHITE FLASHING	Low voltage battery conditions	Suspend use of the tool and replace with fully charged battery.

Drilling with Annular Cutters

1. Annular cutters only cut material at the periphery of the hole, rather than converting the entire hole to shavings. As a result the energy required to make a hole is lower than for a twist drill.
2. When drilling with an annular cutter, it is not necessary to drill a pilot hole.

CAUTION: *Do not touch the cutter or the parts close to the cutter immediately after operation, as they may be extremely hot and cause burns to the skin. Ensure nobody is in the work area where the metal core is ejected.*

Drilling Conditions

The ease with which material can be drilled is dependent on several factors including tensile strength and abrasion resistance. Hardness and /or strength is the usual criterion, wide variations in machine ability can exist among material showing similar physical properties. The drilling conditions are dependent on requirements for tool life and surface finish. These conditions are further restricted by the rigidity of the tool and the workpiece, lubrication and machine power available. The harder the material the lower the cutting speed. Some materials of low hardness contain abrasive substances leading to rapid cutting edge wear at high speeds. Feed rates are governed by rigidity of set-up, volume of material to be removed, surface finish and available machine power.

Drilling a Hole (Fig. A)

1. Always apply an appropriate cutting fluid/coolant on the cutting area.
2. Lower the guard 25 so that it screens the surface to be drilled.
3. Make sure the drill point or cutter pilot is properly installed over the spot to be drilled.
4. Push the power switch 1 up **(I)** to run the tool.
5. Slowly feed the accessory into the workpiece using the feed handle 6.
6. At the start of the cut, apply light pressure to allow the accessory to perform the initial groove.
7. Continue applying sufficient pressure to achieve a smooth progressive cut. Do not force.
8. Take extra care when the accessory is about to break through the surface to prevent splintering.
9. Always turn off the motor, the magnet and the power, in that particular order, when work is finished and before removing the battery.

MAINTENANCE

Your power tool has been designed to operate over a long period of time with a minimum of maintenance. Continuous satisfactory operation depends upon proper tool care and regular cleaning.

WARNING: To reduce the risk of serious personal injury, turn tool off and disconnect battery pack before making any adjustments or removing/ installing attachments or accessories. *An accidental start-up can cause injury.*

The charger and battery pack are not serviceable.

Lubrication

Your power tool requires no additional lubrication.

Tool Connect™ Chip (Fig. L)

Optional Accessory

WARNING: To reduce the risk of serious personal injury, turn unit off and remove the battery pack before making any adjustments or removing/ installing attachments or accessories. *An accidental start-up can cause injury.*

Your tool is Tool Connect™ Chip ready and has a location for installation of a Tool Connect™ Chip.

Tool Connect™ chip **1** communicates with an optional application for your smart device (such as a smart phone or tablet) that connects the device to utilize the mobile application for inventory management functions.

Refer to ***Tool Connect™ Chip Instruction Sheet*** for more information.

Installing the Tool Connect™ Chip

1. Remove the retaining screws **34** that hold the Tool Connect™ Chip protective cover **36** into the tool.
2. Remove the protective cover and insert the Tool Connect™ Chip into the empty pocket **35**.
3. Ensure that the Tool Connect™ Chip is flush with the housing. Secure it with the retaining screws and tighten the screws.
4. Refer to ***Tool Connect™ Chip Instruction Sheet*** for further instructions.

Cleaning

WARNING: *Blow dirt and dust out of all air vents with clean, dry air at least once a week. To minimize the risk of eye injury, always wear ANSI Z87.1 approved eye protection when performing this procedure.*

WARNING: *Never use solvents or other harsh chemicals for cleaning the non-metallic parts of the tool. These chemicals may weaken the plastic materials used in these parts. Use a cloth dampened only with water and mild soap. Never let any liquid get inside the tool; never immerse any part of the tool into a liquid.*

Optional Accessories

WARNING: *Since accessories, other than those offered by DEWALT, have not been tested with this product, use of such accessories with this tool could be hazardous. To reduce the risk of injury, only DEWALT recommended accessories should be used with this product.*

Consult your dealer for further information on the appropriate accessories.

Protecting the Environment

Separate collection. Products and batteries marked with this symbol must not be disposed of with normal household waste.

Products and batteries contain materials that can be recovered or recycled reducing the demand for raw materials. Please recycle electrical products and batteries according to local provisions. Further information is available at **www.2helpU.com**.

Rechargeable Battery Pack

This long life battery pack must be recharged when it fails to produce sufficient power on jobs which were easily done before. At the end of its technical life, discard it with due care for our environment:

- Run the battery pack down completely, then remove it from the tool.
- Li-Ion cells are recyclable. Take them to your dealer or a local recycling station. The collected battery packs will be recycled or disposed of properly.

Speed (RPM) and Drill Settings (with 9Ah pack)

Cutter Size	Mild Steel	Iron Plate
14 mm–16 mm	600–1000 RPM	800–1200 RPM
	High Gear, Speed 4–5	High Gear, Speed 5
16 mm–21 mm	480–800 RPM	640–960 RPM
	High Gear, Speed 3–5	High Gear, Speed 4–5
21 mm–25 mm	400–660 RPM	530–800 RPM
	High Gear, Speed 3–4	High Gear, Speed 3–5
25 mm–30 mm	320–530 RPM	420–640 RPM
	Low Gear, Speed 4–5	High Gear, Speed 3–4
30 mm–35 mm	270–460 RPM	360–550 RPM
	Low Gear, Speed 4–5	Low Gear, Speed 4–5
35 mm–40 mm	230–400 RPM	320–480 RPM
	Low Gear, Speed 3–4	Low Gear, Speed 4–5
40 mm–45 mm	210–320 RPM	280–420 RPM
	Low Gear, Speed 3–4	Low Gear, Speed 3–5
45 mm–50 mm	190–320 RPM	260–380 RPM
	Low Gear, Speed 2–3	Low Gear, Speed 3–4
For 38 mm diameter or thicker than 25 mm and above use a 9Ah pack.		

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