

17" DRILL PRESS Operating and Maintenance Instructions

The 17" drill press of either the bench or floor type machine you completely assembled. All that is necessary is to raise the head to the operating position desired. On floor-type drills without raising mechanism in the head, lower clamp sets DP-828, raise head in position by sliding spreader on the column, then re-tighten clamp sets. On drills with raising mechanism in head, lower clamp sets on thrust collar below rack and operate ball-crank handle DDL-100-S to feed rack up through head. When rack is through head as far as necessary, re-tighten collar clamp sets, then loosen the head clamp sets and operate ball-crank handle to move head upward on the column. By alternately feeding the rack through the head and the head up and down on the column in this manner, the head and the rack can be set in the most convenient position for the job. It is not necessary to move the rack once set, except for extreme movements of the head.

POWER REQUIRED

For light shop work up to $\frac{1}{2}$ " in cast iron, a $\frac{1}{2}$ H.P. motor of the type of our No. 82-210 or No. 84-252 motor may be used. For medium duty work a $\frac{1}{2}$ H.P. motor is recommended. Use only a ball-bearing motor, preferably one with sealed ball bearings. For work up to $\frac{3}{4}$ " in cast iron, and for heavy continuous work a 1 H.P. motor is recommended. The motor should turn in a clockwise direction, viewed from the top of the motor, when installed. Our motors with built-in switches should be installed so that the switch is at the left-hand side as you face the machine. If motor turns the wrong way, reverse its rotation in accordance with the instructions accompanying the motor.

Install the motor pulley with the largest step at the top, and align it carefully with the spindle pulley to avoid undue wear on the sides of the belt. The motor bracket is adjustable back and forward for correct belt tension. Longer belt life will be obtained if the tension is not too great.

Refer to drawings and Table I for replacement parts.

OPERATING DRILL PRESSES IN GANGS

When a number of drill presses are to be used in gangs, as for production work, they should be provided with three-phase motors for the following reasons. Three-phase motors will save from 20 to 30 percent of the current required by ordinary single-phase motors, besides delivering more power. When they have no brushes, commutators, starting switches or short-circuit cutouts they are practically trouble-free, thus reducing upkeep cost. They are installed on a power line and thus do not flicker lights. A number of drill presses should not be operated with single-phase motors, taking the current from a lighting circuit; in fact this practice is **dangerous** and should be completely avoided.



Fig. 1. 17" Drill Press

Three-phase motors, being wound for 220 volts, must be operated from a power line. They should be wired by a licensed electrician and provided with three-phase switches, as they have no built-in switches or automatic cords.

INSTALLING PRODUCTION TABLE

Production table No. 1322 may be installed on the floor-type machine instead of the regular tilting table. To install, remove index pin DP-464-S and clamp nut and washer DP-1827 and DP-1101, then remove the regular table. Insert production table and replace clamp nut and washer and index pin. The production table has a $\frac{1}{2}$ " x 12" x 12" table surface and is provided with a $\frac{1}{2}$ " x 12" x 12" x 12" table. It is especially suitable for the

D-218



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