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### LEVELING THE DRILL PRESS

Drill press should be level and rest solidly on floor; place shims underneath the three foundation holes to level the drill press. Equal pressure should be applied to foundation bolts to prevent distorting the base.

### RAISING HEAD AND TABLE TO OPERATING POSITION

1. To position drill head, loosen clamp handle on left side of drill press.
2. Slide head up column to desired height and tighten clamp handle.
3. Loosen set screw in safety collar and slide it up column until it touches bottom of head, then tighten set screws.
4. To position table, loosen clamp handle on right side of table.
5. Slide table up column to desired height, and tighten clamp handle.

*Generally, the normal and most convenient position for the head is about 8" to 10" from top of column.*

**IMPORTANT:** Always keep safety collar locked under head.

### LUBRICATION

Keep QUILL (A) and COLUMN (C) covered with a light film of oil— see Fig. (1). FEED SHAFT (B) grease weekly with No. 1 bearing grease — fittings under head.



Figure 1

*All bearings in the head and lower quill are sealed-for-life ball bearings and do not require lubrication. Occasionally grease spindle splines.*

Once a year, clean and grease (medium cup grease) cam in handwheel (C, fig. 2). To disassemble — loosen screw (A) and remove plate (B); remove handwheel by taking out center bolt.



Figure 2

## 15" DRILL PRESSES

VARIABLE SPEED DRIVE

MODELS 1660 THROUGH 1747

SERIES — 16VC-1 — 16VT-1

FROM SERIAL No. 507200 TO \_\_\_\_\_

JUNE 1965

FILE NO. 1661-2

1.2  
2.2  
3.1  
4.2  
5.2  
6.2

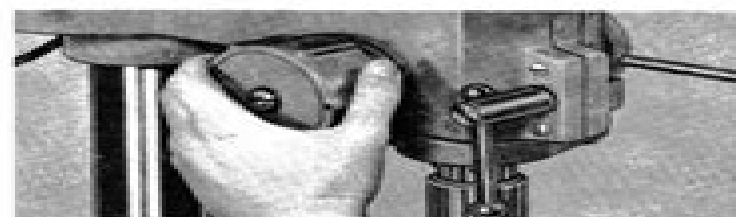


Figure 3

### ADJUSTING SPINDLE RETURN SPRING

To increase tension, lower quill to bottom of stroke, turn the spring cap counter-clockwise. To release tension, pull out spring cap (fig. 3) and turn clockwise.

### ADJUSTING SPINDLE END PLAY

1. Release spindle return spring tension (fig. 3).
2. While holding spindle to prevent its falling, remove hex nut on bottom of depth stop rod. Remove spindle and quill assembly from head.
3. Loosen set screw in collar directly above quill.
4. Push spindle firmly against bottom of quill. Force collar against top of quill and lock collar in this position.
5. Rotate spindle by hand to make sure it turns freely — **DO NOT** have adjustment too tight.
6. Replace spindle — quill assembly.

### ADJUSTING DEPTH STOP

1. When setting drill depth, position pointer at depth required and tighten nuts.
2. Loosen screws and with quill at maximum travel, position scale so pointer is at  $4\frac{3}{4}$ ", then tighten screws (A, fig. 4).

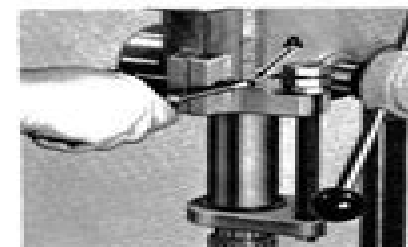


Figure 4

# Clausing 15 Drill Press Manual

**Joacim Rocklöv**



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