



DIVISION, ATLAS PRESS CO.
KALAMAZOO, MICHIGAN

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 TO OPERATING POSITION WITH TABLE LIFT

1. Loosen table lock (D, fig. 1).
2. With lift crank (J), raise the table (E) to bottom of spindle (C). (Place block of wood between spindle and table.)
3. Lock table *securely* with handle (D).
4. Loosen two head lock nuts (A) and quill lock (K).
5. Lift head by turning feed handle (B) counter-clockwise. While holding handle, tighten head lock nuts (A).

6. Slide safety collar (M) up to bottom of head. Tighten screws (L) in collar.

REPEAT OPERATIONS 1-6 until table has reached top of rack.

RAISE RACK—steps 7-10.

7. Lock table with handle (D, fig. 1).
8. Loosen two screws (G) in rack collar (F).
9. Turn crank (J), raising rack (H) to bottom of collar (M).

10. Securely tighten two screws (G) in rack collar.

REPEAT OPERATIONS 1-10 until head is in position.

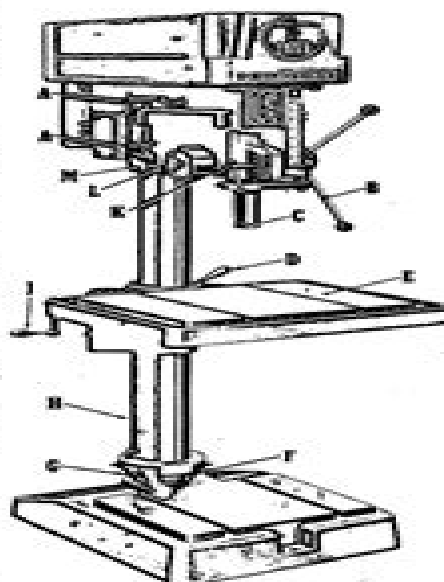


Figure 1

20" DRILL PRESSES VARIABLE SPEED DRIVE

SERIES - 22V

FROM SERIAL No. 500456 TO 501382

MODELS 2251 THROUGH 2288

JUNE, 1961 - FILE No. 2271-2

LUBRICATION

1. SPINDLE PULLEY DRIVE — use a light grease occasionally on spindle splines (A, fig. 2).
2. LOWER QUILL BEARING (C) — lubricate daily with a few drops of S.A.E. No. 20 oil. (All other ball bearings in head are lubricated-for-life.)
3. FEED SHAFT (B) oil once a week with S.A.E. No. 20 oil.
4. Keep QUILL (J) and COLUMN (H) covered with a light film of oil.
5. TABLE LIFT SHAFT (F) — oil once a week with S.A.E. No. 20 oil.
6. LIFT RACK (G) — lubricate regularly with S.A.E. No. 20 oil. Before oiling, clean rack with brush and kerosene.
7. TABLE LIFT GEARS — once a year, clean and repack with gear grease.

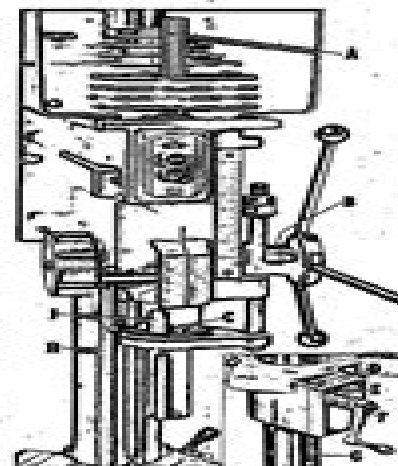


Figure 2

LUBRICATING VARIABLE DRIVE

1. Oil hole in fork (A, fig. 3) — oil once a week with S.A.E. No. 20 oil.
2. Oil post (B) and rod (D) occasionally with S.A.E. No. 20 oil.
3. Do not oil pulley bearings (C).
4. Once a year, clean and grease (medium cup grease) cam in handwheel (C, fig. 4). To disassemble — loosen screw (A) and remove plate (B); remove handwheel by taking out center bolt.



Figure 3



Figure 4

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Fundamentals of Machine Tool Technology and Manufacturing Processes C. Thomas Olivo,1990 Thomas Register of American Manufacturers ,2003 Vols for 1970 71 includes manufacturers catalogs *American Machinist & Automated Manufacturing* ,1986-07 *Wood & Wood Products* ,1980 **Machinery** Fred Herbert Colvin,Lester Gray French,1959 **Machinery** Lester Gray French,1964 *Production* ,1969 School Shop ,1985 Basic Machine Technology C. Thomas Olivo,1980 Good No Highlights No Markup all pages are intact Slight Shelfwear may have the corners slightly dented may have slight color changes slightly damaged spine *Kalamazoo, the Place Behind the Products* Larry B. Massie,Peter J. Schmitt,1981

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