



DIVISION, ATLAS PRESS COMPANY
KALAMAZOO, MICHIGAN 49007

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 holes 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 (F) 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.

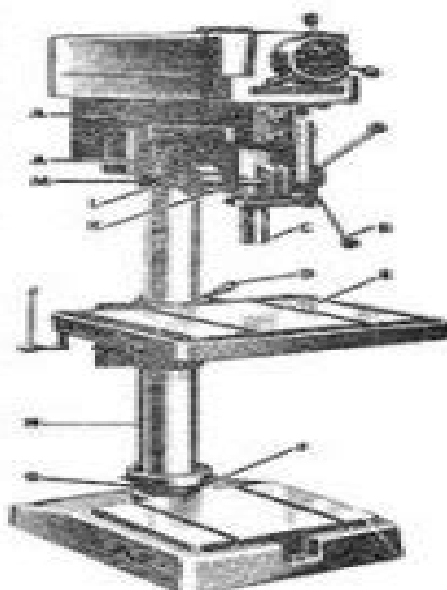


Figure 1

20" DRILL PRESSES VARIABLE SPEED DRIVE

SERIES — 22V-1
FROM SERIAL NO. 517001 TO _____
MODELS 2251 THROUGH 2287
and
2251-300 THROUGH 2287-300
AUGUST, 1975

LUBRICATION

1. **SPINDLE PULLEY DRIVE** — use a light grease occasionally on spindle splines (A, fig. 3).
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)** grease weekly with No. 1 bearing grease — fittings under head.
4. Keep **QUILL (H)** and **COLUMN (G)** covered with a light film of oil.
5. **TABLE LIFT SHAFT (E)** — oil once a week with S.A.E. No. 20 oil.
6. **LIFT RACK (F)** — lubricate regularly with S.A.E. No. 20 oil. Before oiling, clean rack with kerosene.
7. **TABLE LIFT GEARS (D)** — once a year, clean and repack with gear grease.

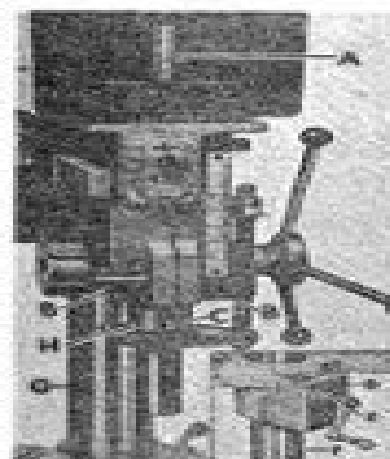


Figure 2

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. Lubricate pulley bearing (C) once a month with ball bearing grease.
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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Surplus Record



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