#### 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

- Loosen table lock (D, fig. 1).
- 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).
- 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 OPERA-TIONS 1-6 until table has reached top of rack.

RAISE RACK—steps 7-10.

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

REPEAT OPERA-TIONS 1-10 until head is in position.

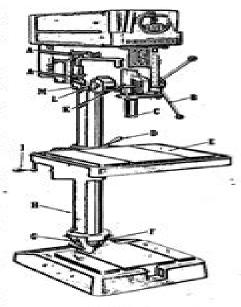


Figure 1

#### 20" DRILL PRESSES

#### VARIABLE SPEED DRIVE

SERIES - 22V

FROM SERIAL No. 500456 TO 501382

MODELS 2251 THROUGH 2288

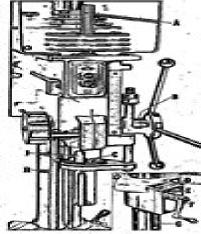
JUNE, 1961 - FILE No. 2271-2

1.2 2.1 3.2 4.1 5.1 6.1 7.2

#### LUBRICATION

- SPINDLE PULLEY DRIVE use a light grease occasionally on spindle splines (A, fig. 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.)
- FEED SHAFT (B) oil once a week with S.A.E. No. 20 oil.
- Keep QUILL (J) and COLUMN (H) covered with a light film of oil.
- TABLE LIFT SHAFT (F) — oil once a week with S.A.E. No. 20 oil.
- LIFT RACK (G) lubricate regularly with S.A.E. No. 20 oil. Before oiling, clean rack with brush and kerosene.
- TABLE LIFT GEARS

   once a year, clean
   and repack with gear
   grease.



LUBRICATING VARIABLE DRIVE

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



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