



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.

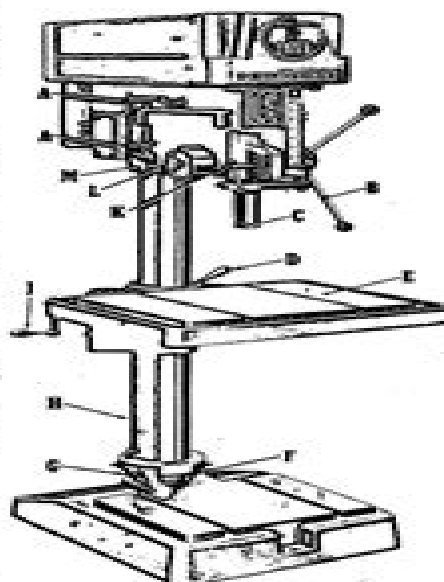


Figure 1

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.

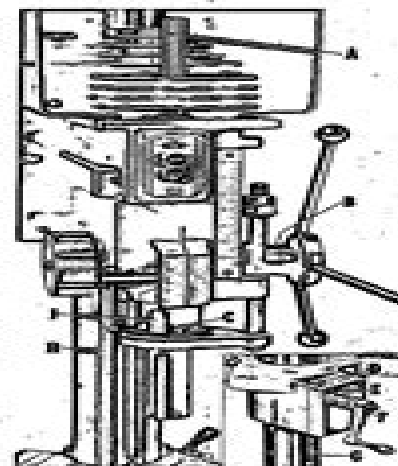


Figure 2

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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L Manion



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Table of Contents Detroit Drill Press Manual

1. Understanding the eBook Detroit Drill Press Manual
 - The Rise of Digital Reading Detroit Drill Press Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Detroit Drill Press Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Detroit Drill Press Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Detroit Drill Press Manual
 - Personalized Recommendations
 - Detroit Drill Press Manual User Reviews and Ratings
 - Detroit Drill Press Manual and Bestseller Lists
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- Detroit Drill Press Manual Public Domain eBooks
- Detroit Drill Press Manual eBook Subscription Services
- Detroit Drill Press Manual Budget-Friendly Options
- 6. Navigating Detroit Drill Press Manual eBook Formats
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 - Detroit Drill Press Manual Compatibility with Devices
 - Detroit Drill Press Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Detroit Drill Press Manual
 - Highlighting and Note-Taking Detroit Drill Press Manual
 - Interactive Elements Detroit Drill Press Manual
- 8. Staying Engaged with Detroit Drill Press Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Detroit Drill Press Manual
- 9. Balancing eBooks and Physical Books Detroit Drill Press Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Detroit Drill Press Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Detroit Drill Press Manual
 - Setting Reading Goals Detroit Drill Press Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Detroit Drill Press Manual
 - Fact-Checking eBook Content of Detroit Drill Press Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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