

The adjusting screw (C) Fig. 5 and nut (D) are set at the factory to give the quill the proper sliding fit in the head casting. After long service play between quill and head casting can be removed without the need to replace these parts. The nut (D) Fig. 5 is loosened, adjustment is made with the screw (C), and the nut is again tightened to prevent the screw from turning. Hold the screw with a screwdriver when nut is tightened, and check by moving the quill up and down several times to be sure the quill does not bind. This adjustment should be made with the stop rod (E) Fig. 5 removed.

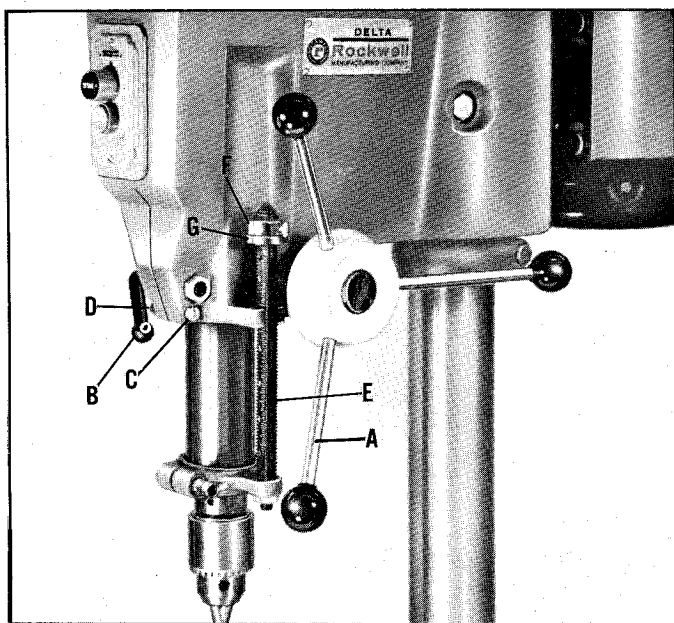


Fig. 5

DRILLING HOLES TO DEPTH

When drilling one or two holes to a predetermined depth, the calibrations on the face of the depth stop rod (E) Fig. 5, can be used.

When drilling a number of holes to a predetermined depth, or if a more exact setting is required, proceed as follows:

1. Raise the locking sleeve (F) Fig. 5, and turn the micro-nut (G) to the desired position on the stop rod (E).
2. Lower the locking sleeve (F) so it will engage micro-nut (G) Fig. 5. Lock sleeve in place with thumb screw if drill press head is mounted in other than vertical position. When the drill press is mounted with the chuck pointing up the locking sleeve (F) and micro-nut (G) Fig. 5, should be reversed on the stop rod (E).
3. When locking sleeve (F) is in place on the micro-nut (G) Fig. 5, the micro-nut can not be turned. When a change in depth is required, the locking sleeve (F) must be raised and while it is raised, turn the micro-nut (G) the necessary calibration marks. Each mark represents .002". Then lower the locking sleeve.

4. The use of the micro-set stop nut will maintain the same hole depth, no matter how many holes are to be drilled. However, we recommend that the hole depth be checked whenever a drill has to be sharpened or changed.

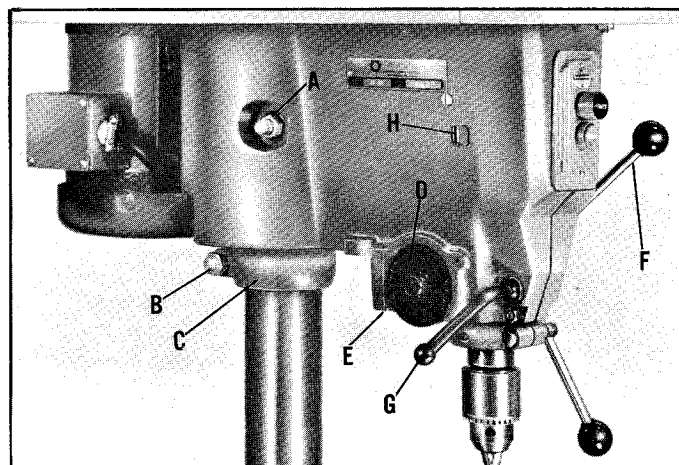


Fig. 6

ADJUSTING SPINDLE RETURN SPRING

For the purpose of automatically returning the spindle upward after the hole has been drilled, a clock spring is provided enclosed in the case (D) Fig. 6. This spring has been properly adjusted at the factory and should not be disturbed unless absolutely necessary. If at any time it is necessary to adjust it proceed as follows:

1. To increase the tension of the spring, turn the screw (E) Fig. 6, which is located underneath the head, clockwise. CAUTION: BE CAREFUL NOT TO BOTTOM RETURN SPRING WHILE TURNING SCREW (E) FIG. 6, CLOCKWISE, THERE SHOULD BE ENOUGH SLACK LEFT IN SPRING TO PERMIT LOWERING THE SPINDLE THE FULL AMOUNT OF TRAVEL.
2. To decrease tension of the spring, turn the screw (E) Fig. 6, counterclockwise.
3. The tension of the spring can be tested by pulling down the pilot wheel lever (F) Fig. 6, and testing to see if the quill will return to the up position. Be sure the quill locking lever (G) Fig. 6, is loose while testing. NOTE: Before determining if this adjustment is necessary, make sure the stop rod (E) Fig. 5, runs freely up and down and is not twisted in the slot or guide of the head casting.

HOW TO CHANGE SPINDLE ADAPTERS

One of the unique features of the Variable Speed 15" Drill Press is the ease with which various spindle adapters may be used.