

Fig. 7

When removing either the chuck or the spindle adapters, we recommend the use of the Cat. No. 15-838 spanner wrench which is supplied with your drill press. Turn the locking collar of the adapter or chuck with the spanner wrench while keeping the spindle from turning by either holding V-belt or holding the chuck with the chuck key in one of the pilot holes in the nose of the chuck, as shown in Fig. 7.

When attaching adapters to the spindle, it is very important to wipe clean both the spindle taper and taper hole in adapter. Then place the adapter on the spindle and tighten the locking collar (A) Fig. 7. If in checking the spindle for accuracy, there should be a run out, we suggest that the adapter be removed and turned perhaps one quarter or one-half turn and replaced. This may reduce or eliminate the run out, it may also increase it, in which case, remove the adapter and turn it some more on the spindle.

## INSTALLING MOTOR

1. When installing a Rockwell 6" Frame Motor, insert the key in the keyway of the motor shaft and place the pulley on the motor shaft until the edge of the pulley sleeve is against the shoulder of the motor shaft.

2. When installing a NEMA 56 Frame Motor, insert the key in the keyway of the motor shaft and place the pulley on the motor shaft, with the edge of the pulley sleeve  $1/8''$  from the shoulder on the motor shaft.

3. If you are installing a NEMA 56 Frame Motor, it is necessary to remove the two upper motor mounting studs (A) Fig. 8, and reposition them in the holes (B) directly below.

4. Make sure the key is in place and tighten the two set screws (C) against the motor shaft.

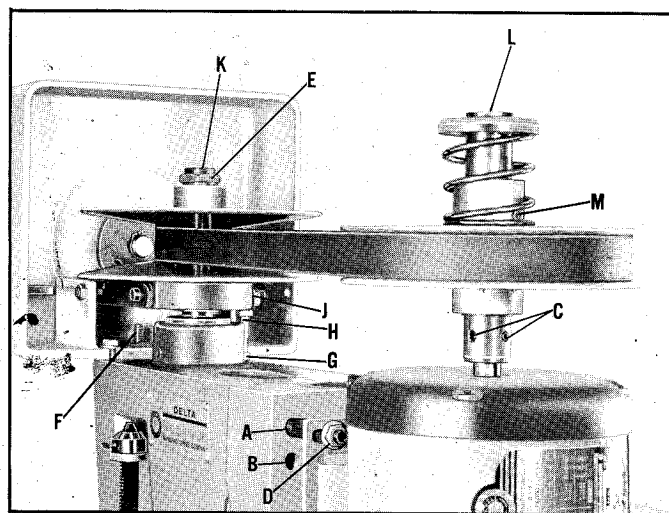


Fig. 8

5. Place the motor on the four motor mounting studs (A) Fig. 8, and install belt.

6. Visually line up the motor shaft so that it is in parallel alignment with the spindle. If the motor must be tilted to the front or rear, it is necessary to loosen the four nuts (D) and move studs (A) in or out as desired until the motor shaft is parallel with the spindle. Then tighten the four nuts (D) Fig. 8.

7. After the motor shaft is in parallel alignment with the spindle, adjust the belt tension. The correct tension is obtained when the distance from the center of the spindle to the center of the motor shaft is approximately  $15 \frac{1}{8}''$ . This may be done by following Steps 8 and 9. When making this adjustment it is important that the motor is kept in parallel alignment with the spindle pulley.

8. If the motor must be moved further away from the spindle, back off each of the four nuts (D) and back off the four studs (A) an equal number of turns against the motor base plate.

9. If the motor must be moved forward turn in each of the four studs (A) an equal number of turns and tighten nuts (D) against the motor base plate.

10. The spindle nut (E) Fig. 8, should then be adjusted so that the distance from the top of the nut to the top of the spindle is  $1/4$  to  $5/16''$ .

11. TO CALIBRATE THE SPINDLE SPEED turn the drill press on and turn pilot wheel clockwise. When the outside circumference of the belt extends  $1/32''$  beyond the outside circumference of the motor pulley, turn off the power, loosen locknut (G) Fig. 8, and adjust the stop screw (H) until it is bearing against the bottom of the bearing retainer (J). With a 1725 rpm motor the speed of the drill press will be approximately 4700 rpm. With a 1140 rpm motor the speed of the drill press will be approximately 3100 rpm. Now set the pointer (B) Fig. 2,