



DELTA POWER TOOL DIVISION
ROCKWELL
 MANUFACTURING COMPANY
 PITTSBURGH 8, PENNSYLVANIA



PM 448-01-651-0001

DATED 11-17-59

HEMOCRAFT RADIAL DRILL PRESS

The new radial drill press possesses all of the basic features of the popular Delta 11" Drill Press. Added to its advantages of flexibility and capacity, the new Delta Radial Drill Press is far "superior" to conventional type drill presses or to similar machines costing four or five times more.

INSTALLATION

After removing your #11-280 Radial Drill Press from the carton, place the base, vertical column and table assembly on a Delta No. 50-821 steel stand or any other suitable level surface. The base should be fastened to the stand or work bench using three 5/16 inch round head stove bolts. Remove the vertical column clamp assembly Fig. 1 from the tee bracket. Place the head, motor plate, and tee bracket assembly on the vertical column. Replace the clamp assembly, taking care to reassemble in the same order. When the motor is installed and the motor pulley and V-Belt are assembled, it is necessary to move the head to take up belt slack. The head Fig. 6 (25) is secured by two set screws (2). At the same time, the head should be set perpendicular to the table surface. Check this setting by means of a drill in the chuck and a square off the table surface. This adjustment should be performed with the plunger locator (12) engaged in the milled slot in the horizontal column (9). This can be checked by noticing the scribed line on the column opposite the milled slot. This line will correspond with the zero mark on the scale (15) when the plunger is engaged.

SELECTING THE MOTOR

We recommend a Delta No. 62-413 1/3 hp. AC, 115 volt, 60 cycle, 1725 rpm motor.

When selecting a motor from any other source, be sure that it is capable of taking end thrust and that it is protected against loss of lubricant when operated in the vertical position.

Use a constant speed 1725 rpm motor. Do not exceed this speed, as higher rates will shorten the life of the spindle bearings.

SPINDLE SPEEDS

The four pulley steps give spindle speeds of 700, 1250, 2400, and 4700 rpm when a 1725 rpm motor is used.

PULLEY AND BELT

The No. 985 motor pulley furnished with this drill press has 1/2-inch bore. It will fit the Delta motor recommended.



Figure 1

INSTALLING THE MOTOR

Attach the motor to the mounting bracket in the vertical position, with the shaft upward, using the carriage bolts SP-808 with washers and nuts. The bracket is slotted to receive the 6-inch frame motor recommended above; some other motors may require special mounting arrangements. Do not tighten the bolts permanently until the belt has been lined up.

Slip the motor pulley No. 985, with the smallest step downward, onto the motor shaft. Make sure that the set screws SP-201 engage the flat of the shaft, and tighten them firmly. Install the drive belt over corresponding steps of the motor and spindle pulleys.

The motor should run clockwise when viewed from above. If it runs the wrong way, reverse its rotation according to the manufacturer's directions furnished on motor name plate.

BELT ALIGNMENT AND TENSION

Place a straight edge across the top of the motor pulley to check the elevation with respect to the spindle pulley. Raise or lower the motor in the slots of the mounting bracket to make the pulleys level. Keep the motor shaft vertical; there is some play in the slots, which might permit the motor to tilt slightly. Tighten

Rockwell Drill Press Owners Manual

Ying-Ying Zheng



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