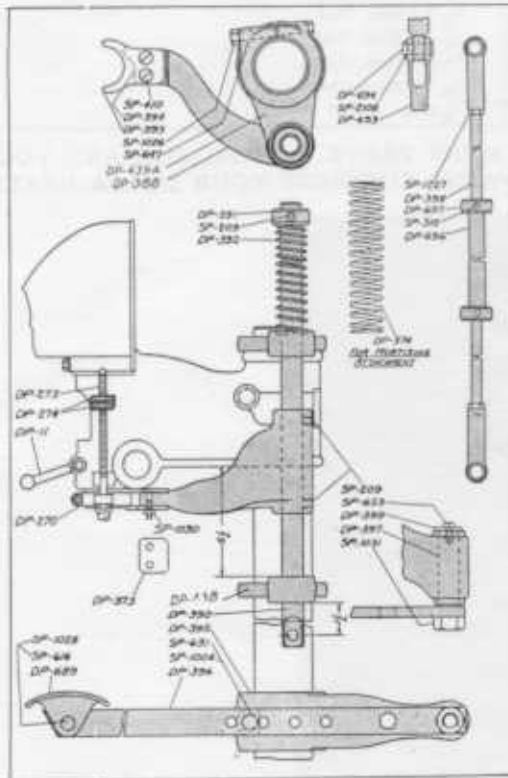


FOOT FEED FOR 14" DRILL PRESS Instructions for Installing and Operating



The No. 1007 foot power feed comes packed in small assemblies for convenience. Installation is simple if the following procedure is adopted. Remove the head and table of the drill press by sliding them off the top of the column. Slide treadle lever bracket DP-395 over the column so that about 4" of the column is exposed between this bracket and the base. Clamp with the treadle lever on right hand side parallel with the center line of base casting. Replace table assembly by sliding standard table assembly over column and clamping, or if new No. 1006 production table is used by following instructions on reverse side. Next slip lower slide-rod bracket DP-389-B (without counterbore) over column, with ribs down, and clamp temporarily in position with hole in bracket on right hand side and approximately $\frac{1}{2}$ " back of column center line $6\frac{1}{2}$ " down from bottom of head as shown.

Replace drill press head and clamp it, leaving $\frac{3}{4}$ " of column exposed above head casting. Slip upper slide rod bracket over column with counterbore up, and clamp temporarily in line with lower bracket.

Shifter bracket DP-388 has a forked steel plate DP-393 on top and a single pronged plate DP-394 at the bottom, where it engages the quill by straddling the quill with one plate above and one plate below the stop rod collar DP-270. The shim plate DP-373 is used only when the foot feed mechanism is used with the No. 990 or No. 996 Tapping Chuck.

Turn stop rod nuts DP-274 to the top of stop rod DP-273, move quill to its lowest position and tighten with quill clamp screw DP-11. Put the quill end of the shifter bracket DP-388 in position, straddling the quill and stop rod collar DP-270, bringing hole on shifter bracket in line with holes in slide rod bracket, DP-389 and DP-389-B. Slide rod DP-390 is passed through the three holes and brought to a position with the clevis pin hole approximately $\frac{1}{2}$ " from bottom of lower bracket. Tighten shifter bracket DP-388 securely on slide rod DP-390 using Allen set screws SP-209.

With slide rod brackets DP-389 and DP-389-B slightly loose tap them lightly at the ends to make the Slide Rod DP-390 perfectly free, in line with column and the Shifter Bracket DP-388 engaging the quill properly. Tighten the Slide Rod Brackets firmly in this position. Slip return spring DP-392 over slide rod extension above head and put collar DP-391 in place.

Make adjustment for spring tension with collar to suit individual job. Spring DP-392, which is the lighter, is to be used for tapping and drilling. The heavier Spring DP-374 is to be used for the mortising attachment where a heavy return pressure is required.

Fasten one yoke DP-693 to bottom of slide rod using clevis pin DP-694. Fasten other tie-rod yoke to one of four small holes in treadle lever. The tie rod is adjustable for length by loosening set screws SP-310 and sliding the end rods DP-398 in and out of the center tube DP-696.

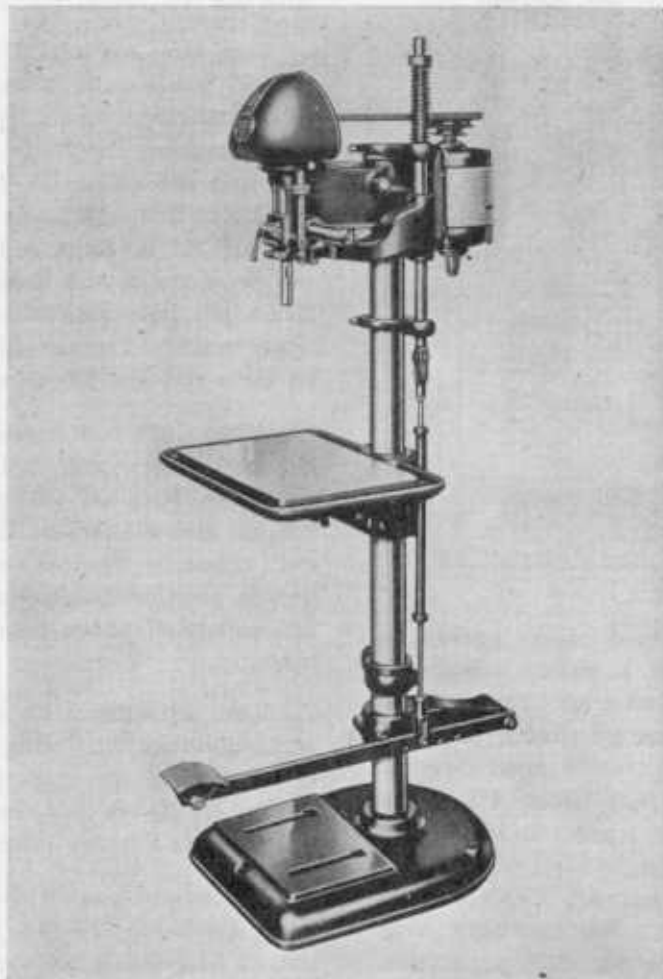
The treadle lever DP-396 has two $\frac{49}{64}$ " holes at the rear to fit over the pivot pin. This gives two lengths of treadle lever, and, with the four clevis pin holes, gives a variety of lever ratios to cover all types of work. The lower treadle lever bracket DP-395 can be raised or lowered to give a variety of movements for standing or sitting to suit individual operator.

Table 1. REPLACEMENT PARTS

IMPORTANT: Give both the Part Number and the Description of each item when ordering from this list; also the Serial Number of the machine on which the parts are to be used.

Part No.	Description	No. Req.	Part No.	Description	No. Req.
DP-373	Shim Plate	1	DP-696-S	Connect. Tube & Collar Assem.	1
DP-374	Spring (for mortising attach.)	1	SP-3	3/8" Allen Wrench 1535	1
DP-388	Shifter Bracket	1	SP-209	3/8-16 x 3/8" Allen Set Screw	3
DP-439	Support Collar (Upper)	1	SP-310	3/8-16 x 5/8" Sq. Hd. Set Screw	2
DP-438-S	Support Collar (Lower)	1	SP-410	3/16-18 x 1 1/2" Flat Hd. Mach. Screw	2
DP-390	Rod	1	SP-616	1/2-13 x 1 1/2" Hex. Hd. Cap Screw	1
DP-391	Set Collar Complete	1	SP-631	7/16-14 x 4" Hex. Hd. Cap Screw	1
DP-392	Spring	1	SP-647	3/8-16 x 3 3/4" Hex. Hd. Cap Screw	2
DP-393	Shift Bracket Plate (Upper)	1	SP-653	3/8-24 x 3/8" Hex. Hd. Cap Screw	1
DP-394	Shift Bracket Plate (Lower)	1	SP-1004	7/16-14 Hex. Nut	1
DP-395	Lower Bracket	1	SP-1026	3/8-16 Hex. Nut	2
DP-396	Treadle Lever	1	SP-1028	1/2-13 Hex. Nut	1
DP-397	Treadle Lever Shaft	1	SP-1030	7/16-18 Hex. Nut	2
DP-398	Connecting Rod	2	SP-1031	3/4-16 Hex. Nut	1
DP-399	Special Washer	1	SP-1227	1/2-20 Hex. Nut	2
DP-689	Treadle Pad	1	SP-1703	3/16" Lockwasher	2
DP-693	Clevis	2	SP-2108	1/8 x 1" Cotter Pin	2
DP-694	Clevis Pin	2			

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14" DRILL PRESS WITH FOOT FEED

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