

Rockwell MANUFACTURING COMPANY

**POWER TOOL DIVISION
PITTSBURGH 8, PENNSYLVANIA**



I-5-9

PM-402-05-655-5010

1371 FOOT FEED FOR 17" DRILL PRESS

Instructions for Installing

Slip gear quadrant DP-687 up through opening in bottom of drill press head, then slip splined shaft DP-688 through quadrant from the right hand side of head. Place fiber washer between quadrant and drill press head. The shouldered end of spindle shaft goes through the left-hand side of the head as shown in drawing. Tighten clamp screw SP-670 to hold quadrant to shaft.

Place other washer DP-698 on splined shaft between drill press head and lever DP-686. Slip lever DP-686 over outer splined end of shaft with quadrant positioned as shown. Pulling down on the lever should now move the quill down. Tighten lever DP-686 on shaft and assemble one clevis DP-693 to the lever with pin DP-694 and cotter pin SP-2108.

Assemble lower bracket DP-685 to the column, about 2 inches up from the bottom, and tighten temporarily in this position. Assemble foot lever DP-682-S to shaft DP-681. The small pin in foot lever to be inserted in one of the holes in shaft DP-681. Assemble lower clevis and reach rod to the foot lever, then slip the connecting tube DP-696 over the rods, set the foot lever approximately level, and the upper feed lever DP-686 as shown and tighten the set screws SP-310 in the connecting tube collars, centering the tube between the upper and lower reach rods.

To tension the foot lever spring, loosen nut SP-1282, put a wrench on the flats of shaft DP-681 and turn about half a turn. Tighten nut SP-1282, if tension is not enough, loosen nut and turn shaft further.

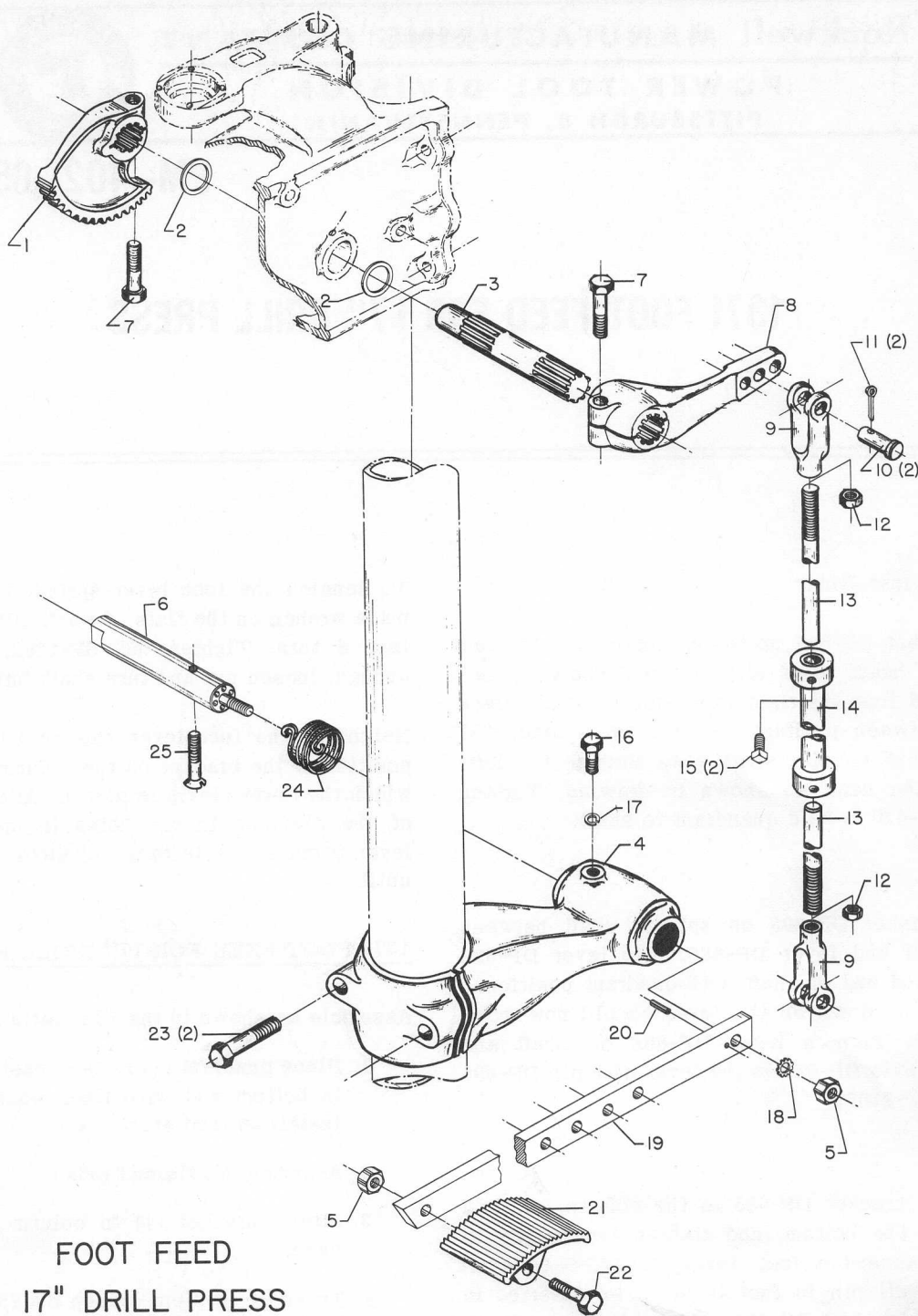
Height of the foot lever can be adjusted both by the position of the bracket on the column and the holes into which the lower clevis is placed. Altering the adjustment of the clevises in the holes in upper level and foot lever permits a wide range of stroke adjustment for the quill.

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Assemble as shown in the illustration.

1. Place quadrant (1) in head casting through opening in bottom and with fiber washers (2) as shown, install splined shaft (3).
2. Assemble clevis and rods.
3. Attach bracket (4) to column about 2" up from base.
4. To apply tension, loosen nut (5) and with wrench, turn shaft (6) about 180° and tighten nut. If more tension is required, loosen nut and turn shaft further.

Height of the foot lever can be adjusted by repositioning of the bracket on the column and repositioning the lower clevis in the foot lever.



FOOT FEED 17" DRILL PRESS

Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
1	DP-687	Gear Sector	14	DP-696-S	Connecting Tube with Collars
2	DP-689	Fiber Washer	15	SP-310	3/8-16 x 5/8" Sq. Hd. Set Scr.
3	DP-688	Shaft	16	SP-642	3/8-16 x 1" Hex. Hd. Cap Scr.
4	DP-685	Column Bracket	17	SP-1704	3/8" Lockwasher
5	SP-1282	1/2"-13 Hex. Nut	18	SP-1755	1/2" External Tooth Lockwasher
6	DP-681	Treadle Lever Shaft	19	DP-682-S	Treadle Lever, Incl:
7	SP-670	3/8-24 x 1 3/4" Hex. Hd. Cap Scr.	20	SP-2718	3/16 x 3/4" Roll Pin
8	DP-686	Lever	21	DP-689	Treadle Pad
9	DP-693	Clevis	22	SP-616	1/2-13 x 1 1/2" Hex. Hd. Cap Scr.
10	DP-694	Clevis Pin	23	SP-667	1/2-20 x 2 1/2" Hex. Hd. Cap Scr.
11	SP-2108	1/8 x 1" Cotter Pin	24	DP-691	Treadle Lever Return Spring
12	SP-1227	1/2"-20 Hex. Jam Nut	25	SP-462	3/8-24 x 2" Flat Hd. Mach. Scr.
13	DP-695	Rod			