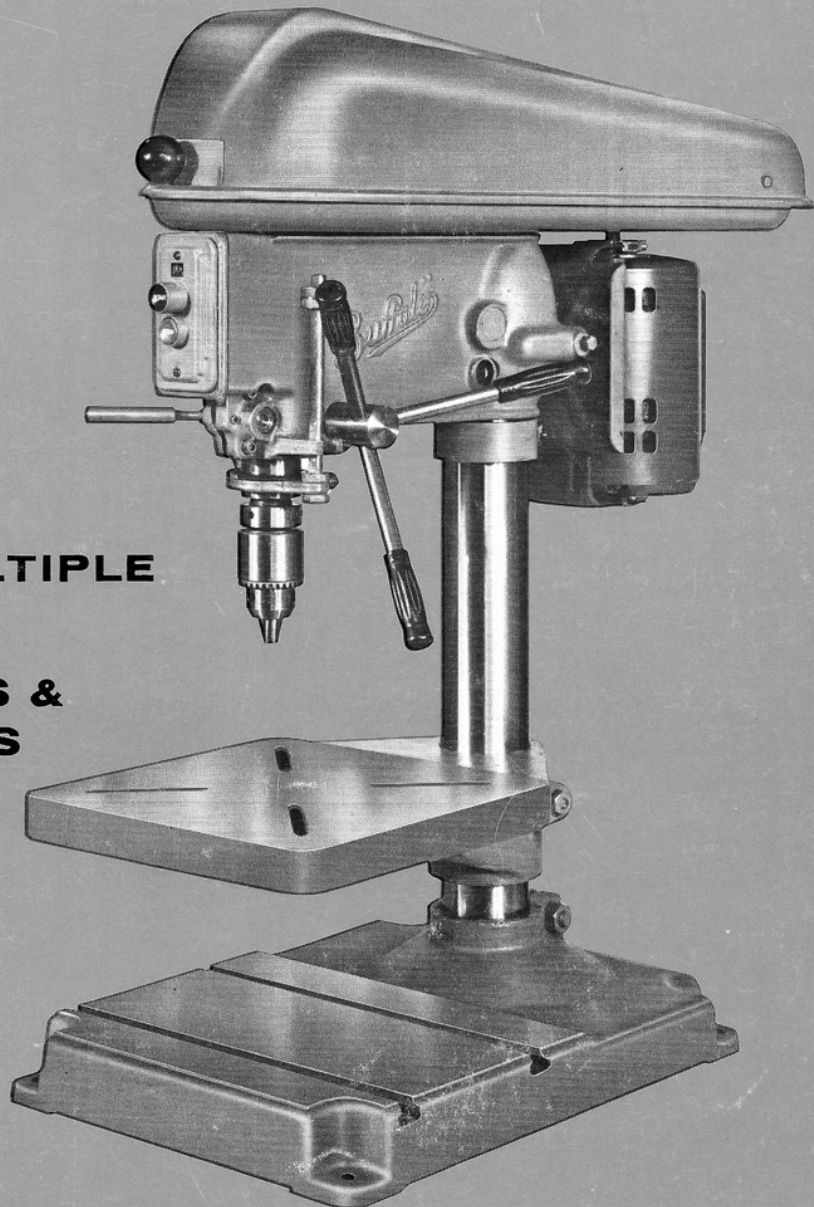




NUMBER
15
PRECISION
DRILLING MACHINES

- **FIVE MODELS**
- **SINGLE & MULTIPLE SPINDLE**
- **ACCESSORIES & ATTACHMENTS**

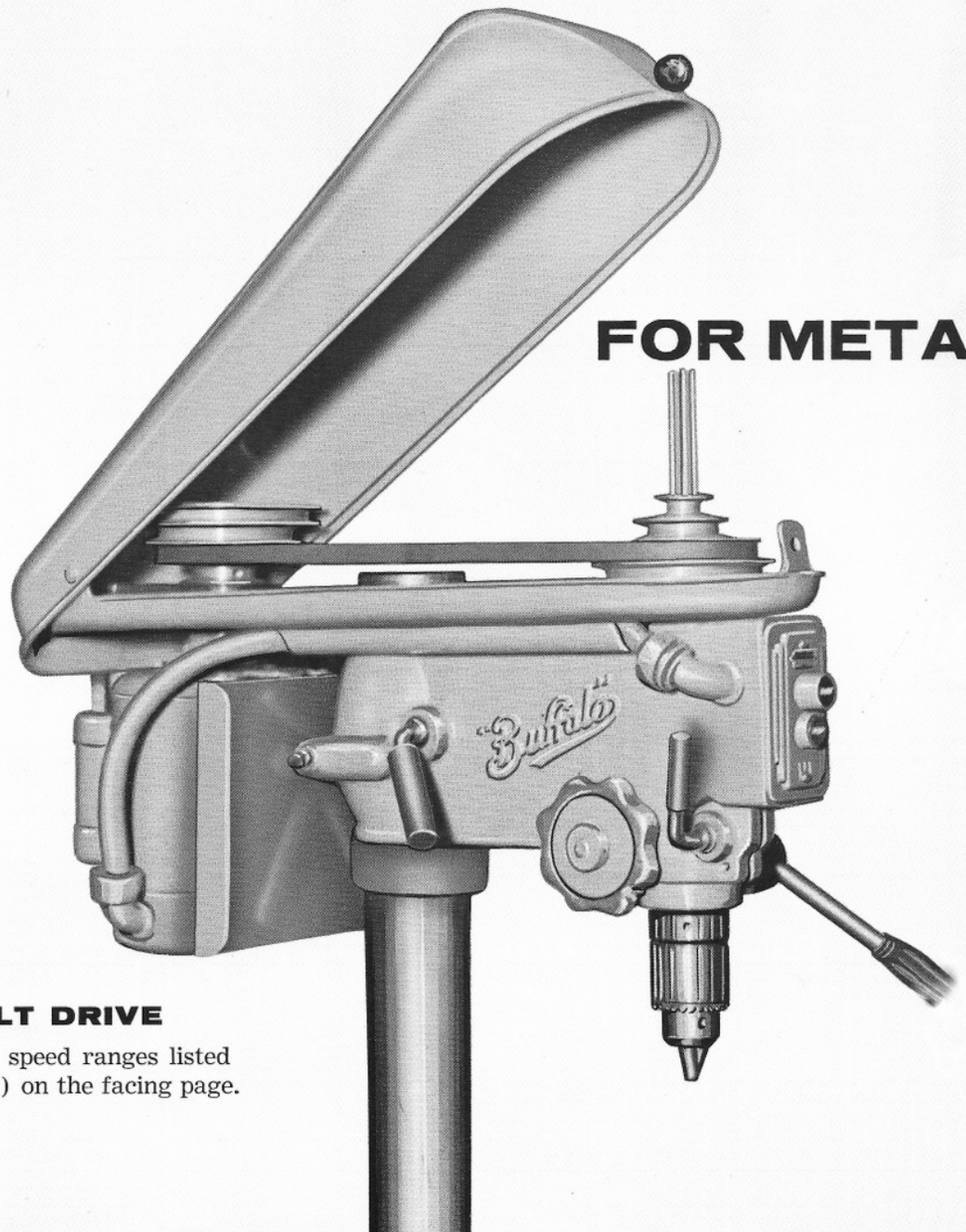


BULLETIN NO. 4024-D



NUMBER
15
PRECISION
DRILLING MACHINES

FOR METAL



V-BELT DRIVE

Provides speed ranges listed
under (1) on the facing page.

Buffalo No. 15 Drilling Machines are best known for Precision, Accuracy and Full ½" Capacity in operation as well as Economy, Extended Service Life and Unexcelled quality.

- 1** 5 speeds for high and low speed drilling

| SPEED RANGE | MOTOR |
|------------------------|---------------------------|
| 460-920-1725-3400-6300 | 60 cycle 1750 RPM |
| 295-600-1140-2200-4200 | 60 cycle 1140 RPM |
| 380-760-1450-2850-5300 | 50 & 25 cycle 1450 RPM |

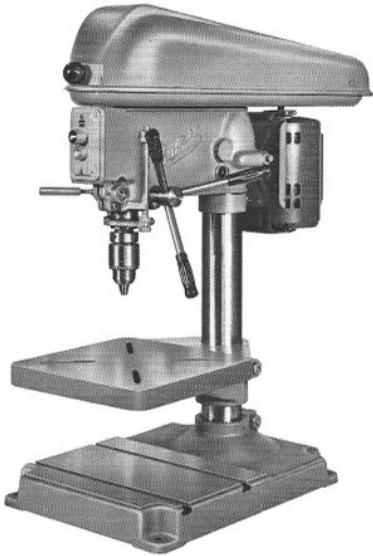
plus, a slow speed attachment at extra cost, which provides additional speeds of 1/4 of speeds listed above.

OR WOODWORKING SERVICE

- 2** Controlled belt tension.
- 3** Adjustable motor bracket.
- 4** Simplified speed changes on progressive pulley steps.
- 5** Frame mounted push-button switch designed for operator convenience.
- 6** Full 4½" spindle travel.
- 7** Counter-balanced complete belt guard facilitates easy belt changes.
- 8** Positive spindle height lock.
- 9** Quick adjusting spindle return spring.
- 10** Positive depth stop with large spin-adjustable nuts.
- 11** Easily adjusted, frame mounted, head-raising device.
- 12** Wear compensation provided by split frame at feed sleeve.
- 13** All bearings "lube-sealed" for life.
- 14** Streamlined "easy clean" bases and table surfaces.



NUMBER
15
PRECISION
DRILLING MACHINES



HEAVY DUTY
BENCH-DRILL

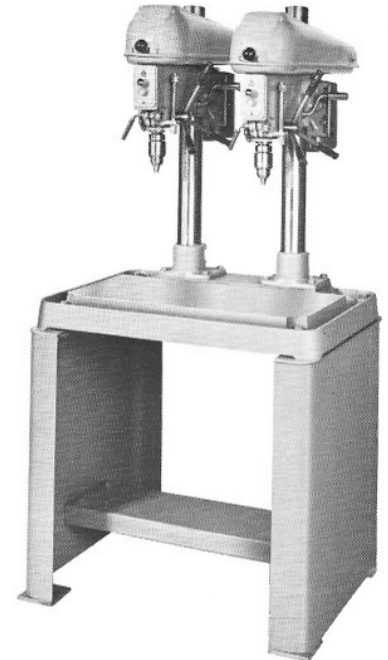
The basic unit for use in factory or any heavy duty drilling. The head is standard. Head-raising device is available as an optional extra. The non-tilting table is 11" x 11". And, it may be swivelled out of the way so that long parts may be set on the 10" x 13" base for drilling. A 10" x 11" tilting table is available at a slight additional cost.



HEAVY-DUTY
FLOOR DRILL

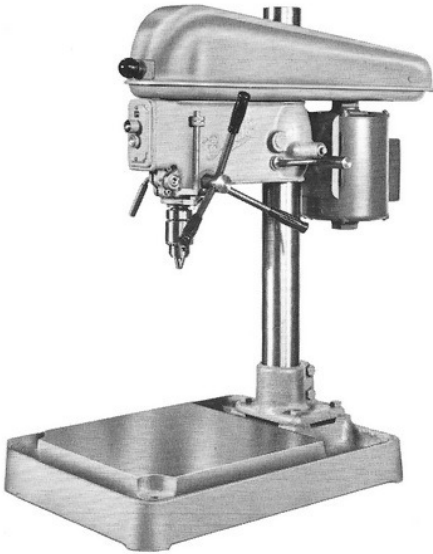
A versatile tool for a variety of uses in the average machine shop. The 11" x 11" non-tilt table swivels on the 2-3/4" diameter column and is mounted on a 10" x 13" base. Maximum distance of spindle nose to base is 47" and to table 41". Overall height of drill is 68-1/2".

The foot feed and/or table adjusting screw, as shown, can be supplied with this model. An oil trough table, slow speed attachment or mortising attachment are also available as extra accessories.



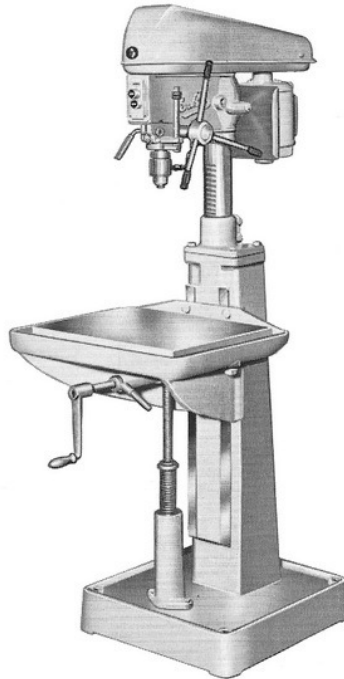
MULTIPLE SPINDLE
BENCH DRILL

This 2-spindle production bench drill is mounted on legs. The pressed steel legs are furnished as an extra. Two and three spindle drills require two legs. Four, six and eight spindle models require three. This model is furnished with head raising device. Working surface of the table, with oil trough, varies from 14 x 14" for one spindle to 14 x 92" for the eight spindle model.



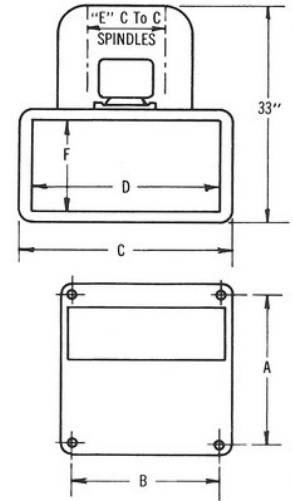
PRODUCTION BENCH MODEL

Rugged production models are available in bench or pedestal types, one to eight spindles, with or without bench legs. All machines are furnished with a frame-mounted head raising device featuring a single gear reduction for easy adjustment. The head raising pinion mates with rack teeth generated in the drill column. This combination provides the versatility necessary to production use.



PEDESTAL TYPE DRILL

For the shop where higher production and versatility are required, this sturdy efficient machine delivers years of dependable service. Convenient three-spoke feed wheels are fitted with comfortable grips. Head and table raising devices provide maximum flexibility of movement to the work. Available in one to eight spindles, machine can be equipped with pneumatic feeds, coolant system, etc. Overall height is 75". Maximum distance of spindle nose to table is 36-1/2". Working surface of table ranges from 14 x 18" for one spindle to 14 x 96" for eight spindle models.



PEDESTAL

DIMENSIONS AND WEIGHTS

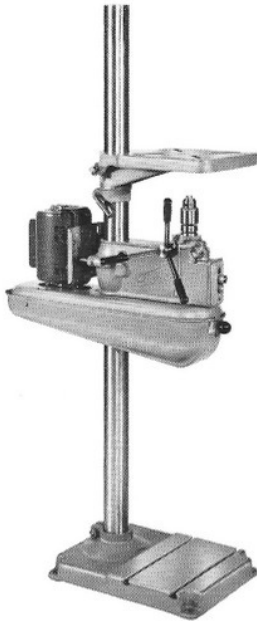
| SPINDLES | 1 | 2 | 3 | 4 | 6 | 8 |
|-------------------|--------|--------|--------|--------|--------|--------|
| A | 19 | 19 | 19 | 19 | 19 | 19 |
| B | 19 3/4 | 19 3/4 | 29 3/4 | 39 3/4 | 60 | 106 |
| C | 21 3/4 | 33 3/4 | 45 3/4 | 57 3/4 | 71 1/4 | 120 |
| D | 18 | 30 | 42 | 54 | 65 1/4 | 114 |
| E | | | | | | |
| C. to C. spindles | — | 10 | 10 | 10 | 10 | 13 3/4 |
| F | 14 | 14 | 14 | 14 | 14 | 17 |
| Net Wgt. | 435 | 635 | 835 | 1025 | 1555 | 2080 |

NO. 15 MULTIPLE SPINDLE DRILLS

| SPINDLES | WORKING SURFACE OF TABLE | | CENTER DISTANCE BETWEEN SPINDLES | |
|----------|--------------------------|--------------|----------------------------------|----------|
| | Production Bench | Pedestal | Production Bench | Pedestal |
| 1 | 14 x 14" | 14 x 18" | — | — |
| 2 | 14 x 26" | 14 x 30" | 12" | 10" |
| 3 | 14 x 38 1/2" | 14 x 42" | 12" | 10" |
| 4 | 14 x 50 1/2" | 14 x 54" | 12" | 10" |
| 6 | 14 x 74 1/2" | 14 x 65 1/4" | 12" | 10" |
| 8 | 14 x 92" | 14 x 96" | 11 1/2" | 13 3/4" |

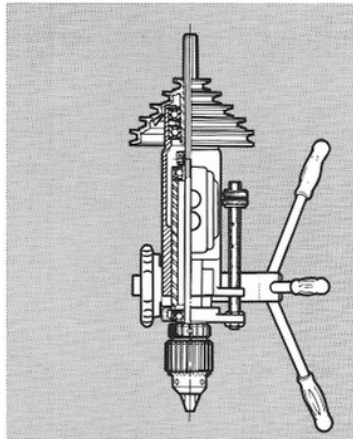


NUMBER
15
PRECISION
DRILLING MACHINES



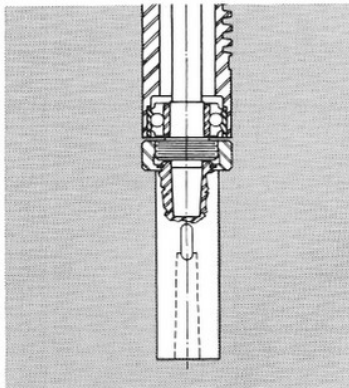
**INVERTED HEAD
FOR ROUTING OR
BACK SPOT-FACING**

Photo illustrates this application which can be set up in the field without tools in a matter of minutes.



SPINDLE ASSEMBLY

Four "sealed-for-life" ball bearings provide positive alignment between the spindle and the spindle pulley. The spindle nose has a No. 33 taper and is fitted with a Jacobs No. 663 D chuck with an attached chuck remover which helps hold the chuck securely on the spindle taper.



No. 1 or 2 Morse taper and straight shank noses are available in place of or in addition to the standard Jacobs 663 D chuck. The 33 taper bore and locking collar fit the standard 33 taper spindle.

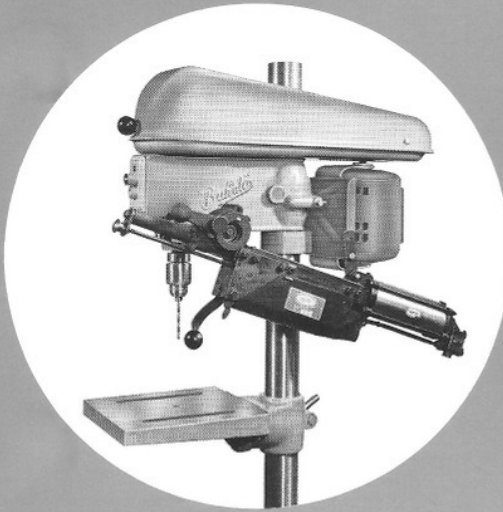
ACCESSORIES



TAPPING MACHINE

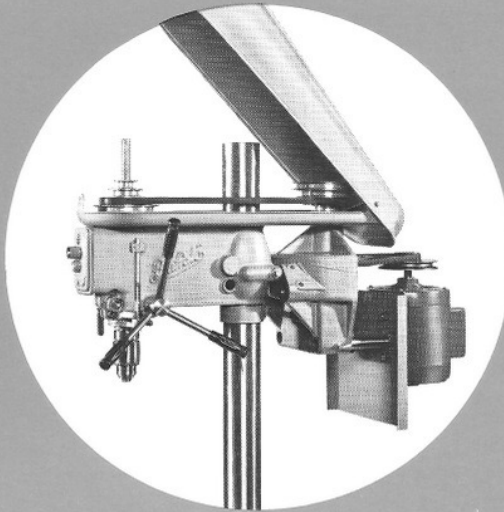
This inexpensive model produces results equal to machines costing many times more. It is available in two sizes . . . No. 0 - 3/16" and No. 1 - 5/16" capacity. A stripper and tap oiler are provided. A 1/3 or 1/2 HP, 1750 RPM motor is required for the No. 0; a 1/2 HP, 1140 RPM motor is recommended for the No. 1.

AND ATTACHMENTS



AIR FEEDS

Providing time and money saving set-ups, these accessories are easily installed and are practically trouble-free. Used on applications ranging from a simple power feed to intermittent or automatic cycle feed. Photo also shows tilting table (an optional extra).

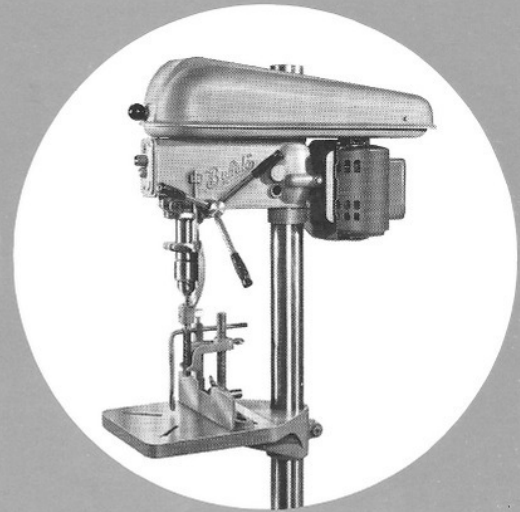


SLOW SPEED ATTACHMENT

Available on all machines, this attachment provides five additional lower speeds.

| SPEED RANGE | MOTOR |
|----------------------|---------------------------|
| 115-230-430-850-1575 | 60 cycle 1750 RPM |
| 75-150-285-550-1050 | 60 cycle 1140 RPM |
| 95-190-360-710-1325 | 50 & 25 cycle 1450 RPM |

Above speeds are in addition to standard speeds listed on Page 3.

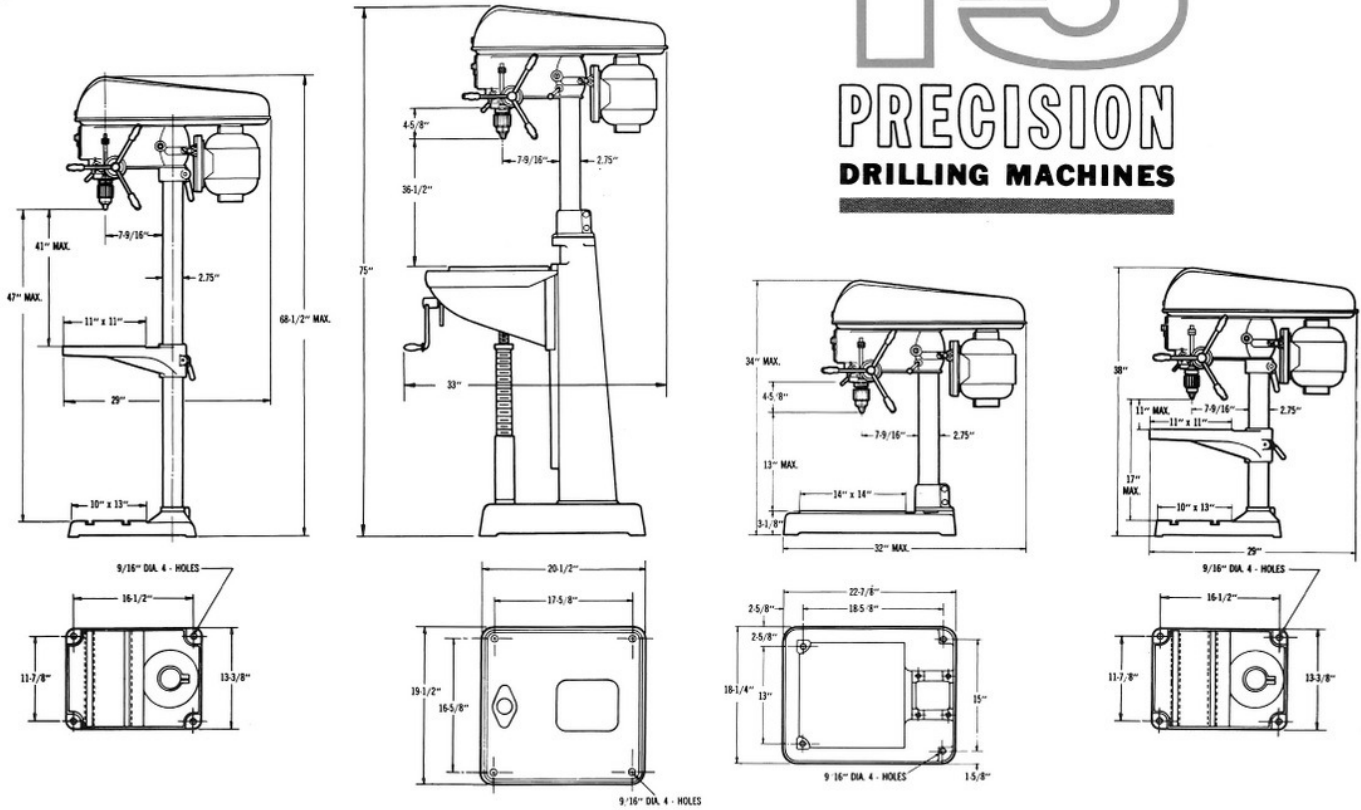


MORTISING ATTACHMENT

Adapted to the No. 15 drill, this mortising attachment fits over the chuck. The fence and hold-down are of all-metal construction similar to those used on higher priced mortising machines. Capacity: 1/2" square. Use chisel with 5/8" shank.

GENERAL SPECIFICATIONS

NUMBER 15 PRECISION DRILLING MACHINES



| NO. 15 DRILLING MACHINES | No. 15 Bench | | No. 15 Floor | | No. 15 Prod. Bench | | No. 15 Pedestal | | No. 15 Tapper | |
|-----------------------------------|--------------|----------|--------------|----------|--------------------|----------|-----------------|----------|---------------|----------|
| | | | | | | | | | No. 0 | No. 1 |
| Capacity in Cast Iron: | | | | | | | | | | |
| With 1/3 H.P. Motor | 1/2" | 1/2" | 1/2" | 1/2" | 1/2" | 1/2" | 1/2" | 1/2" | 3/16" | — |
| With 1/2 H.P. Motor | 5/8" | 5/8" | 5/8" | 5/8" | 5/8" | 5/8" | 5/8" | 5/8" | — | 5/16" |
| Motor H.P. — Standard | 1/3 | 1/3 | 1/3 | 1/3 | 1/3 | 1/3 | 1/3 | 1/3 | 1/3 | 1/2 |
| Spindle Sleeve Diameter | 1.747" | 1.747" | 1.747" | 1.747" | 1.747" | 1.747" | 1.747" | 1.747" | 1.747" | 1.747" |
| Max. Dist., Spindle Nose to Base | 17" | 47" | 13" | — | 43 1/2" | 42" | 35 1/2" | 37" | 35 1/2" | 35 1/2" |
| Max. Dist., Spindle Nose to Table | 11" | 41" | — | 36 1/2" | 37" | 35 1/2" | 35 1/2" | 37" | 35 1/2" | 35 1/2" |
| Feed Travel | 4 1/2" | 4 1/2" | 4 1/2" | 4 1/2" | 4 1/2" | 4 1/2" | 4 1/2" | 4 1/2" | 2 1/2" | 2 1/2" |
| Column Diameter | 2 3/4" | 2 3/4" | 2 3/4" | 2 3/4" | 2 3/4" | 2 3/4" | 2 3/4" | 2 3/4" | 2 3/4" | 2 3/4" |
| Maximum Height | 38" | 68 1/2" | 34" | 75" | 68 1/2" | 68 1/2" | 68 1/2" | 68 1/2" | 68 1/2" | 68 1/2" |
| Net Weight, Lbs. | 96 | 133 | 182 | 435 | 155 | 162 | 155 | 155 | 155 | 162 |
| Working Surface of Base | 10 x 13" | 10 x 13" | 14 x 14" | — | 10 x 10" | 10 x 10" | 10 x 10" | 10 x 10" | 10 x 10" | 10 x 10" |
| Working Surface of Table | 11 x 11" | 11 x 11" | — | 14 x 18" | 11 x 11" | 11 x 11" | 11 x 11" | 11 x 11" | 11 x 11" | 11 x 11" |

Spindle Nose No. 33 Jacobs Taper or No. 1 or No. 2 Morse Taper Noses

Spindle Speeds — All Models:

 With 1750 RPM Motor 460 — 920 — 1725 — 3400 — 6300

 With 1450 RPM Motor 380 — 760 — 1450 — 2850 — 5300

 With 1140 RPM Motor 295 — 600 — 1140 — 2200 — 4200

BUFFALO FORGE COMPANY
 MACHINE TOOL DIVISION / BUFFALO 5, NEW YORK
 CANADIAN BLOWER & FORGE CO., LTD. / KITCHENER, ONTARIO

