

OPERATING INSTRUCTIONS
and
PARTS LIST

CLAUSING

20-inch DRILL PRESSES

VARIABLE SPEED DRIVE
MODELS



CLAUSING CORPORATION

2019 N. PITCHER ST., KALAMAZOO, MI 49007



DIVISION, ATLAS PRESS CO.
KALAMAZOO, MICHIGAN

LEVELING THE DRILL PRESS

Drill press should be level and rest solidly on floor; place shims underneath the three foundation holes to level the drill press. Equal pressure should be applied to foundation bolts to prevent distorting the base.

RAISING HEAD TO OPERATING POSITION WITH TABLE LIFT

1. Loosen table lock (D, fig. 1).
2. With lift crank (J), raise the table (E) to bottom of spindle (C). (*Place block of wood between spindle and table.*)
3. Lock table *securely* with handle (D).
4. Loosen two head lock nuts (A) and quill lock (K).
5. Lift head by turning feed handle (B) counter-clockwise. While holding handle, tighten head lock nuts (A).

6. Slide safety collar (M) up to bottom of head. Tighten screws (L) in collar.

REPEAT OPERATIONS 1-6 until table has reached top of rack.

RAISE RACK—steps 7-10.

7. Lock table with handle (D, fig. 1).
8. Loosen two screws (G) in rack collar (F).
9. Turn crank (J), raising rack (H) to bottom of collar (M).

10. Securely tighten two screws (G) in rack collar.

REPEAT OPERATIONS 1-10 until head is in position.

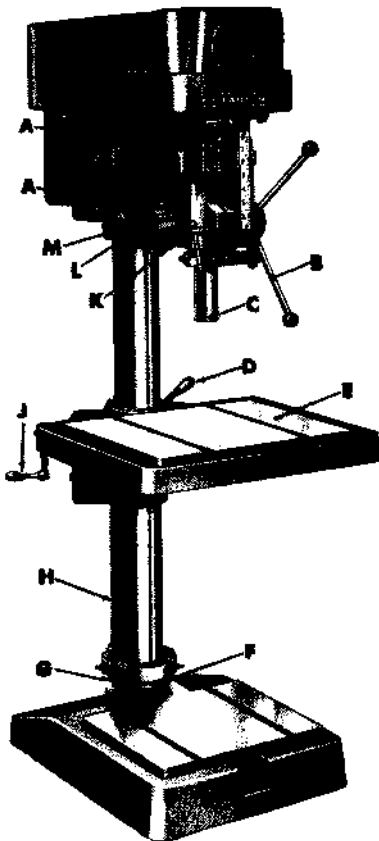


Figure 1

20" DRILL PRESSES

VARIABLE SPEED DRIVE

SERIES - 22V-1

FROM SERIAL No. 503725 TO _____

MODELS 2251 THROUGH 2288

APRIL, 1964 - FILE No. 2271-6

1.6
2.2
3.6
4.1
5.3
6.3
7.2
8.1

LUBRICATION

1. **SPINDLE PULLEY DRIVE** — use a light grease occasionally on spindle splines (A, fig. 2).
2. **LOWER QUILL BEARING (C)** — lubricate daily with a few drops of S.A.E. No. 20 oil. (All other ball bearings in head are lubricated-for-life.)
3. **FEED SHAFT (B)** grease weekly with No. 1 bearing grease — fittings under head.
4. Keep **QUILL (H)** and **COLUMN (G)** covered with a light film of oil.
5. **TABLE LIFT SHAFT (E)** — oil once a week with S.A.E. No. 20 oil.
6. **LIFT RACK (F)** — lubricate regularly with S.A.E. No. 20 oil. Before oiling, clean rack with kerosene.
7. **TABLE LIFT GEARS (D)** — once a year, clean and repack with gear grease.

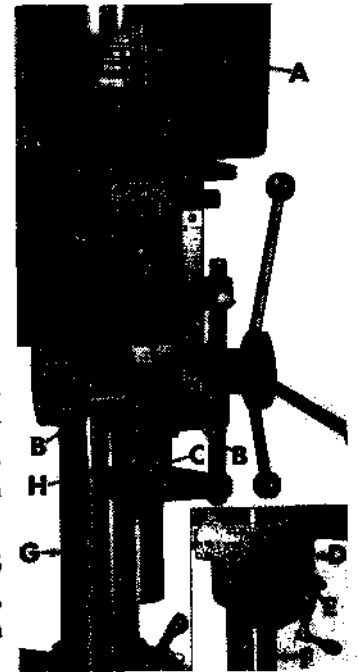


Figure 2

LUBRICATING VARIABLE DRIVE

1. Oil hole in fork (A, fig. 3) — oil once a week with S.A.E. No. 20 oil.
2. Oil post (B) and rod (D) occasionally with S.A.E. No. 20 oil.
3. *Lubricate pulley bearing (C) once a month with ball bearing grease.*
4. Once a year, clean and grease (medium cup grease) cam in handwheel (C, fig. 4). To disassemble — loosen screw (A) and remove plate (B); remove handwheel by taking out center bolt.



Figure 3

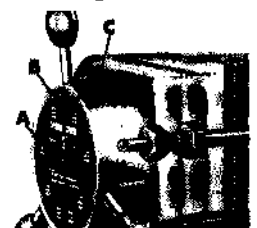


Figure 4

PARTS INDEX

for

20" CLAUSING DRILL PRESSES

VARIABLE SPEED DRIVE

MODELS 2251 THROUGH 2288

22V-1 - SERIES

FROM SERIAL NO. 503725 TO _____

FLOOR DRILLS

Column, Table and Base	4.1
Head Parts	5.3
Pulley Parts	6.3
Guard & Push Rod Assy. Parts	7.2

MULTIPLE SPINDLE DRILLS

Oil Table and Leg Parts	8.1
2216 Head Positioning Mechanism Parts	8.1
2295 Column Mounting Flange Parts	8.1

INSTRUCTIONS FOR ORDERING REPAIR PARTS

It is important to furnish the following information in addition to QUANTITY required:

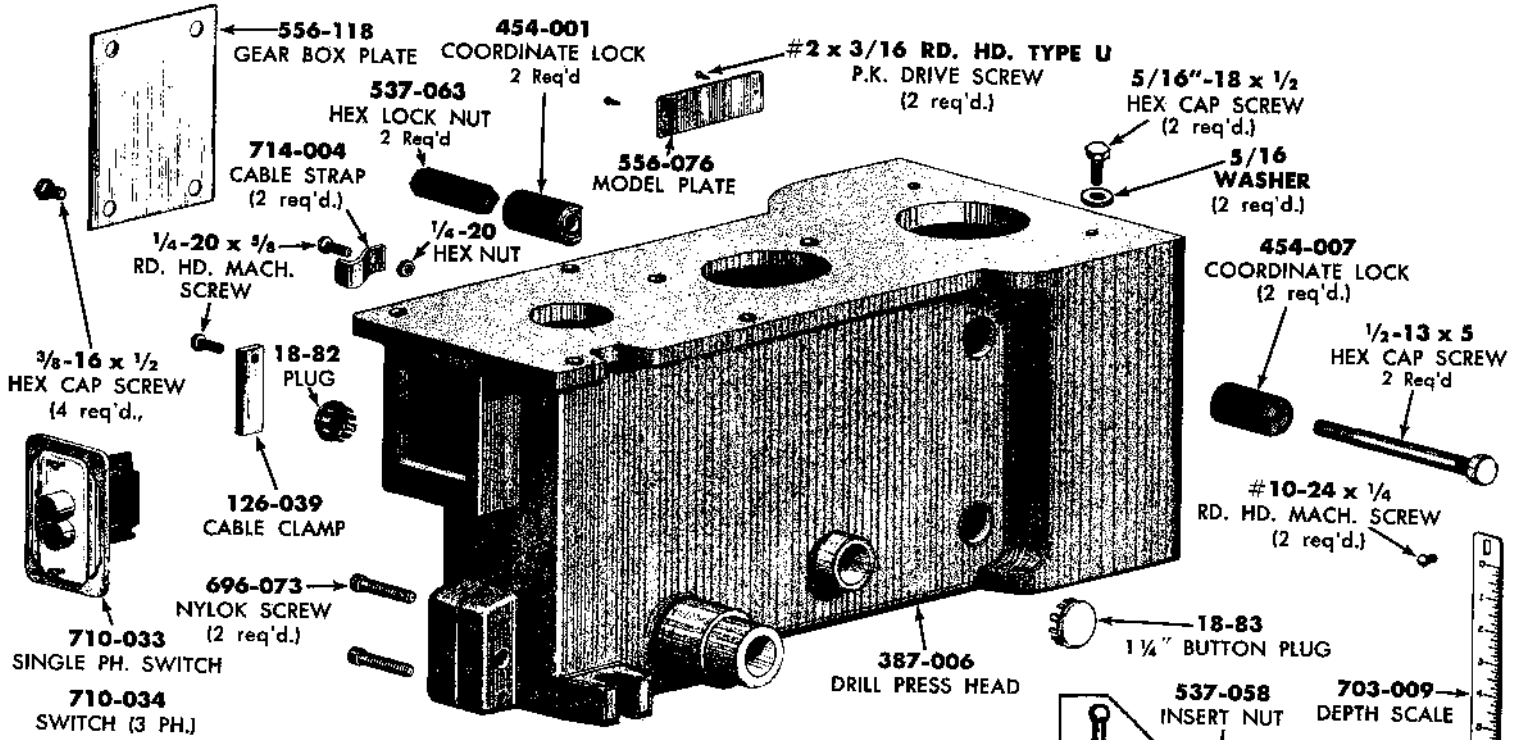
1. PART NUMBER
2. PART NAME
3. MODEL and SERIAL NUMBER of machine tool - you'll find both on the metal plate attached to machine -- note illustration below.



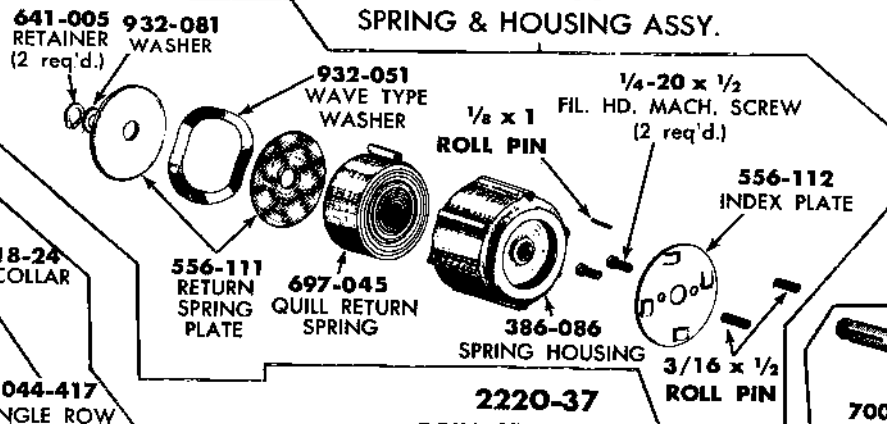
Be sure to give Model and Serial Number on this plate.

NOTE: Screws and nuts shown without part numbers should be purchased locally. We reserve the right to make changes in design and specifications without notice.

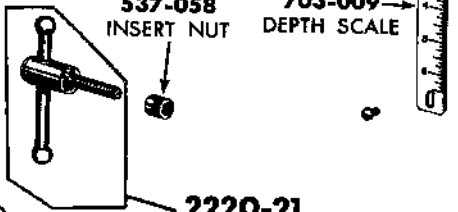
20" DRILL PRESS HEAD PARTS



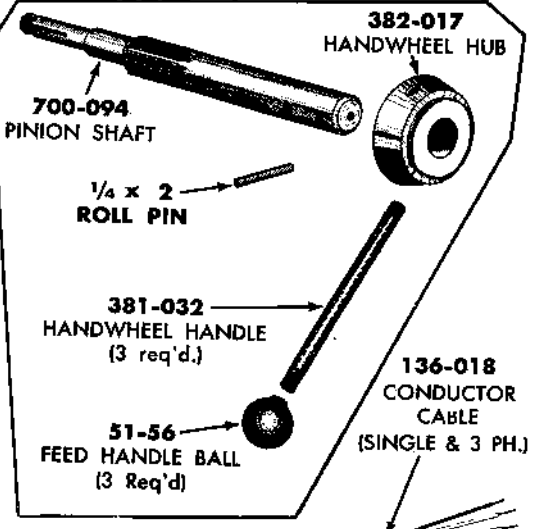
2220-36 SPRING & HOUSING ASSY.



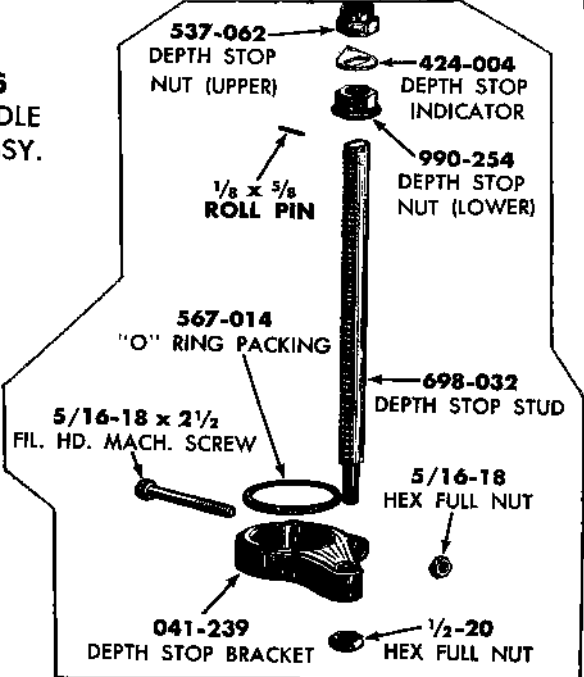
2220-21 QUILL LOCK HANDLE ASSY.



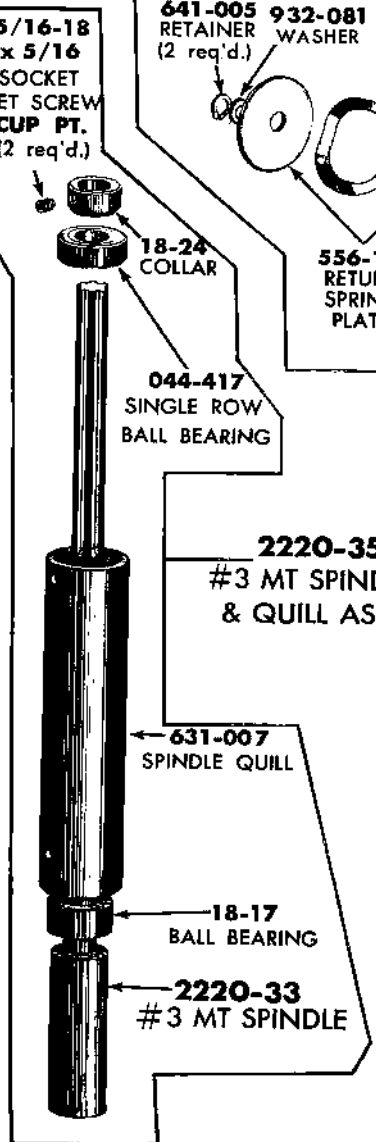
2220-18 HAND FEED ASSY.



2220-37 DRILL STOP ASSY.

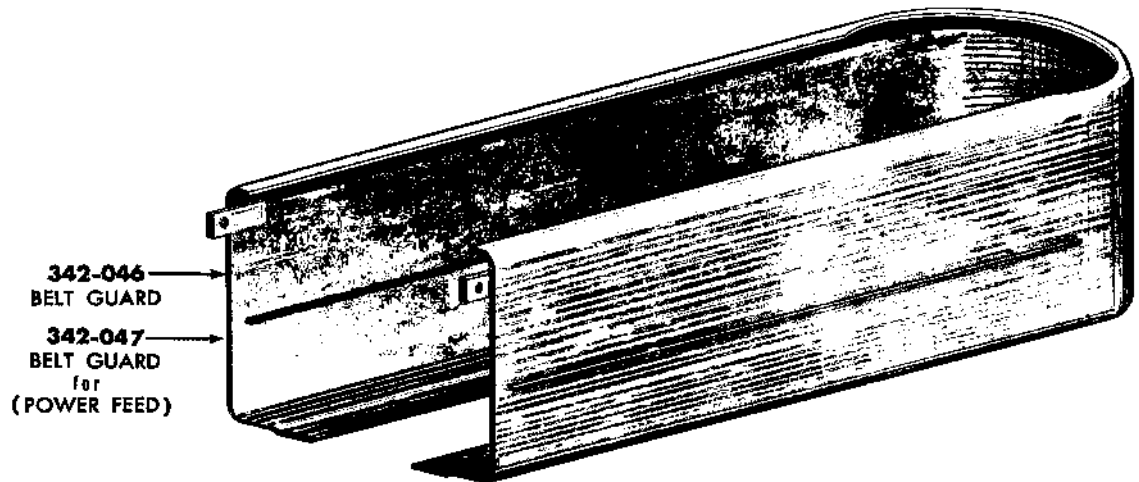


2220-35 #3 MT SPINDLE & QUILL ASSY.

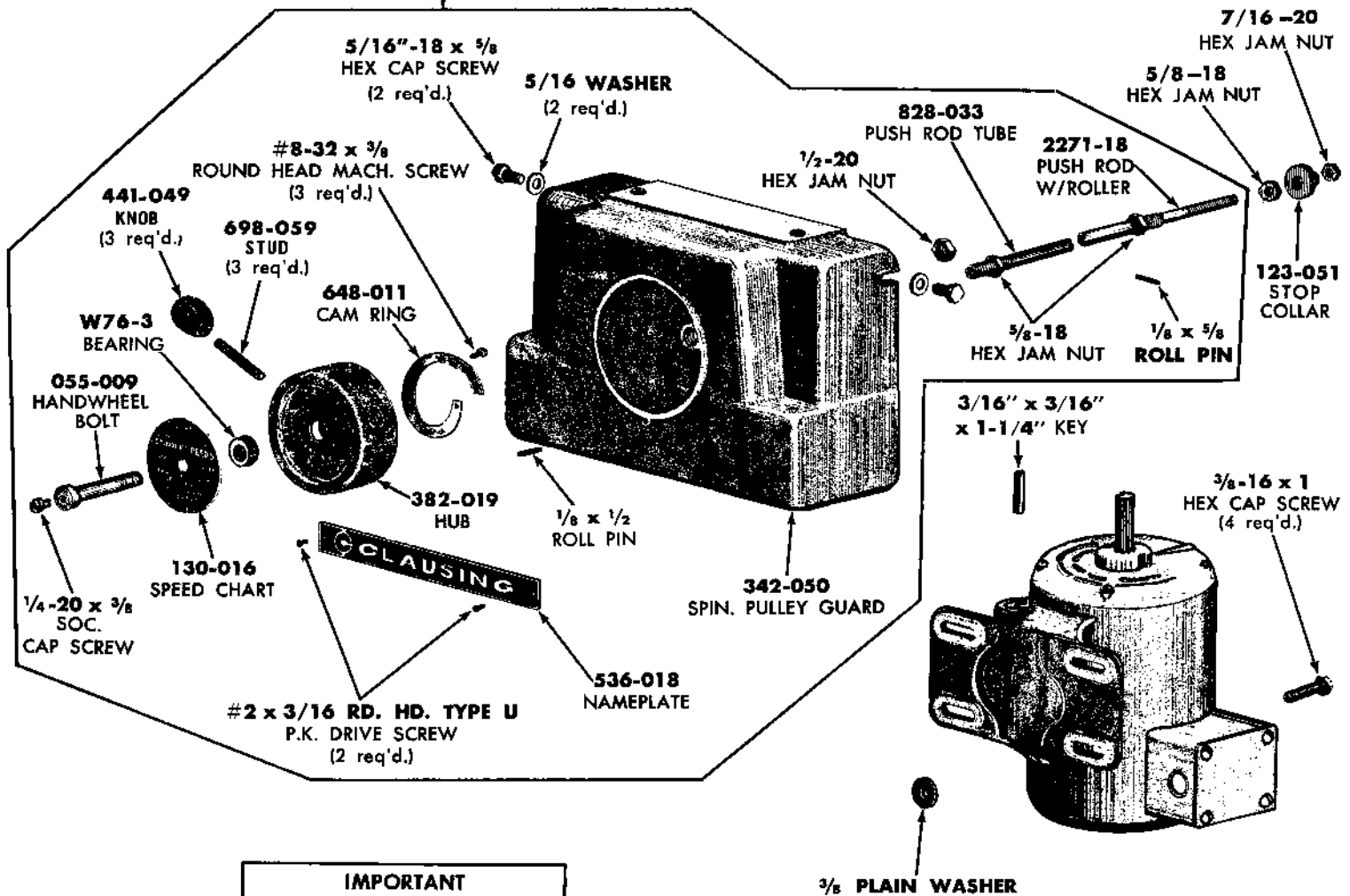


IMPORTANT
 PARTS ILLUSTRATED ON THIS PAGE ARE FOR DRILL PRESSES SERIAL NUMBERS FROM 503725 TO

20" DRILL PRESS VARIABLE DRIVE GUARD & PUSH ROD ASSY. PARTS



2271-20 HANDWHEEL PUSH ROD ASSY.



IMPORTANT

PARTS ILLUSTRATED ON THIS PAGE ARE FOR DRILL PRESSES SERIAL NUMBERS FROM 500456 TO _____