

# KEARNEY & TRECKER CORPORATION

## HORIZONTAL KNEE TYPE MACHINES

MFG., PLAIN & UNIVERSAL - MISC. COLUMN DATA

4 SHEETS - SHEET NO. 1      DATE: JULY 6, 1940

| SIZE OF MACHINE | STANDARD N.E.M.A. MOTOR H.P. | COLUMN BASE L X W | OVERALL HEIGHT OF MACHINE | O.D. OF DRIVE PULLEY | NO. OF VEE BELTS | SIZE OF A.C. TEE ROPE BELT | NO. OF SPEED LEVERS | NO. OF SPEEDS | STANDARD RANGE OF SPEEDS | SIZE OF SPINDLE TAPER | NO. OF SPINDLE BEARINGS | DRIVE GEAR SPLINES ON SPINDLE | DIA. OF BULL GEAR (LOW RANGE) | STANDARD R.P.M. RANGE OF BULL GEAR | DIA.M. OF H.S. SPINDLE GEAR | STANDARD R.P.M. RANGE OF H.S. SPINDLE GEAR | OVERALL DIAMETER ACROSS ARMS | OVERALL WIDTH ACROSS ARMS | RADIAL DISTANCE TO OVERARMS | DIA. OF ARBOR BEARING | ¢ OF SPINDLE TO FLOOR | NET WEIGHT OF MACHINE (APPROX) |
|-----------------|------------------------------|-------------------|---------------------------|----------------------|------------------|----------------------------|---------------------|---------------|--------------------------|-----------------------|-------------------------|-------------------------------|-------------------------------|------------------------------------|-----------------------------|--|------------------------------|---------------------------|-----------------------------|-----------------------|-----------------------|--------------------------------|
| 1H-12 MFG       | 3                            | 37 X 22           | 57                        | 12                   | 2                | B-60                       | 3                   | 16            | 35-1400                  | # 40                  | 2                       | 6                             | 7.222                         | 35-195                             | 3.000                       | 250-1400                                   | 2 7/8                        | 6 7/8                     | 4 9/16                      | 1 7/8                 | 44                    | 2600                           |
| 1H-18 MFG       | 3                            | 37 X 22           | 57                        | 12                   | 2                | B-60                       | 3                   | 16            | 35-1400                  | # 40                  | 2                       | 6                             | 7.222                         | 35-195                             | 3.000                       | 250-1400                                   | 2 7/8                        | 6 7/8                     | 4 9/16                      | 1 7/8                 | 44                    | 2700                           |
| 1H PL.          | 3                            | 37 X 22           | 55 5/8                    | 12                   | 2                | B-60                       | 3                   | 16            | 35-1400                  | # 40                  | 2                       | 6                             | 7.222                         | 35-195                             | 3.000                       | 250-1400                                   | 2 7/8                        | 6 7/8                     | 4 9/16                      | 1 7/8                 | 44                    | 2600                           |
| 1H UNIV.        | 3                            | 37 X 22           | 55 5/8                    | 12                   | 2                | B-60                       | 3                   | 16            | 35-1400                  | # 40                  | 2                       | 6                             | 7.222                         | 35-195                             | 3.000                       | 250-1400                                   | 2 7/8                        | 6 7/8                     | 4 9/16                      | 1 7/8                 | 44                    | 2800                           |
| 2HL PL.         | 3                            | 37 X 22           | 55 5/8                    | 12                   | 2                | B-60                       | 3                   | 16            | 35-1400                  | # 40                  | 2                       | 6                             | 7.222                         | 35-195                             | 3.000                       | 250-1400                                   | 2 7/8                        | 6 7/8                     | 4 9/16                      | 1 7/8                 | 44                    | 2700                           |
| 2HL UNIV.       | 3                            | 37 X 22           | 55 5/8                    | 12                   | 2                | B-60                       | 3                   | 16            | 35-1400                  | # 40                  | 2                       | 6                             | 7.222                         | 35-195                             | 3.000                       | 250-1400                                   | 2 7/8                        | 6 7/8                     | 4 9/16                      | 1 7/8                 | 44                    | 3000                           |
| 2H-18 MFG       | 5                            | 43 X 25           | 58 7/8                    | 13 1/2               | 3                | B-68                       | 3                   | 16            | 35-1400                  | # 50                  | 3                       | 6                             | 8.875                         | 35-195                             | 4.000                       | 250-1400                                   | 3 5/8                        | 8 5/8                     | 5 5/16                      | 2 1/8                 | 46                    | 3800                           |
| 2H-24 MFG       | 5                            | 43 X 25           | 58 7/8                    | 13 1/2               | 3                | B-68                       | 3                   | 16            | 35-1400                  | # 50                  | 3                       | 6                             | 8.875                         | 35-195                             | 4.000                       | 250-1400                                   | 3 5/8                        | 8 5/8                     | 5 5/16                      | 2 1/8                 | 46                    | 3900                           |
| 2H PL.          | 5                            | 43 X 25           | 58 7/8                    | 13 1/2               | 3                | B-68                       | 3                   | 16            | 35-1400                  | # 50                  | 3                       | 6                             | 8.875                         | 35-195                             | 4.000                       | 250-1400                                   | 3 5/8                        | 8 5/8                     | 5 5/16                      | 2 1/8                 | 46                    | 3750                           |
| 2H UNIV.        | 5                            | 43 X 25           | 58 7/8                    | 13 1/2               | 3                | B-68                       | 3                   | 16            | 35-1400                  | # 50                  | 3                       | 6                             | 8.875                         | 35-195                             | 4.000                       | 250-1400                                   | 3 5/8                        | 8 5/8                     | 5 5/16                      | 2 1/8                 | 46                    | 3950                           |
| 2KM PL.         | 7 1/2                        | 49 X 28           | 62 1/2                    | 15                   | 3                | B-68                       | 2                   | 16            | 15-750                   | # 50                  | 3                       | 10                            | 11.285                        | 15-93                              | 6.125                       | 125-750                                    | 4 1/4                        | 9 5/8                     | 6 3/8                       | 2 1/8                 | 48                    | 6100                           |
| 2KM UNIV.       | 7 1/2                        | 49 X 28           | 62 1/2                    | 15                   | 3                | B-68                       | 2                   | 16            | 15-750                   | # 50                  | 3                       | 10                            | 11.285                        | 15-93                              | 6.125                       | 125-750                                    | 4 1/4                        | 9 5/8                     | 6 3/8                       | 2 1/8                 | 48                    | 6400                           |
| 2K PL.          | 7 1/2                        | 49 X 28           | 62 1/2                    | 15                   | 3                | B-68                       | 1                   | 24            | 15-1500                  | # 50                  | 3                       | 10                            | 11.285                        | 15-136                             | 5.125                       | 165-1500                                   | 4 1/4                        | 9 5/8                     | 6 3/8                       | 2 1/8                 | 48                    | 6100                           |
| 2K UNIV.        | 7 1/2                        | 49 X 28           | 62 1/2                    | 15                   | 3                | B-68                       | 1                   | 24            | 15-1500                  | # 50                  | 3                       | 10                            | 11.285                        | 15-136                             | 5.125                       | 165-1500                                   | 4 1/4                        | 9 5/8                     | 6 3/8                       | 2 1/8                 | 48                    | 6400                           |
| 3H PL.          | 7 1/2                        | 49 X 28           | 62 1/2                    | 15                   | 3                | B-68                       | 2                   | 16            | 20-1000                  | # 50                  | 3                       | 10                            | 11.285                        | 20-124                             | 6.125                       | 165-1000                                   | 4 1/4                        | 9 5/8                     | 6 3/8                       | 2 1/8                 | 48                    | 6150                           |
| 3H UNIV.        | 7 1/2                        | 49 X 28           | 62 1/2                    | 15                   | 3                | B-68                       | 2                   | 16            | 20-1000                  | # 50                  | 3                       | 10                            | 11.285                        | 20-124                             | 6.125                       | 165-1000                                   | 4 1/4                        | 9 5/8                     | 6 3/8                       | 2 1/8                 | 48                    | 6450                           |
| 3KM PL.         | 10                           | 55 X 32           | 66 1/4                    | 15                   | 4                | B-68                       | 2                   | 16            | 15-750                   | # 50                  | 3                       | 10                            | 13                            | 15-93                              | 6.714                       | 125-750                                    | 5                            | 11 1/4                    | 7 1/4                       | 2 3/4                 | 50                    | 7800                           |
| 3KM UNIV.       | 10                           | 55 X 32           | 66 1/4                    | 15                   | 4                | B-68                       | 2                   | 16            | 15-750                   | # 50                  | 3                       | 10                            | 13                            | 15-93                              | 6.714                       | 125-750                                    | 5                            | 11 1/4                    | 7 1/4                       | 2 3/4                 | 50                    | 8250                           |
| 3K PL.          | 10                           | 55 X 32           | 66 1/4                    | 15                   | 4                | B-68                       | 1                   | 24            | 15-1500                  | # 50                  | 3                       | 10                            | 13                            | 15-106                             | 5.428                       | 165-1500                                   | 5                            | 11 1/4                    | 7 1/4                       | 2 3/4                 | 50                    | 7800                           |
| 3K UNIV.        | 10                           | 55 X 32           | 66 1/4                    | 15                   | 4                | B-68                       | 1                   | 24            | 15-1500                  | # 50                  | 3                       | 10                            | 13                            | 15-106                             | 5.428                       | 165-1500                                   | 5                            | 11 1/4                    | 7 1/4                       | 2 3/4                 | 50                    | 8250                           |
| 4H PL.          | 10                           | 55 X 32           | 66 1/4                    | 15                   | 4                | B-68                       | 2                   | 16            | 20-1000                  | # 50                  | 3                       | 10                            | 13                            | 20-124                             | 6.714                       | 165-1000                                   | 5                            | 11 1/4                    | 7 1/4                       | 2 3/4                 | 50                    | 7850                           |
| 4H UNIV.        | 10                           | 55 X 32           | 66 1/4                    | 15                   | 4                | B-68                       | 2                   | 16            | 20-1000                  | # 50                  | 3                       | 10                            | 13                            | 20-124                             | 6.714                       | 165-1000                                   | 5                            | 11 1/4                    | 7 1/4                       | 2 3/4                 | 50                    | 8250                           |
| 4K PL.          | 15                           | 68 X 37           | 71                        | 18 3/4               | 5                | B-81                       | 2                   | 24            | 13-1300                  | # 50                  | 3                       | 10                            | 15                            | 13-119                             | 5.666                       | 144-1300                                   | 5 3/4                        | 12 7/8                    | 8 9/16                      | 2 3/4                 | 55                    | 12500                          |
| 4K UNIV.        | 15                           | 68 X 37           | 71                        | 18 3/4               | 5                | B-81                       | 2                   | 24            | 13-1300                  | # 50                  | 3                       | 10                            | 15                            | 13-119                             | 5.666                       | 144-1300                                   | 5 3/4                        | 12 7/8                    | 8 9/16                      | 2 3/4                 | 55                    | 13200                          |
| 5H PL.          | 15                           | 68 X 37           | 71                        | 18 3/4               | 5                | B-81                       | 2                   | 24            | 13-1300                  | # 50                  | 3                       | 10                            | 15                            | 13-119                             | 5.666                       | 144-1300                                   | 5 3/4                        | 12 7/8                    | 8 9/16                      | 2 3/4                 | 55                    | 12750                          |
| 5H UNIV.        | 15                           | 68 X 37           | 71                        | 18 3/4               | 5                | B-81                       | 2                   | 24            | 13-1300                  | # 50                  | 3                       | 10                            | 15                            | 13-119                             | 5.666                       | 144-1300                                   | 5 3/4                        | 12 7/8                    | 8 9/16                      | 2 3/4                 | 55                    | 13450                          |

\* (1) ON TWO BEARING SPINDLES, SPACING BETWEEN BEARINGS IS 1 1/4 INCHES  
 (2) ON THREE BEARING SPINDLES, BEARINGS AT EACH END, PLUS A CENTER BEARING WHICH REDUCES BY ONE THE DISTANCE BETWEEN BEARINGS, INCREASES THE RIGIDITY BY A RATIO OF 8 TO 1

# KEARNEY & TRECKE CORPORATION

## HORIZONTAL KNEE TYPE MACHINES

MFG. PLAIN & UNIVERSAL Misc. TABLE SADDLE & KNEE DATA  
4 SHEETS - SHEET NO. 2 DATE - JULY 6, 1940

| SIZE OF MACHINE | WORKING SURFACE OF TABLE | NUMBER AND WIDTH OF T-SLOTS | CENTER DISTANCE OF T-SLOTS | LENGTH OF SADDLE BEARING FOR TABLE | SPAN OF SADDLE BEARING ON KNEE | CENTER THICKNESS OF SADDLE | HEIGHT FROM TABLE TOP TO KNEE TOP | LENGTH OF KNEE BEARING ON COLUMN | KNEE LENGTH TO OUTER END | DIA. & PITCH OF STANDARD TABLE SCREW | DIVISIONS ON SCREW DIAL | DIA. & PITCH OF STANDARD CROSS FEED SCREW | DIVISIONS ON SCREW DIAL | NO. OF FEEDS | STANDARD RANGE OF FEEDS | LONGITUDINAL POWER FEED OF TABLE | CROSS POWER FEED OF SADDLE | VERTICAL POWER FEED OF KNEE | MAX. HORIZON. TO FACE OF TABLE | MAX. BETWEEN COLUMN AND SPINDLEFACE |
|-----------------|--------------------------|-----------------------------|----------------------------|------------------------------------|--------------------------------|----------------------------|-----------------------------------|----------------------------------|--------------------------|--------------------------------------|-------------------------|---|-------------------------|--------------|-------------------------|----------------------------------|----------------------------|-----------------------------|--------------------------------|-------------------------------------|
| 1H-Z MFG.       | 10 1/4 x 33              | 3 - 1 1/16                  | 2 1/4                      | 19 1/4                             | 9                              | 4 1/8                      | 7 1/8                             | 20 1/8                           | 20 1/8                   | 2-4                                  | NONE                    | 1-5                                       | 200                     | 16           | 1'-40"                  | 12                               | 3HF                        | 15HF                        | 15                             | 18 5/16                             |
| 1H-B MFG.       | 10 1/4 x 39              | 3 - 1 1/16                  | 2 1/4                      | 19 1/4                             | 9                              | 4 1/8                      | 7 1/8                             | 20 1/8                           | 20 1/8                   | 2-4                                  | NONE                    | 1-5                                       | 200                     | 16           | 1'-40"                  | 18                               | 3HF                        | 15HF                        | 15                             | 18 5/16                             |
| 1H PL.          | 9 x 40                   | 3 - 1 1/16                  | 2 1/4                      | 22                                 | 9                              | 3 1/2                      | 6                                 | 18 1/2                           | 23 1/2                   | 1 1/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 16           | 1'-20"                  | 22                               | 8                          | 16                          | 16 1/4                         | 21 1/16                             |
| 1H UNIV.        | 9 x 40                   | 3 - 1 1/16                  | 2 1/4                      | 22                                 | 9                              | 4 1/2                      | 7                                 | 18 1/2                           | 23 1/2                   | 1 1/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 16           | 1'-20"                  | 22                               | 8                          | 16                          | 15 1/4                         | 21 1/16                             |
| 2HL PL          | 9 x 46                   | 3 - 1 1/16                  | 2 1/4                      | 22                                 | 9                              | 3 1/2                      | 6                                 | 18 1/2                           | 23 1/2                   | 1 1/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 16           | 1'-20"                  | 28                               | 10                         | 16                          | 16 1/4                         | 21 1/16                             |
| 2HL UNIV.       | 9 x 46                   | 3 - 1 1/16                  | 2 1/4                      | 22                                 | 9                              | 4 1/2                      | 7                                 | 18 1/2                           | 23 1/2                   | 1 1/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 16           | 1'-20"                  | 28                               | 10                         | 16                          | 15 1/4                         | 21 1/16                             |
| 2H-18 MFG.      | 11 3/4 x 41              | 3 - 1 1/16                  | 2 1/4                      | 21 1/4                             | 10 1/2                         | 4 1/8                      | 7 1/8                             | 19 1/8                           | 25                       | 2-4                                  | NONE                    | 1-5                                       | 200                     | 16           | 1'-40"                  | 18                               | 4HF                        | 17HF                        | 17                             | 24 5/16                             |
| 2H-24 MFG.      | 11 3/4 x 47              | 3 - 1 1/16                  | 2 1/4                      | 21 1/4                             | 10 1/2                         | 4 1/8                      | 7 1/8                             | 19 1/8                           | 25                       | 2-4                                  | NONE                    | 1-5                                       | 200                     | 16           | 1'-40"                  | 24                               | 4HF                        | 17HF                        | 17                             | 24 5/16                             |
| 2H PL.          | 10 x 50                  | 3 - 1 1/16                  | 2 1/4                      | 24                                 | 10 1/2                         | 3 3/4                      | 6 3/4                             | 19                               | 25 3/4                   | 1 3/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 16           | 1'-20"                  | 28                               | 10                         | 17                          | 17 1/4                         | 24 5/16                             |
| 2H UNIV.        | 10 x 50                  | 3 - 1 1/16                  | 2 1/4                      | 24                                 | 10 1/2                         | 5 1/8                      | 8 1/8                             | 19                               | 25 3/4                   | 1 3/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 16           | 1'-20"                  | 28                               | 10                         | 17                          | 16                             | 24 5/16                             |
| 2KM-PL          | 12 x 56                  | 3 - 1 1/16                  | 2 3/4                      | 30                                 | 12                             | 4 3/4                      | 7 1/8                             | 22 1/4                           | 28 1/2                   | 1 3/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 16           | 1'-30"                  | 28                               | 10                         | 17                          | 17 1/16                        | 26 7/16                             |
| 2KM-UNIV.       | 12 x 56                  | 3 - 1 1/16                  | 2 3/4                      | 30                                 | 12                             | 5 1/8                      | 8 1/2                             | 22 1/4                           | 28 1/2                   | 1 3/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 16           | 1'-30"                  | 28                               | 10                         | 17                          | 15 1/16                        | 26 7/16                             |
| 2K PL.          | 12 x 56                  | 3 - 1 1/16                  | 2 3/4                      | 30                                 | 12                             | 4 3/4                      | 7 1/8                             | 22 1/4                           | 28 1/2                   | 1 3/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 32           | 1'-60"                  | 28                               | 10                         | 17                          | 17 1/16                        | 26 7/16                             |
| 2K UNIV.        | 12 x 56                  | 3 - 1 1/16                  | 2 3/4                      | 30                                 | 12                             | 5 1/8                      | 8 1/2                             | 22 1/4                           | 28 1/2                   | 1 3/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 32           | 1'-60"                  | 28                               | 10                         | 17                          | 15 1/16                        | 26 7/16                             |
| 3H PL.          | 13 1/2 x 64              | 3 - 1 1/16                  | 2 3/4                      | 30                                 | 12                             | 4 3/4                      | 7 1/8                             | 22 1/4                           | 28 1/2                   | 1 3/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 16           | 1'-30"                  | 34                               | 12                         | 17                          | 17 1/16                        | 26 7/16                             |
| 3H UNIV.        | 13 1/2 x 64              | 3 - 1 1/16                  | 2 3/4                      | 30                                 | 12                             | 5 1/8                      | 8 1/2                             | 22 1/4                           | 28 1/2                   | 1 3/8-4                              | 250                     | 1 3/8-4                                   | 250                     | 16           | 1'-30"                  | 34                               | 12                         | 17                          | 15 1/16                        | 26 7/16                             |
| 3KM PL          | 15 1/2 x 64              | 3 - 1 1/16                  | 2 3/4                      | 34                                 | 14                             | 5 1/4                      | 7 5/8                             | 22 3/4                           | 32 3/4                   | 1 3/4-4                              | 250                     | 1 5/8-4                                   | 250                     | 16           | 1'-30"                  | 34                               | 12                         | 18                          | 18 1/8                         | 30 3/16                             |
| 3KM UNIV.       | 15 1/2 x 64              | 3 - 1 1/16                  | 2 3/4                      | 34                                 | 14                             | 5 5/8                      | 9 1/4                             | 22 3/4                           | 32 3/4                   | 1 3/4-4                              | 250                     | 1 5/8-4                                   | 250                     | 16           | 1'-30"                  | 34                               | 12                         | 18                          | 16 1/2                         | 30 3/16                             |
| 3K PL.          | 15 1/2 x 64              | 3 - 1 1/16                  | 2 3/4                      | 34                                 | 14                             | 5 1/4                      | 7 5/8                             | 22 3/4                           | 32 3/4                   | 1 3/4-4                              | 250                     | 1 5/8-4                                   | 250                     | 32           | 1'-60"                  | 34                               | 12                         | 18                          | 18 1/8                         | 30 3/16                             |
| 3K UNIV.        | 15 1/2 x 64              | 3 - 1 1/16                  | 2 3/4                      | 34                                 | 14                             | 5 5/8                      | 9 1/4                             | 22 3/4                           | 32 3/4                   | 1 3/4-4                              | 250                     | 1 5/8-4                                   | 250                     | 32           | 1'-60"                  | 34                               | 12                         | 18                          | 16 1/2                         | 30 3/16                             |
| 4H PL.          | 15 1/2 x 74              | 3 - 1 1/16                  | 3 1/2                      | 34                                 | 14                             | 5 1/4                      | 7 5/8                             | 22 3/4                           | 32 3/4                   | 1 3/4-4                              | 250                     | 1 5/8-4                                   | 250                     | 16           | 1'-30"                  | 42                               | 14                         | 18                          | 18 1/8                         | 30 3/16                             |
| 4H UNIV.        | 15 1/2 x 74              | 3 - 1 1/16                  | 3 1/2                      | 34                                 | 14                             | 5 5/8                      | 9 1/4                             | 22 3/4                           | 32 3/4                   | 1 3/4-4                              | 250                     | 1 5/8-4                                   | 250                     | 16           | 1'-30"                  | 42                               | 14                         | 18                          | 16 1/2                         | 30 3/16                             |
| 4K PL.          | 18 x 82                  | 3 - 1 1/16                  | 3 1/2                      | 42                                 | 16 1/2                         | 5 3/4                      | 8 1/8                             | 26 1/4                           | 38 1/4                   | 2-4                                  | 250                     | 1 3/4-4                                   | 250                     | 32           | 1'-60"                  | 42                               | 14                         | 20                          | 20                             | 36                                  |
| 4K UNIV.        | 18 x 82                  | 3 - 1 1/16                  | 3 1/2                      | 42                                 | 16 1/2                         | 7 3/4                      | 10                                | 26 1/4                           | 38 1/4                   | 2-4                                  | 250                     | 1 3/4-4                                   | 250                     | 32           | 1'-60"                  | 42                               | 14                         | 20                          | 18 1/8                         | 36                                  |
| 5H PL.          | 18 x 94                  | 3 - 1 1/16                  | 3 1/2                      | 42                                 | 16 1/2                         | 5 3/4                      | 8 1/8                             | 26 1/4                           | 38 1/4                   | 2-4                                  | 250                     | 1 3/4-4                                   | 250                     | 32           | 1'-60"                  | 52                               | 16                         | 20                          | 20                             | 36                                  |
| 5H UNIV.        | 18 x 94                  | 3 - 1 1/16                  | 3 1/2                      | 42                                 | 16 1/2                         | 7 3/4                      | 10                                | 26 1/4                           | 38 1/4                   | 2-4                                  | 250                     | 1 3/4-4                                   | 250                     | 32           | 1'-60"                  | 52                               | 16                         | 20                          | 18 1/8                         | 36                                  |



\* POWER FEED EXCEPT WHERE H.F. INDICATES HAND FEED

# KEARNEY & TRECKI CORPORATION

## VERTICAL KNEE TYPE MACHINES

MFG., PLAIN & SWIVEL HEAD - Misc. COLUMN DATA  
DATE-JULY 6, 1940

4 SHEETS SHEET #3

| SIZE OF MACHINE             | STANDARD N.E.M.A. MOTOR H.P. | COLUMN BASE L X V.  | OVERALL HEIGHT OF MACHINE | O.D. OF DRIVE PULLEY | NO. OF VEE BELTS | SIZE OF A.C. TROUPE BELT LEVERS  | NO. OF SPEED LEVERS | NO. OF SPEEDS | STANDARD RANGE OF SPEEDS | SIZE OF SPINDLE TAPER | NO. OF SPINDLE BEARINGS | DRIVE GEAR SPLINES ON SPINDLE | DIAM. OF BULL GEAR (LOW RANGE) | STANDARD R.P.M. RANGE OF BULL GEAR | DIAM. OF H.S. SPINDLE GEAR | STANDARD R.P.M. RANGE OF H.S. SPINDLE GEAR | NET WEIGHT OF MACHINE (APPROX.) |
|-----------------------------|------------------------------|--|---------------------------|----------------------|------------------|---|---------------------|---------------|--------------------------|-----------------------|-------------------------|-------------------------------|--------------------------------|------------------------------------|----------------------------|--|---------------------------------|
| 1H-12 VERT. SWIVEL HD. MFG. | 3                            | 37x22  | 69 3/4                    | 12                   | 2                | B-60  | 3                   | 16            | 35-1400                  | 40                    | 3                       | 6                             | 7.222                          | 35-195                             | 3                          | 250-1400                                   | 2650                            |
| 1H-16 VERT. SWIVEL HD. MFG. | 3                            | 37x22  | 69 3/4                    | 12                   | 2                | B-60  | 3                   | 16            | 35-1400                  | 40                    | 3                       | 6                             | 7.222                          | 35-195                             | 3                          | 250-1400                                   | 2750                            |
| 1H-SWIVEL HD. VERT.         | 3                            | 37x22  | 69 3/4                    | 12                   | 2                | B-60  | 3                   | 16            | 35-1400                  | 40                    | 3                       | 6                             | 7.222                          | 35-195                             | 3                          | 250-1400                                   | 2800                            |
| 2H-SWIVEL HD. VERT.         | 3                            | 37x22  | 69 3/4                    | 12                   | 2                | B-60  | 3                   | 16            | 35-1400                  | 40                    | 3                       | 6                             | 7.222                          | 35-195                             | 3                          | 250-1400                                   | 3000                            |
| 2H-18 VERT. MFG.            | 5                            | 43x25  | 70                        | 13 1/2               | 3                | B-68  | 3                   | 16            | 35-1400                  | 50                    | 3                       | 6                             | 8.875                          | 35-195                             | 4                          | 250-1400                                   | 3650                            |
| 2H-24 VERT. MFG.            | 5                            | 43x25  | 70                        | 13 1/2               | 3                | B-68  | 3                   | 16            | 35-1400                  | 50                    | 3                       | 6                             | 8.875                          | 35-195                             | 4                          | 250-1400                                   | 3750                            |
| 2H-PL. VERT.                | 5                            | 43x25  | 70                        | 13 1/2               | 3                | B-68  | 3                   | 16            | 35-1400                  | 50                    | 3                       | 6                             | 8.875                          | 35-195                             | 4                          | 250-1400                                   | 4250                            |
| 2KM PL. VERT.               | 7 1/2                        | 49x28  | 75 7/8                    | 15                   | 3                | B-68  | 2                   | 16            | 15-750                   | 50                    | 3                       | 10                            | 11.286                         | 15-93                              | 5.750                      | 125-750                                    | 6700                            |
| 2K PL. VERT.                | 7 1/2                        | 49x28  | 75 7/8                    | 15                   | 3                | B-68  | 1                   | 24            | 15-1500                  | 50                    | 3                       | 10                            | 11.286                         | 15-136                             | 4.750                      | 165-1500                                   | 6700                            |
| 3H PL. VERT.                | 7 1/2                        | 49x28  | 74                        | 15                   | 3                | B-68  | 2                   | 16            | 20-1000                  | 50                    | 3                       | 10                            | 11.286                         | 20-124                             | 5.750                      | 165-1000                                   | 6750                            |
| 3KM PL. VERT.               | 10                           | 55x32  | 81 3/4                    | 15                   | 4                | B-68  | 2                   | 16            | 15-750                   | 50                    | 3                       | 10                            | 13                             | 15-93                              | 6.714                      | 125-750                                    | 8800                            |
| 3K PL. VERT.                | 10                           | 55x32  | 81 3/4                    | 15                   | 4                | B-68  | 1                   | 24            | 15-1500                  | 50                    | 3                       | 10                            | 13                             | 15-136                             | 5.429                      | 165-1500                                   | 8800                            |
| 4H PL. VERT.                | 10                           | 55x32  | 81 3/4                    | 15                   | 4                | B-68  | 2                   | 16            | 20-1000                  | 50                    | 3                       | 10                            | 13                             | 20-124                             | 6.714                      | 165-1000                                   | 8750                            |
| 4K PL. VERT.                | 15                           | 68x37  | 89                        | 18 3/4               | 5                | B-81  | 2                   | 24            | 13-1300                  | 50                    | 3                       | 10                            | 15                             | 13-119                             | 4.857                      | 144-1300                                   | 14000                           |
| 5H PL. VERT.                | 15                           | 68x37  | 89                        | 18 3/4               | 5                | B-81  | 2                   | 24            | 13-1300                  | 50                    | 3                       | 10                            | 15                             | 13-119                             | 4.857                      | 144-1300                                   | 14250                           |

# KEARNEY & TRECKER CORPORATION

## VERTICAL KNEE TYPE MACHINES

MFG. PLAIN & SWIVEL HEAD - MISC. TABLE, SADDLE & KNEE DATA  
4 SHEETS SHEET #4  
DATE: JULY 6, 1940

| SIZE OF MACHINE             | WORKING SURFACE OF TABLE                          | NUMBER & WIDTH OF T SLOTS | CENTER DISTANCE OF T SLOTS | LENGTH OF SADDLE BEARING FOR TABLE | SPAN OF SADDLE BEARING ON KNEE | CENTER THICKNESS OF SADDLE | HEIGHT FROM TABLE TO KNEE TOP | LENGTH OF KNEE BEARING ON COLUMN | DIAM. & PITCH OF TABLE SCREW | DIVISIONS ON TABLE SCREW DIAL | DIAM. & PITCH OF STANDARD SCREW | DIVISIONS ON CROSS ELEVATING SCREW DIAL | NO. OF FEEDS | STANDARD RANGE OF FEEDS | LONGITUDINAL FEED OF TABLE | CROSS POWER FEED OF SADDLE | VERTICAL POWER FEED OF KNEE | MOVEMENT OF VERTICAL SPINDLE                        | SPINDLE NOSE TO TABLE TOP MIN. MAX. | COLUMN TO THROAT TO CENTER OF SPINDLE |
|-----------------------------|---|---------------------------|----------------------------|------------------------------------|--------------------------------|----------------------------|-------------------------------|----------------------------------|------------------------------|-------------------------------|---------------------------------|---|--------------|-------------------------|----------------------------|----------------------------|-----------------------------|---|-------------------------------------|---------------------------------------|
| 1H-12 VERT. SWIVEL HD. MFG. | 10 1/2 X 33                                       | 3 - 1 1/16                | 2 1/4                      | 19 1/4                             | 9                              | 4 1/8                      | 7 1/8                         | 20 1/8                           | 2" - 4                       | NONE                          | 1" - 5                          | 200                                     | 16           | 1 - 40                  | 12                         | 3 H.F.                     | 15 H.F.                     | 0 - NON ADJ. 3/16 SWIVEL 3 UNIV.                    | 2 NON ADJ. 0 SWIVEL 17              | 14                                    |
| 1H-14 VERT. SWIVEL HD. MFG. | 10 1/2 X 33                                       | 3 - 1 1/16                | 2 1/4                      | 19 1/4                             | 9                              | 4 1/8                      | 7 1/8                         | 20 1/8                           | 2" - 4                       | NONE                          | 1" - 5                          | 200                                     | 16           | 1 - 40                  | 18                         | 3 H.F.                     | 15 H.F.                     | 0 - NON ADJ. 3/16 SWIVEL 3 UNIV.                    | 2 NON ADJ. 0 SWIVEL 17              | 14                                    |
| 1H-14 VERT. SWIVEL HD. MFG. | 9 X 40  | 3 - 1 1/16                | 2 1/4                      | 22                                 | 9                              | 3 1/2                      | 6                             | 18 1/2                           | 1 1/8 - 4                    | 250                           | 1" - 4                          | 250                                     | 16           | 1/2 - 20                | 22                         | 10                         | 16                          | 0 - NON ADJ. 2 NON ADJ. 3/16 SWIVEL 0 SWIVEL 18 1/2 | 2 NON ADJ. 0 SWIVEL 18 1/2          | 14                                    |
| 2H-14 VERT. SWIVEL HD. MFG. | 9 X 46  | 3 - 1 1/16                | 2 1/4                      | 22                                 | 9                              | 3 1/2                      | 6                             | 18 1/2                           | 1 1/8 - 4                    | 250                           | 1" - 4                          | 250                                     | 16           | 1/2 - 20                | 28                         | 10                         | 16                          | 0 - NON ADJ. 2 NON ADJ. 3/16 SWIVEL 0 SWIVEL 18 1/2 | 2 NON ADJ. 0 SWIVEL 18 1/2          | 14                                    |
| 2H-18 VERT. MFG.            | 11 3/4 X 41                                       | 3 - 1 1/16                | 2 1/4                      | 21 1/4                             | 10 1/2                         | 4 1/8                      | 7 1/8                         | 19 7/8                           | 2" - 4                       | NONE                          | 1" - 5                          | 200                                     | 16           | 1 - 40                  | 18                         | 4 H.F.                     | 17 H.F.                     | 4 H.F.  | 0 - 17                              | 14                                    |
| 2H-24 VERT. MFG.            | 11 3/4 X 47                                       | 3 - 1 1/16                | 2 1/4                      | 21 1/4                             | 10 1/2                         | 4 1/8                      | 7 1/8                         | 19 7/8                           | 2" - 4                       | NONE                          | 1" - 5                          | 200                                     | 16           | 1 - 40                  | 24                         | 4 H.F.                     | 17 H.F.                     | 4 H.F.  | 0 - 17                              | 14                                    |
| 2H PL. VERT.                | 10 X 50   | 3 - 1 1/16                | 2 1/4                      | 24                                 | 10 1/2                         | 3 3/4                      | 6 3/4                         | 19                               | 1 3/8 - 4                    | 250                           | 1" - 4                          | 250                                     | 16           | 1/2 - 20                | 28                         | 12                         | 15                          | 4   | 0 - 17 1/4                          | 14                                    |
| 2KM PL. VERT.               | 12 X 56   | 3 - 1 1/16                | 2 3/4                      | 30                                 | 12                             | 4 7/16                     | 7 1/8                         | 22 1/4                           | 1 3/8 - 4                    | 250                           | 1 1/8 - 4                       | 250                                     | 16           | 1/2 - 30                | 28                         | 12                         | 14                          | 6   | 0 - 19 3/8                          | 14                                    |
| 2K PL. VERT.                | 12 X 56   | 3 - 1 1/16                | 2 3/4                      | 30                                 | 12                             | 4 7/16                     | 7 1/8                         | 22 1/4                           | 1 3/8 - 4                    | 250                           | 1 1/8 - 4                       | 250                                     | 32           | 1/4 - 60                | 28                         | 12                         | 14                          | 6   | 0 - 19 1/16                         | 14                                    |
| 3H PL. VERT.                | 13 1/2 X 64                                       | 3 - 1 1/16                | 2 3/4                      | 30                                 | 12                             | 4 7/16                     | 7 1/8                         | 22 1/4                           | 1 3/8 - 4                    | 250                           | 1 1/8 - 4                       | 250                                     | 16           | 1/2 - 30                | 34                         | 12                         | 14                          | 6   | 0 - 19 1/16                         | 14                                    |
| 3KM PL. VERT.               | 15 1/2 X 64                                       | 3 - 1 1/16                | 2 3/4                      | 34                                 | 14                             | 5 7/16                     | 7 5/8                         | 22 3/4                           | 1 3/4 - 4                    | 250                           | 1 3/8 - 4                       | 250                                     | 16           | 1/2 - 30                | 34                         | 14                         | 16                          | 7   | 0 - 20 3/4                          | 18                                    |
| 3K PL. VERT.                | 15 1/2 X 64                                       | 3 - 1 1/16                | 2 3/4                      | 34                                 | 14                             | 5 7/16                     | 7 5/8                         | 22 3/4                           | 1 3/4 - 4                    | 250                           | 1 3/8 - 4                       | 250                                     | 32           | 1/4 - 60                | 34                         | 14                         | 16                          | 7   | 0 - 21                              | 18                                    |
| 4H PL. VERT.                | 15 1/2 X 74                                       | 3 - 1 1/16                | 3 1/2                      | 34                                 | 14                             | 5 7/16                     | 7 5/8                         | 22 3/4                           | 1 3/4 - 4                    | 250                           | 1 3/8 - 4                       | 250                                     | 16           | 1/2 - 30                | 42                         | 14                         | 16                          | 7   | 0 - 21                              | 18                                    |
| 4K PL. VERT.                | 18 X 82   | 3 - 1 1/16                | 3 1/2                      | 42                                 | 16 1/2                         | 5 3/16                     | 8 1/8                         | 26 1/4                           | 2" - 4                       | 250                           | 1 3/4 - 4                       | 250                                     | 50           | 1/4 - 60                | 42                         | 16                         | 20                          | 8   | 0 - 22                              | 21                                    |
| 5H PL. VERT.                | 18 X 94   | 3 - 1 1/16                | 3 1/2                      | 42                                 | 16 1/2                         | 5 3/16                     | 8 1/8                         | 26 1/4                           | 2" - 4                       | 250                           | 1 3/4 - 4                       | 250                                     | 50           | 1/4 - 60                | 52                         | 16                         | 20                          | 8   | 0 - 22                              | 21                                    |
| *                           | POWER FEED EXCEPT WHERE H.F. INDICATES HAND FEED. |                           |                            |                                    |                                |                            |                               |                                  |                              |                               |                                 |   |              |                         |                            |                            |                             |   |                                     |                                       |

KEARNEY & TRECKER  
CORPORATION

FEED RANGE DATA BED TYPE MACHINE

| MACHINE SIZE  | TYPE OF TABLE NUT | TYPE OF CHANGE                 | NUMBER OF FEEDS | STANDARD FEED RANGE      | OPTIONAL RANGES          | RAPID TRAVERSE  |                |    |  |   |
|---|-------------------|--------------------------------|-----------------|--------------------------|--------------------------|-----------------|----------------|----|--|---|
| M 18 - M 24 - M 30 SIMPLEX  | ADJUSTABLE        | PICK-OFF                       | 16              | 1" - 20"                 | 1/4" - 10"<br>3/4" - 30" | 150"            |                |    |  |   |
| 1200 & 1800 MILWAUKEE SIMPLEX<br>1200 & 1800 MILWAUKEE DUPLEX           | ADJUSTABLE        | PICK-OFF<br>PICK-OFF           | 18<br>18        | 1/2" - 20"<br>1/2" - 20" | 1/4" - 10"<br>1/4" - 50" | 120"            |                |    |  |   |
| 1400 & 2200 MIL-WAUKEE-MIL SIMPLEX<br>1400 & 2200 MIL-WAUKEE-MIL DUPLEX | NON-ADJUSTABLE    | PICK-OFF<br>OR<br>QUICK CHANGE | 18              | 1 - 40<br>1 - 40         | 1/2 - 20"                | 240"            |                |    |  |   |
| FEED INCREMENTS   |                   |                                |                 |                          |                          |                 |                |    |  |   |
| M SERIES  | NO. OF FEEDS      | FEED RANGE                     | TYPE OF CHANGE  | NUMBER OF FEEDS          | STANDARD FEED RANGE      | OPTIONAL RANGES | RAPID TRAVERSE |    |  |   |
|   |                   |                                |                 |                          |                          |                 |                | 16 | .33 .52 .87 1.42 2.3 3.6 6.1 10.0        | HYDRAULICALLY ACTUATED FEED & R.T. CLUTCHES |
|   |                   |                                |                 |                          |                          |                 |                | 16 | .25 .41 .69 1.09 1.7 2.8 4.8 7.6         |   |
| MILWAUKEE 1200<br>1800 SERIES   | NO. OF FEEDS      | FEED RANGE                     | TYPE OF CHANGE  | NUMBER OF FEEDS          | STANDARD FEED RANGE      | OPTIONAL RANGES | RAPID TRAVERSE |    |  |   |
|   |                   |                                |                 |                          |                          |                 |                | 16 | .50 .82 1.38 2.20 3.5 5.7 9.6 15.3       | HYDRAULICALLY ACTUATED FEED & R.T. CLUTCHES |
|   |                   |                                |                 |                          |                          |                 |                | 16 | .75 1.23 2.07 3.3 5.2 8.6 14.4 23.       |   |
| MILWAUKEE 1200<br>1800 SERIES   | NO. OF FEEDS      | FEED RANGE                     | TYPE OF CHANGE  | NUMBER OF FEEDS          | STANDARD FEED RANGE      | OPTIONAL RANGES | RAPID TRAVERSE |    |  |   |
|   |                   |                                |                 |                          |                          |                 |                | 18 | .31 .47 .73 1.1 1.7 2.65 4.2 6.5 10      | HYDRAULICALLY ACTUATED FEED & R.T. CLUTCHES |
|   |                   |                                |                 |                          |                          |                 |                | 18 | .25 .38 .59 .90 1.4 2.1 3.4 5.2 8        |   |
| MILWAUKEE 1200<br>1800 SERIES   | NO. OF FEEDS      | FEED RANGE                     | TYPE OF CHANGE  | NUMBER OF FEEDS          | STANDARD FEED RANGE      | OPTIONAL RANGES | RAPID TRAVERSE |    |  |   |
|   |                   |                                |                 |                          |                          |                 |                | 18 | .62 .95 1.47 2.2 3.4 5.3 8.5 13 20       | HYDRAULICALLY ACTUATED FEED & R.T. CLUTCHES |
|   |                   |                                |                 |                          |                          |                 |                | 18 | .50 .77 1.18 1.8 2.8 4.2 6.8 10.5 16     |   |
| MILWAUKEE 1200<br>1800 SERIES   | NO. OF FEEDS      | FEED RANGE                     | TYPE OF CHANGE  | NUMBER OF FEEDS          | STANDARD FEED RANGE      | OPTIONAL RANGES | RAPID TRAVERSE |    |  |   |
|   |                   |                                |                 |                          |                          |                 |                | 18 | 1.56 2.38 3.67 5.5 8.5 13.1 21.2 32.5 50 | HYDRAULICALLY ACTUATED FEED & R.T. CLUTCHES |
|   |                   |                                |                 |                          |                          |                 |                | 18 | 1.25 1.92 2.95 4.5 6.9 10.5 16.2 26.2 40 |   |
| MILWAUKEE 1200<br>1800 SERIES   | NO. OF FEEDS      | FEED RANGE                     | TYPE OF CHANGE  | NUMBER OF FEEDS          | STANDARD FEED RANGE      | OPTIONAL RANGES | RAPID TRAVERSE |    |  |   |
|   |                   |                                |                 |                          |                          |                 |                | 18 | .62 .95 1.47 2.2 3.4 5.3 8.5 13 20       | MANUALLY ACTUATED FEED & R.T. CLUTCHES      |
|   |                   |                                |                 |                          |                          |                 |                | 18 | .5 .77 1.18 1.8 2.8 4.2 6.8 10.5 16      |   |
| MILWAUKEE 1200<br>1800 SERIES   | NO. OF FEEDS      | FEED RANGE                     | TYPE OF CHANGE  | NUMBER OF FEEDS          | STANDARD FEED RANGE      | OPTIONAL RANGES | RAPID TRAVERSE |    |  |   |
|   |                   |                                |                 |                          |                          |                 |                | 18 | 1.25 1.92 2.95 4.5 6.9 10.5 16.2 26.2 40 | MANUALLY ACTUATED FEED & R.T. CLUTCHES      |
|   |                   |                                |                 |                          |                          |                 |                | 18 | .5 .77 1.18 1.8 2.8 4.2 6.8 10.5 16      |   |
| MILWAUKEE 1200<br>1800 SERIES   | NO. OF FEEDS      | FEED RANGE                     | TYPE OF CHANGE  | NUMBER OF FEEDS          | STANDARD FEED RANGE      | OPTIONAL RANGES | RAPID TRAVERSE |    |  |   |
|   |                   |                                |                 |                          |                          |                 |                | 18 | 1.25 1.92 2.95 4.5 6.9 10.5 16.2 26.2 40 | MANUALLY ACTUATED FEED & R.T. CLUTCHES      |
|   |                   |                                |                 |                          |                          |                 |                | 18 | .5 .77 1.18 1.8 2.8 4.2 6.8 10.5 16      |   |

MILWAUKEE-MILL

FORM No. 484

KEARNEY & TRECKER CORP  
SPEED RANGE DATA - BED TYPE MACHINES

| SPEED RANGE                       | No. OF SPEEDS | STANDARD SPEED RANGE | OPTIONAL SPEED RANGES<br>(AT ADDITIONAL COST) |                   |
|-----------------------------------|---------------|----------------------|---|-------------------|
|                                   |               |                      | 150 - 1000                                    | 20-135 (SEE NOTE) |
| 1200 & 1800 MILWAUKEE SIMPLEX     | 10            | 30-200 R.P.M.        | 75 - 500                                      | 150 - 1000        |
| 1200 & 1800 MILWAUKEE DUPLEX      | 10            | 30-200 R.P.M.        | 75 - 500                                      | 150 - 1000        |
| 1400 & 2200 MILWAUKEE-MIL SIMPLEX | 12            | 15-150 R.P.M.        | 20-200  | 30 - 300          |
| 1400 & 2200 MILWAUKEE-MIL DUPLEX  | 12            | 15-150 R.P.M.        | 20-200  | 30 - 300          |
| M18, M24, & M30 MILWAUKEE SIMPLEX | 16            | 20-500 R.P.M.        | 40-1000                                       | 50 - 500          |

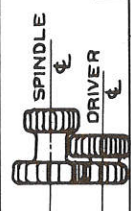
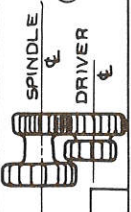
  

| SPEED RANGE     | No. OF SPEEDS | SPEED PLATE READINGS |     |     |     |     |     |     |     |     |      |     |     |     |     |     |      |
|-----------------|---------------|----------------------|-----|-----|-----|-----|-----|-----|-----|-----|------|-----|-----|-----|-----|-----|------|
|                 |               | 20                   | 25  | 31  | 38  | 47  | 58  | 72  | 88  | 112 | 135  | 162 | 200 | 264 | 323 | 410 | 500  |
| 20-135 R.P.M.   | 10            | 20                   | 25  | 31  | 38  | 47  | 58  | 72  | 88  | 112 | 135  |     |     |     |     |     |      |
| 30-200 R.P.M.   | 10            | 30                   | 37  | 46  | 57  | 70  | 87  | 106 | 131 | 162 | 200  |     |     |     |     |     |      |
| 75-500 R.P.M.   | 10            | 75                   | 90  | 115 | 140 | 173 | 224 | 264 | 323 | 410 | 500  |     |     |     |     |     |      |
| 150-1000 R.P.M. | 10            | 150                  | 183 | 231 | 282 | 349 | 431 | 533 | 652 | 827 | 1000 |     |     |     |     |     |      |
| 15-150 R.P.M.   | 12            | 15                   | 19  | 23  | 29  | 35  | 42  | 55  | 66  | 79  | 99   | 122 | 150 |     |     |     |      |
| 20-200 R.P.M.   | 12            | 20                   | 24  | 30  | 37  | 45  | 54  | 70  | 86  | 103 | 130  | 160 | 200 |     |     |     |      |
| 30-300 R.P.M.   | 12            | 30                   | 38  | 46  | 58  | 70  | 84  | 108 | 133 | 160 | 202  | 249 | 300 |     |     |     |      |
| 50-500 R.P.M.   | 12            | 50                   | 62  | 76  | 95  | 115 | 137 | 178 | 219 | 262 | 332  | 409 | 500 |     |     |     |      |
| 20-500 R.P.M.   | 16            | 20                   | 25  | 31  | 38  | 47  | 58  | 72  | 90  | 112 | 138  | 172 | 214 | 260 | 325 | 404 | 500  |
| 40-1000 R.P.M.  | 16            | 40                   | 58  | 62  | 76  | 94  | 116 | 144 | 180 | 224 | 276  | 344 | 428 | 520 | 650 | 808 | 1000 |

\* NOTE - THIS RANGE REQUIRES SPECIAL BEVEL GEARS

**KEARNEY & TRECKER**  
**SPEED RANGE DATA - KNEE TYPE MACHINES**

FORM No. 483

| MACHINE SIZE     |  | No. OF SPEED CHANGE LEVERS   | No. OF SPEEDS                                      | STANDARD SPEED RANGE   | OPTIONAL RANGE (AT ADDITIONAL COST) |
|------------------|--|--|--|--|-------------------------------------|
| No. 1H MFGS.-    | HORIZONTAL & SWIVEL HEAD VERTICAL        | 3  | 16   | 35-1400 R.P.M.   | 60-2400 R.P.M.                      |
| No. 1H -         | PLAIN, UNIVERSAL & SWIVEL HEAD VERTICAL  | 3  | QUICK CHANGE                                       |  |                                     |
| No. 2HL-         | PLAIN, UNIVERSAL & SWIVEL HEAD VERTICAL  | 3  |  |  |                                     |
| No. 2H -         | PLAIN, UNIVERSAL & SLIDING HEAD VERTICAL | 3  | 16 Q.C.  | 35-1400 R.P.M.   | 50-2000 R.P.M.                      |
| No.s. 3H & 4H    | PLAIN, UNIVERSAL & SLIDING HEAD VERTICAL | 2  | 16 Q.C.  | 20-1000 R.P.M.   | 30-1500 R.P.M.                      |
| No.s. 2KM & 3KM- | PLAIN, UNIVERSAL & SLIDING HEAD VERTICAL | 2  | 16 Q.C.  | 15-750 R.P.M.  |                                     |
| No.s. 2K & 3K    | PLAIN, UNIVERSAL & SLIDING HEAD VERTICAL | 1  | 24 Q.C.  | 15-1500 R.P.M.   |                                     |
| No.s. 4K & 5H    | PLAIN, UNIVERSAL & SLIDING HEAD VERTICAL | 2  | 24 Q.C.  | 13-1300 R.P.M.   |                                     |
| No. 2D -         | ROTARY HEAD TOOL & DIE MILLING MACHINE   |  | (INFINITE)   | 250-6000 R.P.M.  |                                     |
| SPEED RANGE      | No. OF SPEEDS                            | <br>SPINDLE DRIVER<br>(BULL GEAR ENGAGED) |  | <br>SPINDLE DRIVER<br>(HI - SPEED GEAR ENGAGED) |                                     |
| 35-1400          | 16                                       | 35 45 58 73 93 119 153 195   | 250 322 412 529 666 851 1088 1400                  |  |                                     |
| 60-2400          | 16                                       | 60 77 98 125 160 205 262 336   | 428 550 705 900 1145 1470 1875 2400                |  |                                     |
| 50-2000          | 16                                       | 50 64 82 105 133 171 218 280   | 357 457 587 750 950 1220 1560 2000                 |  |                                     |
| 20-1000          | 16                                       | 20 26 34 44 57 75 96 124   | 165 214 276 355 466 604 778 1000                   |  |                                     |
| 30-1500          | 16                                       | 30 39 51 66 86 110 144 186   | 245 318 410 530 692 900 1165 1500                  |  |                                     |
| 15-750           | 16                                       | 15 20 26 33 43 56 72 93  | 125 162 208 268 352 456 586 750                    |  |                                     |
| 15-1500          | 24                                       | 15 18 22 27 33 40 50 61 74 90 110 136  | 165 202 247 302 365 445 545 670 815 1000 1220 1500 |  |                                     |
| 13-1300          | 24                                       | 13 16 20 24 30 37 45 54 65 79 97 119   | 144 177 216 264 326 400 489 597 717 879 1074 1300  |  |                                     |

KEARNEY & TRECKER  
FEED RANGE DATA - KNEE TYPE MACHINES

| MACHINE SIZE  | TYPE OF CHANGE | NUMBER OF FEEDS  | STANDARD FEED RANGE   | OPTIONAL RANGES  | RAPID TRAVERSE   |  |
|---|----------------|--|---|--|--|--|
| No 1H MFGS. - HORIZ. & SWIVEL HEAD VERT.  | PICK-OFF       | 16   | 1" - 40" LONG   | 1" - 10"<br>4" - 30"<br>4" - 20"   | 150" ALL MACHINES<br>EXCEPT 2H UNIV. WHICH IS 100"   |  |
| No 1H PLAIN UNIV. & SWIVEL HEAD VERT.   | QUICK CHANGE   | 16   | 1" - 20"  | 1" - 20"   | 300" ON MFGS.  |  |
| No 2HL PLAIN UNIV. & SWIVEL HEAD VERT.  | QUICK CHANGE   | 16   | 1" - 20"  | 1" - 40"   |  |  |
| No 2H PLAIN UNIV. & SLIDING HEAD VERT.  | QUICK CHANGE   | 16   | 1" - 20"  | 1" - 60"   |  |  |
| No 3H & 4H PLAIN UNIV. & SLIDING HEAD VERT.   | QUICK CHANGE   | 16   | 1" - 30"  | NONE   |  |  |
| No 2KM & 3KM PLAIN UNIV. & SLIDING HEAD VERT.   | QUICK CHANGE   | 16   | 1" - 30"  | NONE   | 150" LONG 1" & CROSS<br>75" VERTICAL   |  |
| No 2K & 3K PLAIN UNIV. & SLIDING HEAD VERT.   | QUICK CHANGE   | 32   | 1" - 60"  | NONE   | 150" LONG 1" & CROSS<br>75" VERTICAL   |  |
| No 4K & 5H PLAIN UNIV. & SLIDING HEAD VERT.   | QUICK CHANGE   | 32   | 1" - 60"  | NONE   | 150" LONG 1" & CROSS<br>75" VERTICAL   |  |
| No 2D ROTARY HD. TOOL & DIE MACHINE   |                |  |   |  |  |  |
| HAS QUICK CHANGE FEED TO ROTARY HD. VERT. QUILL & TABLE MOVEMENTS - HAND FEED TO SADDLE & KNEE. |                |  |   |  |  |  |
| FEED INCREMENTS   |                |  |   |  |  |  |
| FEED RANGE  | No. OF FEEDS   |  |   |  |  |  |
| 1" - 10"  | 16             | 1/8, 3/16, 1/4, 5/16, 3/8, 7/16, 1/2, 5/8, 3/4, 7/8, 1   | 2 1/8, 2 1/4, 2 1/2, 2 3/4, 3, 3 1/4, 3 1/2, 3 3/4, 4, 4 1/4, 4 1/2, 4 3/4, 5, 5 1/4, 5 1/2, 5 3/4, 6, 6 1/4, 6 1/2, 6 3/4, 7, 7 1/4, 7 1/2, 7 3/4, 8, 8 1/4, 8 1/2, 8 3/4, 9, 9 1/4, 9 1/2, 9 3/4, 10  | 6 1/8, 7 1/8, 8 1/8, 9 1/8, 10 1/8   |  |  |
| 1" - 20"  | 16             | 1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1  | 2 1/4, 2 1/2, 2 3/4, 3, 3 1/4, 3 1/2, 3 3/4, 4, 4 1/4, 4 1/2, 4 3/4, 5, 5 1/4, 5 1/2, 5 3/4, 6, 6 1/4, 6 1/2, 6 3/4, 7, 7 1/4, 7 1/2, 7 3/4, 8, 8 1/4, 8 1/2, 8 3/4, 9, 9 1/4, 9 1/2, 9 3/4, 10   | 12 1/4, 12 1/2, 12 3/4, 13, 13 1/4, 13 1/2, 13 3/4, 14, 14 1/4, 14 1/2, 14 3/4, 15, 15 1/4, 15 1/2, 15 3/4, 16, 16 1/4, 16 1/2, 16 3/4, 17, 17 1/4, 17 1/2, 17 3/4, 18, 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20   |  |  |
| 3" - 30"  | 16             | 1/2, 3/4, 1, 5/4, 3/2, 7/4, 2, 9/4, 5/2, 11/4, 3, 13/4, 7/2, 15/4, 4, 17/4, 9/2, 19/4, 5, 21/4, 11/2, 23/4, 6, 25/4, 13/2, 27/4, 7, 29/4, 15/2, 31/4, 8, 33/4, 17/2, 35/4, 9, 37/4, 19/2, 39/4, 10, 41/4, 21/2, 43/4, 22, 45/4, 23, 47/4, 24, 49/4, 25, 51/4, 26, 53/4, 27, 55/4, 28, 57/4, 29, 59/4, 30 | 6 1/4, 6 1/2, 6 3/4, 7, 7 1/4, 7 1/2, 7 3/4, 8, 8 1/4, 8 1/2, 8 3/4, 9, 9 1/4, 9 1/2, 9 3/4, 10, 10 1/4, 10 1/2, 10 3/4, 11, 11 1/4, 11 1/2, 11 3/4, 12, 12 1/4, 12 1/2, 12 3/4, 13, 13 1/4, 13 1/2, 13 3/4, 14, 14 1/4, 14 1/2, 14 3/4, 15, 15 1/4, 15 1/2, 15 3/4, 16, 16 1/4, 16 1/2, 16 3/4, 17, 17 1/4, 17 1/2, 17 3/4, 18, 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20 | 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20, 20 1/4, 20 1/2, 20 3/4, 21, 21 1/4, 21 1/2, 21 3/4, 22, 22 1/4, 22 1/2, 22 3/4, 23, 23 1/4, 23 1/2, 23 3/4, 24, 24 1/4, 24 1/2, 24 3/4, 25, 25 1/4, 25 1/2, 25 3/4, 26, 26 1/4, 26 1/2, 26 3/4, 27, 27 1/4, 27 1/2, 27 3/4, 28, 28 1/4, 28 1/2, 28 3/4, 29, 29 1/4, 29 1/2, 29 3/4, 30   |  |  |
| 1" - 40"  | 16             | 1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1  | 2 1/4, 2 1/2, 2 3/4, 3, 3 1/4, 3 1/2, 3 3/4, 4, 4 1/4, 4 1/2, 4 3/4, 5, 5 1/4, 5 1/2, 5 3/4, 6, 6 1/4, 6 1/2, 6 3/4, 7, 7 1/4, 7 1/2, 7 3/4, 8, 8 1/4, 8 1/2, 8 3/4, 9, 9 1/4, 9 1/2, 9 3/4, 10   | 24 1/4, 24 1/2, 24 3/4, 25, 25 1/4, 25 1/2, 25 3/4, 26, 26 1/4, 26 1/2, 26 3/4, 27, 27 1/4, 27 1/2, 27 3/4, 28, 28 1/4, 28 1/2, 28 3/4, 29, 29 1/4, 29 1/2, 29 3/4, 30, 30 1/4, 30 1/2, 30 3/4, 31, 31 1/4, 31 1/2, 31 3/4, 32, 32 1/4, 32 1/2, 32 3/4, 33, 33 1/4, 33 1/2, 33 3/4, 34, 34 1/4, 34 1/2, 34 3/4, 35, 35 1/4, 35 1/2, 35 3/4, 36, 36 1/4, 36 1/2, 36 3/4, 37, 37 1/4, 37 1/2, 37 3/4, 38, 38 1/4, 38 1/2, 38 3/4, 39, 39 1/4, 39 1/2, 39 3/4, 40 |  |  |
| 1 1/2" - 60"  | 16             | 1/2, 3/4, 1, 5/4, 3/2, 7/4, 2, 9/4, 5/2, 11/4, 3, 13/4, 7/2, 15/4, 4, 17/4, 9/2, 19/4, 5, 21/4, 11/2, 23/4, 6, 25/4, 13/2, 27/4, 7, 29/4, 15/2, 31/4, 8, 33/4, 17/2, 35/4, 9, 37/4, 19/2, 39/4, 10, 41/4, 21/2, 43/4, 22, 45/4, 23, 47/4, 24, 49/4, 25, 51/4, 26, 53/4, 27, 55/4, 28, 57/4, 29, 59/4, 30 | 6 1/4, 6 1/2, 6 3/4, 7, 7 1/4, 7 1/2, 7 3/4, 8, 8 1/4, 8 1/2, 8 3/4, 9, 9 1/4, 9 1/2, 9 3/4, 10, 10 1/4, 10 1/2, 10 3/4, 11, 11 1/4, 11 1/2, 11 3/4, 12, 12 1/4, 12 1/2, 12 3/4, 13, 13 1/4, 13 1/2, 13 3/4, 14, 14 1/4, 14 1/2, 14 3/4, 15, 15 1/4, 15 1/2, 15 3/4, 16, 16 1/4, 16 1/2, 16 3/4, 17, 17 1/4, 17 1/2, 17 3/4, 18, 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20 | 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20, 20 1/4, 20 1/2, 20 3/4, 21, 21 1/4, 21 1/2, 21 3/4, 22, 22 1/4, 22 1/2, 22 3/4, 23, 23 1/4, 23 1/2, 23 3/4, 24, 24 1/4, 24 1/2, 24 3/4, 25, 25 1/4, 25 1/2, 25 3/4, 26, 26 1/4, 26 1/2, 26 3/4, 27, 27 1/4, 27 1/2, 27 3/4, 28, 28 1/4, 28 1/2, 28 3/4, 29, 29 1/4, 29 1/2, 29 3/4, 30   |  |  |
| 1" - 30"  | 16             | 1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1  | 2 1/4, 2 1/2, 2 3/4, 3, 3 1/4, 3 1/2, 3 3/4, 4, 4 1/4, 4 1/2, 4 3/4, 5, 5 1/4, 5 1/2, 5 3/4, 6, 6 1/4, 6 1/2, 6 3/4, 7, 7 1/4, 7 1/2, 7 3/4, 8, 8 1/4, 8 1/2, 8 3/4, 9, 9 1/4, 9 1/2, 9 3/4, 10   | 17 1/4, 17 1/2, 17 3/4, 18, 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20, 20 1/4, 20 1/2, 20 3/4, 21, 21 1/4, 21 1/2, 21 3/4, 22, 22 1/4, 22 1/2, 22 3/4, 23, 23 1/4, 23 1/2, 23 3/4, 24, 24 1/4, 24 1/2, 24 3/4, 25, 25 1/4, 25 1/2, 25 3/4, 26, 26 1/4, 26 1/2, 26 3/4, 27, 27 1/4, 27 1/2, 27 3/4, 28, 28 1/4, 28 1/2, 28 3/4, 29, 29 1/4, 29 1/2, 29 3/4, 30   |  |  |
| 1" - 60"  | 32             | 1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1  | 2 1/4, 2 1/2, 2 3/4, 3, 3 1/4, 3 1/2, 3 3/4, 4, 4 1/4, 4 1/2, 4 3/4, 5, 5 1/4, 5 1/2, 5 3/4, 6, 6 1/4, 6 1/2, 6 3/4, 7, 7 1/4, 7 1/2, 7 3/4, 8, 8 1/4, 8 1/2, 8 3/4, 9, 9 1/4, 9 1/2, 9 3/4, 10   | 10 1/2, 10 1/4, 10 1/2, 10 3/4, 11, 11 1/4, 11 1/2, 11 3/4, 12, 12 1/4, 12 1/2, 12 3/4, 13, 13 1/4, 13 1/2, 13 3/4, 14, 14 1/4, 14 1/2, 14 3/4, 15, 15 1/4, 15 1/2, 15 3/4, 16, 16 1/4, 16 1/2, 16 3/4, 17, 17 1/4, 17 1/2, 17 3/4, 18, 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20   | 15, 15 1/4, 15 1/2, 15 3/4, 16, 16 1/4, 16 1/2, 16 3/4, 17, 17 1/4, 17 1/2, 17 3/4, 18, 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20, 20 1/4, 20 1/2, 20 3/4, 21, 21 1/4, 21 1/2, 21 3/4, 22, 22 1/4, 22 1/2, 22 3/4, 23, 23 1/4, 23 1/2, 23 3/4, 24, 24 1/4, 24 1/2, 24 3/4, 25, 25 1/4, 25 1/2, 25 3/4, 26, 26 1/4, 26 1/2, 26 3/4, 27, 27 1/4, 27 1/2, 27 3/4, 28, 28 1/4, 28 1/2, 28 3/4, 29, 29 1/4, 29 1/2, 29 3/4, 30 |  |
| MODEL "D"   |                |  |   |  |  |  |
| HEAD 1/5-3 REV PER MINUTE   | 16             | 1/4, 3/8, 1/2, 5/8, 3/4, 7/8, 1, 1 1/4, 1 1/2, 1 3/4, 2 1/4  |   |  |  |  |
| QUILL OF SPINDLE PER REV. INCHES  | 8              | 1/5, 3/16, 1/6, 5/8, 7/8, 1, 1 1/4, 1 1/2, 1 3/4, 2 1/4  |   |  |  |  |
| TABLE PER. MIN. INCHES  | 16             | .0002-.0003-.0006-.0010-.0016-.0028-.0047-.0080  |   |  |  |  |
| FORM 492  |                |  |   |  |  |  |