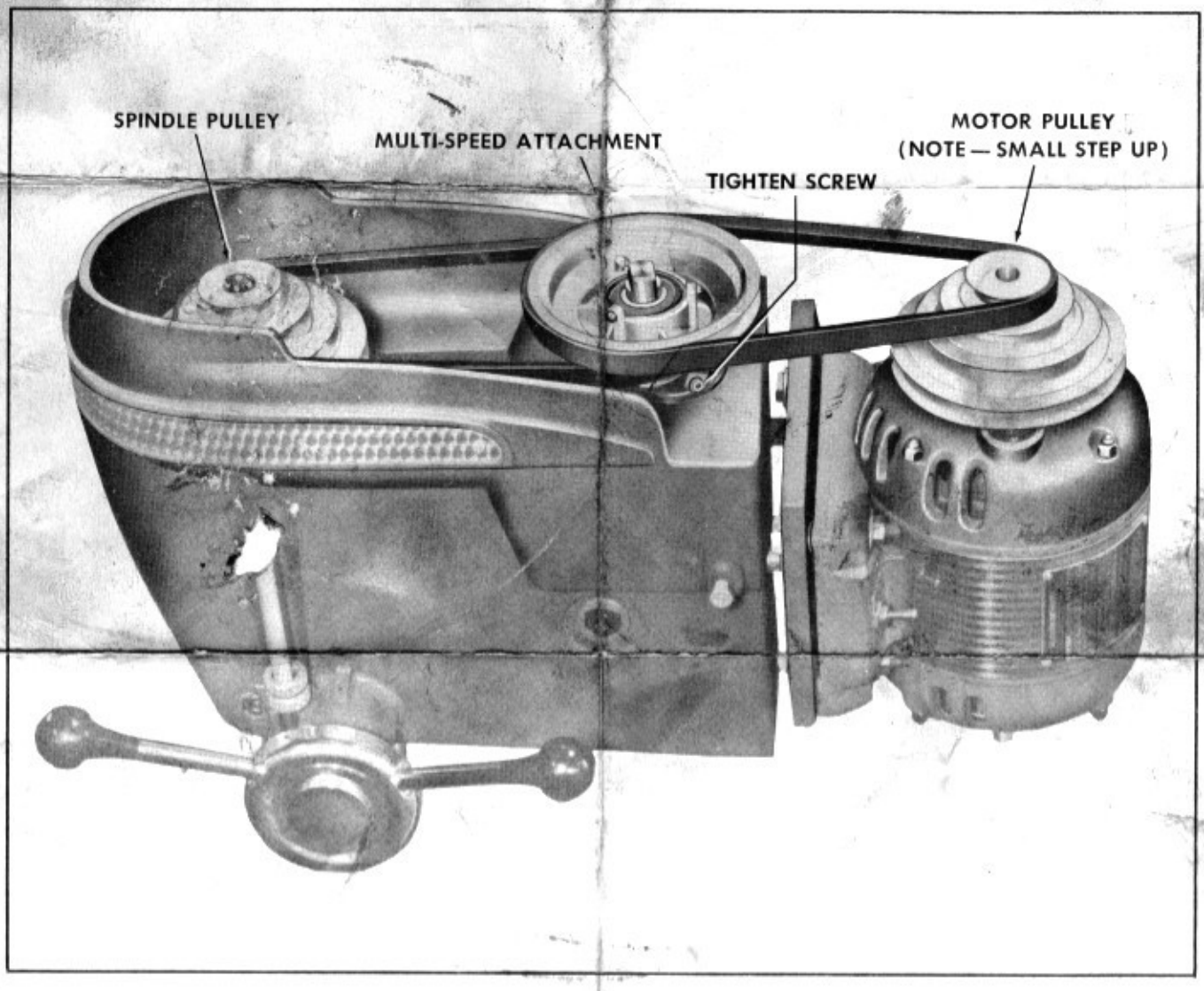
OPERATING INSTRUCTIONS FOR MULTI-SPEED ATTACHMENT 9-2338 FOR DRILL PRESSES 99-2313, 99-2314, 99-2364



The Multi-Speed Attachment when properly installed on one of the above listed drill presses increases the speed range from the original 625-5000 R.P.M. to 175-17500 R.P.M. as shown by the diagram on the back of this sheet.

The 3/16 inch thick 2 3/8 inch diameter collar is supplied for use when the Multi-Speed Attachment is installed in drill press columns with an inside diameter of 2 3/8 inches. If the unit is to be installed on the 99-2364 drill press, you may discard this collar since the cast support will just fit in the 2 inch diameter inside the column.

INSTALLATION:

Remove the stamped metal cap from the top of the drill press column. Insert the cylindrical cast support of the multi-speed unit into the top of the column—use or discard the above mentioned collar as needed. The flange of the support should be seated firmly against the top of the column. Turn the motor pulley over so that the small step is on top.

Two V-Belts are supplied. One is 27 inches long, the other is 29 inches long. If installed on the 99-2364 drill press the shortest belt must be placed between the multi-speed pulley and the drill press pulley. If used on one of the other two models, the longer of the two belts should be installed at this point.

Adjust the tension of the spindle belt by turning the support casting in the column. This moves the multi-speed pulley toward or away from the spindle as desired. After the belts have been installed and the tension established, the support may be fastened tightly in the column by tightening the socket head set screw which you can see through the top of the support. Use a 5/32 inch Allen wrench.

The following chart shows the approximate speeds available with the Multi-Speed Attachment when a 1750 R.P.M. motor is used, and all three pulleys have the same step diameter as is the case in the above mentioned drill presses. Other speeds may be attained by shifting the motor up or down on the support and by moving the entire headstock of the drill press up or down on the column.

For continuous operation the maximum recommended speed is 7800 R.P.M. Higher speeds can be reached, but should not be maintained for long due to the excessive friction on the bearings.

The ball bearings used in this Multi-Speed Attachment were packed with lubricant at the factory, and should require no further attention for the life of the bearing.

SPINDLE R.P.M.	SPINDLE PULLEY	MULTI-SPEED PULLEY	MOTOR PULLEY
17500 7800 3900			
7800 3500 790			
3500 880 400			
750 375 175			