

CATALOG NO. D48

Atlas
**DRILL
PRESSES**

BENCH • FLOOR

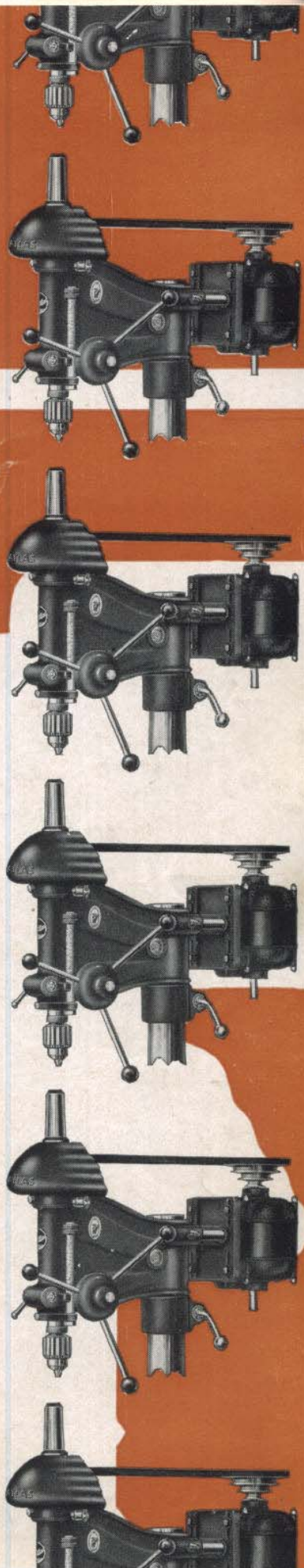
2, 3, 4

SPINDLE MACHINES



ATLAS PRESS COMPANY

**KALAMAZOO
MICHIGAN
U.S.A.**



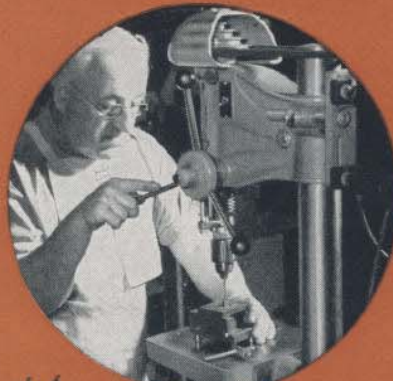
MOST USEFUL TOOL IN AMERICAN INDUSTRY



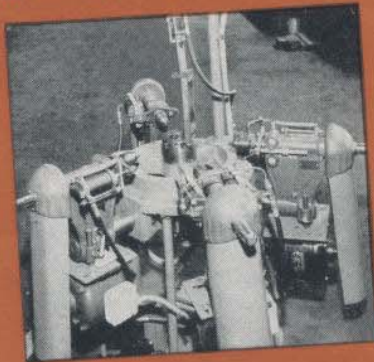
Speed and accuracy in drilling make Atlas the outstanding favorite in automotive repair shops.



Battery of Atlas drill presses used for precision lapping operation at the Steapactite Division of the Pacific Clay Products Co., Los Angeles.



(Right) Atlas drill press used for precision optical work in the Bausch & Lomb Optical Company, Rochester.



Unique combination of 4 Atlas drill press heads set up to drill 4 holes simultaneously at the Pacific Enamel Works, Richmond, California. Air-operated fixtures position the piece, then after a timed interval air cylinders advance the drills.



Output went up 300% when the Cooper Manufacturing Co., Marshalltown, Iowa, installed this Atlas drill press "production line." Two horizontally mounted heads enable operator to see work clearly and simultaneously countersink both ends of bar. Jigged part then goes to next operator for 7 holes, and to end of line for two more holes and tapping.

**15-inch HEAVY DUTY
BENCH TYPE
DRILL PRESS**

All around utility makes the No. 64 a favorite in every type of shop for drilling and tapping of metal, and such woodworking operations as drilling, shaping, mortising, routing, carving, and sanding. It's economical to buy and economical to operate. Has superior spindle-head bearing design that assures accuracy and long service life. Table is full tilting, has ground top. Face of base is ground as an auxiliary table for long work. See page 6 for complete construction details.

No. 64 15" HEAVY DUTY BENCH TYPE DRILL PRESS with No. 70 to 1/2" Jacobs Chuck, belt and motor pulley, less motor. ZIDYG, wt. 125 lb.

No. 64S 15" HEAVY DUTY BENCH TYPE DRILL PRESS, same as No. 64 except with oil table in place of table shown, less motor. ZIGED, 155 lbs.

No. 64-1M 15" HEAVY DUTY BENCH TYPE DRILL PRESS with No. 1 Morse Taper in place of chuck, belt and motor pulley, less motor. ZIDZA, 125 lb. (5/8" diameter spindle — 11 1/4" capacity over table)

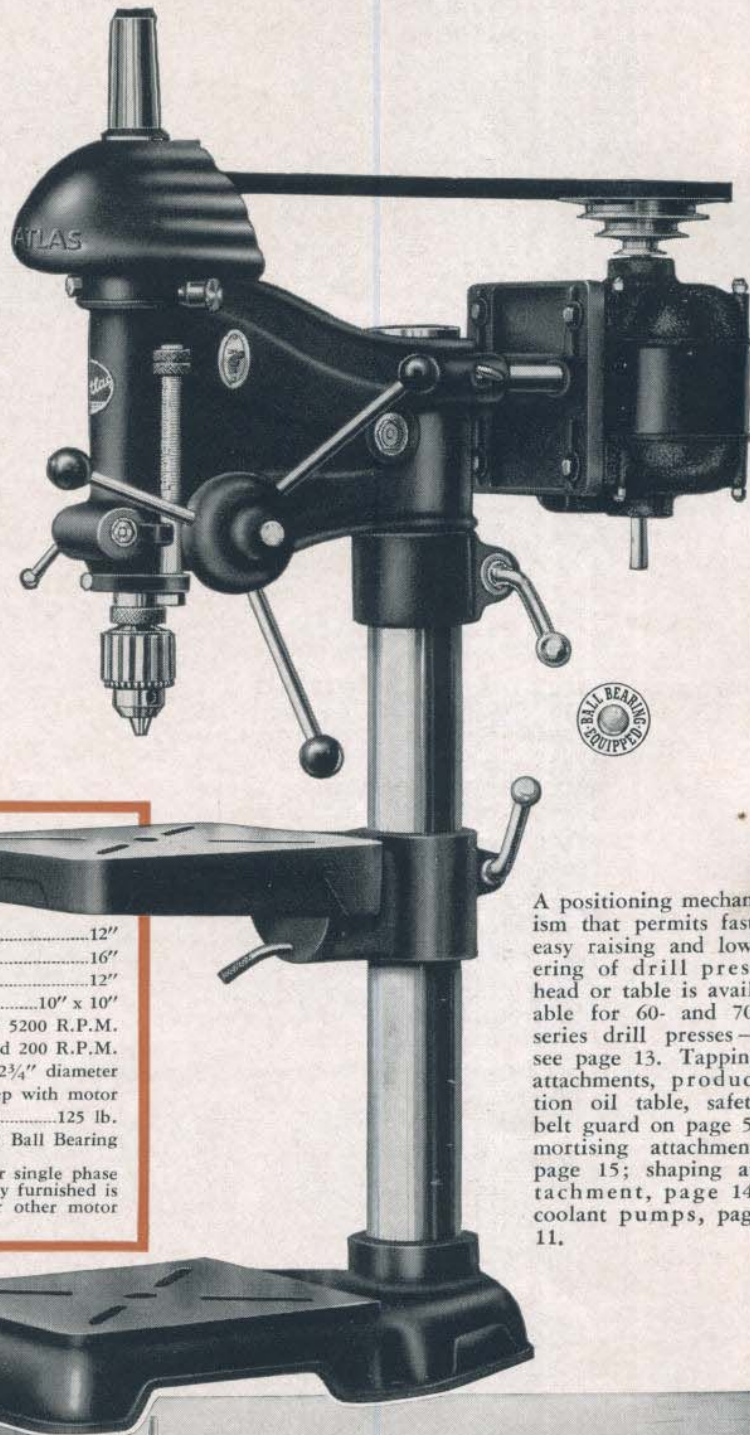
No. 64-1MS 15" HEAVY DUTY BENCH TYPE DRILL PRESS, same as No. 64-1M except with oil table in place of table shown, less motor. ZIGGO, 155 lbs.

SPECIFICATIONS

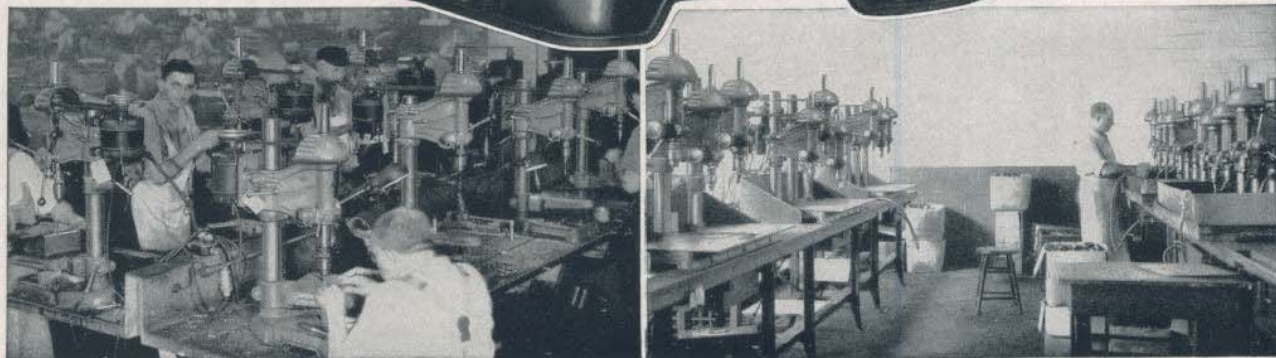
Drills to Center of Circle.....	15" diameter
Chuck Capacity	1/2"
Spindle Travel.....	4"
Maximum Distance Table to Chuck.....	12"
Maximum Distance Base to Chuck.....	16"
Table Travel	12"
Size of Table.....	10" x 10"
9 Speeds between.....	600 and 5200 R.P.M.
With Hi-Lo Speed Attachment (page 13).....	Low Speed 200 R.P.M.
Ground Steel Column.....	2 3/4" diameter
Overall Dimensions.....	41" high x 12" wide x 24" deep with motor
Shipping Weight Less Motor.....	125 lb.
Motor Recommended.....	1/3 or 1/2 H.P. 1725 R.P.M. Ball Bearing

Built-in switch furnished is 10 amperes at 110 volts, for single phase current only — 3 phase controls, page 11. Motor pulley furnished is for 5/8" diameter motor shaft — prices of pulleys for other motor shafts on request.

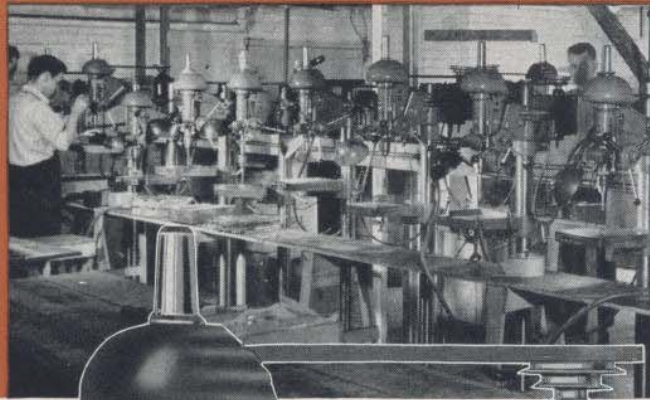
Both single phase and three phase motors are available for use with the No. 64 drill press. Complete details and ordering information on page 11.



A positioning mechanism that permits fast, easy raising and lowering of drill press head or table is available for 60- and 70-series drill presses — see page 13. Tapping attachments, production oil table, safety belt guard on page 5; mortising attachment, page 15; shaping attachment, page 14; coolant pumps, page 11.



Atlas DRILL PRESSES



15-INCH HEAVY DUTY Floor Type DRILL PRESS

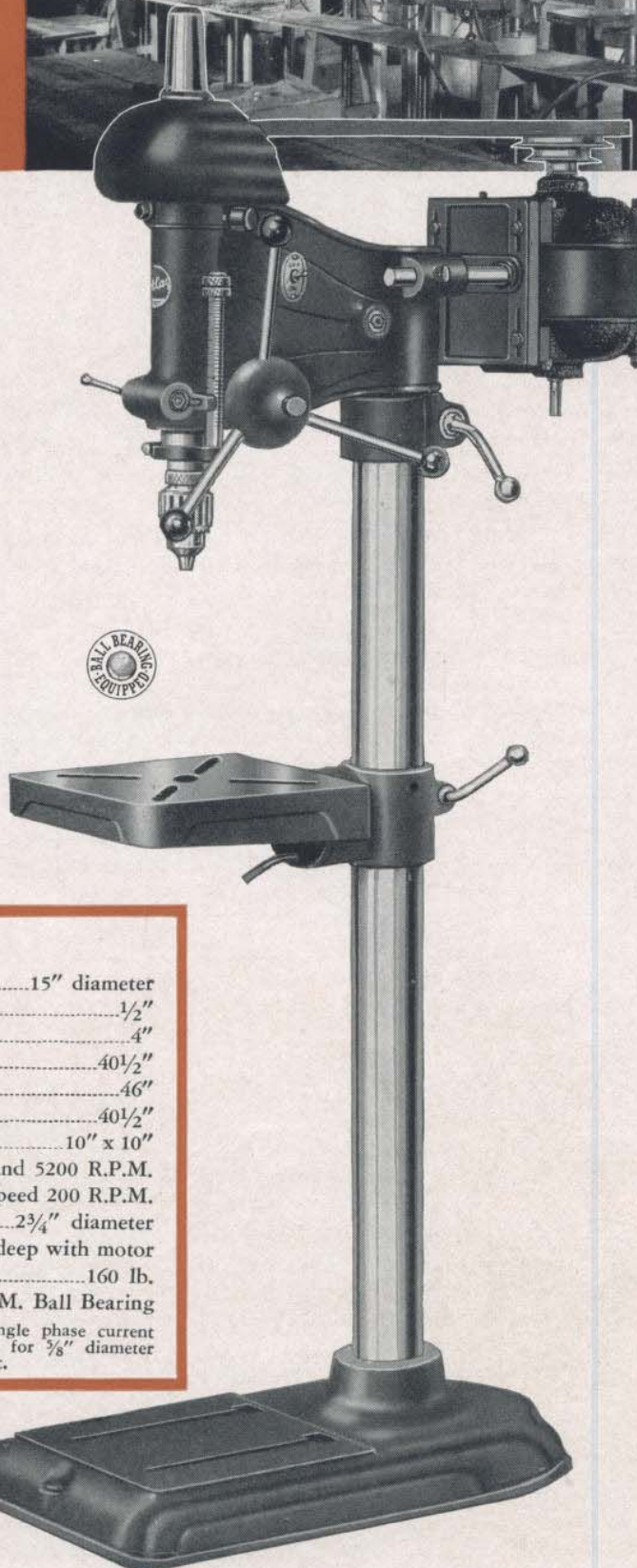
The No. 74 has all the features that have made Atlas drill presses outstanding for rigidity, smoothness and lifetime accuracy *plus* extra work capacity—40½" over table, 46" over base. It has spindle head bearing design with "Floating Drive," splined spindle and drive pulley, adjustable feed return, precision Jacobs Chuck, and full-tilting table—fully described on page 6.

No. 74 15" HEAVY-DUTY FLOOR TYPE DRILL PRESS with No. 70 to ½" Jacobs Chuck, complete as shown with belt and motor pulley, less motor. Code ZIEBY, wt. 160 lb.

No. 74S HEAVY-DUTY FLOOR TYPE DRILL PRESS, same as No. 74 except with oil table in place of table shown, less motor. ZICEZ, 205 lbs.

No. 74-1M 15" HEAVY-DUTY FLOOR TYPE DRILL PRESS with No. 1 Morse Taper in place of chuck. Complete with belt and motor pulley, less motor. Code ZIEGD, wt. 160 lb. (⅝" diameter spindle—39¾" capacity over table)

No. 74-1MS HEAVY-DUTY FLOOR TYPE DRILL PRESS, same as No. 74-1M except with oil table in place of table shown, less motor. ZICIB, 205 lbs.



SPECIFICATIONS

Drills to Center of Circle.....	15" diameter
Chuck Capacity.....	½"
Spindle Travel.....	4"
Maximum Distance Table to Chuck.....	40½"
Maximum Distance Base to Chuck.....	46"
Table Travel.....	40½"
Size of Table.....	10" x 10"
9 Speeds between.....	600 and 5200 R.P.M.
With Hi-Lo Speed Attachment (page 13).....	Low Speed 200 R.P.M.
Ground Steel Column.....	2¾" diameter
Overall Dimensions.....	71" high x 16" wide x 30" deep with motor
Shipping Weight less Motor.....	160 lb.
Motor Recommended.....	⅓ or ½ H.P. 1725 R. P. M. Ball Bearing
Built-in switch furnished—10 amperes at 110 volts—for single phase current only. 3-phase controls, page 11. Motor pulley furnished is for ⅝" diameter motor shaft—prices of pulleys for other motor shafts on request.	

Equipped with the No. W33 foot-lever feed control (next page), the No. 74 drill press is an ideal machine for repetitive drilling and tapping operations. Other production accessories are shown on pages 12 and 13. Shaping attachment, page 14. Mortising attachment, page 15. Coolant pumps, page 11. Safety belt guard, page 5. Motors, page 11.

PRODUCTION ACCESSORIES for 60 and 70 SERIES PRESSES

SAFETY GUARD

A light, durable safety shield that covers the entire drill press drive mechanism, as required by industrial and vocational safety codes in many states. Pin hinges permit quick raising for speed changes — unnecessary to remove guard to change belts.

No. 62-7A SAFETY GUARD for 60 and 70 series Atlas drill presses, may be ordered separately or with drill press. Ready tapped for easy installation. Code ZABSY, wt. 7 lb.

TAPPING ATTACHMENTS (SEE BELOW)

PRODUCTION OIL TABLE

For production work with jigs and fixtures. Can be furnished with Nos. 64 and 74 drill presses in place of standard full-tilting table. Ground working surface, 10½" x 16½". Drain channel removes oil or cutting compound.

No. 61-25 PRODUCTION OIL TABLE for 60 and 70 series drill presses, may be ordered separately or with drill press. Code ZABUR, wt. 65 lb.

FOOT LEVER FEED CONTROL

For 70-series drill presses. Speeds up any repetitive operation. Improves accuracy by freeing operator's hands to hold and guide work. Includes adjustable draw rod, foot pedal, spindle arm, adjustable return spring.

No. W33 FOOT LEVER FEED CONTROL for 70-series drill presses, complete as shown. Code ZAETH, wt. 31 lb. (Note: not recommended for production mortising.)



Drill presses can be adapted to light milling operations with No. W68 universal compound vise—see page 12.

TAPPING ATTACHMENTS

Converts any Atlas 60- or 70-series drill press into a sensitive, high-speed production tapping machine. Heavy duty, highly precise mechanism — spindle turns on ball bearings. Reverse speed is twice forward speed. No adapters necessary.

Also available are Atlas tapping attachments for drill presses with Morse taper spindles — details on request.

No. W39A TAPPING ATTACHMENT complete with "Tru-Grip" tap holder and 7 collets for following taps: Nos. 8, 9, 10, ¼", 5/16", 3/8" (shank diameter .381), 7/16", and ½". CAPACITY: No. 8 tap to 5/16" in steel, 3/8" in cast iron, ½" in brass. Code ZAERF, wt. 13 lb.

No. W39 TAPPING ATTACHMENT complete with "Tru-Grip" tap holder and 4 collets for following taps: Nos. 2, 3, 4, 5, 6, 7, 8, 9, 10, and ¼". CAPACITY: up to 3/16" in steel, ¼" in brass and cast iron. Code ZAEMZ, wt. 7 lb.



"TRU-GRIP" TAP HOLDER

Furnished with Atlas tapping attachments. Light in weight, accurate, and has no delicate parts to cause trouble. Spring collets furnished — both holder and collets are hardened and ground.



CONSTRUCTION FEATURES — 60 and 70 SERIES

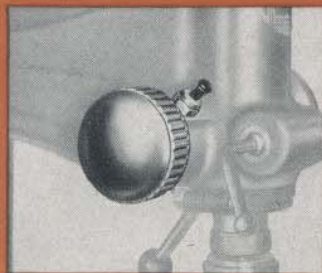
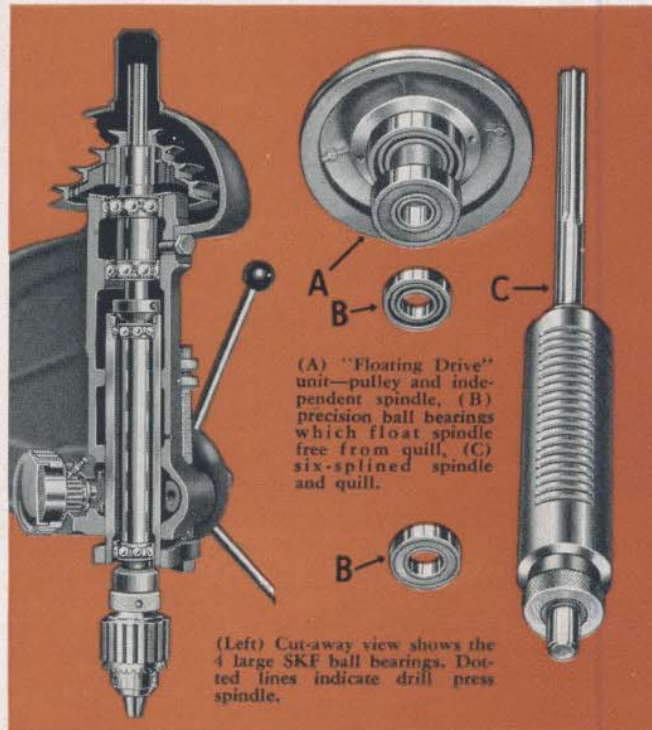
"FLOATING DRIVE" SPINDLE HEAD BEARING DESIGN

GIVES YOU SMOOTHNESS AND LASTING ACCURACY

The exceptional smoothness, long life, and accuracy of Atlas 64 and 74 drill presses are the result of their rugged construction and unique "Floating Drive" spindle bearing design.

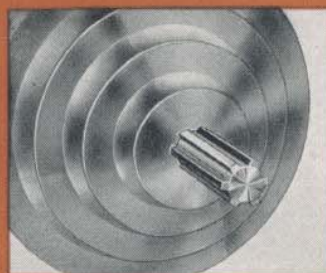
The six-splined pulley is mounted on an independent tubular steel spindle supported in the head by two, deep-grooved ball bearings. This floating drive transmits turning power only to the spindle — all belt pull is taken to the head through the drive unit. The steel quill is precision ground. Two widely spaced ball bearings float the spindle free from the quill.

Head casting is a heavy, rigid, fully-enclosed housing for the entire assembly. The 3 quill guides and 2 drive-bearing housings are precision-bored, and holes for column are bored at same setting to assure accurate alignment of column and spindle.



ADJUSTABLE FEED TENSION

Provides any desired feed tension. Heavy-duty spring housed in cap controls tension on feed pinion shaft. Tension is set by turning ratchet device, released with button.



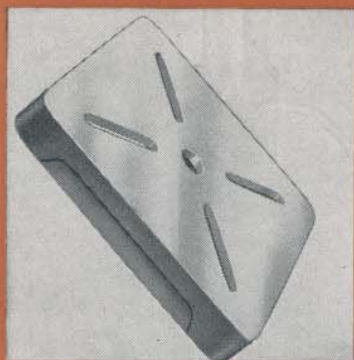
6-Splined SPINDLE and PULLEY

Maintain spindle alignment and transmit maximum power to the drill without whip or backlash. Spindle is special alloy steel ground to extremely close tolerances.



PRECISION JACOBS CHUCK

The accuracy built into the drill press is carried to the drill point by a precision chuck. Capacity, No. 70 to 1/2" drill. No. 1 Morse Taper spindle is available.

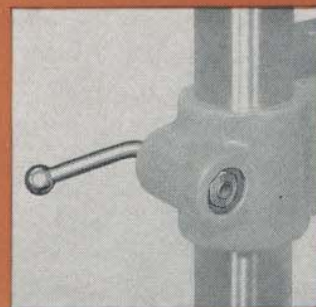


FULL-TILTING PRECISION- GROUND TABLE

A heavy, well-braced machine-ground casting. Tilts any angle right or left — locks securely. Horizontal and 90° positions are indexed.

COORDINATE CLAMP LOCKS

For head, column collar, table support and quill. Ball handle tightens or releases two clamping wedges simultaneously without scoring or distorting quill or column.



PRECISION DRILLING EQUIPMENT FOR ALL SHOPS

12³/₄" DRILL PRESS BENCH TYPE No. 54

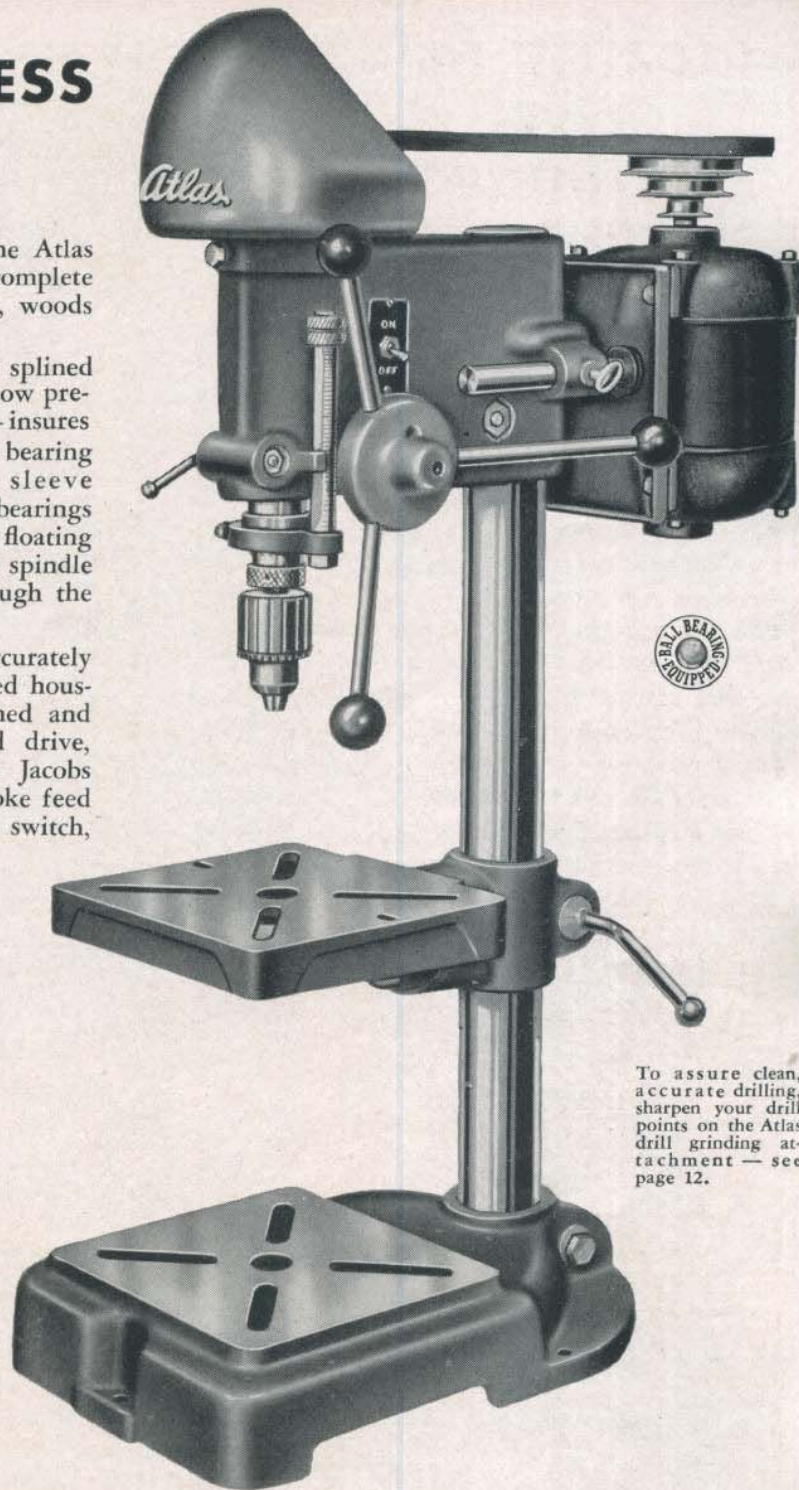
Rugged, accurate, compact, efficient — the Atlas No. 54 makes quick, easy work of the complete range of drill press operations in metals, woods and plastics, at low cost.

The new floating drive unit — with six splined spindle and drive sleeve, and large double-row precision ball bearing mounted in the pulley — insures smooth, quiet operation. Floating drive bearing turns on an independent ground steel sleeve anchored in the head. Two more ball bearings float the spindle free from the quill. The floating drive transmits turning power only to the spindle — all belt pull is taken to the head through the drive unit.

The No. 54 drill press head is a heavy accurately machined casting — a strong, fully enclosed housing for the spindle and bearings. Matched and balanced pulleys, combined with splined drive, practically eliminate vibration. Precision Jacobs chuck, graduated depth indicator, three-spoke feed wheel, built-in 10-ampere motor control switch, and adjustable motor mounting bracket are furnished. Clamp locks for head, quill, and table support are coordinate type. Full tilting table is accurately ground. Heavy base is a rugged support — face is ground to serve as table for long work. Column is 2¹/₄" ground steel.

No. 54 BENCH TYPE DRILL PRESS WITH No. 70 to 1/2" JACOBS CHUCK complete as shown with belt and 5/8" diameter bore motor pulley, graduated depth indicator, 3-spoke feed wheel, built-in 10-ampere switch, adjustable motor mounting bracket, less motor. Code word ZIDOD, shipping weight 95 lbs.

NOTE: Built-in switch is 10 amp. at 110 volts for single phase current only. 3-phase controls, page 11. Motor pulley furnished is for 3/8" diameter motor shaft — prices of pulleys for other motor shafts on request.



To assure clean, accurate drilling, sharpen your drill points on the Atlas drill grinding attachment — see page 12.

SPECIFICATIONS

Drills to Center of 12 ³ / ₄ " diameter Circle.	Ground Steel Column.....	2 ¹ / ₄ " diameter
Chuck Capacity.....	9 Speeds between.....	600 and 5200 R.P.M. (Low Speed 200 R.P.M. with Hi-Lo Attachment)
Spindle Travel.....	Overall Dimensions.....	35 ¹ / ₂ " high x 12" wide x 24" deep with motor
Maximum Distance Table to Chuck.....	Motors Recommended.....	1/3 or 1/2 H.P., 1725 R.P.M. Ball Bearing (see page 11)
Maximum Distance Base to Chuck.....		
Table Travel.....		
Size of Table.....		

NEW PRODUCTION ECONOMIES WITH *Atlas*

In almost every small-part production set-up there are operations where Atlas multiple spindle drill presses can save time. They eliminate waste operator motion on series of drilled and tapped holes. They reduce parts handling, boost output.

The massive production tables provide plenty of "elbow room" for the smooth movement of jigs and fixtures. Each drill head is equipped with its own motor mounting, and the unique Atlas-developed control positions each head as desired with a few turns of the crank.

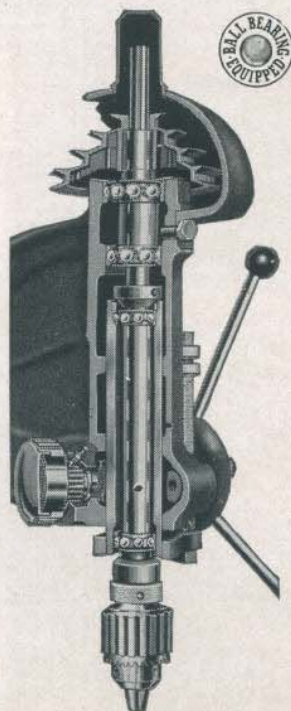
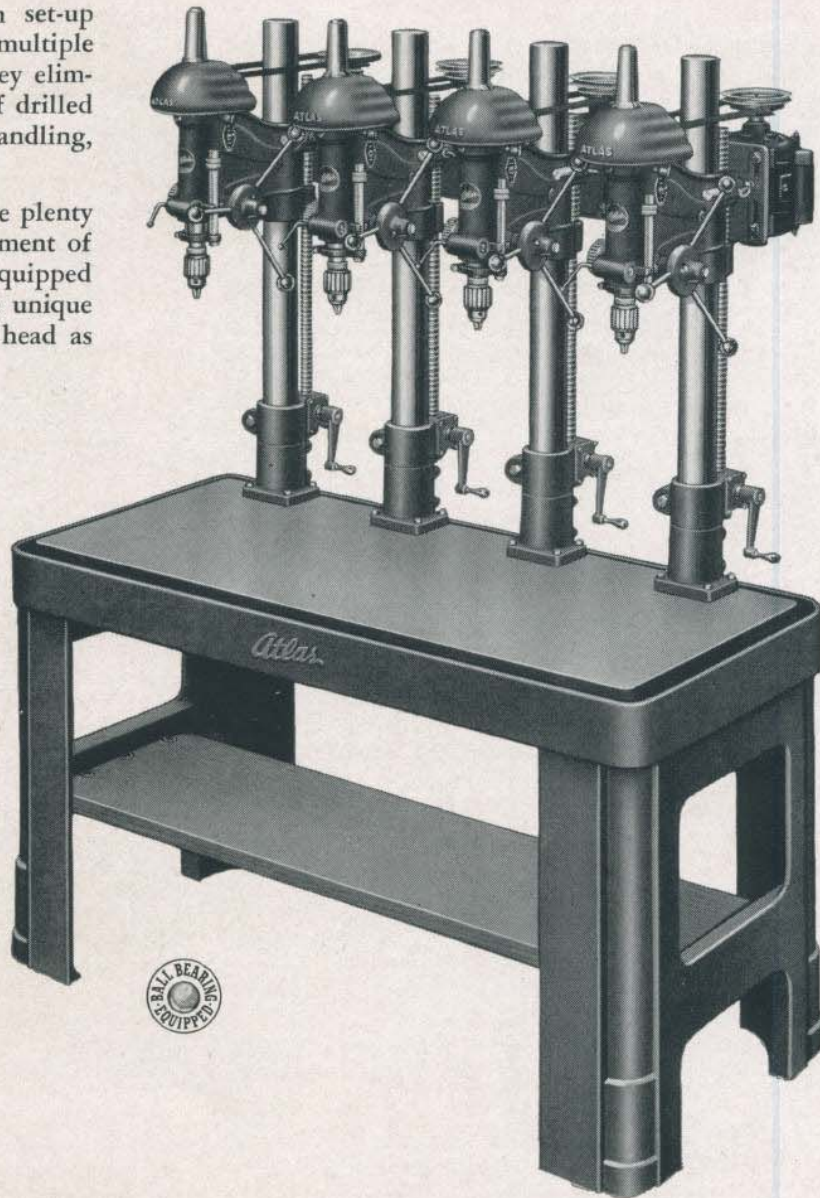
Note the weight of the units, which insures stability — the $\frac{1}{3}$ or $\frac{1}{2}$ HP motor requirement that cuts power cost.

These units are built to give you important production savings. Any special questions about adapting them for your particular needs will get prompt attention from the Atlas Engineering Staff.

No. W-134 FOUR-SPINDLE PRESS

No. W-134 FOUR-SPINDLE DRILL PRESS with Jacobs No. 70- $\frac{1}{2}$ " Chucks, complete with floor legs, less motors. Wt. 960 lbs. Code ZIFHY.

Table working surface is 21" x 49", center to center of spindles 12". See chart on next page for full specifications.

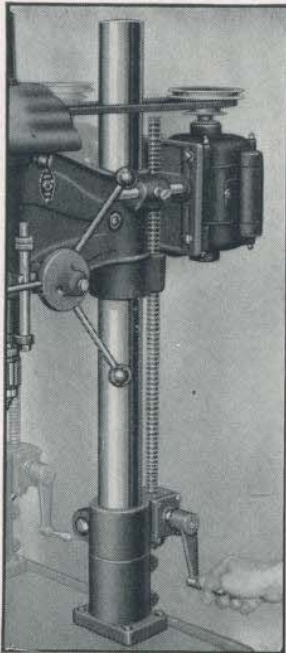


CONSTRUCTION FEATURES

"FLOATING-DRIVE" SPINDLE DESIGN is the secret of the smooth and sensitive drilling action of Atlas multiple spindle presses. The four precision ball bearings — plus the uniquely engineered head design that relieves the spindle of all driving pull — assure unmatched smoothness and accurate spindle alignment on deep holes. This exclusive Atlas head design accounts for many new operating records set by Atlas drill presses in hundreds of the largest, most efficient plants.

EXTRA RUGGED TABLE AND LEGS of these Atlas drill presses provide solidity that minimizes vibration. The massive production oil table is a heavy grey iron casting, rigidly braced with thick ribs on the bottom, planed square with the drilling spindles for accurate work with jigs and fixtures. Drain channel removes oil or cutting compound. Floor legs are heavy, well-braced castings, a rugged support for heavy work.

MULTIPLE SPINDLE DRILL PRESSES



Atlas

HEAD-POSITIONING CONTROL

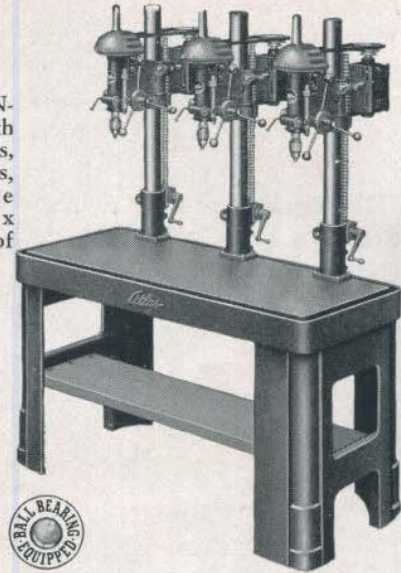
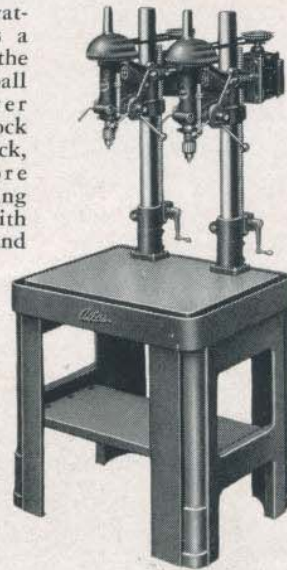
Set-up time is reduced to a minimum with this exclusive Atlas head-positioning mechanism. Simply turning the crank lowers or raises the drill head to the desired position. The elevating screw controls a column collar below the drill head — screw has ball thrust bearing at lower end. Head clamping lock is coordinate type — quick, sure, will not score column. Head positioning control is supplied with multiple spindle units, and is available as an attachment for 60- and 70-series drill presses (see page 13).

STANDARD EQUIPMENT

Each unit is furnished complete as shown with floor legs, less motors. Equipment includes: head raising mechanism, Jacobs No. 70-1/2" chuck or Morse taper spindle, optional, motor mounting bracket, V-belt, motor pulley for 3/8" diam. shaft, built-in switch (10 ampere at 110 volt, single phase). See page 5 for tapping attachments, page 11 for coolant pumps.

No. W-133 THREE-SPINDLE PRESS

No. W-133 THREE-SPINDLE DRILL PRESS with Jacobs No. 70-1/2" Chucks, floor legs, less motors, weight 860 lbs. Code ZIFFO. Table surface 21" x 49", center to center of spindles 17".



No. W-132 TWO-SPINDLE PRESS

No. W-132 TWO-SPINDLE DRILL PRESS with Jacobs No. 70-1/2" Chucks, complete with floor legs, less motors, weight 575 lbs. Code ZIFEC. Table surface 21" x 26", center to center of spindles 13".

COMPLETE SPECIFICATIONS

	4	3	2
Number of Spindles.....	4	3	2
Center to Center of Spindles.....	12"	17"	13"
Maximum Distance, Table to Jacobs Chucks.....	26"	26"	26"
Maximum Distance, Table to No. 1 Morse Taper Spindles.....	24 1/4"	24 1/4"	24 1/4"
Column to Center of Spindle.....	7 1/2"	7 1/2"	7 1/2"
Column Support Bracket to Center of Spindle.....	6 7/8"	6 7/8"	6 7/8"
Chuck Capacity.....	1/2"	1/2"	1/2"
Spindle Travel.....	4"	4"	4"
Table Working Surface.....	21" x 49"	21" x 49"	21" x 26"
9 Speeds between.....	600 and 5200 R.P.M.	Same	Same
Ground Steel Columns.....	2 3/4" diam.	2 3/4" diam.	2 3/4" diam.
Overall Height.....	78 1/2"	78 1/2"	78 1/2"
Overall Depth with Motors.....	31 1/4"	31 1/4"	31 1/4"
Overall Width.....	53"	53"	30"
Floor to Top of Table.....	31"	31"	31"
Wood Shelf.....	14" x 52 1/4"	14" x 52 1/4"	14" x 29 1/4"
Net Weight less Motors.....	960 lb.	860 lb.	575 lb.
Shipping Weight (Approximate).....	1200 lb.	1100 lb.	660 lb.
ORDER NUMBER with Jacobs No. 70 to 1/2" Chucks.....	W-134	W-133	W-132
Code Word with Jacobs No. 70 to 1/2" Chucks, less Motors.....	ZIFHY	ZIFFO	ZIFEC
ORDER NUMBER with No. 1 Morse Taper Spindles.....	W-134-1M	W-133-1M	W-132-1M
Code Word with No. 1 Morse Taper Spindles less Chucks and Motors.....	ZIFUG	ZIFOF	ZIFID

SINGLE PHASE MOTORS

1725 R.P.M., 60 cycle, 110/220 volt capacitor-start motors. Have large SKF ball bearings, 3/8" single end shaft.

No.	H.P.	Wt.	Code Word
2730	1/2	32 lb.	YIDFA
2720	1/2	36 lb.	YIDGE

THREE PHASE MOTORS

1725 R.P.M. 60 cycle for three phase current.

No.	H.P.	Voltage	Wt.	Code Word
2830	1/3	220	26 lb.	YIDUK
2820	1/2	220	32 lb.	YIDDJ
2834	1/3	440	26 lb.	YIEBD
2824	1/2	440	32 lb.	YIDYL

THREE PHASE SWITCH

Required with 3-phase motor. Mounting bracket and flexible cable-covered motor connection cord are furnished.

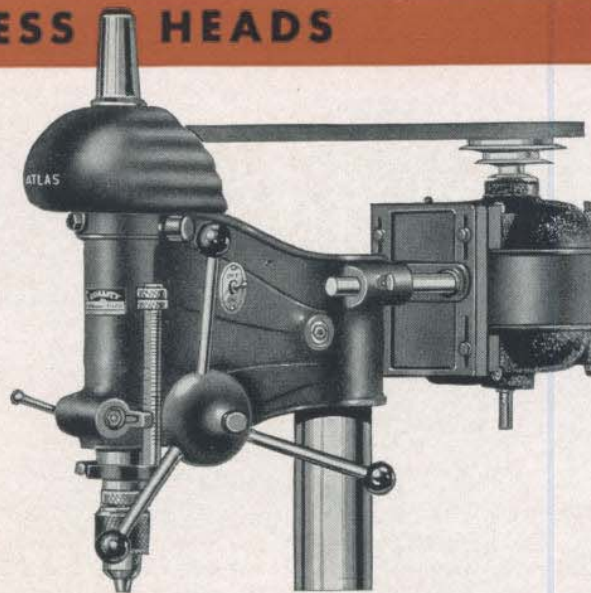
No. W86 THREE PHASE SWITCH for multiple spindle drill presses, with mounting bracket and connections. Code ZEIKD. Wt. 6 lb.

Atlas DRILL PRESS HEADS

Atlas drill press heads have been used by hundreds of plants for special drilling or tapping set-ups that solve difficult production problems at low cost. Often they eliminate the need for a costly special drilling machine.

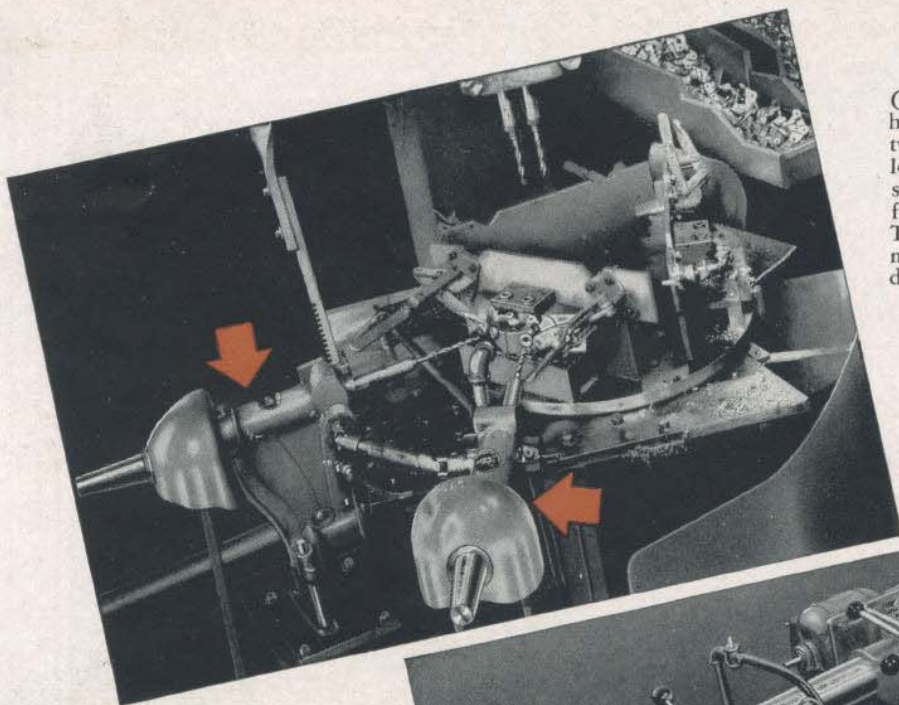
These drill heads are compact, portable, easily adapted to the job, operate in any position. Available in two sizes: the 15" 64-Series and the 12³/₄" 54-Series — complete specifications below. Note: *We do not manufacture special drilling machines.*

SPECIFICATIONS	64 Series	54 Series
Drills to Center of Circle.....	15"	12 ³ / ₄ "
Spindle Travel.....	4"	3"
Column Bore.....	2 ³ / ₄ "	2 ¹ / ₄ "
Speed Range, R.P.M.....	600-5200	600-5200
SKF Ball Bearings.....	4	3
Weight.....	70 lb.	55 lb.
Order No., 70 to 1/2" Jacobs Chuck.	64-1V ZIEVS	54-1X ZIDUF
Order No. with No. 1 Morse Taper.	64-1Z ZIEWT	



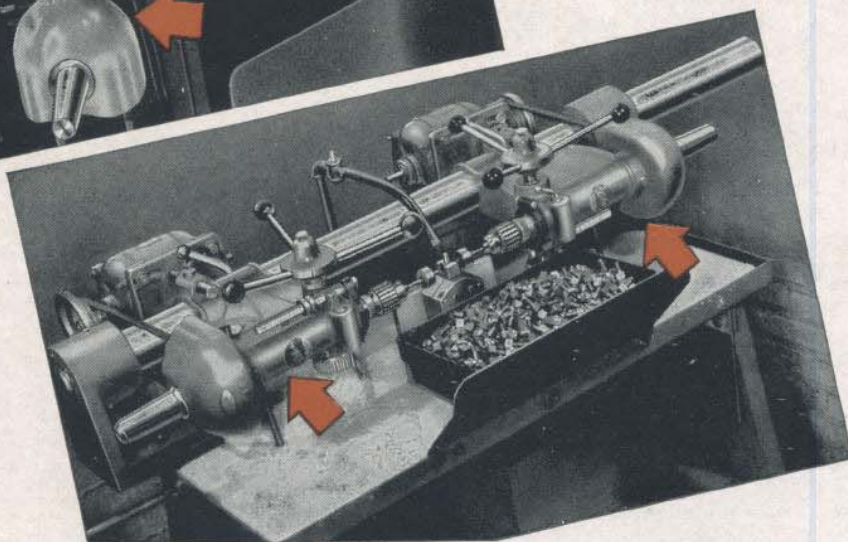
STANDARD EQUIPMENT

FURNISHED: Complete as shown above, with motor mounting bracket, belt and pulley; less motor and column. Motor control switch furnished is 10 amp. at 110 volt single phase only — three phase switch, page 11. Motor pulley furnished is for 5/8" diameter motor shaft — prices of pulleys for other motor shafts on request.

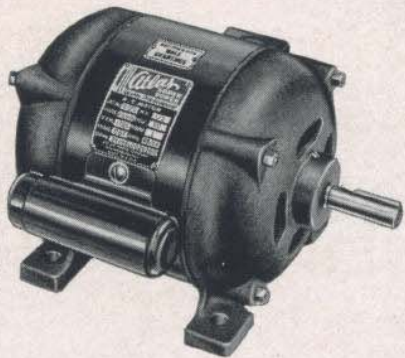


(Left) Two 64-series Atlas drill heads boost production by drilling two extra holes at an extremely low set-up cost. Feed of double-spindle vertical drill also drives feed for Atlas horizontal drills. Three fixtures on rotary table permit loading parts while holes are drilled at the two other stations.

(Right) Production is multiplied on special bolt by simplifying operations from two directions. Two 64-series Atlas drill heads mounted on one column. Piece is first cross-drilled from the right with drill carrying a tool which counterbores a radius as hole is completed. Then the piece is counterbored from the left.



Atlas MOTORS AND SWITCHES

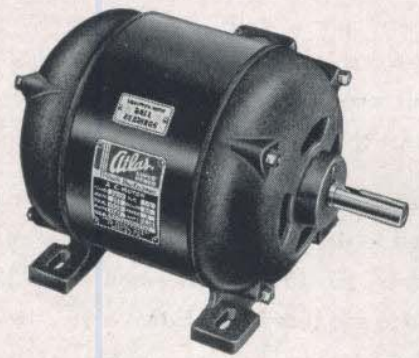


SINGLE PHASE CAPACITOR-START

Atlas Capacitor-Start Motors have high starting and pull-out torque, developing full power instantly under load without drawing excess current. Have ball bearings — may be operated in any position: horizontal, vertical or inverted. $\frac{5}{8}$ " single-end shaft. Do not have switch, cord, or plug.

Cat. No.	Code	H.P.	Volts	Cycle	R.P.M.	Weight
2720	YIDGE	$\frac{1}{2}$	110-220	60	1725	36 lb.
2730	YIDFA	$\frac{1}{3}$	110-220	60	1725	32 lb.

No. 2710 10-ft. Extension Cord and Plug for $\frac{1}{3}$ and $\frac{1}{2}$ H.P. single phase motors. YIDEG. 1 lb.



THREE PHASE

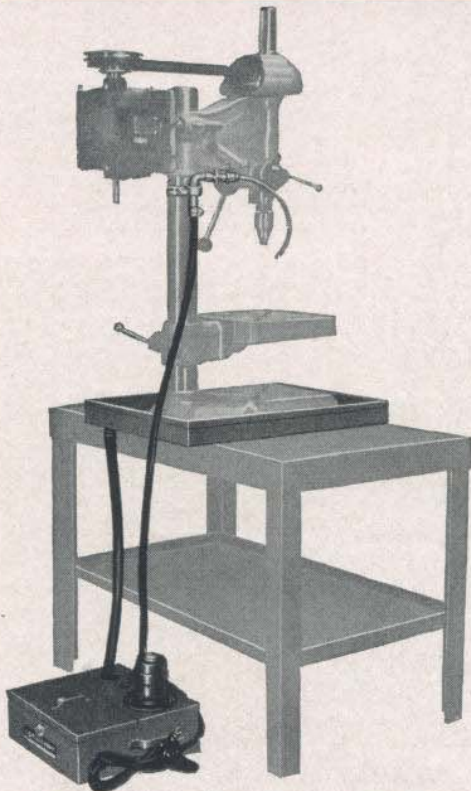
Atlas Three Phase Motors are 60 cycle — have ball bearings, $\frac{5}{8}$ " single-end shaft, terminal box—do not have switch, cord, or plug.

Cat. No.	Code	H.P.	Volts	Cycle	R.P.M.	Weight
2820	YID0J	$\frac{1}{2}$	220	60	1725	32 lb.
2824	YIDYL	$\frac{1}{2}$	440	60	1725	32 lb.
2830	YIDUK	$\frac{1}{3}$	220	60	1725	26 lb.
2834	YIEBD	$\frac{1}{3}$	440	60	1725	26 lb.

No. W67 Three Phase Switch for single spindle drill presses. ZECET. 6 lbs.

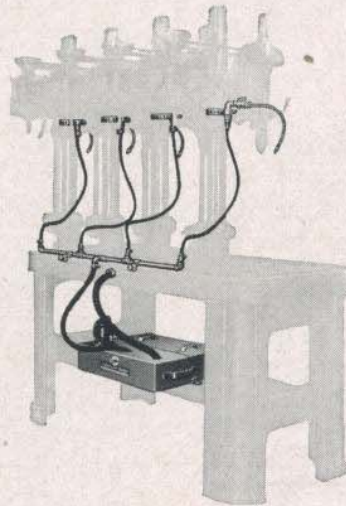
No. W86 Three Phase Switch for multiple spindle drill presses. ZEIKD. 6 lbs.

Atlas COOLANT SYSTEMS FOR COLUMN DIAMETER TO 4 $\frac{1}{2}$ "



No. W110 COOLANT SYSTEM for single spindle drill presses, complete with induction-type pump, feed and return system. Capacity 225 G.P.H. Tank: $2\frac{1}{2}$ gal. Motor: 3450 R.P.M., induction-type for 110-120 volt, 50-60 cycle, AC. Code ZEKUG. Wt. 20 $\frac{1}{2}$ lb.

No. W113 COOLANT SYSTEM for single spindle drill presses, complete with universal-type pump, feed and return system. Capacity 450 G.P.H. 5-gal. tank. Universal motor — 6000 R.P.M., 110-120 volt, AC-DC. Code ZELDE. Wt. 28 lb. (See 3rd column for oil pan.)

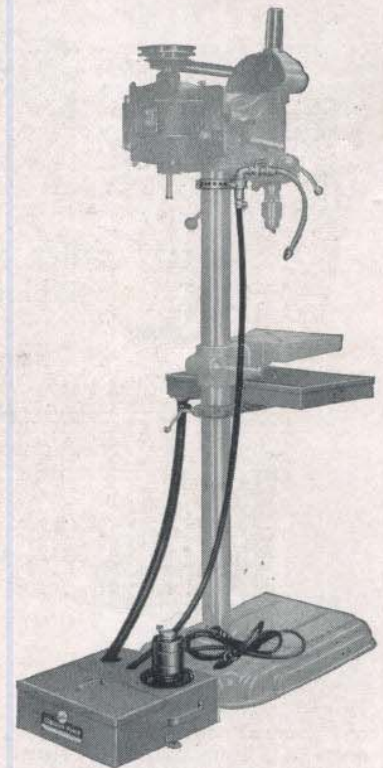


No. W116 COOLANT SYSTEM for Two-Spindle drill presses. Code ZELJY. Wt. 32 lb.

No. W117 COOLANT SYSTEM for Three-Spindle drill presses. Code ZELOG. Wt. 34 $\frac{1}{2}$ lb.

No. W118 COOLANT SYSTEM for Four-Spindle drill presses. Code ZELUH. Wt. 36 $\frac{1}{2}$ lb.

Each system is complete with nozzles, clamps, universal-type pump, feed and return tubes. Specifications: pumping capacity 450 G.P.H.; tank capacity 5 gals., universal motor — 6000 R.P.M., 110-120 volt AC-DC.

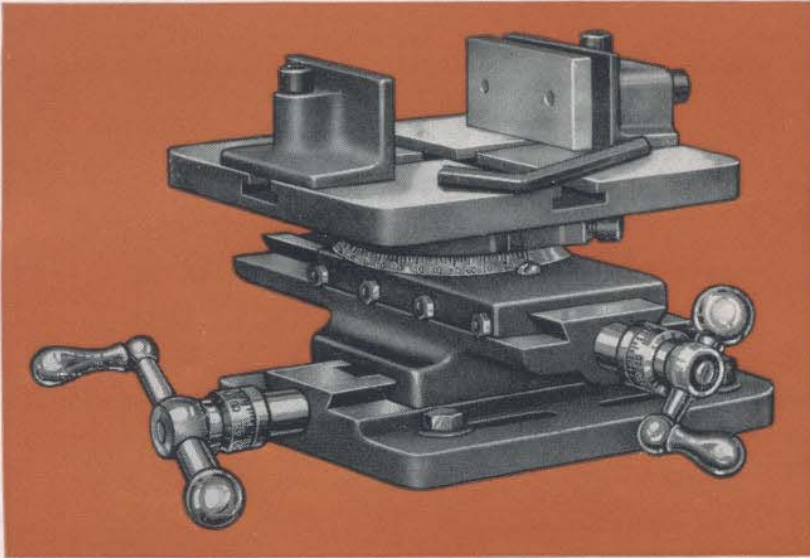


No. W90 OIL PAN for most bench-type drill presses. Size: 16" x 22" x 2" deep. Code ZEKBA. Wt. 10 lb.

No. W91 OIL PAN, for 70-series drill presses and others with $2\frac{3}{4}$ " diameter columns. Adjustable column bracket. Size: 13" x 16" x 2" deep. Code ZEKCE. Wt. 12 lb.

Both of above are leak-proof welded, heavy-gauge steel, have outlet nipple for return hose.

Atlas UNIVERSAL COMPOUND VISE, DRILL GRINDER



UNIVERSAL COMPOUND VISE

All kinds of accurate indexing, layout, and spacing work—straight lines, radial, circular—are handled by this versatile fixture. Built rigidly to adapt drill presses to light milling operations . . . ideal for use with shapers, milling machines, lathes, and grinders for any jobs requiring accurate feeds in two directions.

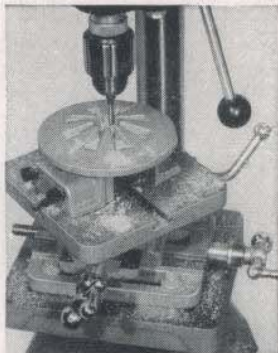
Upper slide is graduated 90° right and left so vise table may be set at any angle. The transverse (upper) and cross (lower) slides travel on dovetail ways with full-length gib plates for take-up. One vise jaw swivels to grip irregular work, other has movable face to tighten on work.

No. W68 UNIVERSAL COMPOUND VISE complete as shown above with wrench and bolts. Code word ZEFWE, wt. 23¾ lb.

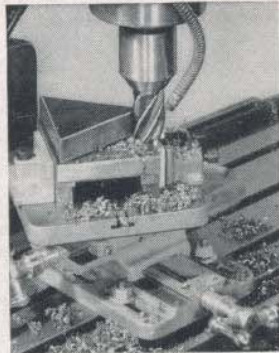
SPECIFICATIONS

Cross Feed Travel (lower).....	6½"
Transverse Feed Travel (upper).....	5½"
Size of Base	6" x 7"
Size of Table.....	7" x 7"
Jaw Width	3"
Jaw Opening	4⅝"
Jaw Height	1⅞"
Height, Base to Table.....	4¼"

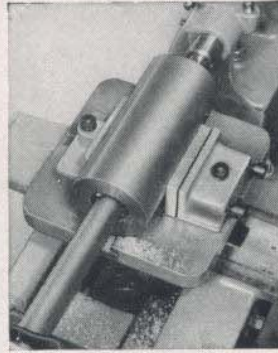
No. W68-2A TABLE ONLY for boring on Atlas 10" lathes, complete with vise and wrench. Code ZEFZO, wt. 12 lb.



The W68 Vise simplifies many jobs in the pattern shop. Above, routing angular cuts with vise mounted on drill press.



Many milling uses—above, machining triangular punch rest on Atlas 10" lathe, to hold long piece for boring.



Here is vise table alone (No. W68-2A) replacing compound rest on Atlas 10" lathe, to hold long piece for boring.

DRILL GRINDING ATTACHMENT

With the Atlas drill grinder, it takes just two minutes to sharpen any drill between 3/32" and 1/2" in diameter, and *both lips are always ground identically*. Fast, clean, accurate drilling is assured, drill life is prolonged, and the uncertainty and waste of hand work eliminated.

Novel chuck and V-block center the drill. Shank stop, micrometer graduated feed, and special lip stop give accurate rechucking for grinding second lip. Base swivels 40° to 80° (80° to 160° included angle), with 59° and 41° positions marked. Adapts to any grinder and wheel thickness.

No. W30 DRILL GRINDING ATTACHMENT complete as shown. Code WUVNE, wt. 7 lb.

DIAMOND POINT FOR DRESSING WHEEL

Trues face of grinding wheel for maximum accuracy. Held in chuck of drill grinding attachment.



No. W30-35A DIAMOND POINT. Code ZEERK, wt. 4 ozs.

SHARPENS DRILLS FROM 3/32" TO 1/2"



FOR ANY GRINDER AND WHEEL THICKNESS

RECESS WHEELS

For Drill Grinding Recessed One Side

No. W30-40:	
Diameter	6"
Diameter Hole	1/2"
Code	WUVSY
Weight2 lb.
No. W30-41:	
Diameter	7"
Diameter Hole	5/8"
Code	WUVUR
Weight	2½ lb.



Atlas DRILL PRESS ACCESSORIES AND ATTACHMENTS

HI-LO SPEED ATTACHMENT



The "Hi-Lo" provides a low speed of 200 R.P.M. for heavy metal work and higher than standard speeds for wood-working.

It can be mounted or removed in less than three minutes. Base is accurately machined to fit inside the top of drill

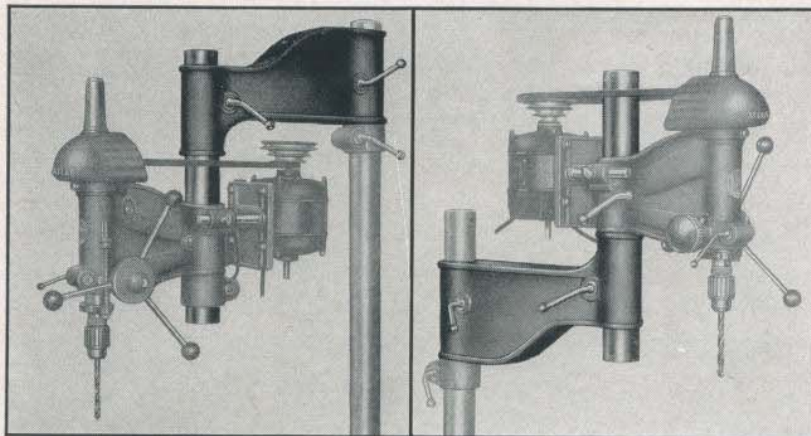
press column. Balanced pulley runs on a large double-row ball bearing. Eccentric mounting of pulley with base permits quick release of belt tension for speed changes.

Order No.	Atlas Drill Press	Column Size Inside Diameter	Code Word
W-14B	53-series	2"	ZEKFO
W-15	60- to 63-series and 70- to 73-series	2½"	ZAFTO
W-121	54-series	2½"	ZEKOF
W-120	64- and 74-series	2½"	ZEKID



Low Speed 200 R.P.M.
Weight 6 lb. — V-belts furnished

Drill press series number is shown on nomenclature plate attached to drill press base.



RADIAL ARM

INCREASES THROAT CAPACITY TO 24"

Converts any Atlas 60- or 70-series drill press into a small radial drilling machine with work range which permits drilling of extra large pieces. Increases chuck-to-column capacity to a full 24", and the auxiliary column furnished adds 15" to chuck-to-base capacity. Can be mounted in an upright or inverted position.

Massive arm casting is ribbed and reinforced to maintain rigidity. Holes for drill press column and auxiliary column are precision bored. The 19" auxiliary column is 2¾" diameter ground steel tubing — allows travel of the drill head up to 6½" — also permits drill head to be mounted above or below arm.

No. W79 RADIAL ARM for 60- and 70-series drill presses. Code word ZAJAT, wt. 46 lb.

No. 61-75B COLUMN COLLAR for supporting drill head on auxiliary column with radial arm inverted. Code ZEHYA, wt. 3½ lb.

COLUMN COLLAR

Simplifies raising and lowering drill press head and permits swinging head. Furnished with Nos. 64 and 74 drill presses.

No.	Drill Press	Wt.	Code
61-75B	60 or 70 series	3½ lb.	ZEHYA
52-75B	50 series	3½ lb.	ZEHZE



HEAD and TABLE POSITIONING MECHANISM

For 60- and 70-Series Drill Presses

Makes fast, easy work of raising or lowering drill press head or table. Quickly installed on any Atlas 60- or 70-series drill press. One revolution of the crank gives ⅛" travel—max. travel at one setting is 12".

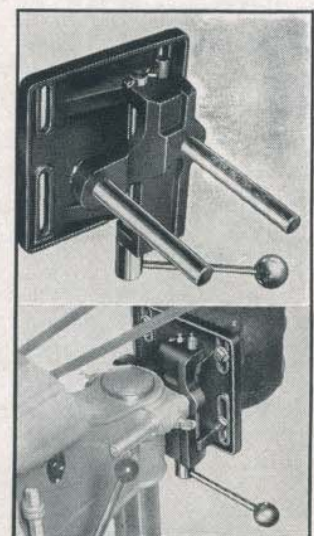
No. W76 HEAD AND TABLE POSITIONING MECHANISM for 60- and 70-series drill presses. ZAIRG. 18 lbs.

QUICK-CHANGE BELT RELEASE

Permits instant release of belt tension, speeds up belt changes, and assures correct tension adjustment at all times.

Motor, on hinged base, is moved toward drill press head by rocker shaft with ball handle control. Easily installed, replacing regular motor bracket.

No. 52-50A QUICK-CHANGE RELEASE for 60- and 70-series drill presses, may be ordered separately or with drill press. V-belt furnished. ZECWO. 12½ lb.



Atlas DRILL PRESS SHAPING ATTACHMENT

Those fluted and rounded moldings, that put home shop furniture into the "professional" class, are made easily, quickly, and accurately with this Atlas shaping attachment. Cutters are available for giving you almost any shape and contour on large or small pieces of regular or irregular shape.

The fence casting is accurately machined grey-iron—a rigid support for the seasoned hard wood faces. Base of fence is slotted to permit 7/16" adjustment—feed screw moves right side in and out for planing operations. Two adjustable spring steel clips, furnished, hold work securely against fence and table during entire length of cut. Cutters, except for portion engaging work, are enclosed by the heavy fence casting which has an opening in back for easy chip removal.

The 5-ply maple table measures 14 3/4" x 18" — plenty of support for shaping long pieces. Top is carefully finished so work rides smoothly as cut is taken. Table is ready drilled to take fence and hold downs — bolts to drill press table.

SHAPING CUTTERS

Atlas shaping cutters are made of select high-carbon steel, carefully heat-treated and ground for clean cutting and long service. They are easily sharpened by grinding across the face of the cutting edges. Adapted to drill press spindle with No. W6-6A, illustrated at right.



Shaping Cutter Set

No. LS-30 SET OF 11 SHAPING CUTTERS, listed at right. Code ZIKGA. Wt. 1 lb.



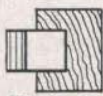
No. LS-21



No. LS-22



No. LS-25



No. LS-26



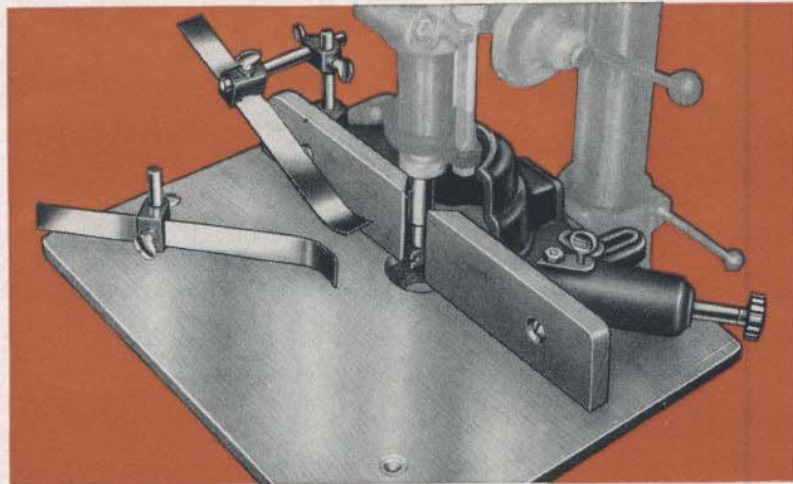
No. LS-28



No. LS-29



No. LS-20



ATLAS SHAPING ATTACHMENT

No. W80 ATLAS SHAPING ATTACHMENT complete, including table, fence, hold-downs, less cutters, adapter and collars. Code YUZOP. Wt. 13 lbs.

No. W80F SHAPING FENCE ONLY, including wood facings, bolts, washers and nuts. Code YUZPO. Wt. 5 1/2 lbs.

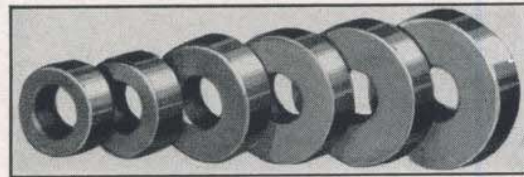
No. W80T EXTENSION TABLE ONLY, complete with screws and guide pin for irregular work. Code YUZRY. Wt. 6 lbs.

No. W80H HOLD-DOWNS ONLY, complete with clamps and stud. Code YUZYR. Wt. 1 1/2 lbs.

DEPTH COLLARS

Necessary for gaging depth of cut—also used as height spacers.

No. LS-31 SET OF SIX DEPTH COLLARS, 1/2" hole, 1/4" wide. Outside diameters: 7/8", 15/16", 1", 1-1/16", 1 1/8", 1 1/4". ZIKHE. 4 1/2 oz.



SHAPING CUTTER ADAPTER

No. W6-6A SHAPING CUTTER ADAPTER for all Jacobs Chuck Spindles, complete with nut and washer. Code ZALUC, wt. 7 oz.

SHAPING CUTTERS

1-11/16" Diameter, 1/2" Hole

No.	Code
LS-16 Moulding Cutter	ZIHYK
LS-17 Moulding Cutter	ZIJAF
LS-18 Moulding Cutter	ZIJEG
LS-19 Moulding Cutter	ZIJFA
LS-20 1/4" Groove Cutter	ZIJGE
LS-21 1/4" Tongue Cutter	ZIJJO
LS-22 1" Straight Face Cutter	ZIJLY
LS-25 1/4" Straight Face Cutter	ZIJOJ
LS-26 1/2" Straight Face Cutter	ZIJUK
LS-28 Moulding Cutter	ZIJYL
LS-29 Moulding Cutter	ZIKAG



No. LS-16



No. LS-17



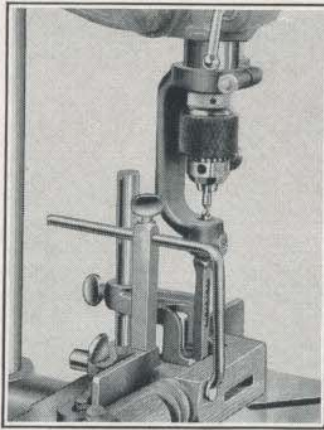
No. LS-18



No. LS-19

Atlas DRILL PRESS WOODWORKING ATTACHMENTS

MORTISING ATTACHMENT



Converts any Atlas drill press into a mortising machine for cutting clean, accurate mortise-and-tenon joints. Gives you much better fits than hand methods — saves hours of time.

Illustrated is the type of work you can do for chair, table, cabinet, and bookcase legs. Also valuable for joint work on doors, storm windows, screens.

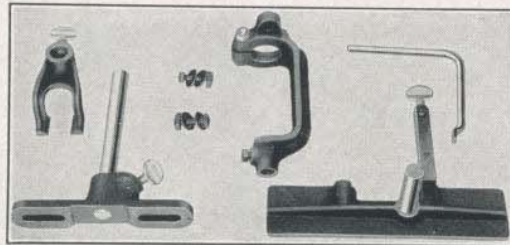
Fence can be adjusted after table bracket has been bolted to drill press table — an exclusive Atlas feature. It permits adjusting work for mortises larger than the regular chisel range. Fence always moves absolutely parallel to the chisel sides.

The hold-down foot is quickly adjusted for work between 1/2" and 6" high. Capacity between fence and sideclamp arm is 5 1/2", but arm can be turned out of the way for wider work.

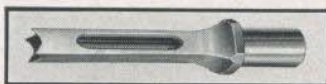
No. W1B MORTISING ATTACHMENT complete as shown below including chisel socket. Code ZALWA, wt. 10 lbs.

No. W1-4 MORTISING CHISEL SOCKET ONLY — for all Atlas drill presses. Code ZAMAY, wt. 3 lbs.

No. W1F MORTISING HOLD-DOWN AND FENCE ATTACHMENT ONLY. ZALEY, wt 8 lbs.



MORTISING CHISELS



Have superior cutting qualities, long life. Made of select high-carbon steel, carefully heat-treated.

No.	Size	Depth of Mortise	Weight	Code
MC-25	1/4" x 1/4"	1 7/8"	1 1/2 oz.	ZIGOG
MC-37	3/8" x 3/8"	2 1/2"	2 oz.	ZIGUH
MC-50	1/2" x 1/2"	3 3/4"	3 oz.	ZIGYJ

MORTISING CHISEL BITS



Held in drill press chuck — no adapters needed. Heat-treated alloy steel.

No.	Size	Diameter Shank	Weight	Code
MB-25	1/4"	3/16"	1/2 oz.	ZIHAD
MB-37	3/8"	19/64"	1 oz.	ZIHDA
MB-50	1/2"	19/64"	2 oz.	ZIHEF

DRUM SANDER



Saves you time and work on fine wood and metal finishing. Abrasive sleeve is changeable. Attached with W6-6A adapter listed below.

No. W6A DRUM SANDER — 2 3/8", 3" high — complete with one medium garnet abrasive sleeve. ZAKWE. Wt. 2 lbs.

No. W6-6A SPINDLE ADAPTER for drum sander. ZALUC. Wt. 7 oz.

No. W6-2A Six ALOXITE abrasive sleeves for metal. ZALOB, 8 oz.

No. W6-2C Six COARSE GARNET abrasive sleeves. ZALIZ, 6 oz.

No. W6-2F Six FINE GARNET abrasive sleeves. ZAKZO, 4 oz.

No. W6-2M Six MEDIUM GARNET abrasive sleeves. ZALBO, 4 oz.

LAMP



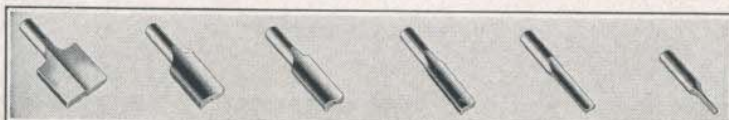
For Atlas and almost any make drill press. Has 15-inch flexible cable, universal mounting bracket with clamp screws. Satin-chrome finish, "push-through" switch.

No. W38 DRILL PRESS LAMP with mounting bracket, 6 ft. rubber cord, switch, plug. ZAFUV. Wt. 2 lbs.

ROUTER BITS



No. R-12 3/4" Carving ZIPOP	No. R-10 1/2" Carving ZIPME	No. R-6 1/2" Dovetailing ZIOXY	No. R-5 3/8" Dovetailing ZINUP	No. R-4 1/4" Dovetailing ZINON
--	--	---	---	---



No. R-9 1" Mortising ZIPLA	No. R-8 3/8" Mortising ZIPEM	No. R-7 1/2" Mortising ZIPAL	No. R-3 3/8" Mortising ZINNO	No. R-2 1/4" Mortising ZINLE	No. R-1 1/8" Mortising ZINKA
---	---	---	---	---	---

Complete set equips your drill press for accurate, fast work on carving, inlaying, round-end mortising, dovetailing, reeding, round edging, boring, and general routing. Bits are alloy steel, ready-sharpened to shape. Shanks are 5/16" in diameter. Held in drill press with No. W31 adapter.

No. R-13 ROUTER BITS — a complete set of 11 bits as illustrated. ZIPPO. Wt. 2 lbs.

ROUTER BIT ADAPTER

Fits drill press spindle in place of Jacobs Chuck. 5/16" hole.

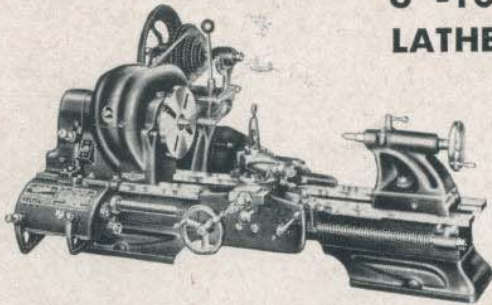
No. W31. ZANEB. Weight 8 oz.



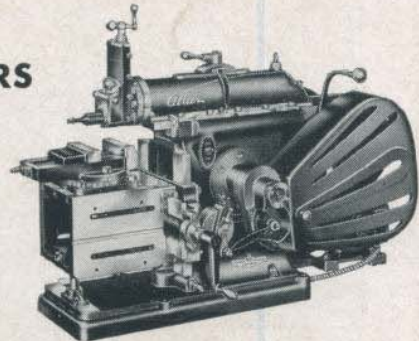
THE *Atlas* 4 TOOL TEAM

FOR SMALL PARTS MACHINING

6"-10"
LATHES



7"
SHAPERS



MILLING
MACHINES



DRILL PRESSES



Whatever your use and need for machine tools, there are outstanding values for you in the complete Atlas line — backed by 36 years of precision production experience.

Easy to set up and operate . . . rugged, accurate and efficient . . . Atlas lathes, drill presses, milling machines and shapers have long been outstanding favorites

throughout the world in almost every type of shop in every type of enterprise. Full use of all the latest technological advances in materials, plus unique Atlas-developed production methods, combine to bring these precision tools to you at low cost. Ask your Atlas distributor for complete specifications and prices on the tools that interest you.

