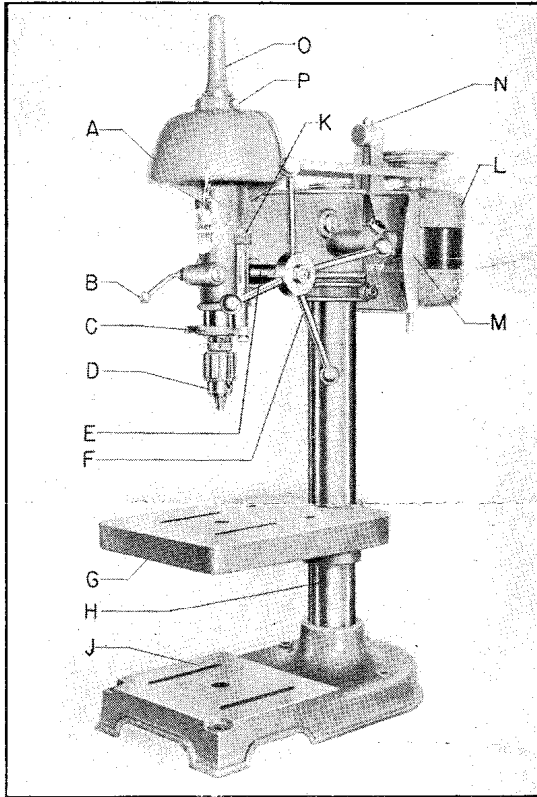


# "900" SERIES DRILL PRESSES

PLEASE NOTE: There will be a minimum invoice charge of 50 cents on all orders under that amount.

S/N P1040



## NOMENCLATURE

- A—Spindle Pulley Housing
- B—Quill Lock Handle
- C—Depth Gauge Stop Collar
- D—Jacobs Key Chuck 0" to 1/2"
- E—Feed Pinion
- F—Feed Lever
- G—10" x 12 1/2" Ground Table
- H—2 3/4" Ground Steel Column
- J—Base 9" x 10" Ground Working Surface
- K—Depth Gauge Stop Nuts
- L—SAB-3 1/3 H. P. Motor (Accessory)
- M—Adjustable Motor Base
- N—Low Speed Attachment Boss
- O—Spindle Cap
- P—Pulley Bearing Lock Screw and Nut

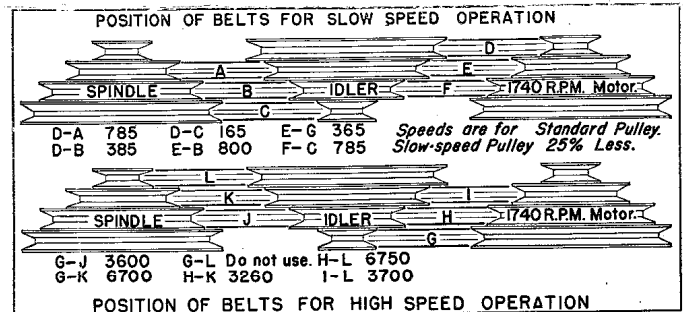
## GENERAL INSTRUCTIONS

All 900 Series Drill Presses with the exception of the Multiple Spindle Models are set-up and adjusted prior to shipment. Motor requirements will be met with a 1/3 H.P. 1740 RPM Motor which will be found satisfactory for all general work. Spindle speeds obtained with this motor and the standard pulley are 600 RPM, 1250 RPM, 2440 RPM and 5000 RPM. When the slow speed pulley is used on the drill press, spindle speeds are reduced to the following: 480, 940, 1300 and 2900 RPM.

### 9D113 SLO-SPEED ATTACHMENT

Still further speed control can be obtained through the use of the 9D113 Slo-Speed attachment. The speeds available with this attachment are shown in the sketch at right. To assemble the 9D113 attachment to the drill press first remove the standard VB42 belt by loosening the two setscrews and lock nuts (12-13 on diagram on page 2) and remove the upper pulley bearing retainer #35 from the head casting. The belt can now be worked through the hole surrounding the spindle. Replace the original belt with one of the VB26 belts supplied with 9D113. Insert the pulley support screw, first removing one of the lock nuts #7, into the hole provided in the motor base. The idler pulley is placed between the motor base and the spindle pulley. If the drill press is to be used mostly for slow speed operations, place the VB26 belt between the idler pulley and motor pulley into position first, then place the second belt between the idler and the spindle pulley. However, if the machine is to be used for speeds higher than those available with the belts placed as above, reverse the procedure by placing the belt between the idler pulley and the spindle pulley into position first, following it with the belt between the idler and motor pulley.

Belt tension between the idler and motor pulley is controlled by the two lock nuts #7. The tension on the other is controlled by sliding the motor bracket into or out of the head casting and locking it in the desired position. When the belts are in the high speed position DO NOT USE POSITION G-L as shown in the chart at right. The high speed developed with the belts in this position is not necessary for any operation performed on this machine and may also prove detrimental to bearing life.



## LUBRICATION

The drill press spindle and pulley bearing are packed with sufficient lubricant to last for one year of normal operation. Lubricate the pulley spline and the splined spindle with good lubricating oil applied through the oil cup on top of the spindle cap. All other moving parts such as feed pinion, return spring, and lock plugs will function better if kept well lubricated.

## CHUCKS AND ADAPTERS

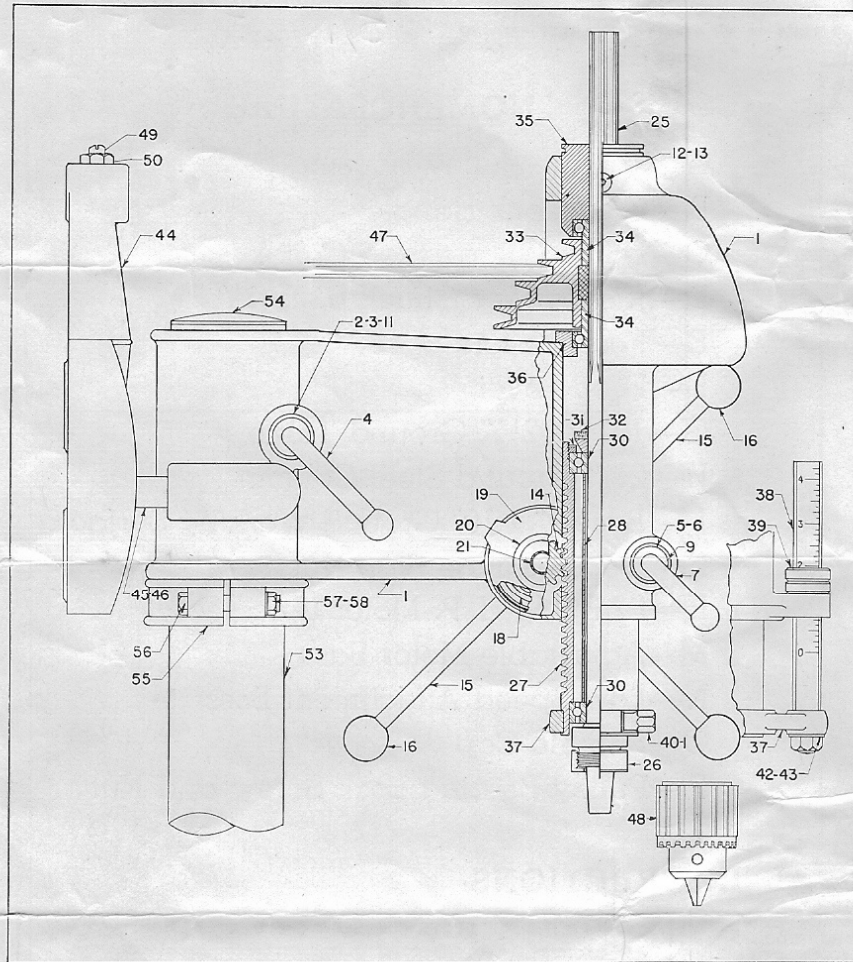
The No. 6A Jacobs Chuck supplied with the drill press can be removed and the No. 9MT1 Adapter attached to the spindle in its place permitting the use of No. 1-Morse Taper shank tools. To remove the chuck the Knurled Nut directly above it is screwed down on the chuck forcing it off the taper. When the 9MT1 Adapter is used the nut must be screwed up on the spindle prior to putting the adapter in place. If this is not done it may be found difficult to remove the adapter. However, when using the 7D11 Collet Chuck or the 9D5 Adapter the Knurled Nut is placed over the adapter or chuck after it is put on the spindle. In the case of the latter items the nut secures them to the spindle assuring their remaining tight despite the side thrust developed through their use, whereas the 9MT1 Adapter is subjected to a vertical thrust only which tends to increase its hold on the spindle without additional mechanical help.

# Walker-Turner Company, Inc.

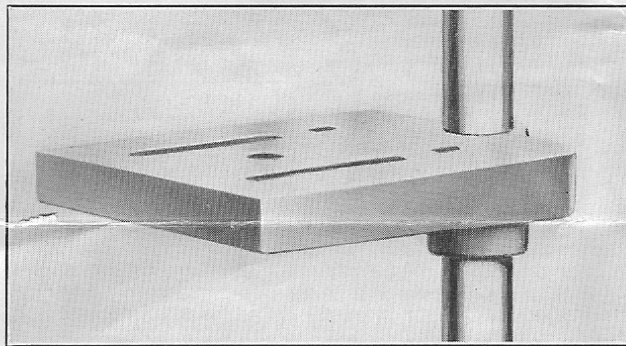
PLAINFIELD

New Jersey, U.S.A.

## PARTS LISTING

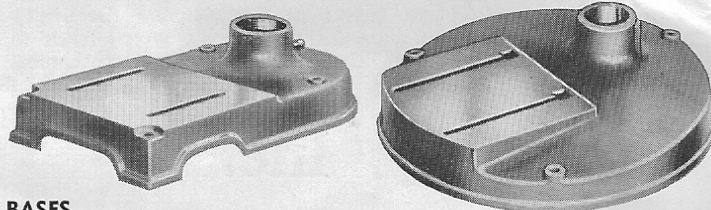


## STANDARD TABLE



## PARTS LISTING

Key No.	Part No.	Description
9D125	9D125A	STANDARD TABLE ASSEMBLY
7D65	7D65	Table Only
7D30	7D30	Lock Stud
7D127	7D127	Lock Handle
Comm.	Comm.	Lock Key
"	"	1/4"-20 x 7/8" Hex Bolt
"	"	1/4" I.D. Flat Washer



BASES

Key No.	Part No.	Description
9D13X	9D13X	HEAD ASSEMBLY WITH CHUCK
		Includes 9D13, 9D15, 9D16, 9D18, 9D19, 9D18X, 9D38 6A, VB42
9D13	9D13	HEAD CASTING COMPLETE
1	9D13A	Head Casting only
2	9D12D	Head Locking Block
3	9D12C	Head Locking Block
4	9D12B	Lock Handle (Long)
5	9D54	Quill Locking Block
6	9D54A	Quill Locking Block
7	9D13C	Lock Handle
9	Comm.	3/8" I. D. Flat Washer
*	"	1/2"-13 x 1" Hex Bolt
11	"	1/2" I. D. Flat Washer
12	"	5/16"-18 x 7/8" Hds. Set Screw (2 used)
13	"	5/16"-18 Hex Nut (2 used)
9D15	9D15	FEED PINION & RETURN SPRING
14	9D15A	Feed Pinion
15	9D118	Feed Wheel Handles
16	9D122	Handle Knobs
*	9D117	Feed Wheel Hub
*	9D15C	Lock Pin
18	9D15E	Return Spring
19	9D15F	Return Spring Housing
20	5BN20C	Washer
21	Comm.	5/16"-18 x 1/2" Hex Bolt
*	"	5/8"-16 Hex Nut
*	9D18	SPINDLE CAP
9D19	9D19	QUILL & SPINDLE ASSEMBLY
25	9D18C	Spindle
26	9D36H	Adapter Nut
27	9D19A	Quill
28	9D19B	Bearing Spacer
30	9D19E	Ball Bearing (2 used)
31	9D19F	Adjusting Ring
32	9D19G	Bearing Collar
9D18X	9D18X	PULLEY ASSEMBLY
33	9D18A	Pulley only
34	9D18B	Ball Bearing (2 used)
35	9D18E	Upper Bearing Retainer
36	9D19H	Lower Bearing Retainer
9D38	9D38	DEPTH GAUGE ASSEMBLY
37	9D38A	Depth Gauge Collar
38	9D79	Depth Gauge
39	9D73	Knurled Stop Nut (2 used)
40	9D47	Special 1/4"-20 Hex Nut
41	Comm.	1/4"-20 x 1 3/4" Hex Bolt
42	"	3/4"-16 Hex Jam Nut
43	"	3/8" I.D. Lock Washer
*	"	1/4" I.D. Flat Washer

Key No.	Part No.	Description
9D111	9D111	MOTOR BRACKET
44	9D111A	Table Only
45	9D11B	Table Rods (2 used)
46	Comm.	5/16"-18 x 7/8" Sq. Hd. Set Screw (2 used)
*	"	3/8"-16 x 1 1/4" Sq. Hd. Bolt with Nut & Washer (4 used)
47	VB42	42" V BELT
48	6-A	0" TO 1/2" JACOBS CHUCK WITH KEY
*	6-A-1	KEY ONLY
9D11	9D11	COLUMN (BENCH MODEL)
53	9D11B	Column Only
54	9D11A	Column Cap
9D21	9D21	FLOOR LENGTH COLUMN
*	9D21A	Column Only
*	9D11A	Column Cap
9D20	9D20	STOP COLLAR
55	9D20A	Collar Only
56	Comm.	3/8"-16 x 3 1/2" Hex Bolt
57	"	3/8"-16 Hex Nut
58	"	3/8" I.D. Flat Washer
*	9D32	TABLE
*	9D12	TABLE BRACKET
*	9D12A	Bracket with Stud
*	9D12S	Clamp Handle
*	MJ15	Taper Pin
*	Comm.	5/8"-18 Hex Nut
*	"	5/8" I.D. Lock Washer
*	"	5/8" I.D. Flat Washer (2 used)
*	"	1/2"-13 Hex Nut
9D10	9D10	BASE
		Consists of:
9D10A	9D10A	Base Casting
Comm.	Comm.	1/2"-13 x 1" Allen Screw (2 used)
9D40	9D40	ROUND BASE
		Consists of:
9D40A	9D40A	Base
Comm.	Comm.	1/2"-13 x 1" Allen Screw (2 used)

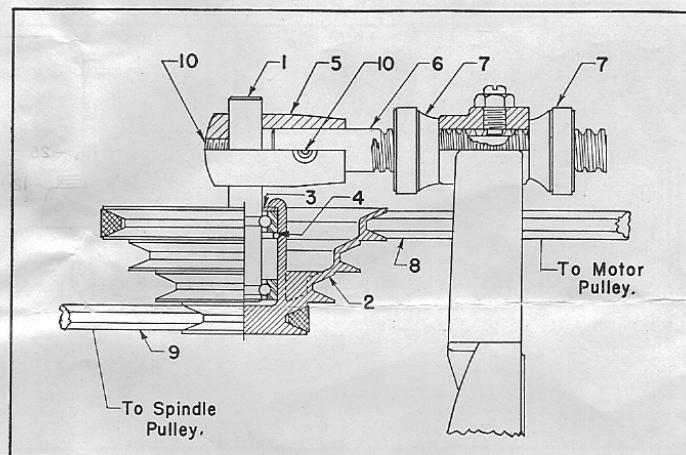
\* Not Illustrated.



## SLOW SPEED PULLEY

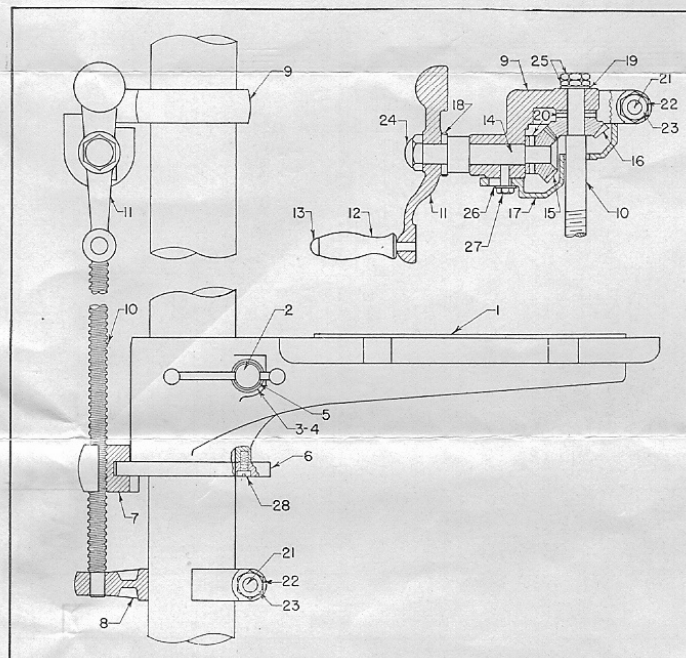
### PARTS LISTING

Key No.	Part No.	Description
	<b>9D113</b>	<b>SLOW SPEED ATTACHMENT</b>
1	7D113A	Pulley Assembly (Includes Key Nos. 1, 2, 3 & 4)
5	7D112	Pulley Bracket
6	7D114	Adjusting Screw
7	7D124	Adjusting Nut (2 used) .....
8	VB26	26" V Belt
9	VB26	26" V Belt
10	Comm.	5/16"-18 x 3/8" Allen Screw (2 used) .....



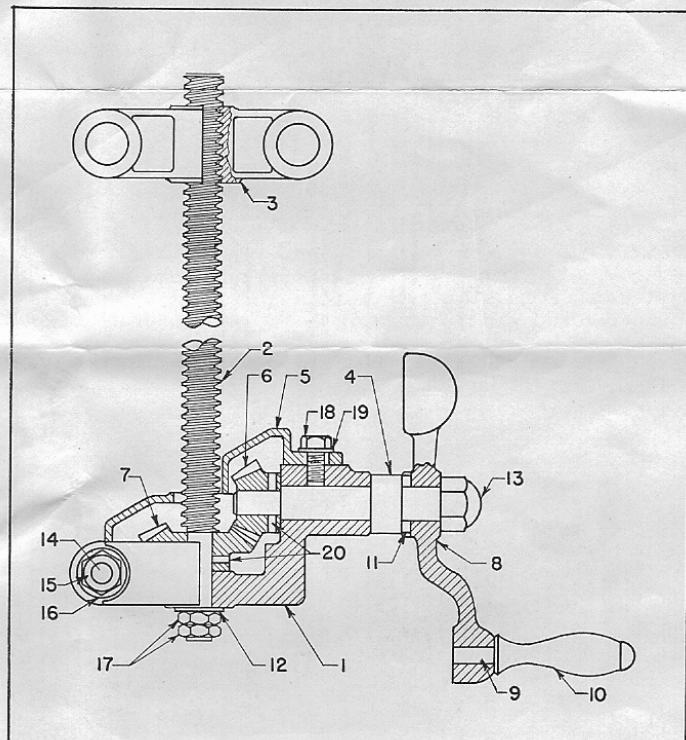
### PARTS LISTING

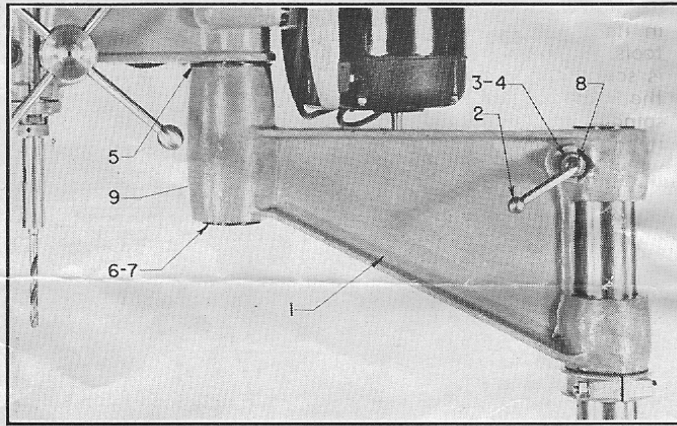
Key No.	Part No.	Description
	<b>9D65N</b>	<b>PRODUCTION TABLE</b>
1	9D65	Production Table
2	9BN36B	Lock Handle
3	9ET7	Lock Block
4	9ET8	Lock Stud
5	Comm.	1/2" I.D. Flat Washer
	<b>9D66</b>	<b>TABLE RAISING MECHANISM</b>
6	9ET4	Table Flange
7	9ET5	Table Adjusting Nut
8	9SM21	Screw Bracket
9	9D76A	Gear Bracket
10	9ET9	Raising & Lowering Screw
11	9DS77	Hand Crank (Includes Key Nos. 12 & 13)
14	9D78	Crank Shaft
15	9S26	Pinion
16	9S30	Gear
17	9D85	Gear Guard
18	9D15C	Pin
19	9TA14A	Key Washer
20	Comm.	5/32" x 1" Groove Pin (2 used) .....
21	"	1/2"-13 x 2 3/4" Hex Bolt (2 used) .....
22	"	1/2"-13 Hex Nut (2 used) .....
23	"	1/2" I.D. Flat Washer (2 used) .....
24	"	5/8"-18 Acorn Nut
25	"	1/2"-24 Hex Jam Nut (2 used) .....
26	"	5/16" I.D. Flat Washer
27	"	5/16"-18 x 3/4" Hex Bolt
28	"	5/16"-24 x 3/4" Fillister Hd. Bolt (4 used) .....



### PARTS LISTING

Key No.	Part No.	Description
	<b>9D75-9D76</b>	<b>HEAD RAISING MECHANISM</b>
1	9D76A	Gear Bracket
2	9D84	Screw
3	9D77	Nut Bracket
4	9D78	Shaft
5	9D85	Geared Guard
6	9S26	Pinion
7	9S30	Gear
8	9DS77	Crank (Includes Key Nos. 8, 9 & 10)
11	9D15C	Pin
12	9TA14A	Key Washer
13	Comm.	5/8"-18 Acorn Nut
14	"	1/2"-13 x 2 3/4" Hex Bolt
15	"	1/2"-13 Hex Nut
16	"	1/2" I.D. Flat Washer
17	"	1/2"-24 Hex Jam Nut (2 used) .....
18	"	5/16"-18 x 3/4" Hex Bolt
19	"	5/16" I.D. Flat Washer
20	"	5/32" x 1" Groove Pin



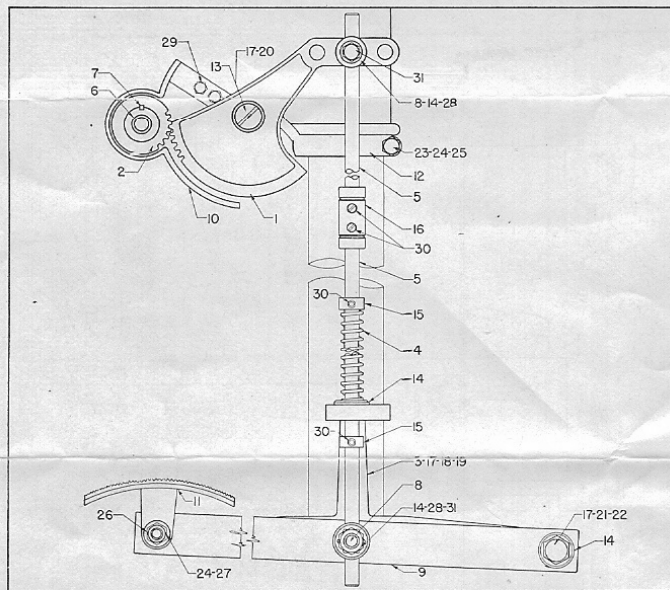


## PARTS LISTING

Key No.	Part No.	Description
	<b>9D6</b>	<b>EXTENSION ARM COMPLETE</b>
1	9D105	Arm Only
2	9D12B	Lock Handle
3	9D12C	Lock Block
4	9D12D	Lock Block
5	9D110	Bakelite Washer
6	9D109	Column
7	9D11A	Column Cap
8	Comm.	1/2" I.D. Flat Washer
9	"	1/2"-13 x 3/4" Allen Screw (2 used) ea.

## PARTS LISTING

Key No.	Part No.	Description
	<b>9D80N</b>	<b>FOOT FEED MECHANISM</b>
1	9D88R	Gear Control Lever
2	9D89	Feed Lever Gear
3	9D104	Foot Pedal Bracket
4	9D91	Tension Spring
5	9D92	Foot Lever Rod (2 used) ea.
6	9D94	Drill Press Pinion
7	9D94K	Sliding Key
8	9D103	Foot Lever Swivel (2 used) ea.
9	9D96	Foot Lever Arm
10	9D97N	Gear Guard
11	9D102	Foot Pad
12	9DP104	Control Lever Bracket
13	9D123	Control Lever Shaft
14	GR10	Tapered Washer (4 used) ea.
15	9D101	Collar
16	L251X	Coupling
17	Comm.	1/2" I.D. Flat Washer (2 used) ea.
18	"	1/2"-13 Hex Nut
19	"	1/2"-13 x 3" Hex Bolt
20	"	1/2"-20 Hex Nut
21	"	1/2"-13 Hex Jam Nut (2 used) ea.
22	"	1/2"-13 x 2" Hex Bolt
23	"	3/8"-16 x 3 1/2" Hex Bolt
24	"	3/8"-16 Hex Nut (2 used) ea.
25	"	3/8" I.D. Flat Washer
26	"	3/8" I.D. Lock Washer
27	"	3/8"-16 x 1 1/2" Hex Bolt
28	"	1/2"-24 Hex Jam Nut (4 used) ea.
29	"	5/16"-18 x 5/8" Hex Bolt (2 used) ea.
30	"	1/4"-20 x 1/4" Hdles. Set Screw (6 used) ea.
31	"	3/8"-16 x 3/4" Hex Bolt (2 used) ea.



## TWO AND FOUR SPINDLE DRILL PRESSES

For prices and descriptions of parts other than those listed below other section of this sheet. For Head Assembly see 9D13X and 9 Head Raising Mechanism.

## PARTS LISTING

Part No.	Description
	<b>D902 TWO-SPINDLE MODEL</b>
9D115	Cast Iron Table only with Bolts
9D116	Column Bracket with Screws (2 used) ea.
92	Steel Bench Complete

Part No.	Description
	<b>D904 FOUR-SPINDLE MODEL</b>
9D115L	Cast Iron Table only with Bolts
9D116	Column Bracket with Screws (4 used) ea.
94	Steel Bench Complete

Part No.	Description
	<b>BELT GUARD</b>
9D755	Belt Guard
9D74	Guard Hinge Pin (2 used) ea.
Comm.	5/16"-18 Hex Nut (2 used) ea.

