



ROCKWELL
MANUFACTURING COMPANY
PITTSBURGH 8, PENNSYLVANIA



DATED 10-30-59

WALKER-TURNER 15" DRILL PRESS

6" travel

1300 SERIES

Old style

SET UP INSTRUCTIONS

The Walker-Turner 1300 series drill press is packed set-up with the exception of the belt guard and motor. In the case of multiple spindle models, the legs are not attached to the table but are packed separately.

MOTORS: Motor installation instructions are as follows:

- a. Loosen the motor-plate lock screw and remove the motor plate from the head.
- b. Attach the motor to the plate. Set the motor shaft so that it will point upward when installed on the head.
- c. Install the motor plate on the head.
- d. Place key and motor pulley on the motor shaft, with the smallest pulley groove down.
- e. Place the single "V" belt on the uppermost grooves of the spindle and motor pulleys. Align the belt and pulley grooves, using a straightedge to check position, by moving the motor pulley up or down, as necessary. Tighten the pulley set screw. Check vertical alignment of the motor shaft to be sure there is no twist in the belt. If necessary, loosen the motor mounting bolts and shift the position of the motor for best belt alignment.
- f. With the motor-plate lock screw loosened, pull the motor plate outward to tighten the "V" belt; then tighten lock screw. Press thumb on belt, midway between pulleys. The belt should depress approximately one-half inch, if it has been tightened correctly.

BELT GUARD: Install the Belt Guard as follows:

- a. Position the guard over the belt, with its front end inside the head. Attach the front end with the two screws, lock washers, and nuts, tightened only finger tight.
- b. Place the switch cord under the clip on the guard, align the holes, and install the remaining two screws.
- c. Tighten the two screws on the front end.

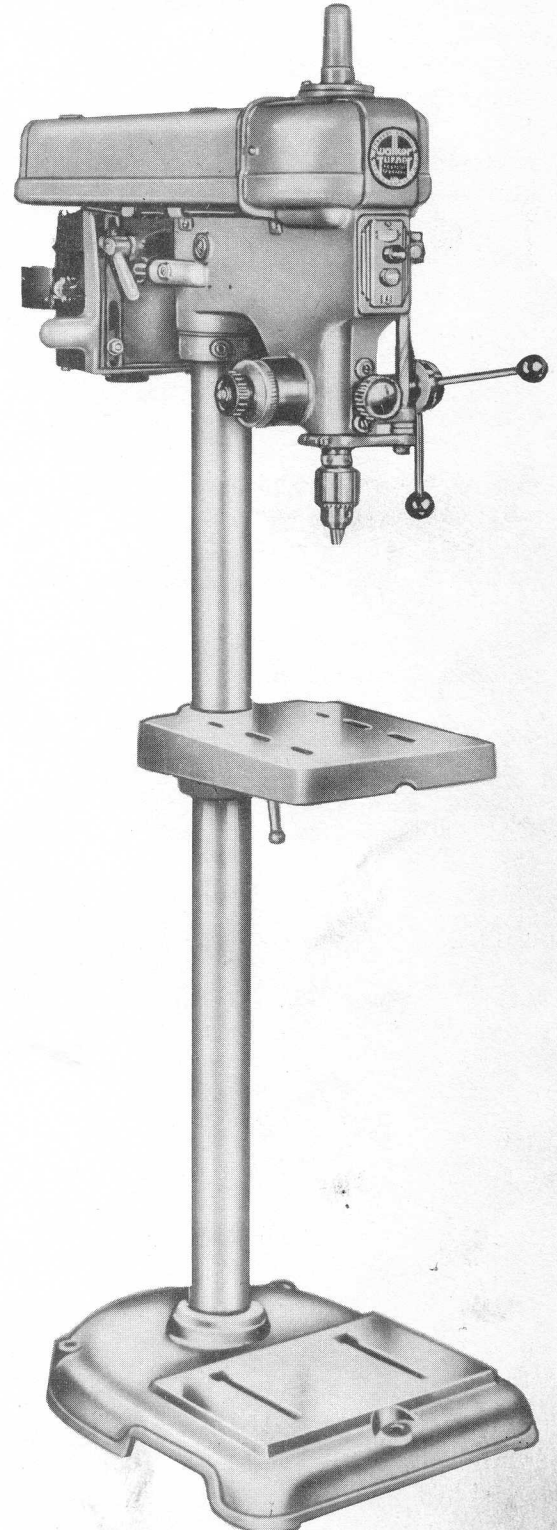


FIGURE 1

RETURN SPRING: To adjust spring tension, slowly turn the feed handle to lower the quill and spindle. Hold the spindle with left hand. Continue to turn handle until quill is disengaged from feed pinion. **DO NOT LET GO OF HANDLE.** Place quill and spindle on table and, using both hands, turn feed handle in same direction to tighten spring or in opposite direction to loosen spring. Holding handle after adjusting spring tension, insert quill and spindle into head and engage quill with feed pinion. Raise spindle slowly while rotating it slightly to be sure splines on spindle engage splines on pulley.

MAINTENANCE

BELT REPLACEMENT: The following outlines the procedure for replacement of the standard single belt.

- a. Raise the head as high as possible on the column. Remove three screws and lock washers, and remove the pulley upper bearing holder. Do not lose the bearing spring washer that rests on top of the bearing.
- b. Lower the quill and spindle until the top of the spindle is slightly above the top of the pulley upper bearing.
- c. Loosen the motor-plate lock screw and push the motor and plate inward.
- d. Remove the belt from the motor and spindle pulleys.
- e. Place new belt on the pulleys and in the grooves for desired spindle speed.
- f. Pull the motor and plate outward to tightened belt. Tighten motor-plate lock screw. The belt is properly tightened when a 1/2-inch of slack is noted when the belt is pressed midway between the pulleys.

- g. Place bearing spring washer on top of pulley bearing and install the bearing holder. Tighten the three screws.

CHUCK REMOVAL:

- a. Attach the spanner wrench to the flange on the lower end of the spindle, just above the spindle nut, to keep the spindle from turning.
- b. Using the pointed end of the chuck-key handle in the hole of the spindle nut, turn the spindle nut down against the chuck. A slight tug is required to break the chuck free.

LUBRICATION:

- a. Spindle - medium machine oil in ball oiler - one or two drops daily.
- b. Head raising mechanism (some models) - light cup grease on screw; light machine oil on gears.
- c. Column and base - wipe on light machine oil.
- d. Motor - If the motor is equipped with sealed for life bearings no lubrication is necessary.

If the motor is not equipped with sealed for life bearings lubricate as follows: Grease in bearing housings, once every six months. Remove set screws from holes in housings to insert grease.

DO NOT OVERLUBRICATE. DO NOT USE OIL IN MOTOR.

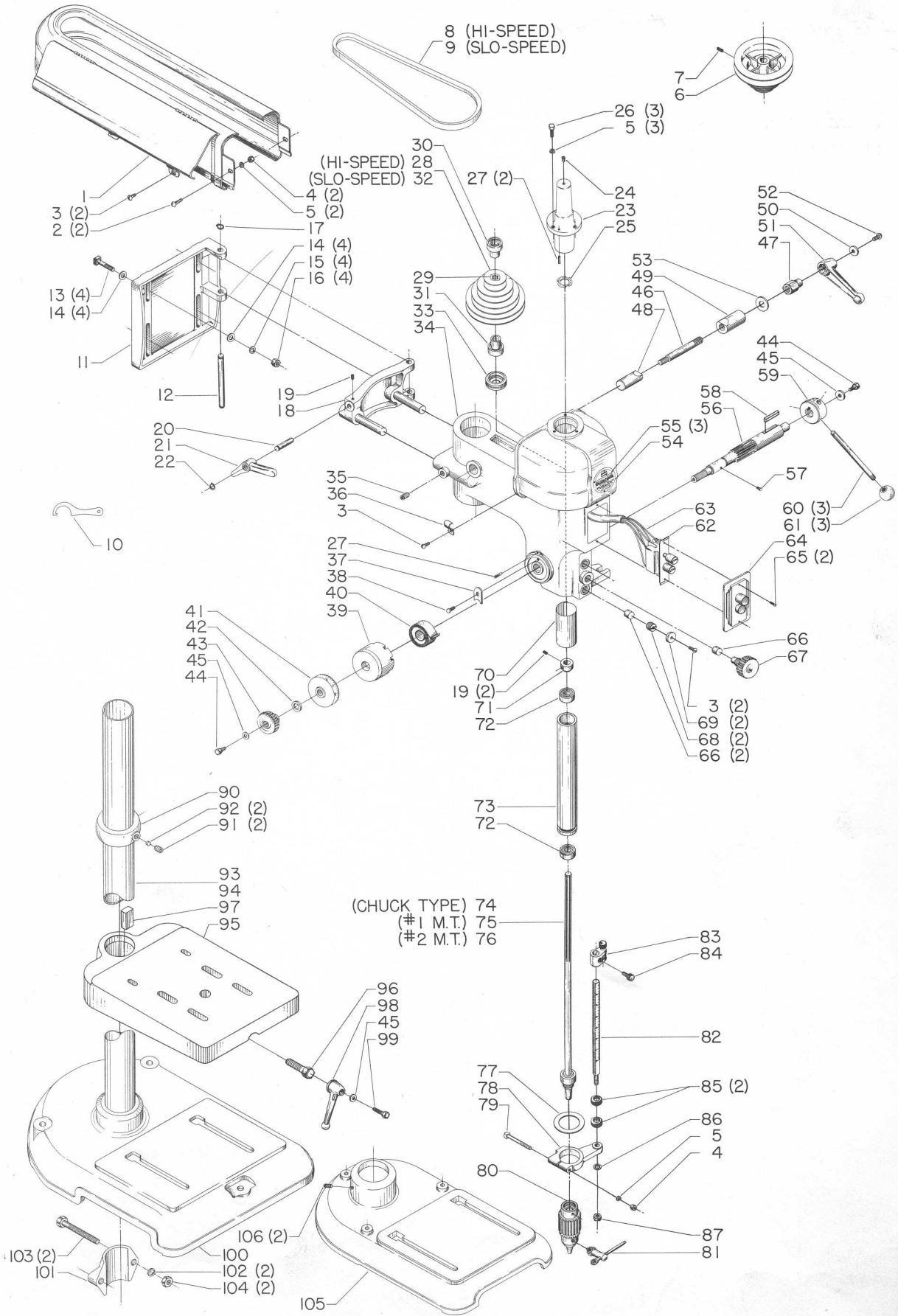


FIGURE 2

Replacement Parts

Ref. No.	Part No.	Description	Ref. No.	Part No.	Description
1	Cat. #13C44 65-844	Belt Guard, Incl; #65-844	53	SP-1622	21/32 x 1 5/16 x 12 Gage Washer
2	SP-504	1/4-20 x 3/4" Rd. Hd. Scr.	54	380-6-2	Name Plate
3	SP-509	1/4-20 x 1/2" Rd. Hd. Scr.	55	SP-2250	#4 x 3/16" Drive Screw
4	SP-1034	1/4"-20 Hex. Nut	56	13-2	Pinion
5	SP-1702	1/4" Lockwasher	57	212-4	Spring Pin
6	Cat. #344C9	Motor Pulley, Incl;	58	SP-2696	3/16 x 3/16 x 5/16" Key
7	SP-202	1/4-20 x 1/2" Soc. Hd. Set Scr.	59	12-15	Hub
8	Cat. #351-47	V-Belt (Hi-Speed)	60	211-7	Spoke
9	Cat. #351-48	V-Belt (Slo-Speed)	61	365-8	Knob
10	Cat. #492-2	Spanner Wrench	62	SP-4882	Switch
3	SP-509	1/4-20 x 1/2" Rd. Hd. Scr.	63	SP-4888-S	Cable Assy.
4	SP-1034	1/4"-20 Hex. Nut	64	SP-4880	Switch Cover
5	SP-1702	1/4" Lockwasher	65	SP-553	#6-32 x 1/2" Rd. Hd. Screw
11	13-18	Motor Plate	66	234-6	Plug
12	293-7	Hinge Pin	67	211A29	Hand Knob w/ Stud
13	SP-2379	3/8-16 x 1 1/4" Sq. Hd. Bolt	68	204-11	Quill Adj. Screw
14	SP-1615	13/32 x 13/16 x 1/16" Washer	69	240-49	Washer
15	SP-1709	3/8" Lockwasher	70	13-39	Sleeve
16	SP-5900	3/8"-16 Hex. Nut	71	254A34	Collar, Incl;
17	SP-7018	Snap Ring	19	SP-208	1/4-20 x 1/4" Soc. Hd. Set Scr.
18	13A19	Motor Mounting Bracket	72	370-10-1	Bearing
19	SP-208	1/4-20 x 1/4" Soc. Hd. Set Scr.	73	13-3	Quill
20	293-8	Pin	74	13M6	Spindle (Chuck Type)
21	369-1	Handle	75	13M11	Spindle (#1M. T.)
22	SP-7418	Snap Ring	76	13M12	Spindle (#2 M. T.)
23	12A7	Top Bearing Retainer, Incl;	77	904-07-060-3774	Gasket
24	SP-2486	Oiler	78	13-10-1	Support Collar
25	SP-7351	Spring Washer	79	401-02-112-5002	1/4-20 x 2 1/4" Spec. Sq. Hd. Scr.
26	SP-626	1/4-20 x 3/4" Hex. Hd. Cap Scr.	80	Cat. #15-830	Chuck, Incl;
27	SP-6861	3/16 x 5/8" Groove Pin	81	DP-597	Key
28	344C1	Hi-Speed Pulley, Incl;	82	13-17	Depth Gauge Rod
29	12-8	Insert	83	13A55	Depth Gauge Stop
30	370-1	Bearing	84	206-8	Hand Screw
31	370-2	Bearing	85	223-3	Knurled Nut
32	344C2	Slo-Speed Pulley, Incl;	86	SP-1789	3/8" Int. Tooth Lockwasher
29	12-8	Insert	87	SP-5433	3/8"-16 Hex. Jam Nut
30	370-1	Bearing	90	12A16	Support, Incl;
31	370-2	Bearing	91	SP-210	1/2-13 x 1/2" Soc. Hd. Set Scr.
33	12-9	Bearing Retainer	92	234-2	Plug
34	13-1	Head	93	Cat. #14-839	Column, 2 3/4 x 31"
35	SP-6229	1/2-20 x 1/2" Soc. Hd. Set Scr.	94	Cat. #15-827	Column, 2 3/4 x 62"
36	SP-4889	Cable Clamp	95	Cat. #12C29	Table, Incl;
37	13-67	Pinion Retainer	96	204-4	Stud
38	SP-8015	1/4-20 x 1/2" Soc. Hd. Cap Scr.	97	309-1	Key
39	11A14-1	Spring Housing, Incl;	98	362-1-1	Handle
40	311-4	Spring	45	SP-1620	11/32 x 11/16 x 1/16" Washer
41	13-50	Dial	99	SP-5769	5/16-24 x 1" Hex. Hd. Cap Scr.
42	244-7	Key Washer	100	DP-287-R	Base (Floor Model), Incl;
43	365-1-4	Hand Knob	101	DP-288	Clamp
44	SP-605	5/16-18 x 1/2" Hex. Hd. Cap Scr.	102	SP-1716	7/16" Lockwasher
45	SP-1620	11/32 x 11/16 x 1/16" Washer	103	SP-2300	7/16-14 x 3 1/2" Hex. Hd. Cap Scr.
46	214-24	Stud	104	SP-5437	7/16-14 Hex. Nut
47	225-6	Lock Nut	105	DP-567	Base (Bench Model)
48	230-3	Lock Plug	106	SP-1107	5/16-18 x 1/2" Soc. Hd. Set Scr.
49	231-8	Lock Plug	*	Cat. #13C3-1	#1 M. T. Spindle & Quill Assy.
50	240-87	Washer	*	Cat. #13C3-2	#2 M. T. Spindle & Quill Assy.
51	362-4	Handle	*	Cat. #13C3-6	Chuck Type Spindle & Quill Assy.
52	SP-512	5/16-18 x 1/2" Rd. Hd. Screw	*	Not Shown	