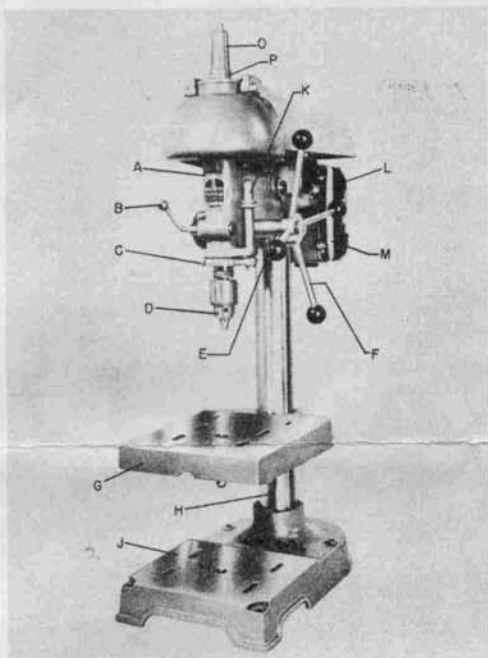


INSTRUCTION SHEET DP93

Effective 11-1-50. Subject to change without notice.

"900" SERIES DRILL PRESSES

Keep this in your files for future reference on accessories and service parts.



DESCRIPTION — TERMS

- 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 — KAB5E 1/2 H.P. Motor (Accessory)
- M — Adjustable Motor Base
- O — Spindle Cap
- P — Belt Guard Attaches Here

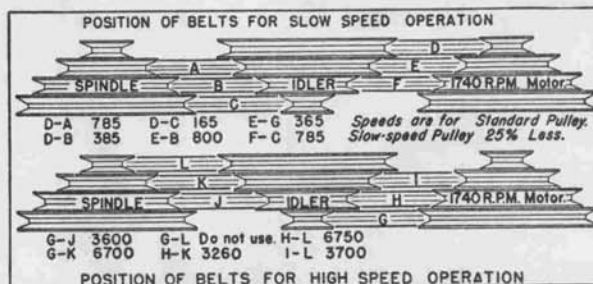
GENERAL INSTRUCTIONS

Motor requirements will be met with a 1/2 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 slower (larger) 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 belt by taking out the three 1/4" - 20 x 3/4" cap screws (see key #27, 28, page 2), and lift off spindle cap (key #25). With the spindle fed down, the belt can now be passed over the top of the pulley. 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 a few drops of 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 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 DIVISION

PLAINFIELD, NEW JERSEY, U.S.A.

• KEARNEY & TRECKER CORPORATION •

FORM 523-5M PRINTED IN U.S.A.

SERIES 900

PARTS LISTING

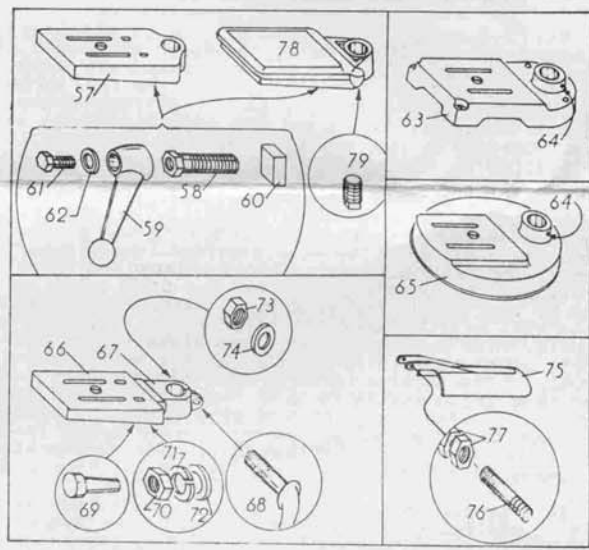
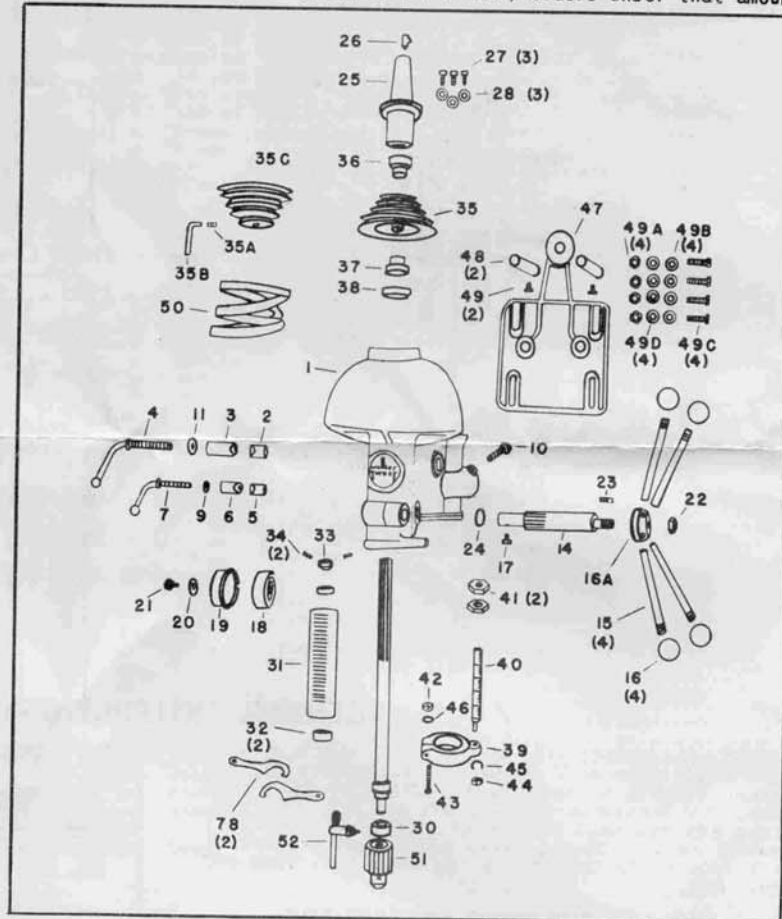
NOTE: These pages are for instruction and repair parts only. They are not packing slips and parts shown are not necessarily included with drills. See General Catalog at date of purchase.

In ordering parts, GIVE: (1) Serial Number (from Machine Name Plate).

(2) Part Number and Name from this listing.
And turn order over to DEALER to fill from warehouse or factory.

There is a minimum charge of \$1.00 on all factory orders under that amount.

Key No.	Part No.	Description
	9D13X	HEAD ASSEMBLY
	Consists of:	Complete.....
		Key Nos. 1 thru 52 on this page only (Specify "standard" or "larger-slower speed" head pulley)
	DDP1NXX	HEAD CASTING
	Consists of:	Complete.....
1	DDP1NN	Head Casting only.....
2	DDP 63	Head locking block (threaded).....
3	DDP 63A	Head Locking Block.....
4	DDP 50	Lock handle (Long).....
5	DDP 54A	Quill Locking Block (threaded).....
6	DDP 54	Quill Locking Block.....
7	RD12	Lock Handle.....
9	Comm.	3/8" I.D. x 3/4" x 1/16" Flat Washer.....
10	Comm.	1/2"-13 x 3/4" Hex Bolt.....
11	Comm.	1/2" I.D. Flat Washer.....
14	DDP8N	FEED PINION.....
	DDP 118X	HAND WHEEL ASSEMBLY.....
	Consists of:	Feed Wheel Handles (4 used).....ea.
15	DDP 118	Handle Knobs (4 used).....ea.
16	DDP 122	Feed Wheel Hub.....
16A	DDP 117N	Spring Catch Pin.....
17	DDP 43	
	DDP 16NX	SPRING and HOUSING ASSEMBLY.....
	Consists of:	Return Spring.....
18	DDP 16N	Return Spring Housing.. Washer.....
19	DDP 40N	5/16"-18 x 1/2" Hex Bolt.....
20	LBS 40	5/8"-18 Hex Jam Nut.....
21	Comm.	3/16" x 3/16" x 1/2" sq key
22	Comm.	7/8" x 1 1/8" x 1/32" Fibre Washer.....
23	RD 39	
24	RD 39	
	DDP-52-HX	SPINDLE CAP.....
	Consists of:	Spindle Cap only.....
25	DDP 52H	Gits Bros. Oil Cup.....
26	#316	1/4"-20 x 3/4" Hex Cap Screw (3 used).....ea.
27	Comm.	1/4" I.D. Lock Washer (3 used).....ea.
28	Comm.	
	DDP57XX	QUILL and SPINDLE ASSEMBLY.....
	Consists of:	Spindle (w/DDP57C collar).....
29	DDP 57X	Adapter Nut.....
30	HSD 13B	Quill.....
31	DDP 9N	Ball Bearing (2 used)ea.
32	70336AZ	Bearing Collar.....
33	DDP 55	1/4"-20 x 1/4" HH Set Screws (2 used).....
34	Comm.	
	DDP 6NX	PULLEY ASSEMBLY.....
	Consists of:	Pulley w/spline insert. 1/4"-20 x 1/2" Hollow Hd. Set-Screw.....
35	DDP 6N	1/4" - Allen Wrench
35A	PV 58N	Motor Pulley 5/8" Bore (same size as head pulley)
35B	DDP 59T	Ball Bearing (465861)...
36	DDP 59	Ball Bearing (70702)...
37	DDP 59	
38	DDP 153N	LOWER BEARING RETAINER.....
	DDP 61X	(LARGER-SLOWER) PULLEY ASSEMBLY.....
	Consists of:	Pulley with Spline Insert.....
36	DDP 59T	Ball Bearing (465861).....
37	DDP 59	Ball Bearing (70702).....
39	HSD 9	Depth Gauge Collar.....
40	DDP 79	Depth Gauge.....
41	DDP 73	Knurled Stop Nut (2 used).....ea.
42	Comm.	1/4"-20 Hex Nut.....
43	Comm.	1/4"-20 x 1 3/4" Hex Bolt.....
44	Comm.	3/8"-16 Hex Jam Nut.....
45	Comm.	3/8" I.D. Std. Lock Washer.....
46	Comm.	1/4" I.D. Std. Washer.....
	9D111 (DDP 11X)	MOTOR BRACKET.....
	Consists of:	Table only.....
47	DDP 111	Table Rods (2 used).....
48	DDP 14N	5/16"-18 x 3/4" Sq. Hd. Set Screw (2 used).....ea.
49	Comm.	3/8"-16 Hex Jam Nut (4 used)...
49A	Comm.	10/32" x 13/16" x 1/16" Flat Washer (4 used).....
49B	Comm.	3/8"-16 x 1 1/4" Sq. Hd. Bolt (4 used).....
49C	Comm.	3/8" Light Lock Washer (4 used)
49D	Comm.	
	Comm.	3/8"-18 x 1 1/4" Sq. Hd. Bolt with nut and Washer (4 used for motor).....ea.
50	VB 42	42" V Belt.....
51	6A	0-1/2" Jacobs Chuck with Key...
52	6A1	Key only.....

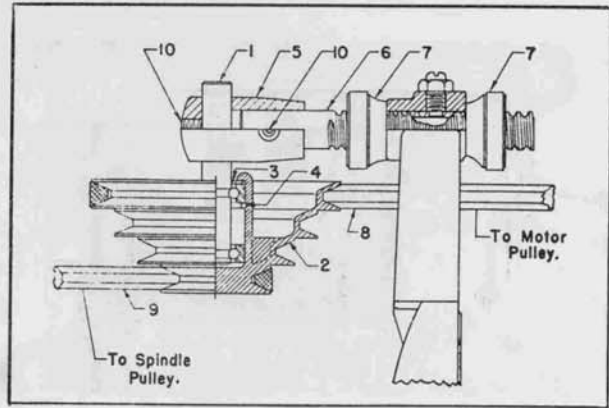


Key No.	Part No.	Description
53	9D11	COLUMN (Bench Model 30").....
53	9D21	COLUMN (Floor Model 60").....
55	DDP 62NX	COLUMN STOP COLLAR with Screws.....
56	Comm.	1/2"-13 x 5/8" H.H. Set Screw Flat Point (2 used).....ea.

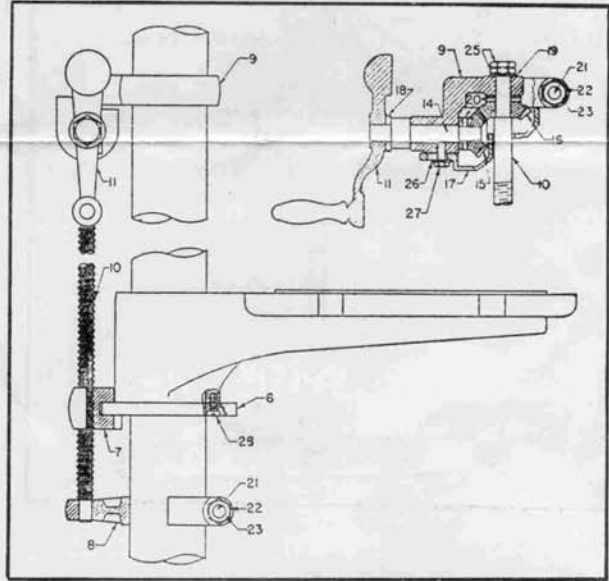
*Not illustrated
Note: Standard commercial (comm.) parts are usually available local from your machinery, hardware, or mill supply dealer.

(Continued on Page 3)

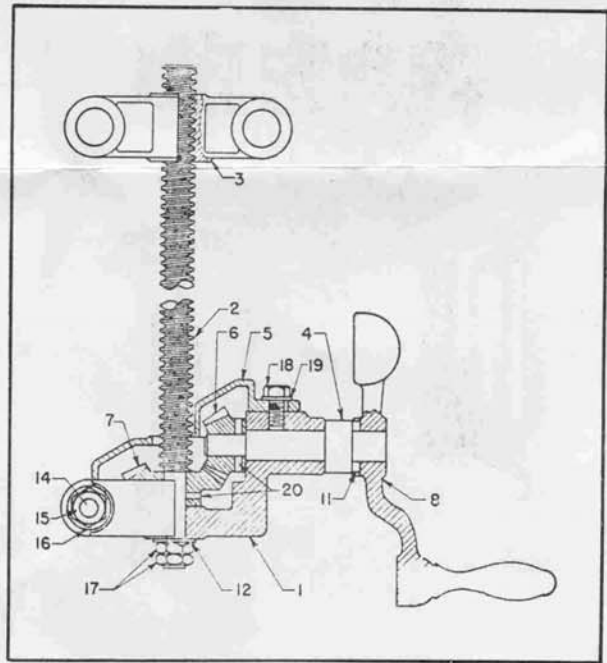
Key No.	Part No.	Description
	9D12-32	TILTING TABLE ASSEMBLY.....
	Consists of:	
66	DDP 3A	Table only.....
67	DDP 4N	Bracket with Stud (DP103A)....
68	DDP 50B	Clamp Handle.....
69	HSD 5B	Taper Pin.....
70	Comm.	5/8"-18 Hex Nut.....
71	Comm.	5/8" I.D. Lock Washer.....
72	Comm.	5/8" I.D. Flat Washer.....ea.
73	Comm.	1/2"-13 Hex Nut.....
74	Comm.	1/2" I.D. Flat Washer.....
63	9D10	BASE COMPLETE with Screws....
	(See Page 2)	
64	Comm.	1/2"-13 x 1" Allen Screw (2 used)
65	9D40	ROUND BASE COMPLETE with Screws
	(See Page 2)	
64	Comm.	1/2"-13 x 1" Allen Screw (2 used)...ea.
	9D125	STANDARD TABLE ASSEMBLY.....
	Consists of: (See Page 2)	
57	DDP125	Table only.....
58	DDP154	Lock Stud.....
59	CS 30	Lock Handle.....
60	DDP 127	Lock Key.....
61	Comm.	5/16"-24 x 7/8" Hex Bolt.....
62	Comm.	5/16" I.D. Flat Washer.....
	9D65N	PRODUCTION TABLE COMPLETE.....
	Consists of: (See Page 2)	
78	DDP 155 N	Production Table only.....
58	DDP 154	Stud.....ea.
59	CS 30	Lock Handle.....
60	DDP 127	Key.....
61	Comm.	5/16"-24 x 7/8" Hex Bolt.....
62	Comm.	5/16" I.D. Flat Washer.....
79	Comm.	1/2" Pipe Plug.....
	9D55	BELT GUARD.....
	(See Page 2)	
75	DDP 75	Belt Guard only.....
76	DDP 178	Hinge Pin (2 used).....ea.
77	Comm.	5/16"-18 Hex Nuts (4 used).....ea.
78	HSD 135	Spanner Wrench (2 used).....ea.
	PV 58 N	MOTOR PULLEY 5/8" BORE.....
	(Same size as head pulley)	
	9D113	SLOW SPEED ATTACHMENT.....
	Consists of: (Upper Right)	
1	DDP 6 SN	Pulley Assembly (includes Key Nos. 1-2-3-4)
5	DDP 112	Pulley Bracket.....
6	DDP 114	Adjusting Screw.....
7	HD 83	Adjusting Nut (2 used).....ea.
8	VB 26	26" V Belt.....
9	VB 26	26" V Belt.....
10	Comm.	5/16"-18 x 3/8" Allen Screw (2 used).....ea.
11	NB 107	Aligning Key Screw.....
12	Comm.	3/8"-24 Hex Nut.....
	9D66	TABLE RAISING MECHANISM.....
	Consists of: (Center Right)	
6	ET 4	Table Flange.....
7	ET 3	Table Adjusting Nut.....
8	SM 21	Adjusting Bracket.....
9	DDP 76H	Adjusting Gear Bracket.....
10	ET 9	Raising and Lowering Screw....
11	MBS 108	Hand Crank.....
14	DDP 78	Crank Shaft.....
15	DDP 82	Pinion.....
16	DDP 83	Gear.....
17	DDP 85	Gear Guard.....
18	Comm.	#1 3/16" x 5/8" Groove Pin....
19	HSD 20C	Key Washer.....
20	Comm.	5/32" x 1" Groove Pin (2 used).....ea.
21	Comm.	1/2"-13 x 2 3/4" Hex Bolt (2 used).....ea.
22	Comm.	1/2"-13 Hex Nut (2 used).....ea.
23	Comm.	1/2" I.D. Flat Washer (2 used).....ea.
25	Comm.	1/2"-24 Hex Jam Nut (2 used).....ea.
26	Comm.	3/8" I.D. Flat Washer.....ea.
27	Comm.	3/8"-16 x 3/4" Hex Bolt.....
28	Comm.	1/4"-20 x 3/4" Fil.Hd. Bolt (4 used).....ea.
*	Comm.	1/4" Drive Oiler Type #0C/ Figure #56....
	9D75-76	HEAD RAISING MECHANISM (Lower Right)
	Consists of:	
1	DDP 76	Adjusting Gear Bracket.....
2	DDP 84	Screw.....
3	DDP 77	Nut Bracket.....
4	DDP 78	Crank Shaft.....
5	DDP 85	Gear Guard.....
6	DDP 82	Pinion.....
7	DDP 83	Gear.....
8	MBS 108	Hand Crank.....
11	Comm.	#1-3/16" x 5/8" Groove Pin....
12	HSD 20C	Key Washer.....
14	Comm.	1/2"-13 x 2 3/4" Hex Bolt.....
15	Comm.	1/2"-13 Hex Nut.....
16	Comm.	1/2"-24 Hex Jam Nut (2 used) ea.
17	Comm.	1/2" I.D. Flat Washer.....
18	Comm.	3/8"-16 x 3/4" Hex Bolt.....
19	Comm.	3/8" I.D. Flat Washer.....
20	Comm.	5/32" x 1" Groove Pin.....
*	Comm.	1/4" Drive Oiler Type #0C/ Fig.#56



9D113



9D66

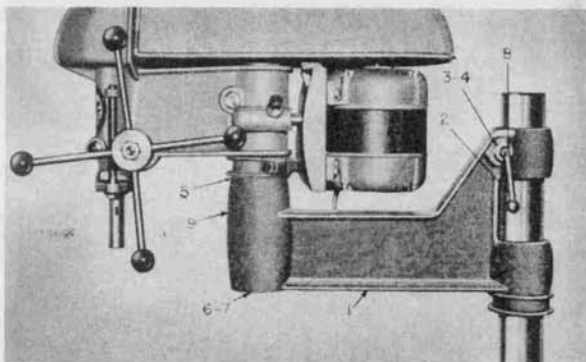


9D75-76

Note: Standard commercial (comm.) parts are usually available locally from your machinery, hardware, or mill supply dealer.

*Not illustrated

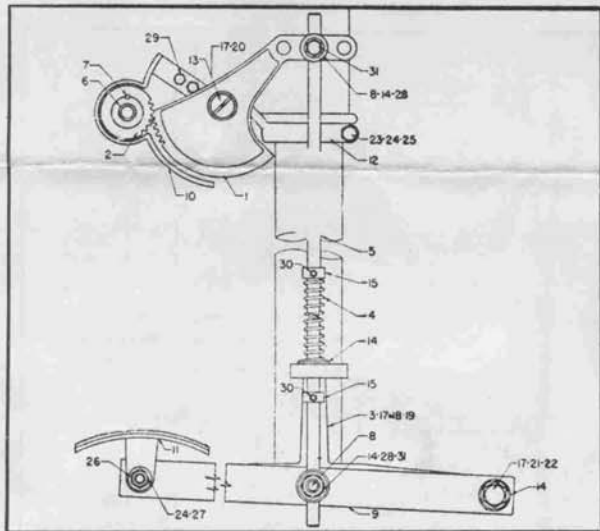
"900" SERIES DRILL PRESSES (Continued)



PARTS LISTING

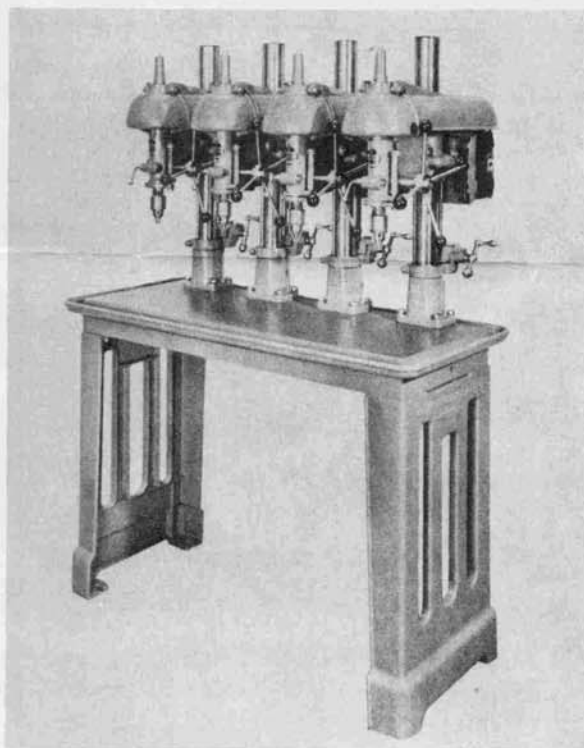
Key No.	Part No.	Description
	9D6	EXTENSION ARM COMPLETE.....
	Consists of:	
1	DDP 105	Arm only.....
2	DDP 50	Lock Handle (Long).....
3	DDP 63 A	Lock Block.....
4	DDP 63	Lock Block (threaded).....
5	NW 126	Bakelite Washer.....
6	DDP 109	Column.....
7	DDP 60	Column Cap.....
8	Comm.	1/2" I.D. Flat Washer.....
9	Comm.	1/2"-13x3/4" Allen Screw (2 used) ea.

Key No.	Part No.	Description
	9D80N	FOOT FEED ATTACHMENT.....
	Consists of:	
1	DDP 88R	Gear Control Lever.....
2	DDP 89	Feed Lever Pinion Gear.....
3	DDP 90	Pedal Adjusting and Spring Bracket.....
4	DDP 91	Foot Lever Tension Spring.....
5	DDP 92	Foot Lever Rod.....
6	DDP 94	Feed Pinion.....
7	DDP 94K	Sliding Key.....
8	DDP 95	Foot Lever Swivel (2 used)..... ea.
9	DDP 96	Foot Lever Arm.....
10	DDP 97N	Gear Guard.....
11	DDP 102	Foot Pad.....
12	DDP 104	Control Lever Bracket.....
13	DDP 123	Control Lever Shaft.....
14	EP 5169B	Tapered Washer (4 used).....
15	FS 6C	Stop Collar (2 used).....
	DU 65	Spacer.....
17	Comm.	1/2" I.D. Flat Washer (2 used).....
18	Comm.	1/2"-13 Hex Nut.....
19	Comm.	1/2"-13 x 3" Hex Bolt.....
20	Comm.	1/2"-30 Hex Nut.....
21	Comm.	1/2"-13 Hex Jam Nut (2 used)..... ea.
22	Comm.	1/2"-13 x 2" Hex Bolt..... ea.
23	Comm.	3/8"-16 x 31/2" Hex Bolt.....
24	Comm.	3/8"-16 Hex Nut (2 used)..... ea.
25	Comm.	3/8" I.D. Flat Washer.....
26	Comm.	3/8" I.D. Lock Washer.....
27	Comm.	3/8"-16 x 1 1/2" Hex Bolt.....
28	Comm.	1/2"-24 Hex Jam Nut (4 used)..... ea.
29	Comm.	5/16"-18 x 5/8" Hex Bolt (2 used)..... ea.
30	Comm.	1/4"-20 x 1/4" Hdls. Set Screw (2 used)..... ea.
31	Comm.	3/8"-16 x 3/4" Hex Bolt (2 used)..... ea.



ONE, TWO, FOUR AND SIX SPINDLE DRILL PRESSES OF PRODUCTION OIL TABLE BENCH TYPE

For prices and descriptions of parts other than those listed below see other sections of this sheet. For Head Assembly see 9D13X and 9D75 Head Raising Mechanism.



PARTS LISTING

Part No.	Description
For D 901	SINGLE SPINDLE MODEL
DDP 131	Cast Iron Table with Bolts..... (Cannot be used with legs 9D60- DDP200)
For D 902	TWO SPINDLE MODEL
DDP 115	Cast Iron Table with Bolts.....
9D60	Cast Iron Legs.....
For D 904	FOUR SPINDLE MODEL
DDP 115 L	Cast Iron Table with Bolts.....
9D60	Cast Iron Legs.....
For D 906	SIX SPINDLE MODEL
DDP 141N	Cast Iron Table with Bolts.....
DDP 116	Column Bracket with Screws..... ea.
	1/2"-13 x 1" Hex Bolts (4 used per bracket ea.
9D60	Cast Iron Legs.....
	(Cannot be used with DDP 131 Single Spindle Table)

Note: Standard commercial (comm.) parts are usually available locally from your machinery, hardware, or mill supply dealer.