

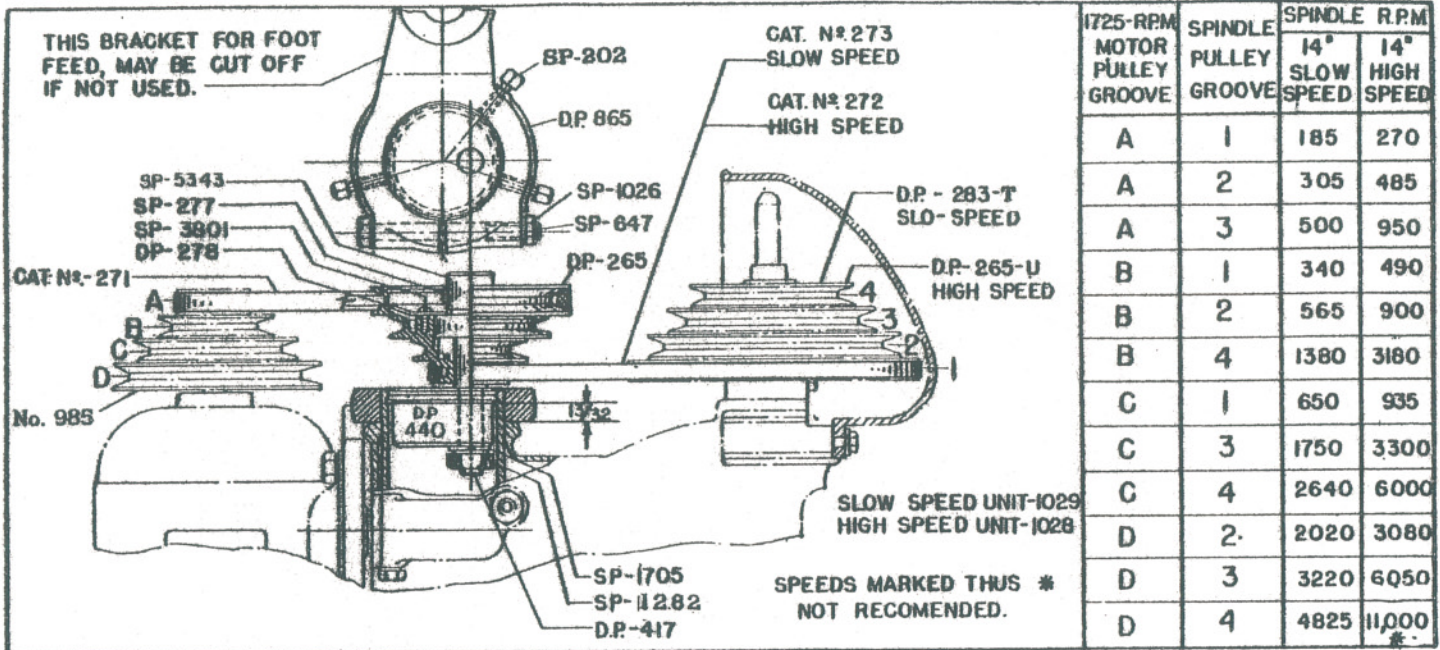


ROCKWELL
MANUFACTURING COMPANY
PITTSBURGH 8, PENNSYLVANIA



1957

1028 & 1029 MULTI-SPEED ATTACHMENTS FOR 14" DRILL PRESS



INSTALLING THE MULTI-SPEED ATTACHMENT

Raise or lower drill press head to point approximately 13/32" below end of column. Mount bracket DP-865 with arm extending towards right of head, when viewed from front of machine.

Drop plug and pulley assembly into place and mount belts; spindle pulleys first. Align pulleys by adjusting pulley DP-265 and motor upward or downward.

Next adjust motor to properly tension motor pulley belt, and lock plug with set screws SP-202. When changing speeds, loosen set screws slightly, select proper grooves and draw belts together between centers, to allow plug to find its center.

WHERE MULTI-SPEED UNIT CAN BE USED

The multi-speed attachment can be used on all 14" drill press heads either high speed or slow speed and on both the floor and bench models.

When using the multi-speed attachment, the drill press head must remain fixed and at the top of the drill press column, and under no conditions can it be used where the Spring Counter-balance Assembly (or the old counterweight assembly) is required.

FEATURES OF THE MULTI-SPEED UNIT

The multi-speed unit is quickly removed and easily adjusted. A grease-sealed ball bearing pulley is used in the assembly and insures smooth, even, vibrationless running.

This is an ideal and economical way to acquire lower and higher speeds than could otherwise be obtained. With this attachment you can use a standard 1725 R.P.M. motor, where a special high speed or slow speed motor would ordinarily be required.

A range of 12 speeds is available with the multi-speed attachment through various combinations. The table above lists the combinations and the speeds acquired.

IMPORTANT—

Although a speed of 11000 R.P.M. is obtainable (as marked * in the above table) with the high speed head, the drill press should not be run at this excessively high speed because of the undue wear on the bearings. The development of this attachment is to obtain lower speeds rather than extremely high speeds.

NOTE: Pay special attention to the type of spindle pulley on the machine when ordering the multi-speed attachment in order to receive the proper belts. Also note the speed range for given type of spindle pulley.

Replacement Parts

Part No.	Description
DP-265-T	Intermediate Pulley, consisting of;
DP-265	Pulley
DP-278	Closure Plate
SP-277	3/8-24 x 3/8" Set Scr.
SP-3801	#8-32 x 3/8" Screw
SP-5343	Bearing
DP-417	Pulley Spindle
DP-440	Column Cam
DP-865	Support Collar
SP-202	1/4-20 x 1/2" Set Scr.
SP-1282	1/2-13 Hex Nut
SP-1705	1/2" Spring Lockwasher
#271	Motor V-Belt
#272	V-Belt for #1028 H. S.
#273	V-Belt for #1029 S. S.
#985	Motor Pulley (Specify Bore)
#1534	1/8" Hex. Wrench