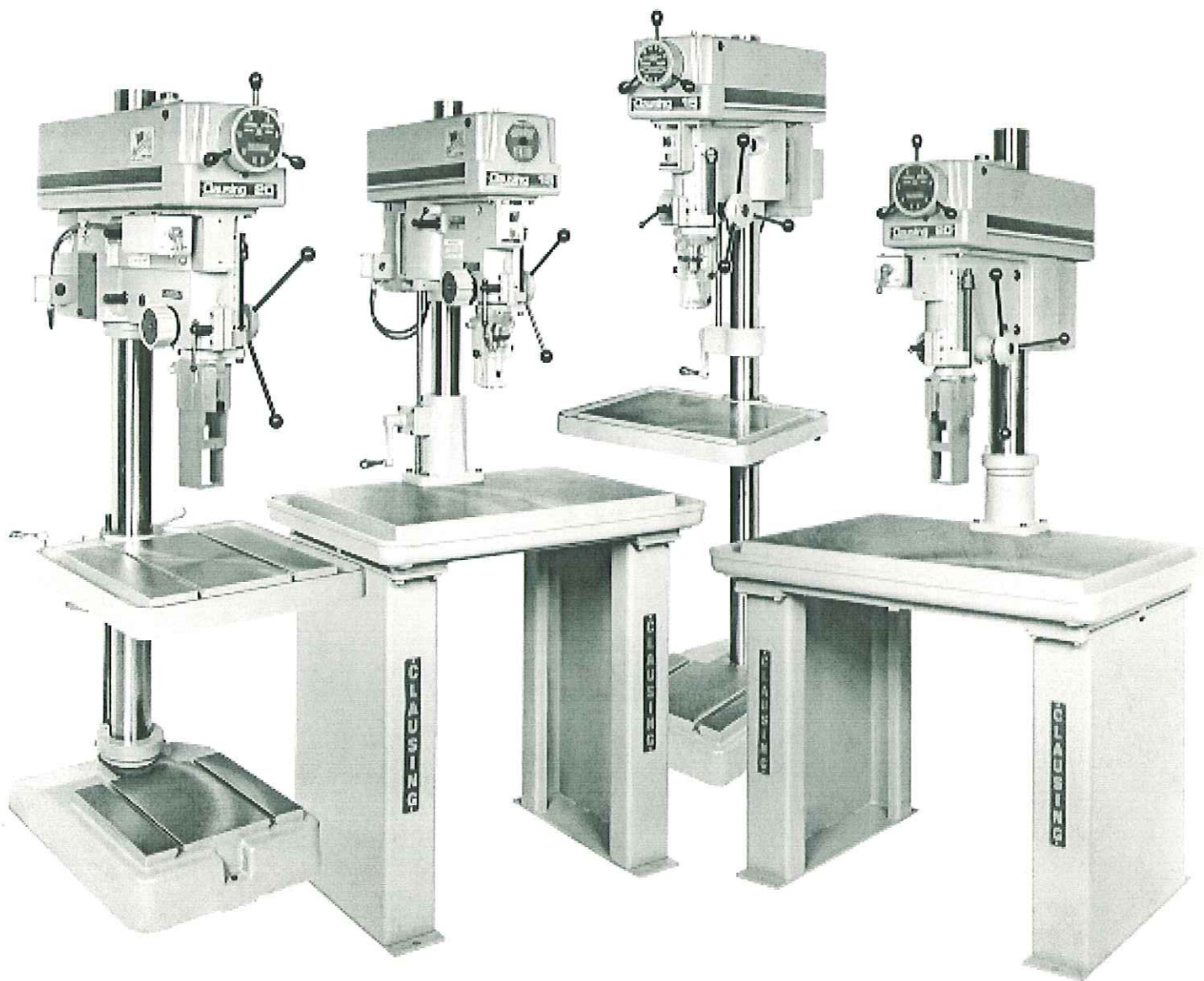

Clausing **DRILLS**

A Full Range of 15" and 20" Industrial Drill Presses...



www.SterlingMachinery.com

Clausing 20"

With speeds from 150-2000 rpm... infinitely

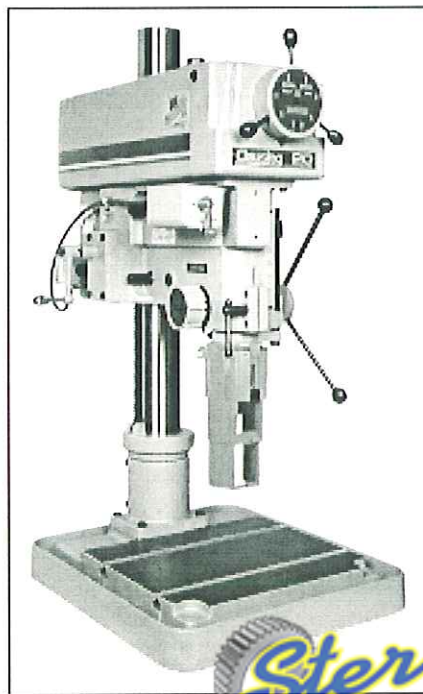
Dial to the best rpm for the tool and material while the job is running, with a Clausing LOW/HIGH.

- ◆ 150 to 2000 rpm ... speeds to drill large holes, small holes ... to spot face, counterbore, ream.
- ◆ And a flip of the switch changes from low range to high range ... perfect for production applications with quick change tooling.
- ◆ Greater capacity, too, with Clausing LOW/ HIGH ... production rated 1 1/8" in cast iron, 7/8" in steel with optional power feed.

Handle more jobs ... better, faster ... with a Clausing 20" LOW/HIGH drill press.

More features for superior performance...

- ◆ Heavy-duty precision head ... all bearing surfaces are precision bored simultaneously for exact alignment. Eight ball bearings support drive and spindle ... bottom spindle bearing is double row, absorbs both radial and thrust loads.
- ◆ 3 MT spindle 6 1/2" travel ... 2 1/2" diameter quill... micrometer depth stop.

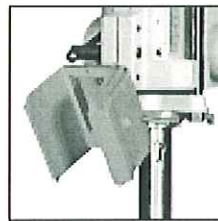


- ◆ 4" turned and ground steel column with 1/2" thick wall ... greater rigidity, accuracy.
- ◆ Precision ground 22" x 19", 45" x 29" or 25" x 22" oil trough tables ... handle big work easier.

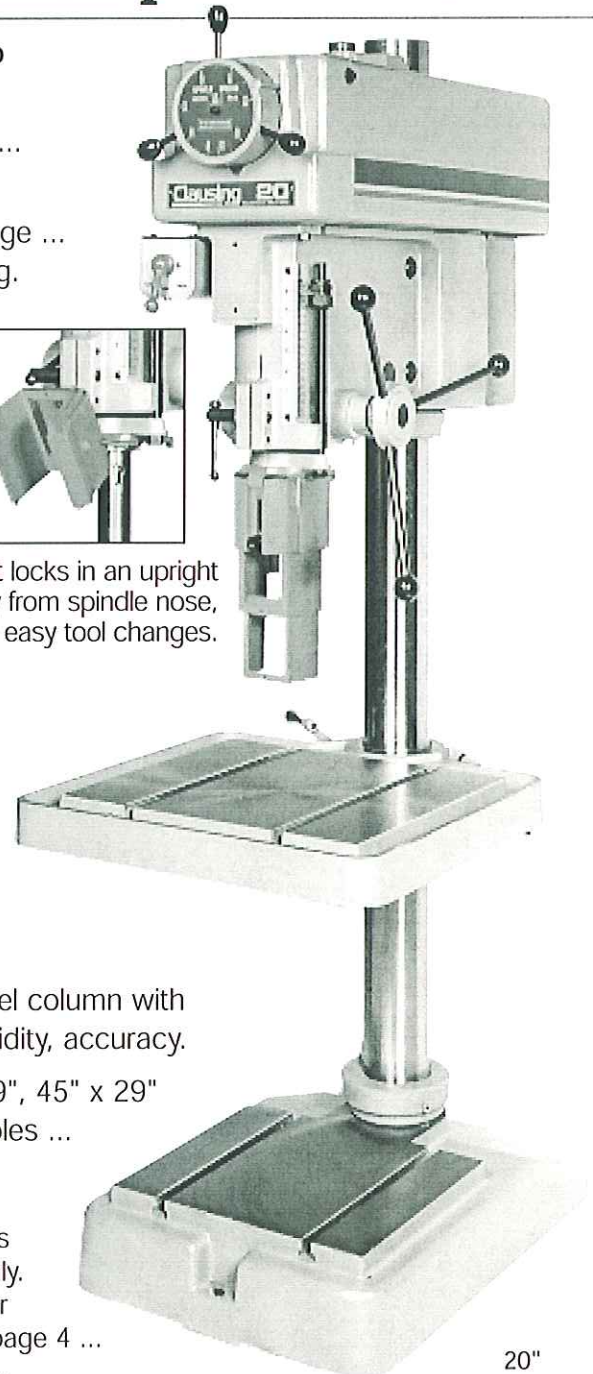
NOTE: LOW/HIGH drill presses operate on 3-phase current only. Single-phase models and other 20" drill presses are listed on page 4 ... multiple spindle drills, page 6 ... accessories, page 8... and components, page 19...

20" Low/High Bench Drill with 25" x 22" Table & Head Lift

Clausing Drills are equipped with a Spindle



Guard that locks in an upright position, away from spindle nose, for easy tool changes.



20" Low/High Floor Drill with 22" x 19" Table

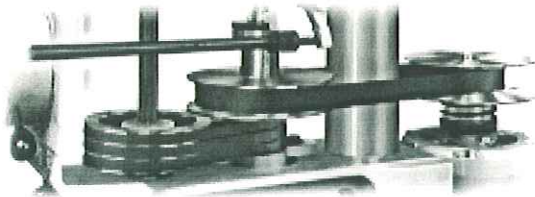
Sterling
MACHINERY EXCHANGE

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Low/High Drill Presses

variable countershaft drive or step pulley drive

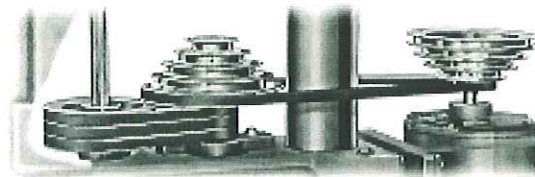
Powerful Countershaft Drive



- ◆ Three V-belts and a cog belt transmit positive power to the spindle.
- ◆ Variable and spindle pulleys are cast iron, fully machined and balanced.
- ◆ Eight ball bearings support drive and spindle.

Clausing's heavy-duty drive delivers full power to spindle at all speeds.

5 Step Pulley Drive

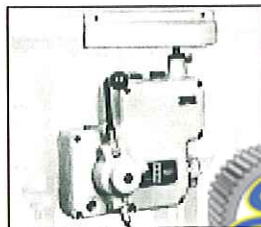


5 Step pulley drills have speeds from 150 to 2000 rpm... powerful 3 V-belt countershaft drive. Ideal for production requiring infrequent speed changes, and for tapping.

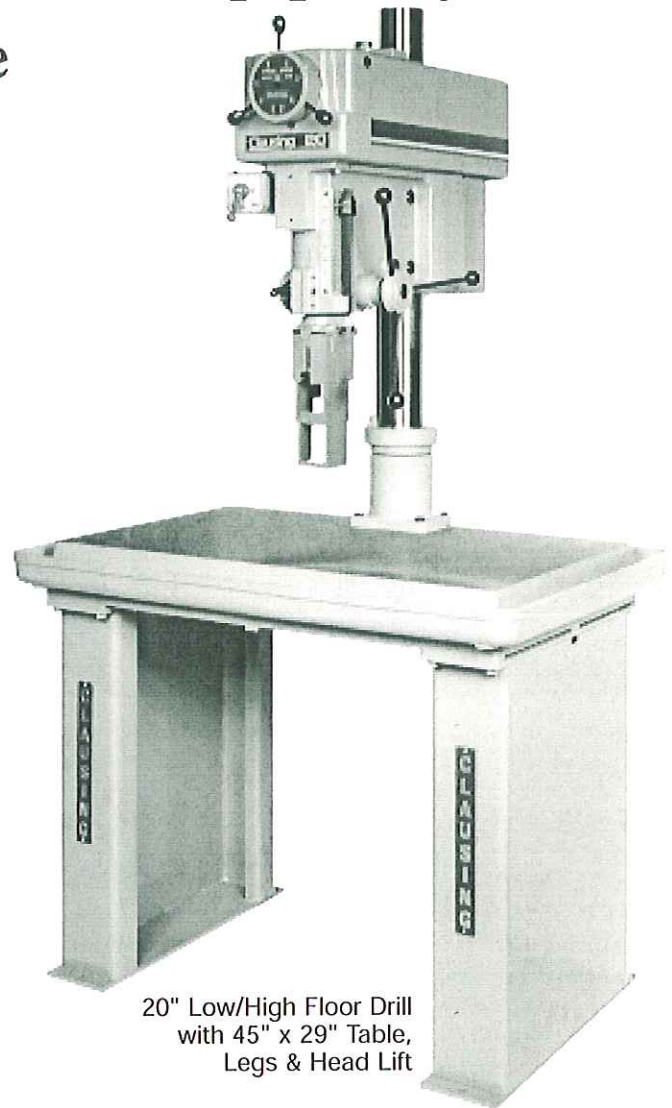


**Production
Rated 1 1/8 inch
in Cast Iron
7/8 inch in Mild
Steel with
Power Feed**

Air-hydraulic or position gear-driven power feeds take full advantage of Clausing's greater work capacity... top efficiency on production or in the tool room.



Sterling
See page 8 & 9
MACHINERY EXCHANGE



20" Low/High Floor Drill
with 45" x 29" Table,
Legs & Head Lift

Low/High Drill Presses

Infinitely variable speeds: 150 - 2000 rpm

Ready to run, with two-speed, 1 1/2 - 3/4 Hp 1800/900 rpm, 3-phase motor, and drum switch.

Bench Drill with 25" x 22" Table & Head Lift

For 220 volt, 3 phase, 60 cycle No.2256

For 440 volt, 3 phase, 60 cycle No.2257

Floor Drill with 22" x 19" Table & Head Lift

For 220 volt, 3 phase, 60 cycle No.2276

For 440 volt, 3 phase, 60 cycle No.2277

Floor Drill with 45" x 29" Table, Legs & Head Lift

For 220 volt, 3 phase, 60 cycle . . . No. 2286-501

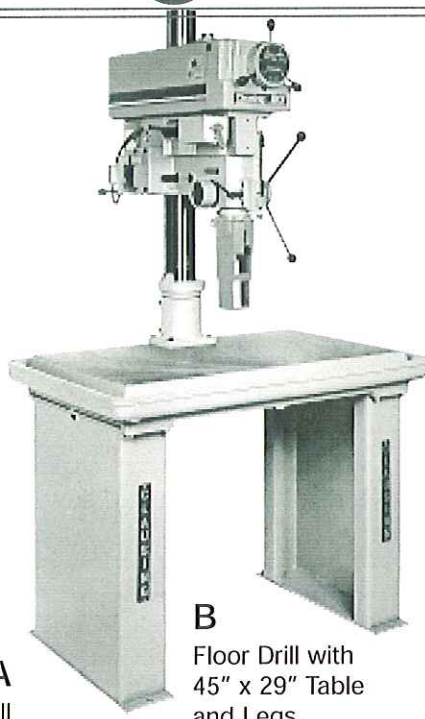
For 440 volt, 3 phase, 60 cycle . . . No. 2287-501

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Clausing 20"



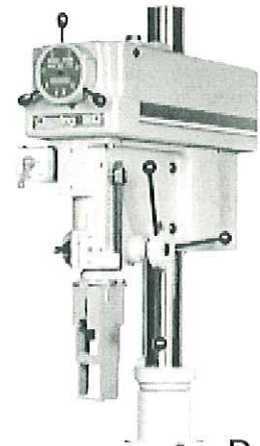
A
Floor Drill
with 22" x 19" Table



B
Floor Drill with
45" x 29" Table
and Legs



C
Bench Drill with
25" x 22" Table
(Legs available-order two
No. 2299 Table Legs-page 19)



D
Low/High Head
& Column
Assembly

INFINITELY VARIABLE SPEED COUNTERSHAFT DRIVE

NOTE: Variable speed drills are NOT available without motors.

Motor Furnished	A Floor Drill 22" x 19" Table	B Floor Drill 45" x 29" Table	C Bench Drill 25" x 22" Table	D Low/High Head & Column Assembly	D Head Only
Low/High Infinitely Variable Speeds: 150-2000 rpm					
2-speed, 3-phase, 220v*	2276	2286-501	2256	2286-300	2286
2-speed, 3-phase, 440v*	2277	2287-501	2257	2287-300	2287
Infinitely Variable Speeds: 200-1300 rpm					
1½ Hp, 3-ph, 1140 rpm	2275	2285-501	2255	2285-300	2285
Infinitely Variable Speeds: 300-2000 rpm					
1½ Hp, 1-ph, 1725 rpm	2272	2282-501	2252	2282-300	2282
1½ Hp, 3-ph, 1725 rpm	2274	2284-501	2254	2284-300	2284

STEP PULLEY COUNTERSHAFT DRIVE

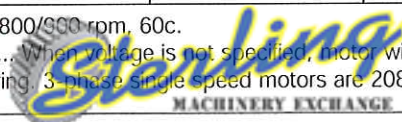
Low/High Ten Speeds: 150-250-300-400-500-600-800-1000-1200-2000 rpm

2-speed, 3-phase, 220v*	2226	2236-501	2246	2236-300	2236
2-speed, 3-phase, 440v*	2227	2237-501	2247	2237-300	2237
Five Speeds: 200-300-500-800-1300 rpm					
1½ Hp, 3-ph, 1140 rpm	2225	2235-501	2245	2235-300	2235
Five Speeds: 300-500-800-1200-2000 rpm					
1½ Hp, 1-ph, 1725 rpm	2222	2232-501	2242	2232-300	2232
1½ Hp, 3-ph, 1725 rpm	2224	2234-501	2244	2234-300	2234
Less Motors (switch furnished)	2220	2230-501	2240	2230-300	2230

*Motor, 1½-¾ Hp 1800/900 rpm, 60c.

SPECIFY VOLTAGE... When voltage is not specified, motor will be wired on lower voltage.

Motors are ball bearing. 3-phase single speed motors are 208/220/440v, 60c. Single-phase motors are capacitor-start, 115/230v, 60c.



www.SterlingMachinery.com

Drill Presses

Specifications:

Capacity, hand feed	1 1/4" dia
Production rated, with optional power feed, 11/2 hp motor	1 1/8" in cast iron 7/8" in mild steel
Drill to center of circle	20" dia.
Spindle nose	No. 3MT, 1.74" OD
Spindle travel	6 1/2"
Column	ground steel, 4" dia., 1/2" thick wall
Quill	ground steel, 2 1/2" dia.
Quill return spring, capacity	40 lbs
TABLE, DRILL PRESS A	
Working surface	22" x 19 1/2"
Table slots	two, 15 1/2" long, for 1/2" T-bolt
Table travel, one setting	20"
Spindle to table, maximum	33 1/8"
BASE, DRILL PRESS A	
Working surface, ground	15 1/2" x 13"
Base T-slots	two, 13" long, for 1/2" T-bolt
Spindle to table, maximum	43 3/8"
TABLE, DRILL PRESS B	
Working surface	40" x 24"
Spindle to table, maximum	25 7/16"
TABLE, DRILL PRESS C	
Working surface	18" x 16"
Table slots	two, 16" long, for 1/2" T-bolts
Spindle to table, maximum	25 7/16"
DRILL PRESS D	
Column bracket to center of spindle	9 1/4"
Column to center of spindle	10"
Spindle to table, max. distance	25 7/16"
Column length	43"
Min. center to center distance	20"
Motor ... NEMA Frame Sizes	182 and 184
Shipping weights, approximate, with motors	
Drill press A	630 lbs.
Drill press B	1,225 lbs.
Drill press C	530 lbs.
Drill press D	390 lbs.

FURNISHED: Variable or step pulley countershaft drive; No. 3 MT spindle; elevating mechanism; switch; belt guard; spindle guard .

Drum switch furnished with 2-speed motor, push button switch furnished with 1-speed motor. Motors and switches are installed and wired, ready to connect to current. Single phase motors have 10' three-wire cord and plug.

Overall Dimensions	Width	Depth	Height
Drill press A	22"	36"	69"
Drill press B	45"	39"	77"
Drill press C	22"	35"	46"
Drill Press D	20"	34 1/4"	51 5/8"

Optional Electrical Equipment*

For Factory Installation Only

NOTE: Magnetic starters protect motor against overload, low and no voltage-Thermal Overload Unit NOT required.

For Single Speed Motor

No. 2371 MAGNETIC STARTER. * Protects motor against overload, low and no voltage. Motor will not automatically restart when power is restored. Transformer provides 110v at start/stop push button switch. 6 lb.

No. 2371-14 MAGNETIC STARTER for 3-phase. Includes disconnect switch and 110 volt push buttons. Meets NMTBA standards.

No. 2371-15 MAGNETIC STARTER for 3-phase. Includes disconnect switch and 110 volt push-buttons. Meets JIC standards.

No. 2377 REVERSING DRUM SWITCH for 3-phase.* Protects motor against overload, low and no voltage. Motor will not automatically restart when power is restored. Transformer provides 110v at start/stop push button switch. 6 lb.

For 2-Speed Motor

No. 2376 MAGNETIC STARTER and TWO-SPEED DRUM SWITCH. * Protects motor against overload, low and no voltage. Motor will not automatically restart when power is restored. Transformer provides 110v at start/stop push button switch. 6 lb.

No. 2375 MAGNETIC STARTER and REVERSING DRUM SWITCH, with reverse on low speed. * Protects motor against overload, low and no voltage. Motor will not automatically restart when power is restored. Transformer provides 110v at start/stop push button switch. 6 lb.

*Controls for field installation, and for single phase ... price on application.

Motors

Catalog Number	H.P.	Speed	Phase	Voltage
2868	1 1/2	1140 rpm	3	208/220/440
2871	1 1/2	1725 rpm	3	208/220/440
2872	1 1/2	1725 rpm	1	115/230
2878	3/4-1 1/2	900/1800 rpm	3	220
2879	3/4-1 1/2	900/1800 rpm	3	460



Clausing 20"

In addition to the models listed below, Clausing multiple spindle drills can be custom tailored to your needs.

Any number of 20" and 15" heads...with choice of high or slow speed drives, hand or power feeds ... can be combined in a multiple drill to meet your specific requirements.

20" heads, tables and components... pages 4, 8 and 19. 15" heads, tables and components ... pages 16, 17 and 19. NOTE: Drills with 1 to 4 spindles ... unless equipped with air feed ... are shipped completely assembled with table mounted on legs. All other models are shipped assembled except that legs must be mounted at destination.

INFINITELY VARIABLE SPEED COUNTERSHAFT DRIVE

NOTE: Variable speed drills are NOT available without motors.

Motor Furnished	2-Spindle Drills	3-Spindle Drills	4-Spindle Drills	5-Spindle Drills	6-Spindle Drills	7-Spindle Drills	8-Spindle Drills
Low/High Infinitely Variable Speeds: 150-2000 rpm							
2-speed, 3-phase, 220v*	2286-502	2286-503	2286-504	2286-505	2286-506	2286-507	2286-508
2-speed, 3-phase, 440v*	2287-502	2287-503	2287-504	2287-505	2287-506	2287-507	2287-508
Infinitely Variable Speeds: 200-1300 rpm							
1½ Hp, 3-ph, 1140 rpm	2285-502	2285-503	2285-504	2285-505	2285-506	2285-507	2285-508
Infinitely Variable Speeds: 300-2000 rpm							
1½ Hp, 1-ph, 1725 rpm	2282-502	2282-503	2282-504	2282-505	2282-506	2282-507	2282-508
1½ Hp, 3-ph, 1725 rpm	2284-502	2284-503	2284-504	2284-505	2284-506	2284-507	2284-508

STEP PULLEY COUNTERSHAFT DRIVE

Low/High Ten Speeds: 150-250-300-400-500-600-800-1000-1200-2000 rpm

2-speed, 3-phase, 220v*	2236-502	2236-503	2236-504	2236-505	2236-506	2236-507	2236-508
2-speed, 3-phase, 440v*	2237-502	2237-503	2237-504	2237-505	2237-506	2237-507	2237-508

Five Speeds: 200-300-500-800-1300 rpm

1½ Hp, 3-ph, 1140 rpm	2235-502	2235-503	2235-504	2235-505	2235-506	2235-507	2235-508
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Five Speeds: 300-500-800-1200-2000 rpm

1½ Hp, 1-ph, 1725 rpm	2232-502	2232-503	2232-504	2232-505	2232-506	2232-507	2232-508
1½ Hp, 3-ph, 1725 rpm	2234-502	2234-503	2234-504	2234-505	2234-506	2234-507	2234-508
LESS MOTORS (switch furnished)	2230-502	2230-503	2230-504	2230-505	2230-506	2230-507	2230-508

*Motor, 1½-¾hp, 1800/900 rpm, 60c.

SPECIFY VOLTAGE ... When voltage is not specified, motor will be wired on lower voltage.

Motors are ball bearing. 3-phase single speed motors are 208/220/440v, 60c. Single-phase motors are capacitor-start, 115/230v., 60c.

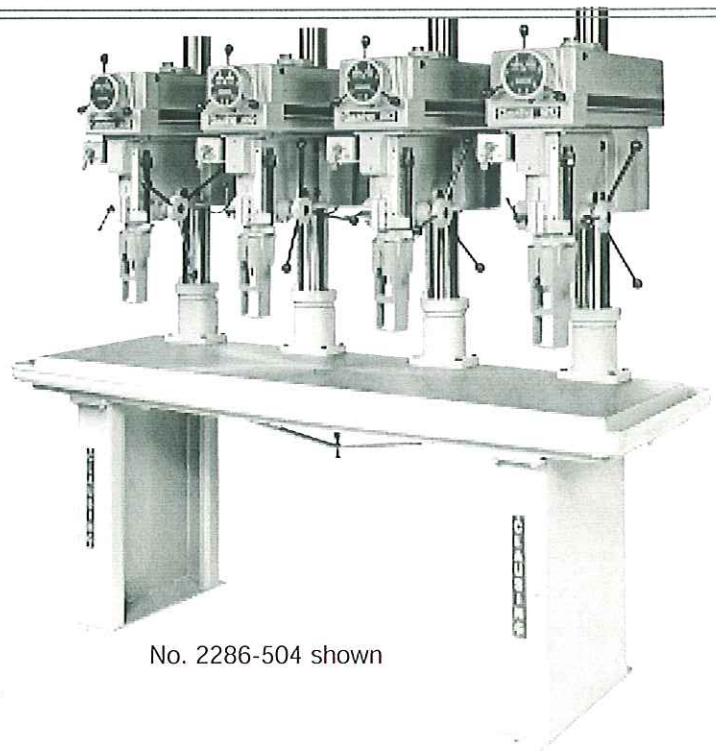
Optional electrical equipment is listed on page 5.



Multiple Spindle Drill Presses

Specifications:

Capacity, hand feed	1 1/4" dia.
Production rated capacity with power feed, 1 1/2 hp motor	1 1/8" in cast iron, 7/8" in mild steel
Spindle nose	No. 3 MT, 1.74" OD
Spindle travel	6 1/2"
Quill	2 1/2" dia. steel
Quill return spring, capacity	40 lb.
Column	4" dia. steel, 1/2" wall 43" long ground
Tables	



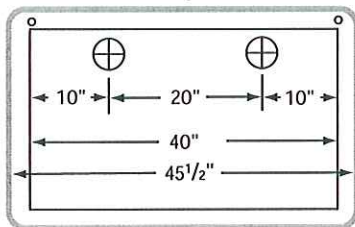
No. 2286-504 shown

Shipping weights, approximate, with motors

2-spindles	1,600 lbs.	5-spindles	3,875 lbs.
3-spindles	2,450 lbs.	6-spindles	4,250 lbs.
4-spindles	2,800 lbs.	7-spindles	5,100 lbs.
		8-spindles	5,450 lbs.

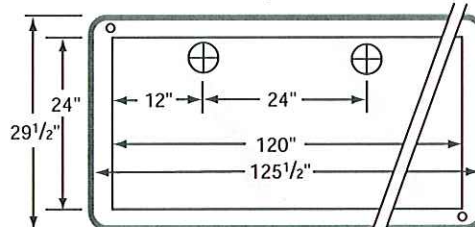
FURNISHED: Head positioning mechanism; belt guard; spindle guards. Drum switch furnished with 2-speed motor, push button switch furnished with 1-speed motor. Motors and switches are installed and wired, ready to connect to current. Single phase motors have 10' three-wire cord, plug.

2-Spindle



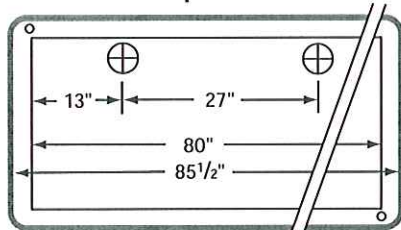
One piece table, two legs furnished

5-Spindle



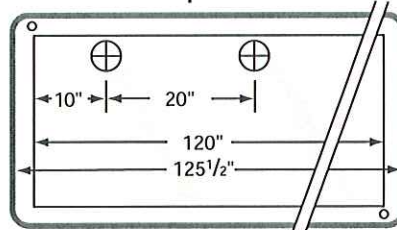
Two piece table, three legs furnished

3-Spindle



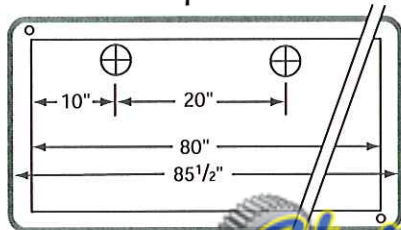
One piece table, two legs furnished

6-Spindle



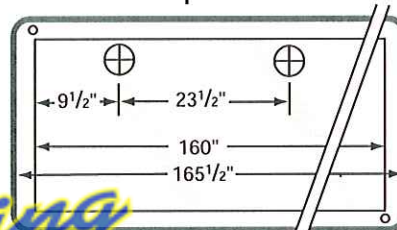
Two piece table, three legs furnished

4-Spindle



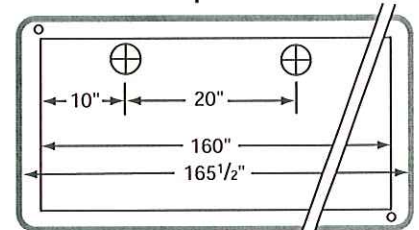
One piece table, two legs furnished

7-Spindle

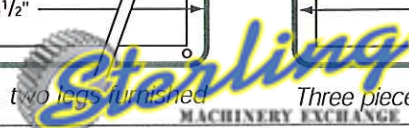
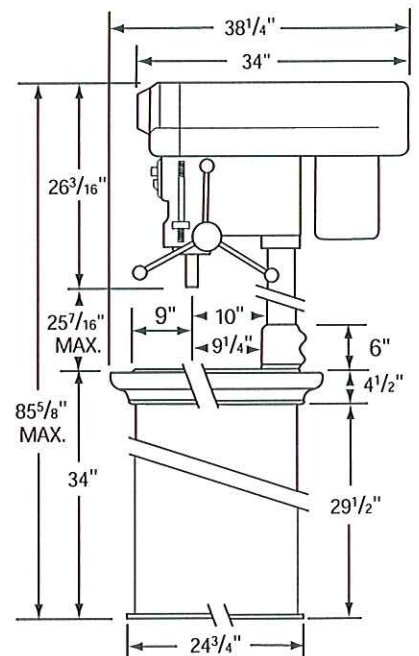


Three piece table, three legs furnished

8-Spindle



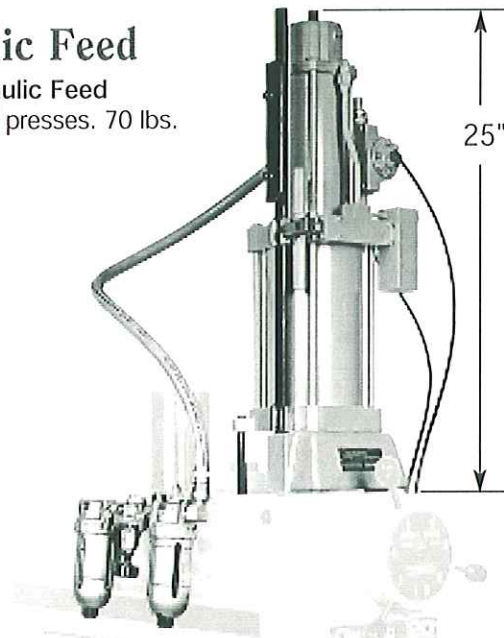
Three piece table, three legs furnished



Clausing 20"

Air-Hydraulic Feed

No. 2217 Air-Hydraulic Feed
for Clausing 20" drill presses. 70 lbs.



For automatic or semi-automatic production.

Easy to set up. Rapid approach and rapid return are cam actuated... to skip feed, merely change shape of cam. Feeds are infinitely variable, 1/2" to 60" per minute... hydraulically controlled for uniformity. Depth stop is micrometer graduated.

In-line thrust assures maximum efficiency ... full power direct to drill point. Ball bearing transfers thrust to spindle ... piston doesn't turn. Cycling controls are air-actuated for trouble-free performance.

Shipped installed when ordered with drill from factory... easily installed on drills in field.

Important Stack Adapters

Factory mounted air feed units for use with multiple drill heads or tapping heads must incorporate adapters to advance the spindle a sufficient distance for mounting the drill or tapping head. Please specify the number of adapters required to coincide with the length of quill needed to mount head.

001-025 Adapter for 20" drills 3/8" thick.

Specifications:

Maximum stroke	5 1/2"
Maximum thrust*	1,919 lbs.
Feed, infinitely variable*	1/2" to 60" per min.
Maximum rapid approach*	280 per min.
Depth accuracy	.002"
Air cylinder diameter	5"

* At 100 psi. air line pressure

Dual Palm Button

No. 1618A-Dual Palm Button Actuator. Both palm buttons must be pushed simultaneously in order for drill to feed down to the work piece.

Includes separate, emergency palm button to retract drill. Available for field installation.



No. 1618 for one air-hydraulic feed. 3 lbs.

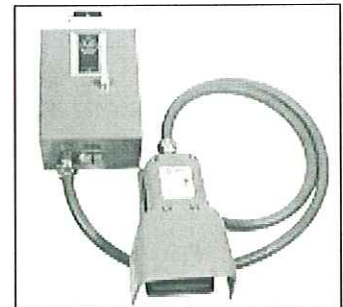
No. 1619 for simultaneous operation of 2, 3, or 4 air-hydraulic feeds. 6 lbs.

Foot Control Valves For Air-Hydraulic Feed

Complete with accumulator, hose, connector.

Electric Foot Control

No. 302 Electric Foot Control
No. 302R1 Electric Foot Control with reversing drum switch for single speed drill
No. 302R2 Electric Foot Control with replacement reversing drum switch for two speed drills
Start and stop drill from foot pedal, reverse spindle from reversing drum switch



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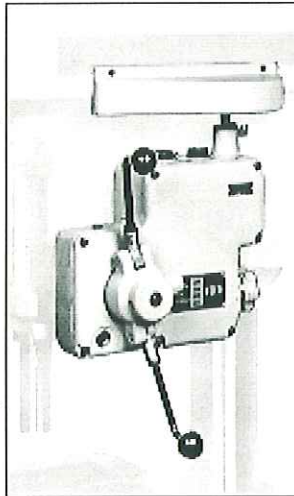
Drill Presses Accessories

Gear Driven Power Feed

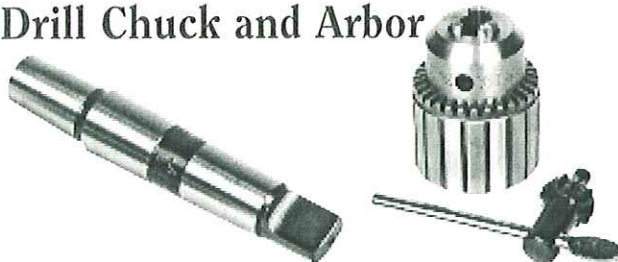
Positive gear drive for maximum power and efficiency ... feed is always in direct relation to drill speed.

Dial feeds: .004", .006", .009" and .012" ipr while drill is running. Either handle engages power feed ... feed disengages automatically at pre-set depth. Has neutral position for setup or hand feed. Heavy-duty construction... steel gears, ground shafts, hardened worm and clutch, anti-friction bearings. Worm and worm gear run in oil. Friction clutch protects against overload. Installed when ordered with drill from factory.

No. 2215 Power Feed Attachment. 77 lbs.



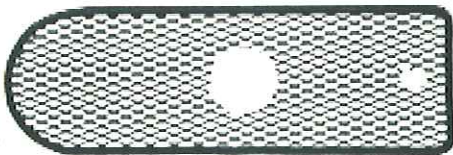
Drill Chuck and Arbor



No. 1897 Key-Type Chuck. Takes 3/16" to 3/4" drills. Adapts to 3 MT spindle with No. 1898 arbor. 4 lbs.

No. 1898 Arbor. Adapts No. 1897 to 3 MT spindle. 1 lb.

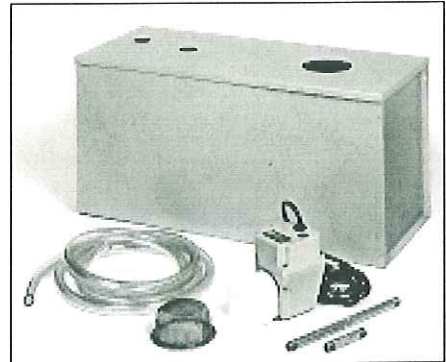
Mesh Guard



No. SK-208 Top Mesh Belt Guard

Coolant System

No. 7044 Coolant System. 5 gallon capacity, 110 volt, 60 cycle single-phase motor, for single spindle drills. Flexible nozzle with regulator valve, plastic hose, clamps, fittings, cord and plug. 18 lb.



No. 2350 Coolant System. For two (2) spindle drills. 5 gallon capacity, 110 volt, 60 cycle single-phase motor. Complete with all valves, hose, fittings, cord and plug.

No. 2351 Coolant System. For three (3) spindle drills. Like No. 2350 except arranged for 3 spindles.

No. 2352 Coolant System. For four (4) spindle drills. Like No. 2350 except arranged for 4 spindles.

No. 2353 Coolant System. For five (5) spindle drills. 2-5 gal. tanks, 10 gallon capacity, 110 volt, 60 cycle, single-phase motor. Complete with all valves, hose, fittings, cord and plugs.

No. 2354 Coolant System. For six (6) spindle drills. Like No. 2353 except arranged for 6 spindles.

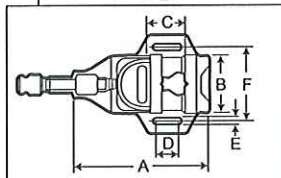
No. 2355 Coolant System. For seven (7) spindle drills. Like No. 2353 except arranged for 7 spindles.

No. 2356 Coolant System. For eight (8) spindle drills. Like No. 2353 except arranged for 8 spindles.

Drill Press Vises



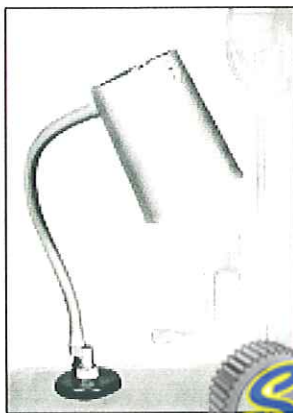
Swivel jaw; cross-drilled handle for extra leverage; precision machined base; precision machined slides; horizontal and vertical V grooved jaws for holding round section work; cast iron body and sliding jaw.



Model	A	B	C	D	E	F
AWH413	7 1/4"	3"	2 1/2"	1 1/2"	7/16"	3/8"
AWH413 Jaw Depth 1"						

Drill Press Lamp

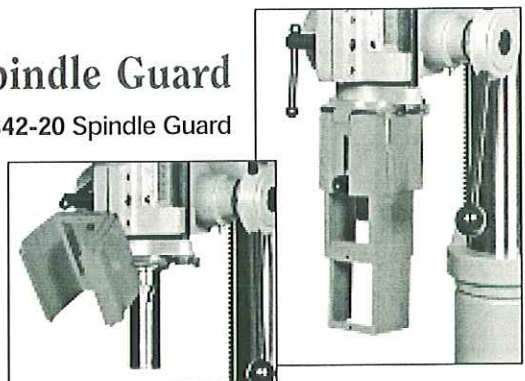
No. 7022 Lamp. Cool burn-proof shade, aluminum reflector, switch, 19" flexible arm, magnetic base, 6' cord and plug.



Spindle Guard

No. 342-20 Spindle Guard

that locks in an upright position, away from spindle nose, for easy tool changes.

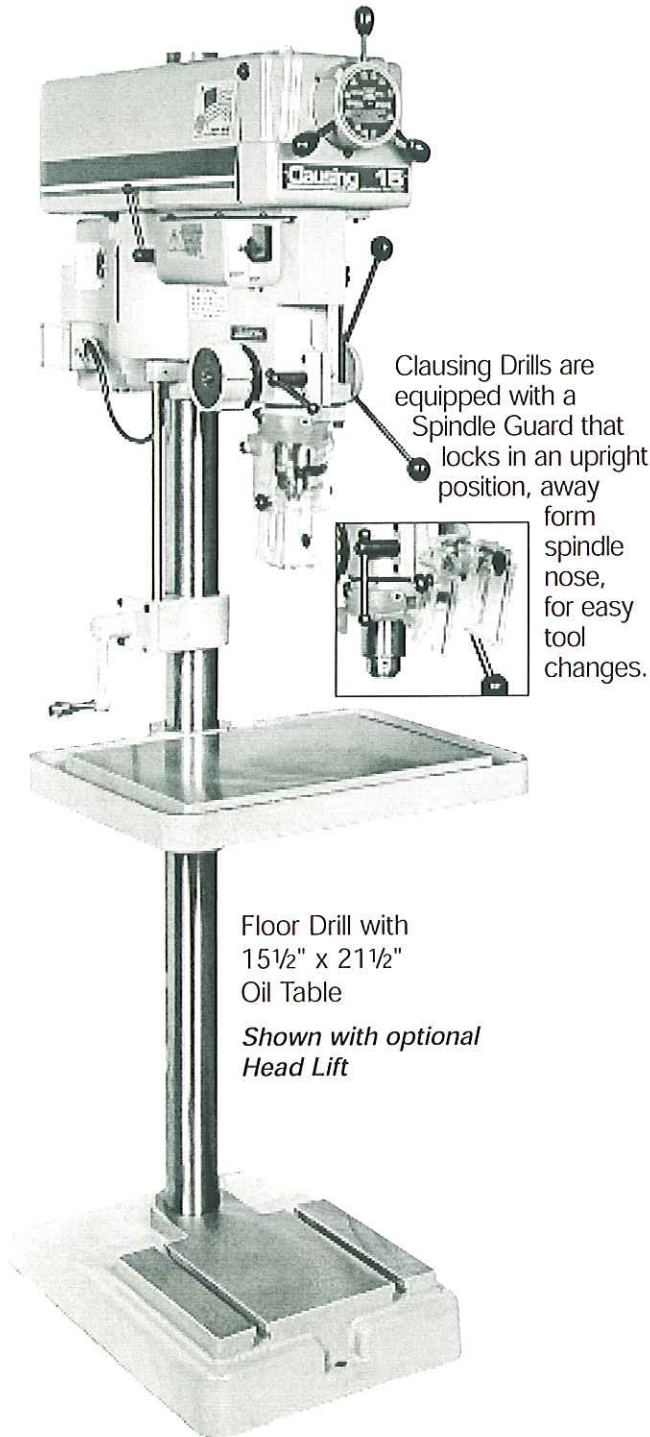


Sterling
MACHINERY EXCHANGE

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Clausing 15"

Built for metalworking... production rated with



The Clausing 15-inch drill press is designed to drill metal. It has the weight and rigidity to maintain the built-in tight tolerances basic to metalworking applications.

The drill head looks massive ... and it is. Widely spaced bearing surfaces give full quill support throughout its travel. These, and the bearing surfaces for the ball-bearing drive, and for the column, are precision bored simultaneously for exact alignment.

And Clausing has the speeds and power for drilling metal ... slow speed and high speed models, with heavy-duty infinitely variable or step pulley drives.

Equipped with a Clausing air-hydraulic feed, the 15 inch delivers top efficiency ... at low cost ... on automatic or semi-automatic drilling up to 5/8" in cast iron, 1/2" in mild steel.

And it is built for production: 3-inch column for greater rigidity, accuracy ... big work capacity tables... lubricated-for-life ball bearings ... positive depth stop and heavy-duty quill return spring ... factory tested... motor and switch installed, ready to run.

Whatever the requirement ... a single drill press, multiple spindles, drill units, components to build special machines ... heads, tables, columns, power feeds ... you'll do the job better and faster with Clausing.

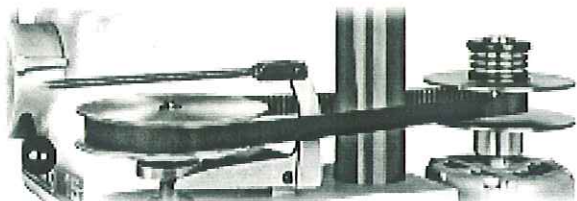
- ◆ Heads, ... page 16.
- ◆ Single spindle drills ... page 12 & 13.
- ◆ Multiple spindle drills ... page 14 & 15.
- ◆ Drill units ... page 16.
- ◆ Drill Components... page 19



Drill Presses

power feed 5/8" in cast iron, 1/2" in mild steel

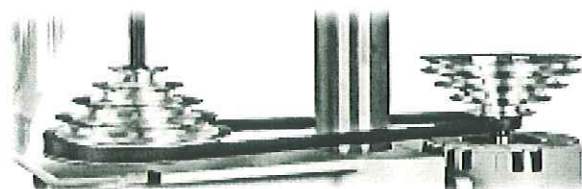
Infinitely Variable Speed Drive...



Just dial the the best rpm for the material and tool while drill is running... optimum efficiency, longer drill life, more production.

Clausing's positive-power variable drive is built for smooth performance. Pulleys are grey iron, fully machined and balanced. Pulley sleeves are ground and hard-chrome plated. Two ball bearings support drive in head... and a third ball bearing in variable control mechanism absorbs thrust. Bearings are lubricated-for-life. Cog belt transmits full power to spindle at every speed

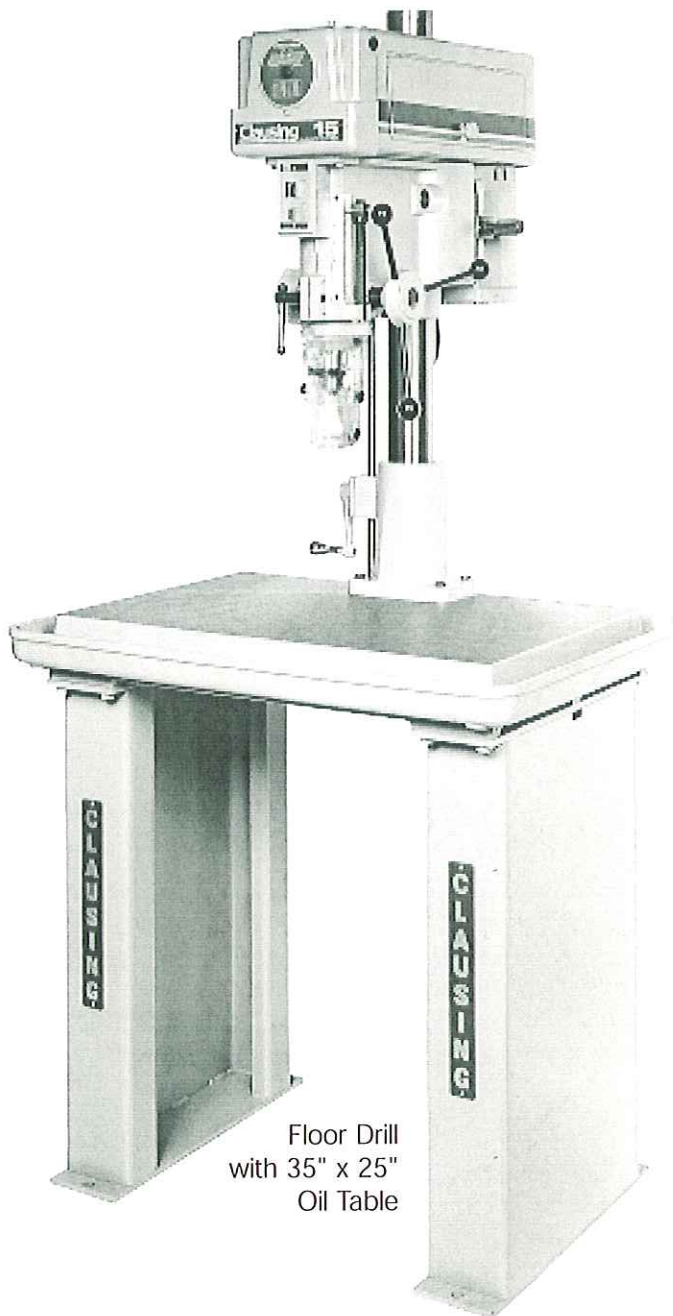
Five Speed Step Pulley Drive...



Wide speed ranges: 260 to 3600
or 400 to 5400 rpm.

Drive is constructed throughout for heavy-duty use. Pulleys are long wearing aluminum alloy, fully machined and balanced. Splined steel driver is supported in head by two lubricated-for-life ball bearings.

Speed changes are easy ... motor base is hinged for quick belt release and proper tensioning.



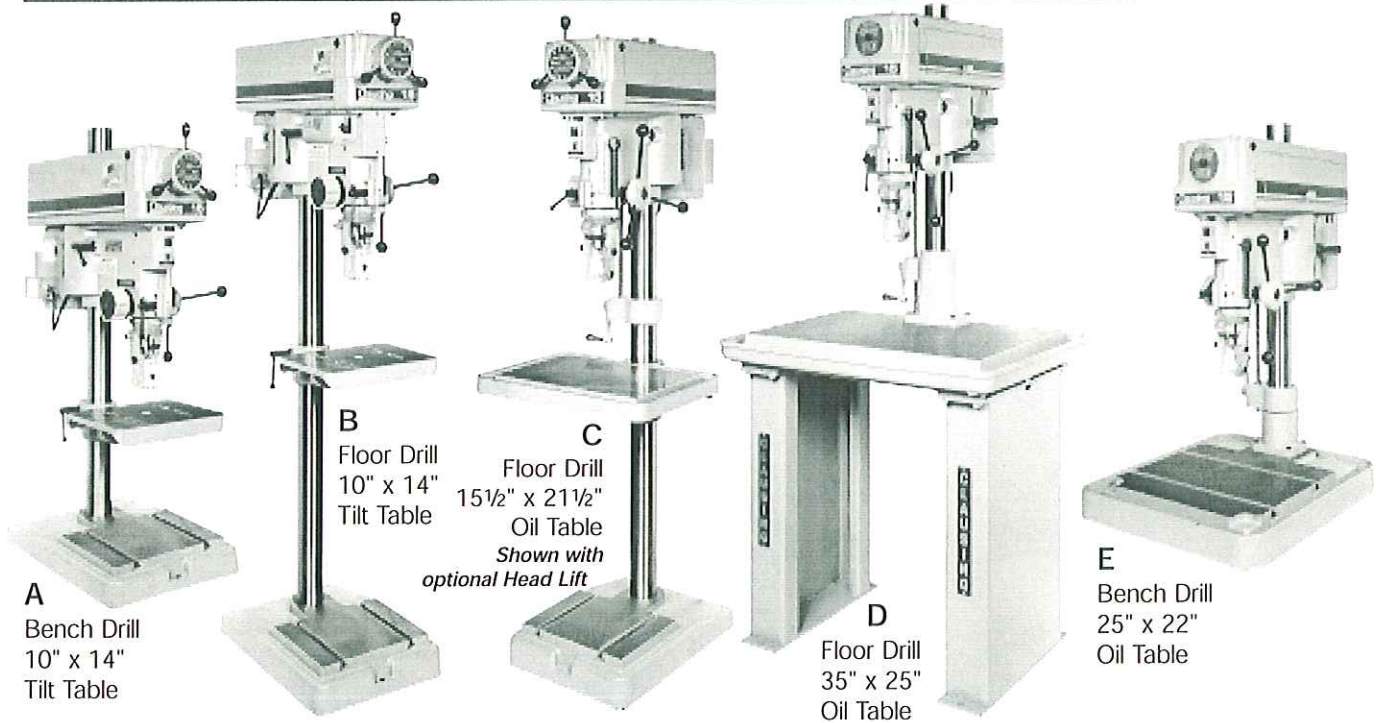
Floor Drill
with 35" x 25"
Oil Table

Clausing sets new standards for 15-inch drills ... in capacity, accuracy, service life, and value. Whatever the job... in the tool room or on high production... you'll do it better, faster with a Clausing.



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Clausing 15"



A
Bench Drill
10" x 14"
Tilt Table

B
Floor Drill
10" x 14"
Tilt Table

C
Floor Drill
15½" x 21½"
Oil Table
Shown with
optional Head Lift

D
Floor Drill
35" x 25"
Oil Table

E
Bench Drill
25" x 22"
Oil Table

INFINITELY VARIABLE SPEED DRIVE

NOTE: Variable speed drills are NOT available without motors.

Motor Furnished	A Bench Drill tilt table		B Floor Drill tilt table		C Floor Drill 15" x 21" table		D Floor Drill 35" x 25" table		E Bench Drill 25" x 22" table	
	½" Key chuck	2 MT	½" Key chuck	2 MT	½" Key chuck	2 MT	½" Key chuck	2 MT	½" Key chuck	2 MT

Slow-Speed-Infinitely variable Speeds: 330 - 2640 rpm

¾ Hp, 1-ph, 1140 rpm	1680	1682	1688	1690	1768	1770	1684-501	1686-501	1790	1792
¾ Hp, 3-ph, 1140 rpm	1681	1683	1689	1691	1769	1771	1685-501	1687-501	1791	1793

Hi-Speed-Infinitely variable Speeds: 500 - 4000 rpm

¾ Hp, 1-ph, 1725 rpm	1660	1662	1670	1672	1764	1766	1665-501	1667-501	1786	1788
¾ Hp, 3-ph, 1725 rpm	1661	1663	1671	1673	1765	1767	1666-501	1668-501	1787	1789

STEP PULLEY DRIVE

Slow-Speed-Five-Speed: 260-530-1060-1860-3600 rpm

¾ Hp, 1-ph, 1140 rpm	1650	1652	1675	1677	1760	1762	1654-501	1656-501	1782	1784
¾ Hp, 3-ph, 1140 rpm	1651	1653	1676	1678	1761	1763	1655-501	1657-501	1783	1785

Hi-Speed-Five Speed: 400-800-1600-2800-5400 rpm

¾ Hp, 1-ph, 1725 rpm	1622	1627	1642	1647	1752	1757	1632-501	1637-501	1774	1779
¾ Hp, 3-ph, 1725 rpm	1624	1629	1644	1649	1754	1759	1634-501	1639-501	1776	1781
Less Motor* (switch Furnished)	1620	1625	1640	1645	1750	1755	1630-501	1635-501	1772	1777

SPECIFY VOLTAGE... When voltage is not specified, motor will be wired on lower voltage.

*Single-phase switch installed and wired use motor with rpm shown above to get speed range indicated. Motors are ball bearing. 3-phase single speed motors are 208/220/440v, 60c. Single-phase motors are capacitor-start, 115/230v., 60c.

Drill Presses

Specifications:

Drill to center of circle	15" dia.
Capacity, hand feed	5/8" dia
Production rated, with optional power feed, 3/4 hp motor	5/8" in cast iron 1/2" in mild steel
Spindle travel	4 3/4"
Spindle	2 MT or 33 JT with 1/2" chuck
Column	ground steel, 3" dia., 3/16" thick wall
Quill	ground steel, 2" dia.
TABLE, DRILL PRESS A and B	
Working surface	14" x 10"
Spindle to table, maximum	
Bench drill A	14 1/4"
Floor drill B	41 3/4"
TABLE, DRILL PRESS C	
Working surface	21 1/2" x 15 1/2"
Spindle to table, maximum	41 3/4"
BASE working surface, ground, DRILLS A, B, C	
Spindle to table, maximum	
Bench drill A	19 5/8"
Floor drill B and C	47 1/8"
TABLE, DRILL PRESS D	
Working surface	30" x 20"
Spindle to table, maximum	23"
Column bracket to center of spindle	67/8"
TABLE, DRILL PRESS E	
Working surface	16" x 18"
Spindle to table, maximum	23"
Column bracket to center of spindle	67/8"

FURNISHED: 1/2" key chuck or 2 MT spindle; micrometer depth stop; drum switch; belt guard; spindle guard; 3 spoke feed wheel. Floor drill D, and bench drill E have head positioning mechanism. Other models have column collar.

Motors and switches are installed and wired, ready to connect to current. Single-phase motors have 10' three-wire cord and plug.

Optional Electrical Equipment*

For Factory Installation Only

(Controls for field installation ... price on application.)

No. 2371 MAGNETIC STARTER.* Protects motor against overload, low and no voltage. Motor will not automatically restart when power is restored. Transformer provides 110v at start-stop push button switch. 6 lbs.

No. 2371-14 MAGNETIC STARTER for 3-phase. Includes disconnect switch and 110 volt push buttons. Meets NMTBA standards.

No. 2371-15 MAGNETIC STARTER for 3-phase. Includes disconnect switch and 110 volt push buttons. Meets JIC standards.

No. 2377 REVERSING DRUM SWITCH for 3-phase. Protects motor against overload, low and no voltage. Motor will not automatically restart when power is restored. Transformer provides 110v at start-stop push button switch. 6 lbs.

* Controls for single phase ... price on application.

Motors

Catalog Number	H.P.	Speed	Phase	Voltage
2790	3/4	1725 rpm	1	115/230
2795	3/4	1140 rpm	1	115/230
2849	3/4	1140 rpm	3	220/440
2840	3/4	1725 rpm	3	220/440

Overall Dimensions	Width	Depth	Height	Weight
Drill press A	15 1/2"	28"	44 5/8"	275 lbs.
Drill press B	15 1/2"	28"	72 5/8"	300 lbs.
Drill press C	21 1/2"	28"	72 5/8"	350 lbs.
Drill Press D	35"	32 1/2"	78 1/2"	645 lbs.
Drill Press E	22"	32 1/2"	47"	350 lbs.



Clausing 15"

In addition to models listed, any assortment of 15" and 20" drill heads and tables can be combined in a multiple drill to meet your requirements.

20" head assemblies page 4, 15" head assemblies page 16 and tables are listed on page 19.

Motors and switches installed and wired, ready to connect to current. Single phase motors have 3-wire 10' cord and plug. NOTE: Drills with 1 to 4 spindles ... unless equipped with air feed ... are shipped completely assembled with table mounted on legs. All other models are shipped assembled except that legs must be mounted at destination.

VARIABLE SPEED DRIVE

NOTE: Variable speed drills are NOT available without motors.

Spindles and Motors	2-Spindle Drills	3-Spindle Drills	4-Spindle Drills	5-Spindle Drills	6-Spindle Drills	7-Spindle Drills	8-Spindle Drills
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Slo Speed-Speeds Infinitely Variable: 330-2640 rpm

1/2" Key Chucks							
3/4 Hp, 1-ph 1140 rpm	1684-502	1684-503	1684-504	1684-505	1684-506	1684-507	1684-508
3/4 Hp, 3-ph 1140 rpm	1685-502	1685-503	1685-504	1685-505	1685-506	1685-507	1685-508
No. 2 Morse Taper							
3/4 Hp, 1-ph 1140 rpm	1686-502	1686-503	1686-504	1686-505	1686-506	1686-507	1686-508
3/4 Hp, 3-ph 1140 rpm	1687-502	1687-503	1687-504	1687-505	1687-506	1687-507	1687-508

Hi Speed-Speeds Infinitely Variable: 500-4000 rpm

1/2" Key Chucks							
3/4 Hp, 1-ph 1725 rpm	1665-502	1665-503	1665-504	1665-505	1665-506	1665-507	1665-508
3/4 Hp, 3-ph 1725 rpm	1666-502	1666-503	1666-504	1666-505	1666-506	1666-507	1666-508
No. 2 Morse Taper							
3/4 Hp, 1-ph 1725 rpm	1667-502	1667-503	1667-504	1667-505	1667-506	1667-507	1667-508
3/4 Hp, 3-ph 1725 rpm	1668-502	1668-503	1668-504	1668-505	1668-506	1668-507	1668-508

STEP PULLEY DRIVE

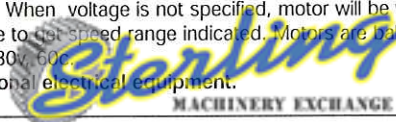
Slo Speed-Five Speeds: 260-530-1060-1860-3600 rpm

1/2" Key Chucks							
3/4 Hp, 1-ph 1140 rpm	1654-502	1654-503	1654-504	1654-505	1654-506	1654-507	1654-508
3/4 Hp, 3-ph 1140 rpm	1655-502	1655-503	1655-504	1655-505	1655-506	1655-507	1655-508
No. 2 Morse Taper							
3/4 Hp, 1-ph 1140 rpm	1656-502	1656-503	1656-504	1656-505	1656-506	1656-507	1656-508
3/4 Hp, 3-ph 1140 rpm	1657-502	1657-503	1657-504	1657-505	1657-506	1657-507	1657-508

Hi Speed-Five Speeds: 400-800-1600-2800-5400 rpm

1/2" Key Chucks							
3/4 Hp, 1-ph 1725 rpm	1632-502	1632-503	1632-504	1632-505	1632-506	1632-507	1632-508
3/4 Hp, 3-ph 1725 rpm	1634-502	1634-503	1634-504	1634-505	1634-506	1634-507	1634-508
Less motor*	1630-502	1630-503	1630-504	1630-505	1630-506	1630-507	1630-508
No. 2 Morse Taper							
3/4 Hp, 1-ph 1725 rpm	1637-502	1637-503	1637-504	1637-505	1637-506	1637-507	1637-508
3/4 Hp, 3-ph 1725 rpm	1639-502	1639-503	1639-504	1639-505	1639-506	1639-507	1639-508
Less motor*	1635-502	1635-503	1635-504	1635-505	1635-506	1635-507	1635-508

SPECIFY VOLTAGE ... When voltage is not specified, motor will be wired on lower voltage. *Single-phase switches installed and wired-use motors with rpm shown above to get speed range indicated. Motors are ball bearing. Three-phase motors are 208/220/440v, 60c. Single-phase motors are capacitor start, 115/230v, 60c. See page 13 for optional electrical equipment.

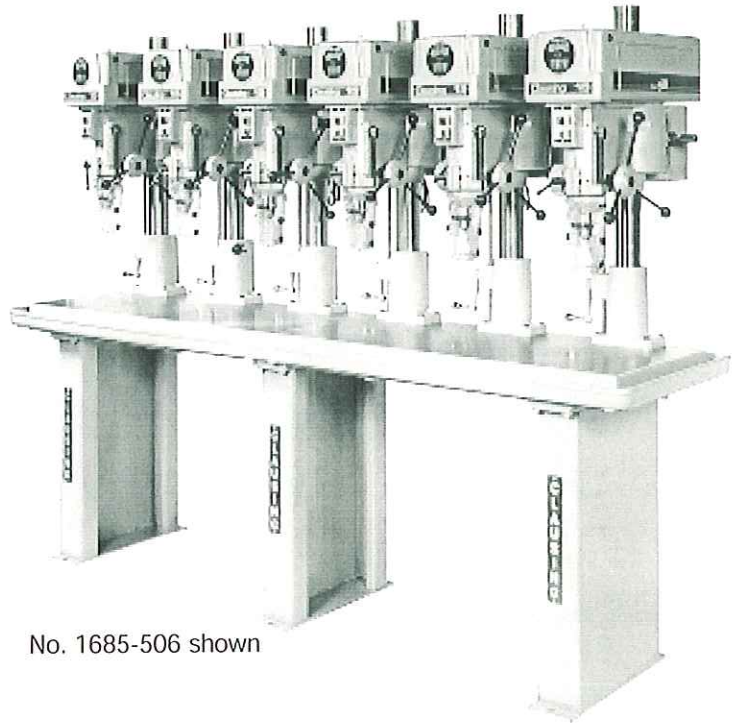


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Drill Presses

Specifications:

Capacity, hand feed	5/8" dia.
Production rated capacity with optional power feed, 3/4" Hp motor	5/8" in cast iron, 1/2" in mild steel
Spindle	2 MT or 33 JT with 1/2" chuck
Spindle travel	43/4"
Quill	ground steel, 2" dia
Quill return spring, capacity	40 lb.
Column, ground steel	3" dia., 3/16" wall
Tables	43" long ground



No. 1685-506 shown

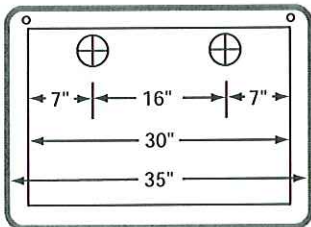
Shipping weights, approximate, with motors

2-spindles	820 lbs.	6-spindles	2,150 lbs.
3-spindles	1,330 lbs.	7-spindles	2,550 lbs.
4-spindles	1,520 lbs.	8-spindles	2,750 lbs.

FURNISHED: 1/2" key chucks or No. 2 MT spindles; head positioning mechanisms; drum switches; belt guards; spindle guards; 3-spoke feed wheels.

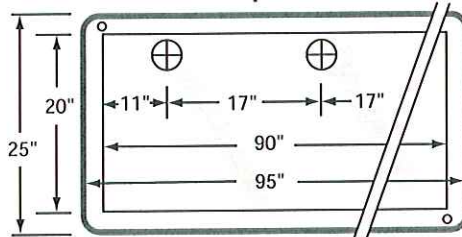
For other specifications, see chart below.

2-Spindle



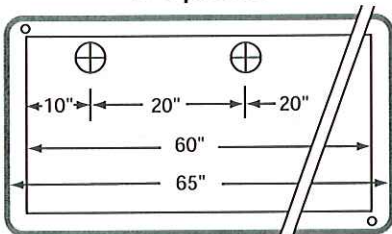
One piece table, two legs furnished

5-Spindle



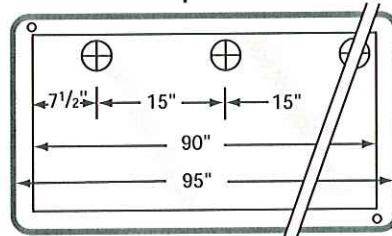
Two piece table, three legs furnished

3-Spindle



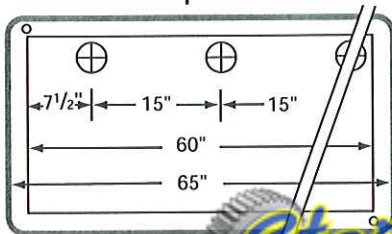
One piece table, two legs furnished

6-Spindle



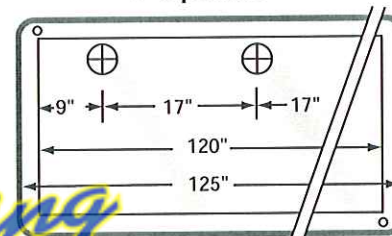
Two piece table, three legs furnished

4-Spindle



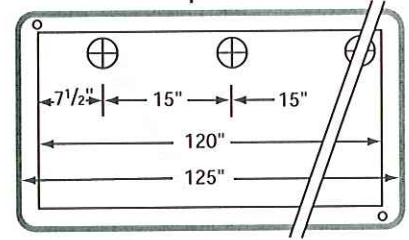
One piece table, two legs furnished

7-Spindle

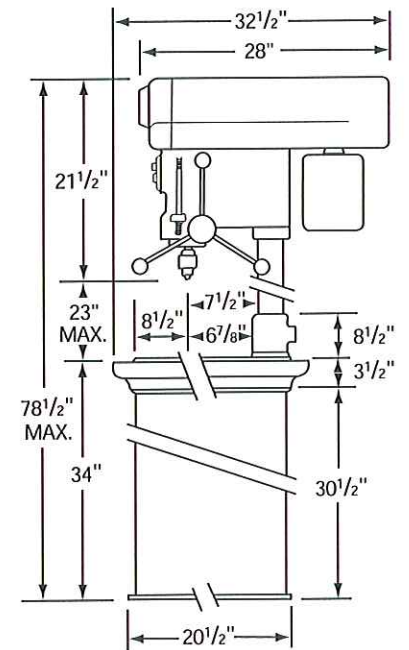


Three piece table, three legs furnished

8-Spindle

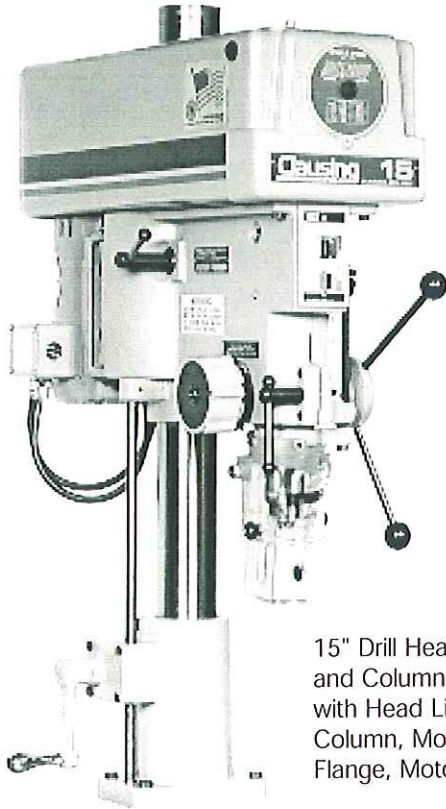


Three piece table, three legs furnished



Clausing 15"

Drill Head and Column Assembly



15" Drill Head and Column Assembly with Head Lift, 37" Column, Mounting Flange, Motor

Up-date your drilling efficiency ... at low cost ... with Clausing 15" heads. When ordered with table, listed below, head assemblies will be mounted to your specifications... include sketch for spacing requirements.

Specifications:

Capacity, hand feed	5/8" dia.
Production rated capacity with optional power feed, 3/4" Hp motor	5/8" in cast iron, 1/2" in mild steel
Spindle travel	4 3/4"
Spindle	2 MT or 33 JT with 1/2" chuck
Column, ground steel	3" dia., 3/16" wall
Quill	ground steel, 2" dia.
Minimum center to center distance	
Variable speed, hand feed	12"
Variable speed, air-hydraulic feed	15"
Step pulley, hand feed	15"
Step pulley, air-hydraulic	20"

Overall Dimensions: 15 1/4" wide, 28 1/2" deep, 44 1/2" high

INFINITELY VARIABLE SPEED DRIVE

NOTE: Variable speed drills are NOT available without motors.

Motor	Head and Column Assembly		Drill Head Only	
	1/2" Key chuck	2 MT	1/2" Key chuck	2 MT

Slow-Speed-Infinitely variable: 330 - 2640 rpm

3/4 Hp, 1-ph, 1140 rpm	1684-300	1686-300	1684	1686
3/4 Hp, 3-ph, 1140 rpm	1685-300	1687-300	1685	1687

Hi-Speed-Infinitely variable: 500 - 4000 rpm

3/4 Hp, 1-ph, 1725 rpm	1665-300	1667-300	1665	1667
3/4 Hp, 3-ph, 1725 rpm	1666-300	1668-300	1666	1668

STEP PULLEY DRIVE

Slow Speed-Five Speeds: 260-530-1060-1860-3600 rpm

3/4 Hp, 1-ph, 1140 rpm	1654-300	1656-300	1654	1656
3/4 Hp, 3-ph, 1140 rpm	1655-300	1657-300	1655	1657

Hi Speed-Five Speeds: 400-800-1600-2800-5400 rpm

3/4 Hp, 1-ph, 1725 rpm	1632-300	1637-300	1632	1637
3/4 Hp, 3-ph, 1725 rpm	1634-300	1639-300	1634	1639
Less motor*	1630-300	1635-300	1630	1635

SPECIFY VOLTAGE when ordering ... When voltage is not specified, motor will be wired on lower voltage.

*Single-phase switch installed and wired ... use motor with rpm shown above to get speed range indicated.

Motors are ball bearing. Three-phase single speed motors are 208/220/440v, 60c.

Single-phase motors are capacitor-start, 11 5/230v., 60c.

Optional Electrical Equipment*

For Factory Installation Only

(Controls for field installation ... price on application.)

No. 2371 MAGNETIC STARTER. * Protects motor against overload, low and no voltage. Motor will not automatically restart when power is restored. Transformer provides 110v at start-stop push button switch. 6 lbs.

No. 2371-14 MAGNETIC STARTER for 3-phase. Includes disconnect switch and 110 volt push buttons. Meets NMTBA standards.

No. 2371-15 MAGNETIC STARTER for 3-phase. Includes disconnect switch and 110 volt push buttons. Meets JIC standards.

No. 2377 REVERSING DRUM SWITCH. * Protects motor against overload, low and no voltage. Motor will not automatically restart when power is restored. Transformer provides 110v at start-stop push button switch. 6 lbs.

* Controls for single phase ... price on application.

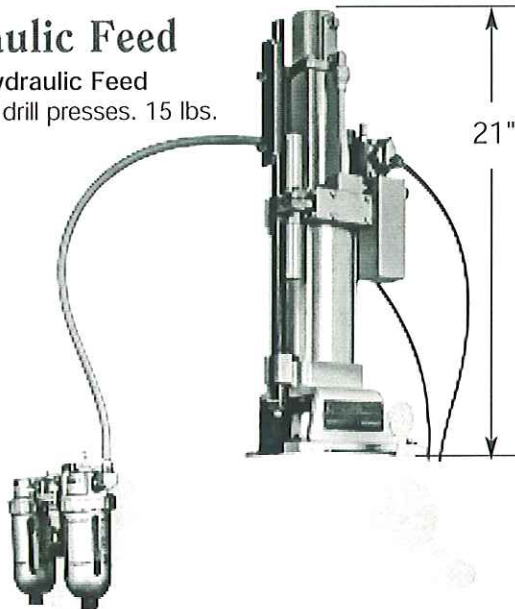


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Accessories

Air-Hydraulic Feed

No. 1617 Air-Hydraulic Feed
for Clausing 15" drill presses. 15 lbs.



Equips the Clausing 15" for automatic or semi-automatic production.

Quick set up. Length of rapid approach is adjusted by positioning a cam ... to skip feed, merely change cam shape. Select the right feed for the job by turning knob on hydraulic flow control valve. Micrometer depth stop sets total length of stroke.

In-line thrust assures maximum efficiency ... full power direct to drill point. Ball bearing transfers thrust to spindle ... piston doesn't turn. Cycling controls are air-actuated for trouble-free performance.

Shipped installed when ordered with drill from factory... easily installed on drills in field.

Important Stack Adapters... Factory mounted air feed units for use with multiple drill heads or tapping heads must incorporate adapters to advance the spindle a sufficient distance for mounting the drill or tapping head. Please specify the number of adapters required to coincide with the length of quill needed to mount head. 001-034 Adapter for 15" drills 1/4" thick.

Specifications:

Maximum stroke	4"
Maximum thrust*	687 lbs.
Feed, infinitely variable*	1" to 90" per min.
Maximum rapid approach*	480 per min.
Depth accuracy	.002"
Air cylinder diameter	3"

* At 100 psi. air line pressure

Dual Palm Button

No. 1618A-Dual Palm Button Actuator. Both palm buttons must be pushed simultaneously in order for drill to feed down to the work piece.

Includes separate, emergency palm button to retract drill. Available for field installation.



Foot Control Valves For Air-Hydraulic Feed

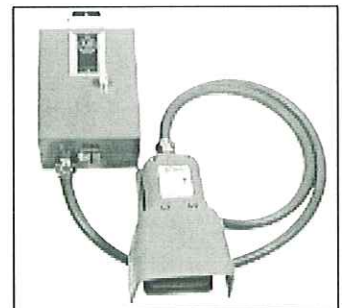
Complete with accumulator, hose, connector.

No. 1618 for one air-hydraulic feed. 3 lbs.

No. 1619 for simultaneous operation of 2, 3, or 4 air-hydraulic feeds. 6 lbs.

Electric Foot Control

No. 302 Electric Foot Control
No. 302R1 Electric Foot Control with reversing drum switch for single speed drill
No. 302R2 Electric Foot Control with replacement reversing drum switch for two speed drills
Start and stop drill from foot pedal, reverse spindle from reversing drum switch



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Clausing 15" Accessories

Coolant System

No. 7044 Coolant System. 5 gallon capacity, 110 volt, 60 cycle single-phase motor, for single spindle drills. Flexible nozzle with regulator valve, plastic hose, clamps, fittings, cord and plug. 18 lb.



No. 2350 Coolant System. For two (2) spindle drills. 5 gallon capacity, 110 volt, 60 cycle single-phase motor. Complete with all valves, hose, fittings, cord and plug.

No. 2351 Coolant System. For three (3) spindle drills. Like No. 2350 except arranged for 3 spindles.

No. 2352 Coolant System. For four (4) spindle drills. Like No. 2350 except arranged for 4 spindles.

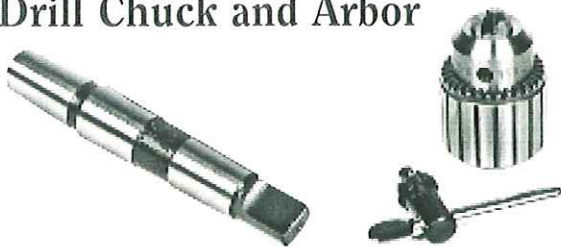
No. 2353 Coolant System. For five (5) spindle drills. 2-5 gal. tanks, 10 gallon capacity, 110 volt, 60 cycle, single-phase motor. Complete with all valves, hose, fittings, cord and plugs.

No. 2354 Coolant System. For six (6) spindle drills. Like No. 2353 except arranged for 6 spindles.

No. 2355 Coolant System. For seven (7) spindle drills. Like No. 2353 except arranged for 7 spindles.

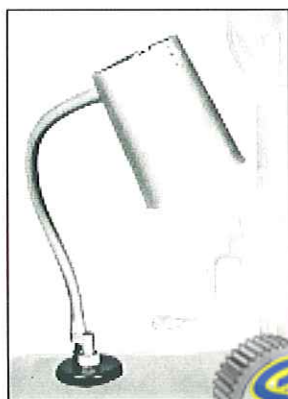
No. 2356 Coolant System. For eight (8) spindle drills. Like No. 2353 except arranged for 8 spindles.

Drill Chuck and Arbor



No. 40-60 Key-Type Chuck. Takes No. 70 to 1/2" drills. Adapts to No. 2 MT spindle with No. 378 arbor. 2 lbs.

No. 378 Arbor. Adapts No. 40-60 to No. 2 MT spindle. 1 lb.

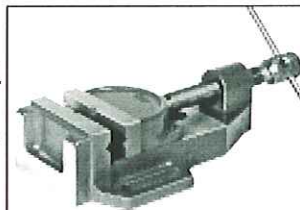
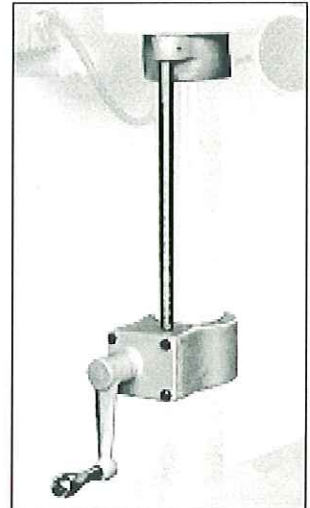


Drill Press Lamp

No. 7022 Lamp. Cool burn-proof shade, aluminum reflector, switch, 19" flexible arm, magnetic base, 6' cord and plug.

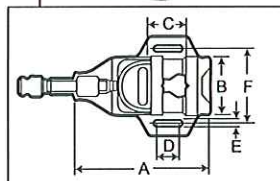
Head or Table Positioning Mechanism

No. 1613 Positioning Mechanism. For head or table of floor models, head only of bench drills. One revolution of crank gives 1/8" travel ... maximum travel at one setting, 10". Installed when ordered with drill from factory. 16 lb



Drill Press Vises

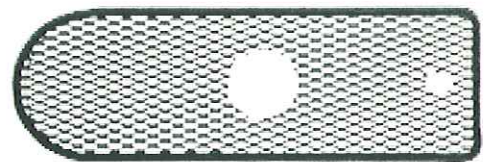
Swivel jaw; cross-drilled handle for extra leverage; precision machined base; precision machined slides; horizontal and vertical V grooved jaws for holding round section work; cast iron body and sliding jaw.



Model	A	B	C	D	E	F
AWH413	7 1/4"	3"	2 1/2"	1 1/2"	7/16"	3 7/8"
AWH414	9"	4"	3"	1 7/8"	9/16"	5"

AWH413 Jaw Depth 1"
AWH414 Jaw Depth 1 1/4"

Mesh Guard

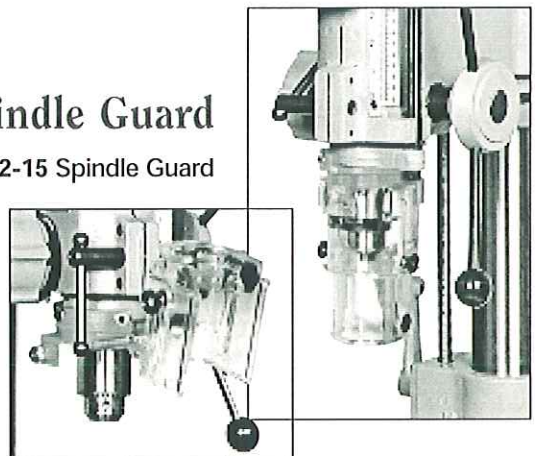


No. SK-1001 Top Mesh Belt Guard

Spindle Guard

No. 342-15 Spindle Guard

that locks in an upright position, away from spindle nose, for easy tool changes.



Sterling
MACHINERY EXCHANGE

www.SterlingMachinery.com

Clausing 15" & 20" Components

Oil Trough Tables

T-Slotted Tables are available. Furnished with 2 T-Slots. Position of T-Slots to be specified by customer. Contact factory for price and delivery.



15" Drill Presses

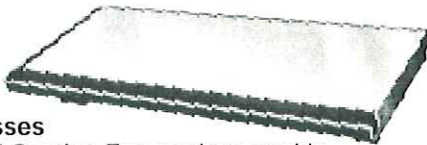
No. 1692 Table One piece 20" x 30" working surface. Takes up to two 15" heads. 275 lbs.

No. 1696 Table One piece 20" x 60" working surface. Takes up to four 15" heads. 535 lbs.

20" Drill Presses

No. 2292 Table One piece 24" x 40" working surface. Takes up to two 20" heads. 500 lbs.

No. 2296 Table One piece 24" x 80" working surface. Takes up to four 20" heads. 860 lbs.

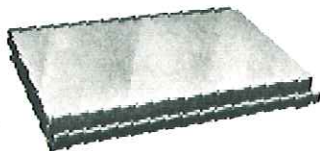


15" Drill Presses

No. 1697 End Section Two sections provide 20" x 90" working surface for up to six 15" heads. 375 lbs.

20" Drill Presses

No. 2297 End Section Two sections provide 24" x 120" working surface for up to six 20" heads. 700 lbs.



15" Drill Presses

No. 1698 Mid Section. 20" x 30" working surface. Takes two 15" heads.

Use with two No. 1697 End Sections. 225 lbs.

20" Drill Presses

No. 2298 Mid Section. 24" x 40" working surface. Takes up to two 20" heads. Use with two No. 2297 End Sections. 450 lbs.



No. 1616 Oil Table. 15 1/2" x 21 1/2" ground work surface, lever controlled lock, column collar. 57 lbs

15" Drill Presses & 20" Drill Presses

No. 2291 Oil Table. 25" deep & 22" wide. 16" x 18" working surface not drilled for mounting flange unless specified. Takes one 15" or 20" head. (Legs available ... order two No. 2299 legs.)



When ordered with Head Assemblies, tables are drilled for mounting flanges-enclose sketch for spacing required.

Table Leg

15" Drill Presses

No. 1699 Table Leg. Two required for Nos. 1692 and 1696, three required for two No. 1697, and three required for two No. 1697 with one No. 1698. 83 lbs.

20" Drill Presses

No. 2299 Table Leg. Two leg required for Nos. 2292 and 2296. Three legs required for two No. 2297. Three legs required for two No. 2297 with one No. 2298 133 lbs.



Column, Column Collar and Mounting Flange

15" Drill Presses

No. 1693 Column 37" x 3" 18 lb. **No. 1694 Column** 65" x 3" 32 lb.

20" Drill Presses

No. 2293 Column 43" x 4" x 1/2" wall 78 lb.

No. 2294 Column 66" x 4" x 1/2" wall 121 lb.

No. 2349 Column 90" x 4" x 1/2" wall 160 lb.

15" Drill Presses



No. 1615 Column Collar 3 lbs



20" Drill Presses



No. 2214 Column Collar 3 lbs



No. 2295 Column Mounting Flange.

7 1/4" x 5 1/2" x 6" high. Has 4 holes for 1/2" bolts. 22 lb.

No. 1695 Column Mounting Flange.

5 1/2" x 5" x 4 1/2" high. Has 4 holes for 3/8" bolts. 17 lb.

Head Positioning Mechanism

No. 2216 Positioning Mechanism, for 20" Drill Maximum travel, one setting, 10". Head swivels on ball race in support collar. Installed when ordered with drill from factory. 16lbs.



Head Lift and Flange Assembly

No. 1961 Lift and Flange for 15" Drill same as furnished with multiple spindle drills. One revolution of crank gives 1/8" travel ... maximum travel, 19". 21 lbs.



Clausing Service Center



The Clausing Service Center

Only Clausing maintains a separate Service Center designed solely to support our customers' parts and service needs! Located in Goshen, Indiana, this facility has served as an invaluable resource since 1974.

Over 47,000 Parts

With thousands of parts in our inventory, the Clausing Service Center can provide replacement parts for machines you may have purchased thirty years ago! Lathes, drill presses, sheet metal fabricating equipment... all Clausing products are backed by the friendly and resourceful staff of our Customer Service Department.

95% of all parts orders are shipped within 24 hours!

In this modern age, of course, computers have brought exceptional speed and efficiency to our department. When a customer calls with a problem, our Customer Service Department can check stock immediately and initiate the shipping order while the customer is still on the phone. Within minutes, the parts order can be picked and delivered to the Shipping Department for packing and shipment. RUSH orders get top priority... we know our customers can't afford downtime!

Service

In addition to supplying the parts that keep all our customers' equipment running, the Service Center has its own staff of highly-qualified service technicians... and they're available to solve problems all across the country.

Regular service schools are conducted for dealer personnel, to review new products and to insure that each Clausing dealer has a highly-trained service staff.

At Clausing, we're committed to service after the sale... and the Clausing Service Center demonstrates that commitment. That's the Clausing Difference.

For parts and service, please call the Clausing Service Center.

(574) 533-0371

e-mail: info@clausingsc.com

Distributed By:



Clausing Industrial Inc.
1819 North Pitcher Street
Kalamazoo, Michigan 49007-1886
Phone: 269-345-7155
Fax: 269-345-5945

Web Site: www.clausing-industrial.com
Information: info@clausing-industrial.com

www.SterlingMachinery.com

