

# **CLAUSING**

## **15" Step Pulley Drive**

# **PARTS LIST**

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## **INSTRUCTIONS FOR ORDERING REPAIR PARTS**

It is important to furnish the following information in addition to quantity required:

1. Part number
2. Part name
3. Model and serial number of machine tool - you'll find both on the metal plate attached to machine - note illustration below.



Be sure to give model and serial number on this plate.

For parts and service, phone (574) 533-0371 • fax (574) 533-0403

NOTE: Screws and nuts shown without part numbers should be purchased locally.  
We reserve the right to make changes in design and specifications without notice.

# The Clausing WARRANTY

The Clausing Industrial Inc., Kalamazoo, Michigan, warrants that each Product will be free from defects in material and workmanship for one year from the date of delivery to the User.

Clausing will correct any defects without charge. Parts will be repaired or replaced at Clausing's option. Warranty work will normally be performed at the User's plant, but at the option and expense of Clausing, the Product, or any part thereof, may be returned to Clausing for the service. User shall provide access to the Product during regular business hours and shall provide such other assistance as determined necessary by Clausing.

Clausing shall not be responsible for expenditures made or incurred by the User for repairs of the Product. The warranty is void for any Product that has been subjected to neglect, misuse, accident, or improper operation, or that has been tampered with or altered in any way.

The foregoing warranty is exclusive and in lieu of all other warranties, express or implied, except as to title, including any implied warranty of MERCHANTABILITY or of FITNESS FOR A PARTICULAR PURPOSE.

The liability of Clausing under this warranty, or for any loss or damage to the equipment, whether the claim is based on contract or negligence, shall not in any case exceed the cost of correcting defects in the equipment as herein provided and upon the expiration of the warranty period all such liability shall terminate. The foregoing shall constitute the exclusive remedy of the User and the exclusive liability of Clausing.

In no event, whether as a result of breach of contract or warranty, or alleged negligence, shall Clausing be liable for special or consequential damages including, but not limited to, loss of profits or revenue, loss of use of the equipment or any associated equipment, cost of capital, cost of substitute equipment, facilities or services, down-time costs, or claims of customers of the User for such damages.

No one other than an officer of Clausing acting in writing is authorized to assume any liability on behalf of Clausing or impose any obligation upon it in connection with the sale of any product other than as stated above.

**CLAUSING INDUSTRIAL INC.**  
**KALAMAZOO, MICHIGAN 49007**



# Clausing

## SAFETY RULES FOR POWER TOOLS

### ● KNOW YOUR POWER TOOL

Read the owner's manual carefully. Learn its application and limitations as well as the specific potential hazards peculiar to this tool.

### ● GROUND ALL TOOLS

If tool is equipped with three-prong plug, it should be plugged into a three-hole receptacle. If adapter is used to accommodate two-prong receptacle, the adapter wire must be attached to a known ground. Never remove third prong.

### ● KEEP GUARDS IN PLACE

and in working order.

### ● REMOVE ADJUSTING KEYS AND WRENCHES

Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning on tool.

### ● KEEP WORK AREA CLEAN

Cluttered areas and benches invite accidents.

### ● AVOID DANGEROUS ENVIRONMENT

Don't use power tools in damp or wet locations. Keep work area well illuminated.

### ● KEEP CHILDREN AWAY

All visitors should be kept a safe distance from work area.

### ● MAKE WORKSHOP KID PROOF

— with padlocks, master switches, or by removing starter keys.

### ● DON'T FORCE TOOL

It will do the job better and be safer at the rate for which it was designed.

### ● USE RIGHT TOOL

Don't force tool or attachment to do a job it was not designed for.

### ● WEAR PROPER APPAREL

No loose clothing or jewelry to get caught in moving parts.

### ● USE SAFETY GLASSES

Also use face or dust mask if cutting operation is dusty.

### ● SECURE WORK

Use clamps or a vise to hold work when practical. It's safer than using your hand, frees both hands to operate tool.

### ● DON'T OVERREACH

Keep your proper footing and balance at all times.

### ● MAINTAIN TOOLS IN TOP CONDITION

Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

### ● DISCONNECT TOOLS

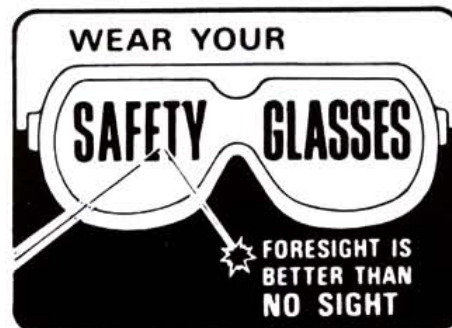
before servicing and when changing accessories such as blades, bits, cutters.

### ● AVOID ACCIDENTAL STARTING

Make sure switch is "OFF" before plugging in cord.

### ● USE RECOMMENDED ACCESSORIES

Consult the owner's manual. Use of improper accessories may be hazardous.



The operation of any power tool can result in foreign objects being thrown into the eyes, which can result in severe eye damage. Always wear safety glasses or eye shields before commencing power tool operation.

# Clausing drill press operating instructions

## for 15" step pulley drive models.

*After the Drill Press has been uncrated and while head is in the low position it may be more convenient to mount the motor before head is raised to the operating position.*

### Step Pulley drill press motor mounting instructions

*A 3/4 HP, 1725 ball bearing motor is recommended to operate drill press.*

1. Remove belt guard by loosening and removing the two hex head screws from front guard and the two from top of head casting.
2. Slide motor pulley on shaft with small step next to motor, and lock securely with set screw.
3. Fasten motor to motor support bracket with bolts furnished - position so top mounting bolts are in center of motor support bracket slots.
4. Place belt over pulleys and shift motor or motor pulley, until pulleys are in line. Push motor base lock handle until belt is tight, then lock in place. Center motor so belt will not rub on column.
5. The motor should rotate clockwise viewed from pulley end - wire according to instructions shown on motor.
6. Replace belt guard and tighten screws.

### Leveling the drill press

Drill press should be level and rest solidly on floor; place shims underneath the three foundation holes to level the drill press. Equal pressure should be applied to foundation bolts to prevent distorting the base.

### Raising head and table to operating position

1. To position drill head, loosen clamp handle on left side of drill press.
2. Slide head up column to desired height and tighten clamp handle.
3. Loosen set screw in safety collar and slide it up column until it touches bottom of head, then tighten set screws.
4. To position table, loosen clamp handle on right side of table.
5. Slide table up column to desired height, and tighten clamp handle.

*Generally, the normal and most convenient position for the head is about 8" to 10" from top of column.*

*Important: Always keep safety collar locked under head.*

### Lubrication

Keep Quill (A) and Column (C) covered with a light film of oil - see Fig. (2). Feed shaft (B) grease weekly with No. 1 bearing grease - fittings under head.

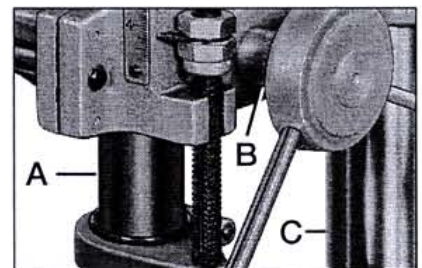


Figure 2

*All bearings in the head and lower quill are sealed-for-life ball bearings and do not require lubrication. Occasionally grease spindle splines.*

**For a detailed Parts List of Clausing Drill Presses e-mail:**

**info@clausingsc.com**

**or call The Clausing Service Center (574) 533-0371 request an electronic (pdf) Part List:**



## Changing spindle speeds

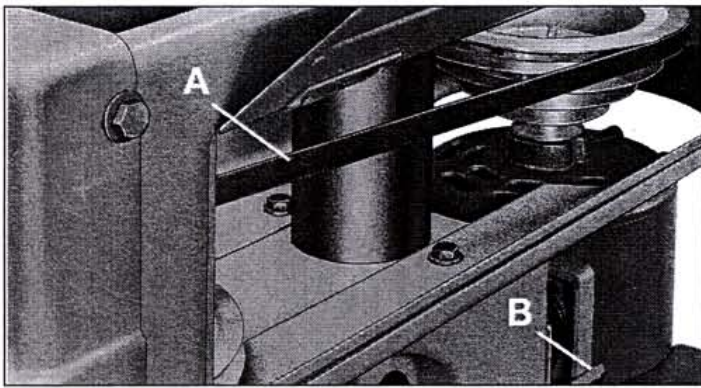


Figure 3

1. Raise door on guard. Loosen lock handle (B, fig. 3) on motor base, to release belt tension.
2. Shift belt (A) to step desired.
3. Push motor base lock handle until belt is tight and lock in place.

## Removing chuck

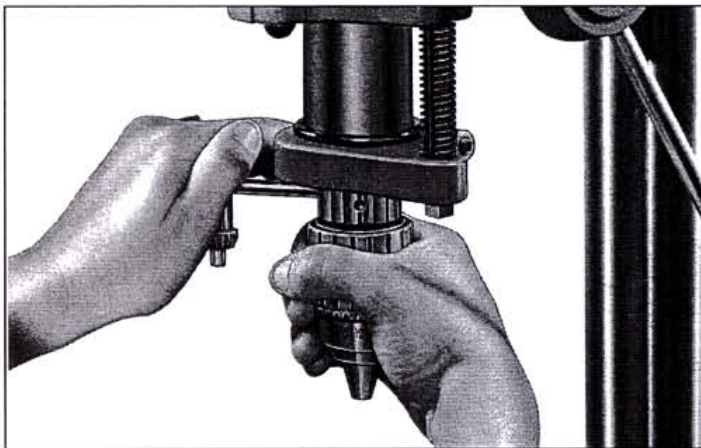


Figure 4

Insert chuck wrench handle in hole in chuck collar. While holding chuck in right hand, strike wrench handle with heel of left hand in a clockwise direction - see Fig. (4). Continue turning collar to remove chuck from spindle.

*Important - Always clean spindle taper and chuck taper bore before replacing chuck. Chips or dirt score the spindle and cause chuck to slip and run out of true.*

## Adjusting spindle return spring

To increase tension, lower quill to bottom of stroke, turn the spring cap counter-clockwise. To release tension, pull out spring cap (fig. 5) and turn clockwise.

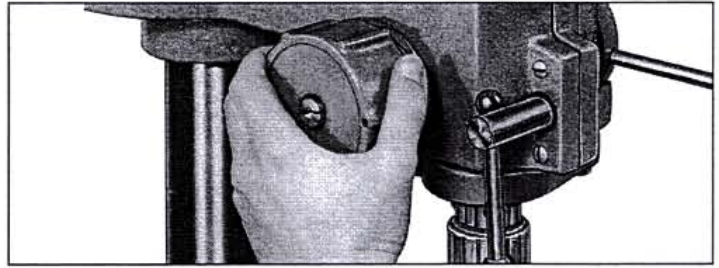


Figure 5

## Adjusting spindle end play

1. Release spindle return spring tension (fig. 5).
2. While holding spindle to prevent its falling, remove hex nut on bottom of depth stop rod. Remove spindle and quill assembly from head.
3. Loosen set screw in collar directly above quill.
4. Push spindle firmly against bottom of quill. Force collar against top of quill and lock collar in this position.
5. Rotate spindle by hand to make sure it turns freely - **DO NOT** have adjustment too tight.
6. Replace spindle - quill assembly.

## Adjusting depth stop

1. When setting drill depth, position pointer at depth required and tighten nuts.
2. Loosen screws and with quill at maximum travel, position scale so pointer is at  $4\frac{3}{4}$ ", then tighten screws (B, fig. 6).

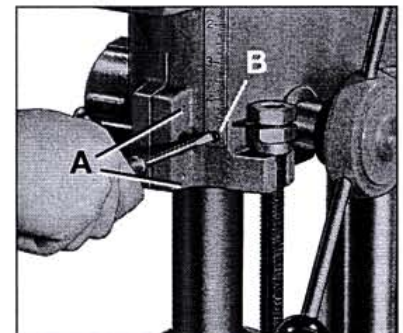


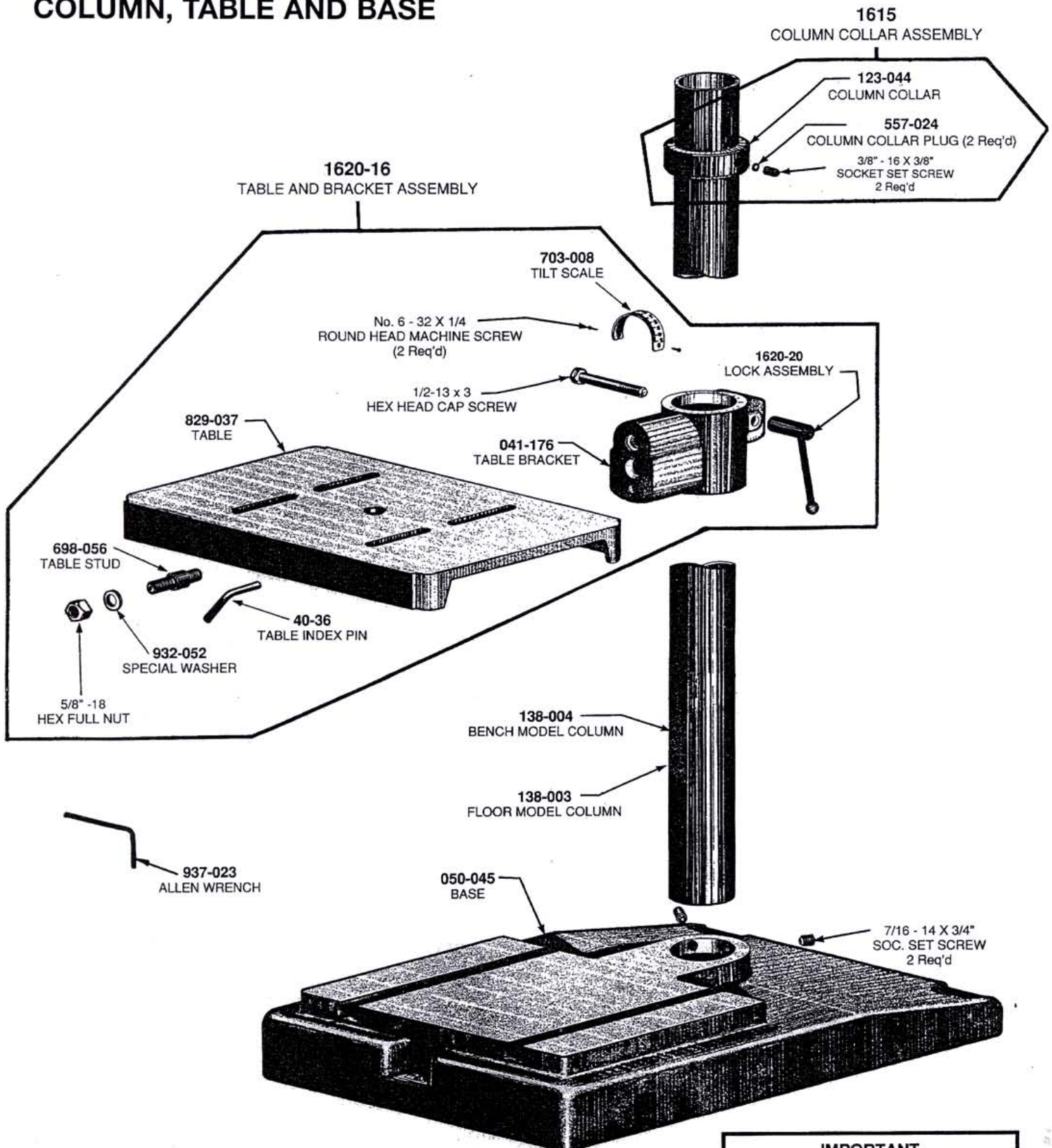
Figure 6

## Quill take-up

Front of drill press head is split - has two take-up screws set at factory to provide accurate fit between head and quill. This setting should not be disturbed unless play develops between quill and head. To eliminate play, tighten screws (A, fig. 6) - using correct size screw driver - until play has been removed. Move quill up and down in head to make sure it slides freely.

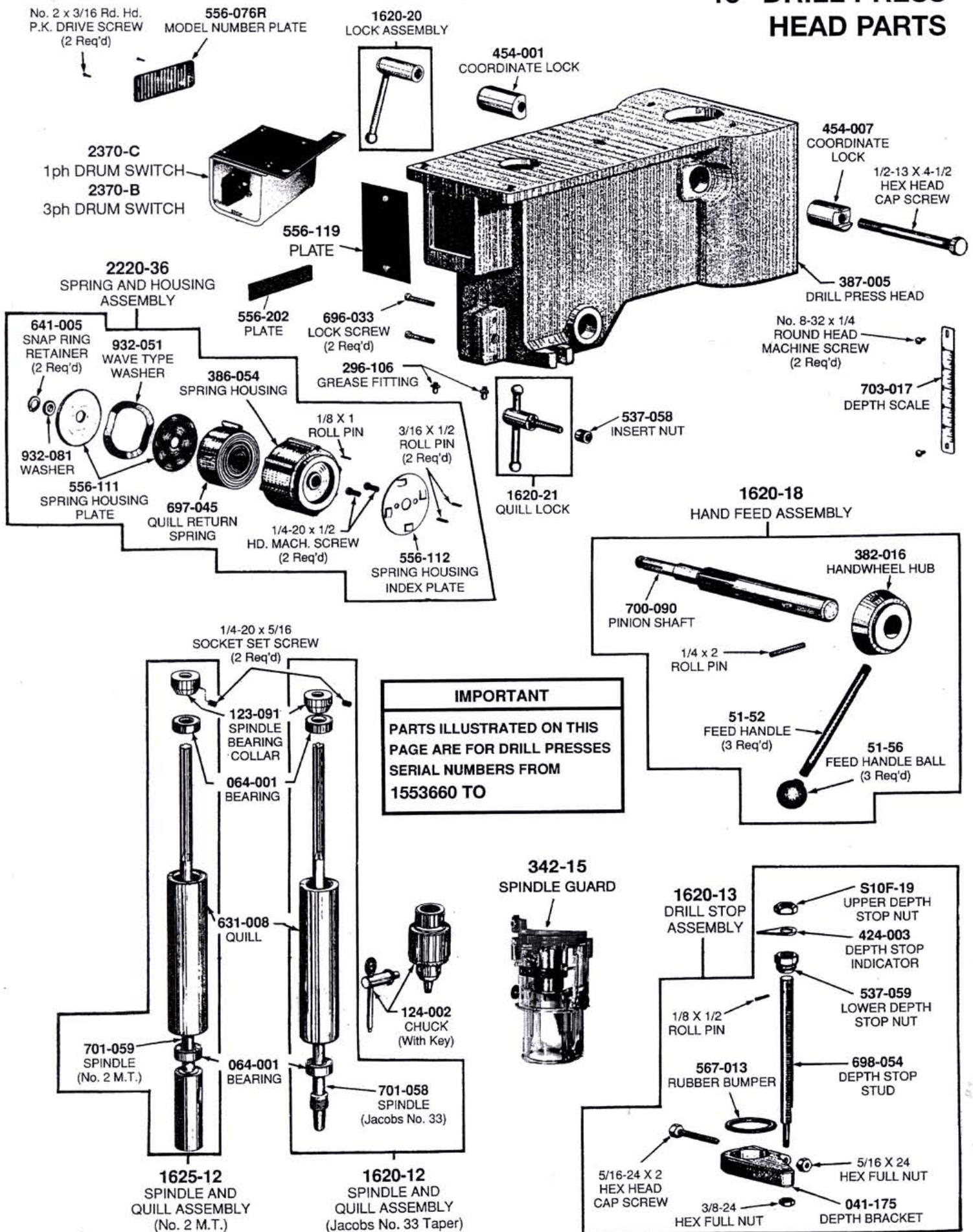


# 15" DRILL PRESS COLUMN, TABLE AND BASE



<b>IMPORTANT</b>
PARTS ILLUSTRATED ON THIS PAGE ARE FOR DRILL PRESSES SERIAL NUMBERS FROM 000200 TO

# 15" DRILL PRESS HEAD PARTS

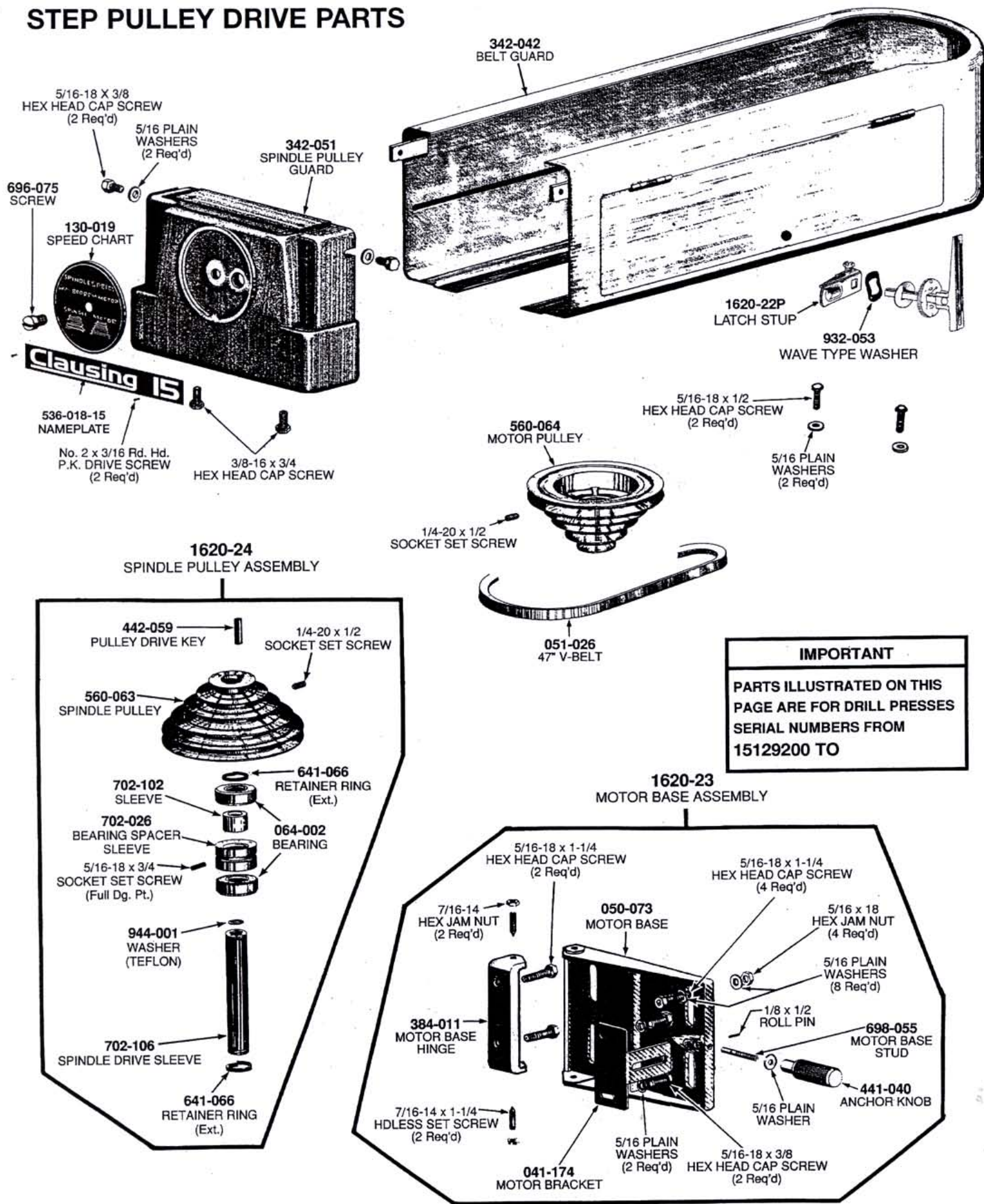


**IMPORTANT**

PARTS ILLUSTRATED ON THIS PAGE ARE FOR DRILL PRESSES SERIAL NUMBERS FROM 1553660 TO



# 15" DRILL PRESS STEP PULLEY DRIVE PARTS



## IMPORTANT

PARTS ILLUSTRATED ON THIS  
PAGE ARE FOR DRILL PRESSES  
SERIAL NUMBERS FROM  
15129200 TO



# 15" MULTIPLE SPINDLE TABLE PARTS

## OIL THROUGH TABLES AND LEGS

050-051 BASE, 22"x25" working surface. Single 15" head

No. 1692 TABLE, 20"x30" working surface. Takes two 15" heads

No. 1696 TABLE, 20"x60" working surface. Takes four 15" heads

No. 1697 END SECTION, Two sections provide 20"x90" working surface. Two takes six 15" heads

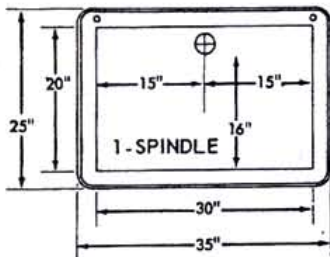
No. 1698 MID SECTION, 20"x30" working surface. Takes two 15" heads. Use with two No. 1697 End Sections.

No. 1699 TABLE LEGS, Two required for Nos. 1692 and 1696, three required for two No. 1697, and three for two No. 1697 with one No. 1698

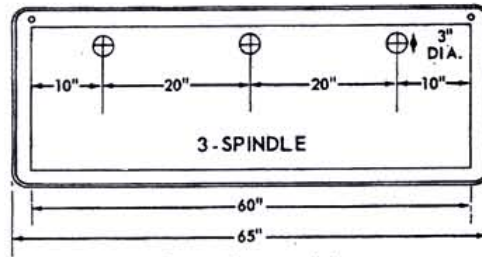
Tables are drilled for legs. Holes and column mounting brackets drilled on order to customer's specifications.

Head and components parts are illustrated on parts pages in front of this section.

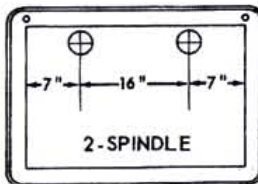
**NOTE:** Fastener are included with table legs



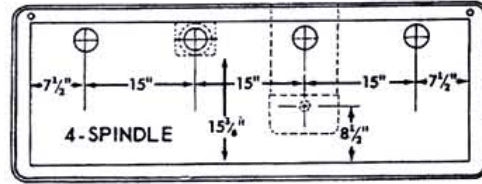
One piece table  
two legs required



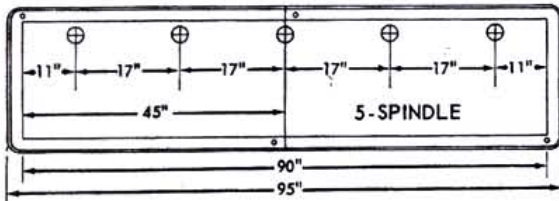
One piece table  
two legs required



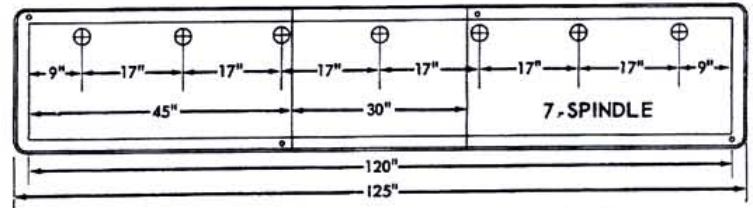
One piece table  
two legs required



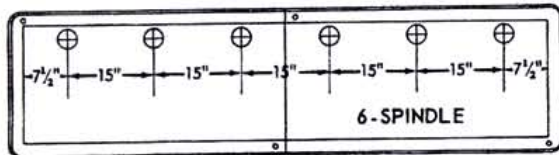
One piece table  
two legs required



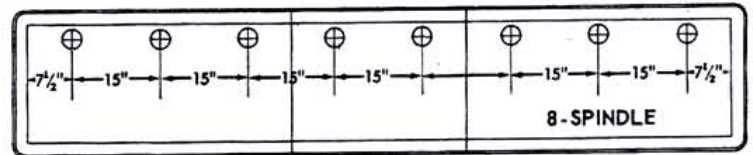
Two piece table, three legs required



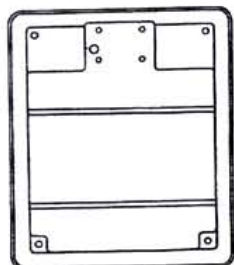
Three piece table, three legs required



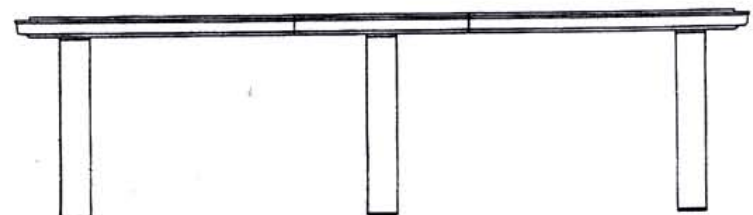
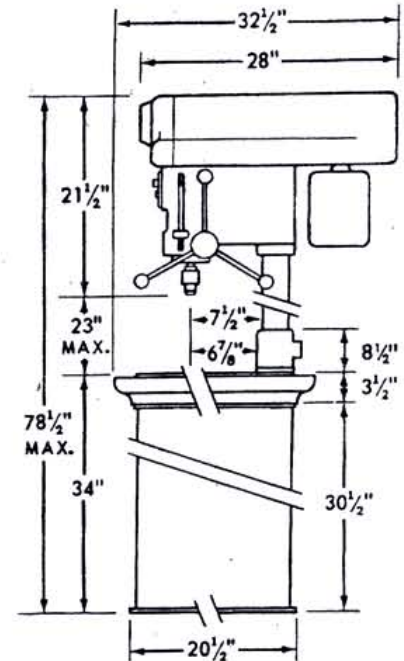
Two piece table, three legs required



Three piece table, three legs required

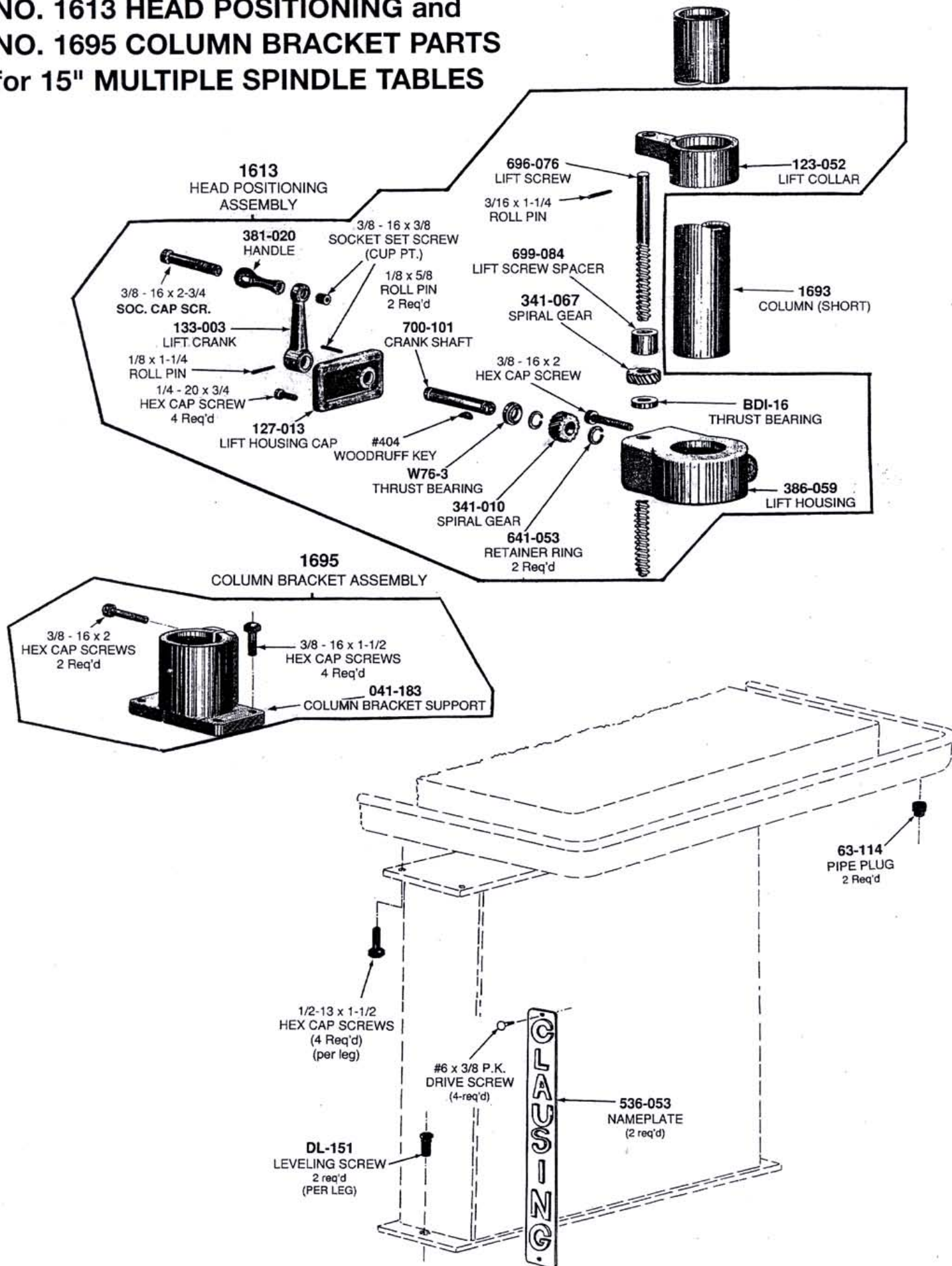


050-051  
BASE. PRODUCTION



No. 1699 TABLE LEG

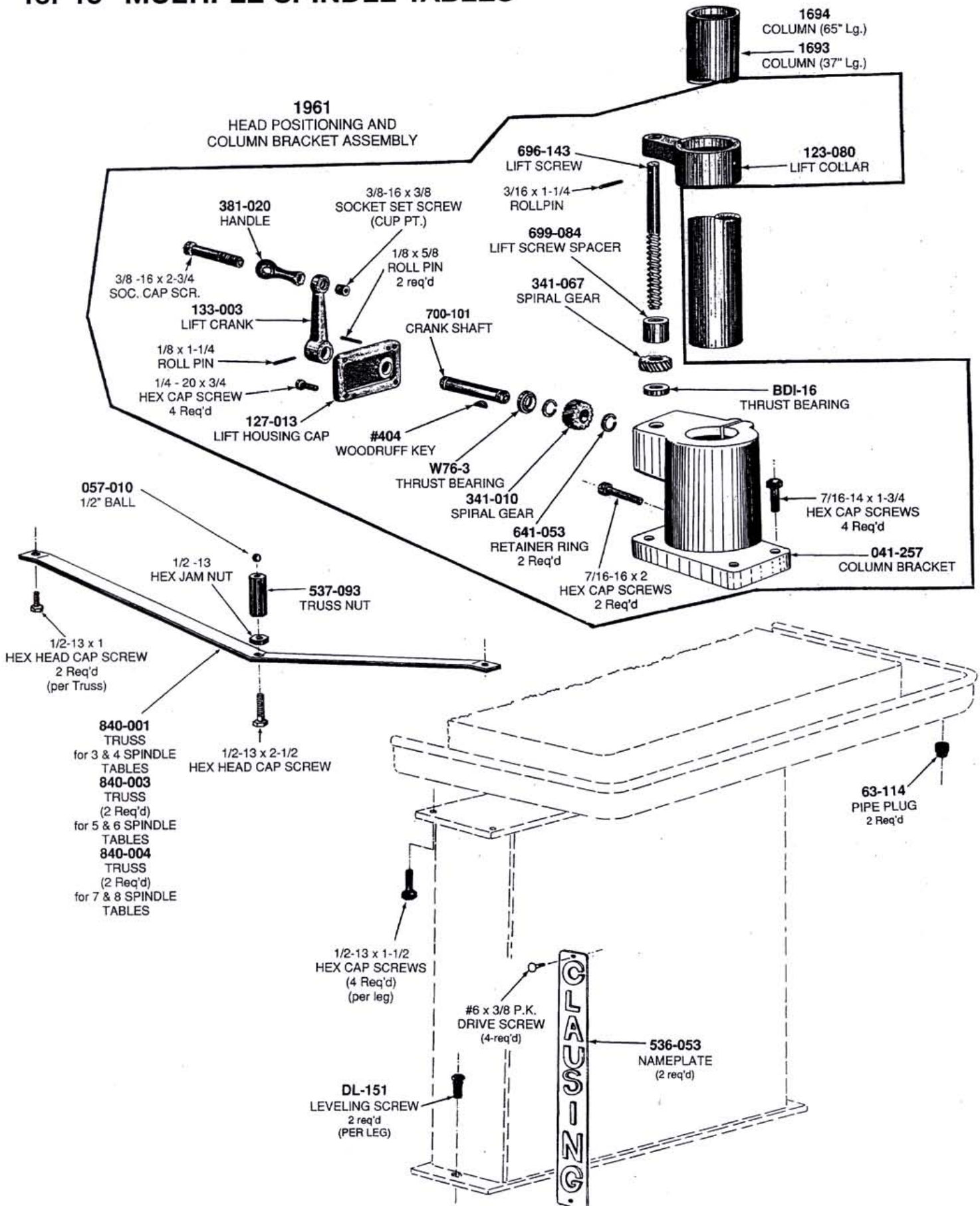
# NO. 1613 HEAD POSITIONING and NO. 1695 COLUMN BRACKET PARTS for 15" MULTIPLE SPINDLE TABLES





# NO. 1961 HEAD POSITIONING AND COLUMN BRACKET PARTS for 15" MULTIPLE SPINDLE TABLES

## 1961 HEAD POSITIONING AND COLUMN BRACKET ASSEMBLY





## The Clausing Difference

Frankly, there are a number of fine machine tool manufacturers... building high-quality products that will increase your productivity. **But...**there's one particularly important difference between Clausing and those other manufacturers... and that's the attention the customer gets **after the sale.**

## 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  
P.O. Box 877  
Goshen, IN 46526-0877

**Phone: (574) 533-0371**

**Fax: (574) 533-0403**

**e-mail: [info@clausingsc.com](mailto:info@clausingsc.com)**



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