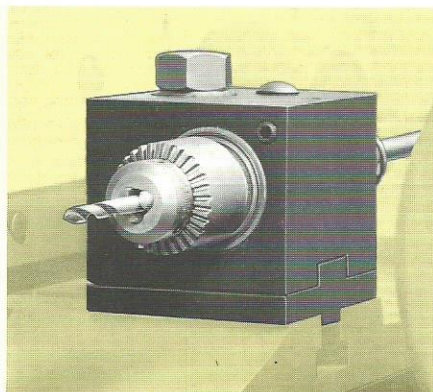


Cross Drilling Attachments

For 00, 2 and 3 Ultramatic Screw Machines and 2 Ultramatic Chucking Machines



The Cross Drilling Attachment is of advantage in making capstan screws, binding posts, pins and studs with cotter-pin holes, and similar work requiring one drilled hole at right angles to the axis of the piece.

The attachment is quickly located on the back cross slide of the machine. Vertical adjustment of the spindle provides for accurate alignment of the drill spindle with the center of the work.

Motors are 1/3 H.P. (.25kw) for the 00 size attachment, and 1/2 H.P. (.37kw) for the 2 and 3 size.

The drill speed is 4744 R.P.M. for both attachments. Sets of additional sheaves available give speeds of 1446 R.P.M. and 2372 R.P.M. to both attachments.

Capacities and Shipping Weights

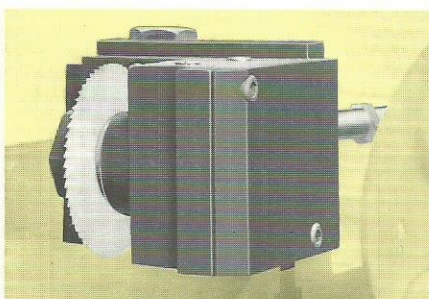
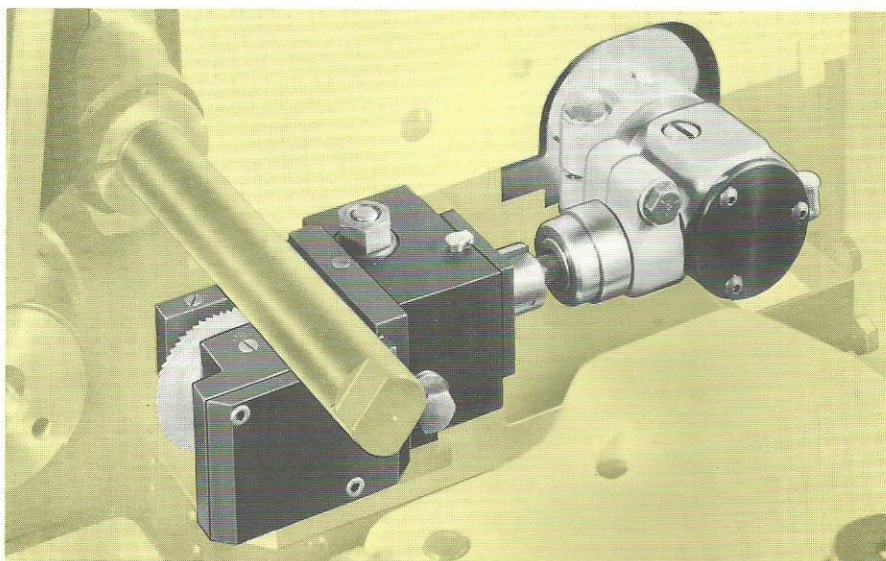
Machine Where Used	Maximum Drill Diameter		Shipping Weight, (Approx.)	
	Inches	mm	Lbs	kg
00	1/8††	3.2††	95	43
2, 2C or 3	1/4‡	6.4‡	120	54

††Maximum feed of drill in brass, .008" (.20mm) per revolution.

‡Maximum feed of drill in brass, .004" (.10mm) per revolution.

Rear Cross Slide Milling Attachment

For 00, 2 and 3 Ultramatic Screw Machines, and 2 Ultramatic Chucking Machines



This attachment permits the milling of flats, forms, or slots in the side of the workpiece while the machine spindle is held stationary by means of a brake furnished.

One or more cutters,* up to 2 3/4" (69.9mm) diameter, (with 5/8" (15.9mm) hole), can be accommodated on the attachment spindle.

Drive is through sheaves and positive drive belt from a 1/2 H.P. (.37kw) motor mounted on a bracket attached to the rear of the machine bed. Choice of either a 3450 R.P.M. motor or a 1725 R.P.M. motor.

With a 3450 R.P.M. motor and the sheaves furnished, the cutter speed is 280 R.P.M. Sheaves available at extra cost give speeds of 460 R.P.M. and 920 R.P.M. The 1725 R.P.M. motor and sheaves furnished give a speed of 140 R.P.M. Available sheaves give speeds of 230 R.P.M. and 460 R.P.M.

This attachment is available with or without an "outboard" bearing. The attachment with a single bearing is particularly useful for milling close to shoulders or close to the nose of the machine spindle.

Shipping weight (approx.) 123 lbs. (55.8kg).

*Cutters are available at extra cost (not furnished with attachment).

Application information concerning the 00 Ultramatic on request.