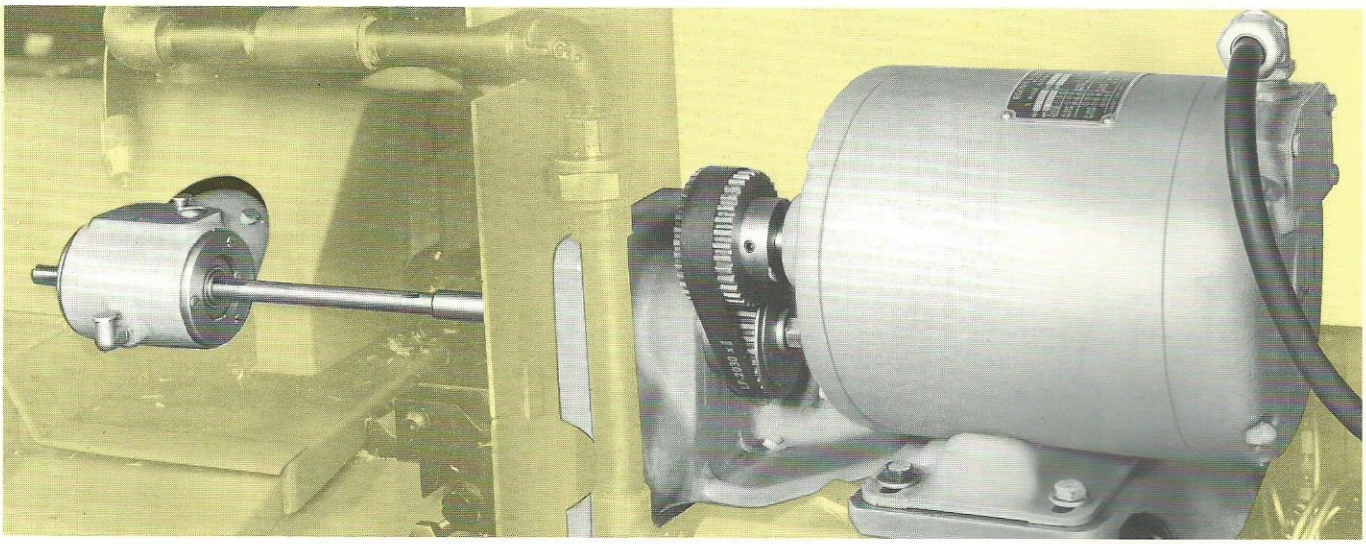
Turret Drilling Attachments

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



The Turret Drilling Attachment is available for either 6 or 8 hole turrets and serves to increase the speed of the drill relative to the work without increasing the speed of the work spindle. This attachment is of particular value in the production of pieces requiring the use of one or more small drills, for in order to obtain an economical cutting speed on such operations it is often necessary that the drilling be done at a much higher speed than that required for any of the other operations on the piece. The Turret Drilling Attachment accomplishes this by rotating the drill in a direction opposite to the direction of rotation of the stock.

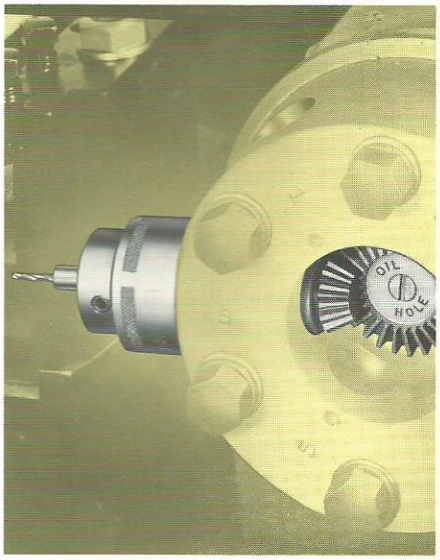
Several drills may be run at the same speed by using additional drill spindles in other turret holes not adjacent and meshing the bevel pinion on each spindle with the large bevel gear in the center, in the same manner as the single drill illustrated.

The spindle runs in bronze boxes and has a ball thrust bearing. The spindle assembly is inserted in one of the turret holes.

Drive is from a motor mounted on a bracket attached to the rear of the machine bed. The mechanism in no way limits indexing of the turret or movement of the turret slide.

Motors are ⅓ H.P. (.25kw) for the 00 size and ½ H.P. (.37kw) for the 2 and 3 size.

Drill speeds are 4366 R.P.M. for the 00 attachment and 4178 R.P.M. for the 2 and 3 attachment. Sets of additional sheaves available give speeds of 1331 R.P.M. and 2183 R.P.M. to the 00 size and speeds of 1274 R.P.M. and 2089 R.P.M. to the 2 and 3 size. Attachments to run at other than standard speeds are also available; information on application. Since the drill rotates opposite the work, the cutting speed of the drill equals the drill speed plus the work speed.



Capacities and Shipping Weights

Machine Where Used	Maximum Drill Diameter Inches	mm	Shipping Weight, (Approx.) Lbs	kg
00	3/32	2.4	95	43
2, 2C or 3	3/16*	4.8*	120	54

*Maximum feed of drill in brass in .008" (.20mm) per revolution relative to work.