

Clausing Drill Presses

600 Group

*Celebrating Over 105 Years
in the Machine Tool Business*

*Variable Speed 20" Single and
Multi-spindle, Belt Drive Industrial
Drill Presses*



Two Speed Variable Speeds 150-2000rpm
Variable Speeds 200-1300rpm
Variable Speeds 300-2000rpm

Clausing 20"

Drill Presses

Infinitely Variable Speed Countershaft Drive...

Dial to the best rpm for the tool and material while the job is running, with a Clausing Two Speed Variable Speed Drill Press.

150 to 2000 rpm... speeds to drill large holes, small holes to spot face, counterbore and ream.

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 Two Speed, production rated 1" in cast iron, 3/4" in steel *with optional power feed.*

Handle more jobs ... better, faster with a Clausing 20" Two Speed drill press.

More features for superior performance...

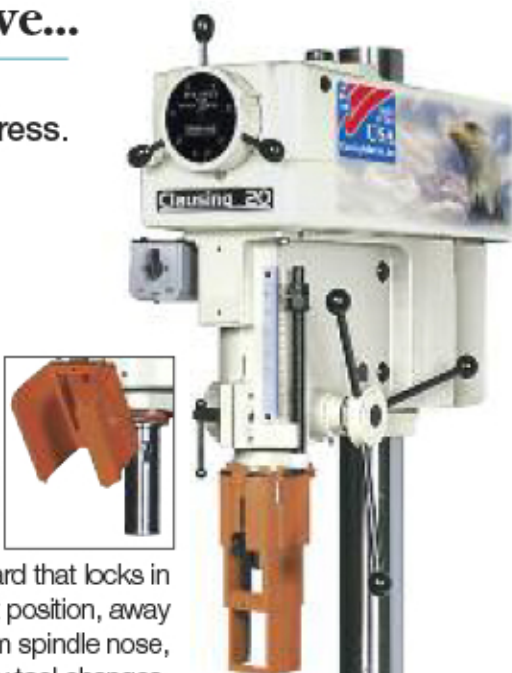
Heavy-duty precision head... all bearing surfaces are precision bored simultaneously for exact alignment. Eight ball bearings support the drive and spindle, lower spindle bearing has a double row to absorb both radial and thrust loads.

3 MT spindle... with 6-1/2" travel, 2-1/2" diameter quill and thread adjustable depth stop.

4" column with 3/16" thick wall for great rigidity and accuracy. Precision ground 22" x 19" coolant trough table, handles large parts and fixtures.

Clausing Drills are equipped with a

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



Style A

Floor Drill

22" x 19.5" (559 x 495mm)
Table, 66" (1676mm)
column standard and 1/2"
cored T-slots on 9" centers
for table and base
SEE MODELS

Style B

Head & Column Assembly
mounted on optional 20-501
Table Assembly* **SEE MODELS**



Powerful Countershaft Drive



Three V-belts and a cog belt transmit positive power to the spindle.

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

Specifications:

Capacity, hand feed	1.25" (31.75mm) dia.
Production rated, with optional power feed, 11/2 hp motor	1" (25.4mm) in cast iron 3/4" (19mm) in mild steel
Drill to center of circle	20" (508mm) dia.
Spindle nose	No. 3MT, 1.74" (44.2mm) OD
Spindle travel	6.5" (165mm)
Column	ground steel, 4" (102mm) dia., 3/8" (9.5mm) thick wall
Quill (ground steel)	2.5" (63.5mm) dia.
Quill return spring, capacity	40 lbs (18kg)
TABLE, DRILL PRESS Style A	
Working surface	22" x 19.5" (559 x 495mm)
Table slots	two, 15.5" (394mm) long, for .5" (12.7mm) T-bolt
Table travel, one setting	20" (508mm)
Spindle to table, maximum	33.125" (841mm)
BASE, DRILL PRESS Style A	
Working surface, ground	15.5" x 13" (394 x 330mm)
Base T-slots	two, 13" (330mm) long, for .5" T-bolt
Spindle to Base, maximum	43.375" (1102mm)
DRILL PRESS Style B	
Column bracket to center of spindle	9.25" (235mm)
Column to center of spindle	10" (254mm)
Spindle to table, max. distance	25.437" (646mm)
Column length	43" (1092mm)
Min. center to center distance	20" (508mm)
Motor ... NEMA Frame Sizes	182 and 184
Shipping weights, approximate, with motors	
Drill press Style A	630 lbs. (286kg)
Drill press Style B	390 lbs. (177kg)

FLOOR MODELS FURNISHED with: No. 3MT spindle; table elevating mechanism; switch; belt guard; spindle guard. Motors and switches are installed and wired, ready to connect to power.

Design and specifications are subject to change without notice.

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. 6 lbs.

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

No. 2377 REVERSING DRUM SWITCH for 1 & 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.

For 2-Speed Motor

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 lbs.

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

Overall Dimensions	Width	Depth	Height
Drill press Style A	22" (559mm)	36" (914mm)	69" (1753mm)
Drill Press Style B	20" (508mm)	3.25" (870mm)	51.625" (1311mm)

Infinitely Variable Speed Countershaft Drive

MODEL SELECTION CHART	Style A	Style B
Motor Furnished	Floor Drill 22" x 19" Table	Head & Column Assembly
Two Speed Infinitely Variable Speeds: 150-2000 rpm 1-1/2 - 3/4 Hp		
2-speed, 3-phase, 220v*	2276	2286-300
2-speed, 3-phase, 440v*	2277	2287-300
Infinitely Variable Speeds: 200-1300 rpm 1-1/2 Hp		
1 1/2 Hp, 3-ph, 1140 rpm	2275	2285-300
Infinitely Variable Speeds: 300-2000 rpm 1-1/2 Hp		
1 1/2 Hp, 1-ph, 1725 rpm	2272	2282-300
1 1/2 Hp, 3-ph, 1725 rpm	2274	2284-300

*Motor, 1 1/2-3/4 hp 1800/900 rpm, 60hz. 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, 60hz. Single-phase motors are capacitor-start, 115/230v, 60hz.

**Head and Column Models Furnished with: No. 3MT spindle, head elevating mechanism, column, mounting flange, switch and belt guard. Motor and switches are installed and wired, ready to connect to power.



****Style B**
Head & Column
Assembly,
43" (1092mm)
Column Standard

Clausing 20" (508mm) Multiple Spindle Drill Presses

Clousing multiple spindle drills can be custom built with up to four 20" heads. When ordering a multiple spindle drill press use the table model number below, plus the appropriate head and column assemblies for the corresponding number of heads.

Mix and match any number of drill heads as your requirements demand. **Example:** If you wish to have a 3 spindle drill press with three-20" heads you would order (1) 20-503 table assembly and (3) 2286-300 20" head assemblies. Tell us the order to mount the heads and you have the 3-spindle drill you require.

*If you have a special request, contact us for a quotation. *Special orders priced on application.*

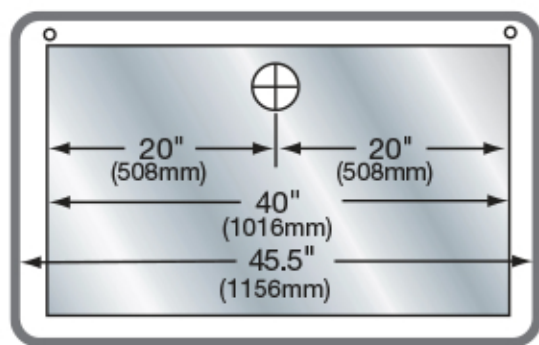


(1) 2286-300 Head & Column Assembly and
20-200 22" x 25" (559 x 635mm) Production Base



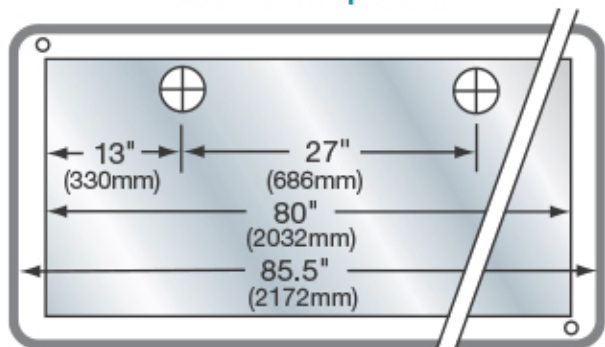
(4) 2286-300 Head & Column Assembly and
20-504 85.5" x 29.5" (2172 x 750mm) Table with Legs

20-501 • 1-Spindle



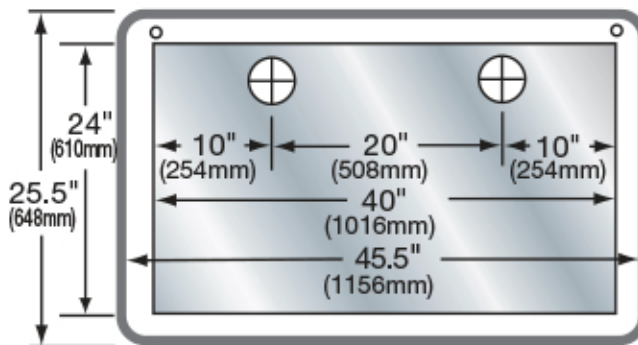
One piece table, two legs furnished

20-503 • 3-Spindle



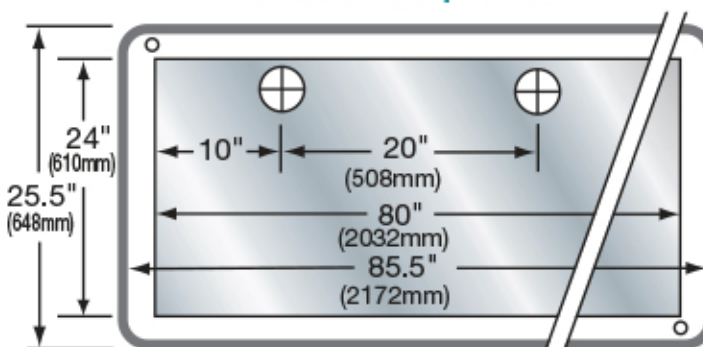
One piece table, two legs furnished

20-502 • 2-Spindle

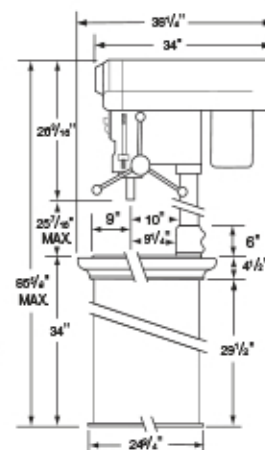


One piece table, two legs furnished

20-504 • 4-Spindle



One piece table, two legs furnished



Clausing 20" (508mm) Drill Accessories

Programmable Macro-Driller Power Feed



No. 2215-1 or 2215-1/440 (for 440v machines)

The Programmable Macro-Driller can be installed on any model of Clausing 20" drill press, either at time of purchase or as a retrofit. It allows you to automate hole drilling and is most effective on deep hole 'Peck' drilling. Peck drilling is used to prevent shavings from tangling with the drill bit and breaking it. The up and down motion of 'peck drilling' allows the drill to go slightly deeper into the material then with drawing to pull the chips out of the hole. The Programmable Macro-Driller is easy to program by using the keypad.

Programmable Macro-Driller Specification

Quill Travel:	6.4" (62mm)
Feedrate Range:	0.01 - 120 ipm (0.25 - 3000mm/min)
Peck Steps:	0.001" - 6.4" (0.02 - 162mm)
Maximum Pecks per Hole:	1400
Accurate Hole Depth:	±0.001" (0.02mm)
Maximum Quill Force:	1250 lbs. (568kg)
LED Numerals:	5/8" (15.9mm) High
Control Power:	220/230 volt, 50/60 Hz Single or Three Phase
Max. Drilling Capacity:	3/4" (19mm) in Cast Iron 5/8" (16mm) in Mild Steel

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 reversing drum switch for two speed drills Start and stop drill from foot pedal



Columns

No. 2294-AMT 66" (1676mm) Column in lieu of 43" (1092mm) Column 78 lbs. (35kg)

No. 2349-AMT 90" (2286mm) Column in lieu of 66" (1676mm) Column 107 lbs. (49kg)

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 lbs.

No. 7044-2 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. 7044-3 Coolant System. For three (3) spindle drills.

Like No. 7044-2 except arranged for 3 spindles.

No. 7044-4 Coolant System. For four (4) spindle drills.

Like No. 7044-3 except arranged for 4 spindles.



Drill Press Lamp

No. 7022 Lamp.

Cool burn-proof shade, aluminum reflector, switch, 19" (483mm) flexible arm, magnetic base, 6' (1.5m) cord and plug.

Drill Press LED Light

No. 20-LED LED Light

The New Clausing 120v LED Work Light mounts in the slot under the Drill Head behind the spindle.

The three ultra bright LED lights provides ample lighting over the entire work area.



Drill Chuck and Arbor



No. 1897 Key-Type Chuck. Takes 3/16" (4.8mm) to 3/4" (19mm) Drills.

Adapts to 3MT Spindle with No. 1898 arbor. 4 lbs. (1.8kg)

No. 1898 Arbor. Adapts No. 1897 to 3MT Spindle. 1 lb. (.5kg)

Electronic DRO

No. 20-900



- Easy to read LCD display
- Data output port
- 0" - 6" measuring range
- 0.005" (0.01mm) resolution
- 59 in./sec. measuring speed