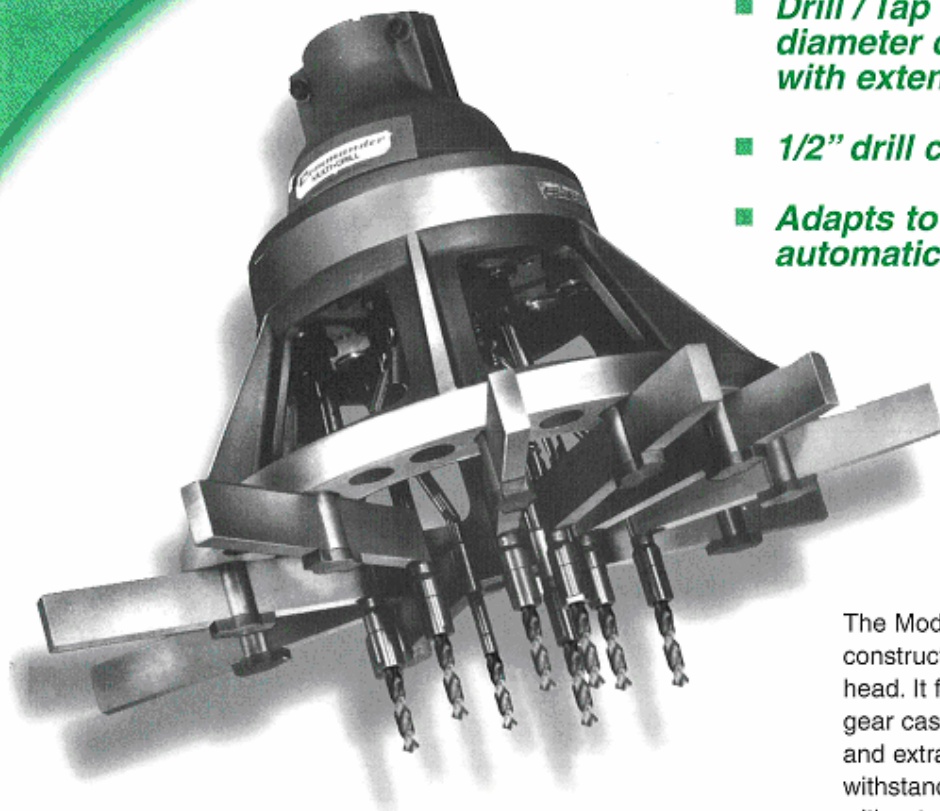


Commander®**MULTIPLE SPINDLE DRILL HEAD****MULTI-DRILL®**

1200 Sturdy, Low Profile Head with Heavy-Duty Capabilities



- Drill / Tap up to 19 holes in a 12" diameter circle or 25-1/2" circle with extension spindles
- 1/2" drill capacity
- Adapts to any drill press or automatic feed unit.



Proudly made in
Franklin, WI USA

The Model 1200 Multi-Drill is a ruggedly constructed, heavy-duty multiple spindle drill head. It features precision built anti-friction gear case drive with ball and roller bearings and extra-strength gear train. It is capable of withstanding high torque and thrust in keeping with rated capacity.

| MULTI-DRILL 1200 | ITEM # |
|-------------------------------|--------|
| Basic Unit without Adaptation | C70135 |
| Basic Unit with Adaptation | C70136 |

Commander Multi-Drill has on file spindle specifications for most machines. Please furnish us with the make and model number of the machine that our head will be adapted to. (See adaptations page) In some cases there may be an additional charge for adaptation.

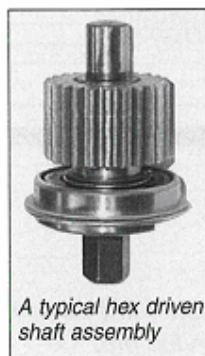
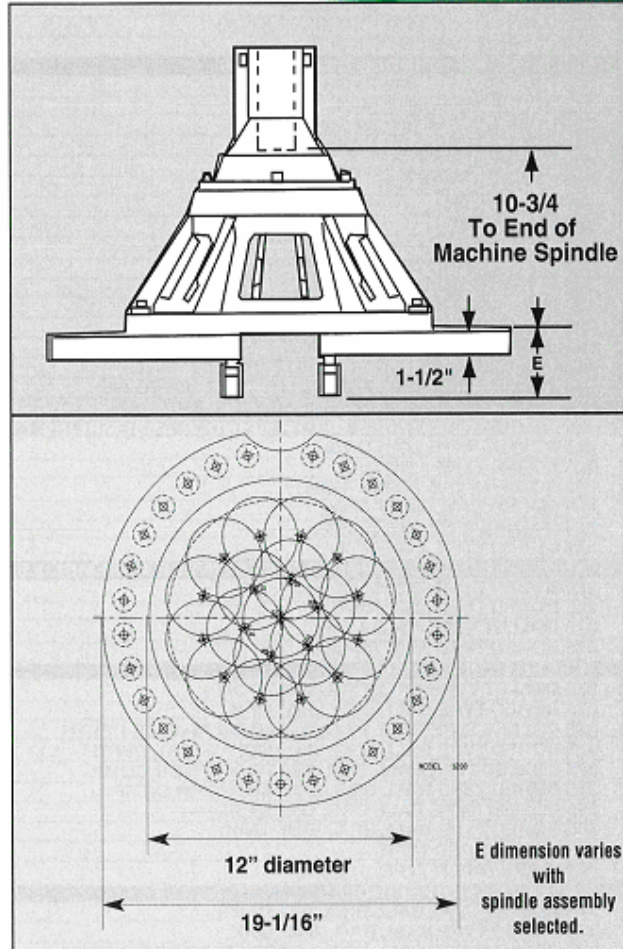
| SPECIFICATIONS | |
|---|---------------|
| Maximum Drilling Area | 11-7/8" diam. |
| Minimum Center Distance | 7/16" diam. |
| Maximum Number of Spindles | 19 |
| Drill Capacity in mild steel | 1/2" |
| Maximum Drilling Area w/ Extension Spindles | 25-1/2" |
| Maximum Horsepower Transmitted | 5 |
| Maximum Torque Transmitted | 70 inch/lbs. |
| Maximum Spindle RPM | 1800 |
| Maximum Drill Press RPM | 1800 |
| Speed Ratio | 1:1 |

www.commandermultidrill.com

Ideal for adaptation to drill presses, tapping machines, automatic self-feed drill and tap units, and special machines

- Spindle capacity 1/2" in mild steel
- Heavy-duty gear case allows drilling up to to 19 holes, 12" diameter circle, or up to 25-1/2" diameter circle with extension spindles.
- Can be used on a 17" drill press – contoured to fit.
- Close center capacity.
- Operate in any position: upright, inverted or horizontal.
- Adapt to any drilling machine. Standard adapter caps available to fit most popular drilling machines.
- These drill heads can be used for multiple tapping by use of a motor reversing unit.
- Minimum maintenance required.
- Extremely versatile, maximum flexibility of application.
- One center hex drive and six driven shaft assemblies are included. (For additional driven shaft assemblies use item #C71230).

The maximum angularity of universal joint assemblies should be no more than 22 degrees to obtain best service life.



A typical hex driven shaft assembly

*** Multi-Drill Terminology...
Hex Pick-Off**

A Hex Pick-Off is the hex protruding from the multi-drill gear case that a universal joint spindle can be attached to.

The model 1200 includes 7 hex pick-offs with the basic unit. You may add up to 12 more pick-offs for a maximum total of 19 spindles.

MULTI-DRILL® 1200 ADJUSTABLE ARM



| Minimum Center Distances | | Spindle Length "E" Dimension <i>see drawing</i> | Adjustable Arm | |
|--------------------------|--------|--|----------------|--------|
| Plain | Booted | | Plain | Booted |

| STANDARD COLLET TYPE SPINDLE ASSEMBLIES | | | | | |
|---|-------|-------|---------|--------|--------|
| 125 COLLET TYPE 1/32 TO 1/8 | 1/2 | ----- | 3-5/16 | C74820 | N/A |
| 125 COLLET TYPE 1/32 TO 1/8 | 7/16 | ----- | 3-5/16 | C74909 | N/A |
| 125 BORED TYPE .255" MAX. | 1/2 | ----- | 3-1/8 | C74825 | N/A |
| 265 COLLET TYPE 1/32 TO 17/64 | 11/16 | ----- | 3-9/16 | C74826 | N/A |
| 265 COLLET TYPE 1/32 TO 17/64 | 5/8 | ----- | 3-9/16 | C74911 | N/A |
| 265 BORED TYPE .4375" MAX. | 5/8 | ----- | 3-1/8 | C74912 | N/A |
| 375 COLLET TYPE 1/32 TO 3/8 | 5/8 | 1-1/4 | 3-5/8 | C74828 | C75828 |
| 375 BORED TYPE .500" MAX. | 5/8 | 1-1/4 | 3-3/8 | C74830 | C75830 |
| #1 MORSE TAPER TYPE | 5/8 | 1-1/4 | | C74831 | C75831 |
| 375 Q.T. FLOATING TAP SPINDLES | 7/8 | 1-1/4 | P.O.A. | P.O.A. | P.O.A. |
| 375 Q.C. FLOATING TAP SPINDLES (BILZ) | 7/8 | 1-1/4 | P.O.A. | P.O.A. | P.O.A. |
| 375 PLAIN FLOATING SPINDLES | 7/8 | 1-1/4 | P.O.A. | P.O.A. | P.O.A. |
| BALL BEARING SPINDLE ASSEMBLIES | | | | | |
| 375 COLLET TYPE 1/32 TO 3/8 | ----- | 1-1/4 | 3-3/16 | ----- | C85330 |
| 375 BORED TYPE .500" MAX. | ----- | 1-1/4 | 3-3/16 | ----- | C85466 |
| 500 COLLET TYPE 1/32 TO 1/2 | ----- | 1-1/4 | 3-5/8 | ----- | C85335 |
| 500 BORED TYPE .625" MAX. | ----- | 1-1/4 | 3-5/8 | ----- | C85468 |
| #1 MORSE TAPER TYPE | ----- | 1-1/4 | 4-9/16 | ----- | C85331 |
| #2 MORSE TAPER TYPE | ----- | 1-1/4 | 4-15/16 | ----- | C85332 |
| 5/8 ASA SPINDLE | ----- | 1-1/4 | 5-5/16 | ----- | C85333 |
| 7/8 ASA SPINDLE | ----- | 1-1/4 | 5-15/16 | ----- | C85334 |
| STUB ASA COLLET TYPE (SPECIFY BORE) | ----- | 1-1/4 | 4-5/16 | ----- | C85406 |
| 375 PLAIN FLOATING TAP SPINDLES | ----- | 1-1/4 | 3-3/16 | ----- | C85394 |
| 375 Q.T. FLOATING TAP SPINDLES | ----- | 1-1/4 | 3-3/16 | ----- | C85397 |
| 375 Q.C. FLOATING TAP SPINDLES (BILZ) | ----- | 1-1/4 | 3-5/8 | ----- | C85377 |
| 500 Q.T. FLOATING TAP SPINDLES | ----- | 1-1/4 | 3-5/8 | ----- | C85395 |
| ADJUSTABLE DEPTH 375 COLLET TYPE 1/32 TO 3/8 | ----- | 1-1/4 | 4-3/8 | ----- | C85421 |
| ADJUSTABLE DEPTH 375 BORED TYPE .500" MAX. | ----- | 1-1/4 | 4-3/8 | ----- | C85489 |
| PITCH COMPENSATING 375 COLLET TYPE 1/32 TO 3/8 | ----- | 1-1/4 | 4-1/8 | ----- | C85431 |
| PITCH COMPENSATING 375 BORED TYPE .500" MAX. | ----- | 1-1/4 | 4-1/8 | ----- | C85490 |
| STANDARD ADJUSTABLE DEPTH SPINDLE ASSEMBLIES | | | | | |
| 125 COLLET TYPE 1/32 TO 1/8 | 1/2 | ----- | 3-5/8 | C74852 | ----- |
| 125 BORED TYPE .255" MAX. | 1/2 | ----- | 3-5/8 | C74815 | ----- |
| 265 COLLET TYPE 1/32 TO 17/64 | 11/16 | ----- | 3-5/8 | C74853 | ----- |
| 265 BORED TYPE .4375" MAX. | 11/16 | ----- | 3-5/8 | P.O.A. | ----- |
| 375 COLLET TYPE 1/32 TO 3/8 | 7/8 | 1-1/4 | 3-5/8 | C74854 | C75854 |
| 375 BORED TYPE .500" MAX. | 7/8 | 1-1/4 | 3-5/8 | C74857 | C75857 |
| STANDARD PITCH COMPENSATING SPINDLE ASSEMBLIES | | | | | |
| 125 BORED TYPE .255" MAX. | 1/2 | ----- | 3-5/8 | C74862 | ----- |
| 265 BORED TYPE .255" MAX. | 11/16 | ----- | 3-7/8 | C74864 | ----- |
| 375 COLLET TYPE #0-5/16 TAP | 7/8 | 1-1/4 | 3-7/8 | C74865 | C75865 |
| 375 BORED TYPE 5/16" TAP MAX. | 7/8 | 1-1/4 | 3-7/8 | P.O.A. | P.O.A. |
| 3" EXTENSION SPINDLES | | | | | |
| 375 COLLET TYPE BALL BRG. 1/32 TO 3/8 | 1-3/8 | 1-3/8 | 3-5/8 | C74844 | C75844 |
| 375 BORED TYPE BALL BRG. .500" MAX. | 1-3/8 | 1-3/8 | 3-3/8 | C74846 | C75846 |
| 375 COLLET TYPE BALL BRG. 1/32 TO 3/8 ADJUST. DEPTH | 1-3/8 | 1-3/8 | 3-3/8 | C74850 | C75850 |
| 375 BORED TYPE BALL BRG. .500 MAX ADJUST. DEPTH | 1-3/8 | 1-3/8 | 3-3/8 | C74849 | C75849 |
| 375 COLLET TYPE BALL BRG. 1/32 TO 3/8 PITCH COMP. | 1-3/8 | 1-3/8 | 3-3/8 | C74851 | C75851 |
| 375 BORED TYPE BALL BRG. .500 MAX PITCH COMP | 1-3/8 | 1-3/8 | 3-3/8 | P.O.A. | P.O.A. |
| 500 COLLET TYPE BALL BRG. 1/32 TO 1/2 | 1-3/8 | 1-3/8 | 4-9/16 | C74877 | C75877 |
| 500 BORED TYPE BALL BRG. .625" MAX. | 1-3/8 | 1-3/8 | 3-13/16 | C74878 | C75878 |
| #1 MORSE TAPER TYPE | 1-3/8 | 1-3/8 | 4-11/16 | C74875 | C75875 |
| #2 MORSE TAPER TYPE | 1-3/8 | 1-3/8 | 5-7/16 | C74876 | C75876 |
| 6 3/4" EXTENSION SPINDLES | | | | | |
| 375 COLLET TYPE BALL BRG. 1/32 TO 3/8 | 1-3/8 | 1-3/8 | 3-5/8 | C74836 | C75836 |
| 375 BORED TYPE BALL BRG. .500" MAX. | 1-3/8 | 1-3/8 | 3-3/8 | C74838 | C75838 |
| 375 COLLET TYPE BALL BRG. 1/32 TO 3/8 ADJUST. DEPTH | 1-3/8 | 1-3/8 | 3-3/8 | C74840 | C75840 |
| 375 BORED TYPE BALL BRG. .500 MAX ADJUST. DEPTH | 1-3/8 | 1-3/8 | 3-3/8 | C74842 | C75842 |
| 375 COLLET TYPE BALL BRG. 1/32 TO 3/8 PITCH COMP. | 1-3/8 | 1-3/8 | 3-3/8 | C74843 | C75843 |
| 375 BORED TYPE BALL BRG. .500 MAX PITCH COMP | 1-3/8 | 1-3/8 | 3-3/8 | P.O.A. | P.O.A. |
| 500 COLLET TYPE BALL BRG. 1/32 TO 1/2 | 1-3/8 | 1-3/8 | 4-9/16 | C74873 | C75873 |
| 500 BORED TYPE BALL BRG. .625" MAX. | 1-3/8 | 1-3/8 | 3-13/16 | C74874 | C75874 |
| #1 MORSE TAPER TYPE BALL BRG. | 1-3/8 | 1-3/8 | 4-11/16 | C74871 | C75871 |
| #2 MORSE TAPER TYPE BALL BRG. | 1-3/8 | 1-3/8 | 5-7/16 | C74872 | C75872 |
| VERSA SPINDLES | | | | | |
| 3/8" CAPACITY | | | | | C80145 |
| 1/2" CAPACITY | | | | | C80150 |



The maximum angularity of universal joint assemblies should be no more than 22 degrees to obtain best service life.

MULTI-DRILL® 1200 SLIP SPINDLE



| Minimum Center Distances | | Spindle Length "E" Dimension <i>see drawing</i> | Slip Spindle | |
|--------------------------|--------|--|--------------|--------|
| Plain | Booted | | Plain | Booted |

| STANDARD COLLET TYPE SPINDLE ASSEMBLIES | | | | | |
|--|-------|-------|---------|--------|--------|
| 125 COLLET TYPE 1/32 TO 1/8 | 1/2 | ----- | 3-5/16 | C74549 | P.O.A. |
| 125 COLLET TYPE 1/32 TO 1/8 | 7/16 | ----- | 3-5/16 | P.O.A. | ----- |
| 125 BORED TYPE .255" MAX. | 1/2 | ----- | 3-1/8 | C74554 | P.O.A. |
| 265 COLLET TYPE 1/32 TO 17/64 | 11/16 | ----- | 3-9/16 | P.O.A. | P.O.A. |
| 265 COLLET TYPE 1/32 TO 17/64 | 5/8 | ----- | 3-9/16 | P.O.A. | P.O.A. |
| 265 BORED TYPE .4375" MAX. | 5/8 | ----- | 3-1/8 | P.O.A. | P.O.A. |
| 375 COLLET TYPE 1/32 TO 3/8 | 5/8 | 1-1/4 | 3-5/8 | C74555 | C75555 |
| 375 BORED TYPE .500" MAX. | 5/8 | 1-1/4 | 3-3/8 | C74557 | C75557 |
| #1 MORSE TAPER TYPE | 5/8 | 1-1/4 | | C74598 | C75598 |
| 375 Q.T. FLOATING TAP SPINDLES | 7/8 | 1-1/4 | P.O.A. | P.O.A. | P.O.A. |
| 375 Q.C. FLOATING TAP SPINDLES (BILZ) | 7/8 | 1-1/4 | P.O.A. | P.O.A. | P.O.A. |
| 375 PLAIN FLOATING SPINDLES | 7/8 | 1-1/4 | P.O.A. | P.O.A. | P.O.A. |
| BALL BEARING SPINDLE ASSEMBLIES | | | | | |
| 375 COLLET TYPE 1/32 TO 3/8 | ----- | 1-1/4 | 3-3/16 | ----- | C85346 |
| 375 BORED TYPE .500" MAX. | ----- | 1-1/4 | 3-3/16 | ----- | C85471 |
| 500 COLLET TYPE 1/32 TO 1/2 | ----- | 1-1/4 | 3-5/8 | ----- | C85351 |
| 500 BORED TYPE .625" MAX. | ----- | 1-1/4 | 3-5/8 | ----- | C85473 |
| #1 MORSE TAPER TYPE | ----- | 1-1/4 | 4-9/16 | ----- | C85347 |
| #2 MORSE TAPER TYPE | ----- | 1-1/4 | 4-15/16 | ----- | C85348 |
| 5/8 ASA SPINDLE | ----- | 1-1/4 | 5-5/16 | ----- | C85349 |
| 7/8 ASA SPINDLE | ----- | 1-1/4 | 5-15/16 | ----- | C85350 |
| STUB ASA COLLET TYPE (SPECIFY BORE) | ----- | 1-1/4 | 4-5/16 | ----- | C85406 |
| 375 PLAIN FLOATING TAP SPINDLES | ----- | 1-1/4 | 3-3/16 | ----- | C85472 |
| 375 Q.T. FLOATING TAP SPINDLES | ----- | 1-1/4 | 3-3/16 | ----- | C85374 |
| 375 Q.C. FLOATING TAP SPINDLES (BILZ) | ----- | 1-1/4 | 3-5/8 | ----- | C85377 |
| 500 Q.T. FLOATING TAP SPINDLES | ----- | 1-1/4 | 3-5/8 | ----- | C85375 |
| ADJUSTABLE DEPTH 375 COLLET TYPE 1/32 TO 3/8 | ----- | 1-1/4 | 4-3/8 | ----- | C85418 |
| ADJUSTABLE DEPTH 375 BORED TYPE .500" MAX. | ----- | 1-1/4 | 4-3/8 | ----- | C85489 |
| PITCH COMPENSATING 375 COLLET TYPE 1/32 TO 3/8 | ----- | 1-1/4 | 4-1/8 | ----- | C85428 |
| PITCH COMPENSATING 375 BORED TYPE .500" MAX. | ----- | 1-1/4 | 4-1/8 | ----- | C85492 |
| STANDARD ADJUSTABLE DEPTH SPINDLE ASSEMBLIES | | | | | |
| 125 COLLET TYPE 1/32 TO 1/8 | 1/2 | ----- | 3-5/8 | C74562 | ----- |
| 125 BORED TYPE .255" MAX. | 1/2 | ----- | 3-5/8 | C74590 | ----- |
| 265 COLLET TYPE 1/32 TO 17/64 | 11/16 | ----- | 3-5/8 | P.O.A. | ----- |
| 265 BORED TYPE .4375" MAX. | 11/16 | ----- | 3-5/8 | P.O.A. | ----- |
| 375 COLLET TYPE 1/32 TO 3/8 | 7/8 | 1-1/4 | 3-5/8 | C74563 | C75563 |
| 375 BORED TYPE .500" MAX. | 7/8 | 1-1/4 | 3-5/8 | C74565 | C75565 |
| STANDARD PITCH COMPENSATING SPINDLE ASSEMBLIES | | | | | |
| 125 BORED TYPE .255" MAX. | 1/2 | ----- | 3-5/8 | C74562 | ----- |
| 265 BORED TYPE .255" MAX. | 11/16 | ----- | 3-7/8 | P.O.A. | ----- |
| 375 COLLET TYPE #0-5/16 TAP | 7/8 | 1-1/4 | 3-7/8 | C74573 | C75573 |
| 375 BORED TYPE 5/16" TAP MAX. | 7/8 | 1-1/4 | 3-7/8 | P.O.A. | P.O.A. |

| HEAD ACCESSORIES | ITEM # |
|----------------------------|----------------|
| FIXED POSITION PLATE | C71046 |
| BORED HOLES | C71135 |
| GUIDE RODS AND BUSHED ARMS | C71211/ C71212 |



The maximum angularity of universal joint assemblies should be no more than 22 degrees to obtain best service life.



Fixed Position Plate



Guide Rods & Bushed Arms