COLUMN GUIDE BAR ASSEMBLY

The column guide bar assembly clamps to round column drilling machine, and stabilizes the unit against possible machine quill looseness.

A connecting arm attached to the drill head, riding up and down on the guide bar through two ball bearing rollers, provides rigidity for precision drilling and tapping. Select from appropriate tables.

GUIDE RODS AND BUSHED ARMS

Guide rods and bushed arms are available for all Universal joint models of Commander Multi-Drill drill heads and Multi-Tappers (except the 300, which has specially designed guide rods and bushed arms), increasing stability and rigidity beyond that obtainable in the drilling machine being used. Rods mount on the drill press table and extend through the adjustable arm bushing.

NOTE: The use of Guide Rods and Bushed Arms with a Fixed Position Plate probably will require alteration of the plate to provide clearance for the arms.

Ordering Information:

Guide rods (pair) .................. Item C71211
Bushed arms (pair) for all universal joint heads .................. Item C71212

FIXED POSITION PLATE

Fixed position plates and lock-in-position spindle cartridges provide the user with the advantages of a fixed center drill head, without any of the disadvantages. The fixed position plate is bored to the hole pattern to be drilled, then the lock-in-position spindle cartridges are inserted. Fixed position plates provide fast and accurate set-up for re-runs. When ordering fixed position plate bored include diagram of desired hole pattern, and specify spindle being used.

<table>
<thead>
<tr>
<th>FIXED POSITION PLATES</th>
<th>BORER HOLE DIMENSIONS</th>
<th>ORDERING INFORMATION</th>
</tr>
</thead>
<tbody>
<tr>
<td>500, 700, 850, 875, 900</td>
<td>MULTI-DRILL: 125</td>
<td>UNBored PLATE: 875</td>
</tr>
<tr>
<td>3-22, 4-15, 8-12, 1200</td>
<td>3-32</td>
<td>3-32</td>
</tr>
</tbody>
</table>

Bored Hole Dimensions Required for Fixed Position Plates:

- Multi-Drill: 4370/.4375
- Standard S/A: .670/.475
- Ball Bore: .670/.475
- Heavy-Duty S/A: 1.002/.0815
- .012/.0015
- .005/.015

Typical Lock-in-Position Spindle Assembly

*No T-Wrench needed.