

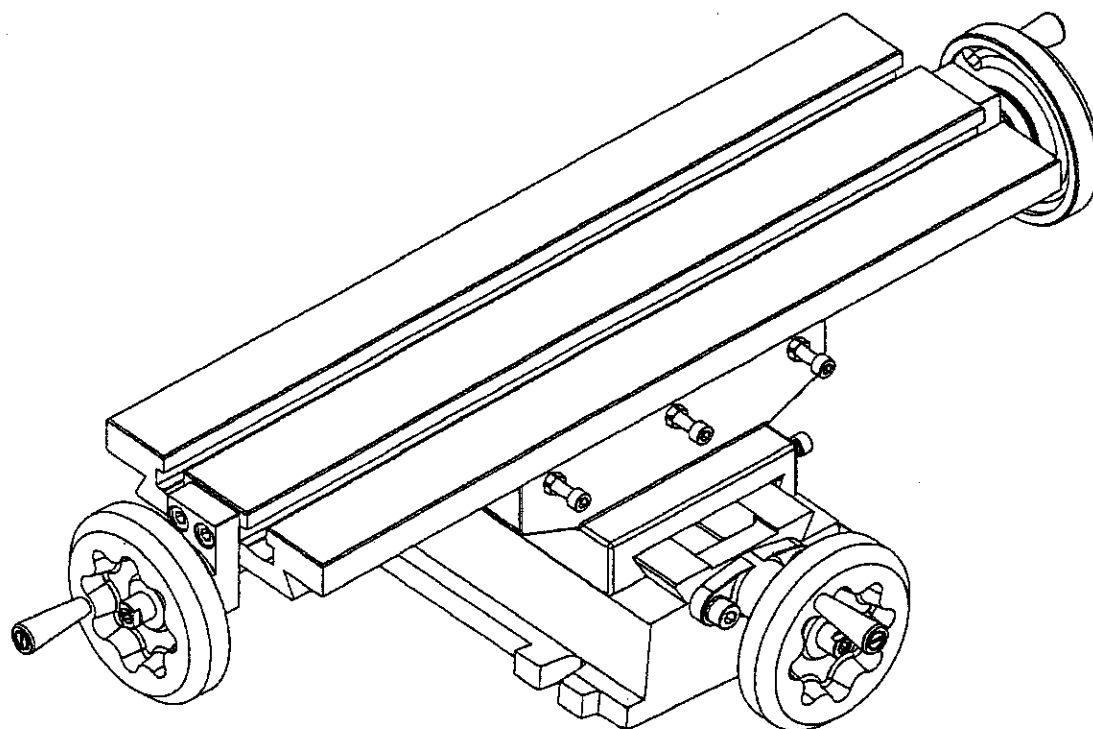
Operator's Manual

CRAFTSMAN[®]

COMPOUND MILLING TABLE

Model No.

351.275931



CAUTION: Read and follow all Safety Rules and Operating Instructions before First Use of this Product.

- Safety
- Assembly
- Operation
- Maintenance
- Parts List

Sears, Roebuck and Co., Hoffman Estates, IL 60179 U.S.A.

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WARRANTY

FULL ONE YEAR WARRANTY

If this product fails due to a defect in material or workmanship within one year from the date of purchase, Sears will at its option repair or replace it free of charge.

Contact your nearest Sears Service Center to arrange for product repair, or return this product to place of purchase for replacement.

If this product is used for commercial or rental purposes, this warranty will apply for 90 days from the date of purchase.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

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SAFETY RULES

- Understand and follow all safety instructions supplied with drill press, or other machines on which milling table is used.
- Mount table to work surface by bolting or clamping base securely in four mounting locations.
- Be alert and think clearly. Always check your set up; for example, rotate accessory by hand before applying power.
- Make sure workpieces, guides, fences, or power heads are securely clamped, as applicable. Do not force accessory. Be positive you are feeding in right direction.
- Never feed "free-hand" without table guide and/or guides. Use vises or appropriate clamps to secure each workpiece, securely clamping them to work surface.
- Use only accessories designed for mill. Keep power tool guard in place. Dress properly. Do not wear jewelry, gloves, or loose clothing.
- Wear a face shield or safety glasses. Never place hands in jeopardy.

UNPACKING

Check for shipping damage. If damage has occurred, a claim must be filed with carrier immediately. Check for completeness. Immediately report missing parts to dealer.

NOTE: The tool has been coated with a protective coating in order to ensure proper fit and operation, the coating must be removed. Removed coating with mild solvents, such as mineral spirits, and a soft cloth. Nonflammable solvents are recommended. After cleaning, cover all exposed surfaces with a light coating of oil. Be sure to lubricate table as described in "Maintenance".

WARNING: Never use highly volatile solvents. Avoid getting cleaning solution on paint as it may tend to deteriorate these finishes. Use soap and water on painted components.

ASSEMBLY

Refer to Figure 1.

- Attach each handle (Key No. 9) to handwheel (Key No. 13) with handle screw (Key No. 10).
- Tighten each screw securely.
- Attach one handwheel (Key No. 13) to cross feed screw (Key No. 21) with key (Key No. 5) and locking nut (Key No. 12).
- Attach two handwheels to longitudinal feed screw (Key No. 7) with keys and locking nuts.
- Tighten each locking nut securely.

OPERATION

DESCRIPTION

Craftsman Compound Milling Table is manufactured from cast iron and steel. The table fits most drill presses. Milling operations can be done by moving work right and left (longitudinal), or front and back (cross) directions. The table can also be used to accurately position or index a workpiece under a drill but when not doing milling operations. A U-clamp hold down set is included with the table.

- The Milling Table is heavy. Do not lift it by the crank handles.
- Make sure that drill press table is fastened securely, does not shift in any direction, and is clean and free of nicks and burrs.
- Center table on drill press. There are two $\frac{5}{8}$ " slots on each side of base for securing to drill press.
- If drill press table has T-slots, use four T-nut clamp assemblies, two on each side, to secure milling table. Clamp assemblies are not supplied.
- If drill press table has slots to fit T-nuts, use four bolts with heavy washers (not supplied) and attach T-nuts to bottom of table. Secure milling table with locking nuts (not supplied).
- If drill press table does not have T-slots or threaded holes, drill and tap four holes, matching location of $\frac{5}{8}$ " slots in base. Fasten milling table with four bolts and heavy washers (not supplied).

SPECIFICATIONS

Table	18 $\frac{3}{4}$ x 6"
T-Slots	$\frac{9}{16}$ "
T-Slots (center to center)	2 $\frac{9}{16}$ "
Longitudinal Travel	12"
Cross Travel	8"
Value of One Division	0.0008"
Cross Travel per One Revolution	0.0787"
Longitudinal Travel per One Revolution	0.0787"

U-CLAMP

- U-clamp can be used to clamp thicknesses up to 2".
- Position workpiece; it should rest flat on table prior to clamping.
- For clamping, use edge of U-clamp which is closest to ball joint because a greater force is created at this edge.
- Make sure U-clamp can rest on workpiece and table with hole in ball joint over a slot in table.
- Slide stud with T-nut into slot.
- Slide U-clamp over stud and into position to clamp on as much of the workpiece as possible.
- Screw the flange nut onto stud.
- Make sure T-nut is properly shouldered in slot and the stud is perpendicular to table.
- Tighten flange nut to securely clamp workpiece.

T-NUT

- For a proper clamping configuration, T-nut should be shouldered within T-nut slot or open slot of work table.
- T-nut must be connected to threaded stud. T-nut has thread stops; screw stud into T-nut until thread stops.
- With a T-slotted table, studs should be connected before inserting stud with T-nut into table.
- With an open slotted table, studs can not be connected until after stud with T-nut is inserted through slot.

ADJUST POSITION

- Motion toward or away from operation is adjusted with cross feed screw by turning handwheel on the front.
- Motion from side to side is adjusted with longitudinal feed screw by turning handwheel on either side.
- Use handwheels to move table to desired position. Make sure that table motion is smooth. Adjust wear plates if necessary.

ADJUST WEAR PLATES

Refer to Figure 1.

- Wear plates (Key No. 16) are used to minimize play within guide grooves.
- Wear plates should be adjusted to produce a uniform drag for entire length of travel.
- Both wear plates should be adjusted in the same manner.
- Loosen hex nuts (Key No. 24).
- Adjust drag of wear plate by applying an equal amount of torque to each set screw (Key Nos. 23 and 25) at each end of the wear plates. Adjust the screws until a slight drag is felt when rotating the handwheel.
- Lock set screws into position by holding position with an L- wrench and tightening hex nuts.

INDEXING TABLE MOTION

- Index collar rotates with handwheel but can be repositioned to calibrate table feed. Position table at a convenient reference point.
- Turn handwheel to move table opposite to the direction which it will travel. Slowly turn handwheel to bring table back to reference point. This will take out play in feed screw.
- Hold handwheel steady and rotate index collar to align it with scale.
- Index collar can be calibrated to indicate relative distance traveled in same direction. Collar must be indexed again to accurately indicate distances in opposite direction.

OPERATING GUIDELINES

Refer to Figure 1.

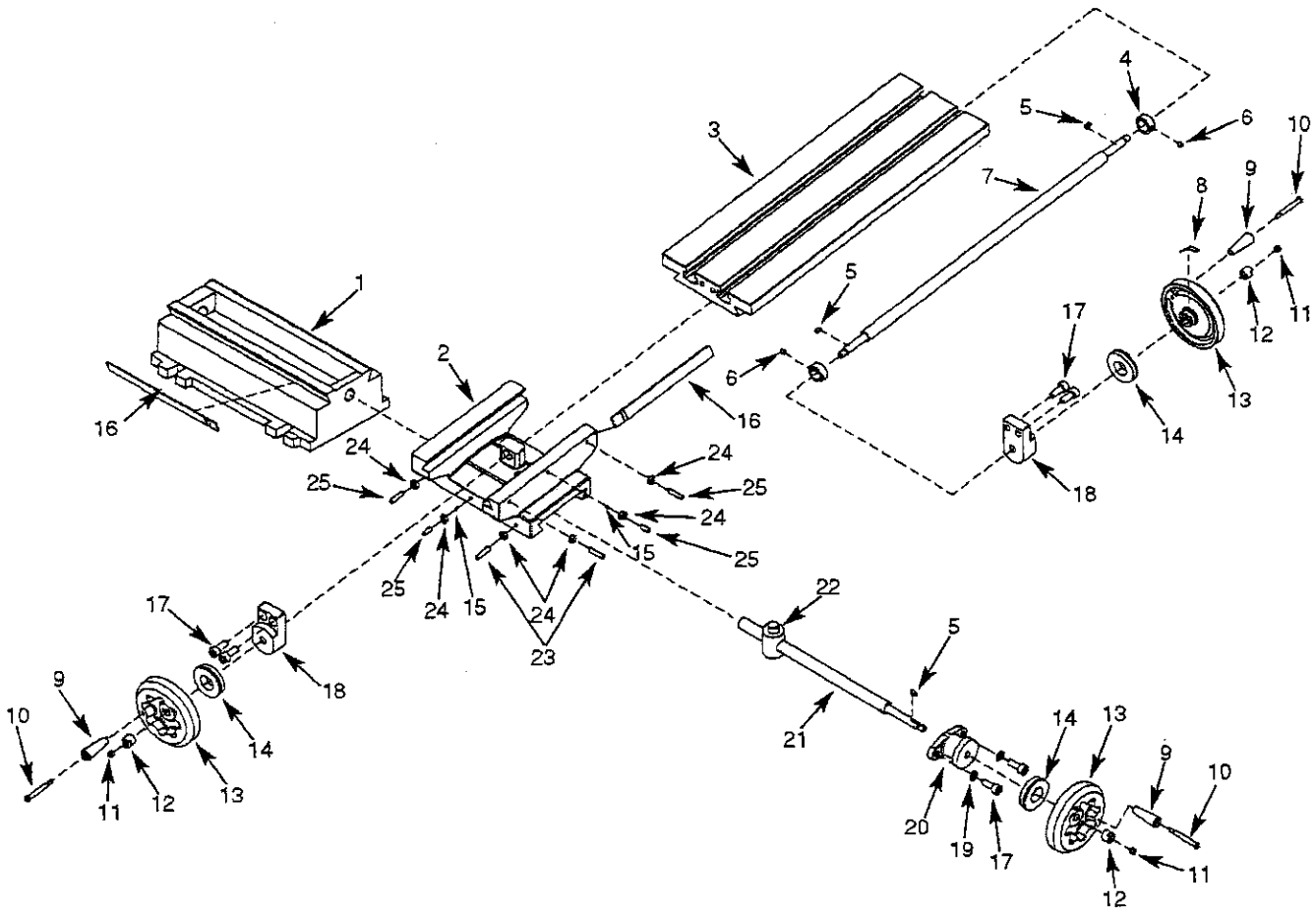
- Do not attempt to take heavy cuts. It may "grab" and ruin your workpiece, break cutter, or damage equipment. The choice of cut must be proportional to rigidity of set up, capability of equipment, choice of milling cutter, and hardness of workpiece.
- Direction of feed should always be against direction of cutter rotation.
- Avoid vibration during milling operation. Correct this by using a cutter with a different number of teeth, by changing speed of cutter rotation, or by adjusting feed of cut.
- Covering the opening over cross feed screw (Key No. 21), in front and back, is recommended to prevent any chips from dropping on threads of screw and on table base.
- Tighten center set screw (Key No. 25) to secure position if required.

MAINTENANCE

- After completing each milling operation, clean all chips off table and out of T-slots with a hard bristle brush.
- Keep threads of cross and longitudinal feed screws oiled and free of foreign matter.
- Keep table top, all machined surfaces and moving parts lubricated.
- Periodically turn handwheels to move table right and left, back and forth, and full length of travel. This will keep the Milling Table in good working condition.

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Figure 1 - Replacement Parts Illustration for Compound Milling Table



REPLACEMENT PARTS LIST FOR COMPOUND MILLING TABLE

KEY NO.	PART NO.	DESCRIPTION	QTY.
1	09900.00	Base	1
2	10281.00	Saddle	1
3	10282.00	Table	1
4	10283.00	Collar	2
5	01531.00	4 x 4 x 10mm Key	3
6	00964.00	6-1.0 x 6mm Set screw	2
7	10284.00	Longitudinal feed screw	1
8	01279.00	Spring plate	3
9	10286.00	Handle	3
10	10287.00	Handle Screw	3
11	01282.00	8-1.25 x 6mm Set screw	3
12	01281.00	Locking nut	3
13	10289.00	Handwheel	3
14	10175.00	Graduated collar	3
15	09884.00	1/8" Ball	2
16	09903.00	Wear plate	2
17	01822.00	8-1.25 x 20mm Socket head bolt	6
18	10178.00	Longitudinal bracket	2
19	STD852008	8mm Lock washer*	2
20	10179.00	Cross feed bracket	1
21	10090.00	Cross feed screw	1
22	10091.00	Cross feed nut	1
23	16365.00	6-1.0 x 25mm Set screw	2
24	STD840610	6-1.0mm Hex nut*	6
25	05110.00	6-1.0 x 20mm Set screw	4
Δ	25134	2-Piece U-Bolt Clamp Set	1
Δ	16305.01	Operator's Manual	1

* Standard hardware item available locally

Δ Not Shown

**In U.S.A. or Canada
for in-home major brand repair service:**

Call 24 hours a day, 7 days a week

1-800-4-MY-HOMESM (1-800-469-4663)

Para pedir servicio de reparación a domicilio – 1-800-676-5811

Au Canada pour tout le service – 1-877-LE-FOYERSM (1-877-533-6937)

For the repair or replacement parts you need:

Call 6 a.m. – 11 p.m. CST, 7 days a week

PartsDirectSM

1-800-366-PART (1-800-366-7278)

www.sears.com/partsdirect

Para ordenar piezas con entrega a domicilio – 1-800-659-7084

For the location of a Sears Service Center in your area:

Call 24 hours a day, 7 days a week

1-800-488-1222

To purchase or inquire about a Sears Maintenance Agreement:

Call 7 a.m. – 5 p.m. CST, Monday – Saturday

1-800-827-6655

