



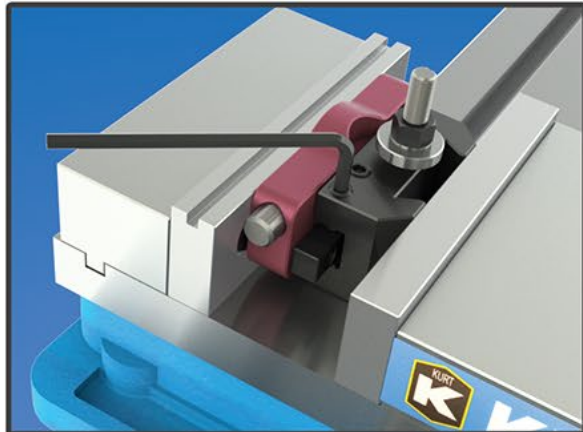
TOOL POST DRILL CHUCK

OWNER'S MANUAL

THE TOOL POST DRILL CHUCK IS DESIGNED TO DECREASE THE TIME IT TAKES TO DRILL A HOLE ON THE LATHE. PECK DRILLING CAN BE PERFORMED MUCH FASTER WHEN THE DRILL IS HELD AT THE TOOL POST INSTEAD OF THE TAILSTOCK. ACCURATE HOLE DEPTHS CAN NOW BE ACHIEVED BY MONITORING THE DRO FOR THE CARRIAGE. THE TOOL POST DRILL CHUCK CAN QUICKLY BE ALIGNED TO THE SPINDLE USING THE PROCEDURE BELOW.

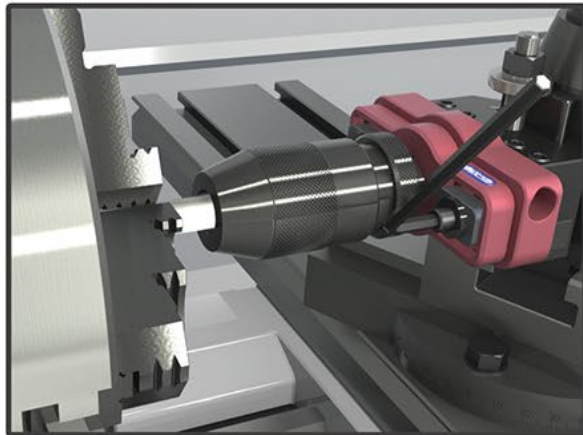
STEP 1

- IT IS IMPORTANT THE TOOL POST DRILL CHUCK BE MOUNTED IN THE TOOL HOLDER SQUARELY. TO DO THIS, REMOVE THE TWO 1/4"-20 SOCKET SCREWS TO DETACH THE REAR HALF OF THE BODY. USE A MACHINE VISE TO CLAMP THE REAR FACE OF THE BODY TO THE FRONT FACE OF THE TOOL HOLDER AS SHOWN.
- TIGHTEN THE SET SCREWS IN THE TOOL HOLDER.
- REMOVE FROM VISE AND REASSEMBLE WITH THE FRONT PORTION OF THE BODY.



STEP 2

- USE A DIAL INDICATOR TO ENSURE THAT THE TOOL POST IS PARALLEL TO THE TRAVEL OF THE CROSS SLIDE.
- INSTALL THE TOOL HOLDER ON THE TOOL POST. REMOVE THE 1/2" ALIGNMENT PIN FROM THE BODY AND INSTALL IT IN THE DRILL CHUCK. NOTE THAT THE ALIGNMENT PIN IS HELD IN THE BODY BY A SMALL MAGNET.
- LOOSEN THE TWO 1/4"-20 SOCKET SCREWS SO THAT THE FRONT HALF OF THE BODY IS FREE. CLAMP THE ALIGNMENT PIN IN THE LATHE CHUCK OR COLLET AS SHOWN. TIGHTEN THE TWO 1/4"-20 SOCKET SCREWS.



STEP 3

- INSERT THE ALIGNMENT PIN BACK INTO THE STORAGE HOLE IN THE BODY.
- ZERO THE DIAL OR DRO FOR THE CROSS SLIDE.

NOTE:

- IT IS HIGHLY RECOMMENDED TO USE A SPOT DRILL OR CENTER DRILL TO START EACH HOLE.
- THE FRONT HALF OF THE BODY SHOULD NOT BE TURNED UPSIDE DOWN. THE BLUE STICKER SHOULD BE FACING UP.

