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INSTRUCTIONS FOR FLOATING DRILL HOLDER

1. Mount Floating Drill in turret of machine and clamp securely.
2. For "V" type Floating Drill Holder, install drill into "V" section of holder and tighten both clamp screws securely, but not so tight as to bend clamp. Note that clamp can be reversed – it can be used with "V" inside for small drill or reversed for large drills.
3. Loosen Body Screws and then retighten lightly so that body can move laterally with minimal hand pressure.
4. Start machine spindle and advance turret into drilling position. Hold body so that drill is in approximate center of workpiece and push drill into stock and drill a small cone. Drill should find its own center. While holding pressure of turret against drill, stop spindle rotation, then tighten both body screws securely.
5. Restart spindle and continue drilling hole. Check hole for size, tapers, bellmouth etc... and repeat above operations until hole is as desired.