



INSTRUCTIONS FOR DRILLING TAPERED SPINDLE CROSS PIN HOLE

Form Z548
Date 3-99/A

1. ASSEMBLE TAPERED CHUCK TO TAPERED SPINDLE.
NOTE: MAKE SURE CHUCK IS TIGHT ON SPINDLE.
2. DRILL CROSS PIN HOLE USING $\varnothing 1/8$ CARBIDE FAN DRILL AT APPROXIMATELY 700 RPM DRILL SPEED.
3. INSTALL TAPERED PIN IN HOLE AND CUT OFF PIN FLUSH WITH CHUCK BODY.

**SIoux
TOOLS INC.**

250 SNAP-ON DRIVE ■ PO BOX 1596 ■ MURPHY, NC 28906 ■ USA ■

Printed In U.S.A.



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