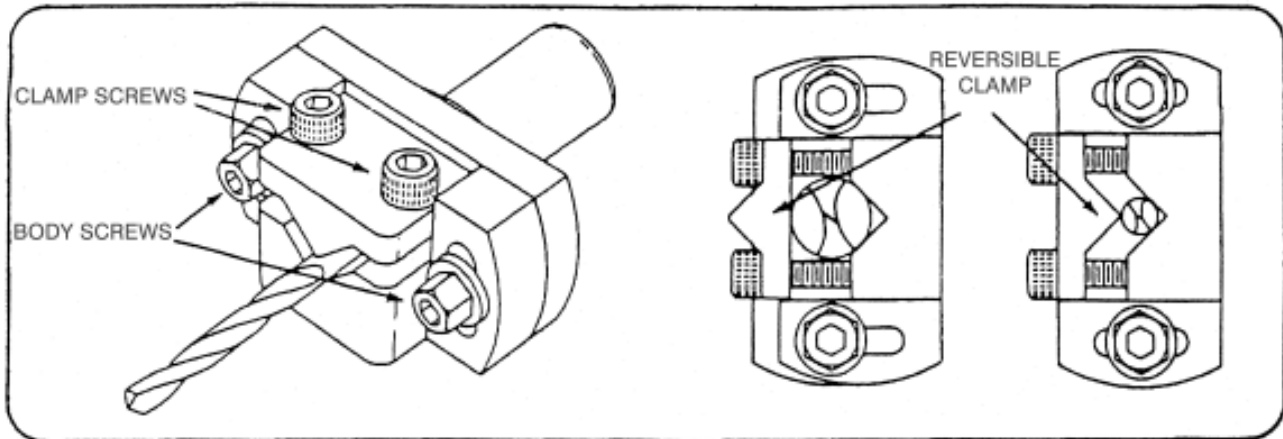


TOOL SETTING INSTRUCTIONS

Rapid, Accurate Set-ups EVERY TIME



Correct setting of drills and other tools in a Brookfield Tool Holder takes only one *hex wrench*, supplied with the Holder.

PLEASE do not use a hammer. There's no need for tapping, and it would damage the holder.

Before setting any tool:

(1) Loosen all screws. Clean all chips from Tool Holder and turret hole. Clamp Holder in turret hole.

(2) Place shank of tool (drill, reamer, counterbore, etc.) in V section of Tool Holder body. Tighten clamp screws, making sure that clamp is approximately parallel to top surface of V body section. **DO NOT OVERTIGHTEN!**

If tool shank is greater in diameter than $\frac{1}{2}$ the capacity of the holder, reverse clamp as shown in cut. Clamp on shank only, not on flutes.

In setting drills:

(3) With spindle running bring drill into cutting position using turret manual feed. With body screws finger-tight, and while supporting body of tool holder in roughly centered position with one hand-force drill point gently into revolving stock

Drill should center itself.

(4) If the drill does not find its own center: tighten one body screw gently (with wrench), and force drill into work a little harder, at a slow spindle speed. This will bring the tool to the center line.

(5) At this time, before any errors can accumulate, the drill should be in only about as deep as $\frac{1}{2}$ the length of its point.

(6) Examine center hole for correct form (no cone at center). Jog spindle to check for runout.

(7) If both O.K.: Loosen body screws, and with drill held firmly in center hold (spindle stopped), retighten.

(8) Start spindle and drill a deep hole.

(9) Stop spindle, and with drill at bottom of hole, loosen body screws once more. Float drill in hole, and tighten body screws again. This should assure correct alignment and setting.

In setting other tools, (for which the hole has already been made), the simple procedure should be apparent.

NOTE: Just remember to make final alignment of any tool at the deepest hole possible.