



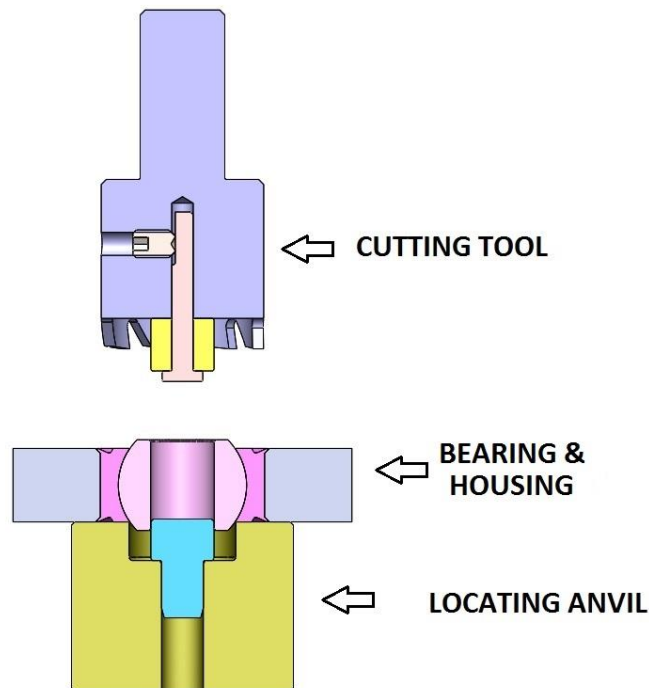
## Drill Press Cutter Instructions

### Setup instructions

- A) Install cutting tool into drill press chuck or vertical milling machine
- B) Bring the cutter down until it contacts the edge of the bearing, set the spindle stop so it will let the cutter only cut .025-.035 below the initial contact point
- C) Adjust spindle speed - recommend approximately = 160 divided by the Bearing OD.

### Operating instructions

- A) Position part (sub-assembly – bearing & housing) on the flat surfaced locating fixture in bearing bore.
- B) With part resting securely on locating fixture slowly lower the spindle — ensuring Cutter bushing is piloted into the bearing bore.
- C) Apply cutting oil (Moly Dee) to the edge of the bearing.
- D) Start the spindle and apply steady pressure as the teeth cut the bearing, continue to feed down till you feel the spindle contact the stop.
- E) Release pressure and withdraw tool from bearing/housing sub-assembly.
- F) Inspect the cut, if it doesn't appear to be deep enough yet adjust the spindle stop.
- G) Repeat steps B through F until cut is complete.



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