

DRILL-TAP FIXTURE

Operation Instruction

---

### 1. Application and property

This unit is a drill-tap of various applications. It can be applicable for all kinds of lathe by connecting various tail-stock.

When it be machining the work piece at some steps that drilling, boring, reaming and tapping etc, necessary to insert the drill chuck, reaming frame, machine taps as on into the cram bore of the turning tower fight by connecting rod.

When it is necessary to change the tools after the first operation step ,without the necessity for taking off the clamp, but only to turn the turning tower.

Amount to the same thing that

1

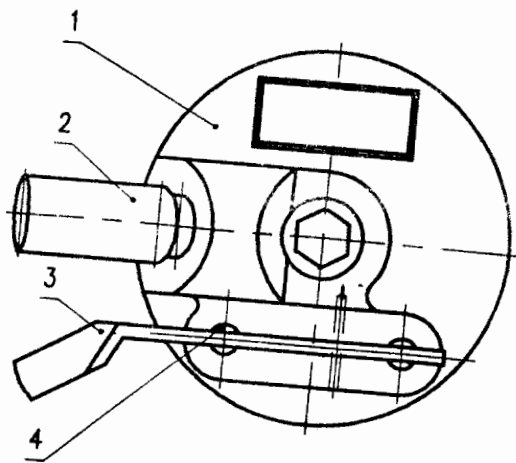
changing clamp.

This fixture not only can be saving time and strength but also be easy to store . So it is a ideal drill-tap fixture.

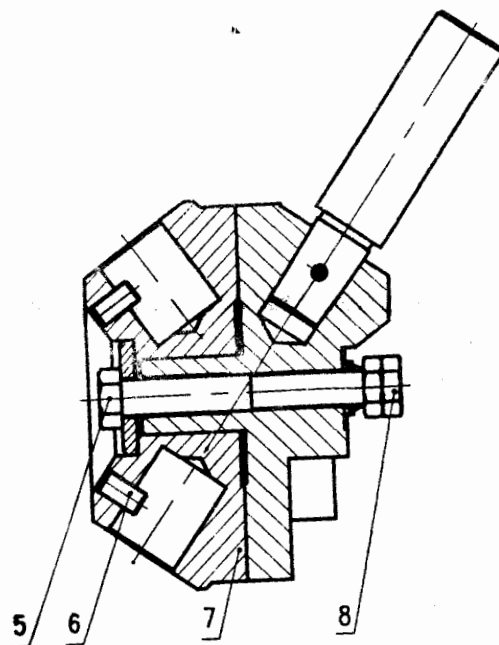
### 2. Part drawing number and description, quantity

Number	description	quantity
1	Boring frame	1
2	Connecting handle	1
3	Adjusting handle	1
4	Set pin	1
5	Connecting screw	1
6	Locking screw	6
7	Turning tower	1
8	Clamp nut	1

2



3



4

3. Main technical specification:

Model	Out Dia	Clamping range	Connecting handle
F <sub>3</sub> -5"	φ 128	1"	Straight 1" MS2,3,4
F <sub>3</sub> -2-1/2"	φ 63.5	5/8"	MS1,2,3

4. Using method

- 1) First put the turning tower (7) up and toe into the lathe tail stock.
- 2) Then set the drill chuck, machine taps on require into the cram bore of the turning tower(7) ,and tight them with (6).
- 3) When after the first step and be necessary to change the fixture: take down the adjusting handle(3), divide set pin (4) from turning

tow-er(7) ,turning the turning tower and loose the adjusting handle (3), as listening the voice that the set pin (4) into the other cram bore. The changing end, the second step can be done. Successive as such above ,you can obtain six difference positions.