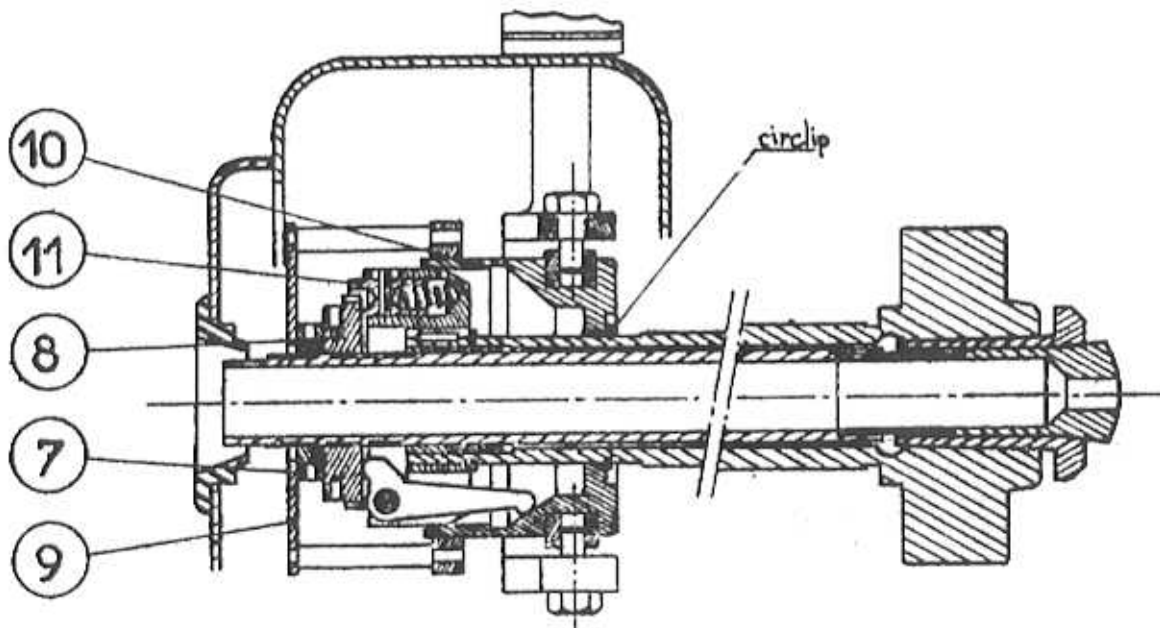


DRAW-IN COLLET ATTACHMENT :

The De Vallière Collet Attachment is a precision unit and should be given the same treatment and care as other precision equipment. Once it has been adjusted properly, slight pressure of the operating lever is all that is necessary to open and close the collet. Use of force is unnecessary and will damage the unit.



INSTRUCTIONS FOR USE :

1) Insert # 5C Collet into Collet Adapter at front of spindle and thread into draw-tube until back of collet strikes bottom of recess in tube. Then back off 1 or 2 threads.

2) While operating the Attachment with the hand lever, adjust the position of large Nut # 8 so that the lever operation opens and closes the collet properly. DO NOT FORCE - EXCESSIVE PRESSURE IS NOT NECESSARY.

Then lock Nut # 8 securely in position with small Nut # 7. The setting of these two nuts should not be changed after they have been adjusted.

3) Adjust operating lever so that, with the lever in its extreme open position, the arms of Pusher tap Nut # 7 gently just before the Cup # 10 comes up against the circlip at the back.

IT IS NOT NECESSARY TO USE FORCE.

If force is used the arms of the Pusher will be bent.

4) To change collets, the draw-tube is unscrewed from the collet by turning the tube with Nuts # 7 and # 8 which must remain locked together so their position on the draw-tube remains unchanged. To unscrew the nuts and draw-tube, the Ratchet Pin # 11 must be depressed.