

8 7 6 5 4 3 2 1

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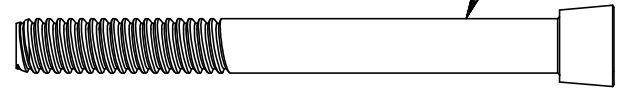
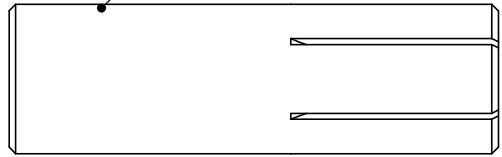
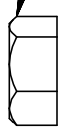
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A

1/4-20 HEX NUT

MANDRIL

ALTERED 1/4-20 SOCKET CAP SCREW



IN PRACTICE: INSERT ALTERED 1/4-20 SOCKET CAP SCREW INTO MANDRIL SO THAT TAPERS WILL BE COINCIDENT. APPLY NUT TO PROTRUDING PORTION OF SCREW AND HAND TIGHTEN. APPLY CUP ONTO SLIT END OF MANDRIL. TIGHTEN NUT UNTIL CUP IS SUFFICIENTLY GRIPPED FOR TURNING.

RUN MANDRIL IN COLLET OR OTHER CAPABLE OF MAX .003 RUNOUT OVER LENGTH OF CUP.

		UNLESS OTHERWISE SPECIFIED:	NAME	DATE	
		DIMENSIONS ARE IN INCHES	DRAWN	6/21/07	
		TOLERANCES:	CHECKED		TITLE:
		FRACTIONAL ±	ENG APPR.		MANDRILL ASSEMBLY
		ANGULAR: MACH ± BEND ±	MFG APPR.		SIZE
		TWO PLACE DECIMAL ±	Q.A.		DWG. NO.
		THREE PLACE DECIMAL ±	COMMENTS:		REV
		INTERPRET GEOMETRIC TOLERANCING PER:			A
		MATERIAL			SCALE: 1:1
		FINISH			WEIGHT:
NEXT ASSY	USED ON				SHEET 1 OF 1
		APPLICATION			
		DO NOT SCALE DRAWING			

8 7 6 5 4 3 2 1