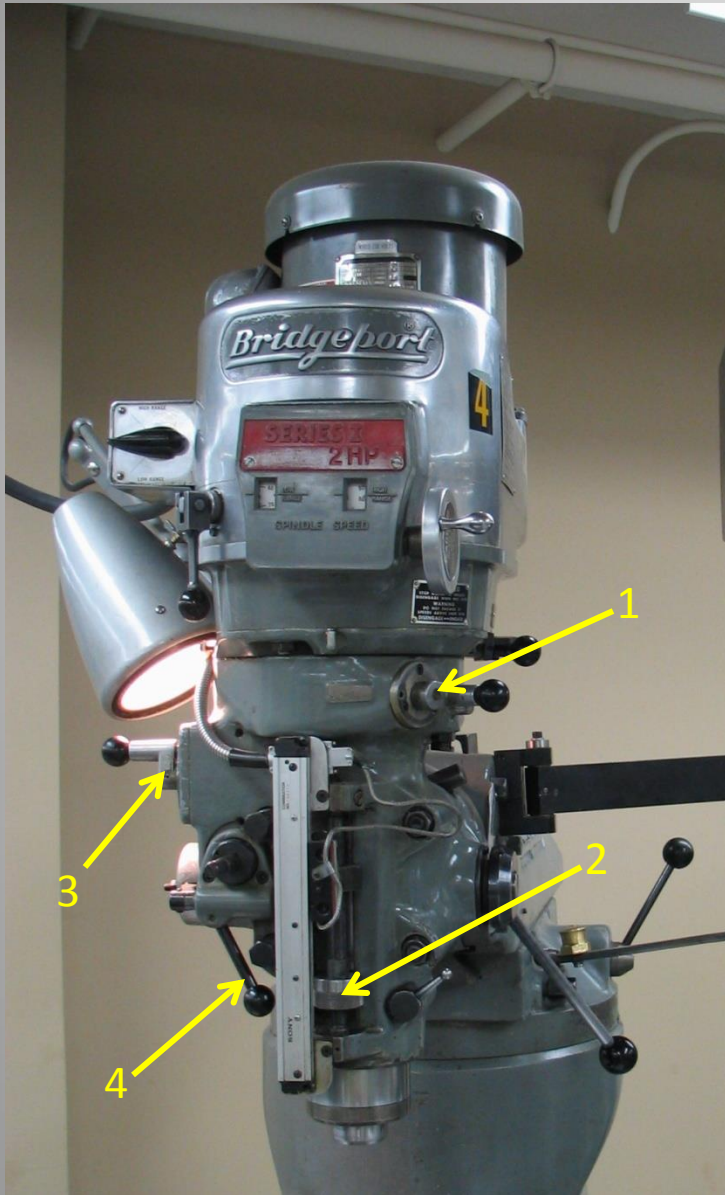


Z-Axis Power Feed Operation



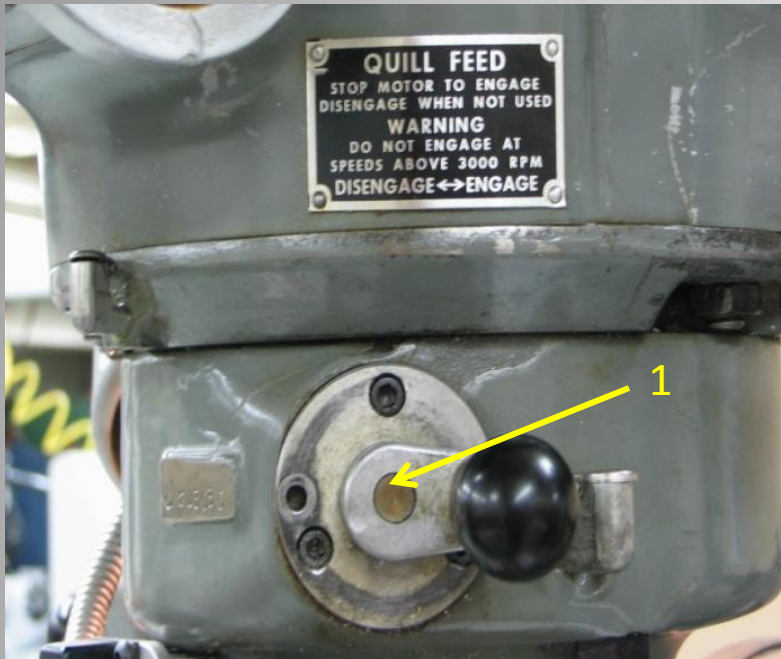
Z-Axis Power Feed Components

- 1) Z-Axis Feed Selector Switch
- 2) Cutting Depth Stop
- 3) Feed Rate Selector
- 4) Z-Axis Feed Engage

Z-Axis Feed Tips

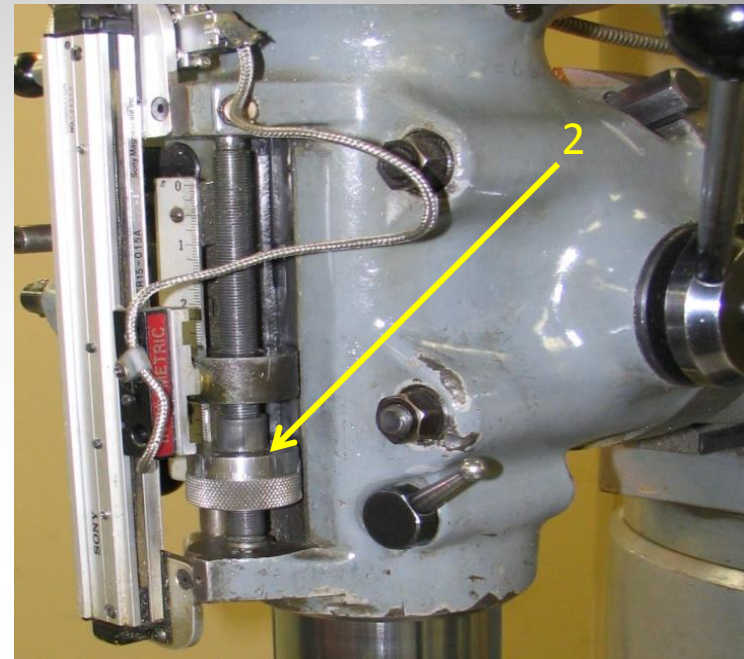
- Use with a boring head.
- Use when drilling through soft materials that “pull” drill bit when finishing cut. Commonly affected materials: copper, brass, Plexiglas.

1) Z-Axis Feed Selector Switch



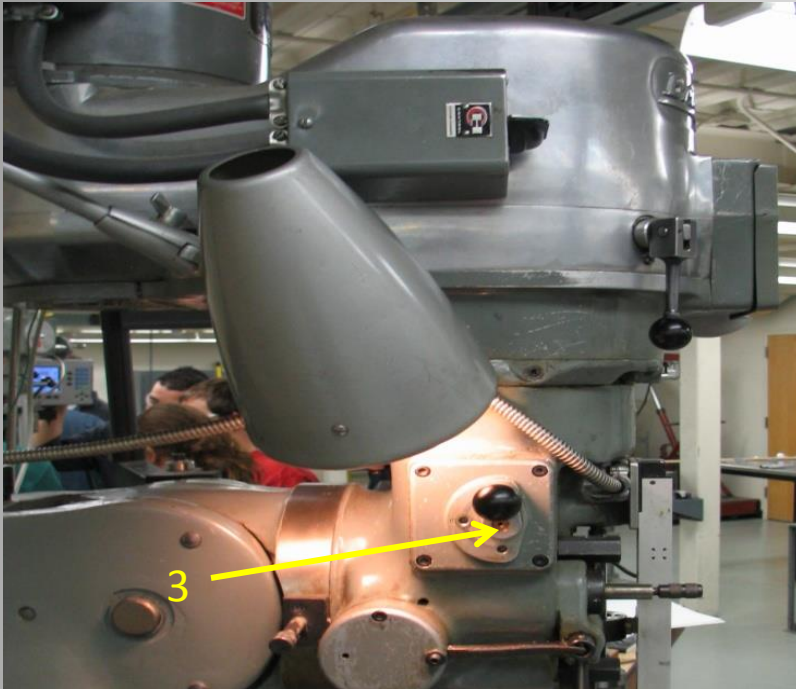
- Engages power to the quill feed drive.
- Motor cannot be running when engaged.

2) Cutting Depth Stop



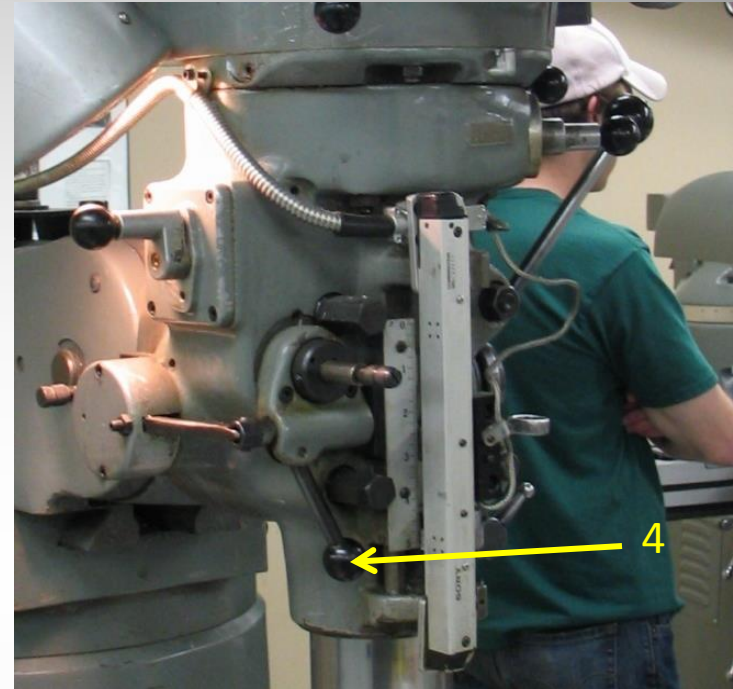
- Set for total depth of cut.
- Will automatically disengage quill feed when desired depth reached.

3) Feed Rate Selector



- Three feed rates: 0.0015", 0.003" and 0.006" per revolution.
- Use the 0.006" rate for soft materials, the 0.003" rate for hard materials and the 0.0015" rate for all finishing cuts.
- May be changed while still or running.

4) Z- Axis Feed Engage



- Swing handle to left to engage quill feed.
- Can manually disengage by moving handle back to the right side or will disengage when reaches depth of cut stop.