

Tip 96 — Drawbar and Chuck Adapter Through-Drill Modification/Roger Adams

Modifying the Drawbar and Chuck Adapter

I have been using your 4400 Series lathe, and 5400 mill for several months now and am absolutely delighted with them. You make a most excellent product at a very reasonable price.

I am using these to make a clock (I'm a clock and watch repairer), and eventually will use them to make a watch from scratch. To this end, I purchased the #3060 milling collets, which I use on both the lathe and the mill for holding and machining drill rod for making clock arbors, etc. If I may make a suggestion regarding these, it would be a good idea if you would supply the associated drawbolt through-drilled to allow a long piece of 3/16", or smaller, stock to be used with them. I actually modified the drawbolt myself like this and it proved most effective. I also through-drilled the #37090 chuck adapter for the rotary table for the same reason. FYI, I needed to mill flats on the end of a long piece of 3/16" drill rod, using the rotary table on the mill to do this and without through-drilling the adapter first as I did, the rod would have stuck out too far from the chuck mounted on the rotary table to allow for this.

These are simple changes that the watch and clock makers that I'm sure are a major portion of your faithful customers would appreciate.

FYI, when friends come to see my workshop, they are universally impressed with the Sherline equipment and attachments. They usually ask about the cost, and I tell them it cost me half a tooth. What does this mean, well I recently payed almost twice the price I paid for your SPI-6000 lathe and mill package for a single tooth implant at my friendly neighborhood dentist. How's that for a marketing catch phrase—buy 2 complete lathe and mill packages for the cost of a tooth?

Great products Sherline, keep up the good work!

Best Regards
Roger Adams
Edmonton, Alberta, Canada

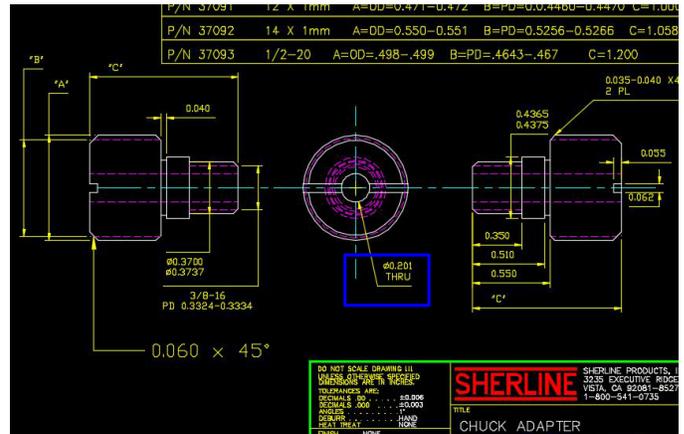


FIGURE 1—The blue box indicates the new drill-through hole for the Sherline Rotary Table-to-Chuck Adapter.

Notes from Sherline

Instead of drilling a hole through the mill collet draw bolt as described in the modification, we suggest using our WW collets. The WW collets have a “draw tube” instead of a draw bolt. They will allow stock up to 3/16" to feed through the collet and the draw tube.

With the feedback from Roger Adams, we have decided to add a .201" through-hole to our P/N 37090 Rotary Table-to-Chuck Adapter. This modification will take place on the next part run.

Thank you,
Sherline Products Inc.



Old style

New through-hole

FIGURE 2—Shows a side-by-side comparison of the old and new P/N 30790 chuck adapter