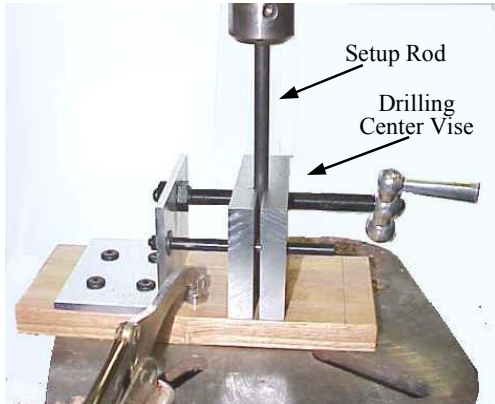


# #DRILLCENT

## Self-Centering “Drilling Center” Vise

### Operating Instructions

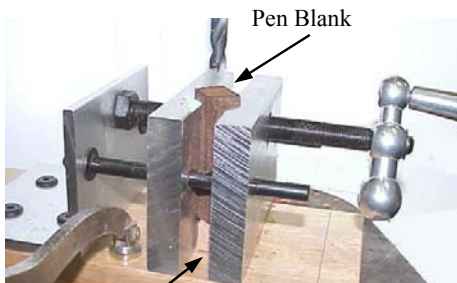
You have just received the most efficient Pen Blank Drilling vise available. Correctly used, it will consistently position your wood blank to drill holes flawlessly through the exact center of your pen blanks (3/4" or smaller) regardless of their shape.



Clamp Vise In Center

#### Setting up for drilling (3/4" blank or smaller)

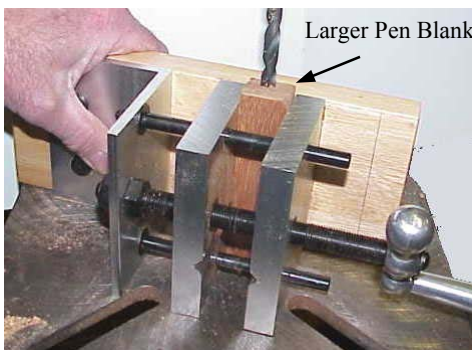
Place a rod (3/8" or larger) in your drill press. If a rod is not available use a drill bit. Open the vise jaws and close the jaws with the rod captivated by the slots in the jaws. When centered, clamp down the vise onto the drill press table (clamping at the center of the base as shown works best.) Adjust the drill press table (if necessary) for proper depth of cut keeping the vise flat and perpendicular to the drill bit.



Scrap Piece

#### Drilling Your Blank

Cut your pen blank to the required length. Your blank should be centered exactly. Use a piece of scrap wood under the blank for support and to avoid tearout when drilling. Insert the blank into the slots in the vise and tighten the vise as shown. You can change bits or blanks as necessary without re-centering the vise.



Drilling Center vise turned on side

#### Drilling Larger Blanks

(Self Centering feature does not apply in this application)  
In the event that your blank is larger than 3/4", place the vise on its side. Mark the center of the blank by drawing lines from corner to corner. Open the jaws, place a scrap piece under the blank between the jaws as shown, then tighten the jaws. Hold the assembly with one hand while the drill bit is advanced by the other.