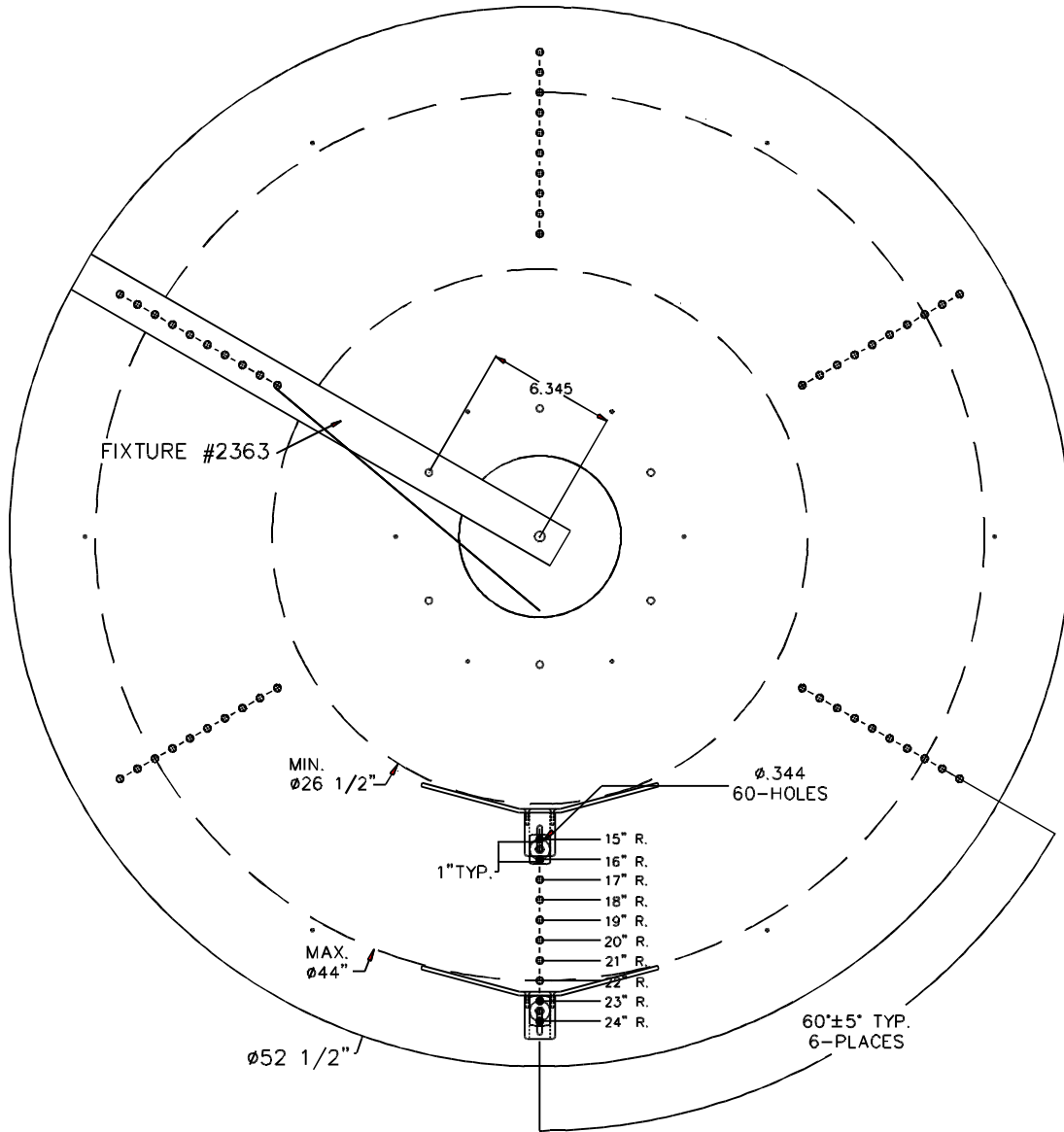
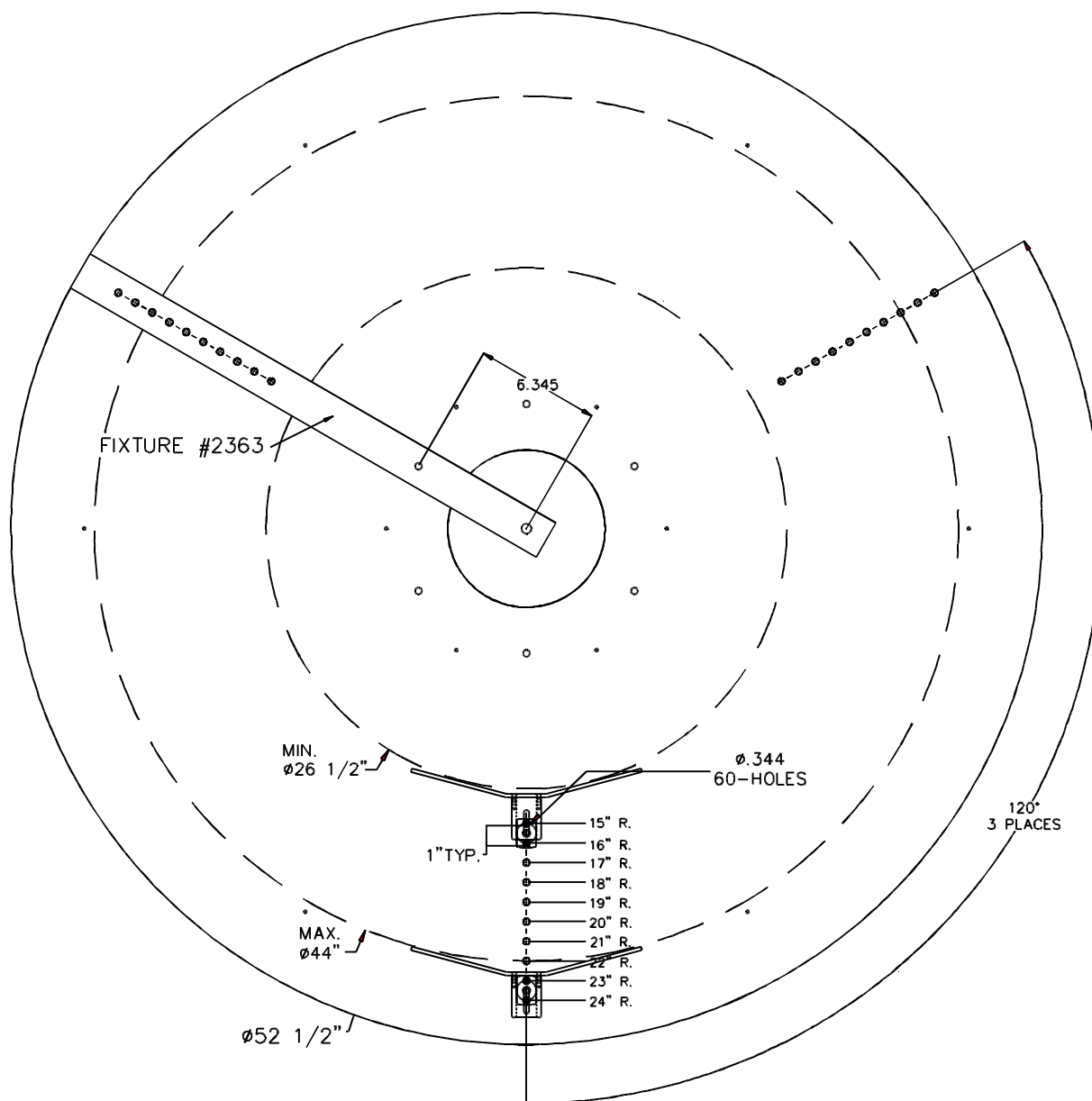


CLAMPING HOLES FOR 60/120 DEGREE 52" DISK DRILL INSTRUCTIONS #4654



60 Degree Drilling Instructions:

1. Remove the film and control plates.
2. Place the drill fixture into the spindle hole, allowing the locating pin to fall into one of the six center ring holes, and clamp it to the outside edge of the disk.
3. Drill ten .344 diameter holes with the included drill bit.
4. Move the drill fixture approx. 60 degrees and relocate in the center ring holes as shown above.
5. Clamp the drill fixture down and repeat step 3.
6. Repeat steps 4 & 5.
7. Lightly de-burr the 60 newly drilled holes.
8. After the platter systems have been modified return the drill fixture for proper credit to:
Design & Manufacturing Inc., P.O. Box 340, 302 W. Division St., Fisher, Il. 61843



120 Degree Drill Instructions:

1. Remove the film and control plates.
2. Place the drill fixture into the spindle hole, allowing the locating pin to fall into one of the six center ring holes, and clamp it to the outside edge of the disk.
3. Drill ten .344 diameter holes with the included drill bit.
4. Move the drill fixture approx. 120 degrees and relocate into every other center ring hole as shown above.
5. Clamp the drill fixture down and repeat step 3.
6. Repeat steps 4 & 5.
7. Lightly de-burr the 30 newly drilled holes.
8. After the platter systems have been modified return the drill fixture for proper credit to:
Design & Manufacturing Inc., P.O. Box 340, 302 W. Division St., Fisher, Il. 61843