

How to drill
the end of a
5/8" steel rod
for a 3/8"
Double ended
end mill
without a
metal lathe



Use a drill press
and align the Jacob's chuck
with the hole in the table



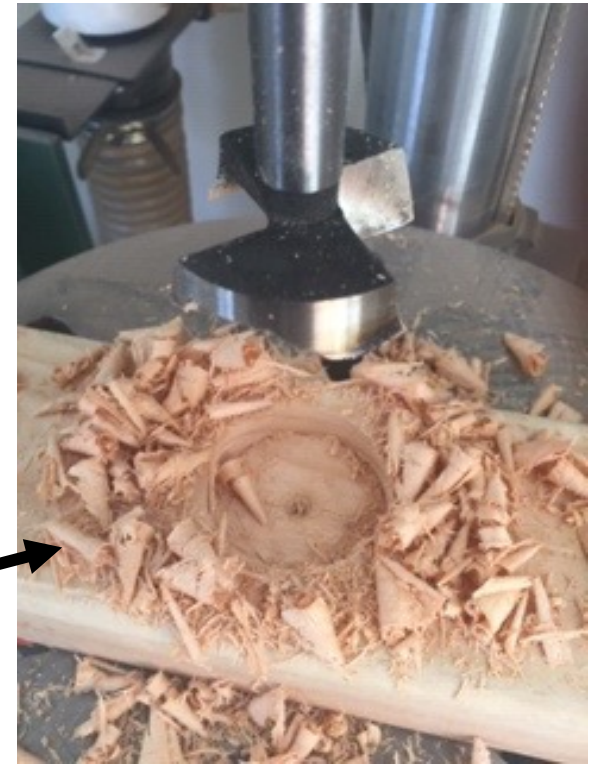
Clamp a
block of
wood to the
table



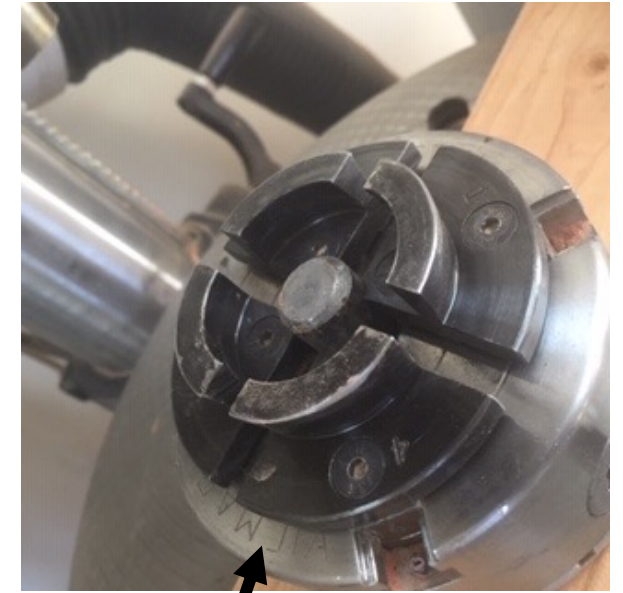
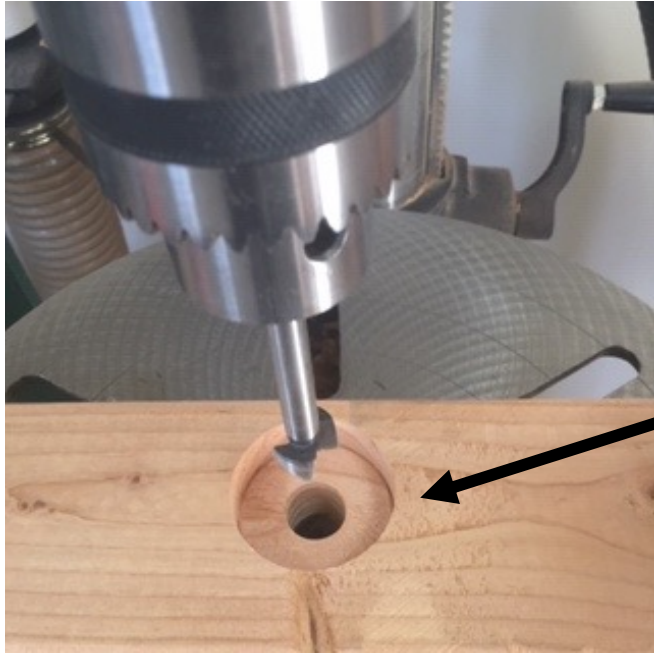
Find a forstner bit
bigger than your
chuck's insert



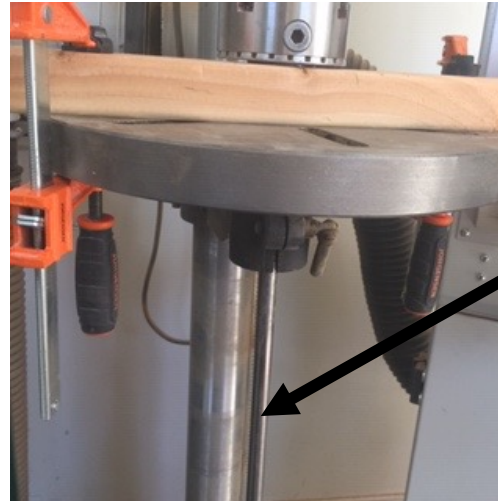
Drill the wood with
the forstner to the
depth of your
chuck's insert
This so the chuck
will lay flat on the
wood

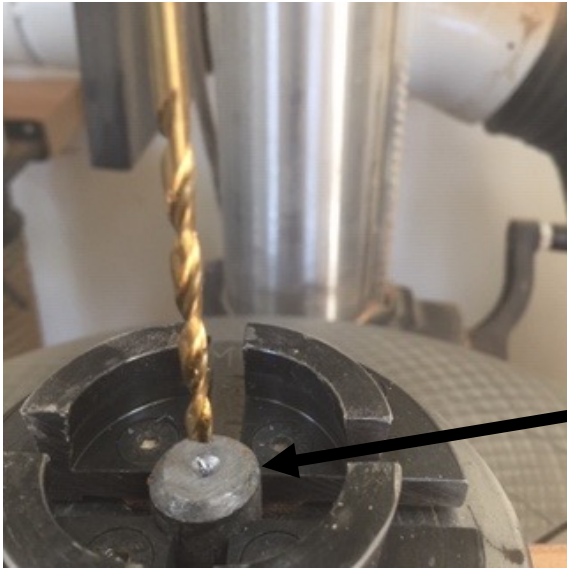


Drill through
the wood using
a 5/8 drill



Insert the rod
through the
table the wood
and clamp it
with the chuck





Mark the start point for your drill

Taking your time and using a lot of oil drill a 1/8" pilot hole 2.5 inches deep.



Again taking your time, using a lot of oil and a 3/8 drill take the hole out to final size