



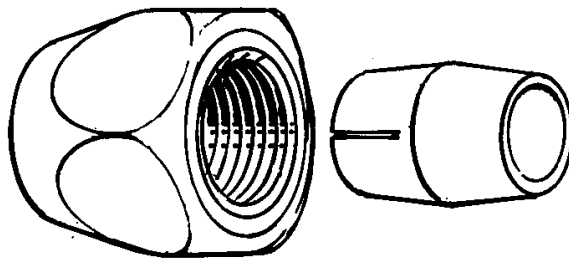
NOVA COMET COLLET QUILL ACCESSORY

INSTRUCTIONS

Code: NCQS

This accessory converts your threaded tailstock quill into a handy drill holder. The Nova Comet Collet Quill accessory is ideal for miniature turning work. It has two advantages over normal drill chucks

- Reduced Overhang. Morse taper drill chucks take up considerable bed length which reduces drilling options.
- Better Support for drilling point. Drill length can be shortened so only the optimum drill length is used for the drilling job. Because the drill is directly held in the tailstock without a morse taper chuck the drill tip is centred more accurately with less tendency to wander.



Collet nut and Collet.

Collet Quill Kit: Collet Nut and two Collets, 29003 and 29004 – see table below.
Other Collet sizes are available – see table below.

Collet Sizes available (sizes are gripping diameters):

| Collet | Collet |
|--|----------------------------------|
| 29002 Ø 3mm (1/8") | 29004 Ø 8.5 – 9mm (~11/32") *STD |
| 29009 Ø 6.5mm – 7mm (~ 1/4") | 29005 Ø 12.7mm (~1/2") |
| 29003 Ø 7.5 – 8mm (~19/64"/5/16") *STD | 29006 Ø 9.5-10mm (~3/8"/25/64") |

To Use:

Check to see if your tailstock quill is threaded to accept the Collet Nut. If it is an older Comet and does not have the threaded quill you will need to exchange with the reseller your tailstock quill for a new threaded quill.

There will be a nominal cost to upgrade to the new quill.

Select the correct collet for the drill being used. Note the drill shank diameter needs to be within the ranges of the gripping diameters set out in table above.

Place collet in morse taper tailstock quill. Make sure split end of collet is facing outwards (to engage with the taper of the Collet Nut).

Screw on Collet Nut.

Ensure drill shank is clean and has no burrs or imperfections on the shank.

Ensure the collet is clean and free from shavings or grit.

Slide the drill into the collet – leaving the fluted section exposed for drilling and firmly tighten the collet nut. If the drill persists in spinning, you may need to increase the tightness of the collet nut by using a spanner. The spanner size required is 38mm (1½") AF.

An optional Teknatool accessory spanner will be available to use with the Collet Quill, Nova & SuperNova Inserts etc, September 1998.

Note: Do Not Overtighten, as this may distort the collet.

Over/

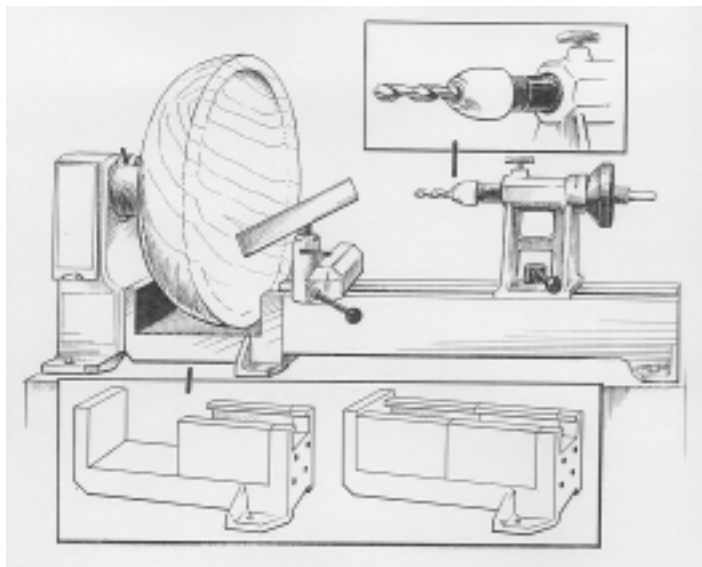
Drilling hint:

It is essential that the flutes of the drill are NOT allowed to become choked with shavings. Clear the drill frequently. A choked drill will probably spin in the collet. Grip the drill as close to the drill tip as possible to reduce flexing and tip wander.

OTHER INNOVATIVE ACCESSORIES FOR YOUR COMET LATHE

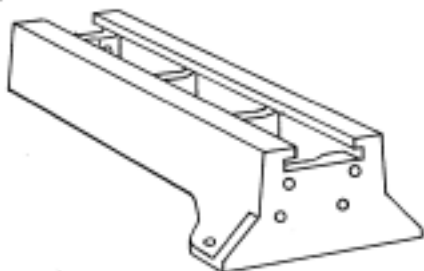
GAP BED ACCESSORY (Code: GBCML)

- 'Real' Gap bed capacity. Increase diameter to $\varnothing 355\text{mm}$ (14") x 190mm (7.5") depth.
- Easily located between headstock and bed.
- Increases bed length to 585mm (23") BC.
- Bed filler enables you to use the full length of gasp for spindle tuning.
- Optional 250mm (10") Toolrest (Code:TR250) to use with Gap Bed.



BED EXTENSION Code: BU3000

- One extension unit extends bed by 500mm (20") BC.
- Easy and precision fitting to existing lathe bed.
- Multiple extension units can be added for extra long beds.



Teknatool International

PO Box 180034 Luckens Point
Henderson Auckland 1008 New Zealand
Ph +64 9 838 7663
Fax + 64 9 837 4049
Email sales@teknatool.com
Website www.teknatool.com