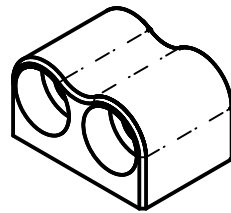
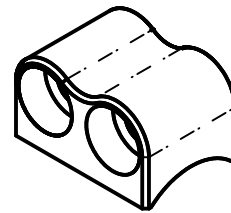


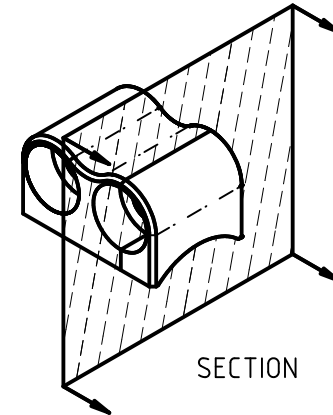
ORIGINAL MS2020  
DOUBLE BINDER  
1018 STEEL



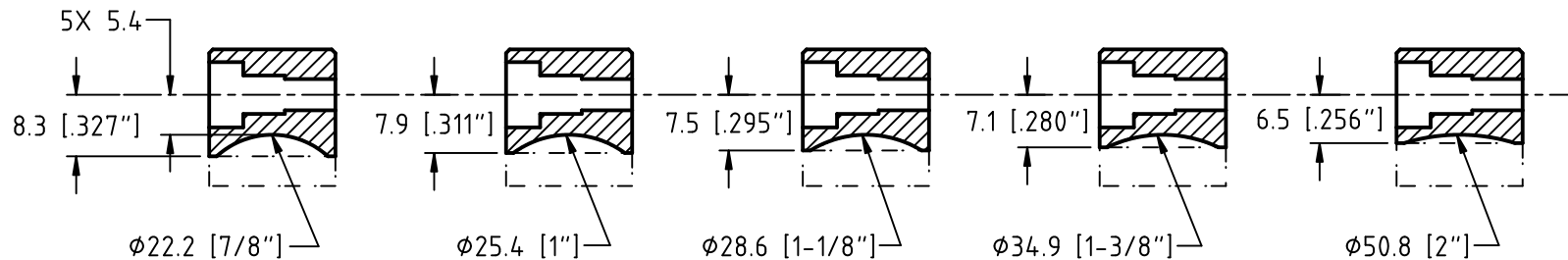
FIRST OPERATION:  
MILL BOTTOM FACE  
3/4" HSS END MILL  
660 RPM, .050" DOC



SECOND OPERATION:  
MITER BOTTOM FACE  
FLY CUTTER, HSS BIT



SECTION



SPINDLE:	660	660	660	325	325	RPM
QUILL FEED:	.003"	.003"	.003"	.006"	.006"	INCH/REV
MAX STEPOVER:	2.0	1.8	1.6	1.3	0.9	MM/PASS

#### QUILL FEED INSTRUCTIONS:

1. Turn off spindle.
2. Set micrometer stop at bottom of cut.
3. Engage feed worm.
4. Set quill feed to 3 or 6 thou per revolution.
5. Turn on spindle.
6. Set feed direction (clockwise for down).
7. Disengage quill lock.
8. Engage feed lever.

#### General Notes:

1. Unless otherwise specified, dimensions are in millimeters.
2. Feeds and speeds target instantaneous motor power delivery of 0.5 hp.