



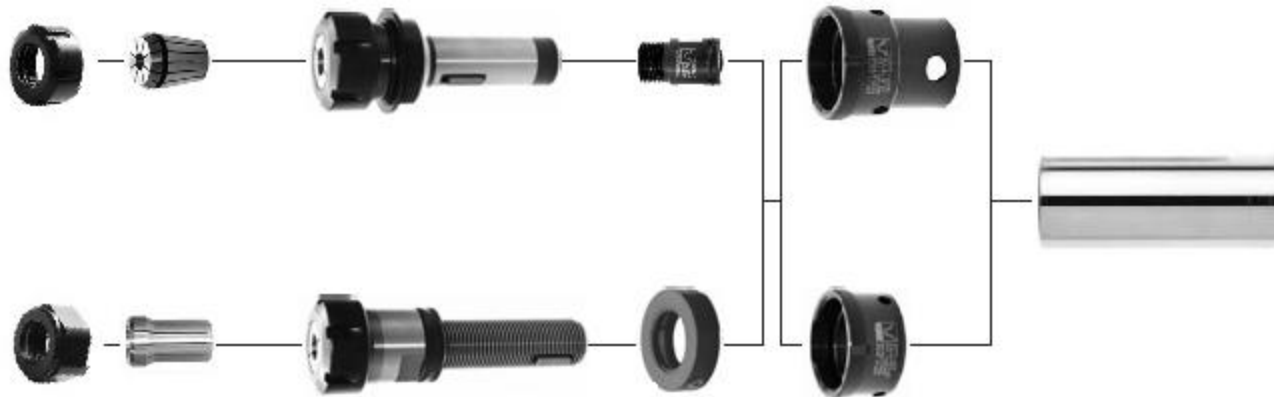
T.M. SMITH TOOL
INTERNATIONAL CORPORATION

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(586) 468-1465 • (800) 521-4894
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SMITH-LOCK[®]

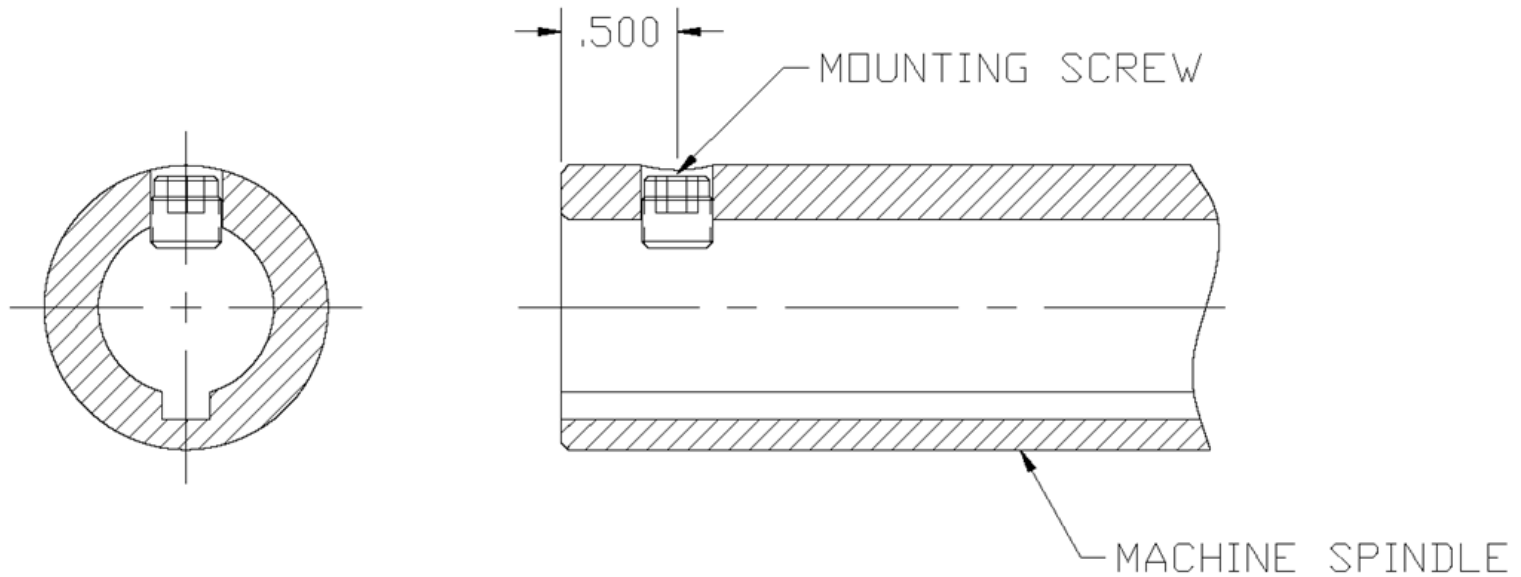
QUICK CHANGE DRILLING SYSTEM

USAGE AND DIRECTIONS



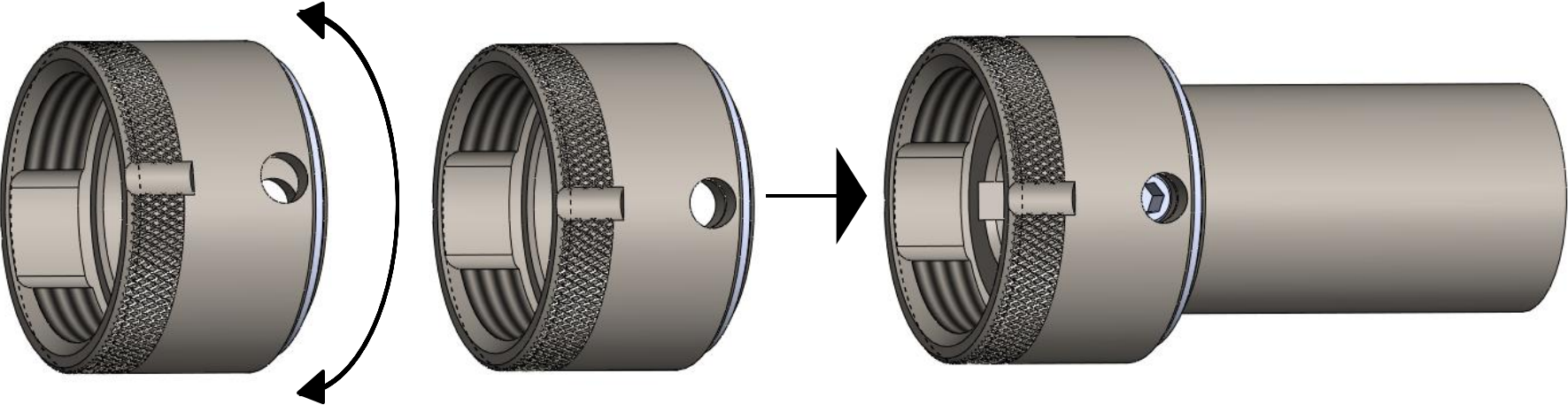
OSA Smith-Lock[®] Stub Series

Spindle Mounting Screw is .500 back from spindle face



Without the tool holder inserted, install the mounting screw with an Allen wrench so that it is below the O.D. of spindle, as shown...

Align the hole on stub body with the hole on the outer shell. Slide the OSA assembly over the spindle so that holes are aligned with tapped hole in the spindle.



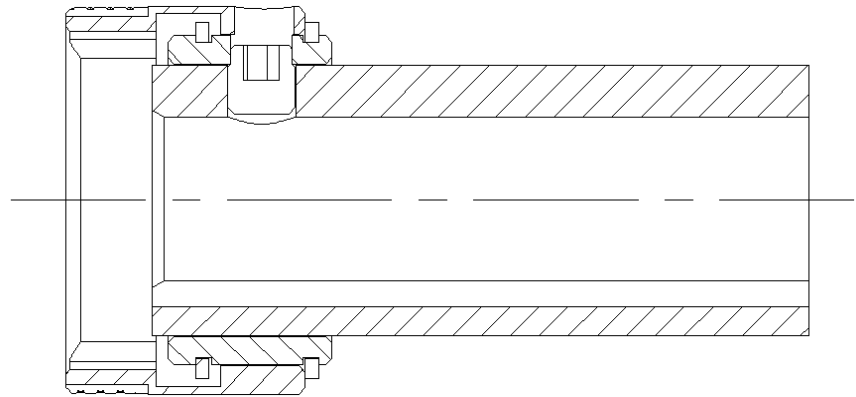
Align the hole on stub body with hole on outer shell.

Slide OSA assembly over the spindle so that all 3 holes are aligned

Locking OSA assembly to Spindle

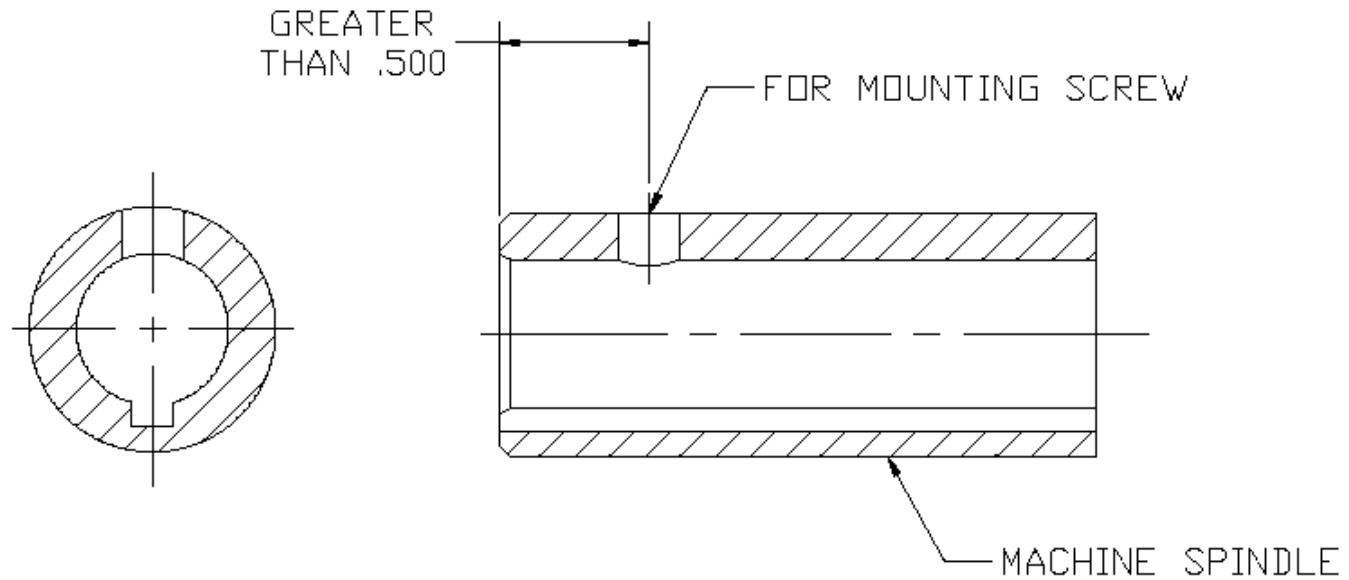
Access the mounting screw through the aligned holes.

Back the screw out until it stops, clearing the spindle I.D. and locking the OSA assembly in place, as shown.



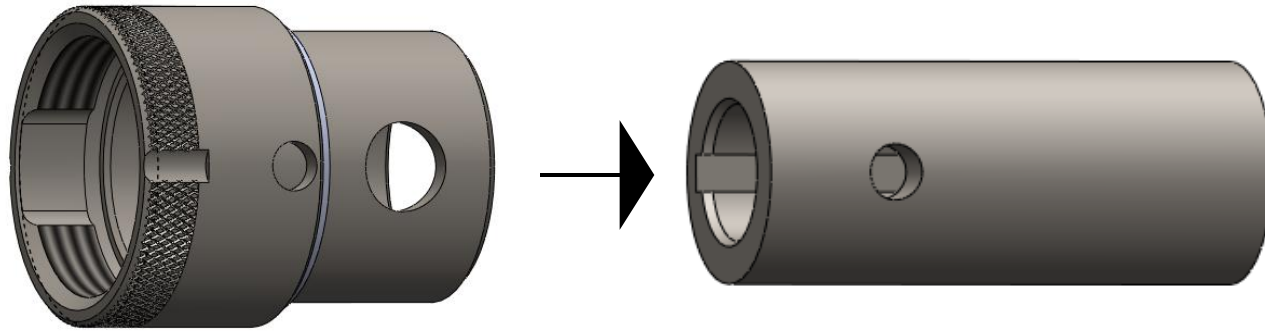
OSA Smith-Lock[®] Standard Series

Spindle Mounting Screw is greater than .500 back from spindle face

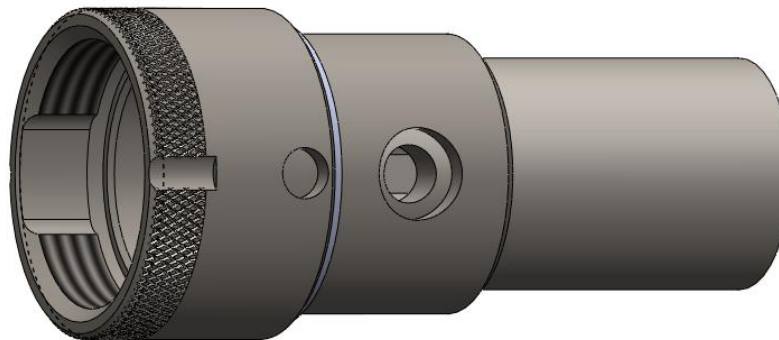


OSA Smith-Lock[®] Standard Style

Spindle Mounting Screw is Greater than .500 back from spindle face



Slide the OSA over the spindle, aligning the mounting hole with the tapped hole in the spindle.

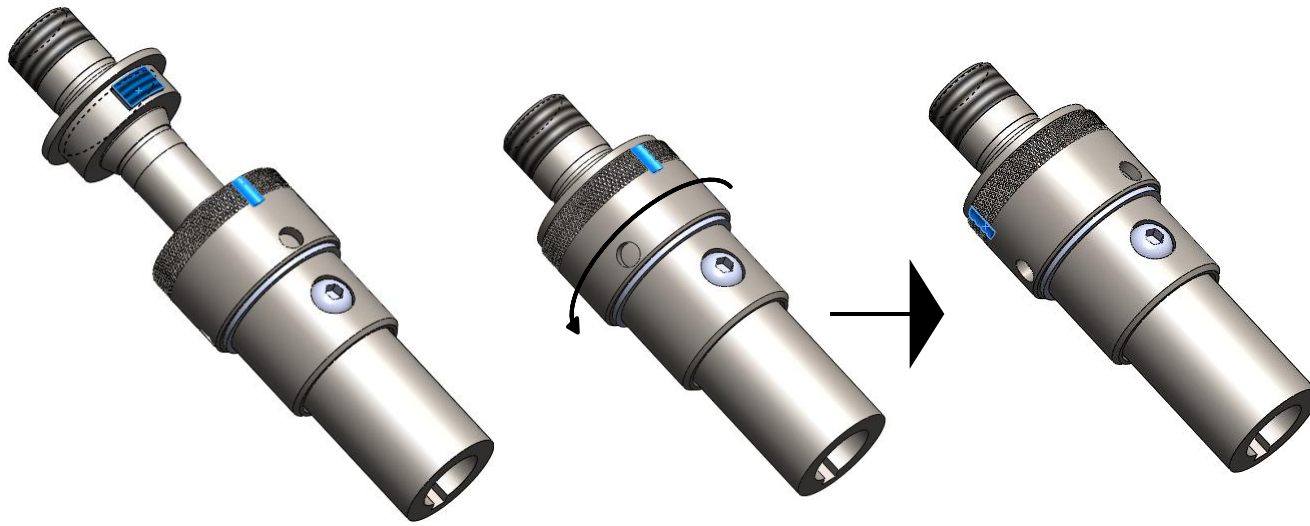


Mounting OSA to Spindle



Install curved washer over mounting hole, followed by button-head screw, as shown.

Inserting and Locking Tool Holder In Place



When inserting the tool holder, ensure the indicator mark on the OSA is lined up with threads on the holder

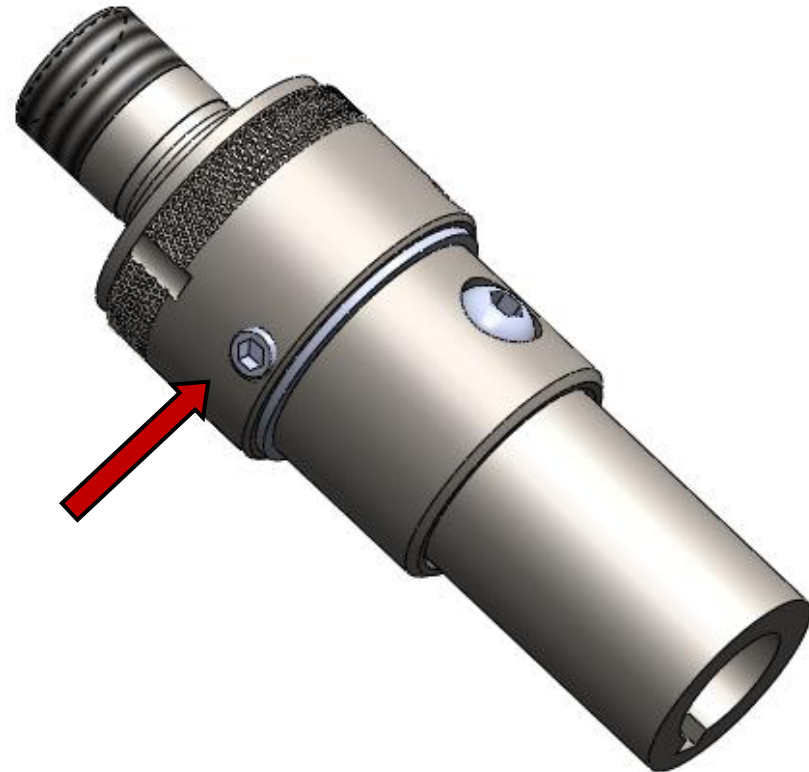
With the tool holder completely inserted, rotate the outer shell on the OSA $\frac{1}{4}$ turn to lock the holder in place, as shown

ADDITIONAL HELPFUL INFORMATION

It is recommended to tighten the lock screw when:

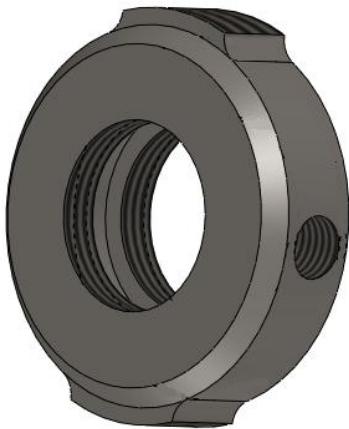
- Excessive inertia is present due to fast spindle starts/stops.
- Excessive chatter is present
- Interrupted cuts occurs

The lock screw **MUST** be loosened before attempting to extract the holder from the spindle.




SMITH-LOCK[®] CONVERSION NUT

OSA Smith-Lock[®] Conversion Nuts can be used on standard ACME shank tooling.



Replace the ACME adjustment nut with the Smith-Lock[®] conversion nut and follow instructions on previous pages.



**For additional information,
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