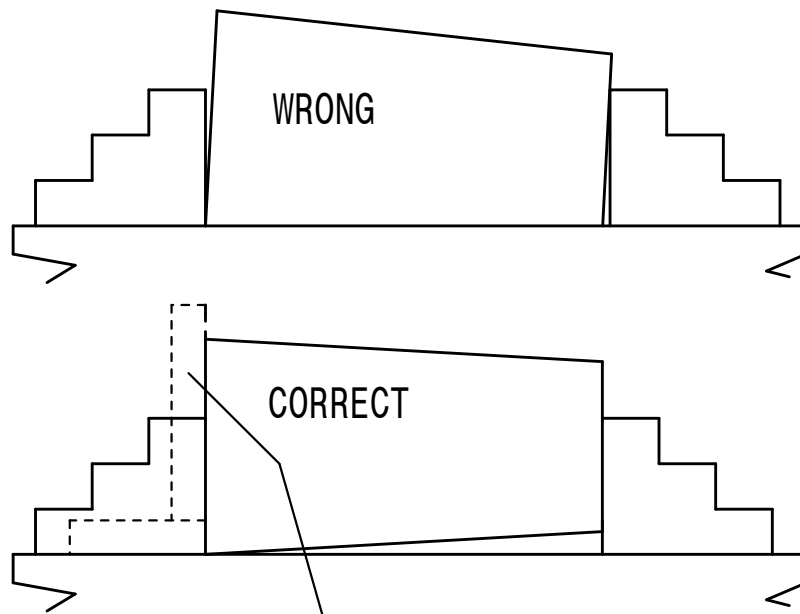


ANGLE ON CASTING
SHOWN EXAGGERATED

SK 1.



USE ENGINEERS SQUARE OFF CHUCK FACE TO
ENSURE THE WORKPIECE SIDE FACE IS UPRIGHT
WHEN TIGHTENING CHUCK.

SK 2.