

*Placing Raster® Braille into aluminum, brass, stone, or solid-surface materials requires a Collet Drill Assembly and Drill Bits.*

*We recommend using the Collet Drill Assembly when drilling holes for Raster® spheres in materials that do not possess a “memory”. This method should be used with an adhesive to secure to the Raster® spheres in place.*



### The Collet Drill Assembly & Parts

The Collet Drill Assembly has been engineered under tight tolerances specifically for our B50 and B52 drill bits. Using other types of drill bits in this collet drill assembly may damage the unit or cause it to not function properly.

#### Collet Drill Assembly

- Part No. 34001003 11/64 inch (top load) with 2 mini wrenches
- Part No. 34001000 1/4 inch (top load) with 2 mini wrenches
- Part No. 34001001 1/4 x 2 inch (bottom load) with 1 mini wrench

#### Collet Drill Bits (sold separately)

- Part No. 36001000 B50 Carbide Drill Bit  
(for placing metal Raster® spheres into metal substrates)
- Part No. 36001001 B52 Carbide Drill Bit  
(for placing acrylic Raster® spheres into metal substrates)

#### Additional Mini Wrenches (sold separately)

- Part No. 39001006 3/16” wrench for 1/4” Collet Drill Assembly
- Part No. 39001007 5/32” wrench for 11/64” Collet Drill Assembly

### How to Use the Collet Drill Assembly

1. Unscrew the small shaft at the end of the collet where the drill bit will be inserted so that it is loosened.
2. Insert a drill bit into the opening of the collet and allow anywhere from 1/4” to 1/2” to protrude from the end and begin tightening the collet by twisting the two shafts back together.
3. Secure the drill bit into place with two mini wrenches. The wrenches should be placed in the grooves that are located at the very tip of the small shaft (where the drill bit gets inserted) and at the upper end of the longer shaft (the drill bit end). Tighten until secure, but do not over-tighten or damage could occur.
4. While holding the collet shaft steadily, firmly pull the drill bit outwards to ensure that it is securely locked into place. The collet drill assembly (with a drill bit) should now be ready to install into your engraver/router spindle.
5. When finished, remove the collet drill assembly from the engraver/router spindle and then remove the carbide drill bit from the collet drill assembly by loosening it once again with the two mini wrenches.

To order  
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800-869-7800