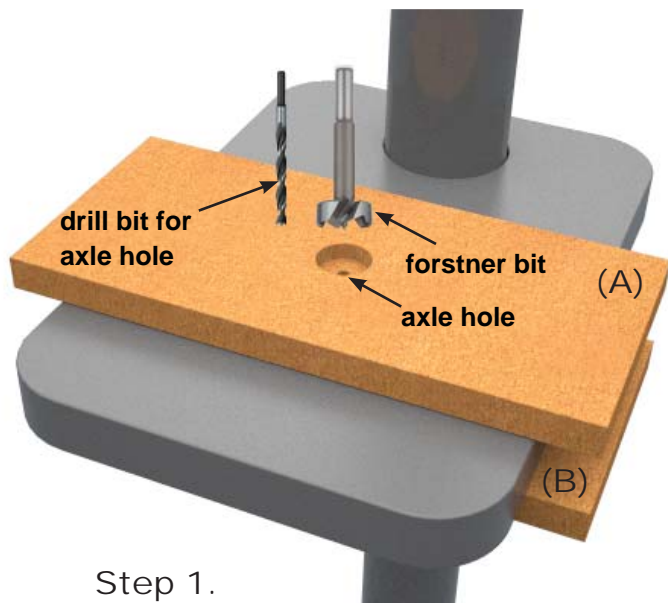
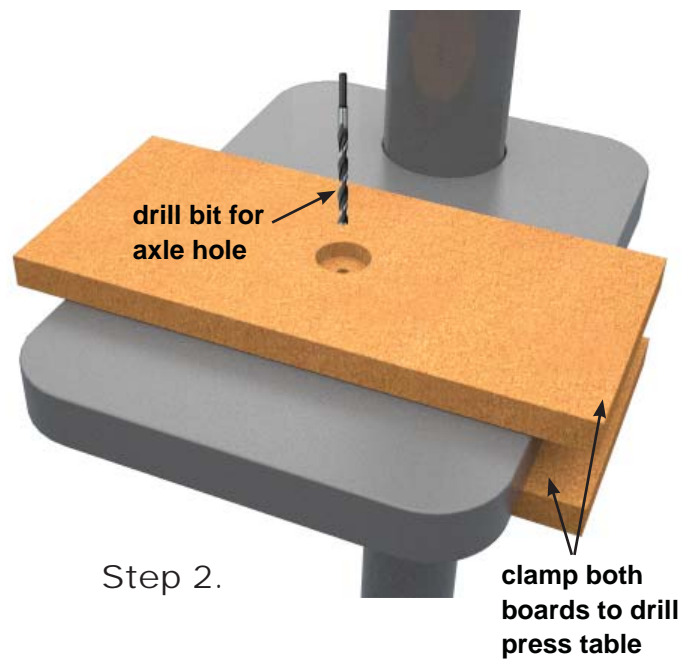


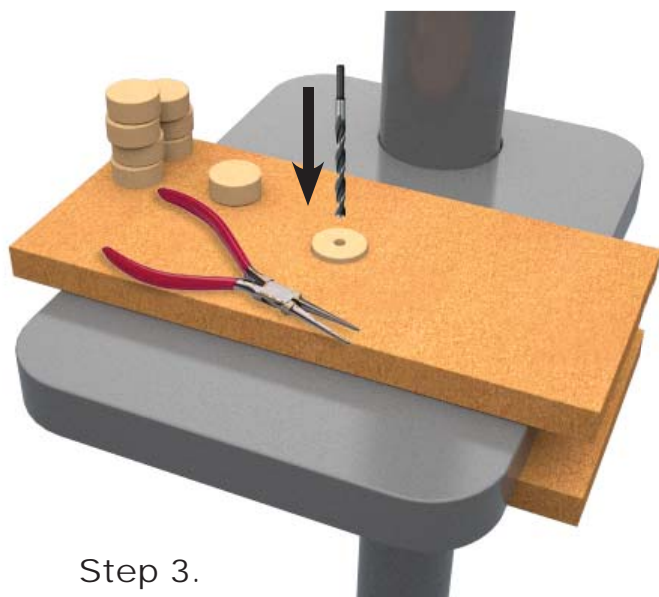
HOW TO DRILL SMALL WHEELS MADE FROM WOOD DOWEL STOCK



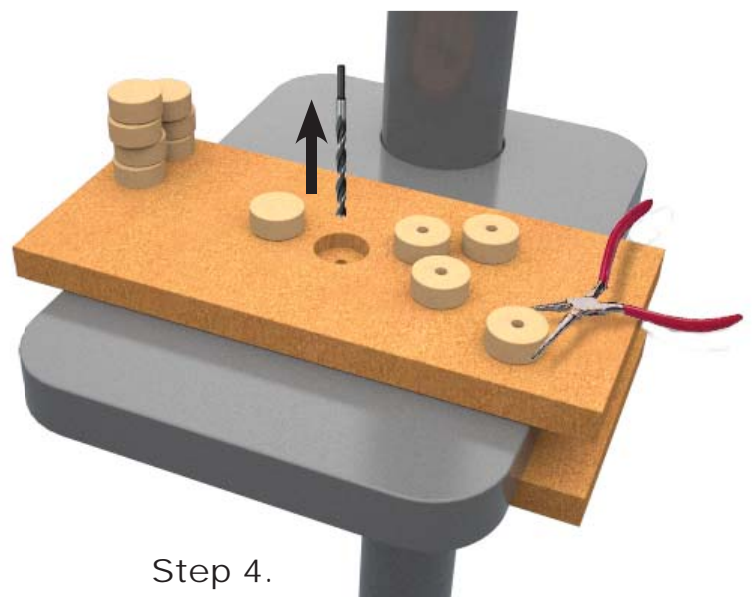
Step 1.



Step 2.



Step 3.



Step 4.

Step 1. Cut two pieces of lumber $\frac{3}{4}$ " 5-1/2" x 12". Medium Density Particle Board works well for production jigs. Use a drill bit the diameter of the wheel axle hole to drill a hole through the center of (A). Next use a Forstner Bit the diameter of the wheel to drill a hole aligned with the axle hole to a depth of $\frac{1}{2}$ the thickness of the wheels to be drilled.

Step 2. Use the undrilled board (B) to assist in clamping (A) to the drill press table while aligning (A) with the axle hole by lowering the axle hole

drill bit mounted in the drill press into the hole in (A).

Step 3. Place an undrilled wheel blank into the wheel cavity in (A) and drill the wheel through using the axle hole bit.

Step 4. Use a pair of needle nose pliers to grip the wheel while drilling the wheel to keep the wheel from spinning. The pliers are also handy for quickly removing the drilled wheel and then for inserting an undrilled wheel for drilling.