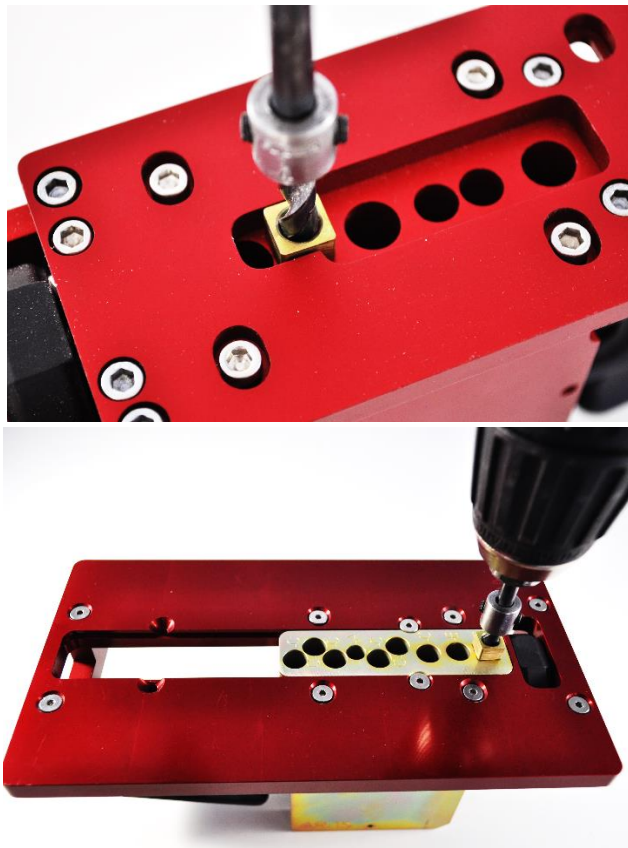




**MODULUS ARMS**



## ***Speed Drill Instructions***

***Patent Pending***

## Modulus Arms Speed Drill Kit Contents

The Modulus Arms Speed Drill contains the following parts:

1. Speed Drill
2. ¼" drill bit
3. ¼" drill stop



*Figure 1: Speed Drill Contents (Actual parts may vary)*

## Modulus Arms Speed Drill Instructions

### Introduction

The Speed Drill is used to drill pilot holes before drilling the 3/8" holes used with all Modulus Arms Jigs. In all areas where a 3/8" Drill Bit is used on your Modulus Arms Jig you can use the Speed Drill to drill a ¼" pilot hole, which drastically reduces the time and effort to complete the material removal as well as reducing wear on the drill guide.

Wherever the Jig Instructions require you to drill a 3/8" hole, if you have a Speed Drill, you will first drill a ¼" pilot hole.

### Using the Speed Drill

Insert the ¼" Drill bit into the drill. Slide the drill stop onto the drill bit. Slide the Speed Drill onto the drill bit. Insert the drill bit and speed drill into the depth gauge. The speed drill should be touching the top of the depth gauge as shown in Figure 2. Slide the drill bit in until it bottoms on the depth gauge. Tighten the drill stop onto the drill bit locking it in position.



*Figure 2: Speed Drill, Drill Stop and Drill in Depth gauge*

Insert the Speed Drill into the 3/8" hole as seen in Figure 3. Drill the hole until the drill stop touches the top of the speed drill. You will need to repeat this as many times as necessary per your Jig Instructions. The depth of each hole will be determined by the Jig Instructions and found with the Depth Gauge. Do not drill any deeper. In the rare event that the speed drill starts to rotate, it has flat sides to use a wrench or pair of vise-grips. Your lower should look similar to Figure 4 after using the Speed Drill depending upon the Jig you are using.



*Figure 3: Using the Speed Drill*



*Figure 4: Example of Lower after use of Speed Drill*

After the pilot holes are made with the Speed Drill, use the 3/8" drill bit and the Jig Drill Template included with your Jig per the Jig instructions. With the 1/4" pilot holes, the 3/8" holes will require little effort to drill. As a result, reduce the feed rate of the 3/8" drill bit to prevent binding. Figure 5 illustrates a lower after use of the 3/8" bit.



*Figure 5: Example of Lower after use of 3/8" Drill Bit*