



# CENTERLINE PEARL JIG

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No. 410-741

***For use with a #60 (0.04" / 1.02 mm) drill***

## Drilling Through Pearls

1. Insert a #60 drill into your drill press or flexshaft handpiece and tighten the chuck only enough to keep the drill from falling out.
2. Unscrew the knurled knob of the Centerline Jig until the space between the two plastic pads is the size of the pearl you will be drilling.
3. Slide the drill bit into the top hole of the jig until it touches the opposite pad. Position the drill in the chuck so that the chuck touches the top of the jig, acting as a stop. Tighten the chuck completely.
4. Remove the drill from the jig and loosen the knurled knob enough to insert the pearl between the plastic pads.
5. Place the pearl on the lower pad and tighten the knurled knob by hand until the pearl is secure. ***DO NOT OVERTIGHTEN.***
6. Using water as a lubricant/coolant, slowly drill through the pearl. Remove the drill occasionally to re-wet.

## Half Drilling Pearls

To drill partially through a pearl, follow steps 1 & 2 above. At step 3, adjust the length of the drill bit so that it will only drill part-way through the pearl, using the chuck as a stop. Continue, following steps 4 through 6 above.

## Cleaning an Obstructed or Imperfect Hole

1. Insert a #60 drill into the top hole of the Centerline Jig.
2. Secure your pearl between the pads of the jig, aligning the hole of the pearl with the drill. ***DO NOT OVERTIGHTEN.***
3. Remove the drill from the jig and install it in a pin vise, flexshaft handpiece, or drill press.
4. Using water as a lubricant/coolant, slowly clean out the hole.