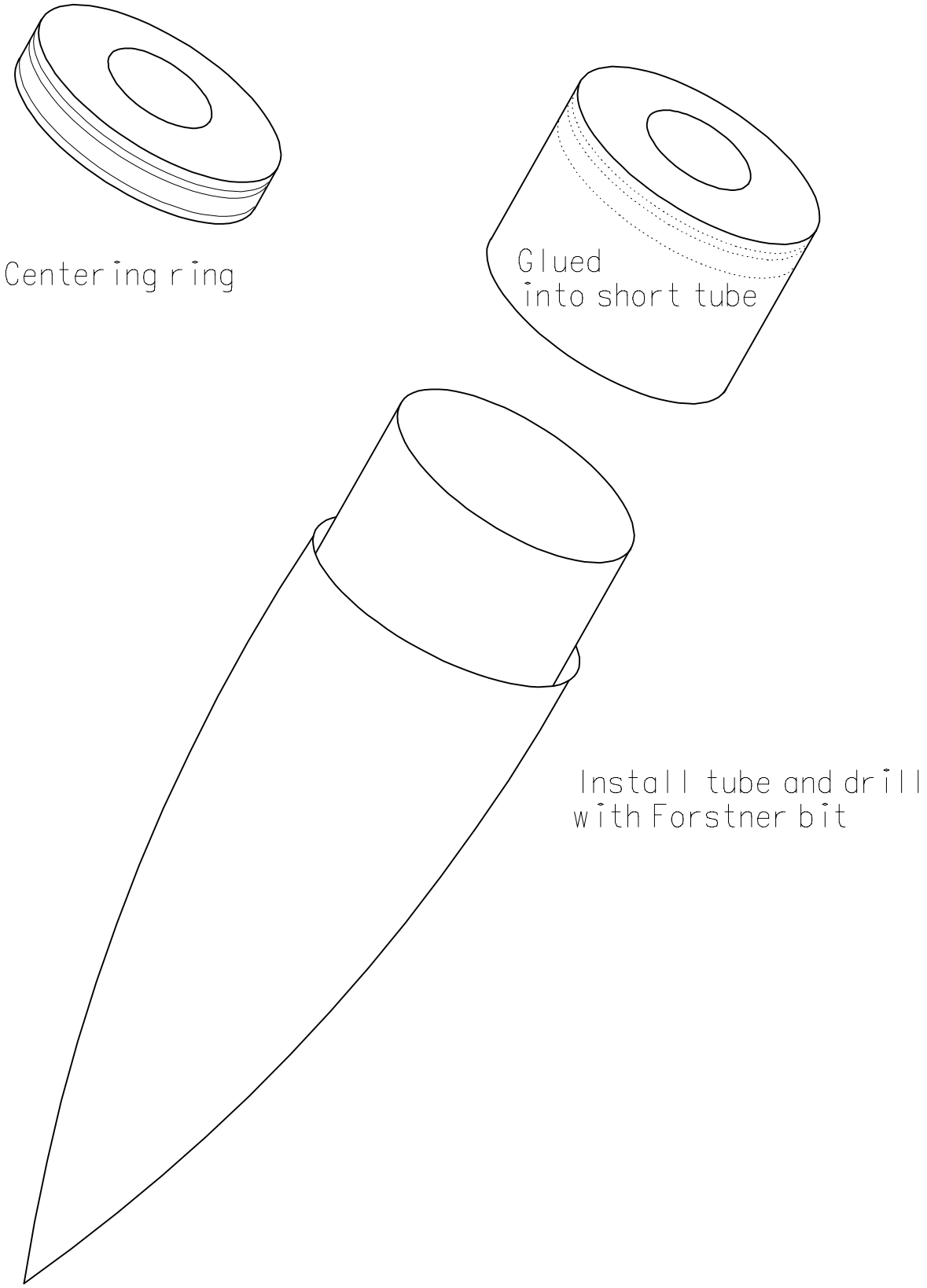
Centering ring
Glued
into short tube
Install tube and drill
with Forstner bit