

## INSTALLATION INSTRUCTIONS

To prepare the lathe for installing the Quick-Change Attachment:

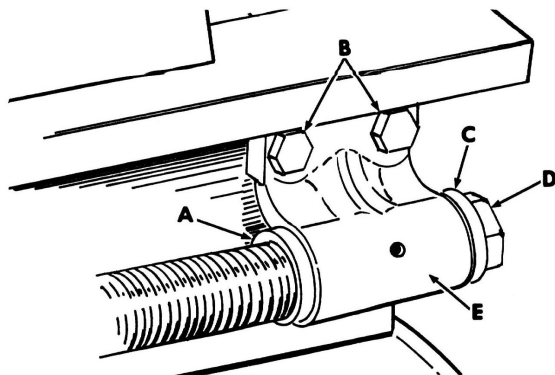


Figure 1

1. Remove nut (D, fig. 1) and collar (C) from end of lead screw.

2. Remove screws (B) from lead screw bracket (E) and slide bracket off lead screw.

NOTE: Leave collar (A) on lead screw.

3. Remove screws (A, fig. 2) and slide feed gear assembly (C) off lead screw (B).

4. Open half nuts and remove lead screw from apron.

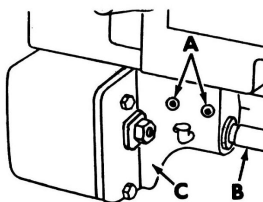


Figure 2

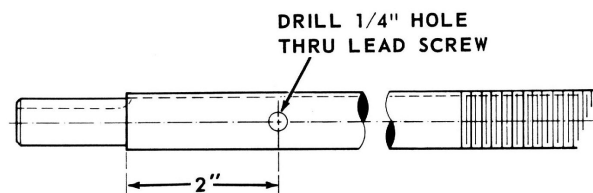


Figure 3

5. Drill 1/4" hole thru lead screw as shown in figure 3.

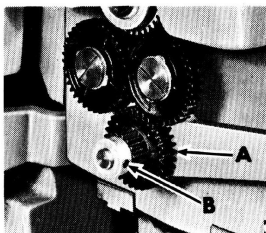


Figure 4

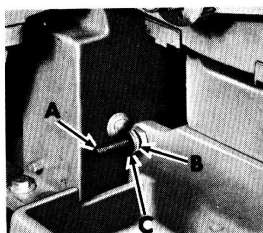


Figure 5

6. Remove compound gear (A, fig. 4) by loosening set screw (B) in collar and replace with compound gear supplied with quick-change.

7. Place square head bolt (A, fig. 5) in lathe leg and lock with jam nut - position nut (B) and washer (C) on bolt.

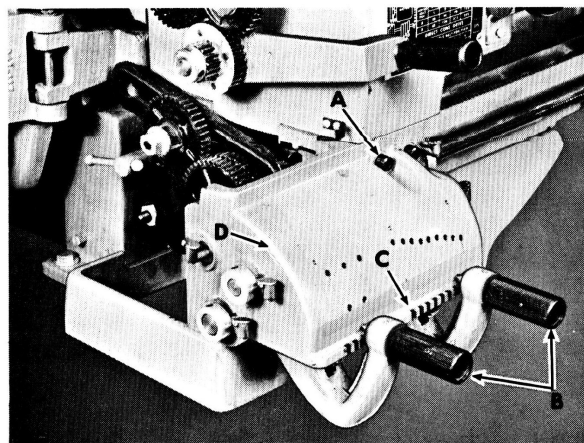


Figure 6

8. Fasten the quick-change gear housing (D, fig. 6) to lathe bed with screws (A, fig. 2). DO NOT tighten securely.

9. Slide lead screw (B, fig. 7) thru apron and in slipping clutch (A), aligning key of clutch with keyway in lead screw.

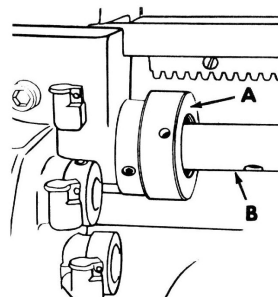


Figure 7

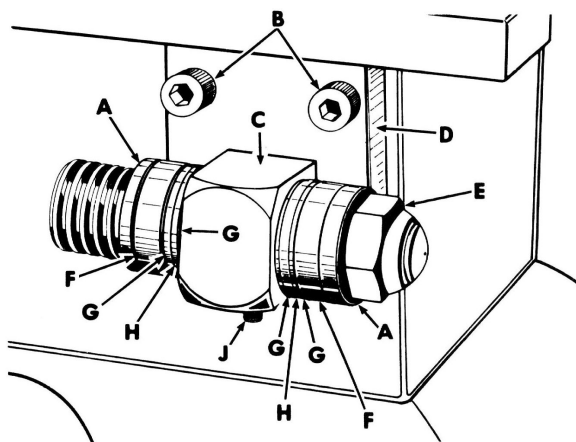


Figure 8

10. To assemble lead screw bearing bracket:

A. Install bearing (C, fig. 8) in bracket (D) but DO NOT tighten set screw (J).

B. Install spacer (F), plate (G), bearing (H), and plate (G) on lead screw.

C. Slide bearing bracket (C) on screw.

D. Install plate (G), bearing (H), plate (G), spacer (F), collar (A) and cone lock nut (E) on screw.

IMPORTANT: Tighten cone lock nut until end play has been removed from lead screw.