



NOTES.

1. FIRST TURN 6mm DIAMETER x 9mm LONG AND 8mm DIAMETER 21mm LONG. OFFSET IN FOUR JAW CHUCK BY 0.35mm (0.7mm TOTAL INDICATOR READING) AND TURN THE OFFSET DIAMETER. THE 6.7mm DIAMETER QUOTED IS FOR REFERENCE PURPOSES ONLY. INITIALLY TURN TO 7.5 mm DIAMETER, REDUCING IT IN STAGES UNTIL A SATISFACTORY CLAMPING ACTION IS ACHIEVED. 2. ON FINAL ASSEMBLY, REDUCE THE 9mm LENGTH UNTIL THE M5 CSK SCREW, WHEN TIGHT, PERMITS THE SPINDLE TO ROTATE WITHOUT EXCESSIVE END PLAY.

MATERIAL. 12 DIA STEEL 230M07 QUANTITY. 2 OFF.

LOCKING SPINDLE. 4





QUICK CHANGE LATHE TOOL POST.