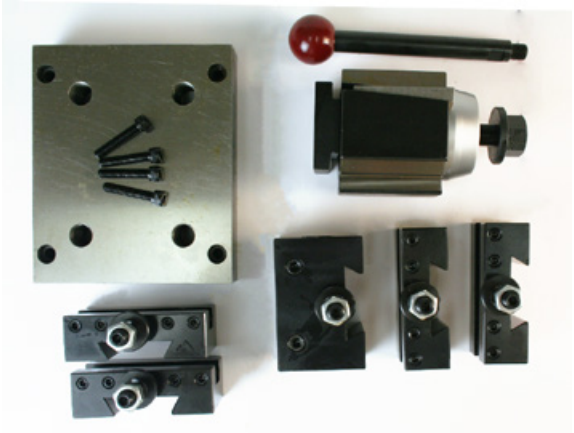
Quick Change Tool Post Installation

Product Identification: Quick Change Tool Post Kit (PN 33272)

Purpose: This document details the installation and use of the Quick Change Tool Post Kit on a 15L Slant-PRO™ Lathe.

Qty.	Quick Change Tool Post Kit	Size	PN
1	Quick Change Tool Post	CXA	34129
1	Tool Post Handle	—	
2	#2 Tool Holder for Quick Change Post	CXA	33124
2	#1 Tool Holder for Quick Change Post	CXA	33123
1	#4 Tool Holder for Quick Change Post	CXA	33125
1	Quick Change Tool Mount Plate	—	33202
4	M8 x 40 mm Socket Head Screw	—	

NOTE: *If any of these items are missing, contact Tormach Customer Service at (608) 849-8381 for a replacement.*



Required Tools and Items:

- Dead-blow hammer
- Metric hex wrench set
- Rust preventative
- Adjustable wrench
- Magnetic dial test indicator

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Installation

1. Remove Mounting Block from bottom of Tool Post and discard. Mounting Block is shown in **Figure 1**.
2. Inspect surfaces of both carriage and Tool Mount Plate; remove burrs, wipe off grit and dirt. If necessary, use hand-held stone to deburr surface. Spray surfaces with rust preventative such as WD40®.

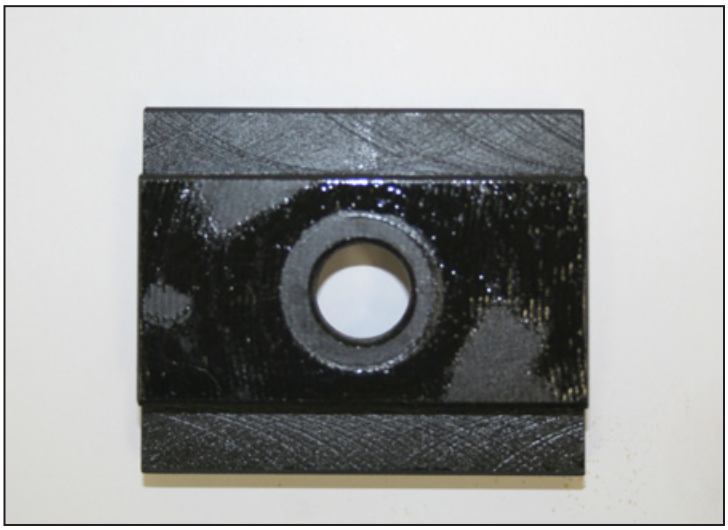

Figure 1

3. Position Tool Mount Plate on lathe carriage; using four M8 x 40 mm Socket Head Screws, attach plate to lathe carriage (see **Figure 2**).

Figure 2

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Figure 3

Figure 4

4. Screw Tool Post Stud into plate and tighten snug (see **Figure 3**).
5. Slide Tool Post over stud. Attach Nut and hand tighten (see **Figure 4**). Screw Tool Post Handle into Tool Post.
6. Match up desired Tool Holder with the desired tool (see **Figure 5**).

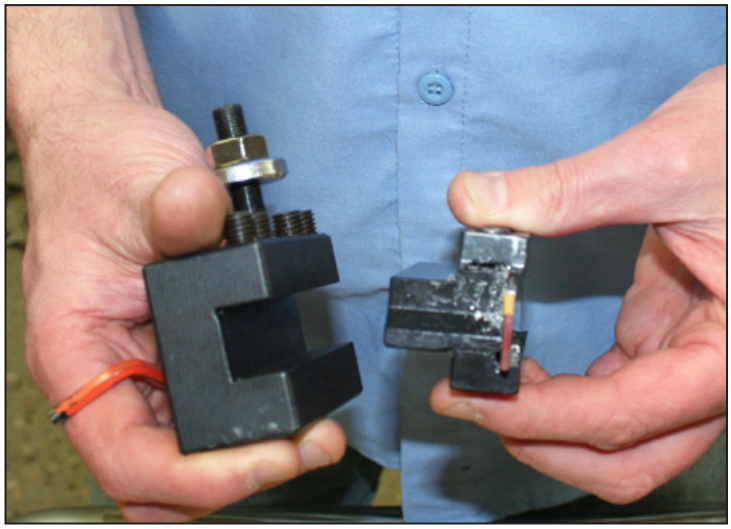

Figure 5

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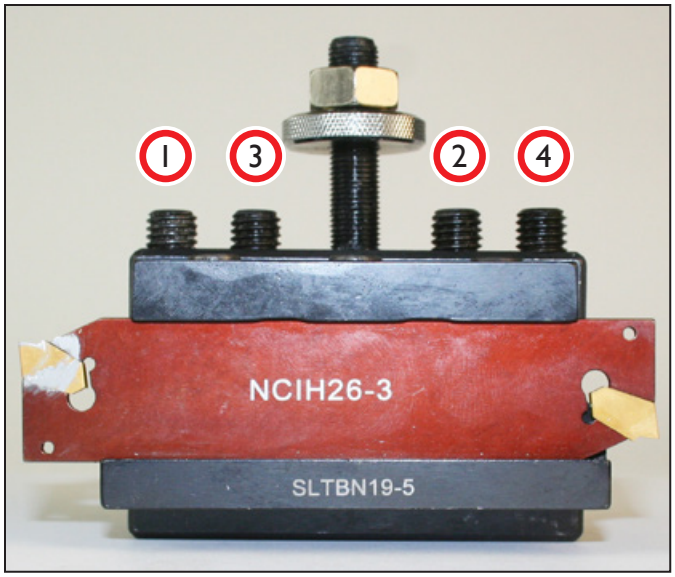

Figure 6

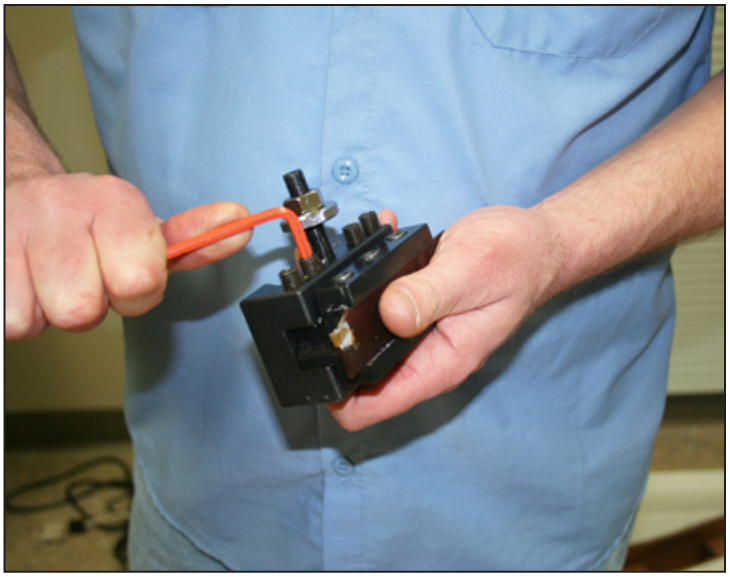

Figure 7

7. Lock tool into Tool Holder by tightening hex-head screws in sequence shown in **Figure 6** and **Figure 7**.
8. Adjust Thumb Screw to set Tool Holder height; secure with Stop Nut (see **Figure 8**).

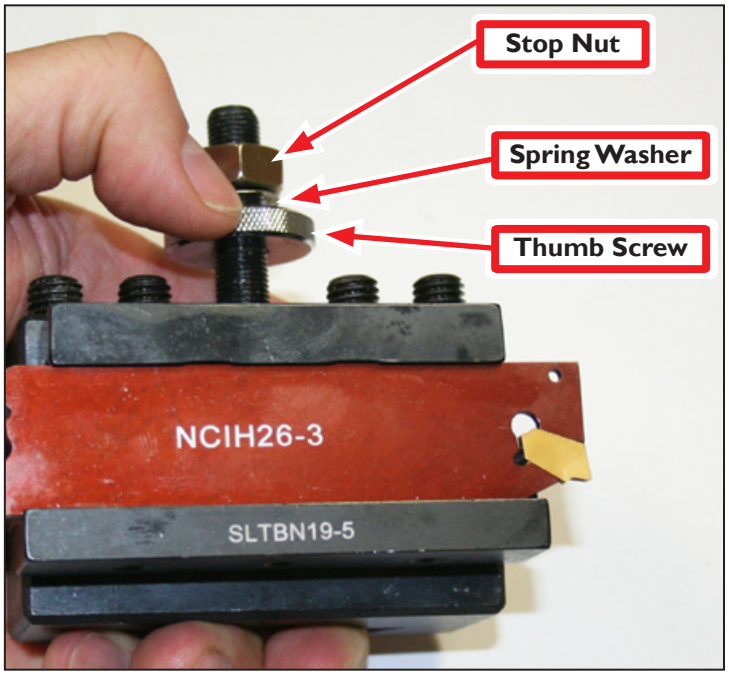

Figure 8

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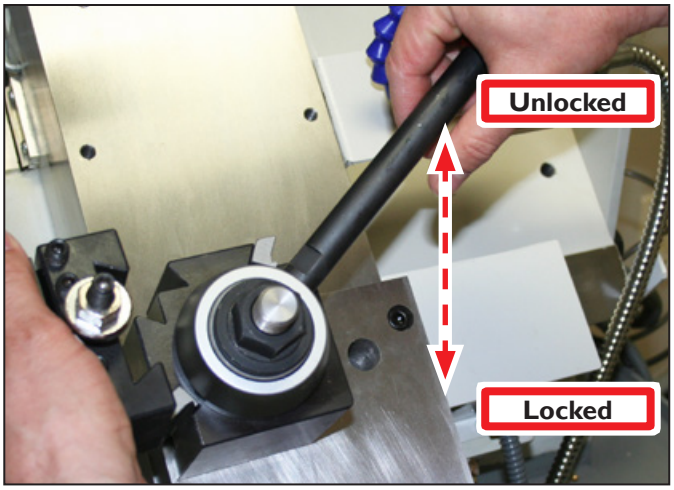

Figure 9

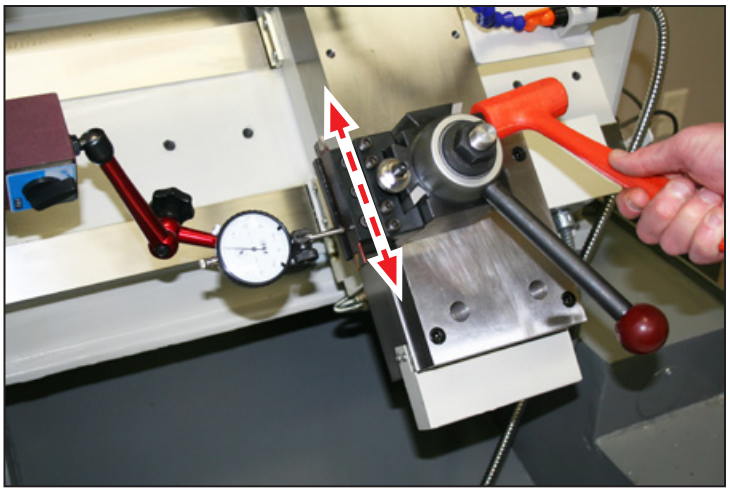
Figure 10

9. Swing Tool Post Handle up to unlocked position (see **Figure 9**).

NOTE: *Tool Post lever must be in unlocked position to attach holder.*

10. Slide Tool Holder onto Tool Post dove tail (see **Figure 9**). Swing Tool Post Handle down to locked position.
11. Attach magnetic dial test indicator to spindle. Position indicator tip against tool face. Power up lathe and move carriage back and forth on X-axis against indicator tip (see **Figure 10**).
12. To correct Tool Post misalignment, tap with dead-blow hammer to adjust, as necessary (see **Figure 10**). Repeat Steps 11 and 12 until suitable alignment is achieved.
13. Tighten Tool Post nut securely with adjustable wrench (see **Figure 11**).
14. Recheck tool with dial indicator to ensure position did not change following tightening of nut.

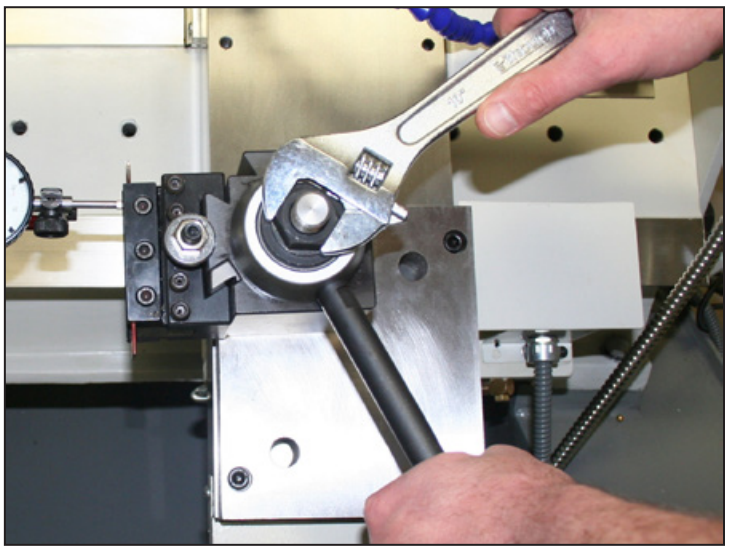
Figure 11

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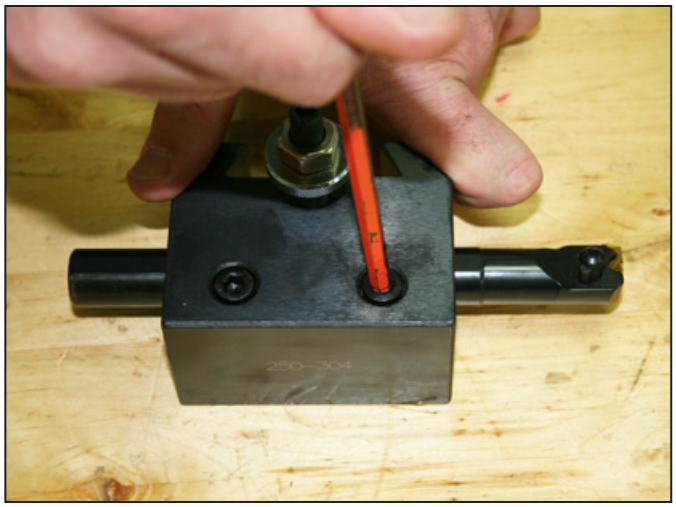

Figure 12

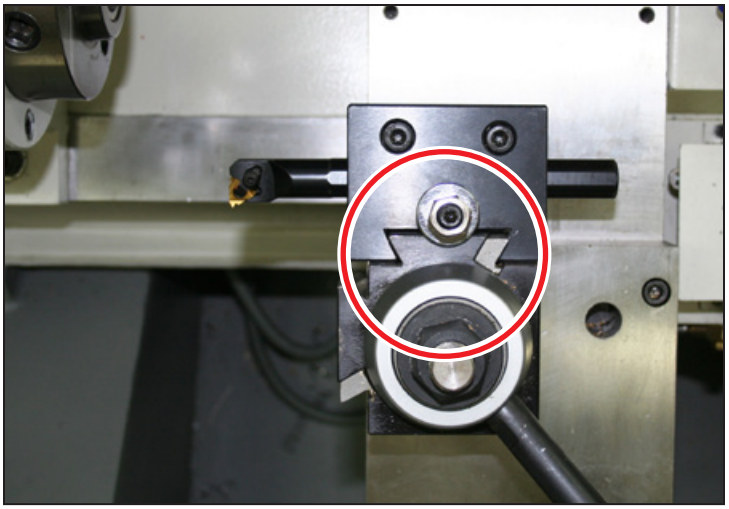

Figure 13

Boring Bar Holder Useage

1. Insert desired tool into Boring Bar Holder and lock tool by tightening two hex-head cap screws (see **Figure 12**).
2. Move Tool Post lever to the unlocked position and slide Boring Bar Holder onto the QCTP dove tail (see **Figure 13**); swing Tool Post lever down to locked position.
3. To change tools, loosen hex cap screws on Boring Bar Holder.
4. Tap both hex-head cap screws with dead-blow hammer to release tool (see **Figure 14**).

NOTE: *Reducer Sleeve (3/4"-1"), located inside the Boring Bar Holder, is included.*

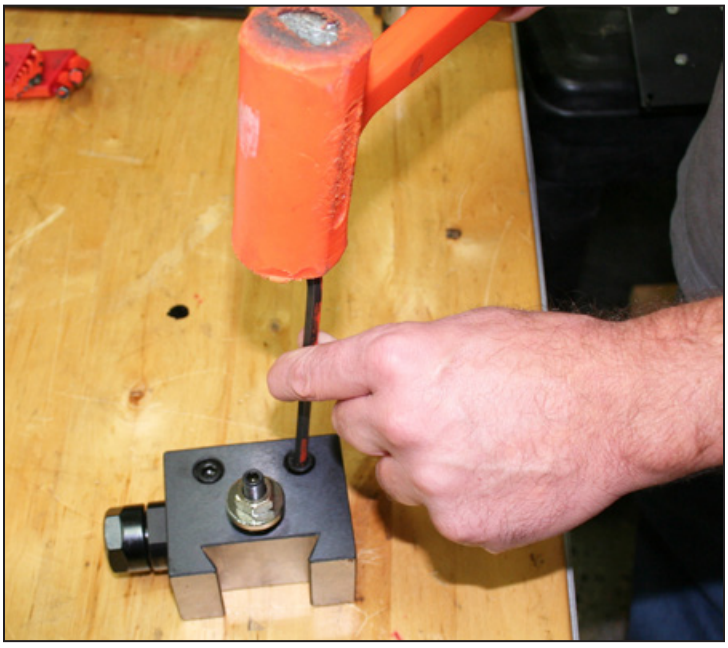

Figure 14

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