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Technical Document

Chuck Guard Kit Installation

Product Identification: 15L Slant-PRO Lathe Chuck Guard Kit (PN 33323)

Purpose: This document details installation of the lathe's Chuck Guard Kit.

Qty Chuck Guard Installation Kit (PN 33323)

1	Chuck Guard
1	Back Splash
1	Front Splash Guard
4	Socket Head Cap Screws (5 mm) w/ lock washers
2	Socket Head Cap Screws (6 mm short) w/ lock washers and nuts
1	Splash Flap w/ two Metal Tie Down Strips
1	T-hex Wrench (6 mm)
10	M5 Phillips Head Screws, Nuts, and Lock Washers
3	Socket Head Cap Screws (6 mm long) w/ Flat Washers, Lock Washers, and Nuts
1	Strip of Edge Trim

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

NOTE: Some screws listed in this document are pre-installed on lathe.

Install Chuck Guard

1. After unpacking the Chuck Guard, hold it with two hands in the locations shown in **Figure 1**.

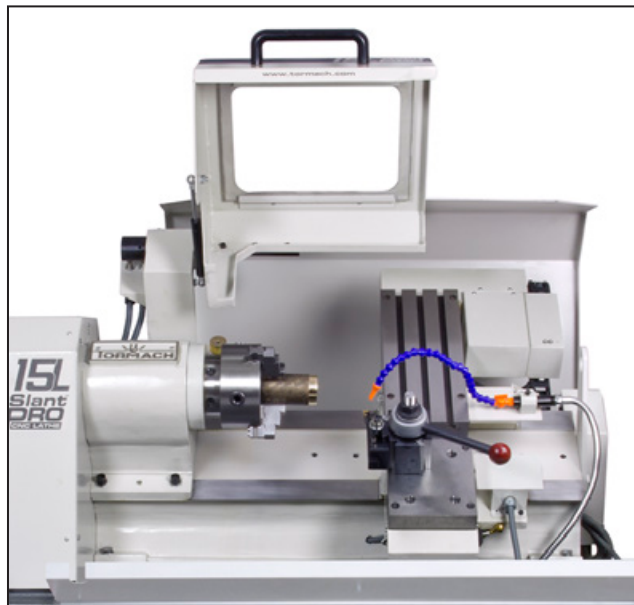


Figure 1

2. Hold the Chuck Guard arm in alignment with the headstock holes (see **Figure 2**).

NOTE: Installation of the Chuck Guard arm requires two people.



Figure 2

3. Using a hex wrench, tighten four socket head screws (pre-threaded) into headstock holes (see **Figure 3**).
4. Locate and mount the Limit Switch bracket using screws pre-threaded in the main chuck guard bracket (see **Figure 4**).

NOTE: The Limit Switches and bracket are pre-wired to the lathe.



Figure 3

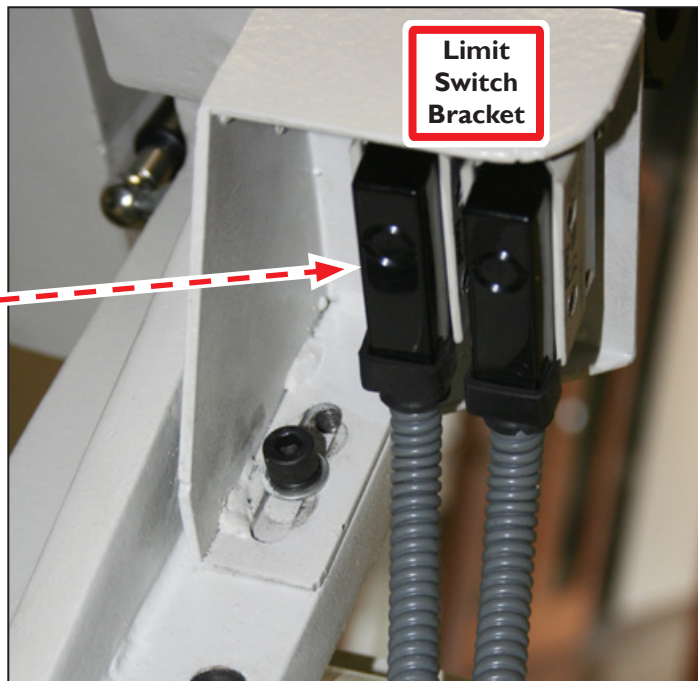


Figure 4

Install Back Splash

1. Position Back Splash at the back of lathe, ensuring the slot located at the bottom of Back Splash fits over the back edge of lathe pedestal (see **Figure 5** and **Figure 6**).

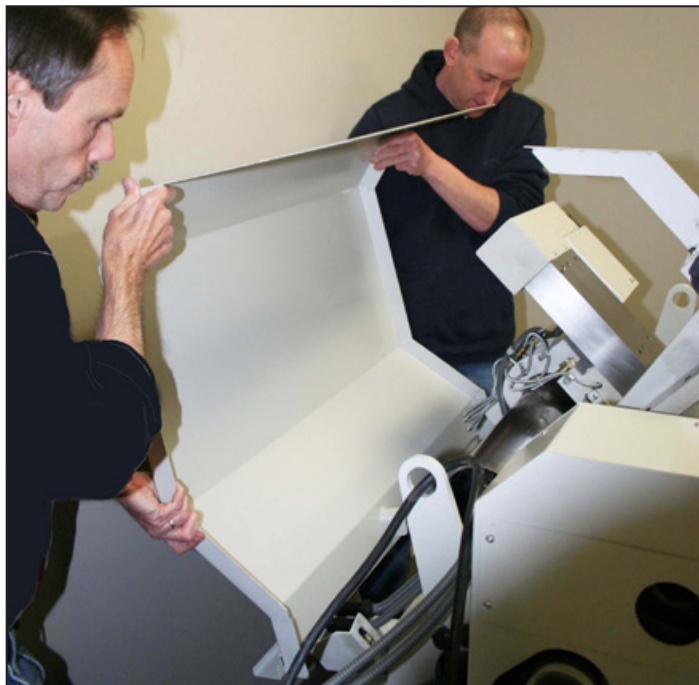


Figure 5



Figure 6

2. Attach the Back Splash to the lathe pedestal with four 5 mm Socket Head Cap Screws (see **Figure 7**).



Figure 7

Connect Back Splash

1. Connect the top of the Back Splash to the Chuck Guard using two 6 mm Socket head cap Screws, lock washers, flat washers and nuts (see **Figure 8**).

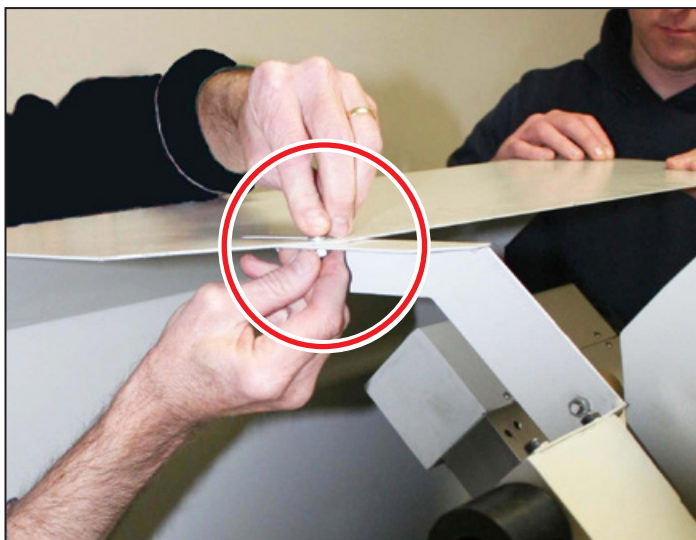


Figure 8

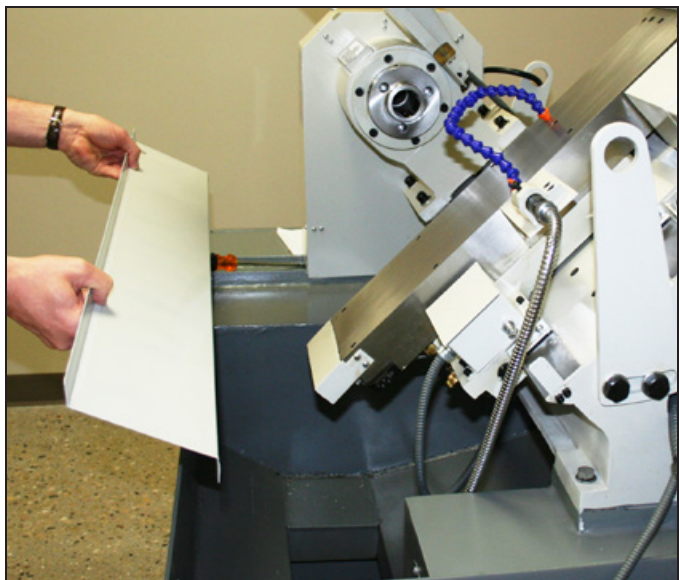


Figure 9

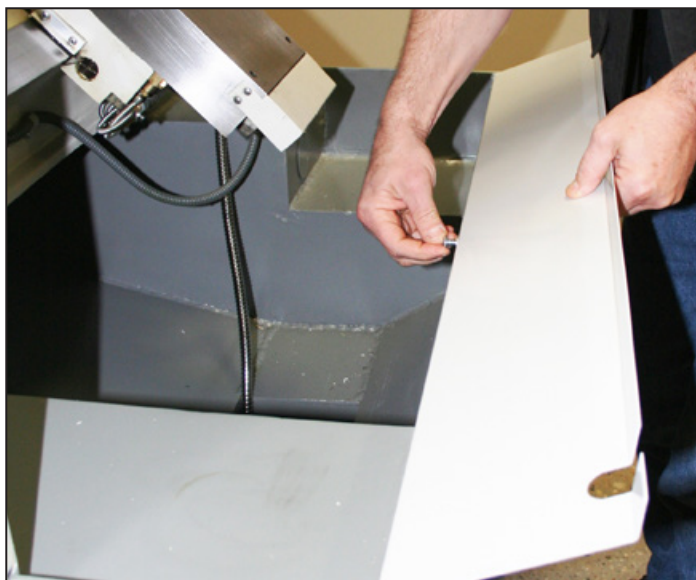


Figure 10

Install Front Splash

1. Attach the Front Splash guard to lathe's front pedestal using three 6 mm long Socket Head Cap Screws (see **Figure 9** and **Figure 10**).
2. Slip Edge Guard over top edge of Front Splash as shown in **Figure 11**.

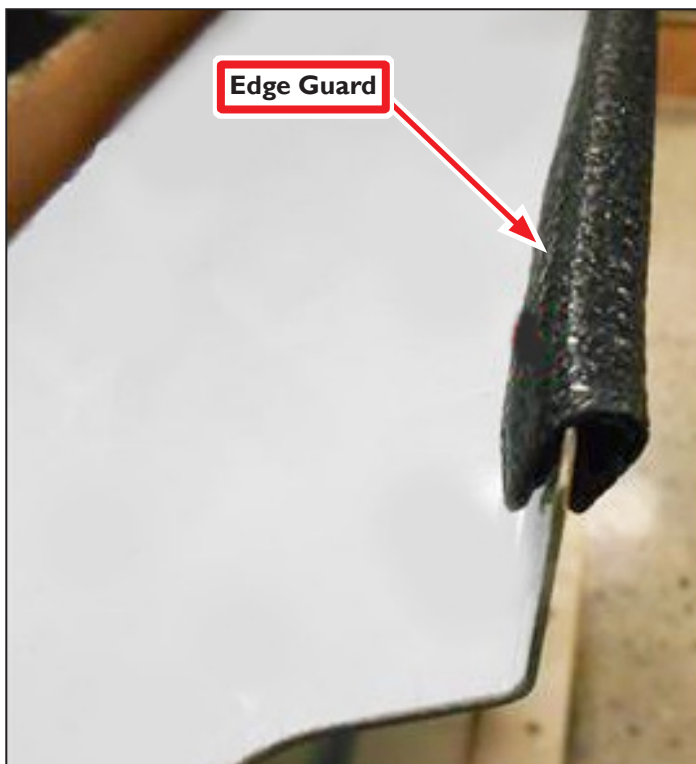


Figure 11

Install Splash Flap

1. Install the Splash Flap to prevent spray back of coolant above the Chuck Guard with 10 Phillips Head Screws, lock washers, and nuts as shown in **Figure 12**.

NOTE: Some tweaking of the upper Back Splash bracket may be required to align the Splash Flap holes.

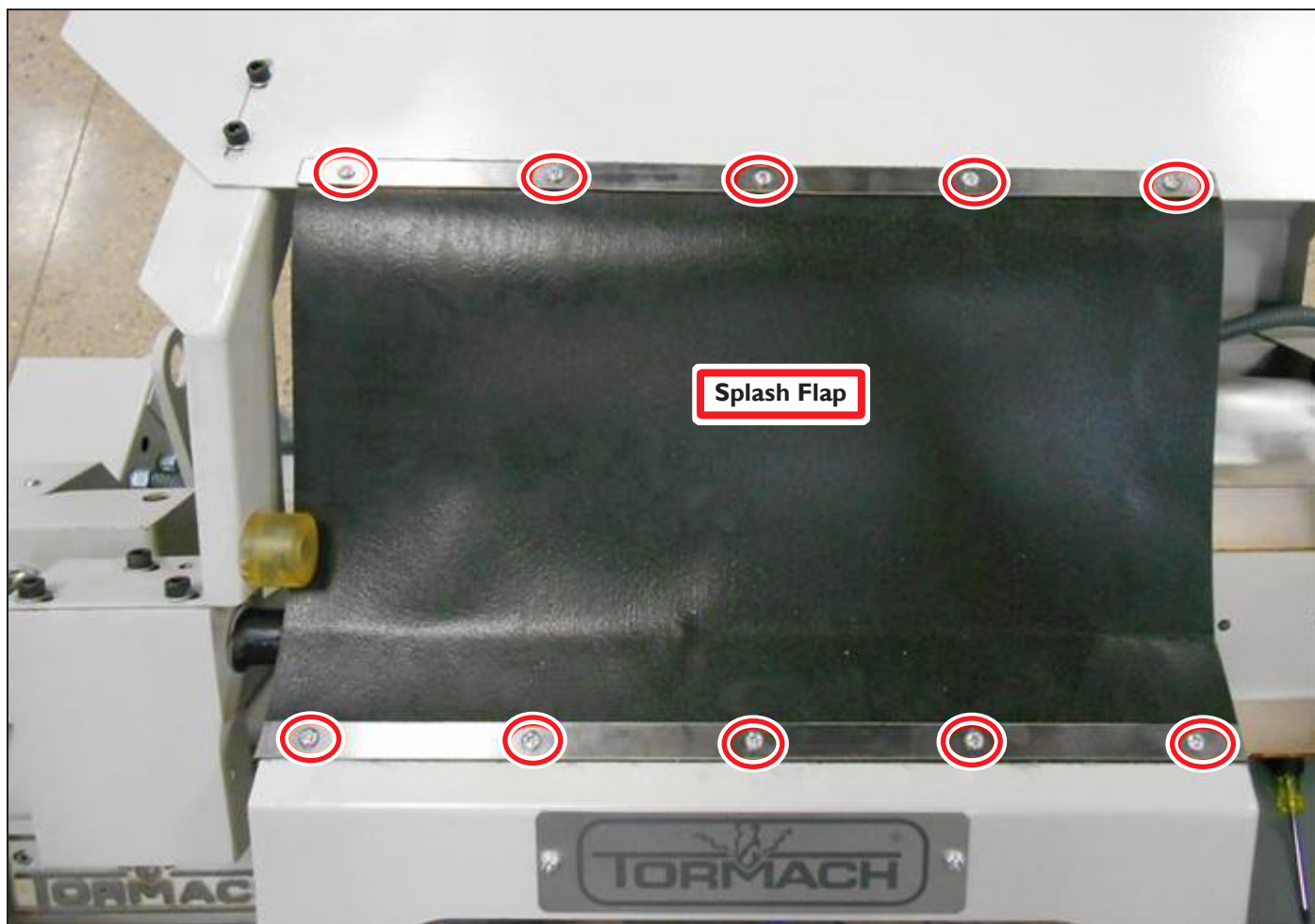


Figure 12

Adjust Chuck Guard

1. Tighten the two Limit Switch slotted nuts and verify they are secure (see **Figure 13**).
2. Verify the door cam position by loosening the set screw on the cam with a hex wrench; slide the cam slightly to the left to expose the dimpled pivot shaft (see **Figure 14**).



Figure 13

3. With set screw still loose, slide the cam back over the shaft ensuring screw and dimple are aligned. Then, slowly tighten screw until it drops into dimple; tighten firmly. See **Figure 14** to review correct positioning when Chuck Guard is closed.
4. Verify the Limit Switch adjustment by lifting the Chuck Guard. If correctly adjusted, two clicks are heard as the rollers run down the cam. If two clicks are not heard, adjust the switch height accordingly.

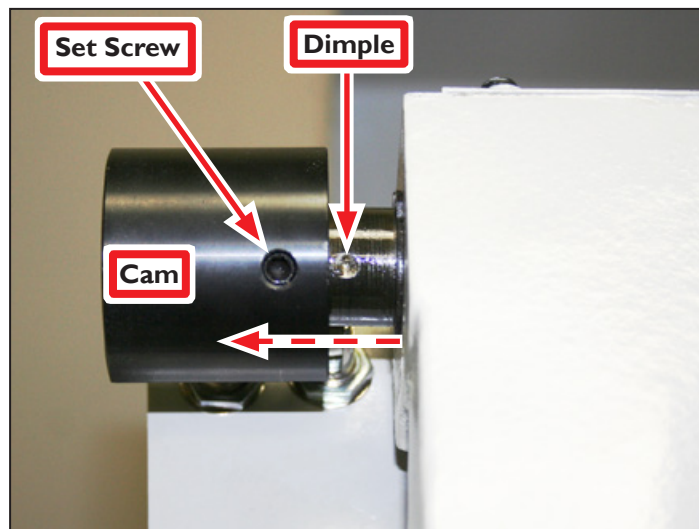
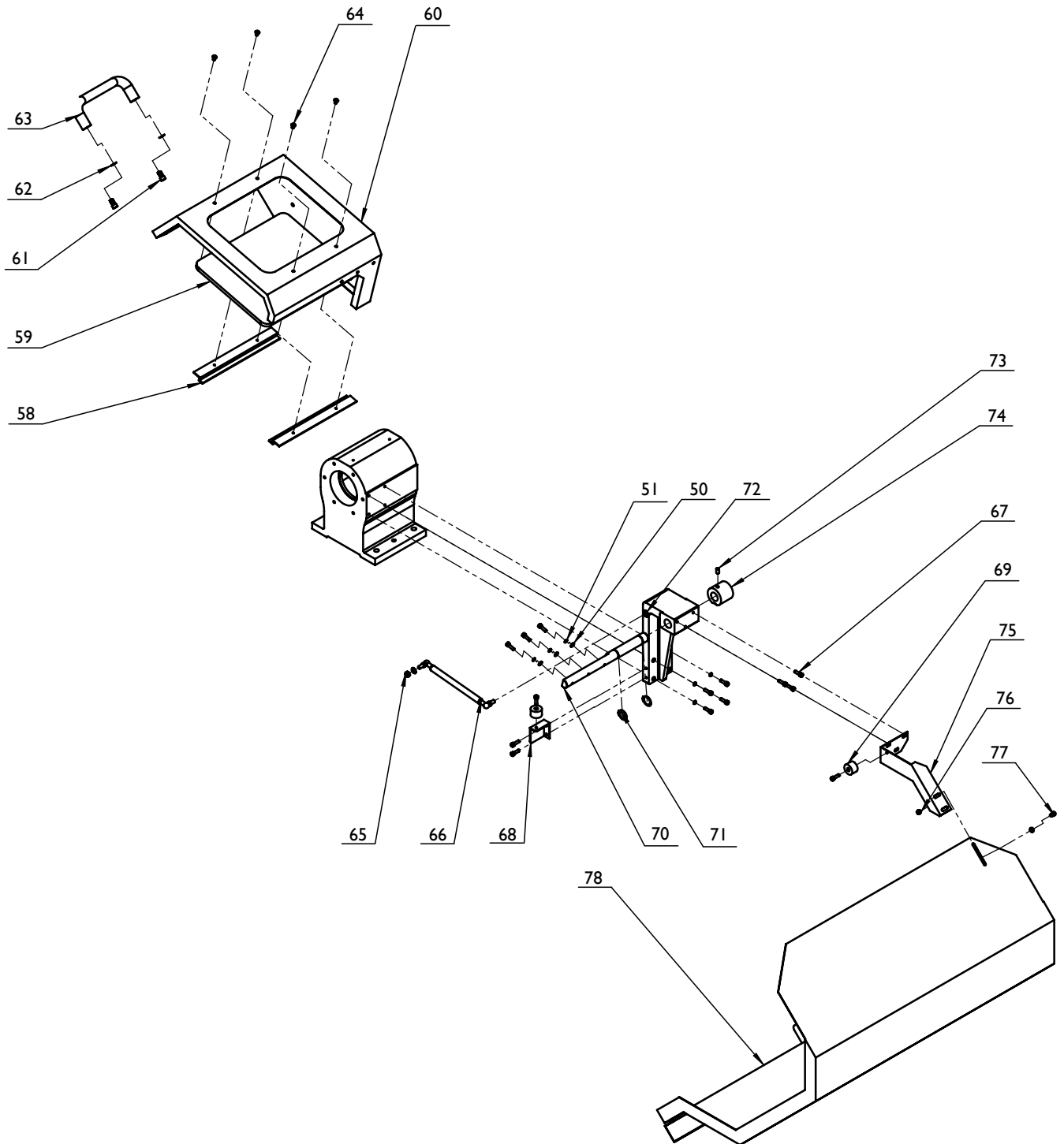


Figure 14

Exploded View





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Parts List

ID	PN	Description
50	34298	Washer, Flat M6
51	34299	Washer, Lock M6
58	34306	Window Bracket
59	34307	Window
60	34308	Chuck Guard
61	34309	Screw, M8x16
62	34310	Washer, M8
63	34311	Handle
64	34312	Screw, M5x10
65	34313	Nut, M8
66	34314	Air Spring
67	34315	Screw, M6x20
68	34316	Bracket
69	34317	Bumper
70	34318	Pivot Shaft
71	34319	Retaining Ring
72	34320	Main Guard Mount Arm
73	34321	Set Screw, M8x14
74	34322	Cam, Door Switch
75	34323	Mounting Bracket
76	34324	Nut, M6
77	34325	Screw, M6x12
78	34326	Back Splash Panel
(not shown)	35691	Switch Bracket