LEVER-OPERATED QUICK-CLOSING ATTACHMENT

A. Fitting and method of operation

The bush 70-30.624 of the quick-closing attachment is mounted on the end of the headstock spindle. It is locked by a key 70-30.613 and secured by the screw 2000.04008.

The support 70-30.604 is fixed to the headstock frame by means of three screws 2020.06020. When the lever is pushed to the left, its tip must locate against the screw 2000.06020. If this is not the case, unlock the nut 2101.00006 and adjust the screw 2000.06020.

To clamp the workpiece, pull the lever 70-30.612 to the right (towards you).

To unclamp the workpiece, push the lever 70-30.612 to the left.

B. Setting

1. Pull the lever 70-30.612 towards you.
2. Fit the collet in the spindle with the workpiece.
3. Clamp the workpiece lightly by screwing in the sleeve 70-30.625.
4. Push the lever 70-30.612 to the left and clamp the workpiece fully by means of the sleeve 70-30.625.

   The sleeve is automatically locked in all its positions by two spring-loaded pistons 70-30.614.

C. Replacing the closing dogs

Whenever it becomes necessary to replace the closing dogs 70-30.620, it is essential to fit two parts of exactly the same number. To replace the dogs, proceed as follows :

1. Withdraw the drawbar completely with the sleeve 70-30.625.
2. Remove the circlip 2154.00112 and withdraw the bush 70-30.616 by about 1 cm in order to be able to release the two dogs from the slots in the bush.

   NOTE : To avoid losing the springs belonging to the pistons 70-30.614, do not withdraw the bush 70-30.616 too far.
3. Place the new closing dogs in position.
4. Refit the circlip 2154.00112 and the drawbar.

D. Fitting the lever-operated quick-closing attachment to a headstock with a quick-closing attachment operated by a standard drawbar

Conversion of the headstock with drawbar-operated closing to a headstock with lever-operated quick closing can be carried out at any time, without difficulty, by any qualified person.