Cleaning on receipt

The lever-operated quick-closing attachment is supplied fully assembled. Prior to despatch it is given a coat of special anti-rust grease, but this must be completely removed before the machine is put into service, since it has no lubricating properties.

Fitting

1. Withdraw the drawbar 70-32.030. This cannot be used for the quick-closing attachment.
2. Place the key 70-21.874 in the slot in the headstock frame.
3. Place the key 70-30.623 in position on the shaft end 70-31.016.
4. Fit the quick-closing attachment by inserting the drawbar 70-30.602 into the spindle 70-31.016.

   Make sure that the flat key 70-30.623 enters the slot in the sleeve 70-30.624.
5. Locate the support 70-30.604 against the headstock frame and place the three screws 2020.06020 in position, tightening them lightly.
6. Run the lathe at reduced speed and adjust the eccentric screws 70-30.622 of the lever 70-30.612 until the sleeve 70-30.609 remains stationary in the vertical plane.

   NOTE : Any runout in the sleeve 70-30.609, however slight, can cause very rapid wear in the bearing 3062.16007.
7. On completion of adjustment lock the three screws 2020.06020 securely.
8. Lubricate the shoes. (See page 2).