

**REAR TAPER ATTACHMENT CROSS FEED SCREWS FOR 10" TO 16" LATHES
WITH BALL THRUST BEARINGS, REGULAR OR HARDENED AND GROUND THREADS
AS A REPLACEMENT FOR
REAR TAPER ATTACHMENT CROSS FEED SCREWS WITHOUT BALL THRUST BEARINGS.**

NOTE: REAR TAPER ATTACHMENT CROSS FEED SCREWS WITH HARDENED AND GROUND THREADS ARE ONLY AVAILABLE FOR LATHES WITH BALL THRUST BEARINGS. HOWEVER, A CROSS FEED SCREW WITH BALL THRUST BEARINGS, WITH REGULAR OR HARDENED AND GROUND THREADS CAN BE INSTALLED ON A LATHE ORIGINALLY EQUIPPED WITH CROSS FEED SCREW WITH-

OUT BALL THRUST BEARINGS BY PROCURING A COMPLETE SCREW ASSEMBLY SHOWN BELOW AND LISTED UNDER ITEMS 1, 2 AND 3

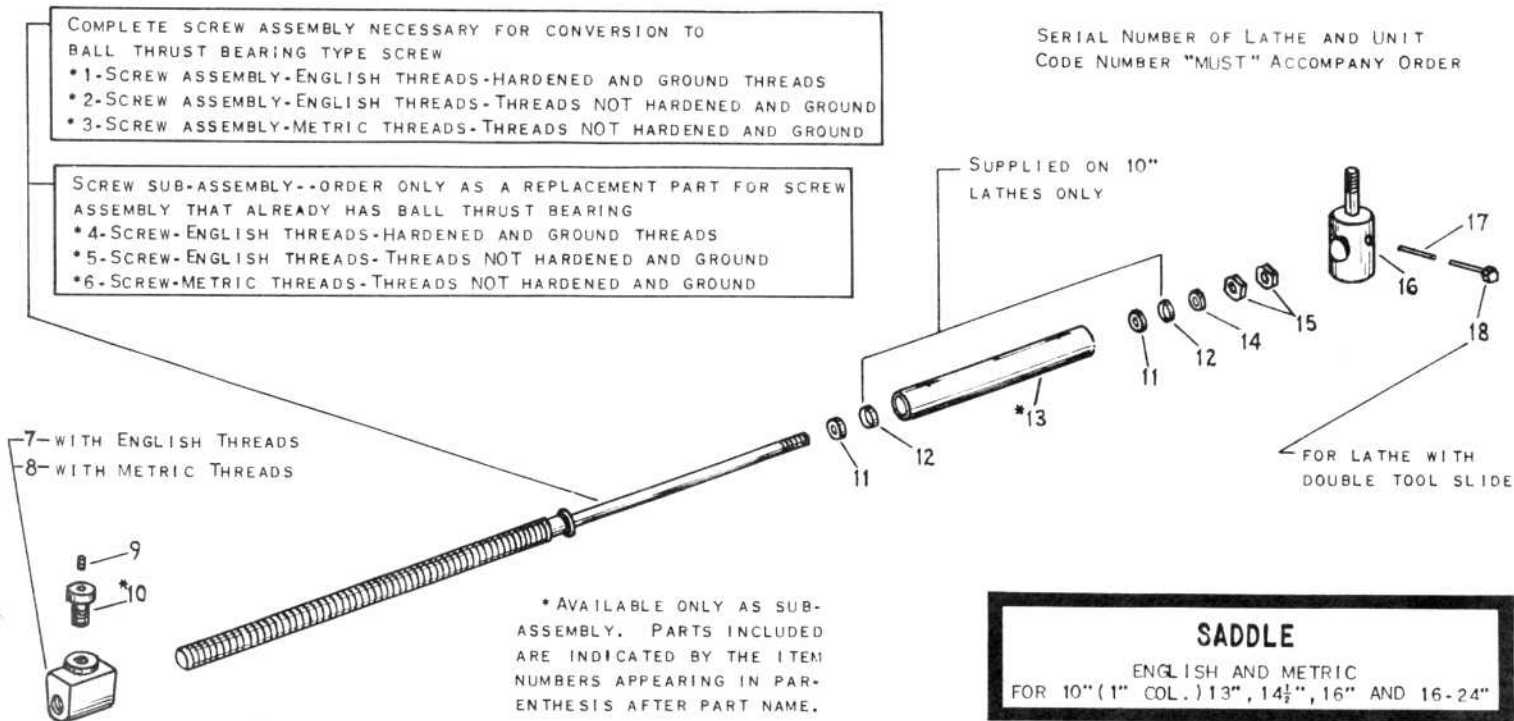
SINGLE ITEMS AND SUB-ASSEMBLIES ARE ALSO LISTED BELOW AS A REPLACEMENT PARTS GUIDE FOR LATHES WHERE THE CONVERSION TO THE BALL THRUST BEARING TYPE CROSS FEED SCREW HAS BEEN MADE.

COMPLETE SCREW ASSEMBLY NECESSARY FOR CONVERSION TO BALL THRUST BEARING TYPE SCREW
 *1-SCREW ASSEMBLY-ENGLISH THREADS-HARDENED AND GROUND THREADS
 *2-SCREW ASSEMBLY-ENGLISH THREADS-THREADS NOT HARDENED AND GROUND
 *3-SCREW ASSEMBLY-METRIC THREADS-THREADS NOT HARDENED AND GROUND

SCREW SUB-ASSEMBLY--ORDER ONLY AS A REPLACEMENT PART FOR SCREW ASSEMBLY THAT ALREADY HAS BALL THRUST BEARING
 *4-SCREW-ENGLISH THREADS-HARDENED AND GROUND THREADS
 *5-SCREW-ENGLISH THREADS-THREADS NOT HARDENED AND GROUND
 *6-SCREW-METRIC THREADS-THREADS NOT HARDENED AND GROUND

SERIAL NUMBER OF LATHE AND UNIT CODE NUMBER "MUST" ACCOMPANY ORDER

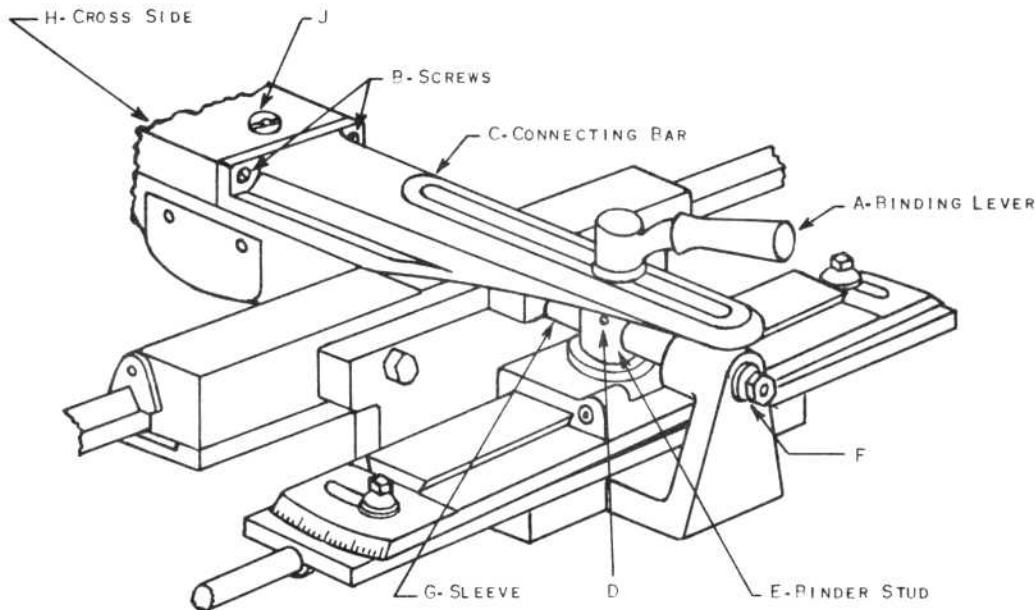
SUPPLIED ON 10" LATHES ONLY



* AVAILABLE ONLY AS SUB-ASSEMBLY. PARTS INCLUDED ARE INDICATED BY THE ITEM NUMBERS APPEARING IN PARENTHESIS AFTER PART NAME.

SADDLE
ENGLISH AND METRIC
FOR 10"(1" COL.) 13", 14 1/2", 16" AND 16-24"

ITEM NO.	PART NAME	10"		13"		14 1/2"		16" & 16/24"	
		PART NO.		PART NO.		PART NO.		PART NO.	
1	REAR T. A. CROSS FEED SCREW ASSEMB. (7-*10-11-12-*13-14-15)	*ASX6827L2		*ASX6827T2		*ASX6827F2		*ASX6827H2	
2	REAR T. A. CROSS FEED SCREW ASSEMB. (7-*10-11-12-*13-14-15)	*ASX483R3		*ASX483T3		*ASX483F3		*ASX483H3	
3	REAR T. A. CROSS FEED SCREW ASSEMB. (8-*10-11-12-*13-14-15)	*ASX2240R2		*ASX2240T2		*ASX2240F2		*ASX2240H2	
4	REAR T. A. CROSS FEED SCREW (7-*10-14-15)	*AS6827L2		*AS6827T2		*AS6827F2		*AS6827H2	
5	REAR T. A. CROSS FEED SCREW (7-*10-14-15)	*AS483R3		*AS483T3		*AS483F3		*AS483H3	
6	REAR T. A. CROSS FEED SCREW (8-*10-14-15)	*AS2240R2		*AS2240T2		*AS2240F2		*AS2240H2	
7	C. F. NUT-ENGLISH	PT65R1		PT65T1		PT65FH1		PT65FH1	
8	C. F. NUT-METRIC	PT2231R1		PT2231T1		PT2231FH1		PT2231FH1	
9	OIL SCREW	122x103		122x504		122x504		122x508	
10	C. F. NUT SCREW (9)	*AS66R2		*AS66T2		*AS66FH2		*AS66FH2	
11	BEARING	AS841R1		AS841R1		AS841R1		AS841T2	
12	BEARING COVER	PT899R1		(NOT REQUIRED)		(NOT REQUIRED)		(NOT REQUIRED)	
13	C.F. SC. SLEEVE (16-17)	*AS858R2		*AS858TF2		*AS858TF2		*AS858H2	
14	COLLAR	PT866R2		PT866TF2		PT866TF2		PT866H2	
15	HEX. NUT	139x25		139x25		139x27		139x31	
16	BINDER STUD	PT867R1		PT867TF1		PT867TF1		PT867H1	
17	TAPER PIN	168x310		168x412		168x412		168x514	
18	LOCKING PIN	AS487R1		AS487TF1		-----		AS487H1	



Installation Instructions

1. REMOVE BINDING LEVER "A" AND COLLAR.
2. REMOVE THE TWO SCREWS AT "B" AND TAKE OFF CONNECTING BAR "C".
3. KNOCK OUT TAPER PIN "D" OUT OF BINDER STUD "E".
4. TAKE OFF NUT AND COLLAR AT "F".
5. SLIP OUT SLEEVE "G".
6. MOVE CROSS SLIDE "H" TO EXTREME REAR POSITION, THUS DISENGAGING THE REAR TAPER ATTACHMENT SCREW FROM FRONT SCREW. NOTE THE SCREW IS STILL ENGAGED WITH THE NUT, AND THIS CAN ONLY BE REMOVED BY UNSCREWING IT OUT OF THE CROSS FEED NUT BY HAND.
7. LIFT OUT BINDER STUD "E".
8. REMOVE CROSS FEED NUT SCREW "J" FROM TOP OF CROSS SLIDE "H" AND CROSS FEED NUT (ITEM 7 OR 8 ON REVERSE SIDE) WILL FALL OUT.
9. INSERT REPLACEMENT BINDER STUD "E" IN PLACE.
10. REPLACE TAPER ATTACHMENT CONNECTING BAR, BUT BEFORE TIGHTENING SCREWS "B" MOVE CROSS SLIDE TO EXTREME REAR POSITION SO BINDER STUD "E" IS IN EXTREME FRONT OF SLOT IN CONNECTING BAR "C". REPLACE COLLAR AND TIGHTEN BINDING LEVER "A" ON TO PLUG, THEN TIGHTEN SCREWS AT "B".
11. LOOSEN BINDING LEVER AND MOVE CROSS SLIDE "H" BACK AND FORTH, CHECKING TO SEE THAT CONNECTING BAR DOES NOT BIND IN ANY POSITION.
12. IF CONNECTING BAR IS TIGHT IN ANY POSITION, REMOVE BINDER STUD AND FACE OFF AT "X" UNTIL CROSS SLIDE WITH CONNECTING BAR IN PLACE IS FREE ON BINDER STUD.
13. REPLACE AND PIN SLEEVE IN POSITION.
14. INSTALL CROSS FEED NUT AND RE-ASSEMBLE CROSS FEED SCREW TO LATHE. BE SURE THAT ALL THE PLAY IS REMOVED BETWEEN THE CROSS FEED SCREW AND SLEEVE. DO NOT TIGHTEN TOO TIGHTLY, FOR BEARINGS CAN BE DAMAGED.