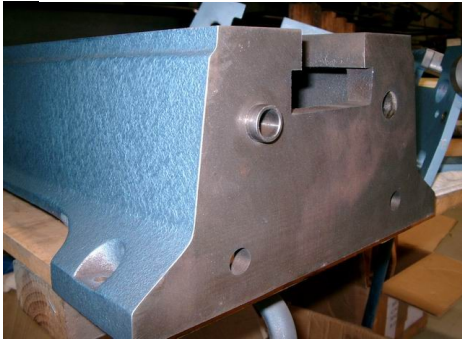


# VERMEC TAILSTOCK SWIVEL ATTACHMENT INSTRUCTION SHEET

**NOTE: Remove M8 Bolt (PIC8) for assembling**



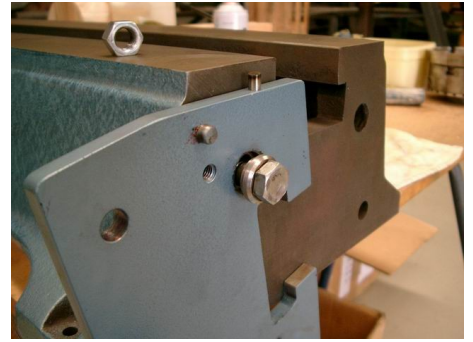
Pic 1

### **Step 1**

Insert Dowel in first hole leaving 7mm protruding from lathe bed. ( fig 1)

### **Step 2**

Slide swivel attachment over dowel and insert special washer and retaining bolt as shown in fig 2. Leave bolt finger tight.



Pic 2



Pic 3

### **Step 3**

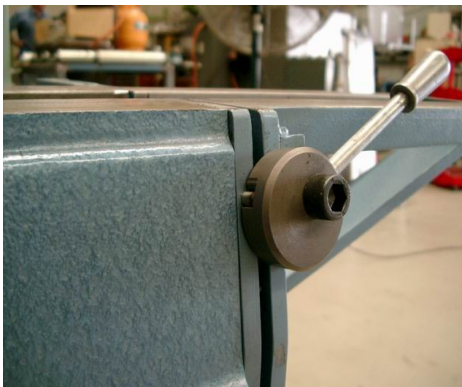
Swing swivel attachment into a position where the 2nd dowel can be inserted. Push dowel in until it is 3mm below the face of the extension plate. Now insert stepped bush and tighten retaining bolt. (fig 3&4)

### **Step 4**

Insert the remainder of the retaining bolts and tighten all 4. You will need to use two 18mm spanners. ( fig 4)



Pic 4



Pic 5

### **Step 5**

Rotate clamping cam until the opening lines up with the dowel in the side of mounting bracket and turn handle to clamp assembly together. Before clamping ensure that the two mating faces of swivel assembly are clean from any debris

### **Step 6**

Try the fit of your tailstock in the extension and if necessary adjust the surfaces as shown in fig 6 & 7 with a flat file until you obtain a nice sliding fit.



Pic 6



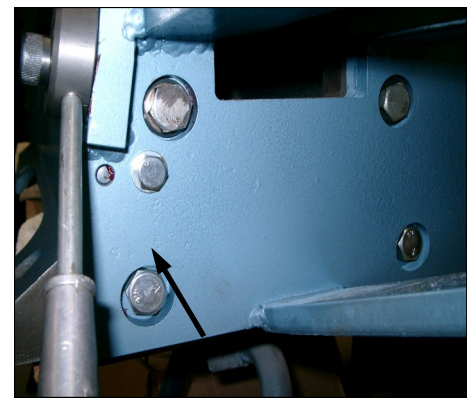
Pic 7

### **Step 7**

Finish off with a sanding block and sandpaper for a nice smooth finish.

### **Warning:**

For sustained use in the closed position insert the 8mm bolt in the hole provided. This is an essential safeguard especially if you are using the extension for turning between centers.



Pic 8

**CAUTION:** Any tool is potentially dangerous - the user should take every precaution to avoid injury. The purchaser is responsible for ensuring that the product is suited to their needs.