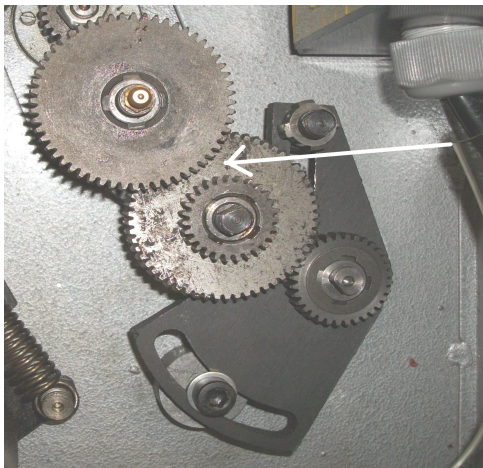


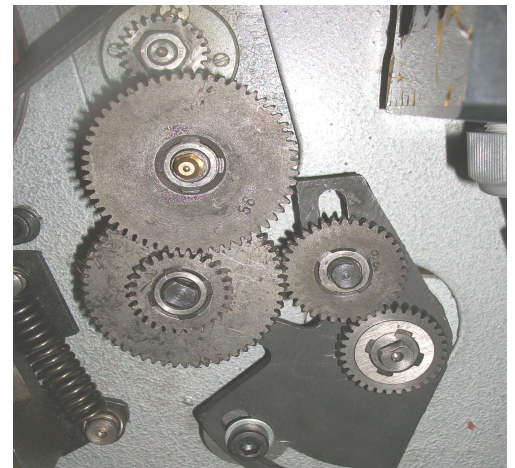
USING THE “E” GEAR ON THE MIDAS 1220 AND 1230 MACHINES

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OVERVIEW: When setting up the gears for some threads, you will find the A and B gear do not come together enough to mesh the teeth on the two gears. The “E” gear is used as a spacer between the “C” and “D” to fill the gap. The use of the “E” gear does reverse the direction of the feed screw so this must be compensated for by the feed direction lever at the left end of the feed screw.



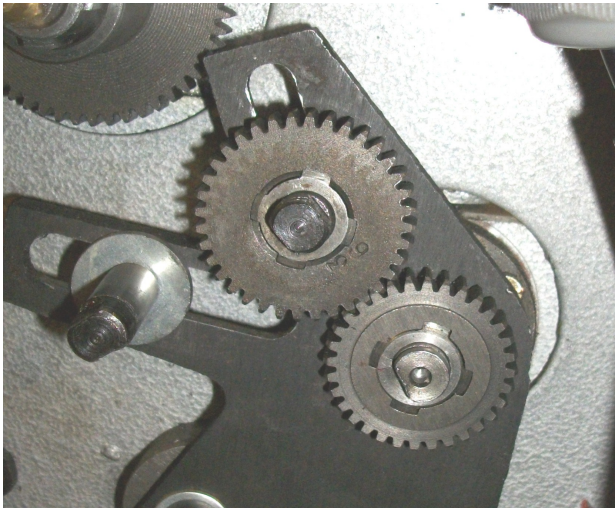
BEFORE
See the gap between the gears.



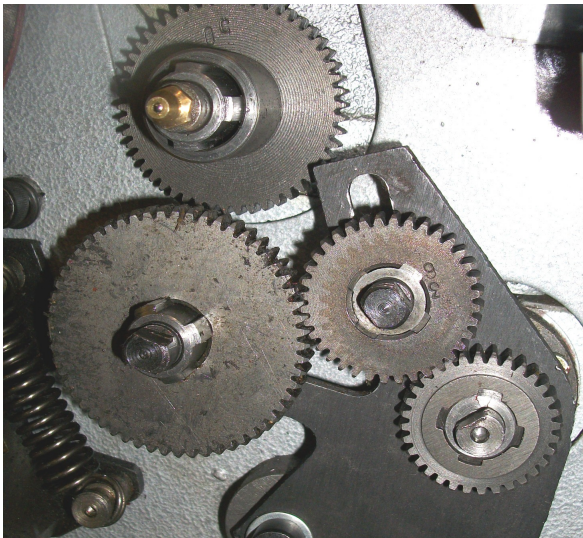
AFTER
All gears are meshing.

<u>STEP</u>	<u>DESCRIPTION</u>	<u>PICTURES</u>
1	Remove all existing gears. Install the appropriate “D” gear for the threads you wish to cut.	
2	Install a small gear onto the “E” shaft. The gear size will <i>not</i> effect the thread pitch.	
3	Use an 8mm wrench to loosen the “E” shaft	

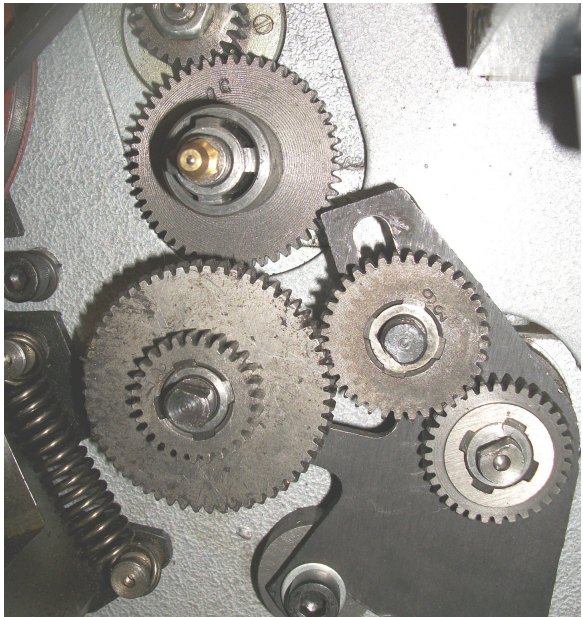
4 Slide the “E” gear and shaft to mesh with the “D” gear and tighten the shaft into place.



5 Install the “C” gear and position the “C” gear and shaft so they mesh with the “E” gear. This shaft moves just like the “E” gear shaft by loosening the shaft and sliding it along the groove in the e gear quadrant.

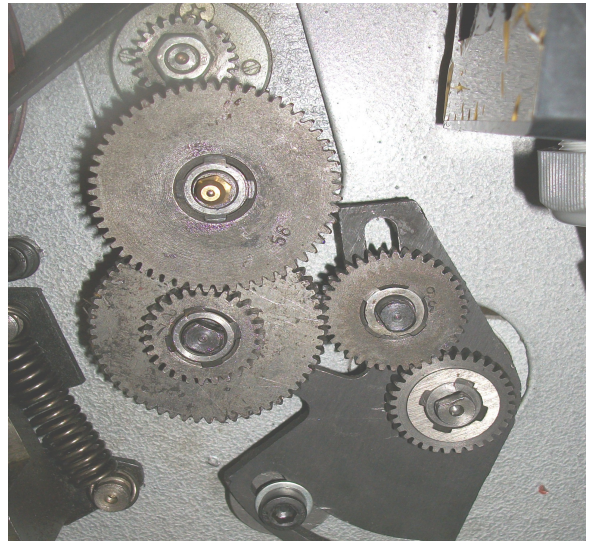


6 Install the “B” gear onto the shaft with the “C”



7 Install the “A” gear and swing the entire gear quadrant up so the “A” and “B” gear mesh. The quadrant moves by loosening the Allen head screw at the lower base of the quadrant.

Use the powerfeed direction lever to set the machine to cut towards the lathe chuck for right hand threads.



END