

QUICK CHANGE TOOL HOLDER MODIFICATION FOR THE SMITHY FREE STANDING LATHES

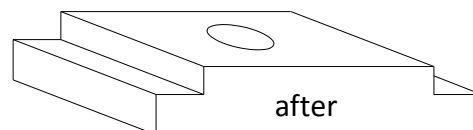
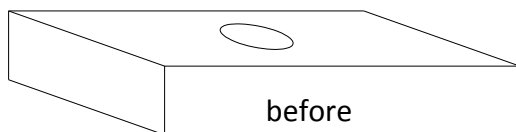
NOTE:

THIS PROCEDURE IS NOT FOR ANY OF THE SMITHY 3 IN 1 MACHINES

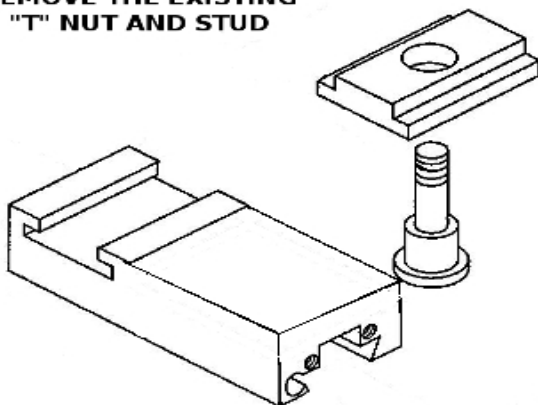
The Quick Change Tool Holder is made to allow modification to fit a variety of tool post bases. Since the sizes of the T-slot in the tool bases vary, the "T" slot plate is not pre-machined.

For use on the Smithy free standing lathes, it is necessary to machine the "T" slot plate that comes with the Quick Change Tool Post to the required dimensions.

NOTE: There may be some slight variation in the dimensions of each individual tool post base. Please use the dimensions of your particular base's T-slot before machining the "T" slot plate blank.

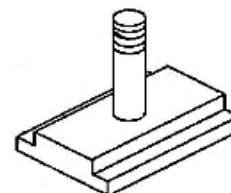
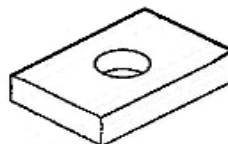


**REMOVE THE EXISTING
"T" NUT AND STUD**



**INSTALL THE NEW "T"
NUT AND STUD AFTER
MACHINING THE "T" NUT**

**NEW "T" NOT BLANK
BEFORE MACHINING**



**GET DIMENSIONS FOR THE "T"
NUT FROM MEASURING DIRECTLY
FROM YOUR MACHINE!
THICKNESS DOES NOT NEED TO
BE CHANGED, JUST MACHINE LIP
ON BOTH EDGES.**

Slide the machined "T" nut and stud assembly into the top of the slide of the tool post.

Place the body of the Quick Change Tool Post over the stud and secure with the not provided.



END