INSTRUCTIONS and PARTS

CLAUSING

DIVISION, ATLAS PRESS COMPANY
KALAMAZOO, MICHIGAN 49001

NO. 7124
METRIC THREAD CUTTING ATTACHMENT

for

5900 SERIES CLAUSING 12" LATHES

from Serial Nos. 502100 to_____

MARCH 1966 **FILE NO. 7124-1**

MOUNTING

1. Remove spindle handwheel and upper and lower guards.

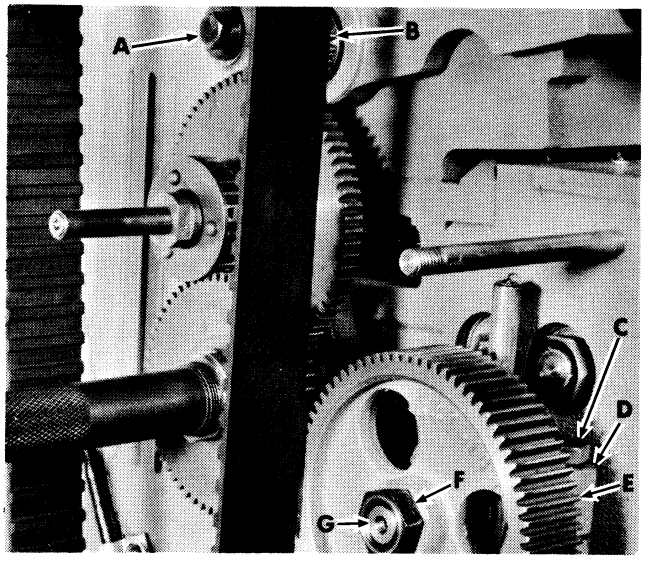

Figure 1

2. Remove jam nut (F, Fig. 1) and pull drive gear (E) off shaft (G).
3. Loosen screw (C) and remove hex cap screw (A).
4. Pull quadrant assembly (D) off lathe.
5. Loosen set screw and remove collar and gear (B).

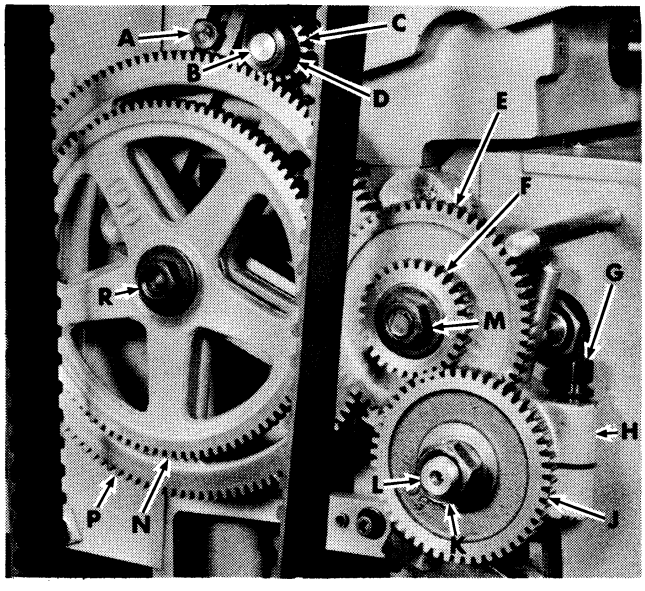

Figure 2

6. Install metric gear (C) on tumbler shaft (B)--*select gear from metric thread chart furnished.*
7. Place collar (D) on tumbler shaft and tighten set screw.
8. Slide metric quadrant and gear assembly (H) on shaft (L).
9. Slide gear (J), indicated on metric thread chart, on shaft (L) and tighten jam nut (K).
10. To set gear clearance:
    A. Loosen nut (M).
    B. Place a sheet of wrapping paper (approximately .004" thick) between the teeth of two meshing gears (J and F).
    C. Move gear (F) until gears (J and F) are properly meshed, tighten nut (M) and turn gears to remove paper.
11. Loosen nut (R), set gear clearance between (E and N), and tighten nut (R) --following the procedure in step 10.
12. Set gear clearance between gears (P and C) and tighten hex cap screw (A).
13. After proper gear clearance is obtained, tighten screw (G). CAUTION: Excessive tightening will cause shaft (L) to bind.
14. Install upper and lower guards, and handwheel.
15. Mount metric thread chart on guard.

LUBRICATION

Periodically lubricate metric gear teeth with TEXACO CRATER NO. 2X fluid or equivalent. Remove oil and dirt before applying. NOTE: Remove upper guard and handwheel to lubricate.

THREAD CUTTING

The threading dial cannot be used for metric threads. For these, the half nuts are closed on the lead screw and remain engaged until the thread is complete.
After each cut and tool withdrawal, the tool is brought back to starting point by reversing the lathe.

INSTRUCTIONS FOR ORDERING REPAIR PARTS

It is important to furnish the following information in addition to quantity required:

1. PART NUMBER
2. PART NAME
3. MODEL NUMBER of attachment.

NOTE: Screws and nuts shown without part numbers should be purchased locally.
We reserve the right to make changes in design and specifications without notice.

NO. 7124 METRIC THREAD CUTTING ATTACHMENT PARTS LIST

for

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