
F O U R - T O O L T U R R E T S C H A U B L I N 102-46.100

The turret is delivered fully assembled and ready for use.

Mounting on carriage

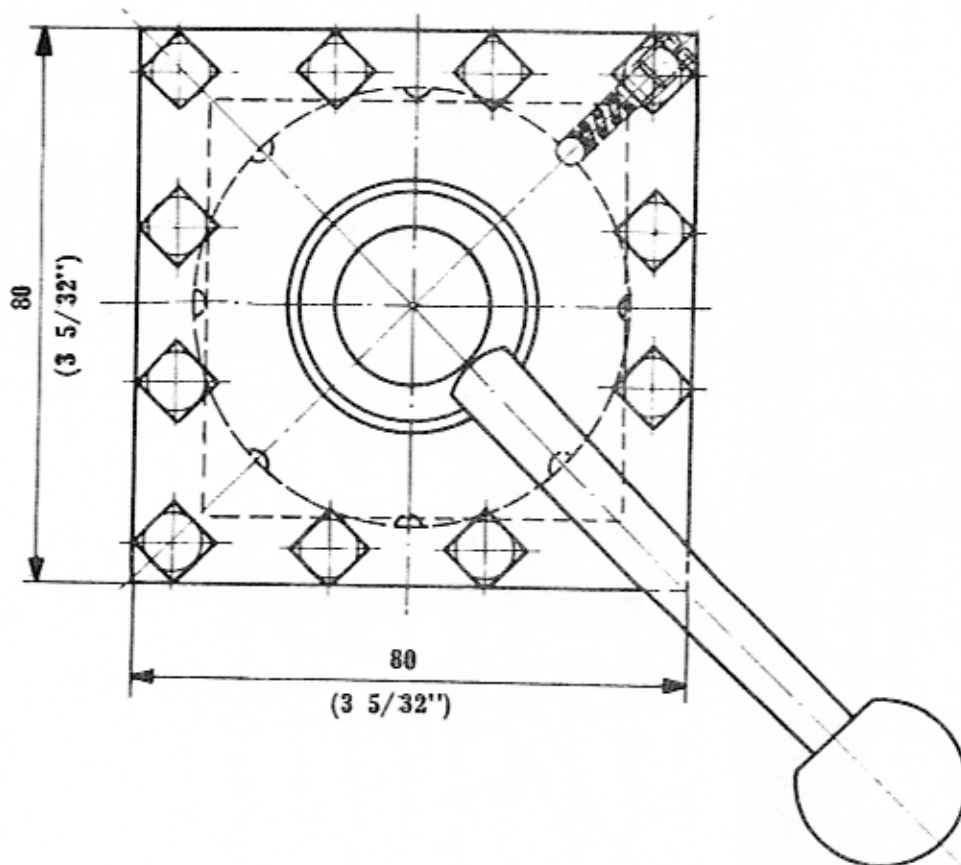
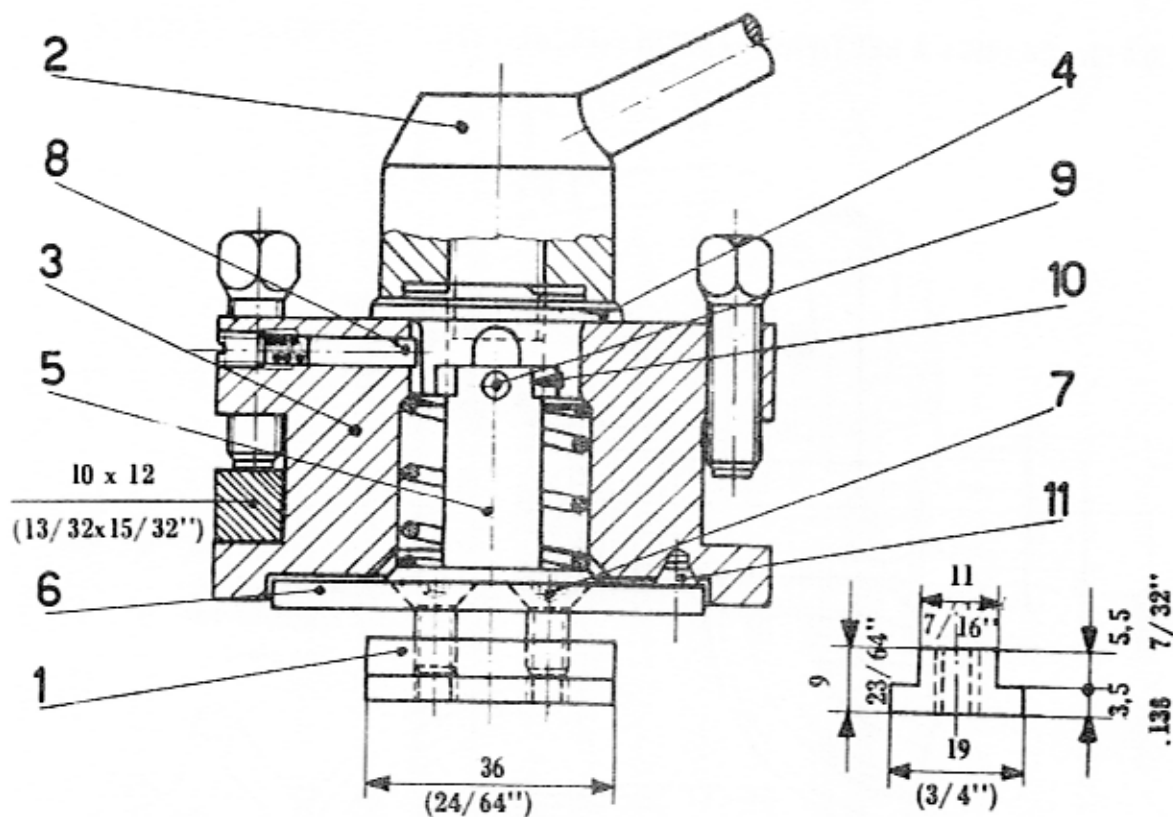
1. Insert the two T-nuts 1 located beneath the turret into the T-slots of the lathe carriage.
2. Press the head 3 right down against the carriage.
3. Loosen and unscrew completely clamping nut 2.
4. Remove the head 3 from the tie rod 5.
5. Secure the index plate 6, which is integral to tie rod 5, on to the carriage by means of the four screws 7 and the T-nuts 1.
6. Slip the turret head 3 over the tie rod 5 taking care that the stop pin 9 comes to rest in the notch 10 of the cam ring 4.
7. Press the turret head right down until it rests on the three truncated cones 11; press down the cam ring 4 and turn it in a clockwise direction (to the right) until it reaches the stop; then tighten the clamping nut 2. If the head has been mounted correctly, the lever of the nut 2 should be in the position shown in the drawing.

Testing operation

8. Loosen the clamping nut 2 with its lever and turn the head through an angle of 90°, positioning being facilitated by the slots in the index plate. Then tighten the clamping nut 2 again. The slots give eight different positions, thus enabling the turret head to be locked every 45° or 90°.

Dismantling

9. Loosen the clamping nut 2, swing the turret through 90° and press it against the carriage whereupon the clamping nut 2 and the turret head 3 can be removed.



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