

please read and save these instructions. Read carefully before attempting to assemble, install, operate or maintain the product described. Protect yourself and others by observing all safety information. Failure to comply with instructions could result in personal injury and/or property damage! Retain instructions for future reference.

phase II+ Wedge Type Quick Change Tool Post Sets

Description

Wedge type tool posts provide instant tool changeover from one operation to another. Hardened and ground working parts have maximum rigidity and provide chatter free performance. Units are completely sealed for maintenance free operation. Each tool post set comes with five different style tool holders for turning, facing, boring, parting and knurling operations. Tool Post and Holders are quickly and easily installed on an engine, bench or turret lathe for a wide range of operations.

Unpacking

Check for shipping damage. If damage has occurred, a claim must be filed with carrier immediately. Check for completeness. Immediately report missing parts to dealer. Carefully remove tool from box.

Identify the following assemblies:

1. Wedge Type Tool Post and Handle
2. Turning and Facing Holder
3. Boring, Turning and Facing Holder
4. Heavy Duty Boring Bar Holder
5. Universal Parting Blade Holder
6. Knurling, Turning and Facing Holder

Tool Post—Wedge Type

Lathe Swing	A	B	C	D	E	F	G
12	2 1/2	3 7/8	2 1/4	9/16	1 3/8	4 11/16	5 3/4
10-15	3	4 5/8	2 3/4	5/8	1 5/8	5 9/16	7 5/16
13-18	3 1/2	5 1/8	3	3/4	1 7/8	6 1/8	7 7/8
14-20	4	6 1/4	3 5/8	7/8	2 1/8	7	9

Tool Holder—Turning and Facing (Style No. 1)

Lathe Swing	Tool Bit	A	B	C	D
12	3/16-1/2	15/16	9/16	7/16	1 1/2
10-15	1/4-5/8	1 1/8	21/32	1/2	1 3/4
13-18	1/2-3/4	1 7/16	51/64	5/8	2 1/8
14-20	1/2-1	1 11/16	11/32	3/4	2 1/2

IMPORTANT: The tool has been coated with a protective coating. In order to ensure proper fit and operation the coating must be removed. Remove coating with mild solvents such as mineral spirits and a soft cloth. Nonflammable solvents are recommended. After cleaning, cover all exposed surfaces with a light coating of oil.

CAUTION Never use highly volatile solvents. Avoid getting cleaning solution on paint as it may tend to deteriorate these finishes. Use soap and water on painted components.

Dimensions

NOTE: All dimensions are in inches.

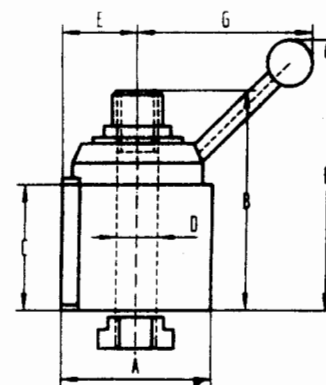


Figure 1 A

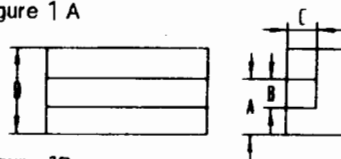


Figure 1 B

Please provide following information:

- Model number
- Serial number (if any)
- Part descriptions and number as shown in parts list

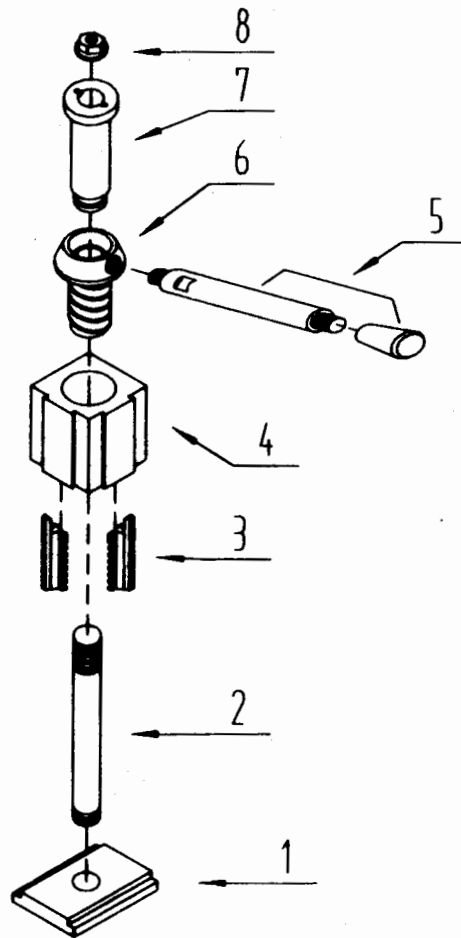


Figure 2—Replacement Parts illustration for Wedge Type Tool Post

Replacement Parts List

Reference Number	Description	Part Number For Models With:				Qty.
		12" Lathe Swing	10—15" Lathe SWING	13—18" Lathe Swing	14—20" Lathe Swing	
1	Base	9047.00	9091.00	9119.00	9155.00	1
2	Threaded rod	9067.00	9092.00	9120.00	9156.00	1
3	Jaw	9068.00	9093.00	9121.00	9157.00	2
4	Body	9069.00	9094.00	9122.00	9158.00	1
5	Handle with knob	9041.00	9075.00	9123.00	9132.00	1
6	Threaded core	9070.00	9095.00	9124.00	9159.00	1
7	Sleeve	9071.00	9096.00	9125.00	9160.00	1
8	Flange nut	9042.00	9076.00	9126.00	9133.00	1

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phase II⁺ Turning and Facing Holder

Description

Turning and facing holder accepts various bit sizes and economizes time and labor when switching operations. Holder design allows to lock turning and facing tools together.

Tool Holder—Turning and Facing (Style No. 1)

Lathe swing	Tool Bit	A	B	C	D
12	3/16 - 1/2	15/16	9/16	7/16	1 1/2
10-15	1/4 - 5/8	1 1/8	21/32	1/2	1 3/4
13-18	1/2 - 3/4	1 7/16	51/64	5/8	2 1/8
14-20	1/2 - 1	1 11/16	1 1/32	3/4	2 1/2

Dimensions

NOTE: All dimensions are in inches.

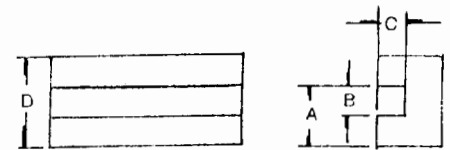


Figure 1

Please provide following information:

- Model number
- Serial number (if any)
- Part descriptions and number as shown in parts list

Address parts correspondence to:



14 Caesar Place
Moonachie, NJ 07074
Tel. 201-933-6300
FAX 201-933-3801

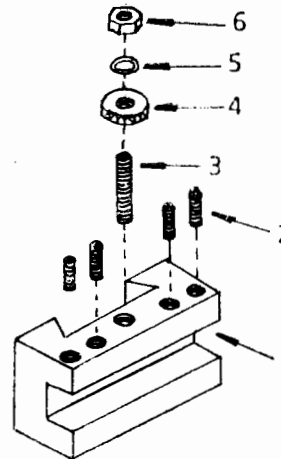


Figure 2—Replacement parts illustration For Tool Holder Style 1

Replacement Parts List

Reference Number	Description	Part Number For Models With:				Qty.
		12" Lathe Swing	10-15" Lathe Swing	13-18" Lathe Swing	14-20" Lathe Swing	
1	Body	9056.00	9087.00	9113.00	9147.00	1
2	8-1.25 x 20mm Set screw	*	—	—	—	4
2	10-1.5 x 20mm Set screw	—	*	—	—	4
2	10-1.5 x 25mm Set screw	—	—	*	—	4
2	12-1.75 x 32mm Set screw	—	—	—	9146.00	4
3	10-1.0 x 45mm Set screw	9054.00	9054.00	—	—	1
3	10-1.0 x 55mm Set screw	—	—	9127.00	—	1
3	12-1.25 x 65mm Set screw	—	—	—	9145.00	1
4	Knurled nut	9053.00	9085.00	9131.00	9144.00	1
5	10mm Wavy washer	9052.00	9052.00	9052.00	—	1
5	12mm Wavy washer	—	—	—	9143.00	1
6	10-1.0mm Hex nut	9051.00	9051.00	9051.00	—	1
6	12-1.25mm Hex nut	—	—	—	9142.00	1

(*) Standard hardware item available locally



Operating Instructions & Parts Manual

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phase II+ Boring, Turning and Facing Holders

Description

Boring, turning and facing holders with V-groove can hold round shank boring bars and tools as well as square tool bits.

Tool Holder—Boring, Turning and Facing (Style No. 2)

Lathe swing	Tool Bit	Shank	A	B	C	D
12	3/16—1/2	7/16	15/16	9/16	7/16	1 1/2
10-15	1/4—5/8	1/2	1 1/8	21/32	1/2	1 3/4
13-18	1/2—3/4	3/4	1 7/16	51/64	5/8	2 1/8
14-20	1/2 - 1	13/16	1 11/16	1 1/32	3/4	2 1/2

Dimensions

NOTE: All dimensions are in inches.

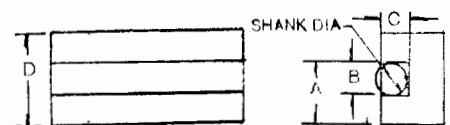


Figure 1

Please provide following information:

- Model number
- Serial number (if any)
- Part descriptions and number as shown in parts list

Address parts correspondence to:



14 Caesar Place
Moonachie, NJ 07074
Tel. 201-933-6300
FAX 201-933-3801

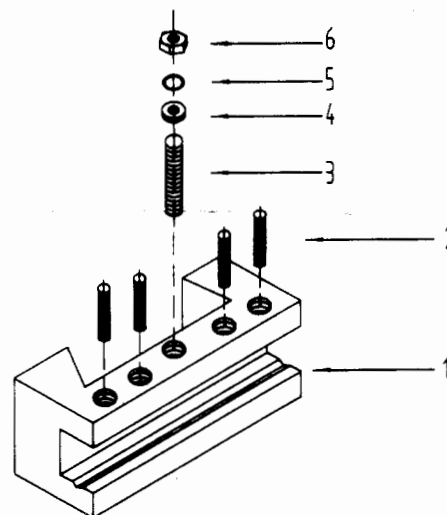


Figure 2—Replacement parts illustration For Tool Holder Style 2

Replacement Parts List

Reference Number	Description	Part Number For Models With:				Qty.
		12" Lathe Swing	10—15" Lathe Swing	13—18" Lathe Swing	14—20" Lathe Swing	
1	Body	9057.00	9088.00	9114.00	9148.00	1
2	8-1.25 x 20mm Set screw	*	—	—	—	4
2	10-1.5 x 20mm Set screw	—	*	—	—	4
2	10-1.5 x 25mm Set screw	—	—	*	—	4
2	12-1.75 x 32mm Set screw	—	—	—	9146.00	4
3	10-1.0 x 45mm Set screw	9054.00	9054.00	—	—	1
3	10-1.0 x 55mm Set screw	—	—	9127.00	—	1
3	12-1.25 x 65mm Set screw	—	—	—	9145.00	1
4	Knurled nut	9053.00	9085.00	9131.00	9144.00	1
5	10mm Wavy washer	9052.00	9052.00	9052.00	—	1
5	12mm Wavy washer	—	—	—	9143.00	1
6	10-1.0mm Hex nut	9051.00	9051.00	9051.00	—	1
6	12-1.25mm Hex nut	—	—	—	9142.00	1

(* Standard hardware item available locally)

Form 550000



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phase II+ Universal Parting Blade Holder

Description

Universal parting blade holder permits cut-off closer to chuck and can be used with bresas well as T-cut blades. Vibration free cutting prevents blade breakage.

Tool Holder—Universal Parting Blade (Style No. 7)

Lathe swing	Blade Height	A	B	C	D
12	1/2	13/16	9/16	3/16	1 1/2
10-15	11/16	1	23/32	3/16	1 3/4
13-18	3/4	1 3/16	13/16	3/16	2
14-20	7/8	1 7/16	61/64	1/4	2 1/2

Dimensions

NOTE: All dimensions are in inches.

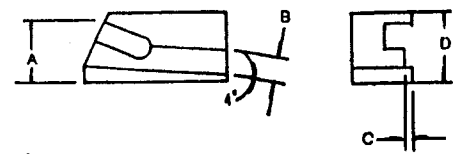


Figure 1

Please provide following information:

- Model number
- Serial number (if any)
- Part descriptions and number as shown in parts list

Address parts correspondence to:



14 Caesar Place
Moonachie, NJ 07074
Tel. 201-933-6300
FAX 201-933-3801

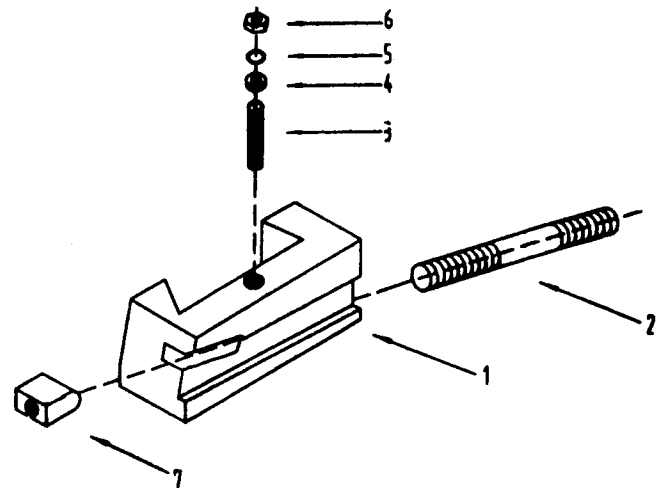


Figure 2—Replacement parts illustration For Tool Holder Style 7

Replacement Parts List

Reference Number	Description	Part Number For Models With:				Qty.
		12" Lathe Swing	10-15" Lathe Swing	13-18" Lathe Swing	14-20" Lathe Swing	
1	Body	9064.00	9055.00	9116.00	9164.00	1
2	Threaded rod	9062.00	9062.00	9115.00	9153.00	1
3	10-1.0 x 45mm Set screw	9054.00	9054.00	—	—	1
3	10-1.0 x 55mm Set screw	—	—	9127.00	—	1
3	12-1.25 x 65mm Set screw	—	—	—	9145.00	1
4	Knurled nut	9053.00	9085.00	9131.00	9144.00	1
5	10mm Wavy washer	9052.00	9052.00	9052.00	—	1
5	12mm Wavy washer	—	—	—	9143.00	1
6	10-1.0mm Hex nut	9051.00	9051.00	9051.00	—	1
6	12-1.25mm Hex nut	—	—	—	9142.00	1
7	Holder	9063.00	9063.00	9063.00	9154.00	1

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phase II+ Heavy Duty Boring Bar Holder

Description

Heavy duty boring bar holder is equipped with a split bushing to accommodate boring bars of smaller diameter. Holder grips bar with extreme rigidity and cuts smoothly without chatter.

Tool Holder—Heavy Duty Boring Bar (Style No. 4)

Lathe Swing	A	B	C	C1
12	3/4	1 1/2	3/4	5/8
10-15	7/8	1 3/4	1	3/4
13-18	1	2	1	3/4
14-20	1 1/4	2 1/2	1 1/4	1

Please provide following information:

- Model number
- Serial number (if any)
- Part descriptions and number as shown in parts list

Dimensions

NOTE: All dimensions are in inches.

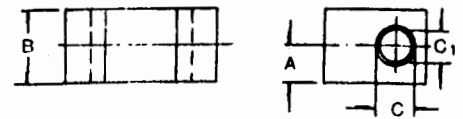


Figure 1

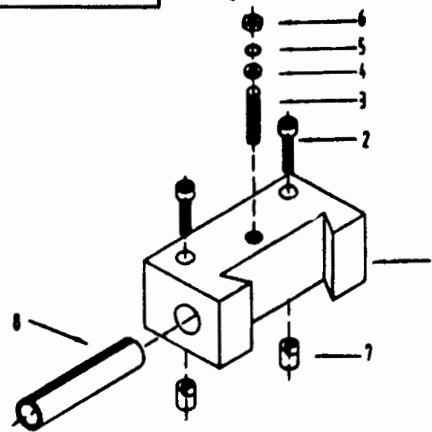


Figure 2—Replacement parts illustration For Tool Holder Style 4

Replacement Parts List

Reference Number	Description	Part Number For Models With:				Qty.
		12" Lathe Swing	10-15" Lathe swing	13-18" Lathe Swing	14-20" Lathe Swing	
1	Body	9058.00	9086.00	9112.00	9149.00	1
2	6-1.0 x 25mm Socket head bolt	*	—	—	—	2
2	6-1.0 x 30mm Socket head bolt	—	—	—	—	2
2	8-1.25 x 30mm Socket head bolt	—	—	*	—	2
2	10-1.5 x 40mm Socket head bolt	—	—	—	—	2
3	10-1.0 x 45mm Set screw	9054.00	9054.00	—	—	1
3	10-1.0 x 55mm Set screw	—	—	9127.00	—	1
3	12-1.25 x 65mm Set screw	—	—	—	9145.00	1
4	Knurled nut	9053.00	9085.00	9131.00	9144.00	1
5	10mm Wavy washer	9052.00	9052.00	9052.00	—	1
5	12mm Wavy washer	—	—	—	9143.00	1
6	10-1.0mm Hex nut	9051.00	9051.00	9051.00	—	1
6	12-1.25mm Hex nut.	—	—	—	9142.00	1
7	Locknut	9059.00	9059.00	9098.00	9150.00	2
8	Sleeve	9060.00	9060.00	9111.00	9151.00	1

(* Standard hardware item available locally)



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phase II⁺ Knurling, Turning and Facing Holder

Description

Knurling, Turning and Facing holders are supplied with a set of high speed, precision ground lapped medium diamond knurls. Knurl size: 3/4" x 3/8" x 1/8".

Tool Holder—Knurling, Turning and Facing (Style No. 10)

Lathe swing	Tool Bit	A	B	C	D	D1
12	3/16-1/2	7/8	2 1/2	1 9/16	35/64	13/32
10-15	1/4-5/8	1	2 5/8	1 3/4	21/32	1/2
13-18	1/2-3/4	1 3/16	3 1/8	2	25/32	1/2
14-20	1/2-1	1 7/16	3 3/4	2 1/2	1 1/64	3/4

Dimensions

NOTE: All dimensions are in inches.

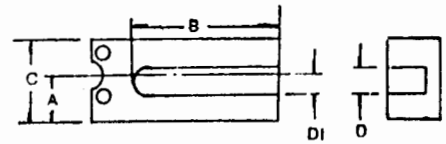


Figure 1

Please provide following information:

- Model number
- Serial number (if any)
- Part descriptions and number as shown in parts list



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Tel. 201-933-6300
FAX 201-933-3801

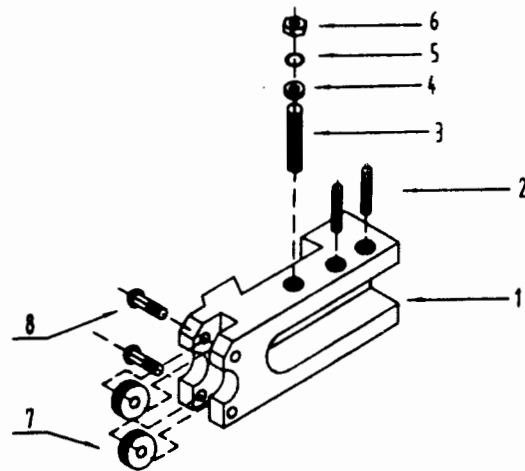


Figure 2—Replacement parts illustration For Tool Holder Style 10

Replacement Parts List

Reference Number	Description	Part Number For Models With:				Qty.
		12" Lathe Swing	10-15" Lathe Swing	13-18" Lathe Swing	14-20" Lathe Swing	
1	Body	9089.00	9090.00	9118.00	9165.00	1
2	8-1.25 x 20mm Set screw	*	—	—	—	2
2	10-1.5 x 20mm Set screw	—	*	—	—	2
2	10-1.5 x 25mm Set screw	—	—	*	—	2
2	12-1.75 x 32mm Set screw	—	—	—	9146.00	2
3	10-1.0 x 45mm Set screw	9054.00	9054.00	—	—	1
3	10-1.0 x 55mm Set screw	—	—	9127.00	—	1
3	12-1.25 x 65mm Set screw	—	—	—	9145.00	1
4	Knurled nut	9053.00	9085.00	9131.00	9144.00	1
5	10mm Wavy washer	9052.00	9052.00	9052.00	—	1
5	12mm Wavy washer	—	—	—	9143.00	1
6	10-1.0mm Hex nut	9051.00	9051.00	9051.00	—	1
6	12-1.25mm Hex nut	—	—	—	9142.00	1
7	Knurled roller	9066.00	9066.00	9066.00	9066.00	1
8	Socket round head bolt	9065.00	9166.00	9117.00	9117.00	1

(* Standard hardware item available locally)

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phase II + Morse Taper Holder

Description

Morse taper holder permits drilling with lathe carriage instead of tailstock. Holder is easily centered and accepts No. 2 or 3 Morse taper drills.

Dimensions

NOTE: All dimensions are in inches.

Tool Holder—Morse Taper (Style No. 5)

Lathe swing	Taper Hole Size	A	B
12	#2MT	3/4	1 1/2
10-15	#2MT	7/8	1 3/4
13-18	#3MT	1	2
14-20	#3MT	1 1/4	2 1/2

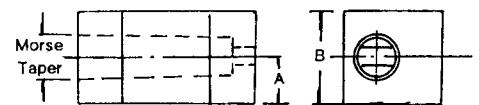


Figure 1

Please provide following information:

- Model number
- Serial number (if any)
- Part descriptions and number as shown in parts list

Address parts correspondence to:



14 Caesar Place
Moonachie, NJ 07074
Tel. 201-933-6300
FAX 201-933-3801

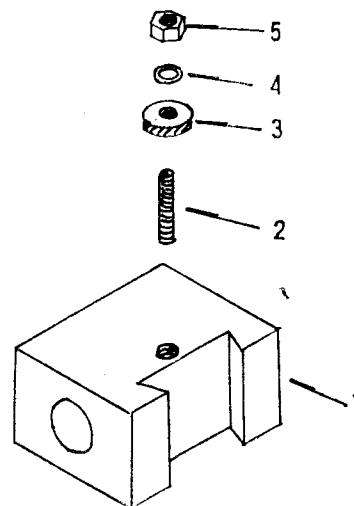


Figure 2—Replacement parts illustration For Tool Holder Style 5

Replacement Parts List

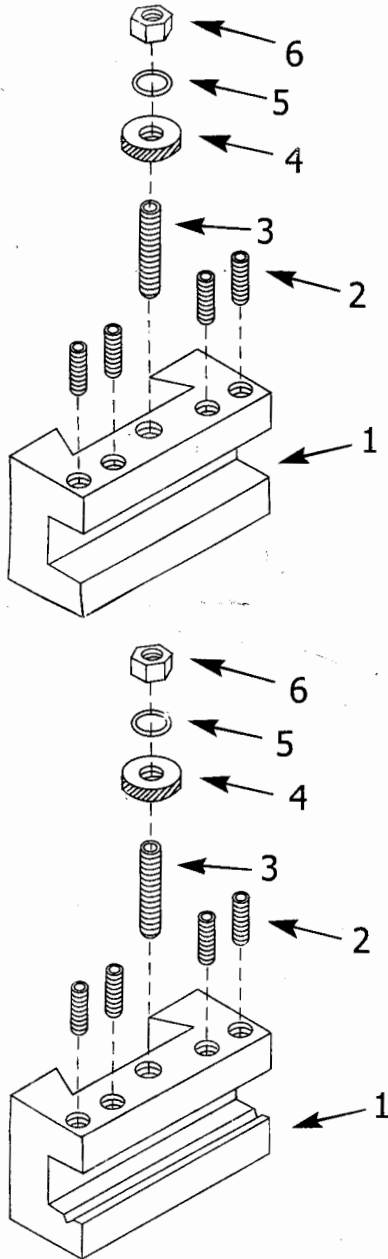
Reference Number	Description	Part Number For Models With:				Qty.
		12" Lathe Swing	10-15" Lathe Swing	13-18" Lathe Swing	14-20" Lathe Swing	
1	Body	9061.00	9179.00	9180.00	9152.00	1
2	10-1.0 x 45mm Set screw	9054.00	9054.00	—	—	1
2	10-1.0 x 55mm Set screw	—	—	9127.00	—	1
2	12-1.25 x 65mm Set screw	—	—	—	9145.00	1
3	Knurled nut	9053.00	9085.00	9131.00	9144.00	1
4	10mm Wavy washer	9052.00	9052.00	9052.00	—	1
4	12mm Wavy washer	—	—	—	9143.00	1
5	10-1.0mm Hex nut	9051.00	9051.00	9051.00	—	1
5	12-1.25mm Hex nut	—	—	—	9142.00	1

(*) Standard hardware item available locally

Wedge Type Quick Change Tool Post Sets

Please Provide following information:
Model Number
Serial Number(if any)
Part Descriptions and number shown in parts list

Figure 3- Replacement Parts Illustration for Tool Holder-Style 1



Ref. No.	Description	12" Lathe Swing	10-15" Lathe Swing	13-18" Lathe Swing	14-20" Lathe Swing	17-48" Lathe Swing
1	Body(style 1)	9056	9087	9113	9147	9190±
1	Body(style 2)	9057	9088	9114	9148	9190±
2	8-1.25x20mm set screw	*	-	-	-	-
2	10-1.5x20mm set screw	-	*	-	-	-
2	10-1.5x25mm set screw	-	-	*	-	-
2	12-1.75x32mm set screw	-	-	-	9146	-
2	12-1.75x32mm set screw	-	-	-	-	9191
3	10-1.0x45mm set screw	9054	9054	-	-	-
3	10-1.0x55mm set screw	-	-	9127	-	-
3	12-1.25x65mm set screw	-	-	-	9145	-
3	14-1.5x73mm Set screw	-	-	-	-	9192
4	Knurled Nut	9053	9085	9131	9144	9193
5	10mm wavy washer	9052	9052	9052	-	-
5	12mm wavy washer	-	-	-	9143	-
5	14mm Wavy washer	-	-	-	-	9194
6	10-1.0mm hex nut	9051	9051	9051	-	-
6	12-1.25mm hex nut	-	-	-	9142	-
6	14-1.5mm Hex nut	-	-	-	-	9195

*Standard hardware item available locally
 ±Advise number of tool holder when ordering

Figure 4 - Replacement Parts Illustration for Tool Holder-Style 2

Wedge Type Quick Change Tool Post Sets

All dimensions are in inches.

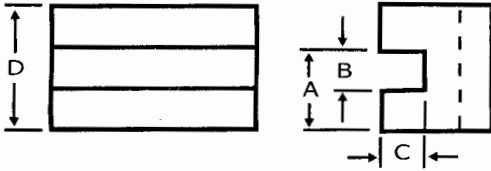


Figure 1B

Tool Holder-Turning and Facing (Style No.1)

Lathe Swing	Tool Bit	A	B	C	D
12	$\frac{3}{16}-\frac{1}{2}$	$\frac{15}{16}$	$\frac{9}{16}$	$\frac{7}{16}$	$1\frac{1}{2}$
10-15	$\frac{1}{4}-\frac{5}{8}$	$1\frac{1}{8}$	$\frac{21}{32}$	$\frac{1}{2}$	$1\frac{3}{4}$
13-18	$\frac{1}{2}-\frac{3}{4}$	$1\frac{7}{16}$	$\frac{51}{64}$	$\frac{5}{8}$	$2\frac{1}{8}$
14-20	$\frac{1}{2}-1$	$1\frac{11}{16}$	$\frac{1}{32}$	$\frac{3}{4}$	$2\frac{1}{2}$
17-48	$\frac{3}{4}-1\frac{1}{4}$	$2\frac{3}{16}$	$\frac{15}{16}$	1	$3\frac{1}{8}$

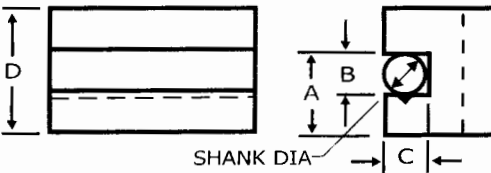


Figure 1C

Tool Holder- Boring, Turning and Facing (Style No.2)

Lathe Swing	Tool Bit	Shank	A	B	C	D
12	$\frac{3}{16}-\frac{1}{2}$	$\frac{7}{16}$	$\frac{15}{16}$	$\frac{9}{16}$	$\frac{7}{16}$	$1\frac{1}{2}$
10-15	$\frac{1}{4}-\frac{5}{8}$	$\frac{1}{2}$	$1\frac{1}{8}$	$\frac{21}{32}$	$\frac{1}{2}$	$1\frac{3}{4}$
13-18	$\frac{1}{2}-\frac{3}{4}$	$\frac{5}{8}$	$1\frac{7}{16}$	$\frac{51}{64}$	$\frac{5}{8}$	$2\frac{1}{8}$
14-20	$\frac{1}{2}-1$	$\frac{13}{16}$	$1\frac{11}{16}$	$\frac{1}{32}$	$\frac{3}{4}$	$2\frac{1}{2}$
17-48	$\frac{3}{4}-1\frac{1}{4}$	$1\frac{1}{8}$	$2\frac{3}{16}$	$\frac{15}{16}$	1	$3\frac{1}{8}$

Tool Holder- Heavy Duty Boring Bar (Style No.4)

Lathe Swing	A	B	C	D1
12	$\frac{3}{4}$	$1\frac{1}{2}$	$\frac{3}{4}$	$\frac{5}{8}$
10-15	$\frac{7}{8}$	$1\frac{3}{4}$	1	$\frac{3}{4}$
13-18	1	2	1	$\frac{3}{4}$
14-20	$1\frac{1}{4}$	$2\frac{1}{2}$	$1\frac{1}{4}$	1
17-48	$1\frac{9}{16}$	$3\frac{1}{8}$	$1\frac{1}{2}$	$1\frac{1}{4}$

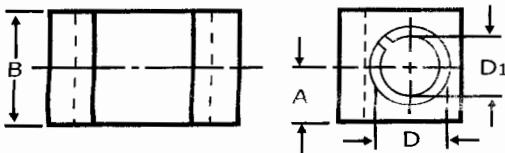


Figure 1D

Tool Holder-Universal Parting Blade (Style No.7)

Lathe Swing	Blade Ht.	A	B	C	D
12	$\frac{1}{2}$	$\frac{13}{16}$	$\frac{9}{16}$	$\frac{3}{16}$	$1\frac{1}{2}$
10-15	$\frac{11}{16}$	1	$\frac{23}{32}$	$\frac{3}{16}$	$1\frac{3}{4}$
13-18	$\frac{3}{4}$	$\frac{13}{16}$	$\frac{13}{16}$	$\frac{3}{16}$	2
14-20	$\frac{7}{8}$	$\frac{17}{16}$	$\frac{61}{64}$	$\frac{1}{4}$	$2\frac{1}{2}$
17-48	$1\frac{1}{8}$	$\frac{13}{4}$	$\frac{13}{16}$	$\frac{1}{4}$	$2\frac{3}{4}$

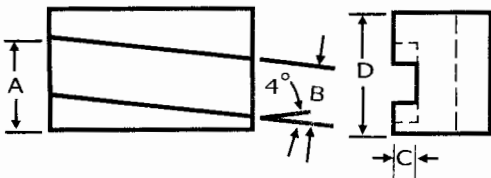


Figure 1E

Tool Holder-Knurling, Turning & Facing (Style No.10)

Lathe Swing	Tool Bit	A	B	C	E	E1
12	$\frac{3}{16}-\frac{1}{2}$	$\frac{7}{8}$	$2\frac{1}{2}$	$\frac{19}{16}$	$\frac{35}{64}$	$\frac{13}{32}$
10-15	$\frac{1}{4}-\frac{5}{8}$	1	$2\frac{5}{8}$	$1\frac{3}{4}$	$\frac{21}{32}$	$\frac{1}{2}$
13-18	$\frac{1}{2}-\frac{3}{4}$	$\frac{13}{16}$	$3\frac{1}{8}$	2	$\frac{25}{32}$	$\frac{1}{2}$
14-20	$\frac{1}{2}-1$	$\frac{17}{16}$	$3\frac{3}{4}$	$2\frac{1}{2}$	$\frac{11}{64}$	$\frac{3}{4}$
17-48	$\frac{1}{2}-1\frac{1}{4}$	$\frac{17}{8}$	$4\frac{1}{2}$	$3\frac{1}{8}$	$\frac{15}{16}$	1

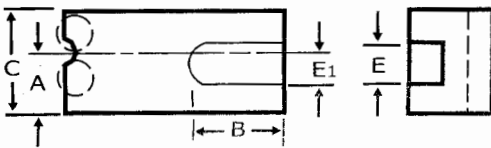


Figure 1F