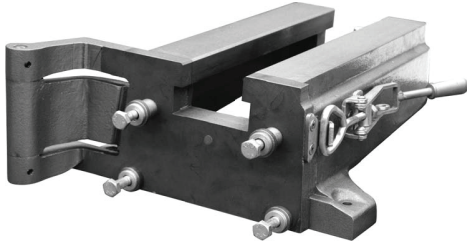


SWINGAWAY TAILSTOCK SUPPORT SYSTEM

ASSEMBLY INSTRUCTIONS



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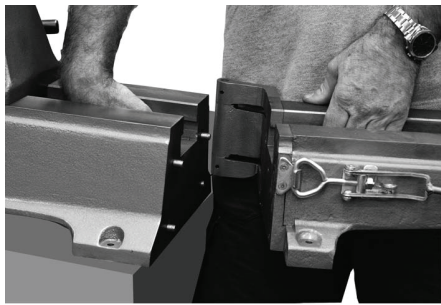
STEP 1

Remove only the four nuts and washers from the swing away tailstock support system (S.T.S.S.).



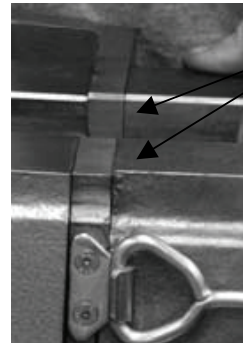
STEP 5

Re-clamp the support closed and test to see if the Tailstock slides through the bed and the STSS freely.



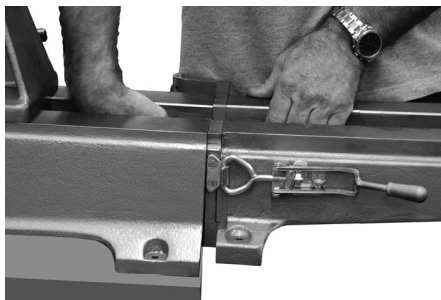
STEP 2

Position STSS to the end of the VL300 short bed. Try and get the two faces together. You may need to wriggle the STSS or tap with a plastic hammer to get the faces close together.



STEP 6

If the tailstock does not slide freely you can try to align the STSS by tapping it with a plastic hammer on the top or sides. If this does not work you may need to slightly file the opening or the top edge of the STSS.



STEP 3

Hold the STSS in position, place on Washers (item 13 then item 14) and then tighten nuts (item 15) finger tight.



STEP 7

For continuous use of the STSS in the closed position i.e. to gain extra length between centers the M10 bolt should be put back in for added strength and to avoid flex.



STEP 4

Undo M10 Bolt (item 6) and unlatch handle then swing the support open. Finish tightening the nuts (item 15) using a 6mm Allen key and a 16mm ring spanner.

Parts List			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1		Tailstock Support Bed
2	1		Hexagon head bolts M8 x 65
3	2		Hex Nut M8, Lock
4	5		Socket Head Countersunk Screw M5 x 12
5	1		Latch
6	1		Hexagon head bolt M10 x 40
7	1		Washer 10mm
8	1		Arm - Inner
9	2		Socket Head Countersunk Screw M8 x 25
10	2		20mm Locating Bush
11	4		Socket Head Countersunk Screw M10 x 60
12	1		Arm - Outer
13	4		Washer 25.4mm
14	4		Spring Washer, 10mm
15	4		Hex Nut M10 x 1.5
16	2		Socket Set Screws M6 x 8
17	2		Dowel Pin 12 x 60 & 12x70

