

# Hub Profile Kits

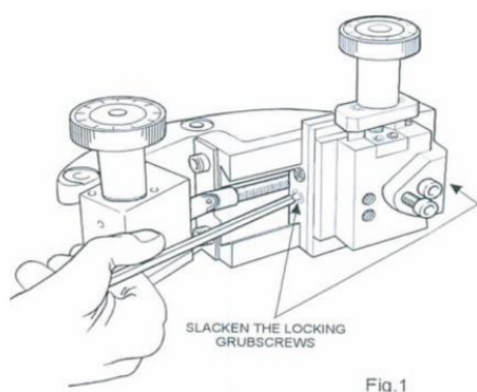
## AX024

### Technical documentation

#### Instructions Setting the Toolpost Angle

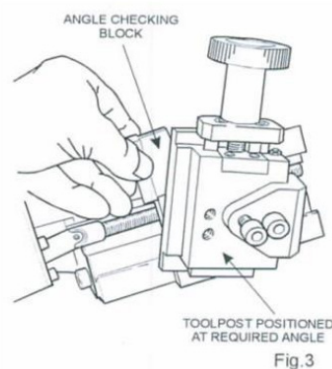
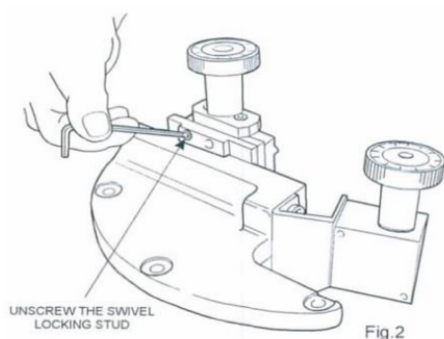
**Note:** These Instructions Presume A Level Of Engineering Experience And Competence To Operate This Type Of Machinery.

1. The toolpost on the Hub Profile unit is designed to swivel and be locked at three pre-determined angles: 15°, 20° and 23°. Decide which toolpost angle is required to suit the Hub Profile. Slacken (approx. ½ turn) the two locking grub screws – one each side of the toolpost. (Fig.1)



2. Unscrew the swivel locking stud (Fig.2) at the rear of the toolpost until the toolpost will swivel. Adjust to the required angle and use the appropriate angle checking block by placing it flat against the revealed toolpost backplate (Fig.3) to verify the angle. Tighten the swivel locking stud.

**NOTE:** if the toolpost angle is correctly set the swivel locking stud will locate in a pre-machined hole in the toolpost backplate.



Integrated Solutions to Piping Problems | [www.patriot-int.com](http://www.patriot-int.com)

#### The Netherlands

Dordrecht

T: +31 (0) 78 652 41 11

E: [info@patriot-int.com](mailto:info@patriot-int.com)

#### United Kingdom

Aberdeen

T: +44 (0) 1224 724726

E: [info@patriot-int.com](mailto:info@patriot-int.com)

#### Belgium

Antwerp

T: +32 (0)36 00 17 07

E: [info@patriot-int.com](mailto:info@patriot-int.com)



## Fitting The Hub Profile Unit

3. Unscrew and remove the three M10 screws securing the standard toolpost saddle unit to the drive ring. Lift out the unit and replace with the Hub Profile unit, fit the three screws and secure the unit in position. (Fig.4)

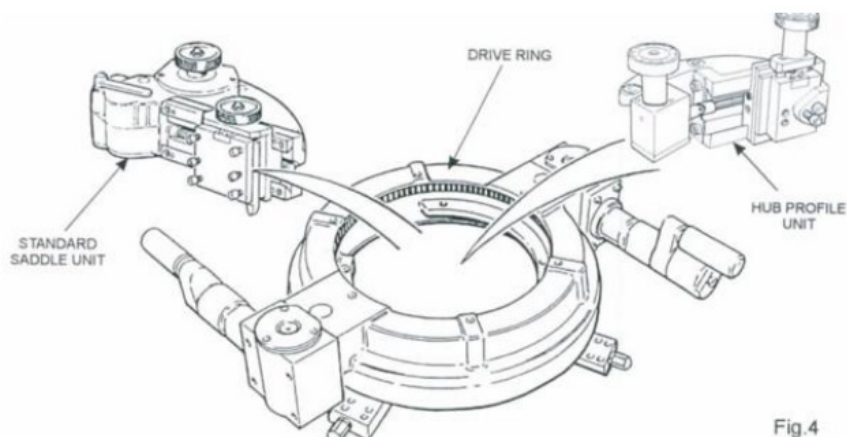


Fig.4

4. To fit the cutting tool, slacken the centre screw on the tool clamp until the tool can be inserted between the clamp bracket and the toolpost body (Fig.5). Position the tool in the desired position and secure by tightening the locking screw.

The Hub Profile unit is now correctly fitted to the drive ring. Refer to the technical manual for setting up the machine on the hub and operation procedures.

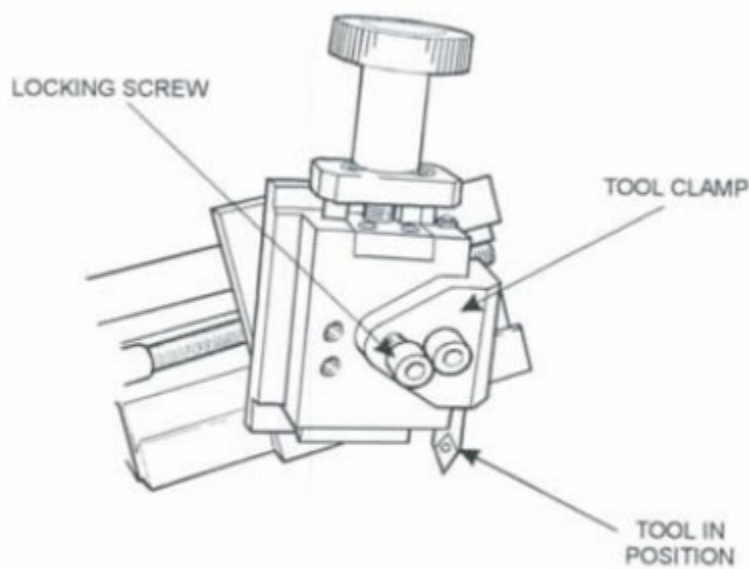


Fig.5

Integrated Solutions to Piping Problems | [www.patriot-int.com](http://www.patriot-int.com)

**The Netherlands**

Dordrecht

T: +31 (0) 78 652 41 11

E: [info@patriot-int.com](mailto:info@patriot-int.com)

**United Kingdom**

Aberdeen

T: +44 (0) 1224 724726

E: [info@patriot-int.com](mailto:info@patriot-int.com)

**Belgium**

Antwerp

T: +32 (0)36 00 17 07

E: [info@patriot-int.com](mailto:info@patriot-int.com)

