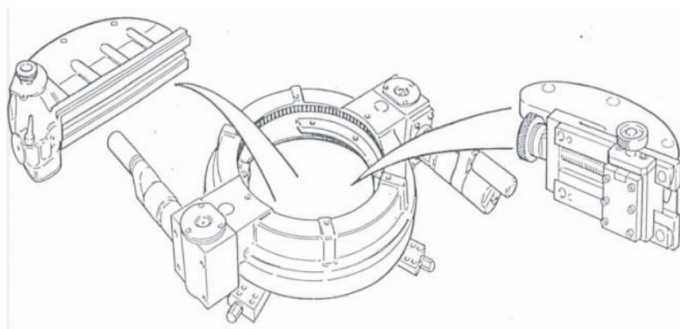


V Groove Machining Kits

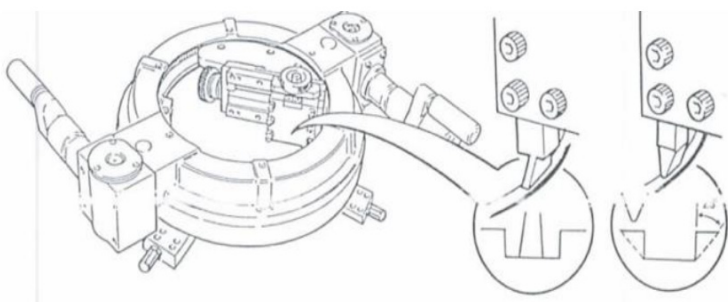
AXL012

Technical documentation

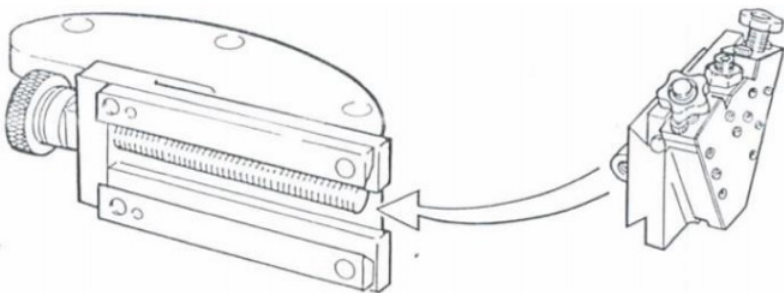
1. Remove standard saddle and replace with hand operated saddle ('D' section).



2. Using the standard tool holder, cut a vertical sided groove at the desired diameter. Remove cutting tool and by using a left/right handed plunge tool, remove sides of the grooves in a rough 'V' shape.



3. Remove the 'D' section saddle from the machine and replace standard toolpost with the 'V' groove toolpost. Refit the saddle on to the machine.



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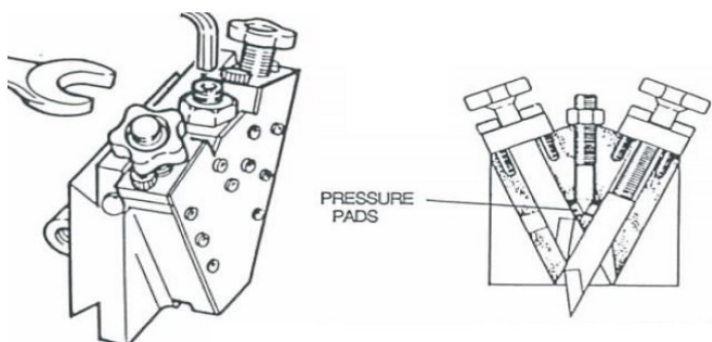
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Antwerp

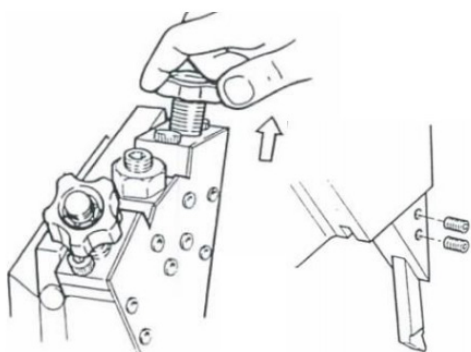
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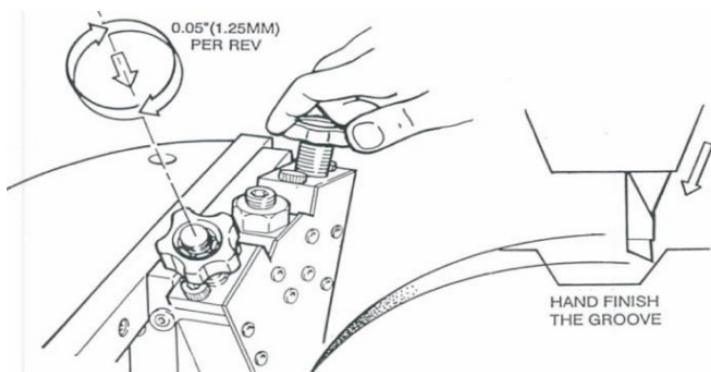
- To set the toolslides on 'V' groove toolpost, slacken off the locknut and use an Allen key to adjust the pressure pads



- Raise the unused slide by the appropriate thumbscrew. Lower the tool slide required, to gain access to the securing grub screws. Slacken off and attach the tool.



- Finally, hand finish the grooves by using the appropriate thumbscrew to lower the tool



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