

7X\*\* MINILATHE  
 FILING GUIDE ATTACHMENT  
 EXPLODED GENERAL ASSEMBLY

## MINILATHE FILING GUIDE ATTACHMENT

### HINTS FOR OPERATION:

1. HEADSTOCK SPINDLE MUST BE CLAMPED SOLID DURING FILING OPERATIONS.
2. SOME MEANS IS NEEDED TO INDEX THE HS SPINDLE FOR ACCURATE LOCATION OF FILED FLATS.
3. PROVIDE A MEANS TO CLAMP THE SADDLE TO THE LATHE BED DURING FILING OPERATIONS.
4. USE A COARSE FILE TO REMOVE MOST OF FLAT, FINISH WITH A SMOOTH-CUT FILE.
5. FILES WITH A 'SAFE EDGE' AGAINST THE STOP ARE EASIER ON THE FLAT WASHER.
6. MAXIMUM DIAMETER OF WORKPIECE IS APPROXIMATELY 2".
7. LONG WORK SHOULD BE SUPPORTED BY THE TAIL STOCK CENTER.
8. TO BEGIN, SECURE WORK IN HS CHUCK, POSITION THE REST ALONG THE LATHE BED.
9. HOLD A STRAIGHTEDGE ACROSS THE REST. ADJUST THE HEIGHT TO JUST TOUCH THE WORK OD.
10. CALCULATE THE SETSCREW TURNS REQUIRED TO LOWER THE REST TO THE DEPTH OF THE FLAT TO BE FILED.

### HINTS FOR CONSTRUCTION:

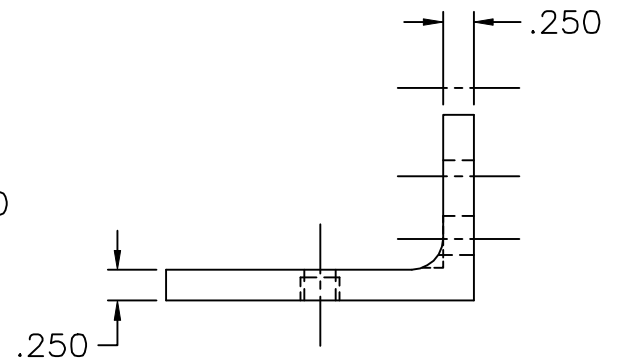
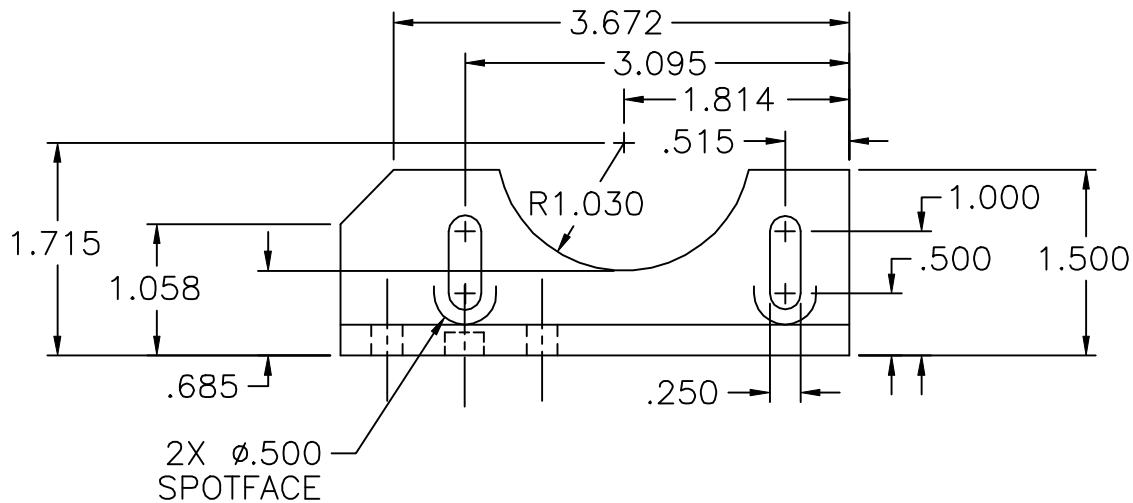
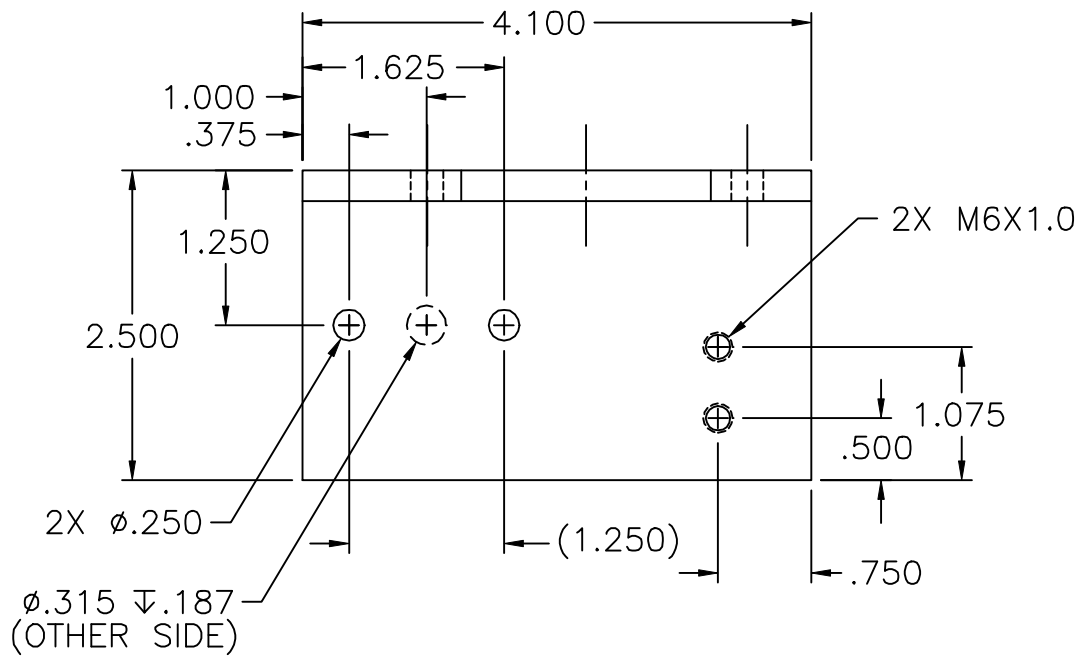
1. TO SOLDER THE LUGS ON THE BACK OF PC-2, DRILL/TAP THE LUG FOR A SMALL BRASS SCREW AND MOUNT THE BLOCK TO THE PLATE. MAKE 3 DIMPLES IN THE PLATE WITH A PRICK PUNCH TO PROVIDE THE REQUIRED .003" SPACE FOR SOLDER TO FLOW INTO THE JOINT.
2. DRILL OUT THE TEMP FASTENER AND DRILL/TAP FOR THE LARGER PERMANENT FASTENER.

\*\* ALTERNATIVE TO PC. 7, HOLDS 3 BEARINGS VS. 5 PER BOLT

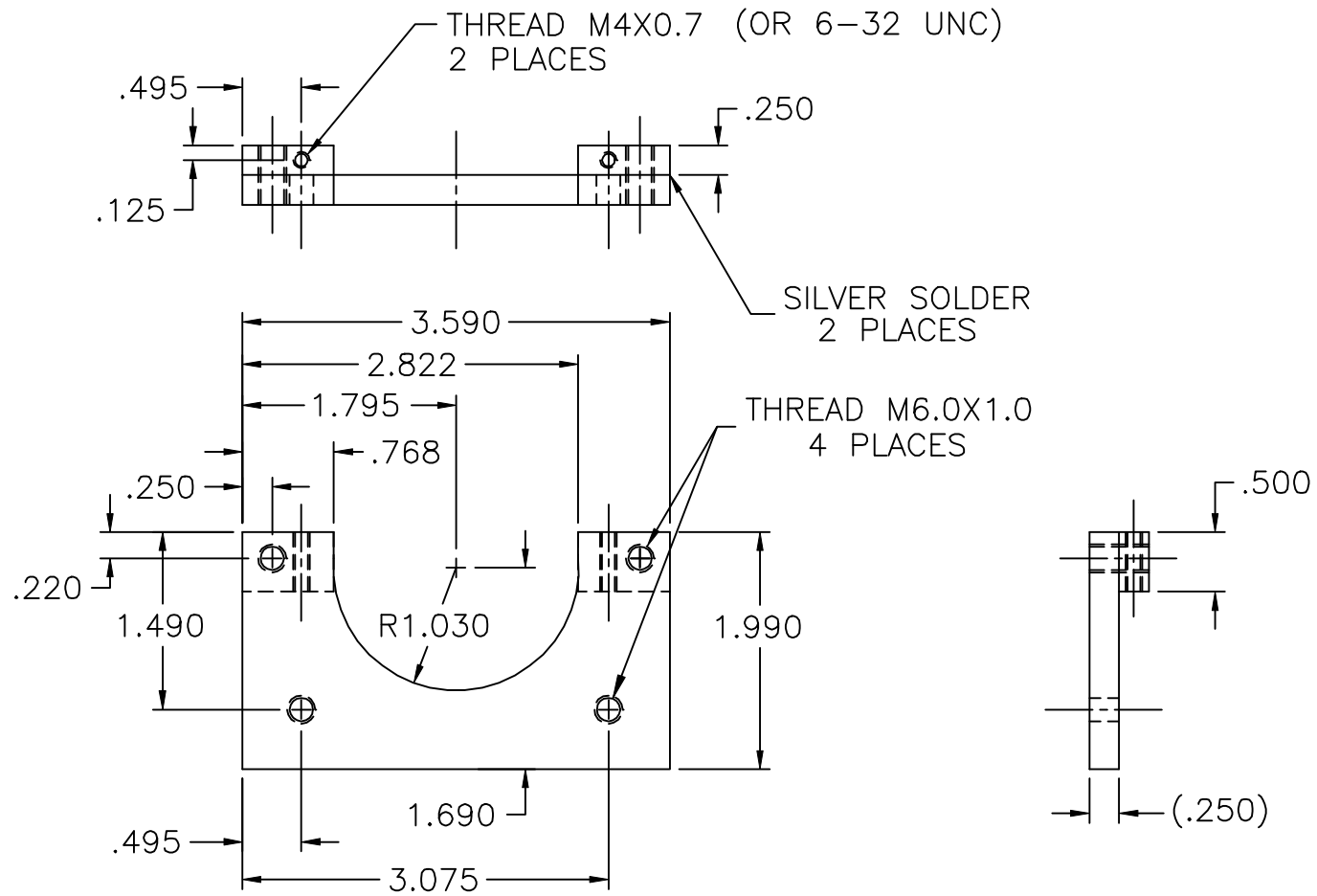
\* QUAN AS REQ'D TO FILL SHOULDER BOLT SHANK LENGTH

9.	SETSCREW, HEX SOCKET	STEEL, BLUE FINISH	M4X.7 X 25MM		2
8.	SKT HD CAP SCREW (SHCS)	STEEL, BLUE FINISH	M6X.1X16MM		4
7a.	SHOULDER BOLT **	STEEL, BLUE FINISH	8MMX25MM (M6X.1 THD)		2
7.	SHOULDER BOLT	STEEL, BLUE FINISH	8MMX40MM (M6X1 THD)		2
6.	FLAT WASHER "HI-COLLAR"	STEEL, ZINC PLATE	6MM ID		4
5.	FENDER WASHER, LARGE	STEEL, ZINC PLATE	1-1/4" OD X .315 ID	DRILL OUT 1/4" SIZE	2
4.	FENDER WASHER *	STEEL, ZINC PLATE	1" OD X .315 ID	DRILL OUT 1/4" SIZE	4
3.	BEARING, BALL (SKATE)	STEEL, BRIGHT, ABEC-5	22 X 8 X 7MM	TYPE 608Z	10
2.	FACEPLATE	FLAT BAR, 2 X 1/4"	STEEL, HOT ROLL, A-36	3-3/4" LONG	1
1.	BASE	ANGLE, 2-1/2 X 1-1/2 X 1/4"	STEEL, HOT ROLL, A-36	4-1/4" LONG	1
ITEM	DESCRIPTION	MATERIAL	SPECIFICATION	CUT SIZE	REQ'D

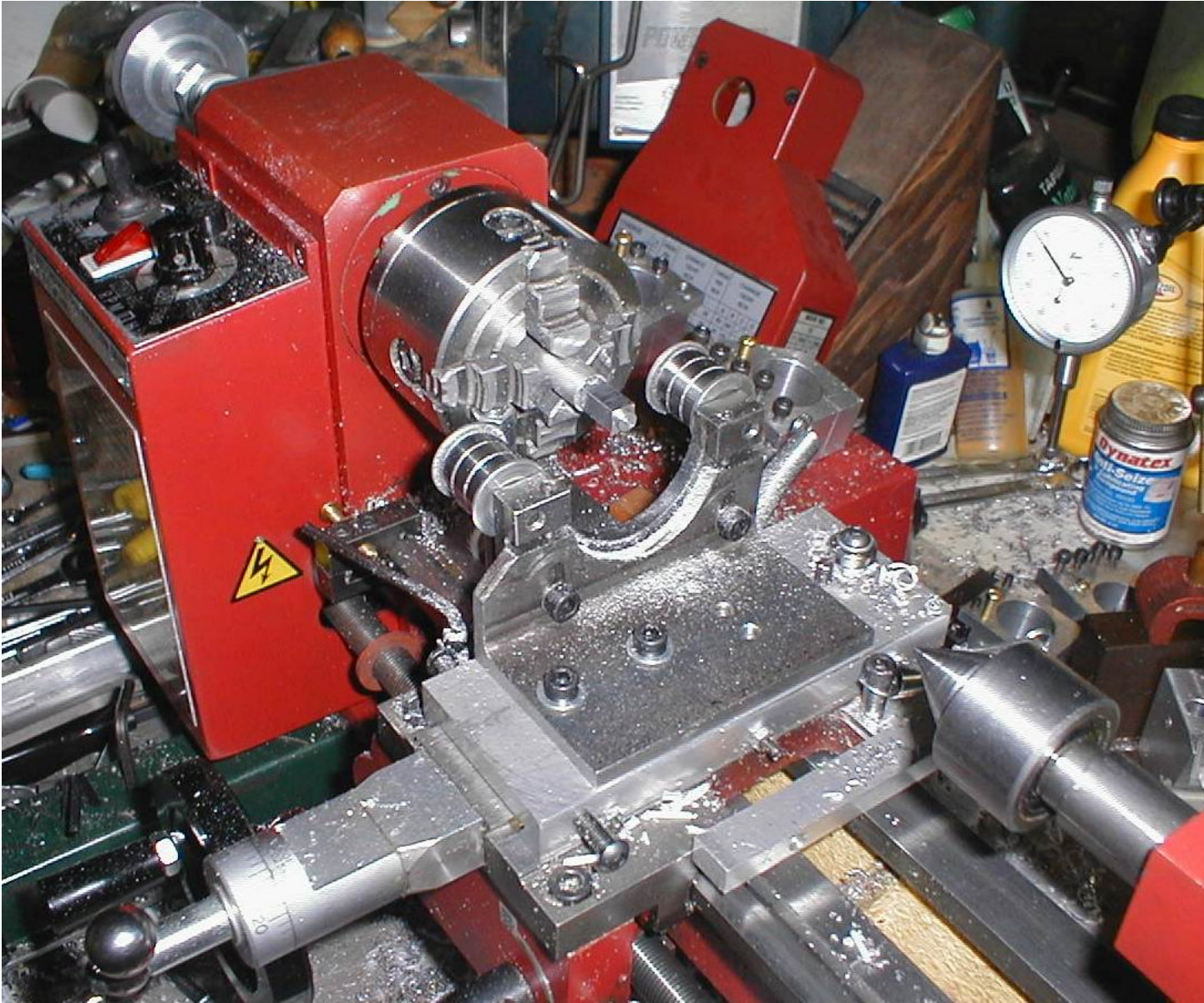
### BILL OF MATERIALS



① BASE  
DETAIL



② FACEPLATE  
 DETAIL



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All ideas, procedures, modifications and whatever is described or shown here is to be used at risk of the reader.

Take care and work safely.