

# SWINGAWAY TAILSTOCK SUPPORT SYSTEM & Extension Bed

## ASSEMBLY INSTRUCTIONS



Vicmarc Machinery Pty Ltd

52 Grice Street Clontarf QLD 4019 Australia

Phone (07) 3284 3103

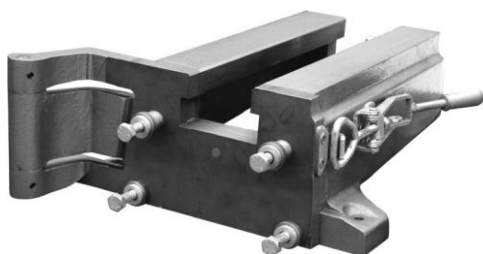
Fax (07)3283 4656

Int Ph 61-7 3284 3103

Int Fax 61-7 3283 4656

Email vicmarc@vicmarc.com

Web www.vicmarc.com



### STEP 1

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



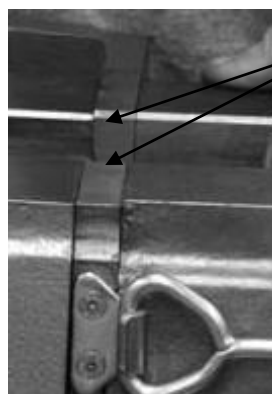
### STEP 5

For the STSS re-clamp the support closed and test to see if the Tailstock slides through the bed and the STSS freely (same with extension beds).



### STEP 2

Position unit to the end of the VL300 short bed. Try and get the two faces together. You may need to wriggle the STSS or extension bed slightly to get the faces close together.



### STEP 6

If the tailstock does not slide freely you can try to align the STSS or extension bed by firmly tapping it with a plastic hammer on the inner sides shown until it moves slightly. If this does not move, you may need to file the bed gap to make the tailstock slide. As you do this and test with the tailstock, you will notice a black mark appear where the 2 parts are tight. This black rub mark is the location that needs to be filed. Sometimes the top edge of the unit may require some filing too.



### STEP 3

Hold the unit in position, place on washers, spring washers and then tighten nuts (finger tight).



### STEP 4

Undo M10 Bolt and unlatch handle for STSS only then swing it open. Finish tightening the nuts using appropriate tools.



### 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.