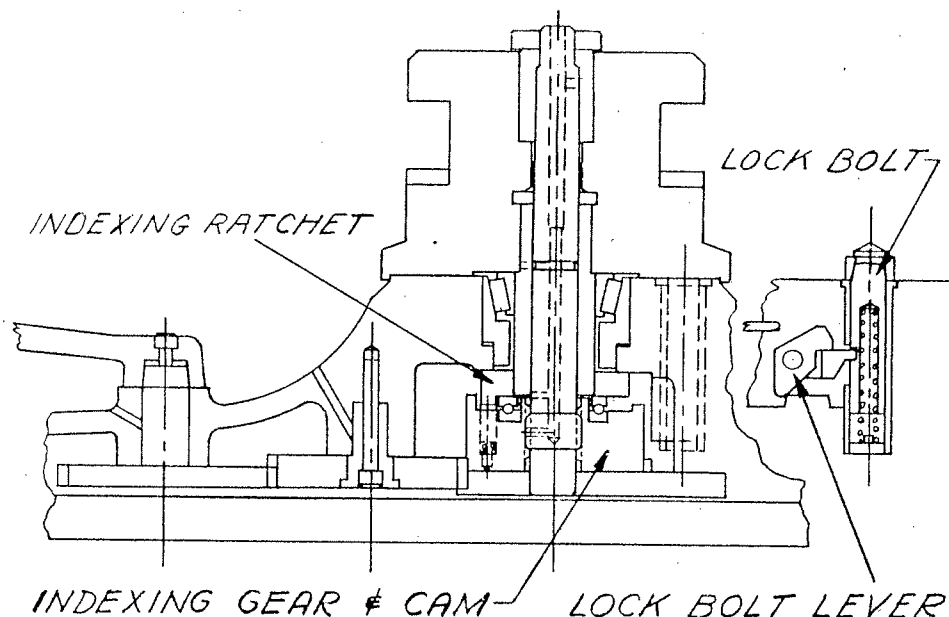


BARDONS & OLIVER, Inc.

MANUFACTURERS OF
TURRET LATHES AND CUTTING OFF MACHINES
CLEVELAND 13, OHIO, U. S. A.



#21A - #21B - #22A - #22B - UNIVERSAL TURRET LATHES

Section Thru Square Turret

These instructions supplement those given on page 7 of Instruction Manual.

To disassemble the Square Turret, remove the Cross Slide from the Carriage. Remove the adjusting nut at the top of the center stud, and remove the bottom plate located beneath the cross slide. All of the parts can now be removed.

To reassemble, fit the index ratchet on the spline of the square turret hub such that the teeth on the ratchet are in line with the center of the turret faces. Screw center stud into index gear so that splined end extends about $7/16$ in. Note: lower thread on center stud is left hand. Insert assembled index gear and stud thru square turret. Lock bolt should be in position. Put bottom plate back on with projecting pin in recess in gear. Replace spacer and adjusting nut at top leaving nut loose.

Reposition operating lever if necessary. Index turret one station and slowly bring lever back until there is a click, which is the lockbolt tumbler. Tighten adjusting nut finger tight. Pull handle back until turret is tight. Lever may be stopped by pin in bottom plate and index gear if adjusting nut is too loose. Change adjusting nut if necessary. Check that bottom of center stud does not extend below bottom plate.

If for any reason indexing mechanism becomes locked loosen adjusting nut and index turret. Repeat above operation of resetting adjusting nut.

December 11, 1950