INSTRUCTIONS

CLAUSING

DIVISION, ATLAS PRESS COMPANY
KALAMAZOO, MICHIGAN 49001

REPLACING LEAD SCREW SHEAR PIN

for

10" – 4900 SERIES LATHES
12" – 5900 SERIES LATHES
14" – 6900 SERIES LATHES

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INSTALLATION INSTRUCTIONS

NOTE: To remove pin that has not been sheared and replace it with new shear pin and retainer follow steps 7 thru 10.

1. Slide tailstock to end of lathe bed and lock.
2. Using carriage handwheel, position carriage assembly in the middle of lathe bed and engage half nut.

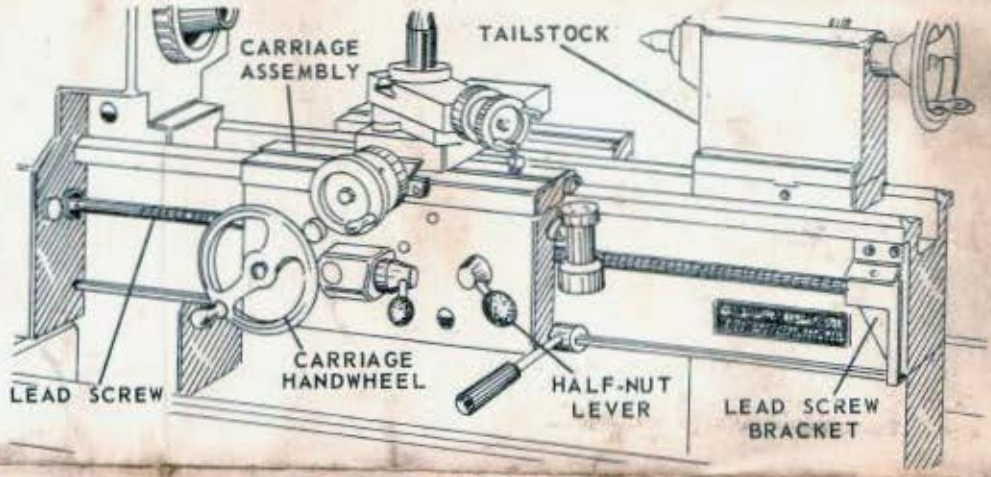


FIGURE 1

3. Remove lead screw bracket from lathe bed by removing two cap screws.
4. With handwheel move carriage toward tailstock until lead screw is free of dog clutch shaft on gear box as shown in figure 2.
5. With 3/32 inch diameter steel rod, remove broken shear pin from holes in lead screw and dog clutch shaft.

CAUTION: Be sure pieces of shear pin are removed from ID of lead screw.

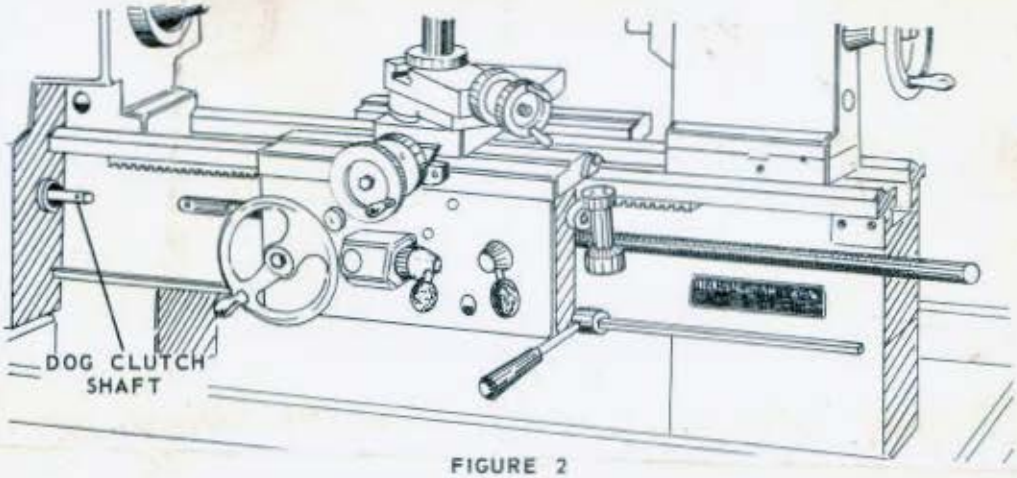


FIGURE 2

6. Move carriage toward headstock and slide lead screw over dog clutch shaft. Disengage half-nut lever.
7. Rotate lead screw by hand until shear pin holes in lead screw are aligned with the hole in dog clutch shaft
8. Insert new shear pin and tap lightly with small hammer. If shear pin does not pass through both shafts with ease, remove shear pin and rotate lead screw 180 degrees. Align holes and tap shear pin through with hammer.
9. Install retainer on shear pin, opposite the head end.
10. Move carriage assembly back against tailstock, engage half-nut lever to align lead screw. Wipe end of lead screw clean and oil – then reinstall lead screw bracket.