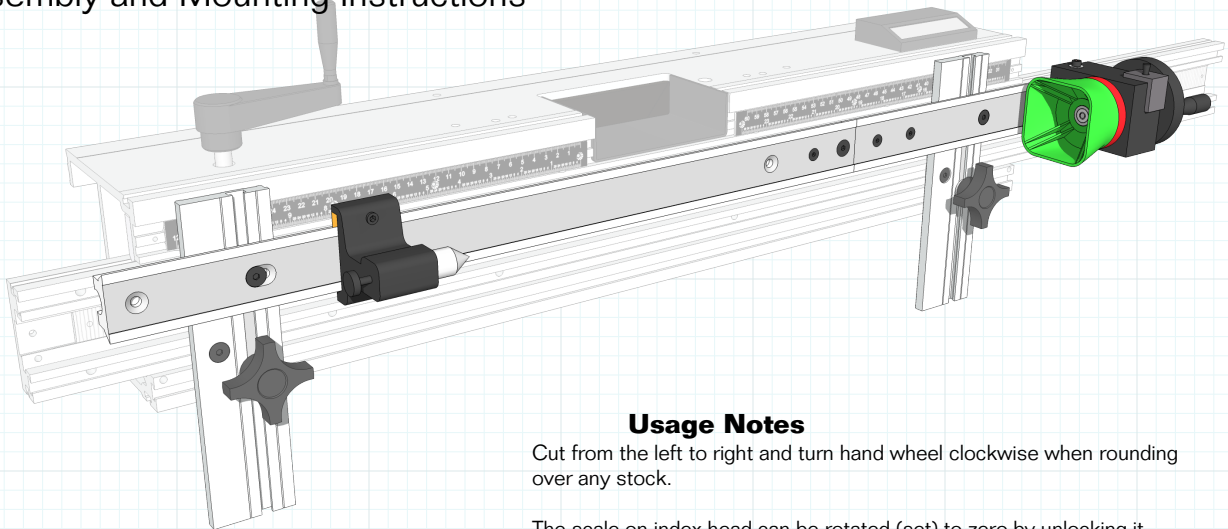




4th Axis Work Holder

Assembly and Mounting Instructions



Usage Notes

Cut from the left to right and turn hand wheel clockwise when rounding over any stock.

The scale on index head can be rotated (set) to zero by unlocking it with a 1/16" Allen wrench. There is a white zero line marked on the index head (near lock lever).

The included faceplate can be mounted on the index head in place of the headstock adapter

Parts List

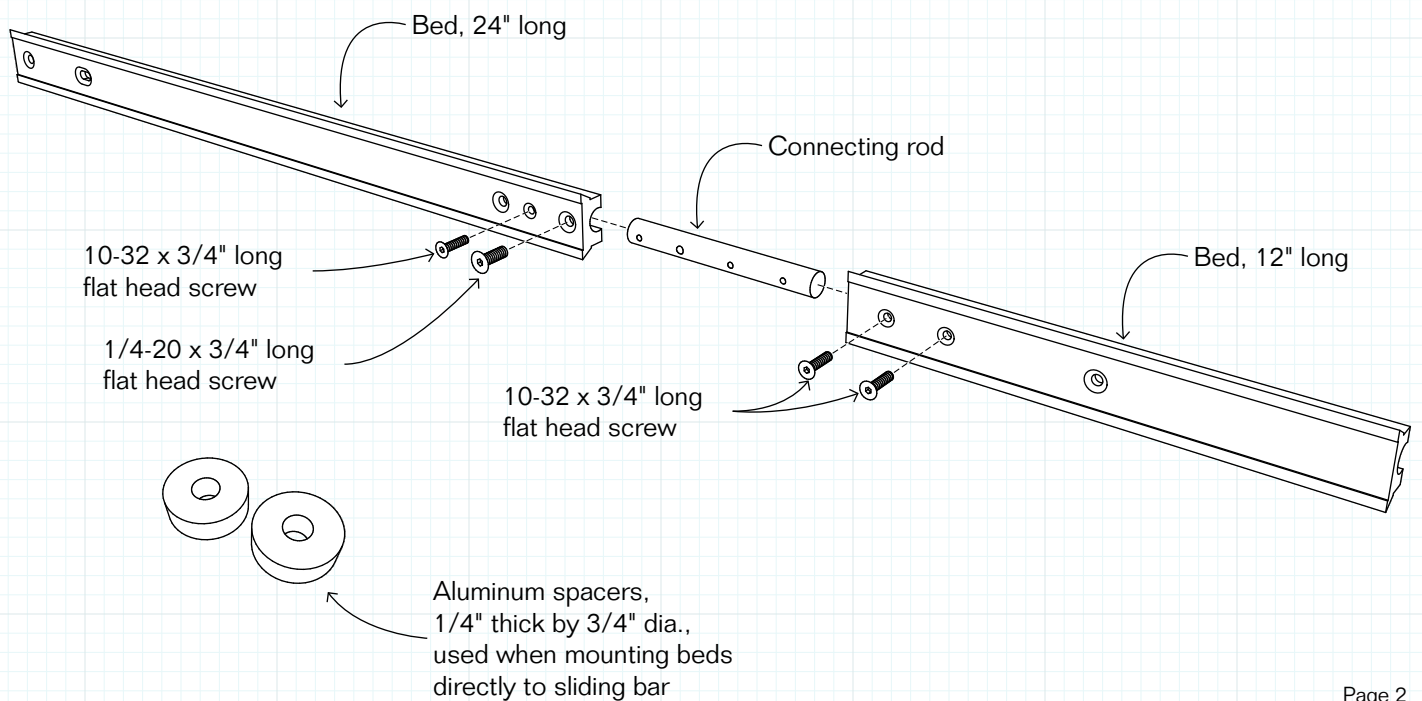
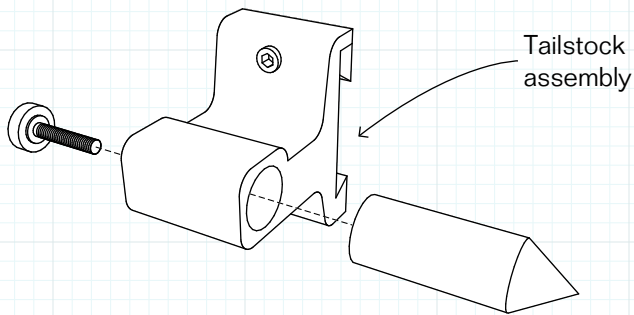
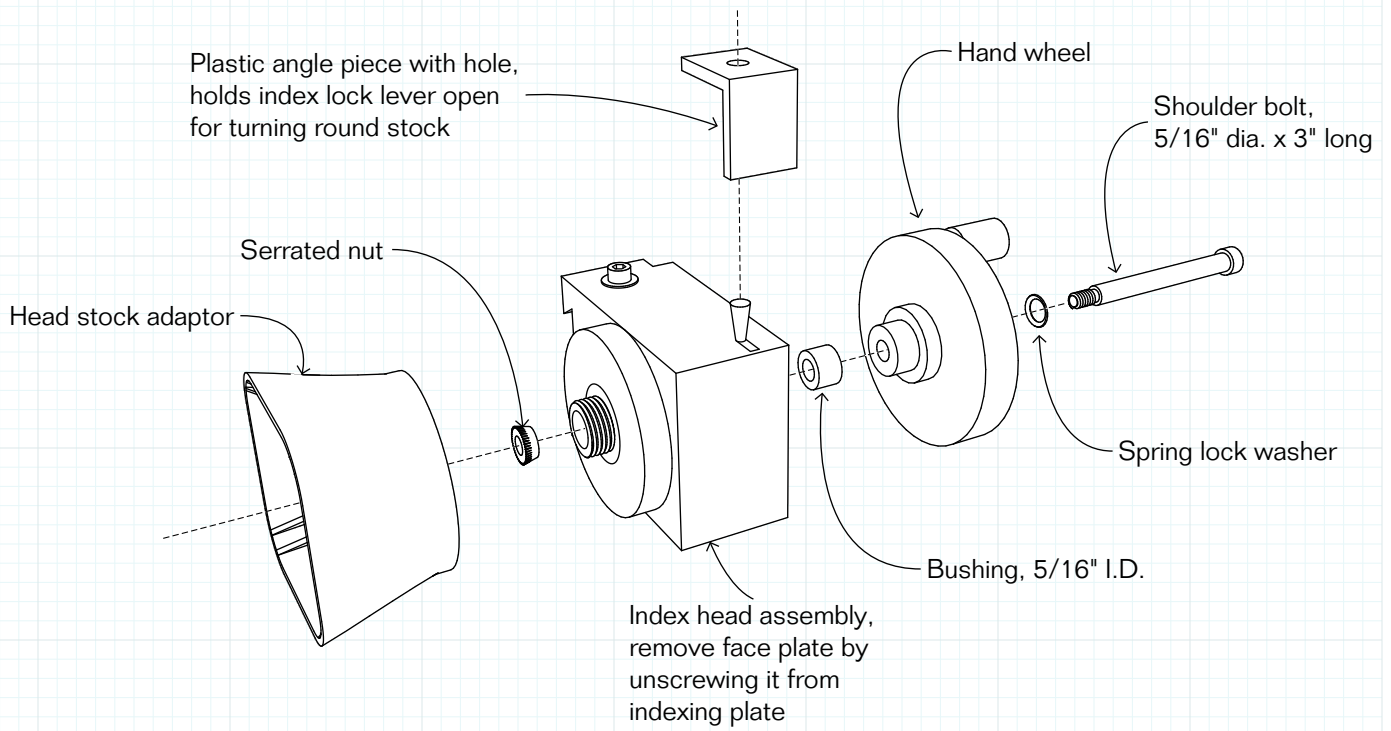
Parts in Kit

- 1 – Index Head supplied with aluminum face plate (remove face plate to install headstock adapter)
- 1 – Index Tailstock
- 1 - 24" Bed
- 1 - 12" Bed
- 1 – Connecting Rod (connects the 2 custom beds)
- 1 – Headstock Adapter (Green polycarbonate plastic) for use with stock that has a square end (chucks are available from Sherline)
- 1 – Plastic angle with hole (holds lock open on the index head so that you can turn stock round)
- 2 – ¼-20 by 1-1/2" flat head screw (For attaching the unit direct to sliding bar)
- 2 – ¼-20 by 7/8" flat head screw (For attaching the unit to mortise table t-track vertical supports)
- 1 – ¼-20 by ¾" flat head screw (For connecting rod)
- 3 – 10-32 by ¾" flat head screw (For connecting rod)
- 1 – 5/16" by 3" shoulder screw (this and the items below are used to assemble crank)
- 1 – ¼-20 serrated edge nut
- 1 – 5/16" spring lock washer
- 1 – 3/8" by 5/16" ID drill bushing
- 1 – Dished hand wheel
- 2 – ¼" by ¾" OD spacer (For attaching bed direct to sliding bar or for use with 4 arm knob below when using mortise table supports)

Craftsman Gallery Parts from Mortise Table

(not included, order separately if you did not purchase the mortise table and want to taper cuts)

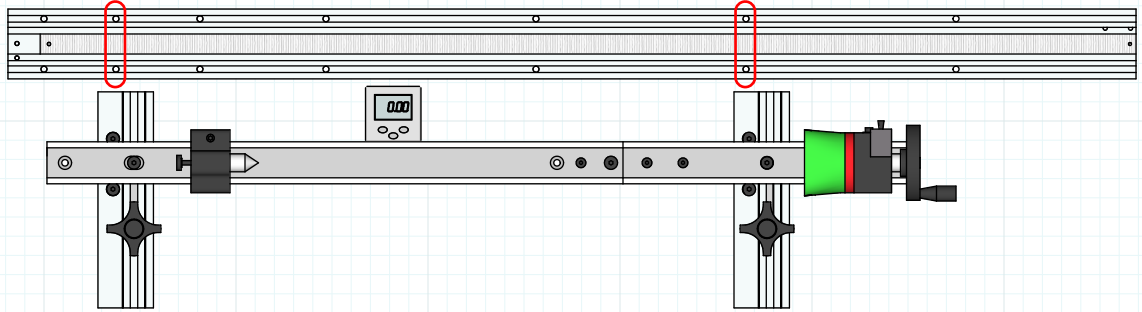
- 2 – Vertical support t-tracks
- 2 – Double tap nut (t-track bar)
- 2 – ¼-20 by ½" stud 4 arm knob
- 2 – 1/8" thick double hole spacer (fits between above support and sliding bar)



Four Ways to Mount The 4th Axis Work holder

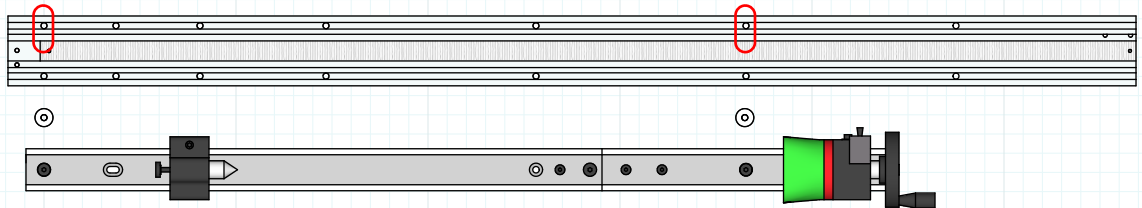
Option 1

Mount vertical tracks from Mortise Table in taps 2 and 6
This allows the bed to be tilted to create tapered turnings
Use Angle Cube to set angle



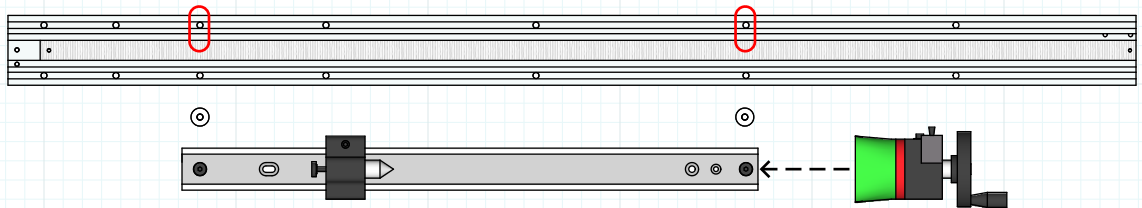
Option 2

Mount directly in taps 1 and 6 with aluminum spacers (included)
Use top taps



Option 3

Mount 24" bed only directly in taps 3 and 6 with aluminum spacers (included)
Use top taps



Option 4

Mount vertical tracks from Mortise Table in taps 2 and 5
Use only 24" bed
This allows the bed to be tilted to create tapered turnings
Use Angle Cube to set angle

