

L-W CHUCK CO.

TOLEDO, OHIO

INSTRUCTIONS

For Operation and Adjustment

Model S. D. 6½" Dividing Head

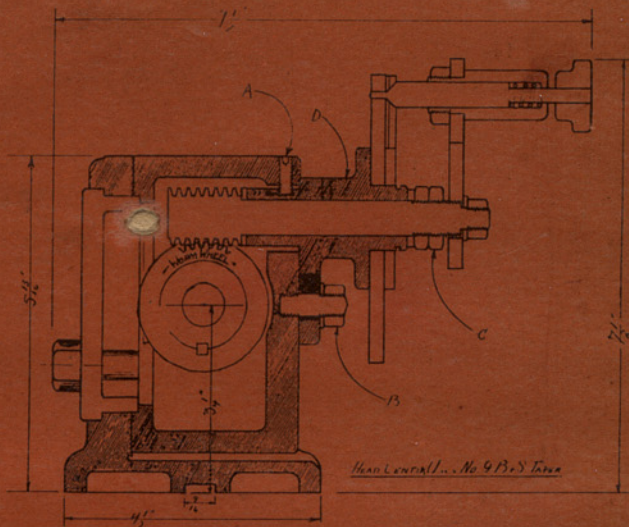
To Remove the Play from the 6½" L-W Dividing Head

1. Remove entire bearing bracket assembly "D" from the head by first unscrewing set screw "A" back about 6 turns. Then remove nut and washer "D" from stud, then worm assembly can be screwed out of the head.

2. Hold large end of worm in a padded vise (caution must be taken to prevent injury to the worm threads). Then with two thin wrenches adjust jam nuts "C" until all play is out but it is still possible to move bearing bracket freely around the worm shaft.

3. Replace bearing bracket assembly in head. Hold bracket "D" up and against the face of the head barrel, then put on washer and nut "B" and set firm (not tight). Screw down "A" until it begins to move "D".

Now lock the spindle binder bolt (not shown but found on the side of the head near the large end of spindle). Then with the plunger pin in the index handle pulled back from the index plate, rock handle back and forth as you gradually tighten down the adjusting screw "A" until all play is out (caution, do not force "A" down to hard or head will not turn free). When proper setting is reached tighten "B" securely. Release spindle binder bolt. Head is now ready for use.



1. Head Stock Barrel
2. Head Stock Frame
3. Worm Bearing Bushing
- 3P. Index Plates
4. Tail Stock Frame
5. Head Frame Cover
6. Driving Dog
7. Spindle Back Collar
8. Worm Shaft
9. Worm Wheel
10. Head Stock Center
11. Spindle
12. Worm Thrust Bearings
13. Tail Center Adj. Knob
14. Tail Center Lock Knob
15. Worm Takeup Collar
16. Tailstock Center
17. Binder Bolt
18. Tailstock Stub
19. Dust Collar
20. Worm Washer ¾" SAE
21. Dividing Sector
22. Index Spring Washer
- 23-24-25. Index Crank
26. Worm End Nut
27. Cover Bolts-Washers
30. Dog Set Screws
32. Spindle Key
33. Bottom Keys
34. Bottom Key Screws
35. Oilers
36. Worm Bearing Stud