

Installing the OXA Quick Change Tool Post

The OXA quick change tool post (QCTP) can be mounted on many small lathes. For some lathes, LittleMachineShop.com includes mounting hardware that makes it a bolt-on installation. For others, some work is required.

On the following pages, you'll find instructions for mounting the OXA QCTP on the following lathes:

- 6" Atlas/Craftsman lathe (P/N 4058 or P/N 3048)
- Taig lathe (P/N 3048)

Lathes not listed above

If your lathe is not listed above, don't despair. You can still mount the OXA QCTP on your lathe. There are two types of tool post mounting:

- On a stud extending from the top of the compound rest
- With a T-slot in the top of the compound rest

Stud mounting

If your lathe has a stud extending out of the compound rest, there are three common things you can do:

- Make a new stud for your lathe (sometimes you can start with an M10 bolt)
- Modify the stud in your lathe to suite the OXA QCTP
- Modify the stud in the OXA QCTP to suite your lathe

Look through the instructions below; you might find an idea that will work for your lathe.

T-Slot mounting

If your lathe has a T-slot in the compound, you also have three choices:

- Make a T-slot nut out of the block furnished on the bottom of the OXA QCTP
- Modify the T-slot nut from your lathe to suit the OXA QCTP
- Make new T-slot nut from other material

A large majority of (especially older) lathes use this method of mounting the tool post. You are doing what most QCTP purchasers have to do.

6" Atlas/Craftsman lathe

This is a large genre of lathes, but the OXA QCTP mounts with a T-slot nut on all of them. However, the dimension of the T-slot nut required varies, so you need to measure the width of the top of the T-slot on your compound rest.

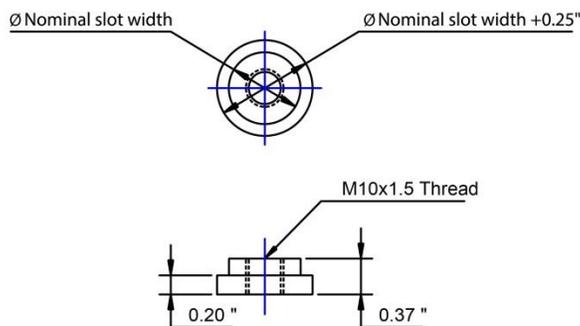
4058 - Quick Change Tool Post Set, OXA for Atlas/Craftsman 6"

This set includes a T-slot nut that fits Atlas/Craftsman lathes with a 5/8" or 3/4" T-slot. This T-slot nut fits most Atlas/Craftsman lathes.

3048 - Quick Change Tool Post Set, OXA, Tormach

If your T-slot is significantly different from either of those dimensions you can make a T-slot nut to fit your lathe.

- You can mill the block of steel that comes on the bottom of the OXA QCTP to make a T-slot nut for your lathe.
- Using your lathe, you can make a T-slot nut like this:



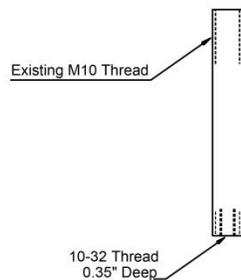
We can't tell you the dimensions, except that the center hole must be tapped M10x1.50 thread. The tap is our P/N 4838. Measure your T-slot and make it an easy fit.

Taig lathe

3048 - Quick Change Tool Post Set, OXA, Tormach

On the Taig lathe the tool post mounts with a T-slot nut in the cross slide. To mount the OXA QCTP you must modify the stud that comes with the OXA QCTP to suit. Follow these steps:

1. Remove the existing tool post, leaving the T-slot nut.
2. Store the parts you remove together.
3. Remove the stud from the OXA QCTP and add a threaded hole in the bottom as shown here.



4. Install a 10-32 x 1/2" set screw into the threaded hole in the end of the stud.
5. Thread the plate from the bottom of the OXA QCTP onto the stud, with the set screw extending through it. This provides a spacer under the QCTP.
6. Thread the exposed end of the set screw into the T-slot nut.
7. Slide the quick change tool post over the stud and add the nut on top.