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Installing the 0XA Quick Change Tool Post

The 0XA 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 0XA QCTP on the following lathes:

- 7x10, 7x12, 7x14, or 7x16 mini lathe (for these lathes, use P/N 3112)
- Emco Compact 5 PC lathe (P/N 3112)
- Unimat 3 or 4, SIEG C0 lathe (P/N 3112)
- Prazi or Emco lathe (P/N 3112)

Lathes not listed above

If your lathe is not listed above, don't despair. You can still mount the 0XA 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 0XA QCTP
- Modify the stud in the 0XA 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 0XA QCTP
- Modify the T-slot nut from your lathe to suit the 0XA 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.

7x10, 7x12, 7x14, or 7x16 mini lathe

3112 - Quick Change Tool Post Set, 0XA, Horizontal Cut-Off, Mini Lathe

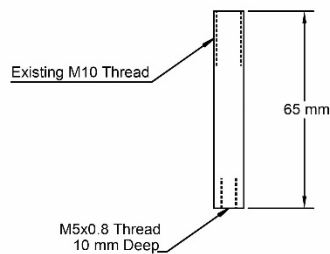Follow these steps to mount the 0XA QCTP on a mini lathe:

1. Remove the stock 4-way tool post and the retaining handle.
2. Remove the stud from the top of the compound rest.
   - You can use a hex (Allen) wrench in the hex socket in the top.
   - You can put two M10 nuts on the stud and jam them together. Then use the lower one to remove the stud.
   - You can grab it in the middle with pliers. Damaged threads there don't matter.
3. Use needle nose pliers to remove the indexing pin and the spring under it from the top of the compound.
4. Store all the parts you have removed together. You do not need them.
5. Take the flat plate off the bottom of the 0XA QCTP. You do not need it.
6. Screw the new stud into the compound rest. You can probably turn it by hand, but use two M10 nuts if necessary.
7. Slide the quick change tool post over the stud and add the nut on top.

Emco Compact 5 PC lathe

3112 - Quick Change Tool Post Set, 0XA, Horizontal Cut-Off, Mini Lathe

On the Emco Compact 5 PC CNC lathe, the tool post mounts to an M5 threaded hole in the cross slide. To mount the 0XA QCTP you must modify the stud that comes with the 0XA QCTP to suit.
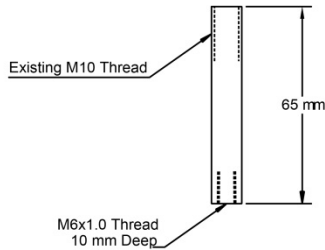
Here is a simple adaptation:

Use an M5 x 20 set screw to mount the stud to the cross slide.

Unimat 3 or 4, SIEG C0 lathe

3112 - Quick Change Tool Post Set, 0XA, Horizontal Cut-Off, Mini Lathe

On these lathes, the tool post mounts to an M6 threaded hole in the cross slide. To mount the 3112 0XA QCTP you must modify the stud that comes with the 0XA QCTP to suit.

Here is a simple adaptation:

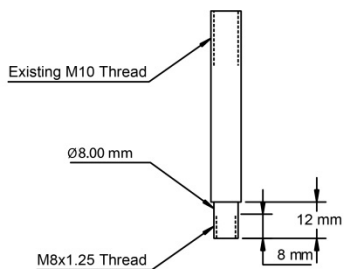Use an M6 x 20 set screw to mount the stud to the compound rest or cross slide.

Prazi or Emco lathe

3112 - Quick Change Tool Post Set, 0XA, Horizontal Cut-Off, Mini Lathe

This tool post will mount on Prazi SD300 and SD400 lathes, many Emco lathes, and other lathes that secure the tool post with an M8 bolt. On the SD300 you can only use tools with up to 5/16" shank. It the Proxxon PD400 with a 1/4" (6 mm) spacer under the tool post.

On these lathes, the tool post mounts to an M8 threaded hole in the cross slide. To mount the 3112 0XA QCTP you must modify the stud that comes with the 0XA QCTP to suit.

Here is a simple adaptation:

Use this stud to mount the 0XA QCTP to the compound or cross slide. If there are two tool post mounting holes, choose one of them to mount the 0XA QCTP.