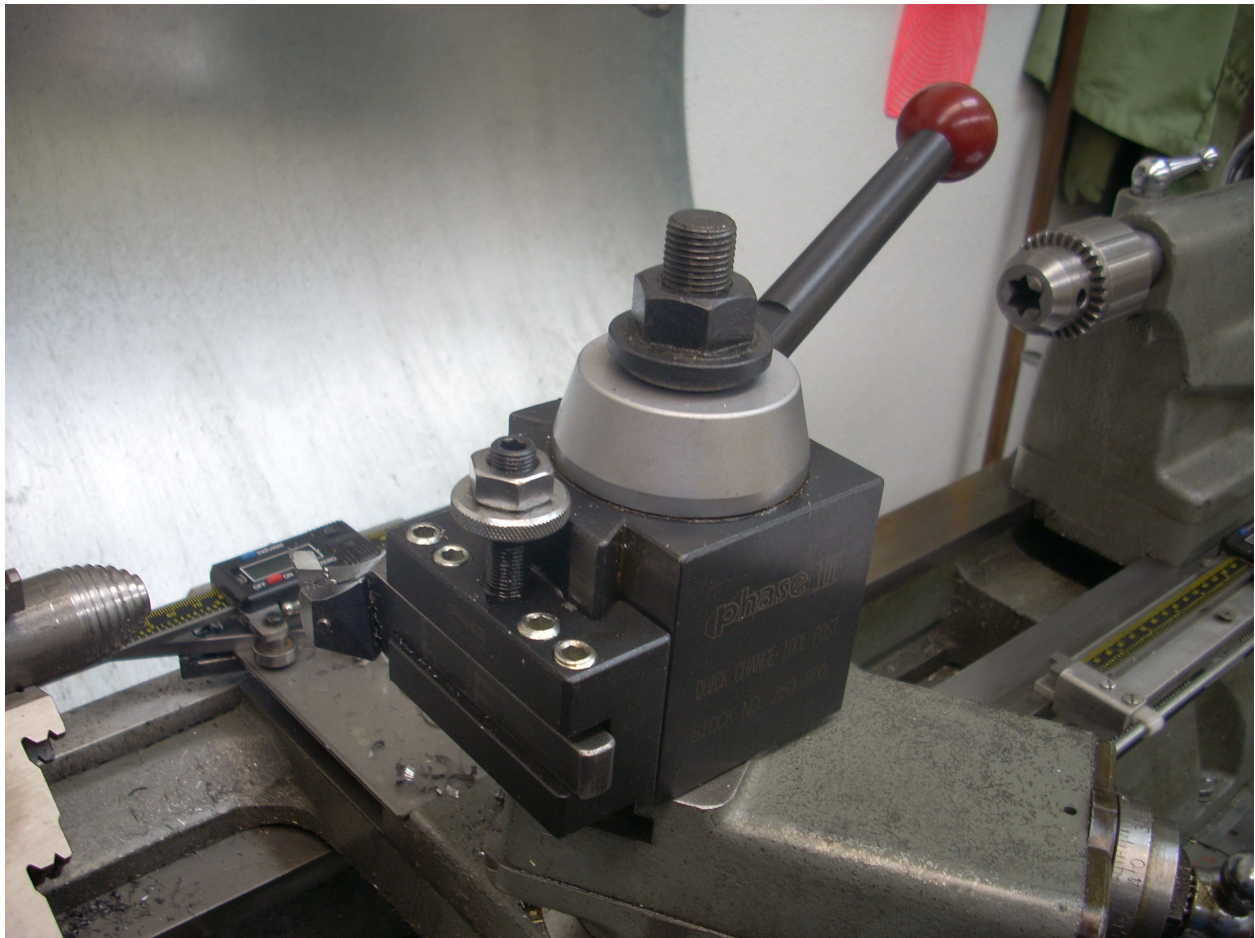


Phase II BXA Quick Change Tool Post on an Atlas Craftsman 12" Lathe

By R.G. Sparber

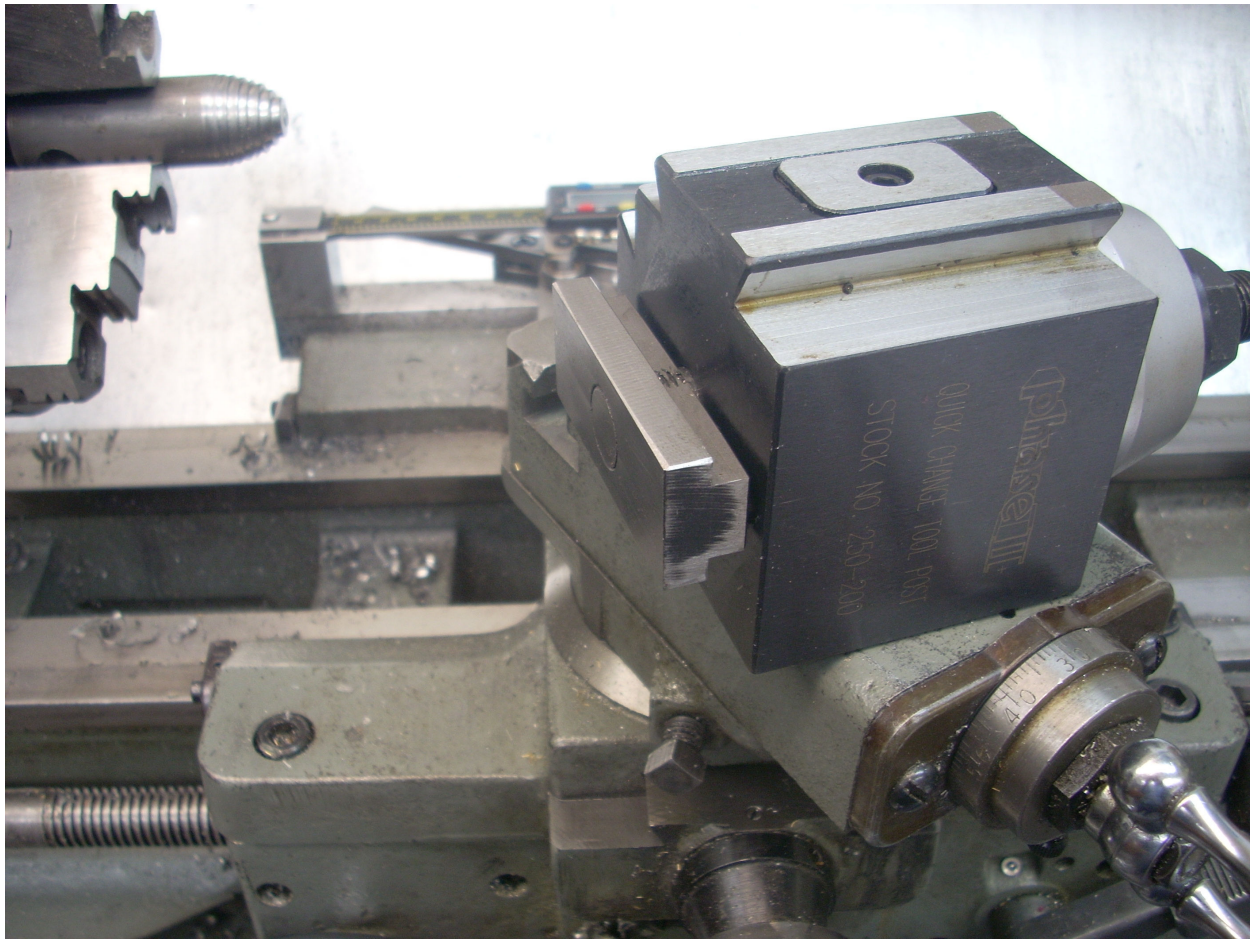
January 3, 2010

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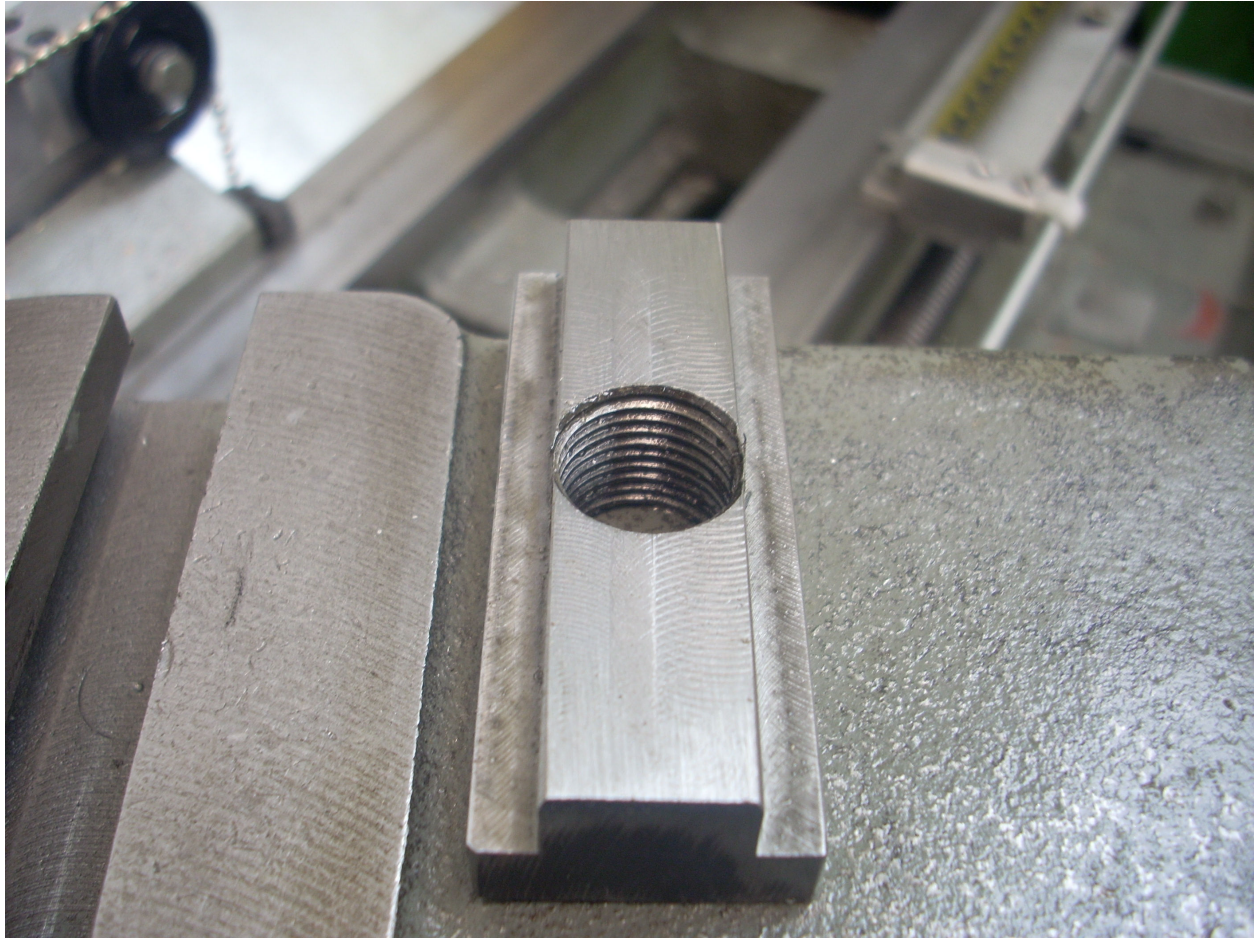


Here is my Quick Change Tool Post (QCTP) installed on the compound of my Atlas Craftsman 12" x 24" lathe.

¹ You are free to copy this document but please do not change it.



The T nut is a close fit to the T slot of the compound. It was cut down from the plate supplied with the tool post. I used my RF-30 mill/drill to do the machining.



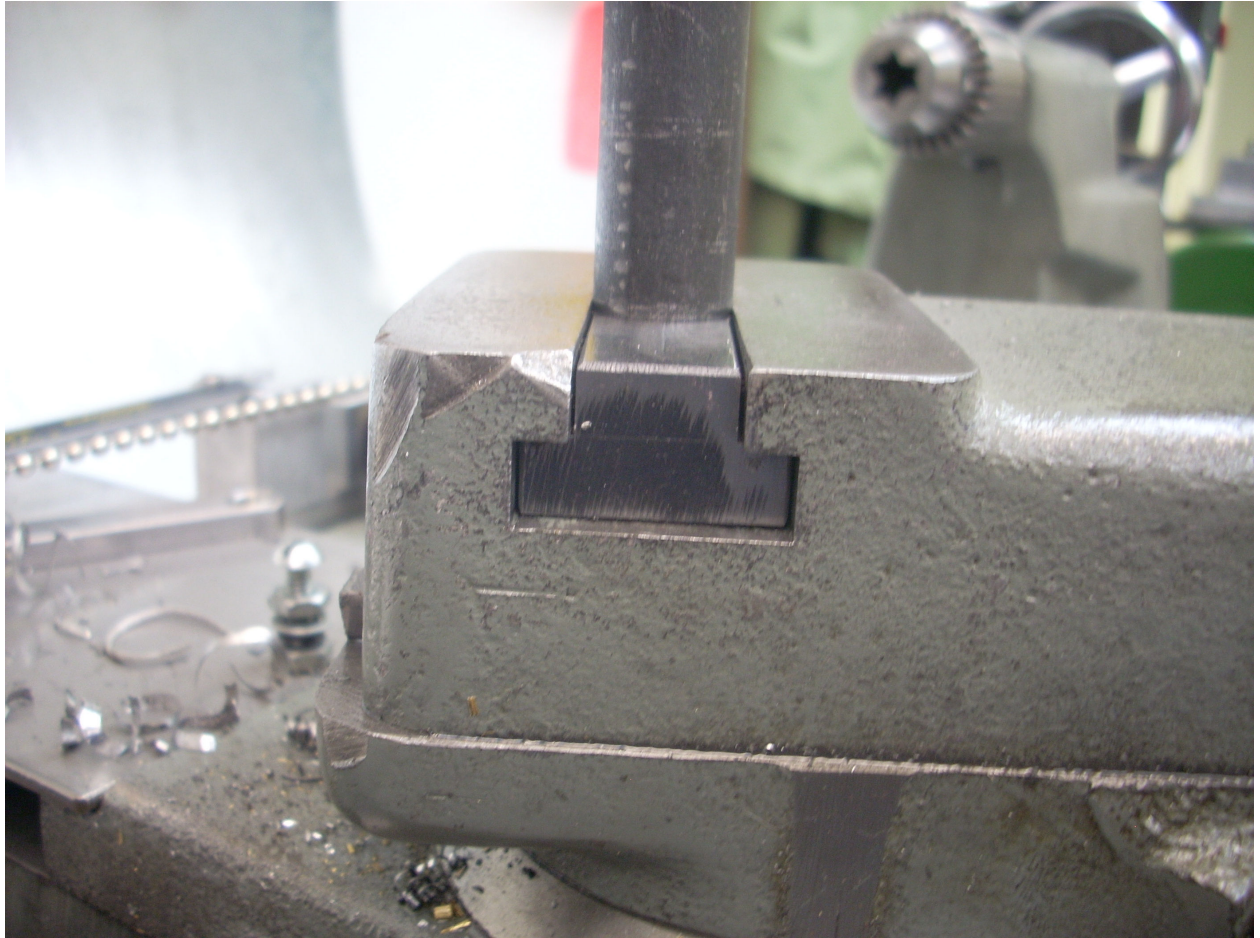
The T slot's top opening is about 0.01" wider than the bolt that threads into the T nut. It is essential that the T nut be machined such that it is centered on the threaded hole. The threads of the hole just barely cut through the side walls of the hole on the narrow part of the T nut. There is plenty of metal left for a secure mount.



You can see that the bolt threads all the way to the bottom of the T nut.



It is a close sliding fit.



The bottom of the T nut is roughly 0.01" narrower than the bottom of the T slot and there is a very small gap between the bottom of the T nut and the bottom of the T slot.



The QCTP sits squarely on the compound.

Rick Sparber