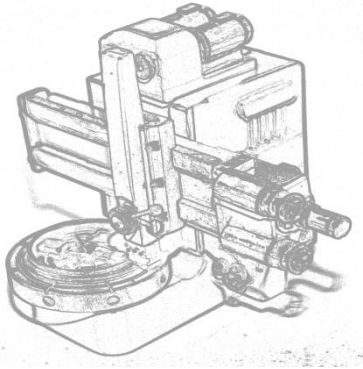


## Single Post Vertical Lathe

Kit number HO/V1PL/m



### Assembly Instructions

There are 9 parts that need to be assembled to make this machine. The colour of choice is at your discretion. We recommend acrylic paints, as this allows for added detailing with enamel paints afterwards. This model can be permanently glued with superglue, or it can be assembled to be animated in different static displays.

1. **Drilling** of all holes and spacers supplied for attachment of wheels and feed shafts to be done according to instruction manual on this. **N.B.** This needs to be done before any actual assembly and any main colour painting begins.
2. **Cleaning and preparing** –once the holes have been drilled and spacers added for the attaching of the wheels, the machines can be cleaned and surfaces filled (if necessary) and prepared for painting.

3. **Assembly** - Remember that the styrene rods and spacers need to have been prepared and in place prior to assembly. Main colour painting needs to have been done.
4. Main body detailing (all in colour of choice) – levers, gauges, electrical box, conduits, handles, hinges, cover plates, bed ways, bolts, shafts sticking out of 2 bearing housings, electrical motors, access doorway on rear of machine.  
Main bridge slide (3 parts) detailing – mounting bolts along the top and down one side.  
Main bridge detailing – end cover plate, bolts, bearing housings and lead screw shafts, electrical box on gearbox motor at the rear and the DC motor on the right hand side sitting horizontal to the 2 gearbox motors.  
Main quill housing detailing – bolts and the inner bed way  
Quill detailing – tool post at bottom of quill, bolts and fine feed shaft.  
Chuck – painted in a steel colour along with jaws to hold job in place on chuck, lead screw holes highlighted  
All fine feed and adjustment brass-etched wheels – painted in red generally (suggestion only)  
These can now be glued in place before final assembly takes place.

Excess shafts sticking out of the end of the brass-etched wheels can be nipped off and touched up with colour of choice.

5. You are now ready to assemble the machine with either Prestik or superglue depending on your layout/choice as mentioned before.  
**Assembly**
6. Attach the main bridge slide (2) to the main body (1) with bolts running horizontally across the top and 3 bolts running vertically to the left of the main body.
7. Assemble the main bridge (3) with all the mechanisms to the right hand side of the machine.
8. Attach the main quill slide/ housing (4) to the quill. (5)
9. Attach the tool bit holder (6) at the bottom of the quill (5) along with the fine feed adjustment shaft sticking out approximately 5-10 mmm.
10. On the end of the fine feed shaft you will attach a spacer as provided in the kit. This being your handle.
11. Place chuck (7) in main body (1). A wheel (8) is supplied with 4 jaws (9) and a lining up tool (10). This fits in the centre of the chuck allowing you to attach any job to the bed way on the chuck. (Actual size of wheel in chuck – outside diameter 5ft 6”ins or 66”ins or 1.67m, width – 9.5 “ ins 240mm)
12. Your model is now fully assembled.

13. Suggested paints – Humbrol Metal cote colours (Polished Steel no. 27003 or Gunmetal no 27004)) especially for the bed ways and chuck. These two colours are exact simulations of steel, one being hardened steel and the other normal free-machining steel. This needs to be polished with a soft cloth after drying and will look like the real thing once dried and polished. I recommend that you try this on scrap styrene card stock first and then polish to suit. You will see what I mean!

**Parts list**

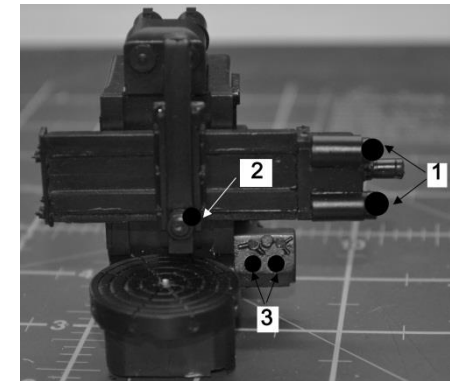
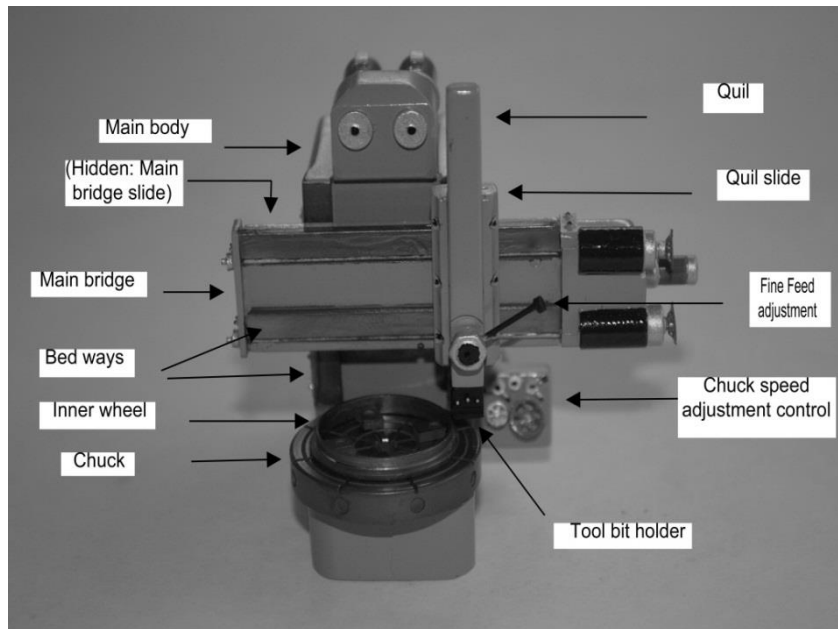
Item	Description	Quantity
1.	Main body	1
2.	Main bridge slide	1
3.	Main bridge	1
4.	Quill slide	1
5.	Quill	1
6.	Tool bit holder	1
7.	Chuck	1
8.	Locomotive inner main wheel being machined	1
9.	4 jaws/1 lining up tool	4 + 1
10.	2.2mm x 1mm thick shaft spacers	7
11.	Brass-etched wheels	1 x 3.4mm 3 x 5.4mm
12.	Styrene rod 210 .030"/0.75mm) x 30 mm long	2 lengths

Parts not included, but available to be purchased separately will be the brass-etched access walkways.

When ordering replacement parts, please specify the kit number, item number and description.

Suggestion - EZ line (Berkshire Junction – [www.berkshirejunction.com](http://www.berkshirejunction.com)) can be used and purchased to super detail the electrical supply cables to the various motors on the machines.

**Picture showing parts of the Single Post Vertical Lathe/Boring Mill**



Pictures showing positioning of adjustment wheels/ Brass-etched wheels