



Model 6936 Cross Feed Extension

Installation Instructions with Parts Identification

AMMCO, Inc. • Hennessy Industries • 1601 J.P. Hennessy Drive, LaVergne, TN 37086-3565
(800) 688-6359 • (615) 641-7533 • (615) 641-5104 FAX • www.ammcoats.com

The Cross Feed Extension is used to increase the capacity of the twin cutter to machine large diameter brake discs on the standard Model 4000 and 4100 Brake Lathes.

The placement of the twin cutter on the Cross Feed Extension is determined by the diameter of the rotor to be machined: Use hole A to increase the rotor diameter by 2 1/4", hole B to increase by 4 1/4" and hole C to increase by 5 1/2".

Mounting Instructions

Referring to the illustration, remove the cross feed locking stud and clean all surfaces of chips. Mount the Cross Feed Extension plate directly on the cross feed with Part # 925271 1/2" x 2" Hex Socket Flat Head Screw — for cross feeds *with* a recess. Use Part # 925270 1/2" x 1" Hex Socket Flat Head Screw — for cross feeds *without* a recess.

Insert the # 911222 locking stud (with the # 911227 nut and washer assembly) through the twin cutter and into hole A, B, or C of the cross feed extension plate. Hand tighten the new stud using the knurled head. Turn the nut and washer assembly down with a wrench to lock the twin cutter in place.

DO NOT discard the cross feed clamp stud or the clamp nut and washers. They will be used again to remount the boring bar clamp and the twin cutter in the standard position.

