

HEGNER

Instruction for Assembly & Operation of

DUPLICATING ATTACHMENT LKH 950

Alignment of Cutter

Cutter is factory aligned. If cutter has moved, align cutter by using supplied gauge (part 6) as shown in diagram. Secure cutter by tightening hex screws.

Duplicating from a Turning

Place the turning you wish to duplicate between the two centers at the rear of the duplicator (you may have to reposition one center to accommodate the length of the piece you are duplicating). Mount the blank. Position roller (part 12) of duplicator so that it rests at the **s m a l l e s t** diameter of the piece to be copied. Turn wheel (part 9) counterclockwise until cutter (part 8) is retracted far enough from blank so that blank can turn freely. Turn on lathe and lower cutter by turning wheel (part 9) clockwise until cutter starts to cut into blank. Begin to turn wheel (part 9) 1/2 to 2 turns at a time, each time moving duplicating cutter along entire length of turning by means of large spoked wheel at the front of the lathe, until you reach the desired diameter in the workpiece. If you need to turn more than one duplicate of the same size, turn lathe off and set the duplicator depth gauge (part 10) so that it touches part 11. Lock depth adjustment into position by tightening nut (part No. 15). The duplicator is now adjusted properly to duplicate additional blanks to identical diameters.

Duplicating from a Template

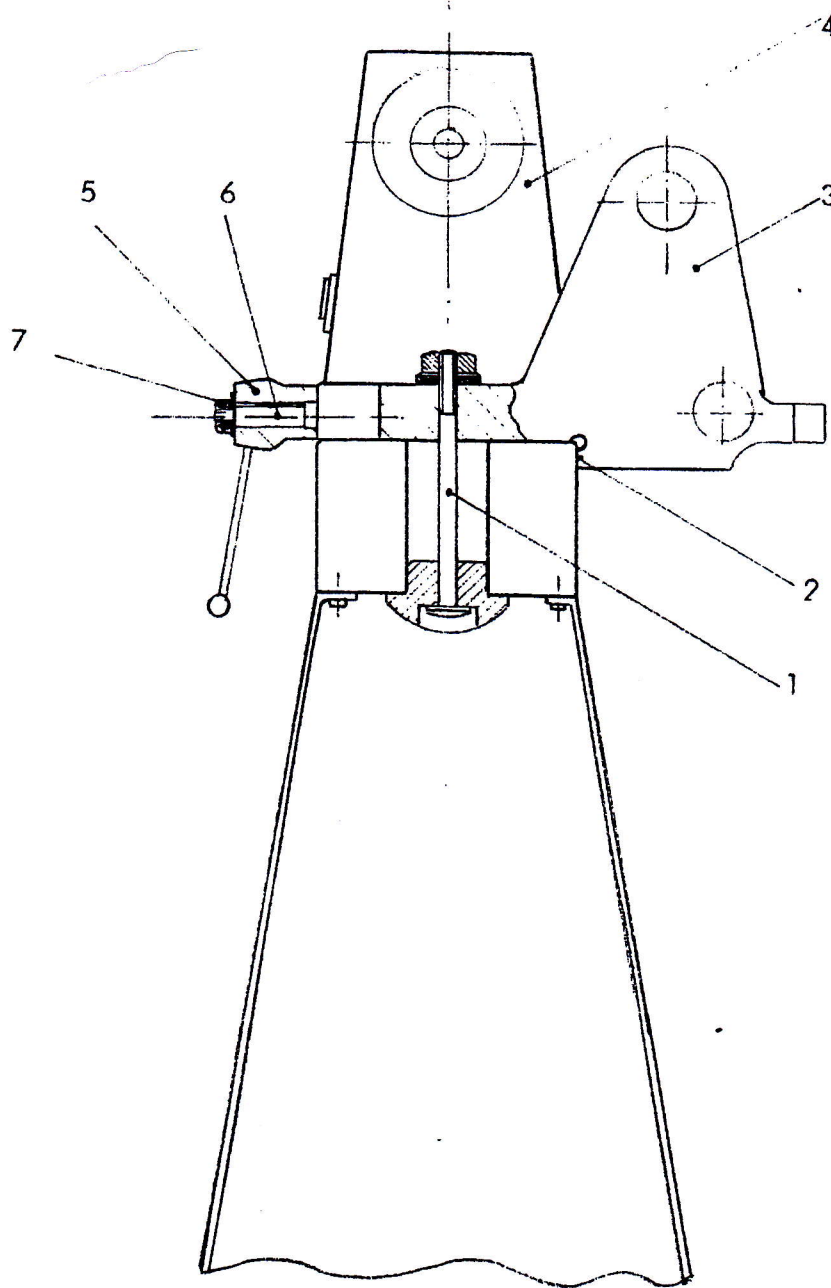
Remove centers for holding turnings on duplicator and mount template holders instead. See diagram for maximum and minimum dimensions allowed for template. Fasten template in template holders by tightening screws. (NOTE: Template holders accept templates up to a maximum thickness of 3/16".) Proceed to adjust duplicator as described under "Duplicating from a Turning".

Sharpening of Cutter

IMPORTANT: Angle of cutter must not be altered. Sharpen cutter when required, but only from the INNER surface, taking care not to alter the angle of the cutter.

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Mounting of Duplicating Attachment LKH 950



Mount duplicating attachment by positioning unit at rear of lathe and fasten to lathe bed with two bolts (No. 1) supplied. Make sure surfaces (No. 2) rest against lathe bed and surface (No. 3) rests against head stock (No. 4).

Remove nut (No. 7) from shaft (No. 6) at left front of duplicator. Slide spoked wheel onto shaft (No. 5) and secure by replacing nut (No.7).

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