

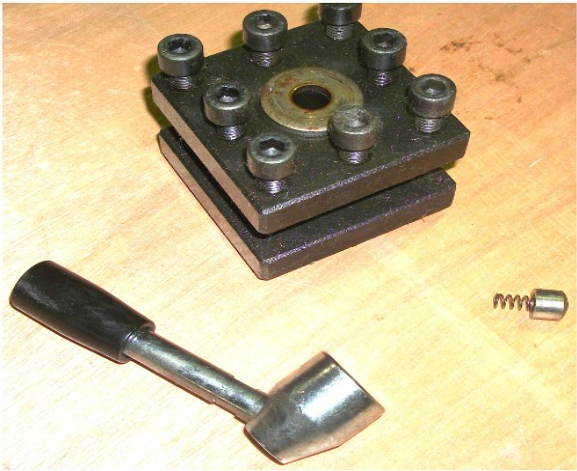


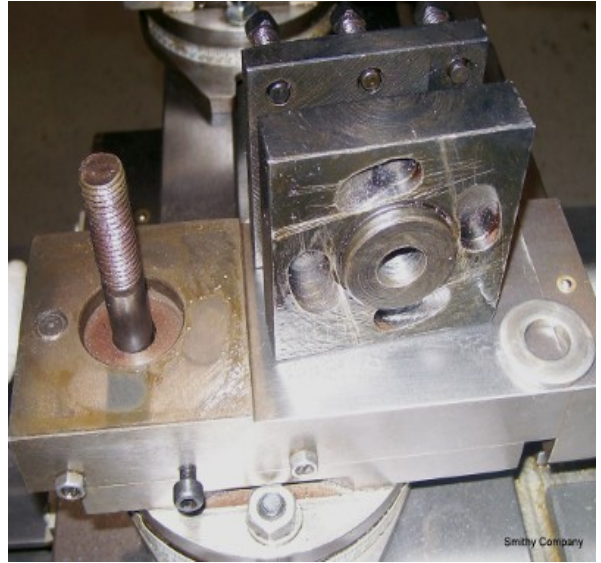
# INSTALLING THE QUICK CHANGE TOOL POST ON THE GRANITE AND MIDAS 3 IN 1 MACHINES

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**DESCRIPTION:** This document is for the installation of the Quick Change Tool Posts on Smith 3 in 1 machines. It is made to replace the turret on the standard compound tool posts supplied with Smithy machines. The 45-271 is for the Granite 1300 series machines. It uses a 45-269 Chicago Bolt. The 45-270 is for the Midas 1200 series machines. It uses a 45-268 Chicago Bolt. Both of these install in exactly the same way. I will be referring to the quick change tool post as the QCTP.

<u>STEP</u>	<u>DESCRIPTION</u>	<u>PICTURES</u>
1	<p>The QCTP comes with a large “T” type stud and nut. This stud and nut will not be used in this installation. You will use the Chicago Bolt supplied with the QCTP.</p> 	
2	<p>Remove the existing locking handle, turret and stop plunger with spring. These items will not be reused.</p>	

3 There are two types of studs you will find that hold the turret on. The early Granite machines and all Midas machines have a turret that protrudes down into the top of the compound slide as shown to the right. If you have this style of tool post, we recommend making a filler washer to fit into the void on the compound slide and give the new QCTP a more solid mounting. This can be made from any available material such as steel, brass, or aluminum.



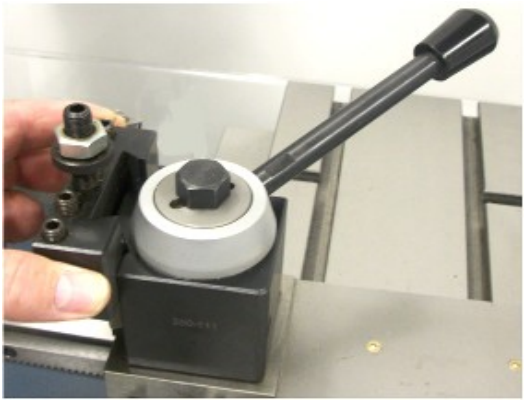
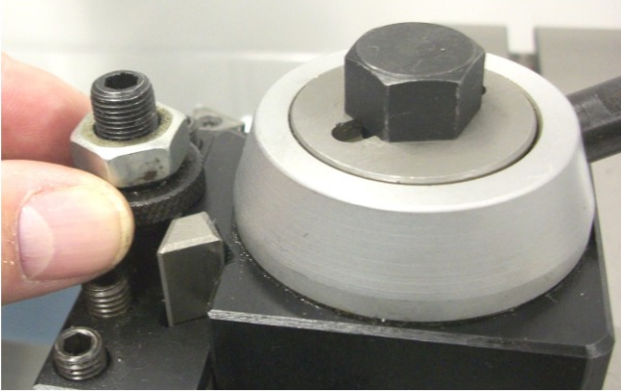
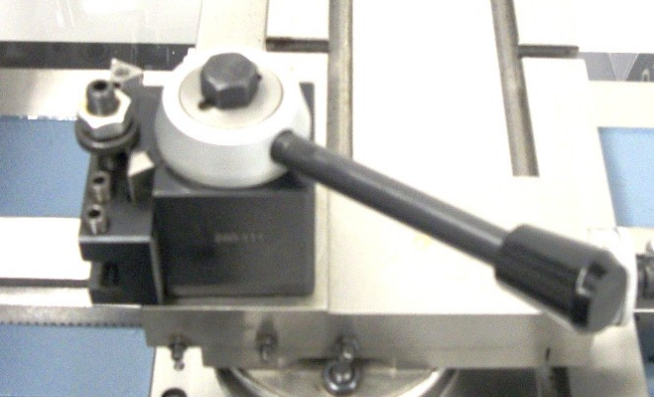
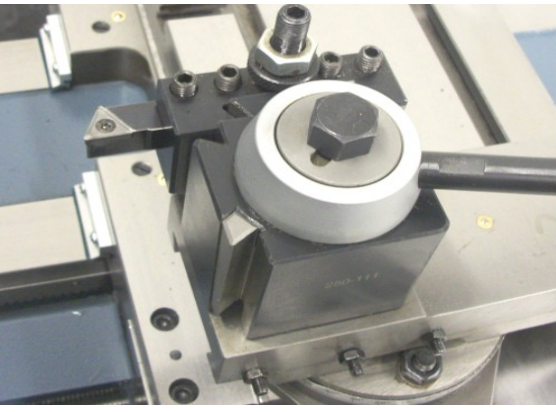
4 Later Granite machines have a stud with a removable sleeve. Lift the sleeve off the stud. It will not be used.



5 The last step in the installation is to place the QCTP over the stud and use the Chicago Bolt to secure it into place.





6	<p>Rotate the handle counter clockwise and drop the selected tool holder and tool onto the QCTP.</p>	
7	<p>Use the knurled wheel to set the desired tool height with the workpiece. Then lock the hex nut down on top of the knurled wheel to lock it into place. This will allow the removal and installation of the tool and holder without the need to readjust tool height.</p>	
8	<p>Rotate the handle clockwise to lock the holder into the QCTP.</p>	
8	<p>Holder can also be installed parallel to the machine bed as shown.</p>	

End