



LATHE-TYPE UNDERCUTTER INSTRUCTIONS

GENERAL:

Mount the armature between the lathe centers with the commutator toward the tailstock.

The undercutter can be used in two ways, either mounted directly to the cross-slide of the lathe or with the optional slide carriage.

If the unit is to be used without the slide carriage, remove the tool post from the lathe and mount the undercutter in its place using the 1/2" bolt and the tapped clamping plate in the "T" slot. If necessary, cut the block to fit your particular lathe. Adjust the undercutter on the vertical post to line up with the lathe centers.

If the undercutter is to be used with the slide carriage, mount the slide carriage loose on top of the cross-slide, in place of the tool post. Align the carriage slide rod parallel with the commutator to assure a uniform cutting depth. Tighten the carriage in position. Bolt the undercutter onto the carriage and adjust the height to line the saw up with the lathe centers.

Line up the saw with a mica strip at the front of the commutator and turn the lathe traverse feed while watching to assure the saw follows the mica strip. Make any upward or downward skew adjustment with the knob on the carriage at the tailstock end. Secure the skew adjustment with the lock-bolt on the underside of the carriage.

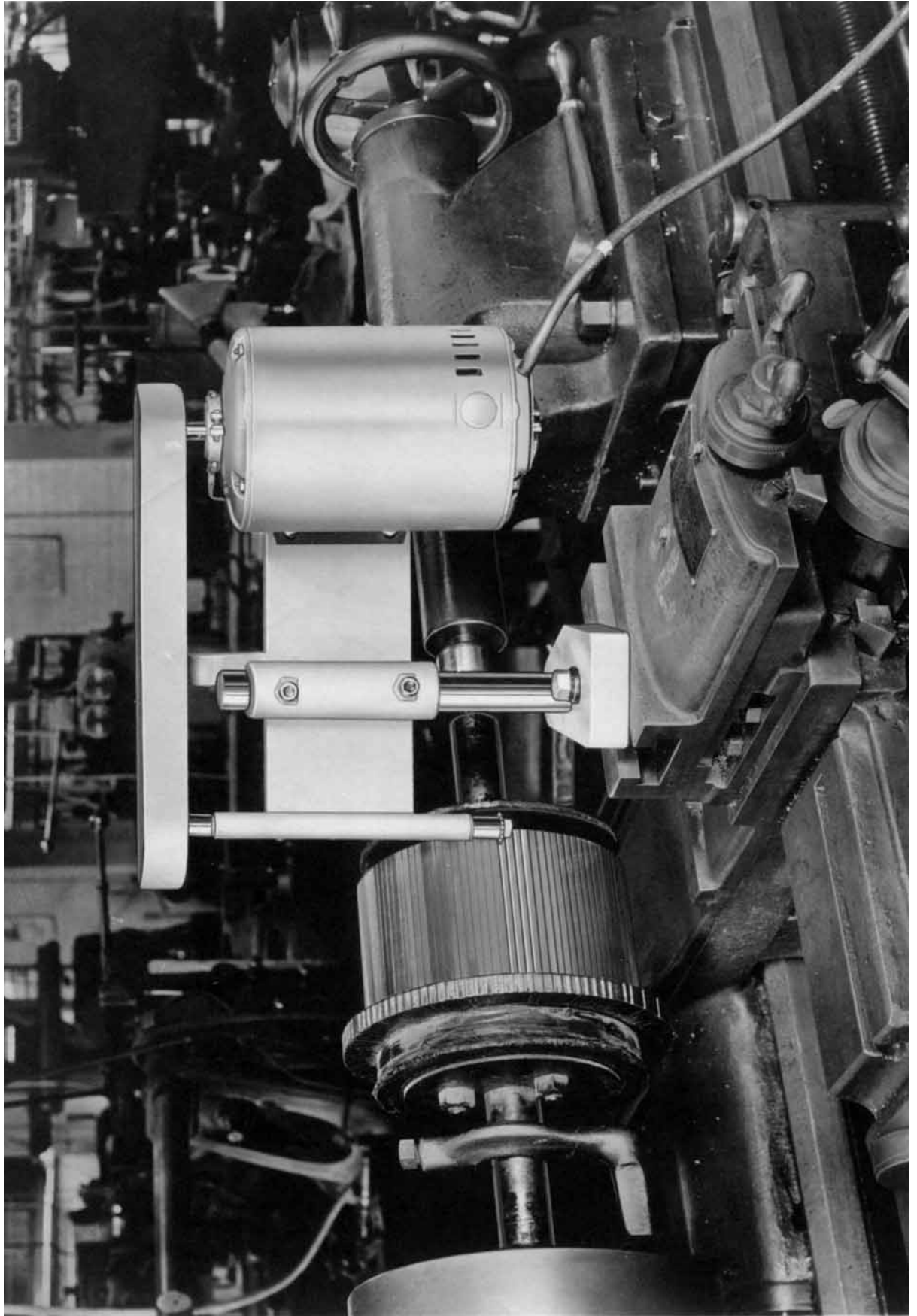
Two spindles are furnished with the undercutter and both are left hand thread. The saw spindle rotates counter-clockwise when looking down at it. When changing spindles use the large (2-1/2") pulley on the 5/16" spindle or the small (1-3/4") pulley on the 3/16" spindle.

Start cutting from the right end of the commutator, the full intended depth of cut, up to the riser, and back out again.

The undercutter is set up with a spring between two hardened washers under the spindle pulley which allows the spindle to move ("float") up or down and follow an existing slot that is being recut. When the mica is flush with the copper we recommend that the spring be removed and the pulley be used to hold the spindle in place with .002" to .003" end play. Adjust the motor pulley also to keep the two pulleys aligned and the belt straight.

The spindle bushings are oil impregnated but may require a few drops of light oil occasionally.

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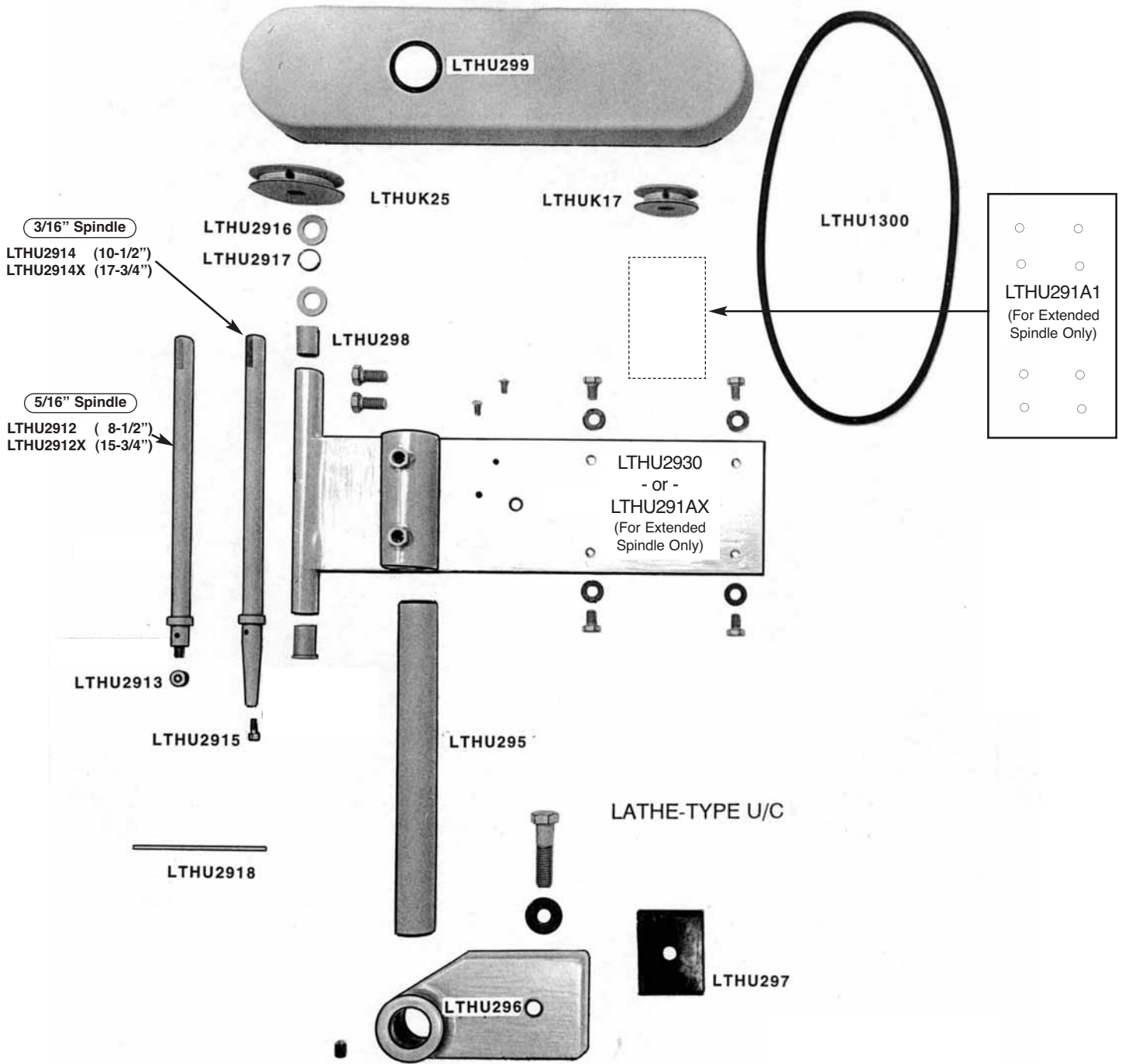


Lathe-Type Undercutter

Parts

Quantity	Description	Part No.
	<u>Undercutter</u>	
1	Motor Mounting Plate Assembly	LTHU2930
1 *	Motor Mounting Plate (For Extended Spindle Only)	LTHU291AX
1 *	Plate, Extension, Aluminum (For Extended Spindle Only)	LTHU291A1
1	Post	LTHU295
1	Base	LTHU296
1	Clamp Plate	LTHU297
1	Spindle Bushing Set	LTHU298
1	Belt Guard (Including Bracket)	LTHU299
1	5/16" Saw Spindle (8-1/2")	LTHU2912
1 *	5/16" Saw Spindle (15-3/4")	LTHU2912X
1	5/16" Saw Retaining Nut -L.H. Thread	LTHU2913
1	3/16" Saw Spindle (10-1/2")	LTHU2914
1 *	3/16" Saw Spindle (17-3/4")	LTHU2914X
1	3/16" Saw Retaining Screw	LTHU2915
2	Hardened Washer	LTHU2916
1	Spring	LTHU2917
1	Motor Pulley, 1-3/4" x 1/2"	LTHUK17
1	Spindle Pulley, 2-1/2" x 1/2"	LTHUK25
1	Motor, 1/3 H.P., 3,450 RPM	LTHUH2C11
1	V-Belt	LTHU1300
1	Screw, 1/2"-13 x 2", Hex Head, Cap	
1	Pin, 1/8" x 4"	LTHU2918
*	(For Extended Spindle Model)	
	<u>Slide Carriage</u>	
1	Plate, Bottom (20.125")	LTHU2950
1 *	Plate, Bottom (26")	LTHU2950L
1 *	Plate, Bottom (31")	LTHU2950L31
2	Slide Rod (18 x 3/4")	LTHU2952
2 *	Slide Rod (22 x 1")	LTHU2952L
2 *	Slide Rod (27 x 1")	LTHU2952L27
1	Slide Plate	LTHU2954A
2	Slide Guide	LTHU2955
1	Slide Adjusting Screw	LTHU2956
1	Lever, Slide, Short (For 20.125" Base)	LTHU29571
1 *	Lever, Slide, Short (For 26" & 31" Base)	LTHU29571L
1	Lever, Slide, Long (For 20.125" Base)	LTHU29572
1 *	Lever, Slide, Long (For 26" & 31" Base)	LTHU29572L
1	Pivot End Angle	LTHU29511
1	Adjusting End Angle	LTHU29512
1	Pivot Collar	LTHU29260
4	Bushing	LTHUAA885
1	Knob	LTHU21108
2	Shaft Collar	LTHU2X570
1	Bolt, 1/2" x 1-1/2", Hex Head	
*	(For Extended Carriage Model)	

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Lathe-Type Undercutter Slide Carriage

