

Model 111 QCTP Upgrade Kit for SIEG SC4 - Fitting Instructions

The Model 111 wedge type tool post is an ideal size for SIEG SC4 and C4 lathes but the standard SC4 tool post stud is too small for the tool post and the standard tool holder places most reasonable sized tools above spindle centre height. To get around these issues, we have introduced a new tool holder and tool post stud.

The Model 100/111 Tool Post Stud is threaded M14x1.5 at the top with a $\varnothing 14$ mm shank to match the tool post bore and is threaded M12 at the bottom for the SC4 lathe's compound slide. Because M14x1.5 wide flange nuts are hard to find, one is supplied with the stud.

The Model 100 'Slim' Tool Holder offers a lower tool height compared to the Standard tool holder easily allowing 10mm turning tools to be used.

Note: The Model 100 piston type tool post can also be used in the same way on the SC4 lathe.

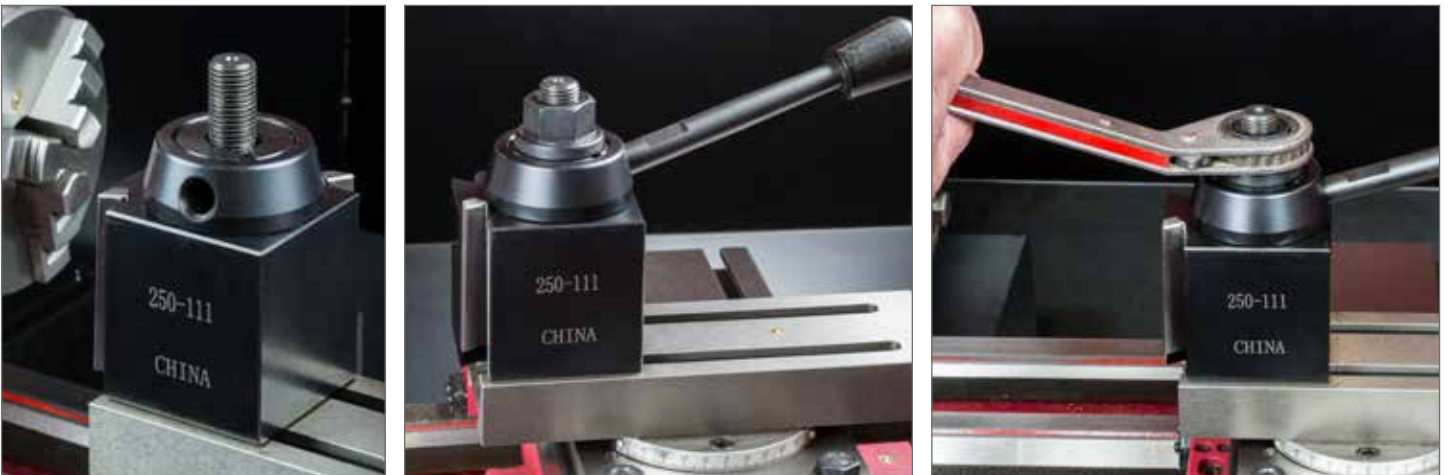


1. Remove the existing tool post and tool post stud from the compound slide.



2. Screw the new tool post stud into the compound slide and tighten with a spanner.

3. Place the new tool post on the stud.



4. Position the tool post where required, add the operating handle and flange nut and tighten with a spanner.

A few examples of turning, boring and parting tools that can be used on the SC4 lathe when using the 090-070-00407 Model 100 Slim Tool Holder:



060-320-31001 10mm HSS-Co5 Right Hand Knife Turning Tool



060-325-11010 SCLC-R 10x10mm Turning Tool Holder



060-325-39510 S10K-SCLC-R 10mm Dia. Boring Tool Holder



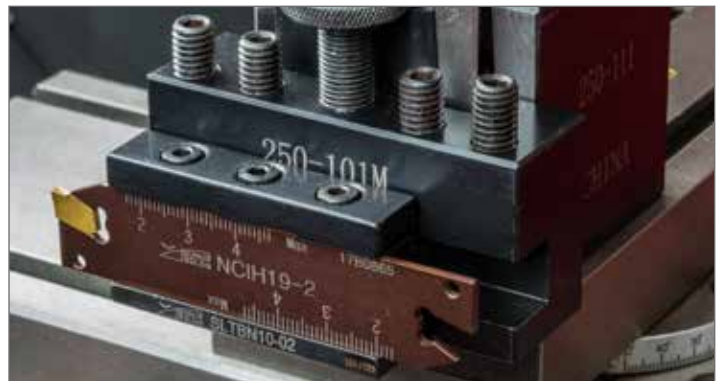
060-325-39512 S12M-SCLC-R 12mm Dia. Boring Tool Holder



060-320-15008 8mm HSS 6pc Internal Threading & Boring Set (8mm because the square holder is 11x11mm)



060-320-01010 Parting Block -10mm shank with M42 HSS-Co8 Blade



060-325-22210 Part Off Blade Holder 10mm Shank + Blade & GTN2



060-325-21002 10x10mm R/H Grooving & Part Off Tool Holder with GTN2



060-325-23010 10x10mm R/H Grooving & Part Off Tool Holder with MGMN200