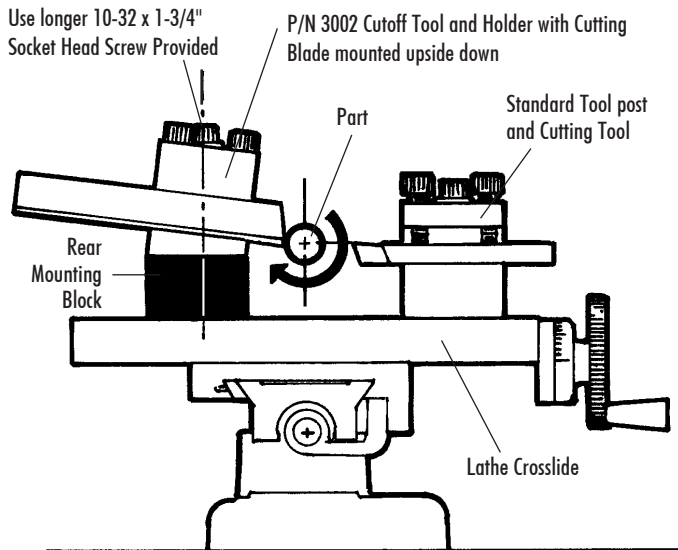


## Rear Mounting Block

(For P/N 3002 Cutoff Tool and Holder)

**P/N 3016**



*FIGURE 1—(Looking from headstock toward tailstock. Arrow shows direction of part rotation.) The rear mounting block is shown in position under the cutoff tool holder and mounted to the “back” side of crossslide table. The cutoff tool holder can now be left mounted to the table, ready for a parting operation at any time. There is no need to remove the standard tool post in order to “part off” the work.*

**NOTE: Use Plenty of Cutting Fluid when Using the Cutoff Tool for Parting Operations**

See P/N 3002 cutoff tool instructions for more details on use and sharpening of the tool.

### Purpose of the Rear Mounting Block

The rear mounting block is a simple spacer block that allows you to mount the cutoff tool and holder to the table on the back side of the part. Because the part is rotating “up” on the back side, the tool must be flipped over in the holder. The mounting block raises the tool holder the amount needed to put the tip of the tool back at the right cutting height. This will save you time by being able to leave the cutoff tool holder mounted to the table while you use the regular tool post in its normal position on the front side of the part.

### Instructions for Use

The mounting block is placed between the standard cutoff tool holder (P/N 3002) and the lathe crossslide. It is mounted on the back side of the part, or the side away from the crossslide handwheel. The longer 10-32 x 1-3/4" socket head screw provided with the rear mounting block is used to attach the unit to the crossslide table. (Use the T-nut that came with the cutoff tool holder.) Note that the hole in the mounting block is not in the center. Rotate the block to find the position where the sides line up with the sides of the cutoff tool holder.

Loosen the two clamping screws which hold the cutoff tool blade in place. Turn the blade over so the cutting tip is facing down and mount it as shown in Figure 1. Adjust the tip of the tool to the desired height by sliding it back and forth in its slot. Lock it in position with the two clamping screws.

Refer to the instructions that come with the P/N 3002 cutoff tool for use. Even though the tool is upside down, all the same rules about its use still apply. The only difference is that the crossslide table is now cranked toward the operator to cut off a part.

Thank you,  
Sherline Products Inc.