



CBN Lathe Sharpening System Set-up Procedure

Instructions – Set up:

1. Place the CBN mandrel on to the spindle
2. Place the *CBN Lathe Sharpening System* onto the lathe bed by firstly turning the folded T- piece side on
3. Rotate the folded T- piece and hold it in position
4. Tighten the black star knob until almost tight
5. Slide the *CBN Lathe Sharpening System* so that it is centred underneath the CBN wheel
6. Using a square with mm measurements place square on top of platform and measure 150mm to spindle centre line (see photos 1 & 2)



1



2

7. Firmly tighten the M10 nut with a 16mm spanner once correct height is achieved (this height will vary according to the lathe model and spindle centre to bed measurement)
8. Once you have set this height you should not need to change it again unless moving to a different lathe
9. You can now fasten the Sharpening Jig or Grinding Rest base on top of the platform using 2x 8mm spanners (see photo 3)
10. Place the CBN wheel over the mandrel
11. Place on the CBN washer
12. Screw together with M12 bolt and spring washer
13. Tighten M12 bolt firmly using a 18mm spanner (see photo 4)
14. Slide and position the *CBN Lathe Sharpening System* by eye so that it is centrally under the CBN wheel
15. Pull the *CBN Lathe Sharpening System* towards you and tighten the black star knob completely
16. You can now set up the Vicmarc Sharpening Jig or Grinding Rest as per the manual to achieve your desired grinds



3

Instructions – To Remove:

1. Undo the black star knob a few turns
2. Slide the *CBN Lathe Sharpening System* away from the headstock
3. Undo the black star knob so that the folded T- piece can be turned so that the attachment can be lifted off the lathe bed
4. Remove the CBN wheel from the spindle (this should be kept assembled as a whole unit including CBN wheel, CBN bush, CBN washer and bolt)



4