General Arrangement of Toolpost
Attached to top slide using original clamp nut
Toolpost Block
Mild Steel or Continuous Cast Iron

Break all corners at 45 degrees

Locate screw hole after trial assembly for best handle position

Cam, Mild Steel

Figure 2

Figure 4
**Figure 3**

Toolpost Clamp Pillar

Medium carbon steel

**Figure 5**

Piston, Brass

2 off

**Figure 6**

Handle, Mild Steel

*adjust length of thread to avoid interference with toolpost clamp nut

10.00 mm

0.127 *

0 3/4

0.00 mm

0.58

0 1/2

1.125 inches

*Make overlength and adjust to get optimum clamp position
Standard Toolholder, Mild Steel

* Adjust dovetail to match toolpost
dovetail detail same for all styles of holder

Figure 7
Parting Toolholder Body, Mild Steel
Other details as standard toolholder

Parting Toolholder Clamp
Mild Steel

Boring Toolholder, Mild Steel
*ream bore as required to suit other tools
Other details as standard toolholder

DTI Holder, Aluminium Alloy
*or bore to suit DTI
Concept for a Quick Change Tangential Toolholder

Figure 12