#6294721, TAILSTOCK SWING AWAY

WARNING – To reduce the risk of serious injury:

- Read and understand all instructions and warnings in lathe manual and Swing Away instructions before operating.
- Replace warning labels if they become obscured or removed.
- Always wear eye protection.
- Tighten knob on Swing Away before using lathe. Knob must remain tightened while Swing Away is in upright position.
- Securely tighten tailstock clamp handle before moving Swing Away.
- Do not allow Swing Away to swing freely; maintain firm grasp on Swing Away throughout movement.
- Keep fingers away from pivot pin area while moving Swing Away.
- Never release tailstock clamp handle unless Swing Away is in upright position with knob tightened.
- Failure to comply with the above warnings may result in serious or even fatal injury, or damage to machine.

NOTE: This accessory is intended only for use with Powermatic models 3520, 3520A, 3520B, PM2020 Lathes.

Contents of container:

1 Swing Away
2 Socket head cap screws, 3/8 x 1-1/4 in.
2 Lock washers, 3/8 in.
4 Flat washers, 3/8 in.
2 Hex nuts, 3/8 in.
1 Instruction sheet

Assembly

Refer to parts breakdown for any assembly clarification. Numbers in parentheses refer to index numbers in parts list.

1. Make sure threaded holes in end of lathe bed are clean.
2. Confirm proper clearance around lathe for Swing Away function.
3. Remove stop bolt from lathe bed and store for future use. (**NOTE:** Always reinstall stop bolt when tailstock is on lathe bed and Swing Away is not engaged.)
4. Mount Swing Away to lathe bed with provided screws and washers (#9/10/11, Figure 1). Do not tighten yet.

   (* For model 3520 Lathes, see special instructions.)
5. Align top surface of Swing Away with lathe bed ways. (Use a straight edge to check.) Loosen knob and open Swing Away; turn set screws (#13) as needed to help achieve parallelism.
6. When properly aligned, **firmly tighten** screws (#9), and close Swing Away. Tighten knob. (Knob is under spring pressure – push in while rotating.)
7. Slide tailstock onto Swing Away, and check for smooth transition of tailstock across joint. Make further adjustments as needed until tailstock transitions smoothly. When done, make sure screws (#9) are securely tightened.

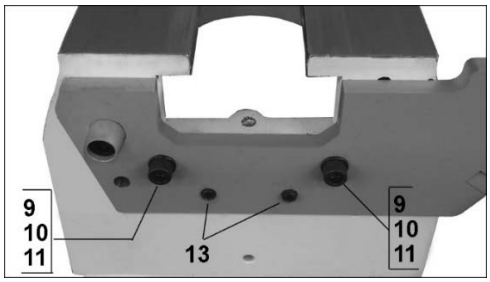


Figure 1

* For model 3520 Lathes:

Two additional flat washers (#11) and hex nuts (#17) are provided for securing Swing Away to model 3520 Lathe. See parts breakdown. When positioning model 3520 tailstock onto Swing Away, compensate for increased bed thickness by adjusting lock nut beneath tailstock (Figure 2).

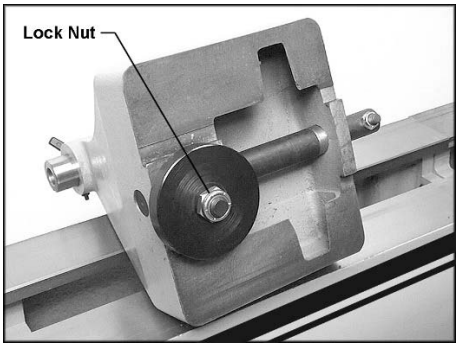


Figure 2: for model 3520 only

Operation

1. Slide tailstock onto Swing Away, and securely tighten tailstock clamp handle.
2. Grasp tailstock handwheel with one hand and slightly push toward lathe to relieve pressure on Swing Away. Loosen knob with other hand.

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3. Swing tailstock gently downward, maintaining control throughout movement.
4. To return Swing Away to operating position, pull tailstock up; steady it with one hand and tighten knob with other hand. (Knob is under spring pressure – push in while rotating.) *Keep hands away from pinch points.*

Maintenance

Keep Swing Away clean of sawdust and debris.

Periodically apply light coat of oil or paste wax to the way surfaces of Swing Away to prevent rust and promote smooth tailstock movement.

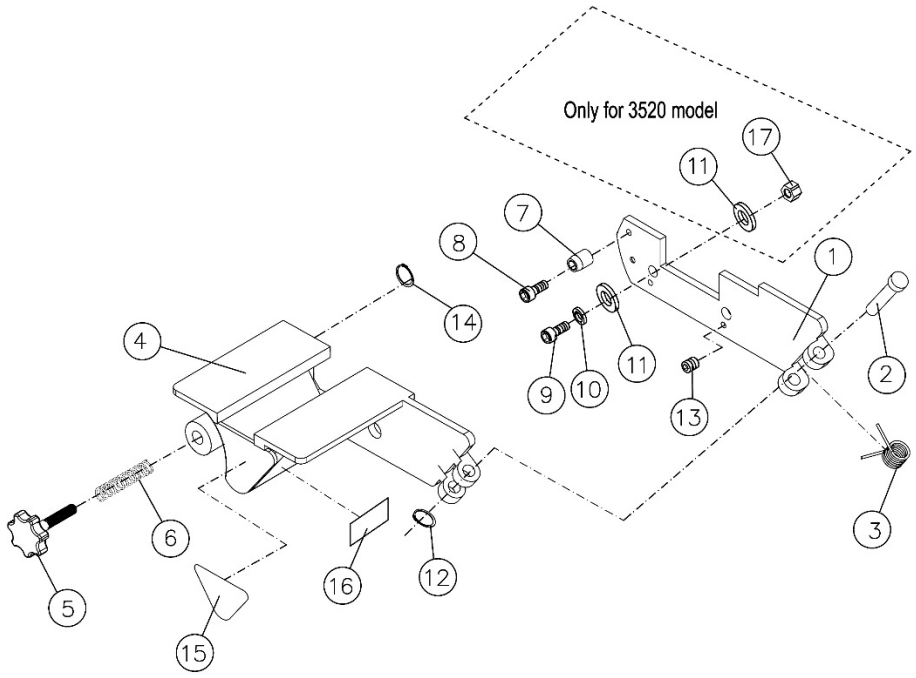
Periodically apply oil to spring and pivot pin area.

Specifications

Model number ..... PM-SA
Stock number 6294721
Main material ..... steel plate
Net weight ..... 17 lb. (7.7 kg)
Shipping weight ..... 19 lb. (8.5 kg)

Specifications were current at time of publication, but because of our policy of continuous improvement, Powermatic reserves the right to change specifications at any time and without prior notice, without incurring obligation

Parts Breakdown for #6294721, Tailstock Swing Away



Index No	Part No	Description	Size	Qty
1		Front Plate		1
2	PMSA-102	Pivot Pin		1
3	PMSA-103	Twist Spring		1
4		Rear Plate		1
5	PMSA-105	Knob Assembly		1
6	PMSA-106	Spring		1
7	PMSA-107	Guide Pin		1
8	TS-0209011	Socket Head Cap Screw	3/8"-16x1/2"	1
9	TS-0209061	Socket Head Cap Screw	3/8"-16x1-1/4"	2
10	TS-0720091	Spring Washer	3/8"	2
11	TS-0680041	Flat Washer	3/8"	4
12	PMSA-112	C-Ring	S-11	1
13	TS-0271051	Set Screw	3/8"-16x1/2”	2
14	PMSA-114	C-Ring	S-9	1
15	LM000011	Warning Label (EN)		1
	LM000065	Warning Label (FR)		1
16	LM000012	ID Label		1
17	TS-0561031	Hex Nut	3/8”-16	2

Some parts are shown for reference only, and may not be available individually.