



291 Griffith Road, Unit 1, Stratford, ON, N5A 2P6, Canada

Phone: 1-519-271-7611

Fax: 1-519-271-8892

E-Mail: postbox@oneway.ca

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1-800-565-7288

www.oneway.ca

Rotary Adaptor Instructions



Your rotary air adaptor contains the following:

- | | |
|----------------------------------|------------|
| 1 Rotary Adaptor Assembly | Part #2733 |
| 1 Removal Lever | Part #2574 |
| 2 M5 * 16 Socket Head Cap Screws | |
| 2 M8 * 10 Set Screws | |
| 1 4mm Hex key | |

Congratulations on the purchase of your ONEWAY Rotary Adaptor.

Packaged separately you will need one Taperlock Adaptor to suit your outboard spindle size. Adaptors are made to fit practically any spindle size. If you change lathes, all you need to do is buy a new adaptor, not a whole Rotary Adaptor.

The taperlock design eliminates the possibility of the adaptor loosening or separating from the chuck body in normal use or when reversing the lathe.

The first step to use your rotary air adaptor is to install the taperlock adaptor.

Mounting the Taper-Lock Adaptor

1. Wipe the inside of the taper of the Rotary Air Adaptor body as well as the outside of the adaptor to be sure all grit and dirt is removed.
2. Slide the adaptor into the Rotary Air body with the holes in the adaptor lined up with the holes in the Rotary Air body. (two holes will line up, and two will not)
3. Thread in the M5 * 16 socket head cap screw and with the 4mm hex key, tighten them alternately. Alternate tightening ensures that the adaptor is pulled into the taper straight.

Removing the Adaptor

1. Remove the two tightening screws and thread them into the two tapped holes of the adaptor. They now become jack screws.
2. Carefully tighten alternately until the adaptor pops loose from the taper.

Mounting the Rotary Adaptor to your Lathe

You are now ready to mount the Rotary Air Adaptor assembly to your lathe. It is important that it is put on your lathe properly.

Proceed as follows:

1. After mounting the adaptor to the Rotary Air Adaptor, carefully screw the assembly onto your outboard lathe spindle. It should go on smoothly without excessive play or binding. Screw it all the way on until the adaptor face contacts the spindle shoulder.
2. Next, lock your spindle, and unscrew the Rotary Adaptor just slightly so you can give it a firm swift spin, consequently snapping the Rotary Adaptor home. Alternatively use the removal lever to bump the Rotary Adaptor home.

Important Note

Two set screws are provided which go in the taperlock adaptor, and when tightened, attach it to the spindle. They should only be used if your lathe has a hardened spindle. If you can mark your spindle with a file, then it is softer than the set screws and these screws should not be tightened down on the Spindle.

Note: Only top quality wood lathes have hardened spindles.

The set screws must be inserted in the adaptor to create a seal. We highly recommend that if you do not have a hardened spindle, these set screws be glued in. This will ensure that they do not come out after prolonged use. If you chose not to glue them in, check regularly that they are in securely.