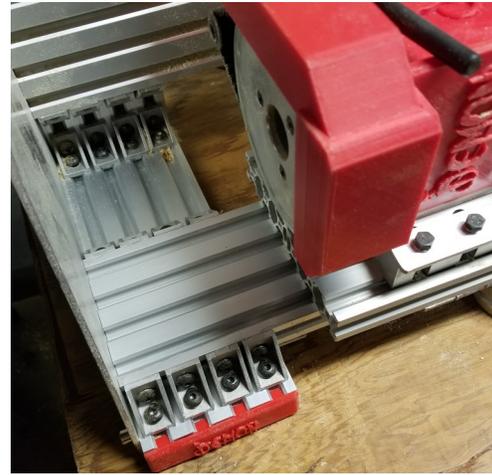
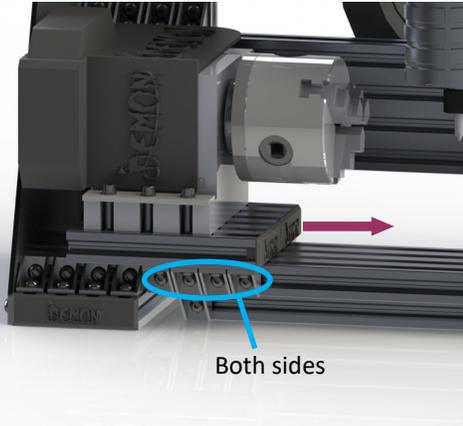
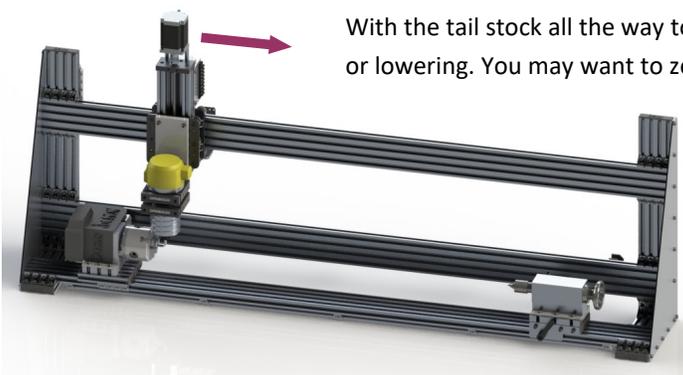


First, loosen the 8 screws (4 on each side) going in horizontally into the main bottom beam holding the chuck in place. Slide the chuck forward about 4 or 5 inches so the main beam's screws are easily accessible and then re-tighten at least 2 of the screws so it doesn't move. Make sure it is fully seated down. Also, move the tailstock to the left a few inches for the same reason.

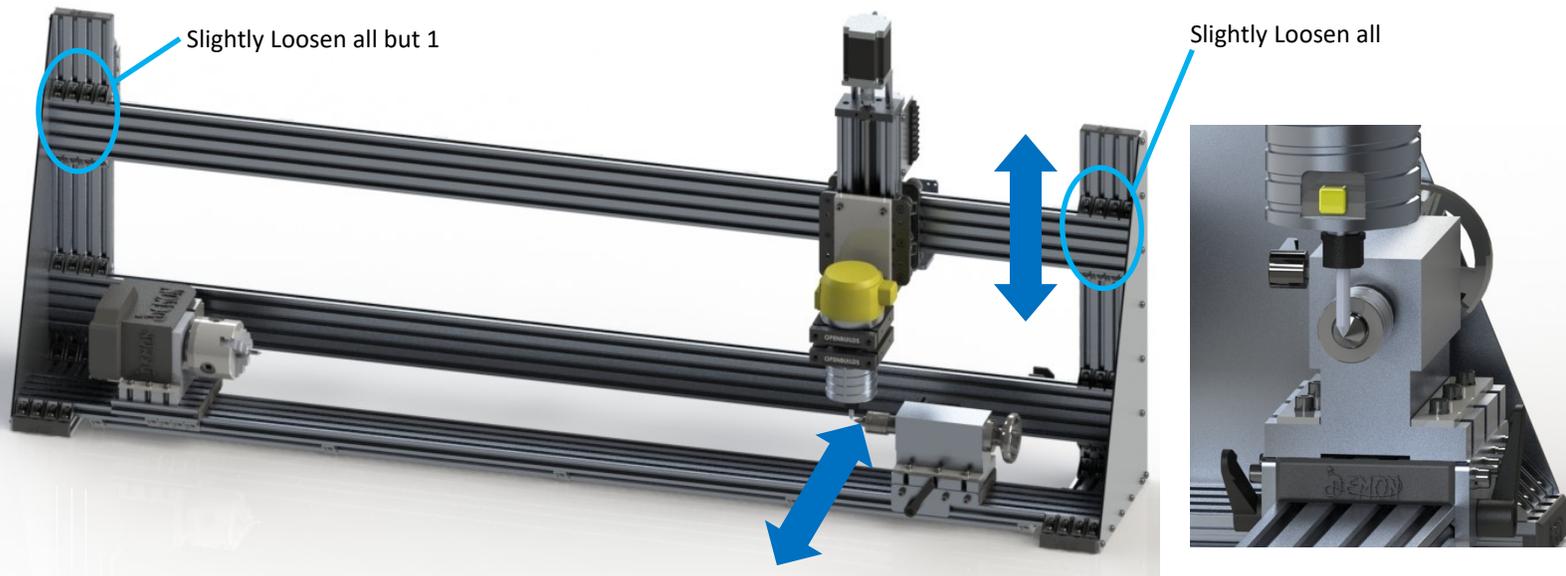


With the spindle to the left, put a pointy bit in the spindle AND the chuck. Make sure the points are as close to touching as you can, especially the spindle bit inline vertically with the center of the axis. Loosen all screws on the left side of the chuck beam and SLIGHTLY loosen all on the right side of the beam. Move the chuck beam in or out to center it on the spindle. You will not want to raise or lower your Z axis for the rest of the squaring. After it looks good, **snug one screw on the left side** of the chuck beam to keep it from moving, but it allows a pivot for moving the other side.



With the tail stock all the way to the right and locked in place, jog the spindle to the right without raising or lowering. You may want to zero the z axis work position to make sure you didn't accidentally move it.

Again, get the bit as close to the tail stock point. Move the right side of the chuck beam in or out to center it on the spindle. If the spindle is high or low on the tail stock point, you will have to loosen all but one of the screws on the left side of the X axis beam and, very carefully, all of them on the right side of the X axis beam. **THE LAST SCREW WILL FREE THE X AXIS** so be very careful. You may want help for that step. Raise or lower the right side to get it aligned vertically then snug one or 2 screws on both the X axis beam and the chuck beam. If you did have to change the vertical position of the X axis beam, the belt ends will need to be raised or lowered also. Then, jog the spindle back to the left and double check the alignment before tightening up all screws.



Last, just slide the chuck head back into place and tighten down. I left enough room to be able to change the belt if I ever needed to without moving the chuck assembly.

