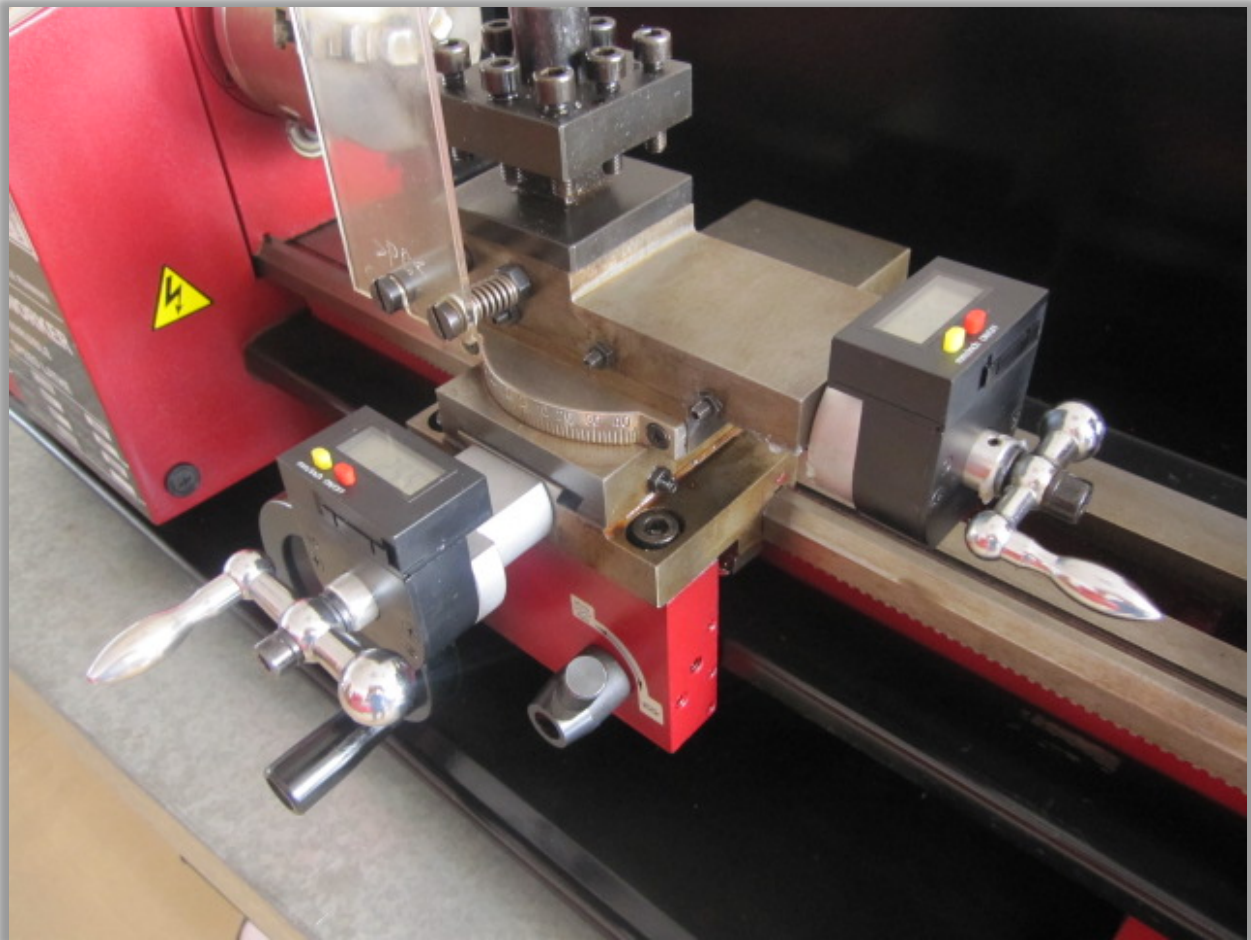


DRCD Kit Assembly Guide



Please note this guide applies to C2, SC2, C3 mini lathe only.

Please read this manual thoroughly and follow all directions carefully

**Part I: The complete set of DRCD kit
(Digital Readout for Cutting Depth)**



Part No 1. Digital readout box

Part No 2. Bracket for the compound slide

Part No 3. Bracket for the cross slide

Part No 4. Transition shaft for the cross slide

Part No 5. Transition shaft for the compound slide

Part No 6. Compound feed screw

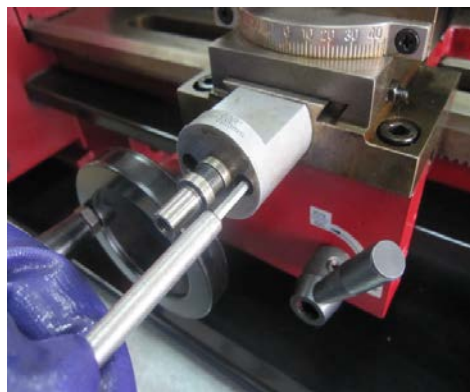
Part No 7. Cross slide feed screw

Part No 8. Screws package

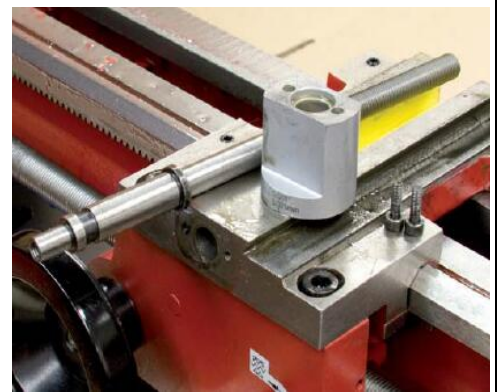
Part II: Assembly on cross slide.



1. Remove the screw securing the cross slide handle. Remove the ball handle, spacer and dial.



2. Remove the dial bracket, and take out the cross slide feed screw.



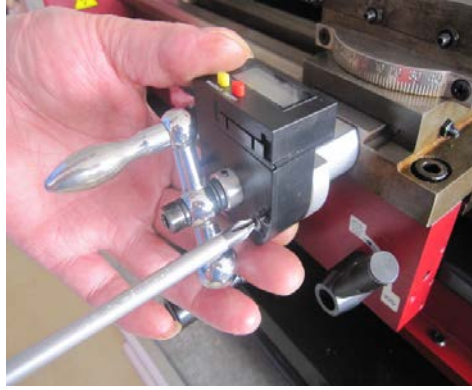
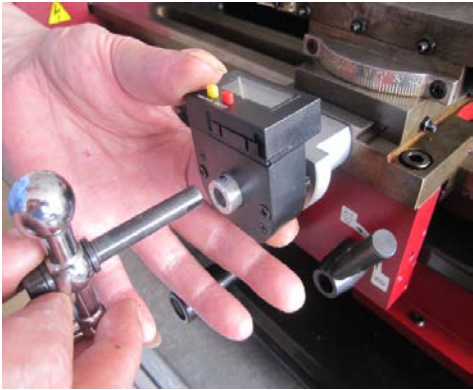
3. Assemble the new cross slide feed screw (Part No.7) , bracket (Part No.3) step by step. Tighten the two M4x16 screws (Part No.8)



4. Assemble the transition shaft (Part No.4) onto the dismantled ball handle.



6. Make the final adjustment for free movement of handle with little drag. Lock the small screws.



5. Assemble the digital readout box(Part No.1) onto the bracket, then fitted the assembled transition shaft and ball handle into the leadscrew. Slightly adjust the transition shaft to make it work well with the leadscrew. Finally tightened with two M3×25 screws (Part No.8).

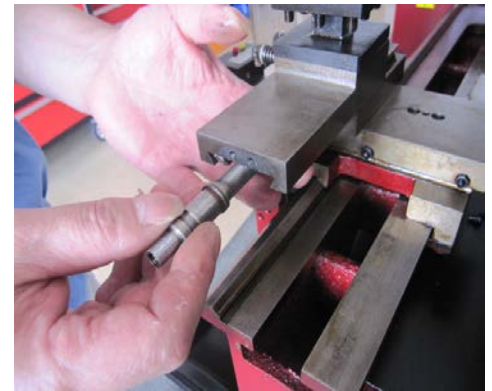
Part III: Assembly on compound slide.



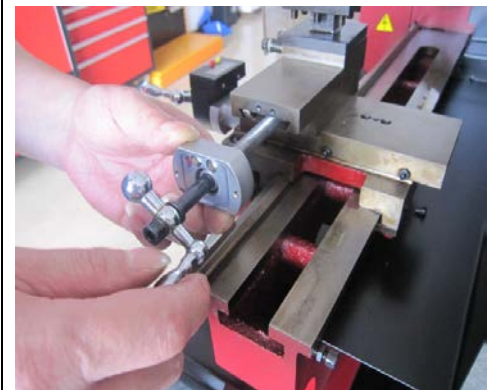
1. Remove the screw securing the compound handle. Remove the ball handle, spacer and dial.



2. Loosen the screws. Remove the dial bracket, and take out the compound feed screw dial.



3. Assemble the block (Part No.8) and compound feed screw (Part No.6) on the bracket (Part No.2).

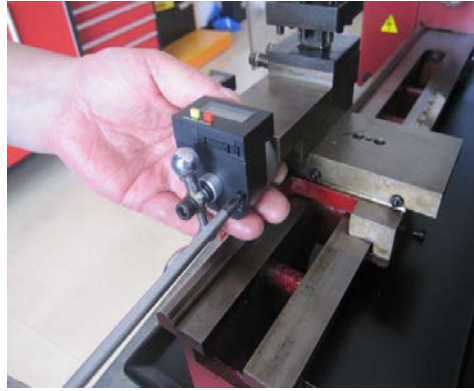
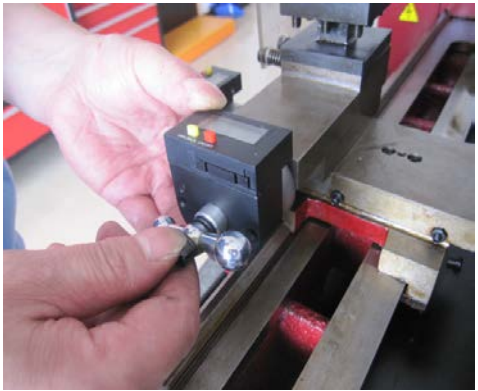


5. Use the transition shaft to push the assembled compound feedscrew and bracket part into the compound slide.



4. Assemble the transition shaft (Part No.5) onto the dismantled ball handle.

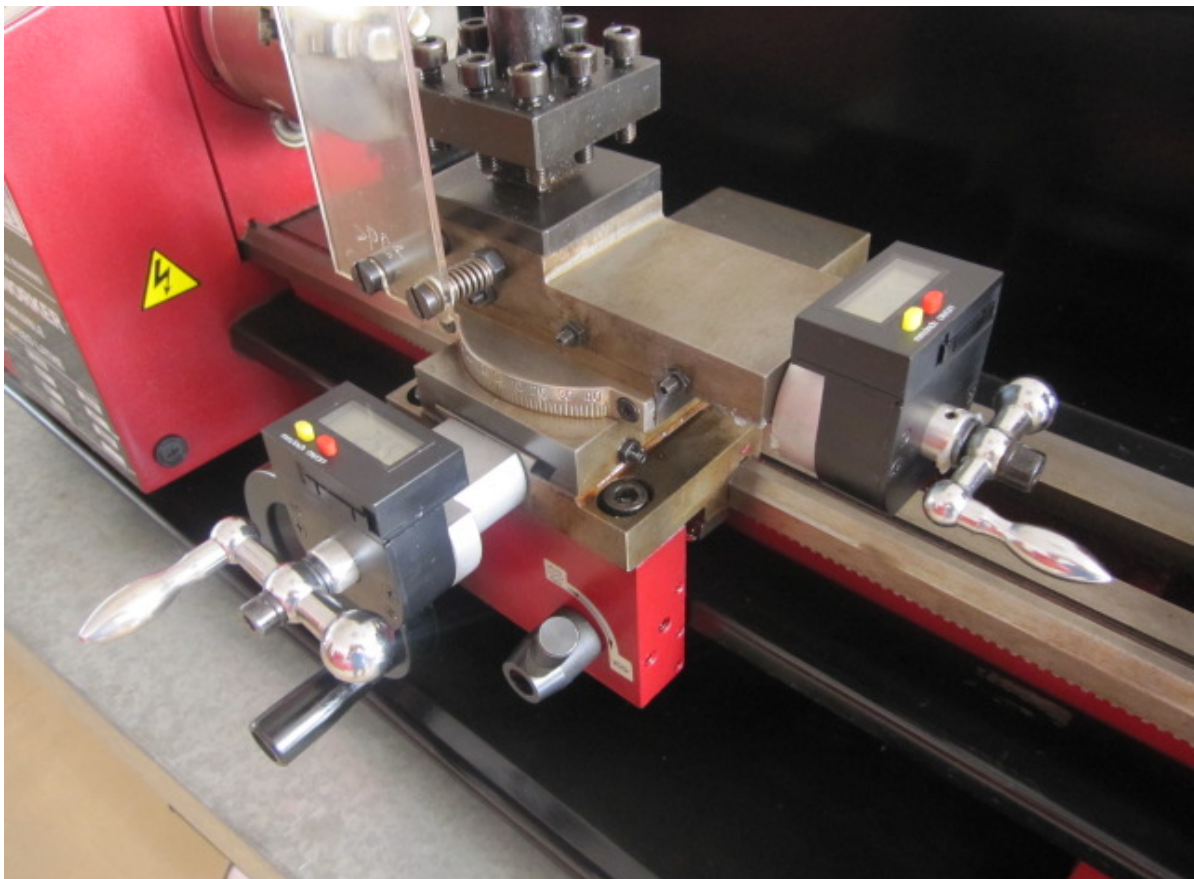
6. Then refit the dismantled original two M4×12 screws. After that, taking out the transition shaft waiting for assembling the digital readout box.



7. Assemble the digital readout box (Part No.1) onto the bracket, then fitted the assembled transition shaft and ball handle into the leadscrew. Slightly adjust the transition shaft to make it work well with the leadscrew. Finally tightened with two M3×25 screws (Part No.8).

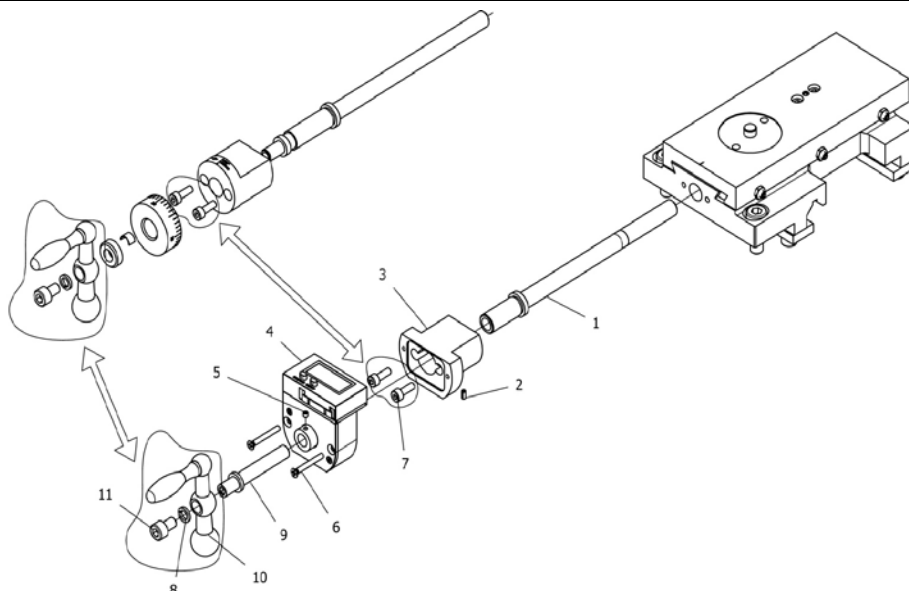
8. Make the final adjustment for free movement of handle with little drag. Lock the small screws.

The completed DRCD kit



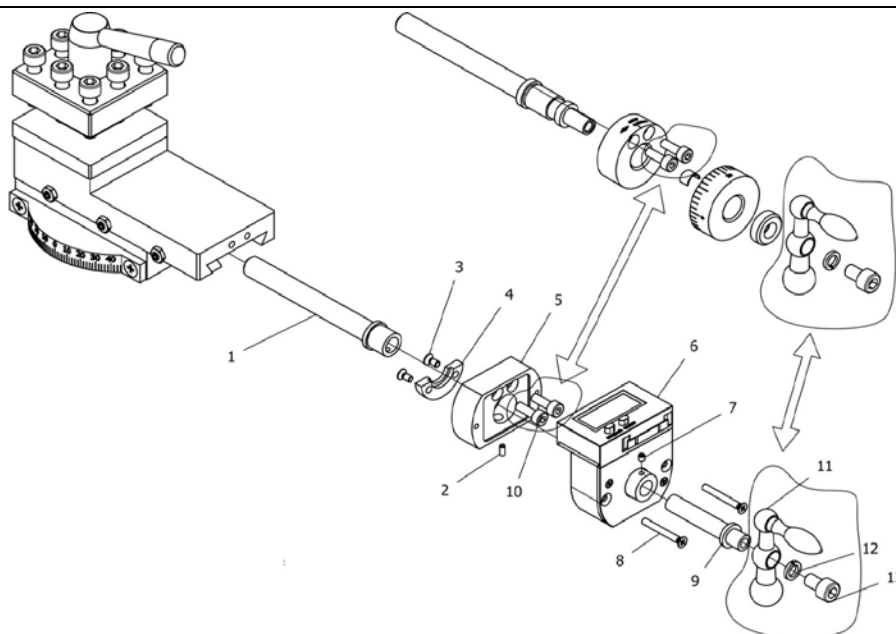
Part IV: Parts Breakdown & Parts List

Y axis →
(cross slide)



| Part No. | Specification | Description | Quantities | Note |
|----------|-----------------|------------------------|------------|------------------------|
| 1 | C2A05E02 | Cross slide feed screw | 1 | |
| 2 | GB 879-86 2.5x5 | Elastic pin 2.5x5 | 1 | |
| 3 | C2A05E033 | Bracket | 1 | |
| 4 | ZCG1.0 | Digital readout box | 1 | |
| 5 | GB77-85 M3x3 | Hex screw M3x3 | 1 | |
| 6 | GB819-85 M3x25 | Cross head screw M3x25 | 2 | |
| 7 | GB70-85 M4x12 | Hex screw M4x12 | 4 | |
| 8 | GB93-87 M6 | Spring washer | 3 | Dismantle from machine |
| 9 | C2A05E01 | Transition shaft | 1 | |
| 10 | C2A0511 | Ball handle | 2 | Dismantle from machine |
| 11 | GB70-85 M6x10 | Hex screw M6x10 | 3 | Dismantle from machine |

X axis →
(compound slide)



| Part No. | Specification | Description | Quantities | Note |
|----------|-----------------|---------------------------|------------|------------------------|
| 1 | C2A04D04 | Compound slide feed screw | 1 | |
| 2 | GB 879-86 2.5x5 | Elastic pin 2.5x5 | 1 | |
| 3 | GB819-85 M3x6 | Cross head screw M3x6 | 2 | |
| 4 | C2A04D01 | Block | 1 | |
| 5 | C2A04D03 | Bracket | 1 | |
| 6 | ZCG1.0 | Digital readout box | 1 | |
| 7 | GB77-85 M3x3 | Hex screw M3x3 | 1 | |
| 8 | GB819-85 M3x25 | Cross head screw M3x25 | 2 | |
| 9 | C2A04D02 | Transition shaft | 1 | |
| 10 | GB70-85 M4x12 | Hex screw M4x12 | 4 | Dismantle from machine |
| 11 | C2A0411 | Ball handle | 2 | Dismantle from machine |
| 12 | GB93-87 M6 | Spring washer | 2 | Dismantle from machine |
| 13 | GB70-85 M6x10 | Hex screw M6x10 | 2 | Dismantle from machine |