

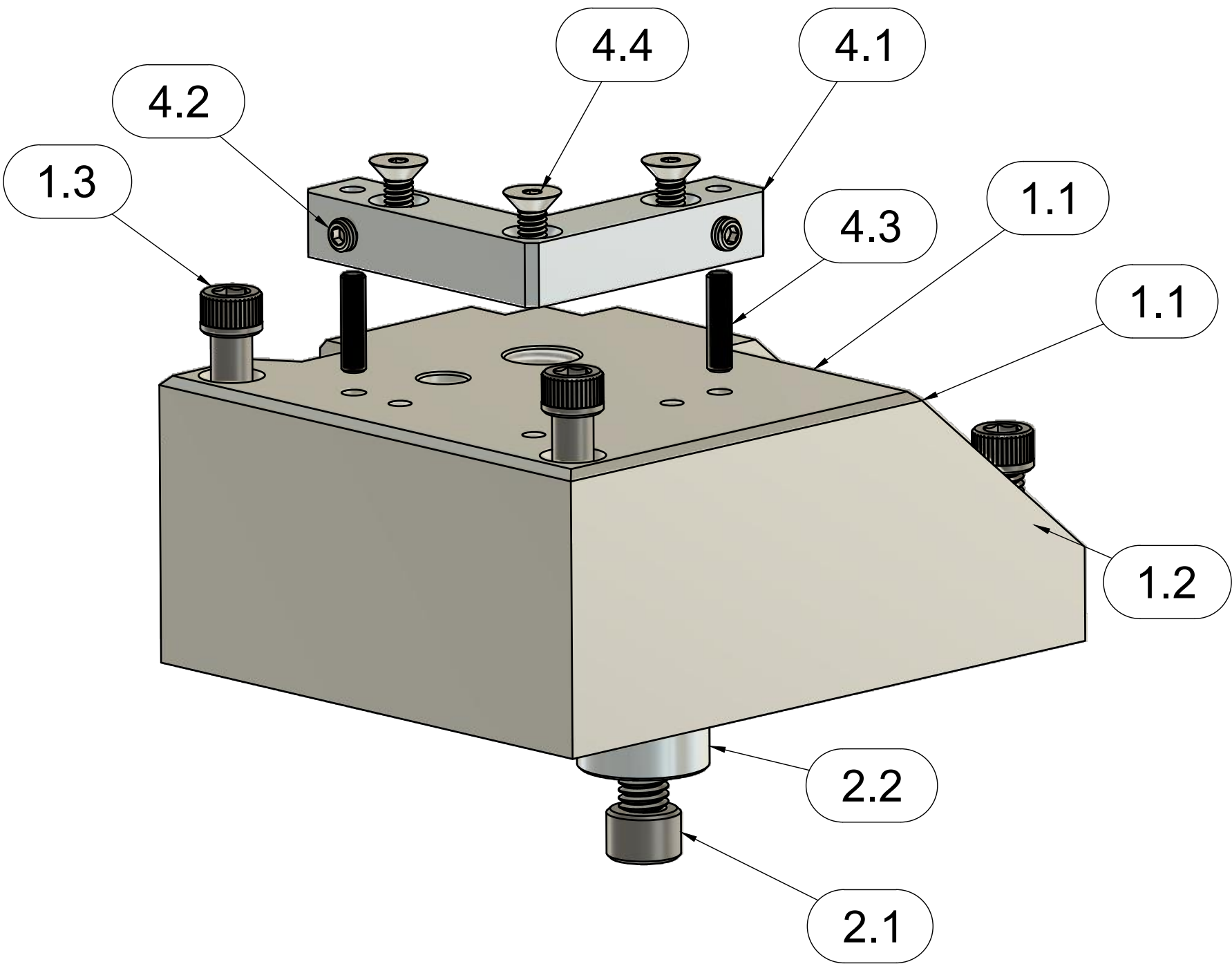
## Exploded Assembly View - Solid Tool Post Mounting Platform for PM-1340GT and PM-1440GT

TITLE: Solid Tool Post Mount for PM-1340/1440GT - BXA QCTP

UNITS: Inches [mm] SHEET: 2/7

DESIGNER: David P. Best

DATE: 12/17/21



PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	SOLID TOOL POST (1)	SOLID TOOL POST MOUNTING BLOCK
1.1	1	SOLD TOOL POST MOUNTING BLOCK	SOLD TOOL POST MOUNTING BLOCK
1.2	2	92185A583_SUPER-CO RROSION-RESISTANT 316 STAINLESS STEEL SOCKET HEAD SCREW	SOLID TOOL POST MOUNTING BOLT 5/16"-18, 1" LONG
1.3	2	92185A592_SUPER-CO RROSION-RESISTANT 316 STAINLESS STEEL SOCKET HEAD SCREW (1)	SOLID TOOL POST MOUNTING BOLT 5/16"-18, 2¼" LONG
2	1	CROSS SLIDE LOCATING SPUD	CROSS SLIDE LOCATING SPUD
2.1	1	90128A622_ZINC-PLAT ED ALLOY STEEL SOCKET HEAD SCREW	LOCATING SPUD BOLT - 3/8"-16, 3/4" LONG
2.2	1	CROSS SLIDE LOCATING SPUD (2)	CROSS SLIDE LOCATING SPUD
4	1	REGISTRATION BRACKET	QCTP ALIGNMENT REGISTRATION BRACKET
4.1	1	REGISTRATION L-BRACKET	
4.2	2	94355A713_18-8 STAINLESS STEEL FLAT-TIP SET SCREWS	ALIGNMENT SETSCREW 1/4"-28, 3/4" LONG
4.3	2	98381A316_DOWEL PIN	REGISTRATION BRACKET STAKE PIN
4.4	3	92210A027_18-8 STAINLESS STEEL HEX DRIVE FLAT HEAD SCREW	REGISTRATION BRACKET MOUNTING SCREW 12-24 HEX-SOCKET FLAT HEAD SCREW 3/4" LONG

Note: All stated part numbers are McMaster.com



Exploded Assembly View - Solid Tool Post Mounting Platform for PM-1340GT and PM-1440GT

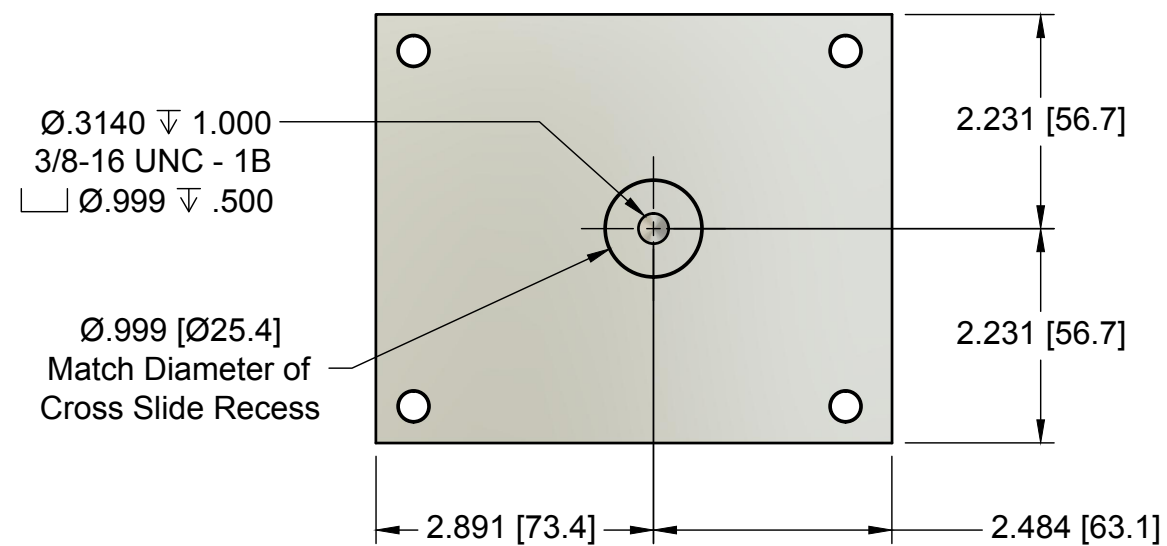
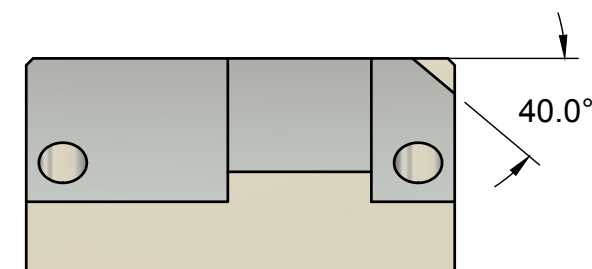
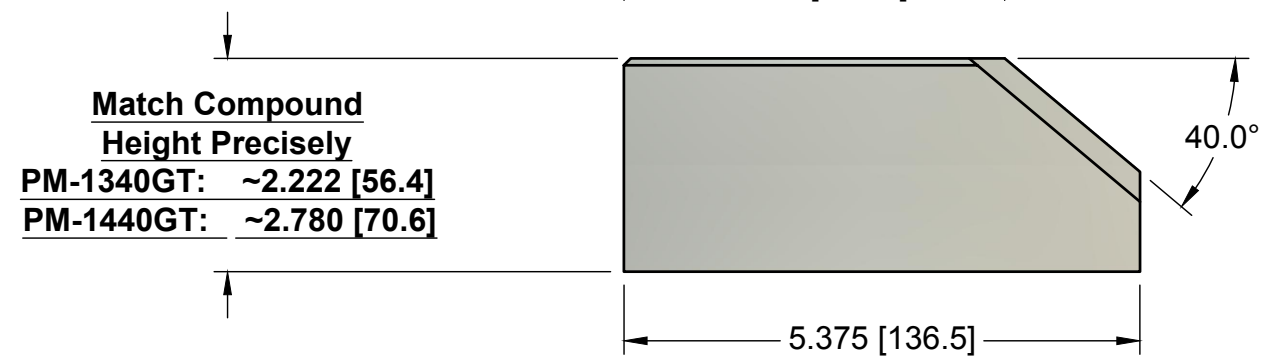
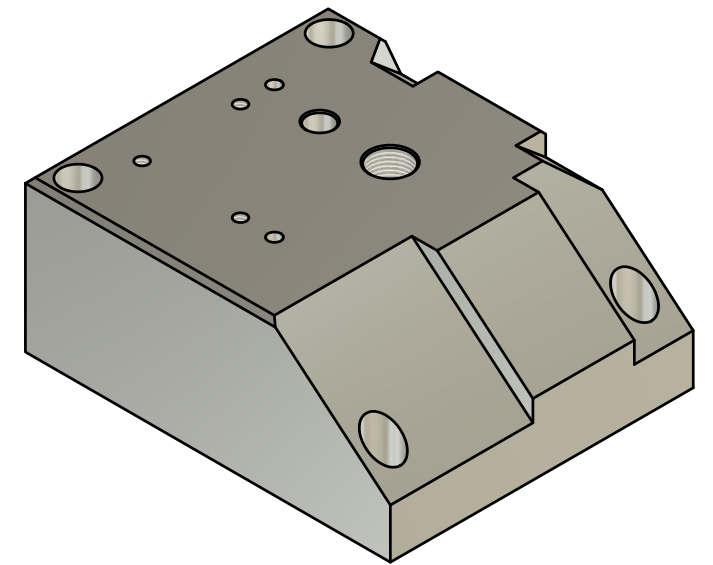
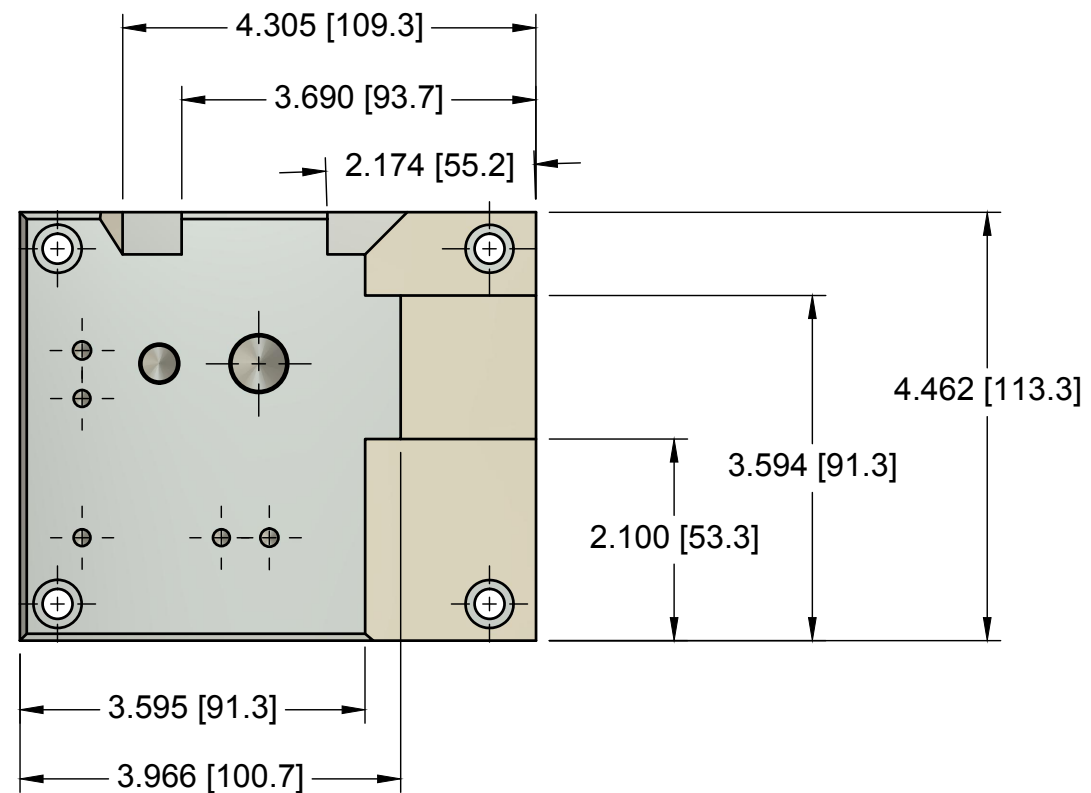
TITLE: Solid Tool Post Mount for PM-1340/1440GT - BXA QCTP

UNITS: Inches [mm]

SHEET: 3/7

DESIGNER: David P. Best

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## Overall Dimensions - Solid Tool Post Mounting Platform for PM-1340GT and PM-1440GT

TITLE: Solid Tool Post Mount for PM-1340/1440GT - BXA QCTP

UNITS: Inches [mm] SHEET: 4/7

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**Position/Diameter of Anti-Rotation  
Indexing Pin Varies -  
Match Location to QCTP**

2X Ø.313 ▽ 2.300  
└─┘ Ø.500 ▽ .400

4.081 [103.7]

Ø.188 ▽ .375

3.021 [76.7]

2.884 [73.2]

2.521 [64]

3X Ø.1760 ▽ .375  
12-24 UNC - 2B

Ø.5715 ▽ .750  
5/8-18 UNF - 1B

Ø.188 ▽ .375

1.071 [27.2]

.381 [9.7]

.000 [0]

.000 [0]

.391 [9.9]

.647 [16.4]

2.097 [53.3]

2.487 [63.2]

2.597 [66]

4.891 [124.2]

2X Ø.313 ▽ 2.300  
└─┘ Ø.500 ▽ 1.610

Best Services

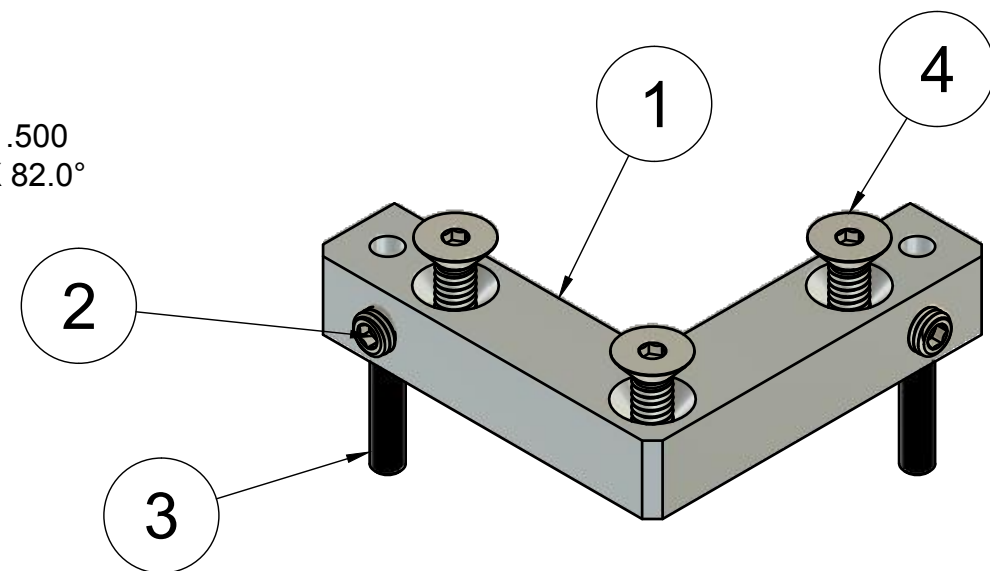
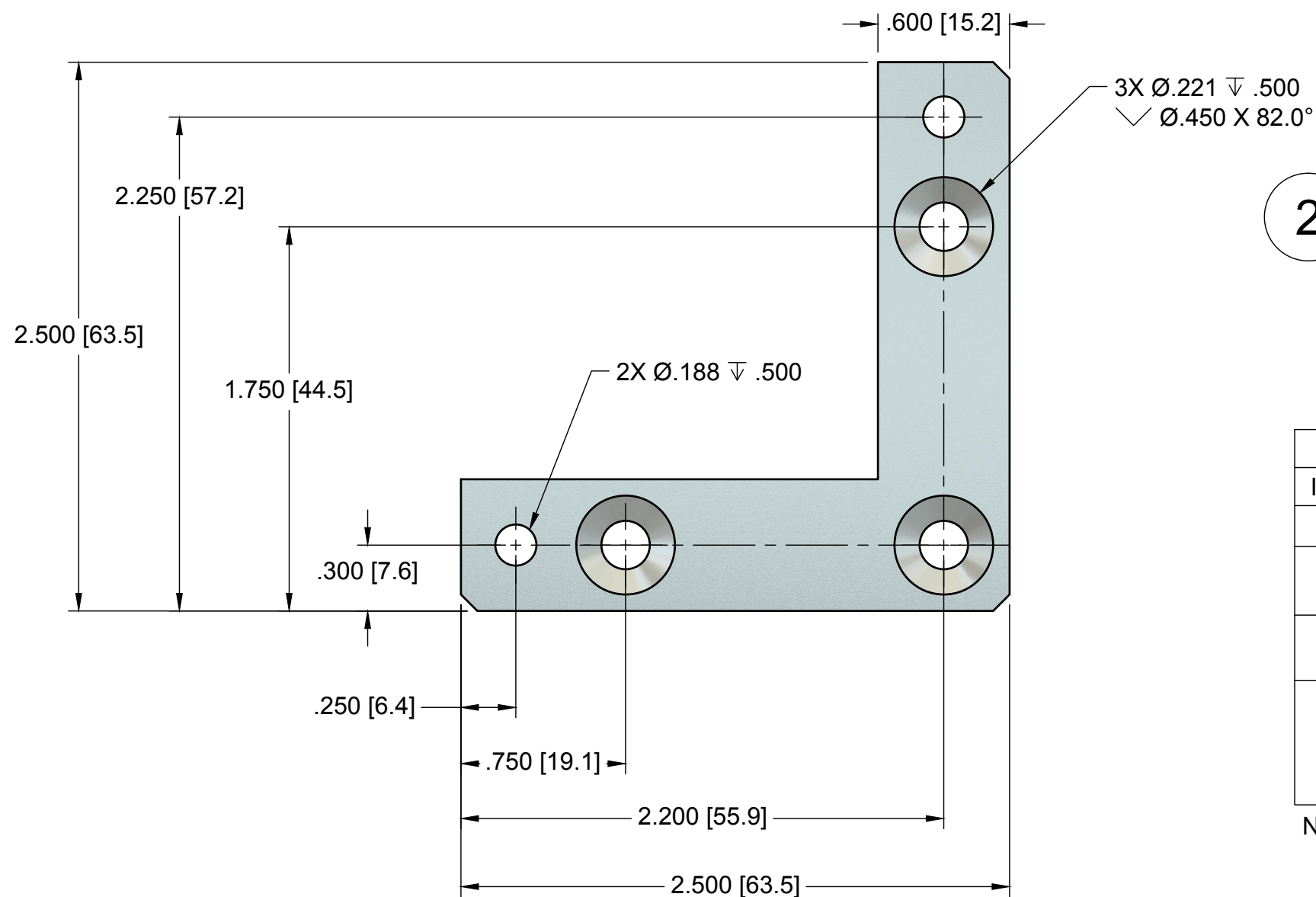
## Drill/Tap Postions Top View - Solid Tool Post Mounting Platform for PM-1340GT and PM-1440GT

TITLE: Solid Tool Post Mount for PM-1340/1440GT - BXA QCTP

UNITS: Inches [mm] SHEET: 5/7

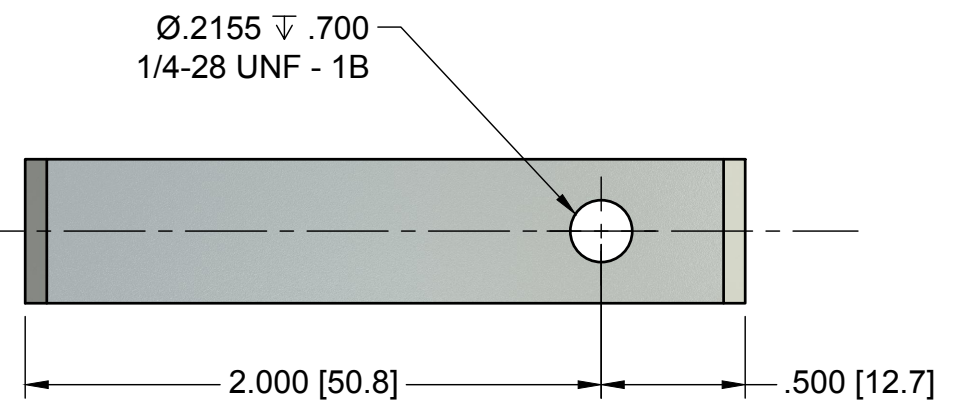
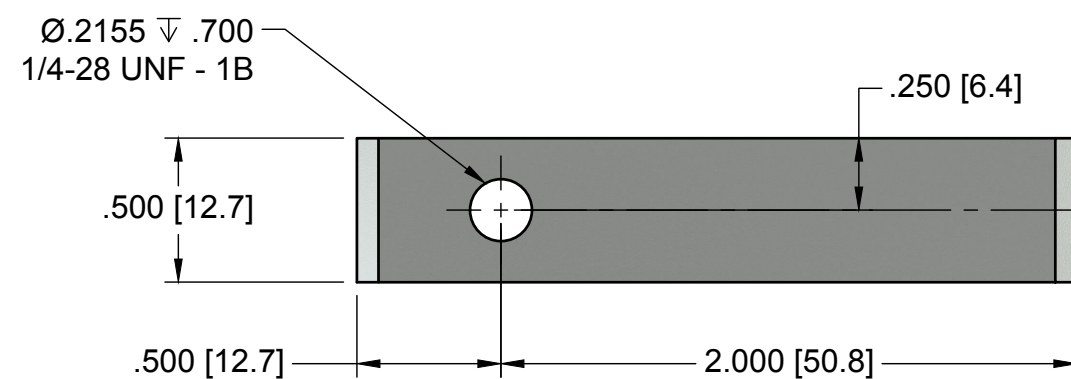
DESIGNER: David P. Best

DATE: 12/17/21



PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
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2	2	94355A713_18-8 STAINLESS STEEL FLAT-TIP SET SCREWS	ALIGNMENT SETSCREW 1/4"-28, 3/4" LONG
3	2	98381A316_DOWEL PIN	REGISTRATION BRACKET STAKE PIN
4	3	92210A027_18-8 STAINLESS STEEL HEX DRIVE FLAT HEAD SCREW	REGISTRATION BRACKET MOUNTING SCREW 12-24 HEX-SOCKET FLAT HEAD SCREW 3/4" LONG

Note: All stated part numbers are McMaster.com



## QCTP Registration/Alignment Bracket - Solid Tool Post Mounting Platform for PM-1340GT and PM-1440GT

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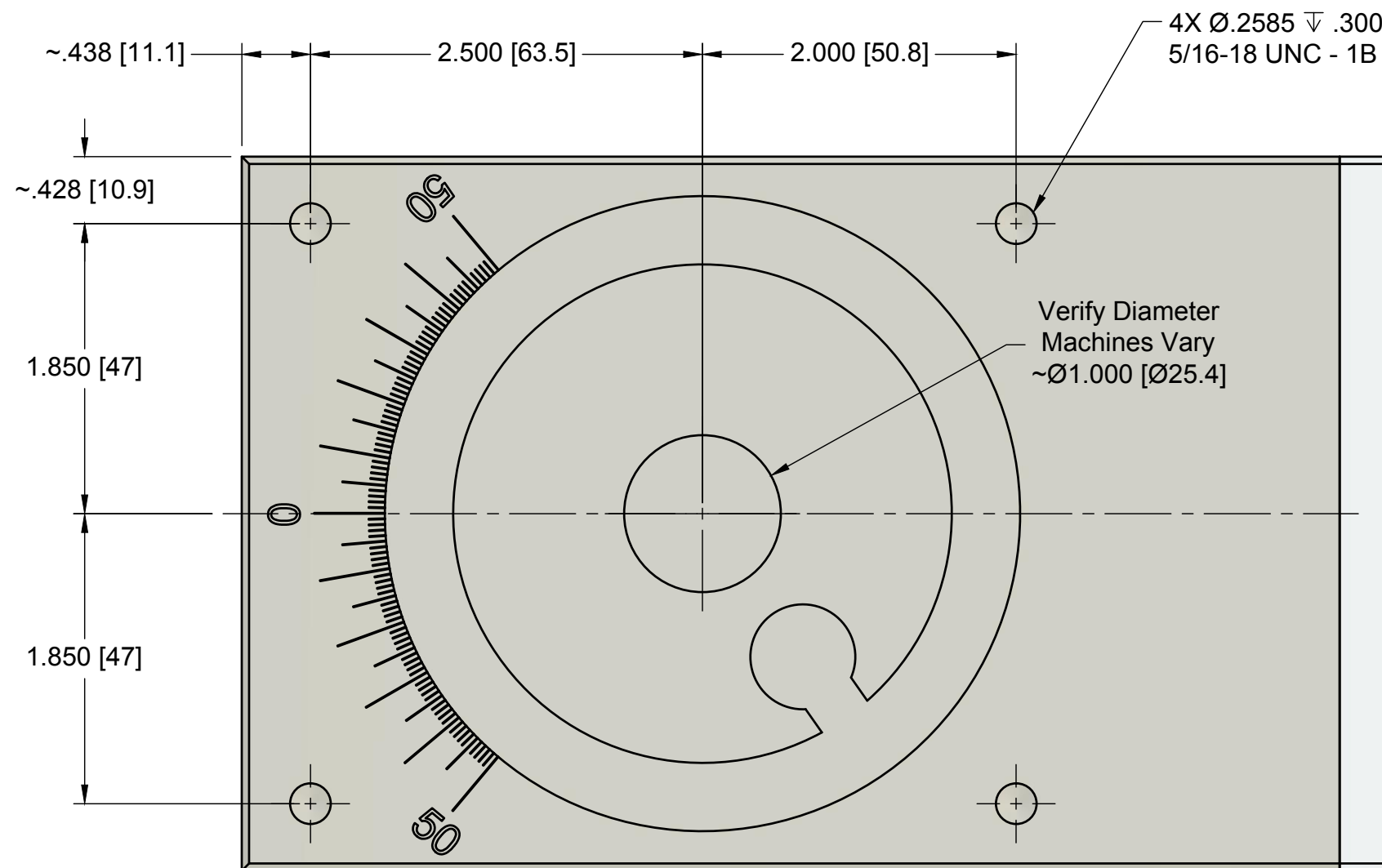
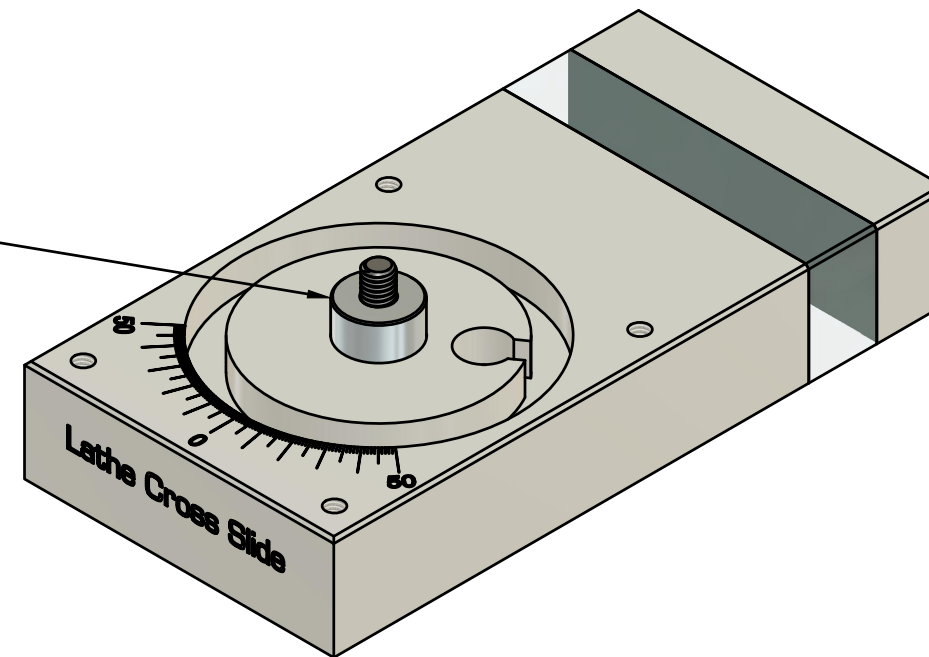
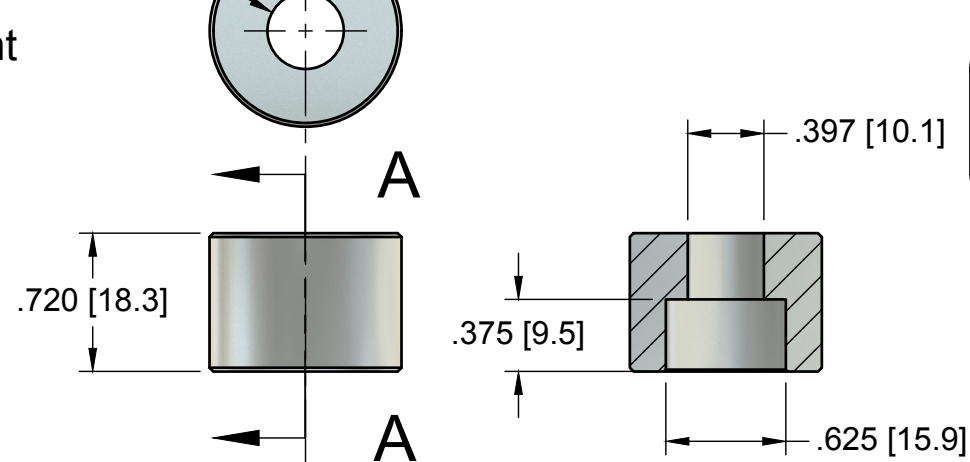
UNITS: Inches [mm] SHEET: 6/7

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# Cross Slide Alignment Spud Detail

Ø.397 [Ø10.1]  
Match Compound  
Rotation Hole Diameter  
in Cross Slide ~Ø.999 [Ø25.4]



Note: To ensure precise location match, the position of the tapped holes in the cross slide should be marked with a transfer punch using the completed solid tool post mounting block as the guide/reference.