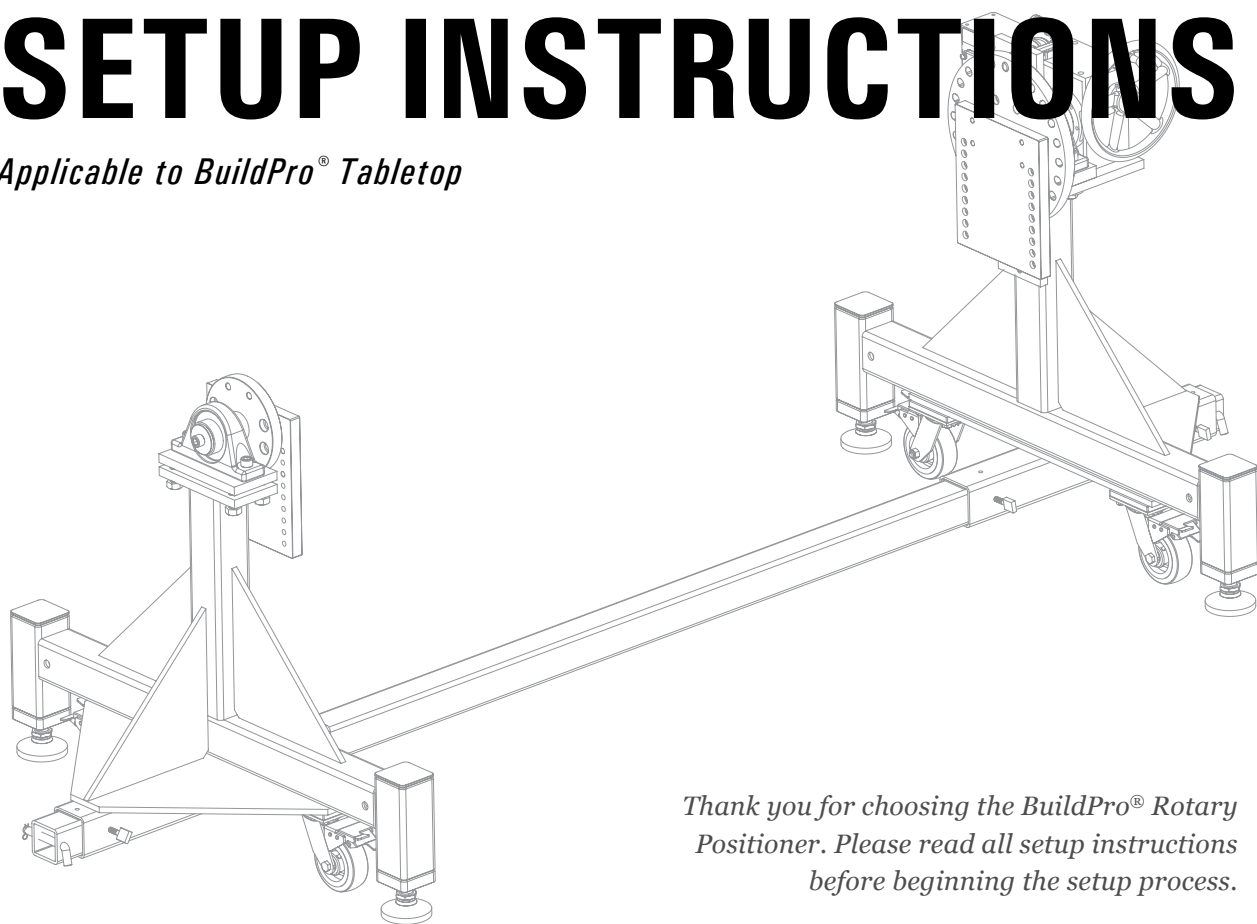


# ROTARY POSITIONER SETUP INSTRUCTIONS

*Applicable to BuildPro® Tabletop*



*Thank you for choosing the BuildPro® Rotary Positioner. Please read all setup instructions before beginning the setup process.*

## PICTORIAL INDEX

- a. Headstock Assembly
- b. Tailstock Assembly
- c. Telescoping Center Tube

## ASSEMBLY INSTRUCTIONS

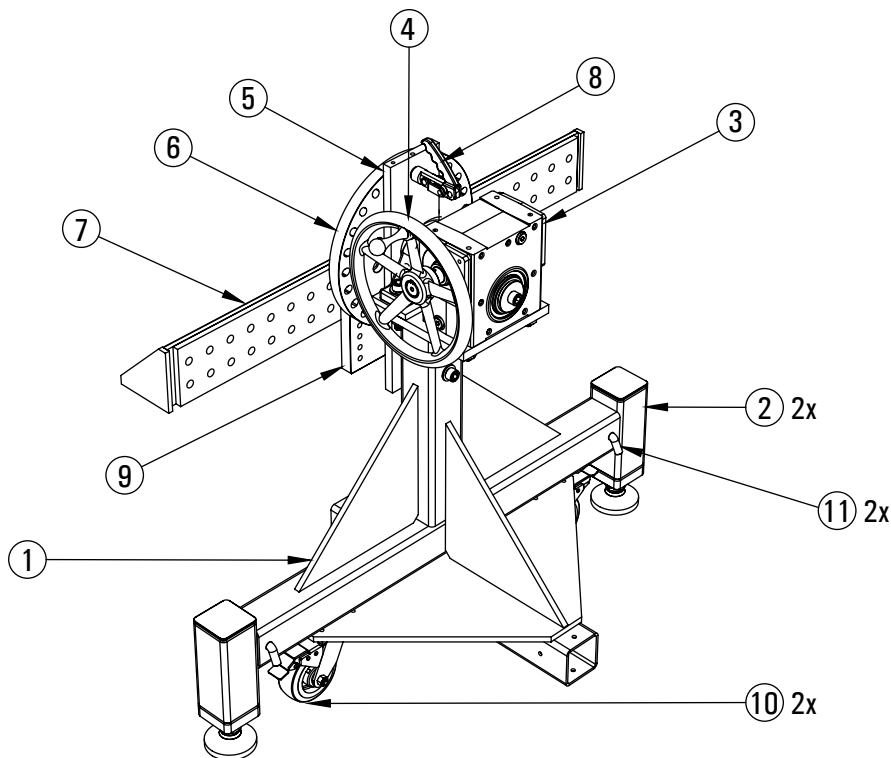
- a. Positioner Assembly
- b. Table Mounting
- c. Height-Adjustment Plate

## MAINTENANCE

- a. Gearbox
- b. Bearings

## SAFETY



**HEADSTOCK ASSEMBLY**
**PART A**


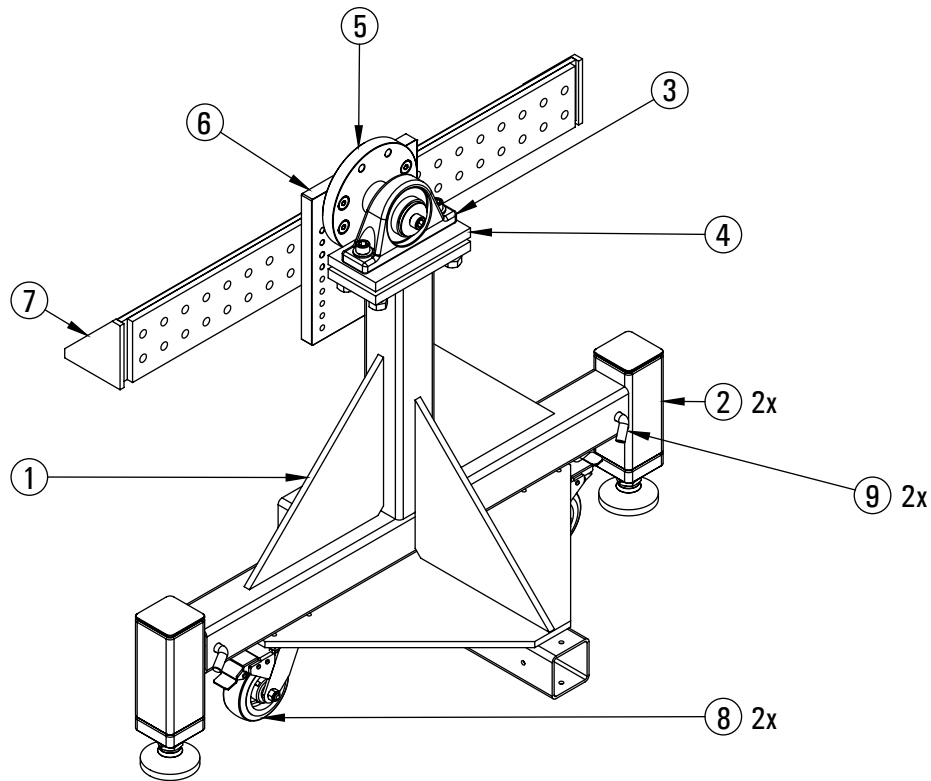
Item Number	Part Description	Qty
1	Headstock	1
2	Legs with Leveling Feet	2
3	Gearbox	1
4	Crankshaft Handle	1
5	Vertical Plate Plunger Mount	1
6	Index Wheel - Headstock	1
7	Table Mounting Bracket*	1
8	Plunger	1
9	Height-Adjustment Table Mounting Plate	1
10	Casters	2
11	5/8 Hitch Pin	2

*Not shown in picture (hidden from view):*

Part Description	Qty
Bearing	1
Bearing Plate	1

## TAILSTOCK ASSEMBLY

### PART B

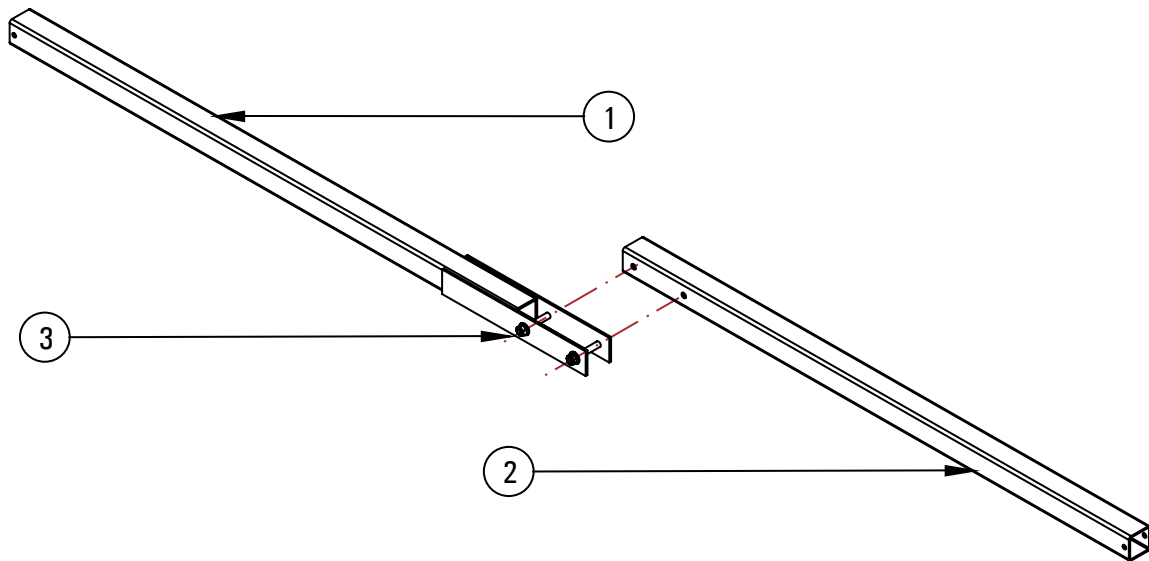


Item Number	Part Description	Qty
1	Tailstock	1
2	Legs with Leveling Feet	2
3	Bearing	1
4	Height-Adjustment Bearing Plate	1
5	Index Wheel - Tailstock	1
6	Height-Adjustment Table Mounting Plate	1
7	Table Mounting Bracket*	1
8	Casters	2
9	5/8 Hitch Pin	2

\* Table Mounting Bracket sizes can vary based on table being used. Drawing shown above may or may not be exact to what you purchased.

TELESCOPING TUBE ASSEMBLY

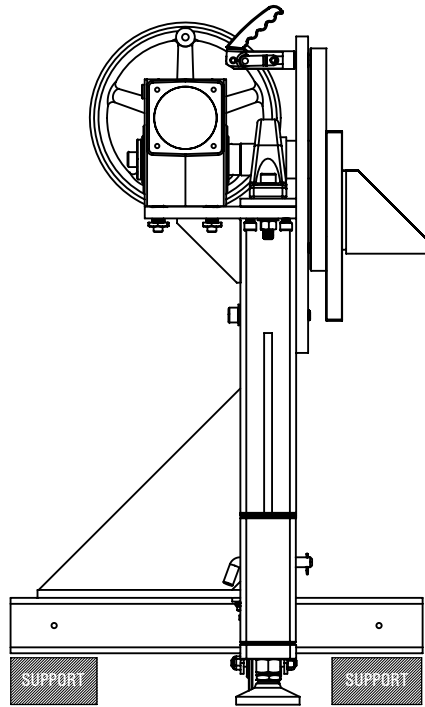
**PART C**



Item Number	Part Description	Qty
1	Telescoping Tube - 1	1
2	Telescoping Tube - 2	1
3	SHCS 5/8-11 x 4-1/2" nut and 2 washers	2

## POSITIONER ASSEMBLY

1. Pallet should contain the 3 main assemblies shown in pictorial index: the headstock(PART A), the tailstock(PART B) and the telescoping tube (PART C, which will be shipped in two parts initially)
2. Starting with the headstock, lift it off the pallet and suspend it in the air.
3. Set the headstock down on the floor with two supports on each side of the center tube, as shown in *Figure 1*. Wooden blocks can be used as supports in this case. (Temporary blocks not included.)

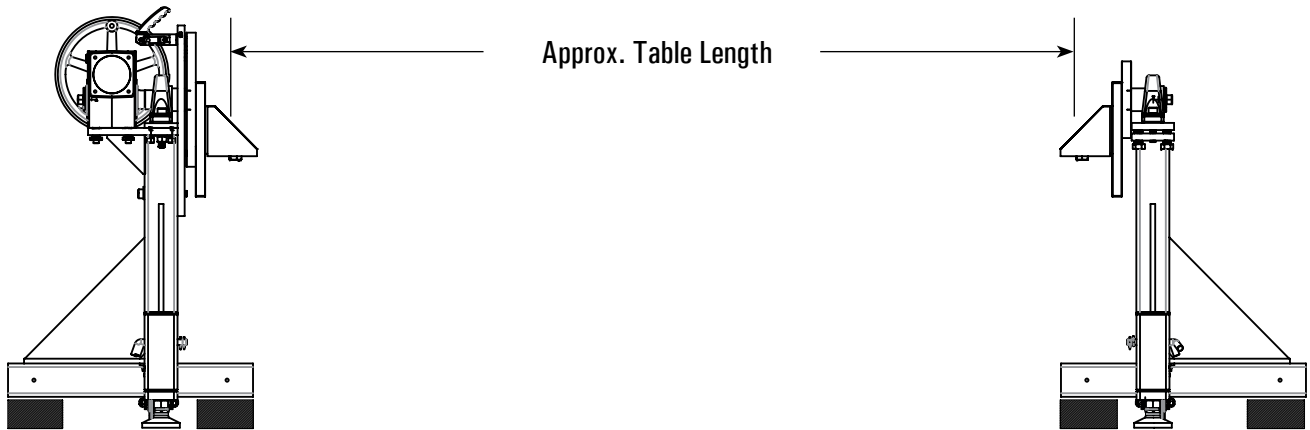


*Figure 1.*

**WARNING:** Setting the assembly down on casters without supports will cause it to topple over due to its center of mass. This can lead to serious injury if it lands on someone.

**POSITIONER ASSEMBLY**

4. Repeat steps 2 – 3 for the tailstock assembly. Place the tailstock assembly opposite the headstock assembly about your table length's distance away, as shown in *Figure 2*.



*Figure 2.*

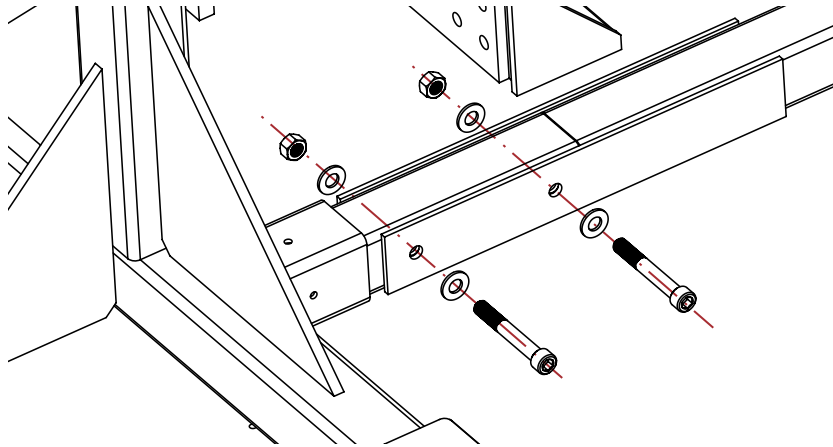
5. Grab the telescoping tube – 2 (Part C.2) and slide it into the center tube of the headstock assembly as shown in *Figure 3*, ensuring that the end with the two 5/8" through holes is on the inner side of the headstock. The orientation can be seen in *Figure 3*.



*Figure 3.*

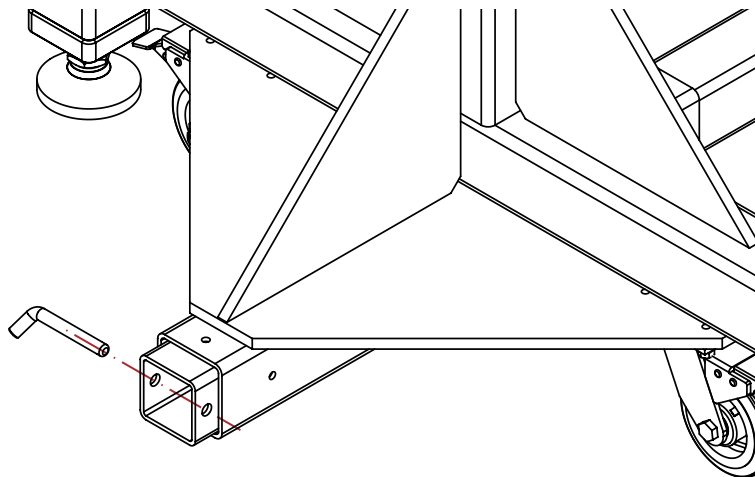
## POSITIONER ASSEMBLY

6. Take the telescoping tube – 1 (Part C.1) and align the two side holes on the plates with the two holes on the telescoping tube – 2 (Part C.2). Bolt them through with 5/8 SHCS as shown in *Figure 4*.



*Figure 4.*

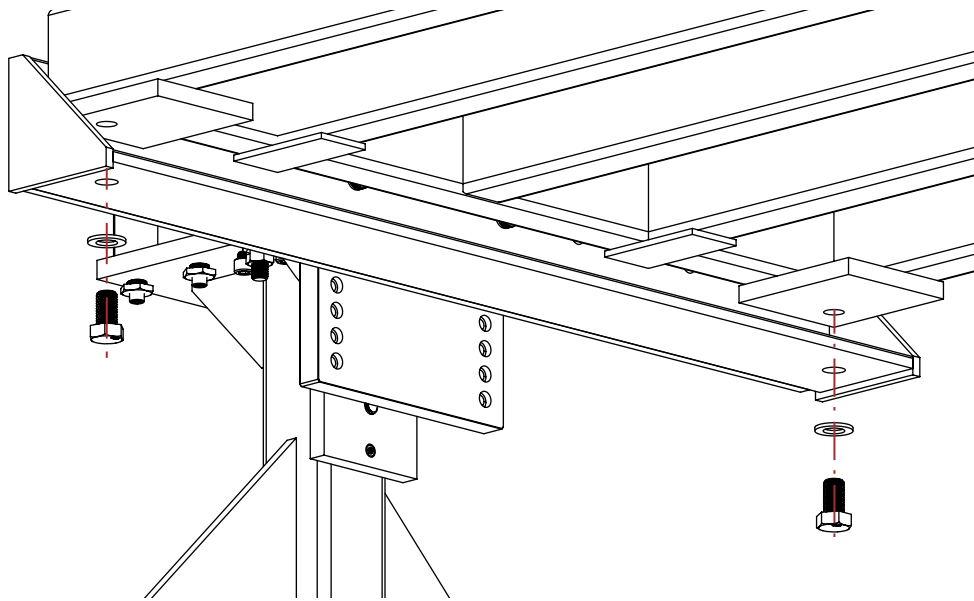
7. Center the tube assembly between the headstock and tailstock.
8. Insert the 1/2" hitch pins on the outside ends of the tube assembly to secure the headstock and tailstock from sliding out, as shown in *Figure 5*.



*Figure 5.*

**TABLE MOUNTING**

1. Ensure that the plunger is inserted into the large index wheel so that the mounting bracket is in a horizontal position.
2. Using a forklift, position the table over the positioner assembly.
3. Shift the headstock and tailstock along the center tube so that the mounting bracket holes line up with the thread holes underneath the table frame.
4. Lower the table so that it is about 1/4" to 1/2" above the mounting brackets.
5. Starting with the headstock end, align the mounting holes again and insert the 20 mm bolts with washers. Hand tighten them, as shown in *Figure 6*.



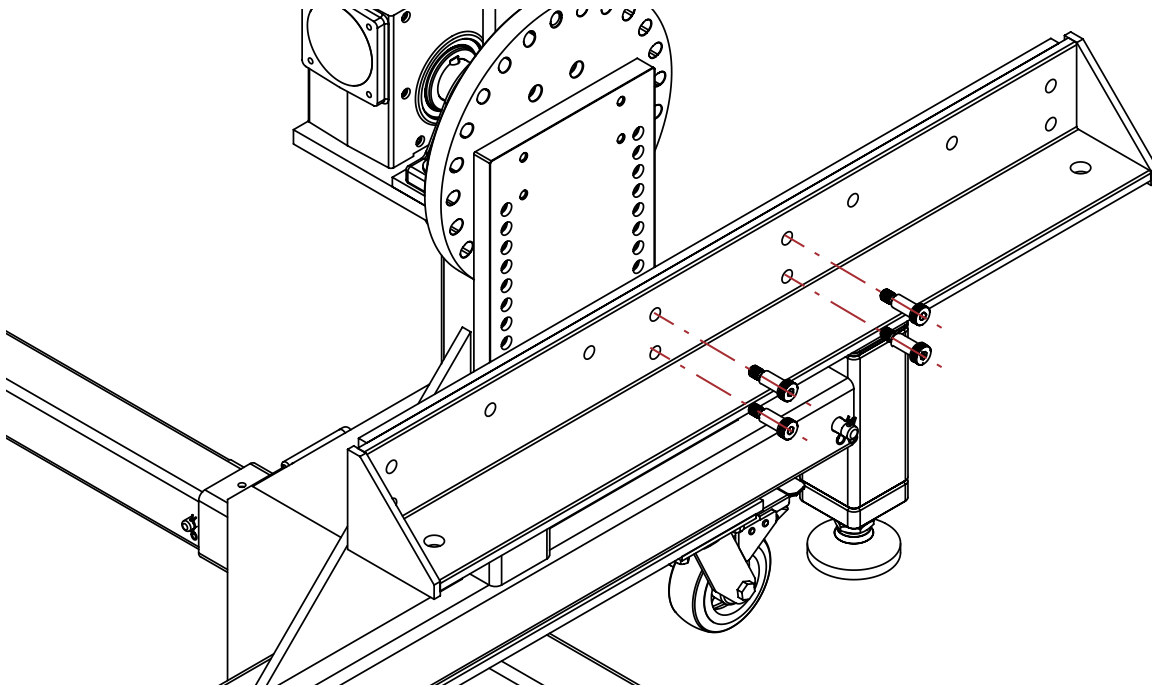
*Figure 6.*

6. Move over to the tailstock end and repeat the last step. The tailstock end can pivot which should make alignment slightly easier.
7. Once both bolts are hand tightened, you can use either a 30 mm or a 1-3/16" wrench to tighten it then use a torque wrench to apply 100 lb-ft of torque.
8. The forklift can now be moved out of the way.



## HEIGHT-ADJUSTMENT PLATE

1. Set forks underneath the table and proceed to remove all the mounting bolts.
2. Move the table away for the time being.
3. Remove the four shoulder screws from the table mounting bracket (Part A.7) as shown in *Figure 7*. Make sure you have assistance in holding the part up so it does not fall to the ground when it is unfastened.
4. Determine which holes on the height-adjustment plate (Part A.9) you would like to change it to and use the shoulder screws you just removed to fasten the table mounting bracket again.
5. Repeat steps 3 and 4 for the tailstock end.
6. Follow the table mounting procedures to get the table back on.



*Figure 7.*

All units are tested and checked before shipping. Optimum performance is best achieved by gradually incrementing the load, up to the full value, over roughly the first 50 hours of its working life. During these early stages, please take precautions to avoid overloading the gearbox.

The provided gearbox is filled with a high quality synthetic lubricant. They are “lubricated for life” and do not require any routine maintenance. In the event that a major overhaul involving strip-down and reassembly of the gear unit, *Table 1* below has a list of approved lubricants. Lubricant quantities are on *Table 2*.

*Table 1: Approved Lubricants*

Supplier	Lubricant Range	Grade 7H
		Oil Suppliers’ Corresponding Designations
Chevron-Texaco	Clarity Synthetic PMO	460 (-23)
Exxon Mobil Corporation	SHC 600 Series	634 (-34)

*Table 2: Lubricant Quantities*

Oil Capacity	
Quarts	Liters
0.96	0.91

BEARINGS

The included bearings use a high-quality lithium complex grease consisting of a lithium complex thickener, mineral oil, and NLGI grade 2 consistency. It is ready to use with no initial lubrication needed. When re-lubricating, it is best to use a lithium complex thickened grease with comparable consistency and base oil properties. The bearings are designed with grease fittings to allow easy lubrication using a hand/automatic grease gun.

It is recommended to lubricated the bearing while it is rotating. It is best to unmount the table and mounting brackets beforehand, so you can turn the shaft easily using the index wheels.

Start by adding one half of the recommended amount on shown on *Table 3*. Turn the bearing continuously for a few minutes, then add the second half of the recommended amount.

*Table 3: Lubrication Specifications*

Grease Charge (Ounces)	Frequency
0.25	4 to 10 months

Follow these guidelines for the safe operation of your Rotary Positioner.



1. To prevent damage to components or any injuries to personnel, make sure welding assembly is secured to table before rotating. Check carefully for any loose parts or tools on the welding tabletop.
2. Operators must be clear of table front and back before rotating.
3. Make sure locking plunger is disengaged before turning hand wheel to prevent damage to plunger.
4. Once you have positioned the table to the desired angle, make sure to engage the locking plunger to prevent unintended movement.
5. Outriggers should be used if the assembly is very tall or top heavy to prevent table from tipping over.
6. Inspect torque (100 lb-ft) on mounting screws before rotating.

## LIMITED WARRANTY

Each Strong Hand Tool® product is warranted to be free from defects in material and workmanship. Call place of purchase if you have any questions.

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