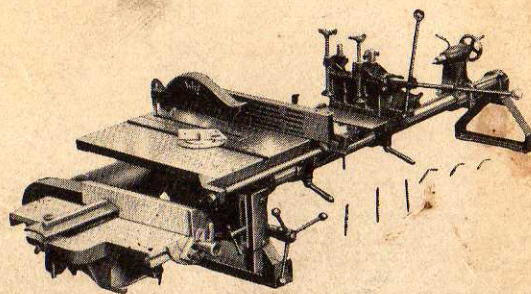


MAJOR

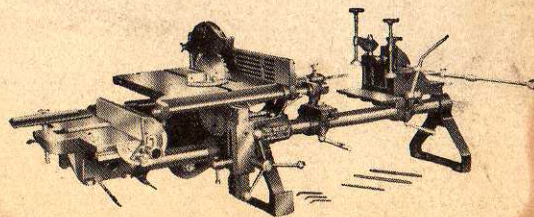


ASSEMBLY INSTRUCTIONS FOR MAJOR & MAJORETTE

The illustrations and instructions in this booklet refer to the Minor and Minorette machines. These instructions also apply to the Major and Majorette machines apart from sizes and the following:

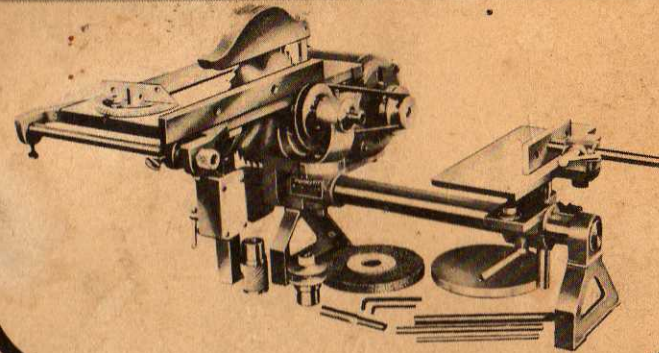
1. The Motor platform for the Major, and Majorette, is assembled from two castings.
2. The Saw table is adjusted by means of a rack and pinion.
3. The Tailstock, and Saddles, are positively positioned by means of spring loaded plungers locating in a groove machined along the Bed.
4. The Headstock on the Major, and Majorette, is fitted with a Taper Pin to locate it in the normal, or swivelled 90°, positions.

MAJORETTE



PRINTED IN ENGLAND

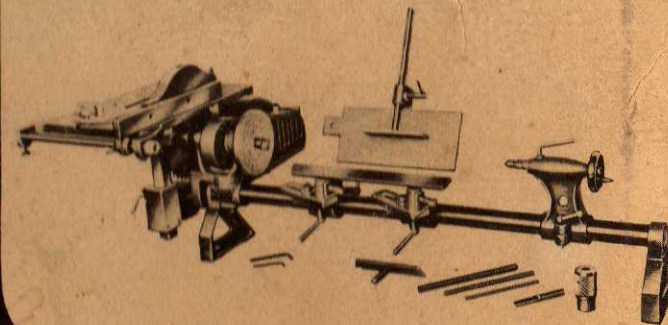
MINORETTE



CORONET

CORONET TOOL CO · ALFRETON RD · DERBY · ENGLAND

MINOR

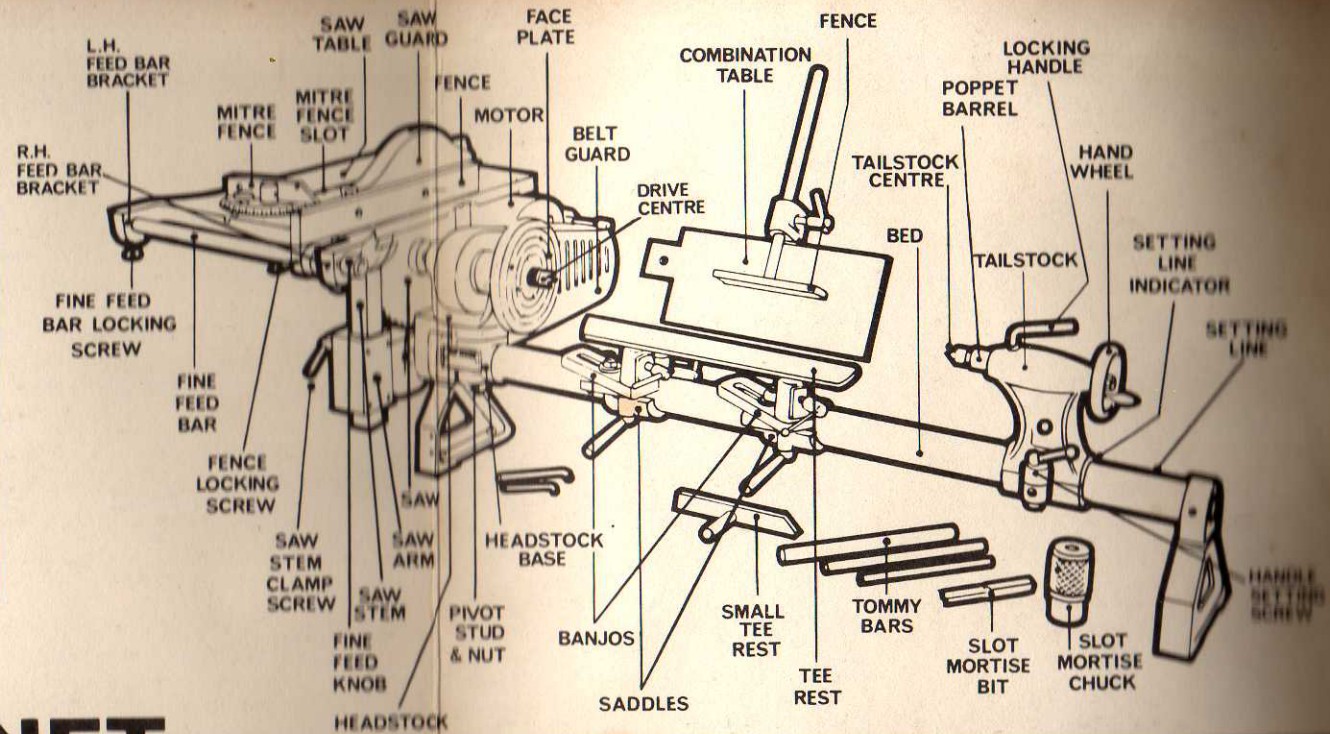


ASSEMBLY INSTRUCTIONS FOR BASIC MACHINES AND ATTACHMENTS

MINOR

BASIC MACHINE

Basically a lathe, supplied with headstock, tailstock, face plate and turning rests. Choice of three bed lengths 2' 6", 3' and 3' 6", giving distances in between centres of 18", 24" and 30". Combination table is moveable to act as panel support with adjustable fence for repetition cutting.



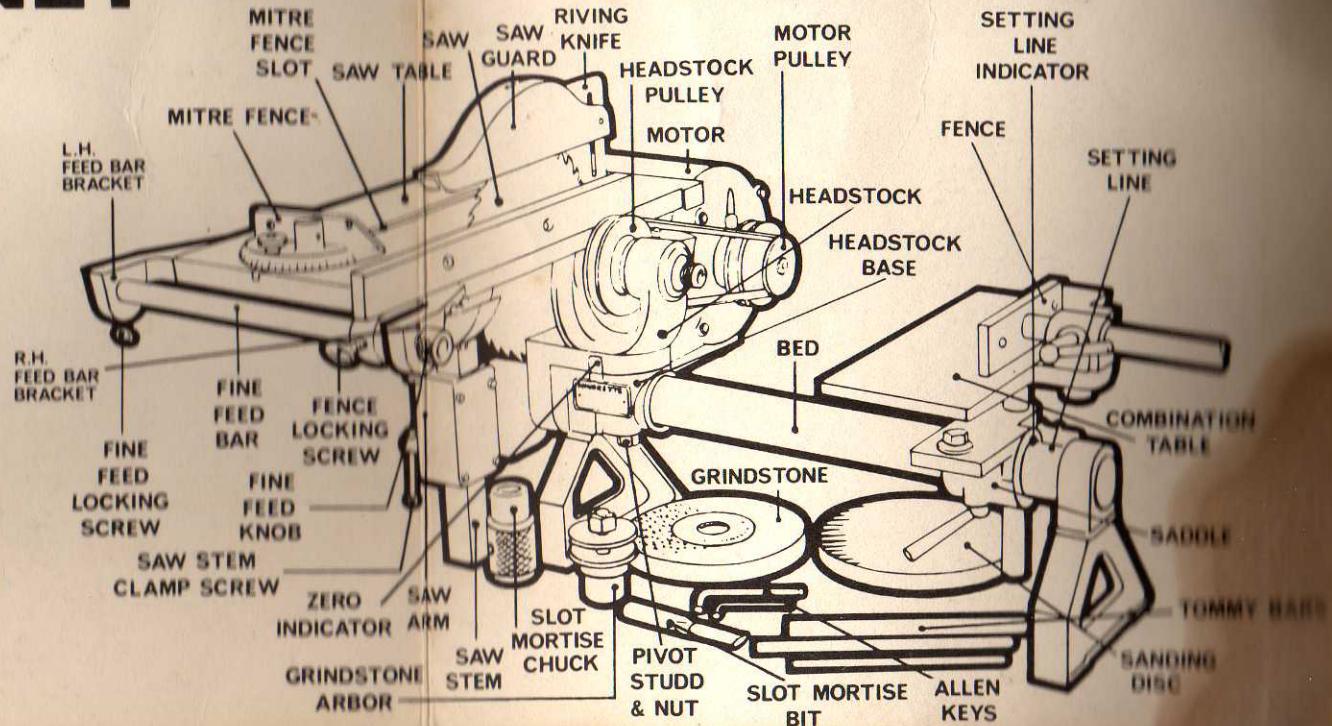
CORONET

MINORETTE

BASIC MACHINE

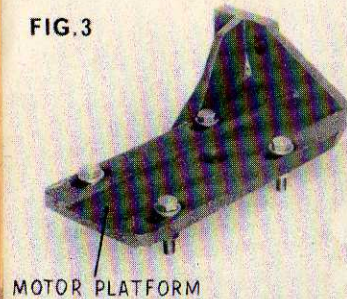
Supplied as power unit complete with circular saw, motor, belt and pulleys, combination tables, grindstone and arbor, disc sanding plate, slot mortising chuck and slot miller bit.

* SEE PAGE 6 FOR DETAILS ON CABINET STAND



ASSEMBLING MOTOR PLATFORM TO HEADSTOCK

FIG. 3



MOTOR PLATFORM

FIG. 4

RIVING KNIFE BRACKET

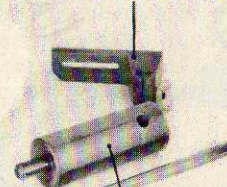
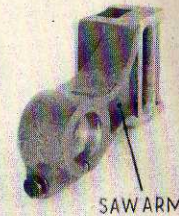


FIG. 5

EXTENSION PIECE



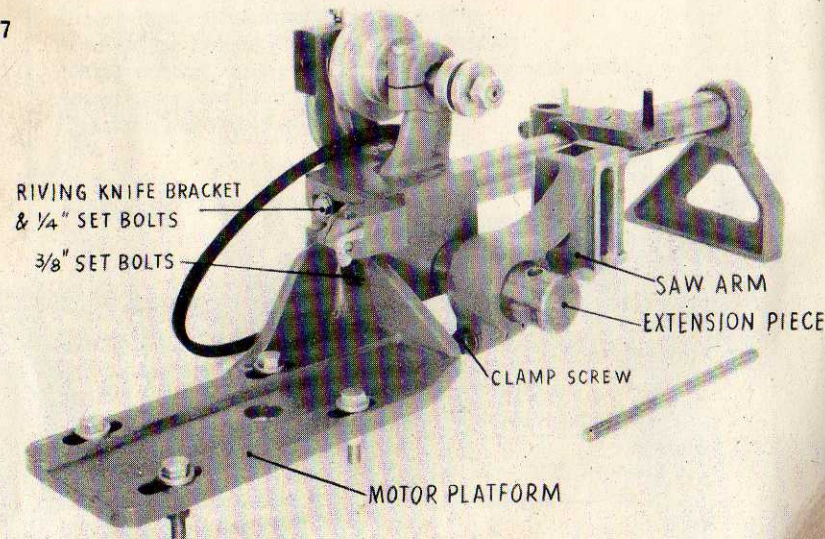
FIG. 6



SAW ARM

For ease of assembly of items shown in Figs. 3, 4, 5 and 6 loosen $\frac{1}{2}$ " pivot nut under headstock (Fig. 1), swivel head 90° to position shown on Fig. 7 — and re-tighten nut.

FIG. 7



See that all faces are clean. Assemble motor platform (Fig. 3) to headstock with two $\frac{3}{8}$ " set bolts; assemble riving knife bracket (Fig. 4) to headstock with two $\frac{1}{4}$ " set bolts; screw short extension piece (Fig. 5) (but if Planer is to be fitted use long extension piece) into headstock and tighten securely with tommy bar; slide saw arm (Fig. 6) on extension piece, place it in approx. position with square slot vertical — tighten clamp screw — as shown in Fig. 7.

FITTING MOTOR, TENSIONING BELT, FITTING SAW BLADE

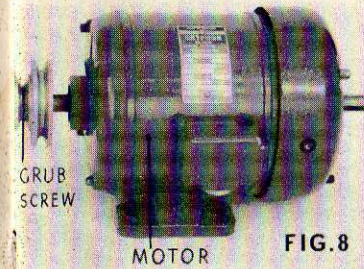


FIG. 8

MOTOR

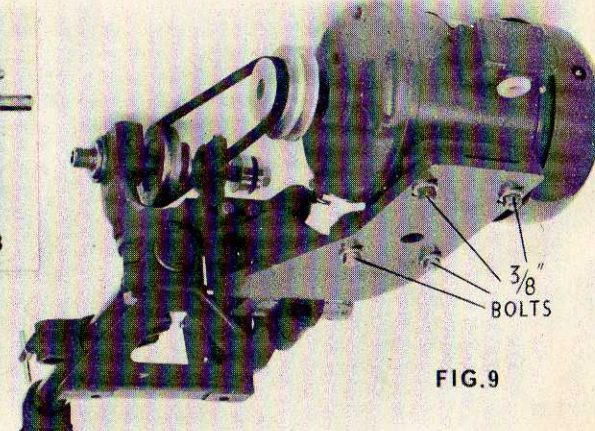
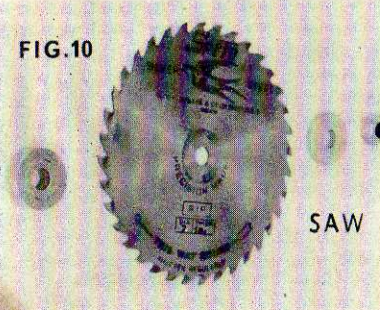


FIG. 9

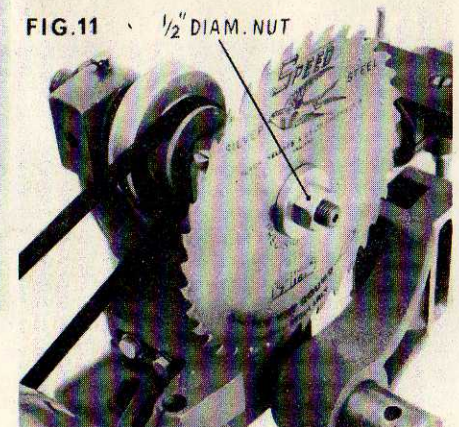
Assemble motor (Fig. 8) on platform with four $\frac{3}{8}$ " bolts, place belt on to either pair of pulley grooves, adjust motor position to give correct belt tension and securely tighten $\frac{3}{8}$ " bolts as shown in Fig. 9. If pulleys on headstock and motor are not in alignment, loosen grub screw on motor pulley (Fig. 8) and re-position, so that the large diameter step on motor pulley is directly in line with small step on headstock pulley, and securely re-tighten grub screw.

FIG. 10



SAW

FIG. 11 $\frac{1}{2}$ " DIAM. NUT



Assemble saw (Fig. 10) to main spindle, place thick collar on spindle with recessed face towards the saw. Place saw on spindle so that the teeth will cut when rotated clock-wise, place thin collar on spindle with recessed face towards the saw; screw on the nut (L.H. thread); hold spindle by means of tommy bar placed through hole in spindle and securely tighten $\frac{1}{2}$ " diam. nut (Fig. 11).

ASSEMBLING & FITTING SAW TABLE



FIG. 12

SAW STEM

INDICATOR FINGER

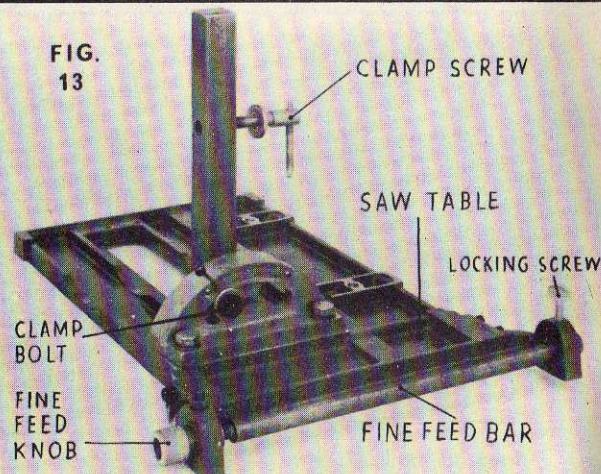


FIG. 13

CLAMP SCREW

SAW TABLE

LOCKING SCREW

CLAMP BOLT
FINE FEED KNOB

FINE FEED BAR

Loosen indicator finger on saw arm quadrant (Fig. 12), assemble saw stem to saw table (Fig. 13), tighten clamp bolt and indicator finger set screw.

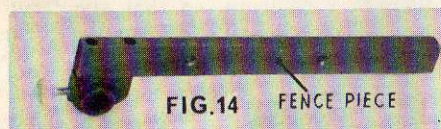


FIG. 14

FENCE PIECE



FIG. 15

MITRE FENCE

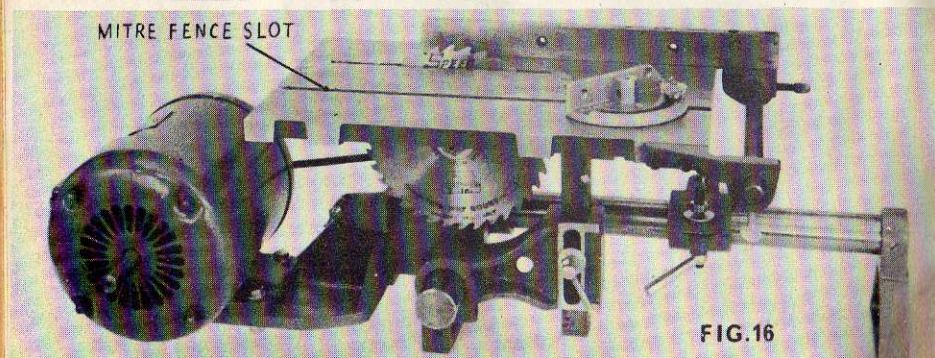


FIG. 16

Remove clamp screw from saw stem (Fig. 13). Lower table over saw until stem enters saw arm (loosen clamp screw on saw arm), adjust position of saw arm so that there is equal clearance on either side of saw with $\frac{1}{8}$ " clearance at front of saw slot at maximum cut (Fig. 18); re-tighten clamp bolt (Fig. 13) securely on saw arm. Unscrew fine feed bar from fine feed knob; slide fence piece (Fig. 14) on to bar, and replace fine feed knob. The Mitre fence (Fig. 15) fits into slot in surface of saw table as shown in Fig. 16.

Checking Saw Table alignment & fitting Combination Table

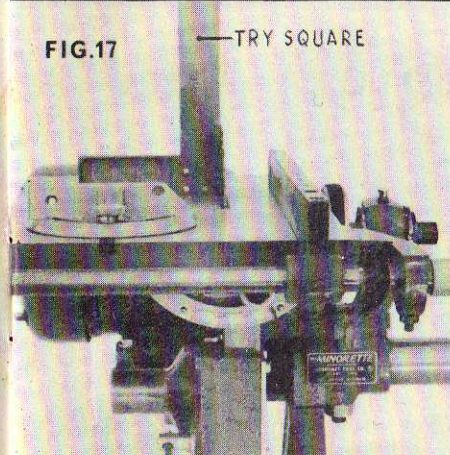
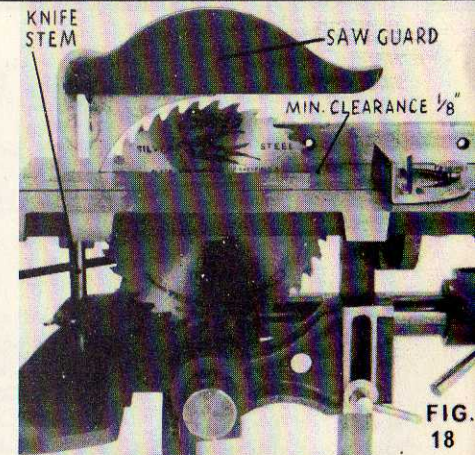


FIG. 17

TRY SQUARE



KNIFE STEM

SAW GUARD

MIN. CLEARANCE $\frac{1}{8}$ "

FIG. 18

Adjust saw table to lowest position — place Try square on saw table against side of saw (Fig. 17); loosen clamp bolt (Fig. 13) which secures saw arm to saw table and adjust table until it is at right angles to the saw — re-tighten clamp bolt.

Position indicator finger (Fig. 12) on to zero degrees and re-tighten its securing screw. Remove screws and Insert Plate from top of saw table. Adjust saw table to highest position. Loosen $\frac{1}{4}$ " set bolts securing knife bracket to headstock. Lower saw guard with riving knife through table slot until stem enters riving knife bracket. Adjust knife in line with saw and clearing it by approx. $\frac{1}{8}$ " and securely tighten $\frac{1}{4}$ " set bolts and thumb screw on knife bracket. Replace insert plate on table (Fig. 18).

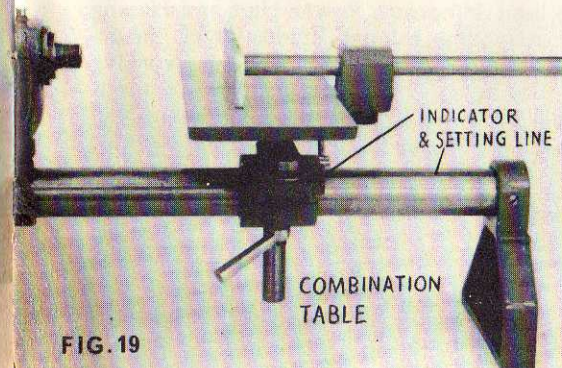


FIG. 19

INDICATOR & SETTING LINE

COMBINATION TABLE

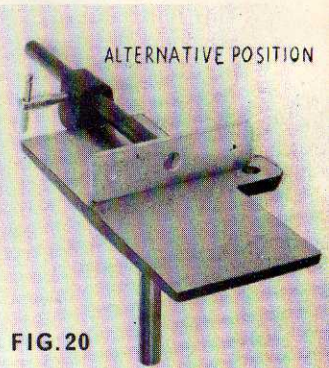


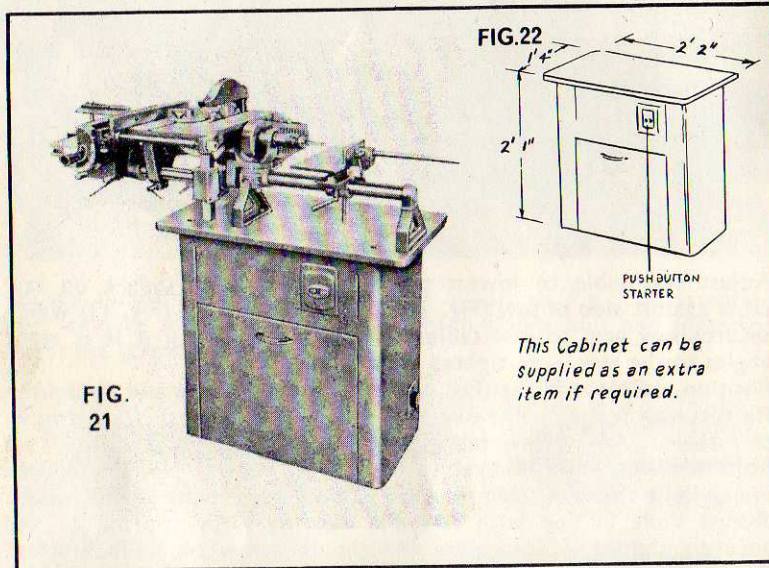
FIG. 20

ALTERNATIVE POSITION

Assemble cross fence to combination table (Fig. 19). Loosen clamp screw on saddle. Lower stem of combination table into bore in saddle and re-tighten clamp screw (Fig. 19). Alternative position for combination table fence is shown in Fig. 20.

CABINETS

MINORETTE POWER UNIT MOUNTED ON CABINET STAND (M13)



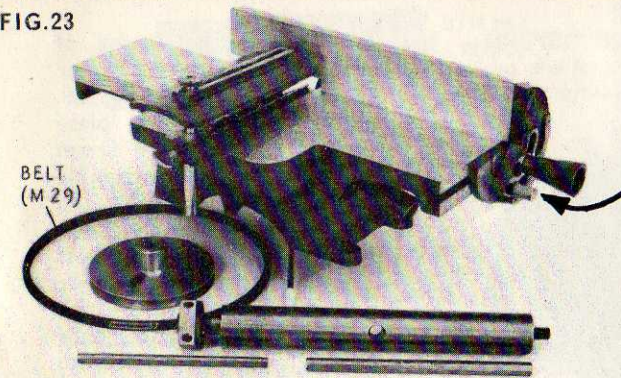
This illustration shows the basic Minorette Power Unit and Planing attachment mounted on attractive cabinet stand which incorporates a storage compartment and polished wooden working surface. The addition of this cabinet makes the machine compact, self-contained and a pleasure to own and use. Keep it clean, well oiled and adjusted, and it can give you many years of pleasurable and profitable use (Figs. 21 & 22).

COMPLETE VERSATILITY

Its versatility can be further increased by the addition of various attachments designed especially for the basic machines. Some of these are shown on the pages which follow.

FITTING PLANER ATTACHMENT

FIG. 23



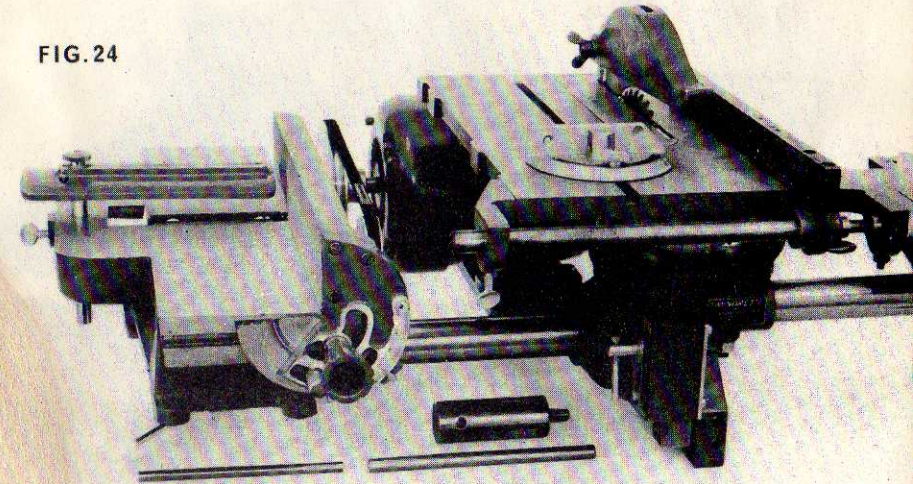
The fence can be tilted 45° left or right by positioning the knurled screw in the appropriate hole.

4 1/2" PLANER ATTACHMENT

Supplied complete with motor pulley, Vee belt, long extension piece with special nut and washer, tommy bars, adjustable fence and cutter guard as illustrated in Fig. 23. To attach to basic machine, remove saw table, saw arm and short extension piece. Screw long extension piece into headstock and tighten securely with tommy bar. Remove nut and washer from extension piece, place Planer in position with threaded end of extension piece projecting through slot in base of Planer, and secure with washer and nut.

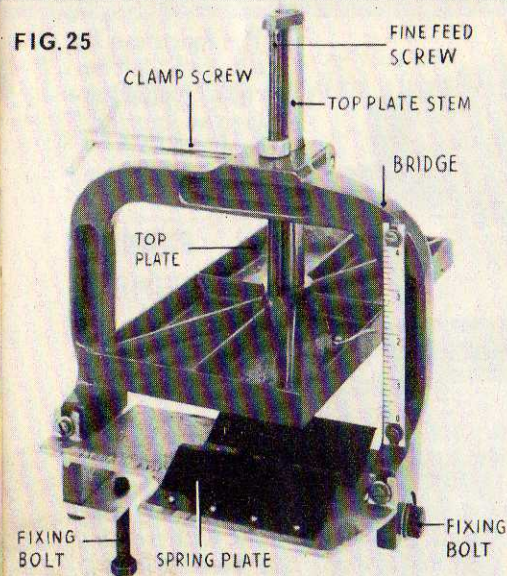
Fit pulley on to motor shaft in alignment with Planer pulley. Fit belt, and adjust position of Planer so that it is level, and belt tension is correct. Finally, tighten securely special nut by means of the tommy bar.

FIG. 24



4 1/2" PLANER FITTED TO MINORETTE

Information regarding adjustment of cutters is given on page 17.



THICKENING ATTACHMENT FOR 4½" PLANER

Subsequent removal from, or re-fitting to the Planer, can be accomplished in a few seconds, merely by means of the two ⅜" securing set screws.

Assembly and fitting of thickener to 4½" Planer as illustrated in Fig. 26. Place stem of top plate through bridge from underside and assemble with fine feed screw and clamp bolt. Adjust front table of Planer to lowest position. Remove fence and cutter guard. Fit bridge assembly to Planer and lock in position with two ⅜" set screws supplied. Attach spring plate to bridge by means of the two set screws. Plate should rest flat on front table. Lower top plate until it touches Planer rear table and set pointer to zero mark on scale.

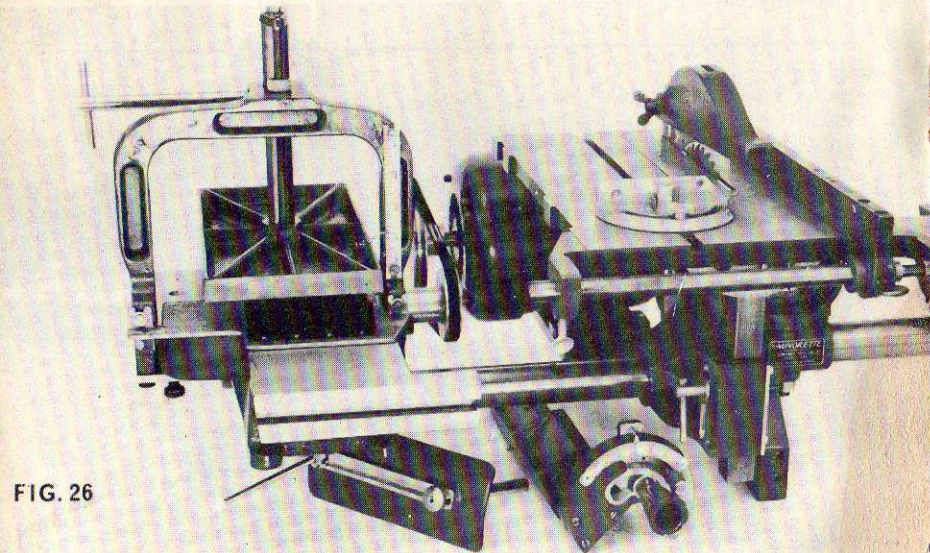


FIG. 26

THICKENER FITTED TO PLANER ON MINORETTE



FIG. 27

SUPPORT BRACKET (M10a)
also used for large Turning (See page 10)

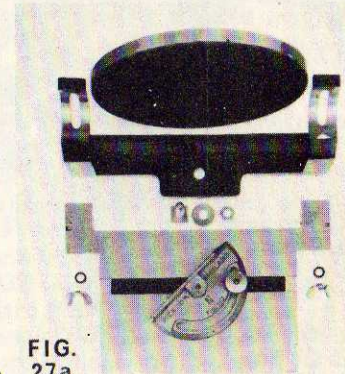


FIG. 27a

TILTING SANDING TABLE (M520)

To assemble items shown in Figs. 27 and 27a on Minor or Minorette, loosen ½" nut on pivot stud (Fig. 1). Rotate headstock assembly 90° to position shown in Fig. 27b and re-tighten nut. Screw sanding disc on to spindle nose (Fig. 2); assemble support bracket (M10a) and tilting sanding table to headstock leg as shown in Fig. 27b.

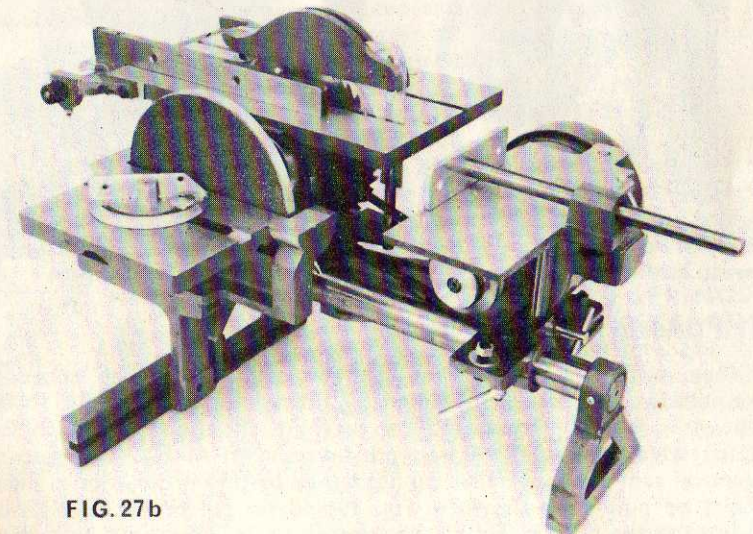


FIG. 27b

SUPPORT BRACKET (M10a) & TILTING SANDING TABLE FITTED TO MINORETTE

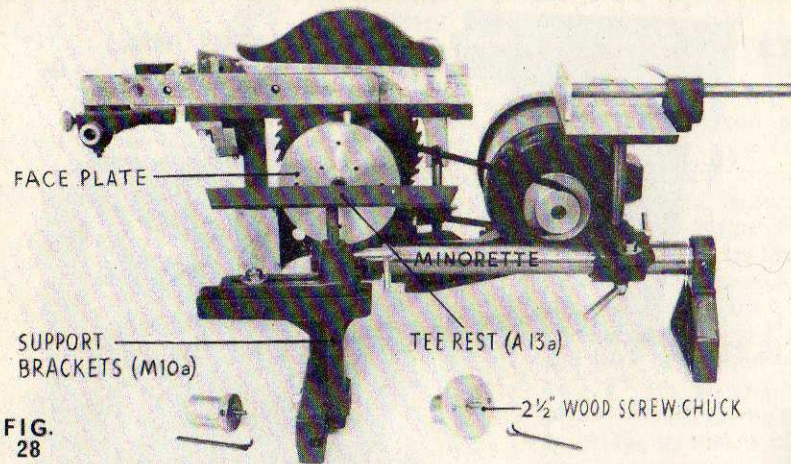


FIG. 28

Used for turning larger articles up to about 12" diam. Use either face plate or 2 1/2" wood screw chuck — on the latter, workpiece can be held more securely by fixing two additional woodscrews through holes in chuck.



FIG. 29

SPEED REDUCING COUNTERSHAFT FOR LARGE DIAMETER TURNING (M19)

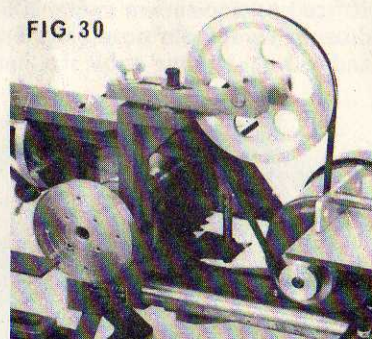


FIG. 30

IMPORTANT

When turning articles larger than 7" diam. a reduced speed is required. This can be obtained by fitting the countershaft (M19) shown in Fig. 29. To assemble to machine, tilt the saw table to 45° left, swivel headstock 90° to position shown in Fig. 30. Secure vertical arm of countershaft to headstock by means of set bolt, place belts on pulleys as shown in Fig. 30 and set to correct tension by adjusting the thumb screw. Articles up to 14" diam. can be turned on either the Minor or Minorette when using these attachments (M10a (Fig. 27) and M19). SEE ALSO PAGE 18.

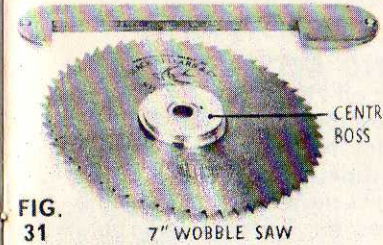


FIG. 31

FIG. 31 7" diam. WOBBLE SAW (For grooving, rebating, etc.) AND TABLE INSERT.

The centre boss is marked in graduations from 0 to 9 and the saw can be rotated in relation to this boss, in order to cut a rebate, or groove, varying in width from the saw thickness up to approx. 3/4".

When required for use, the wobble saw and special table insert are fitted to the machine in place of the standard saw and table insert.



FIG. 32
COMBING JIG
(front & rear view)

FIG. 32 COMBING JIG (fixed to standard Mitre fence).

In conjunction with the wobble saw, this attachment can be used for producing box combed articles. The fingers are adjustable to suit the width of slot required and the saw table height is adjusted to give the correct depth of cut. The workpiece is held against the face of the jig and is passed over the saw. For example, four sides of a box 6" deep can be completely combed in a matter of minutes. (Note—Wood insert can readily be replaced).

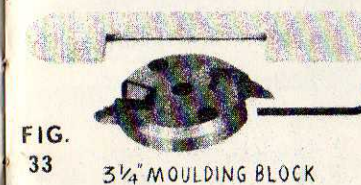


FIG. 33

3 1/4" MOULDING BLOCK

FIG. 33 3 1/4" MOULDING BLOCK AND CUTTERS WITH TABLE INSERT.

Twelve different pairs of cutters are available for use in this cutter block. When fitted to the machine in place of the standard saw, spindle moulding can be quickly and easily carried out.

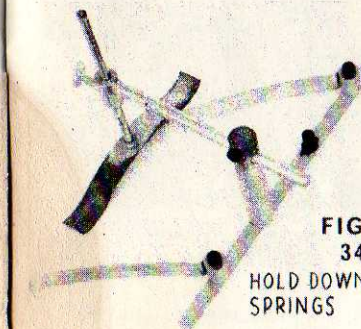


FIG. 34

HOLD DOWN SPRINGS

FIG. 34 HOLD-DOWN SPRINGS - for use with moulding block. This attachment can be fitted into the slot of the saw table and adjusted to securely guide the workpiece being fed into the cutter — a very useful accessory for the production of long or short lengths of mouldings.

*Full instructions for combing are given in Minorette Price List — available on request.

TURNING ACCESSORIES & LONG HOLE BORING ATTACHMENT

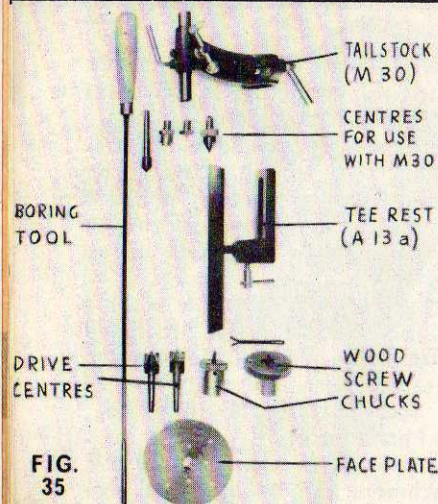


FIG. 35

FIG. 35 TURNING ACCESSORIES

— for use on Minorette.

The Minorette in addition to its capacity for turning diams. up to 12" can, if desired, by the use of attachments shown in Figs. 28 and 29 be used for turning work up to 11" long between centres by fitting the special Minorette tailstock, banjo and tee rest, and any of the centres, face plate, or wood screw chucks shown in Fig. 35. The hollow poppet barrel of this tailstock can be removed and reversed, to allow the use of either no. 1 morse taper shank centres, drill chucks, etc. or, the

special threaded centres illustrated (Fig. 35). $\frac{5}{16}$ " diam. holes can be bored through the axis of the rotating workpiece by removing the normal tailstock centre and fitting the hollow centre, which acts as a drill bush to guide the long hole boring tool.

FIG. 36 LONG HOLE BORING ATTACHMENT for use on Minor (1 and 2) and M.14 steady for slender work (3). Long hole boring cannot be done through the Minor tailstock, because the spindle is solid. This operation can be done by fitting the attachment (Fig. 36-1) to the saddle banjo.

The attachment consists of three main parts, a hollow ring centre which screws into the main body and a centre finder. The centre finder placed in the tailstock is used to position accurately the attachment, which is then locked to the saddle. The hollow centre is then screwed forward to form a register on the workpiece, and locked in position with the thumb screw. The tailstock and centre finder are then withdrawn from the attachment and re-positioned on the bed to allow the boring tool to pass through the hollow centre.

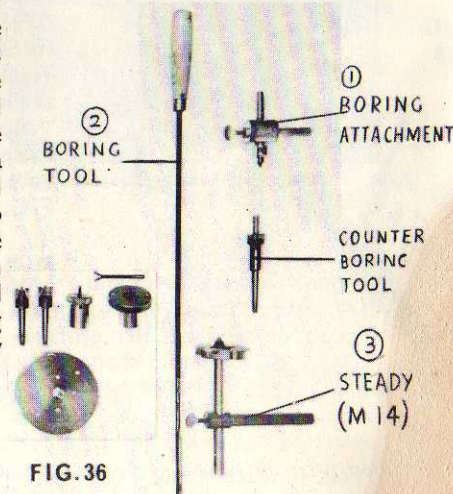


FIG. 36

*Full details for long hole boring are given in Minorette Price List — available on request.

FITTING SLOT MORTISING ATTACHMENT & RANGE OF BITS

CONTINUED FROM PAGE 12

THE M14 STEADY (Fig. 36-3) is fitted to the saddle and is fully adjustable in all directions. It has four different sizes of vee grooves, making it suitable for the support of a variety of slender work.

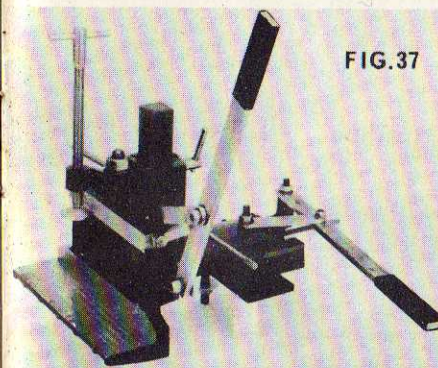


FIG. 37

SLOT MORTISER

FIG. 37 SLOT MORTISING ATTACHMENT (M15).

This unit can be quickly bolted to the saddle and can be used on the Minor or Minorette. It incorporates a rise and fall table and is fitted with adjustable, positive stops, for depth and width of cuts. The workpiece can be securely clamped in position and repetition production quickly and accurately performed. The slot mortise chuck, which screws on to the nose of the headstock spindle will accept a full range of cutters including $\frac{1}{8}$ ", $\frac{3}{16}$ ", $\frac{1}{4}$ ", $\frac{5}{16}$ ", $\frac{3}{8}$ ", $\frac{1}{2}$ ", $\frac{5}{8}$ " diam.

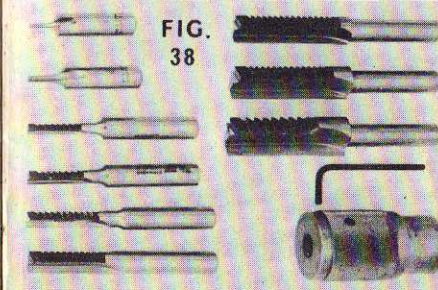


FIG. 38

CHUCK AND CUTTERS

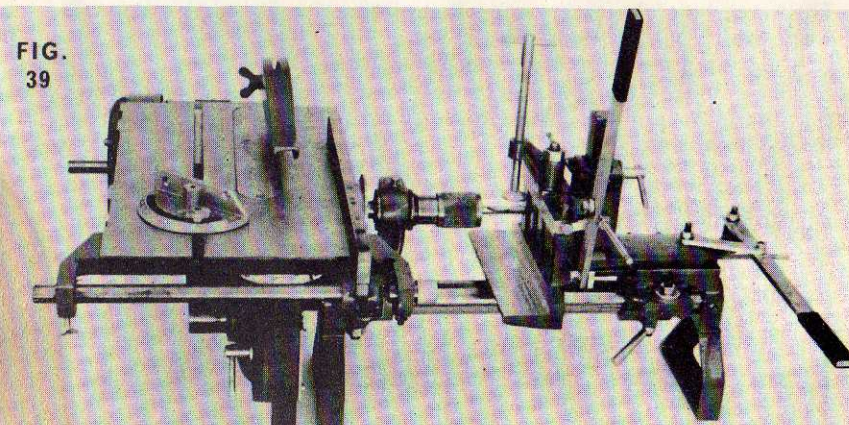


FIG. 39

SLOT MORTISER, FITTED TO MINORETTE

FITTING THE BANDSAW

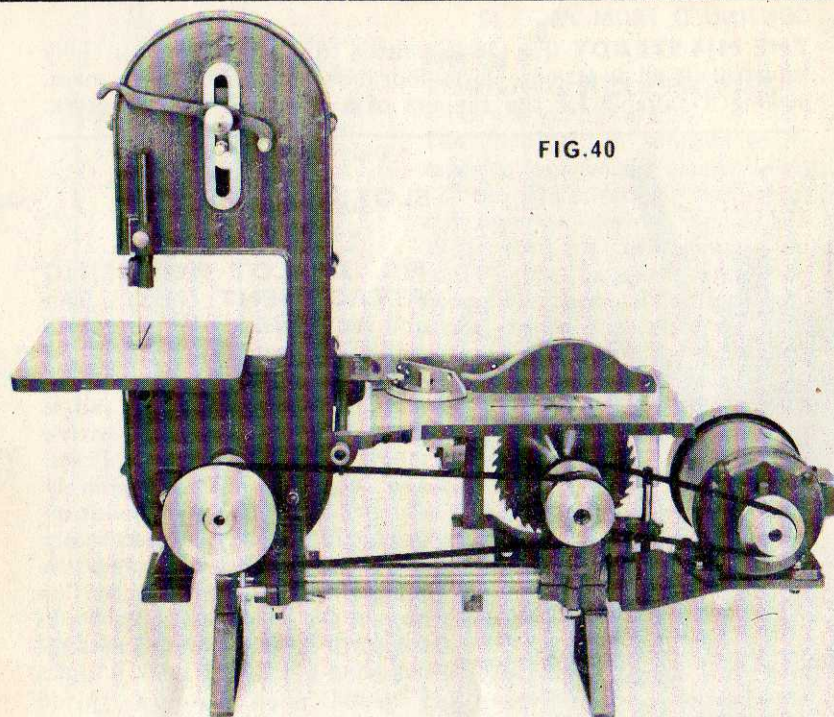


FIG. 40

IONIC 8" BANDSAW (M11) fitted to Minorette

This most helpful attachment will considerably extend the scope of work which can be done on the basic Minor or Minorette (it can also be used on the Major lathe — although the larger Classic Bandsaw is more suitable due to its greater capacity). Alternatively the Bandsaw can be used with its own motor as an entirely independent unit.

CAPACITIES

Maximum depth of cut $3\frac{1}{4}"$	Length of blade 59"
Depth of throat 7"	Width of blade $\frac{1}{4}"$ or $\frac{3}{8}"$

GUARDS - for belts, planer grindstone & undersaw BELT SANDER

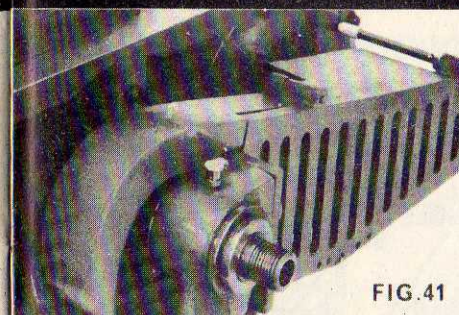


FIG. 41

BELT GUARD

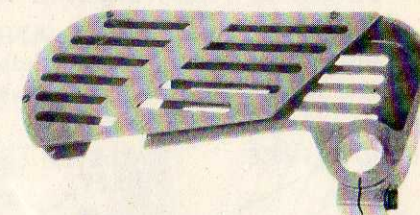


FIG. 41a

PLANER GUARD

Specially designed guards enable belts to be changed without completely removing guard. Simply lift front of guard and side guard can be swung clear. Spring loaded for added safety.

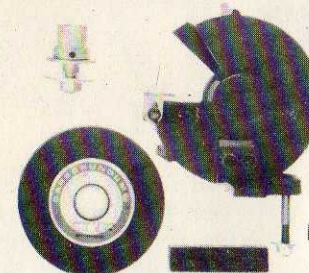


FIG. 42

GRINDSTONE GUARD

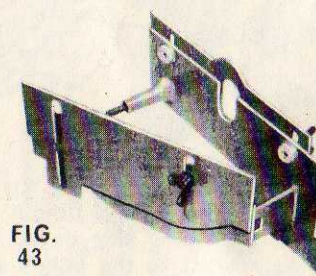


FIG. 43

UNDERSAW GUARD

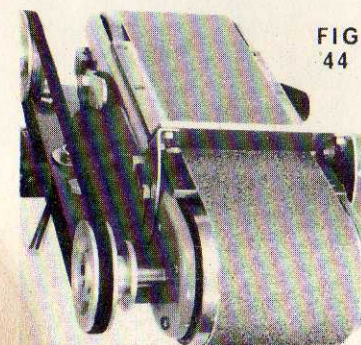


FIG. 44

BELT SANDER

This unit is fitted in seconds. Simply position the unit and bolt on to saddle. Screw vee belt pulley on to spindle nose. Line up sander and nose pulleys. Fit and tension belt. **Important** - Belt sander should be used on slow speed, i.e. belt on small motor pulley, large pulley on headstock spindle. $4\frac{1}{2}" \times 36"$ belt ensures a perfect finish to flat and radiused surfaces.

IN THE INTERESTS OF YOUR SAFETY (and to comply with regulations which are enforced in some parts of the world) it is advisable to fit guards to cover all belts and rotating parts (see Figs. 41, 41a, 42 and 43).

MACHINE MAINTENANCE & ADJUSTMENTS

HEADSTOCK SPINDLE AND MAIN BEARING ADJUSTMENT— keep the machine clean, and the main bearing adequately lubricated with a medium grade oil (S.A.E. 30 or equiv.).

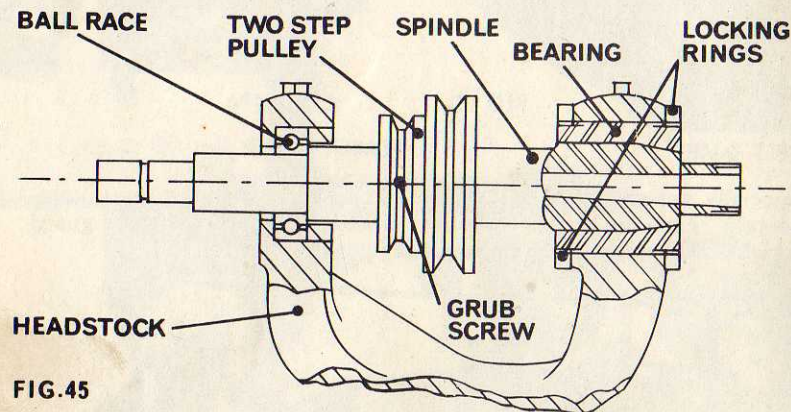


FIG. 45

Check the main spindle for any sign of looseness in the headstock bearing. Adjustment is simple. Remove the belt from the pulley, release the locking ring on rt. hand side of the bearing. Tighten the ring nearest to the pulley until all "play" is removed, but the spindle should still turn freely — then re-tighten the other locking ring.

TO REPLACE A WORN BELT — remove the saw and saw washers, then replace the left hand nut only, screw on to the spindle until its outer face is level with the end of the shaft to prevent damage to the threads. Remove belt from pulleys and loosen grub screw in headstock pulley. Unscrew the inner locking ring completely and push the bronze bearing into the headstock until no threads are visible. With the locking ring located inside the recess in the face of the pulley, slide both along the spindle until the pulley butts against the headstock casting. Cut two pieces of wood of equal length, which, when placed along opposite sides of the spindle, will just go between the face of the pulley and the side of the ball race; the object being to leave the ball race in position whilst driving out the spindle. Place a piece of wood against the L.H. nut to avoid damage and drive the spindle through until it is out of the rear ball race. After removing the L.H. nut, the spindle can be withdrawn until the old belt can be removed and replaced with the new one. The bronze main bearing will also be withdrawn with the spindle. When re-assembling, ensure that the key which prevents rotation of the bearing is correctly positioned.

4½" PLANER ADJUSTMENT (see fig. 46)

It is important that both blades are adjusted to ensure an equal depth of cut. This can easily be tested with a piece of straight wood, or wooden rule, on which two marks have been made about $\frac{1}{8}$ " apart. When lightly held on the rear table with the first mark level with the front edge of the table, slow rotation of the cutter block should cause each blade, at all positions along its length, to move the wood forward and leave it with the second mark level with the table edge. The rear table, (if adjustable), should always be locked at a height which will satisfy this test and the blades adjusted accordingly.

BLADE ADJUSTMENT

Blade adjustment should be carried out by just slackening the 3 Allen screws which clamp each blade, and turning jacking screws with screwdriver, clockwise to lower blades, anti-clockwise to raise blades.

When setting blades, always ensure that the left end of blades (rebating end) projects approx: $\frac{1}{32}$ " beyond side of rear table. The reason for this is to ensure clearance between machined work and rear table side when rebating.

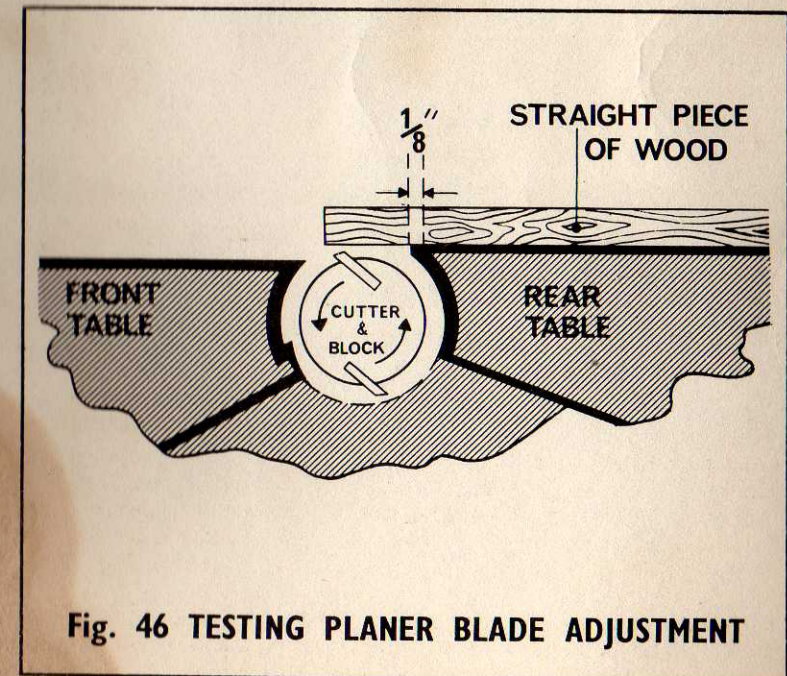
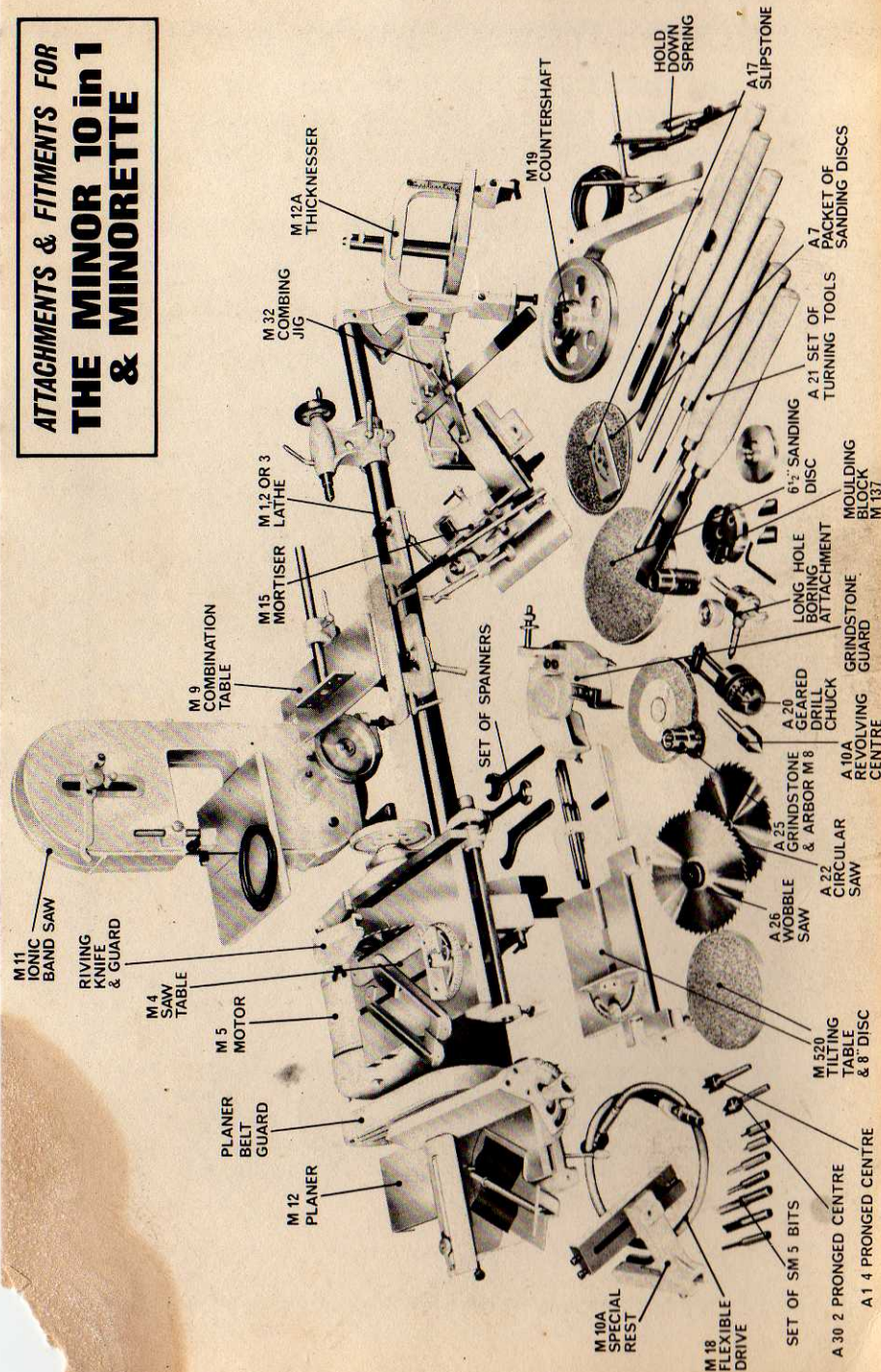
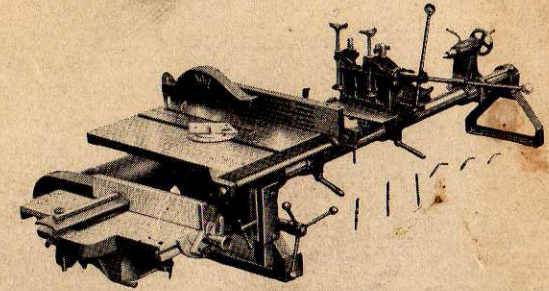


Fig. 46 TESTING PLANER BLADE ADJUSTMENT

ATTACHMENTS & FITMENTS FOR THE MINOR 10 in 1 & MINORETTE



MAJOR

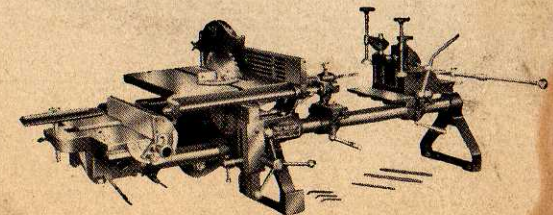


ASSEMBLY INSTRUCTIONS FOR MAJOR & MAJORETTE

The illustrations and instructions in this booklet refer to the Minor and Minorette machines. These instructions also apply to the Major and Majorette machines apart from sizes and the following:

1. The Motor platform for the Major, and Majorette, is assembled from two castings.
2. The Saw table is adjusted by means of a rack and pinion.
3. The Tailstock, and Saddles, are positively positioned by means of spring loaded plungers locating in a groove machined along the Bed.
4. The Headstock on the Major, and Majorette, is fitted with a Taper Pin to locate it in the normal, or swivelled 90°, positions.

MAJORETTE



PRINTED IN ENGLAND