



# INSTRUCTIONS FOR #66225 LEVER KIT

## INSTRUCTIONS FOR ADDING #66225 QUICK RELEASE LEVER

This kit contains a #66223A lever, and #66224 stud for installation on all 2075, 2001, and 680 series VFGM. You will need a small amount of thread locking compound (#242 Loctite or equivalent) to install this kit.

1. Unplug the machine to prevent accidental operation while working on it.
2. Remove the nut, washer, and dressing tool from the machine.
3. Remove the existing stud from the carriage plate. It may be necessary to heat the stud slightly to loosen the thread retaining compound.  
Do not use an open flame to heat stud!
4. Add a small amount of thread locking compound to the large thread of the new stud and screw into the carriage until the thread bottoms. Be careful to not damage the small threads on the stud.
5. Replace the dressing tool and large washer.
6. Add the new lever to the stud. You may use the aligner wrench in the socket on top of the lever to run the lever down.
7. Lift up and turn the lever to index the handle to a convenient position. The lever should just clear the chuck cover when tightened.
8. One-quarter turn of the lever should provide enough clearance to swivel the dressing tool out of the way. If the tool cannot be moved with this amount of clearance, it will be necessary to level the top of the bracket by grinding or milling it parallel to the bottom.

**SIOUX  
TOOLS INC.**



# PARTS LIST FOR 2075 DRESSING TOOL

FURNISH CATALOG SERIAL & MODEL NUMBER WHEN ORDERING PARTS

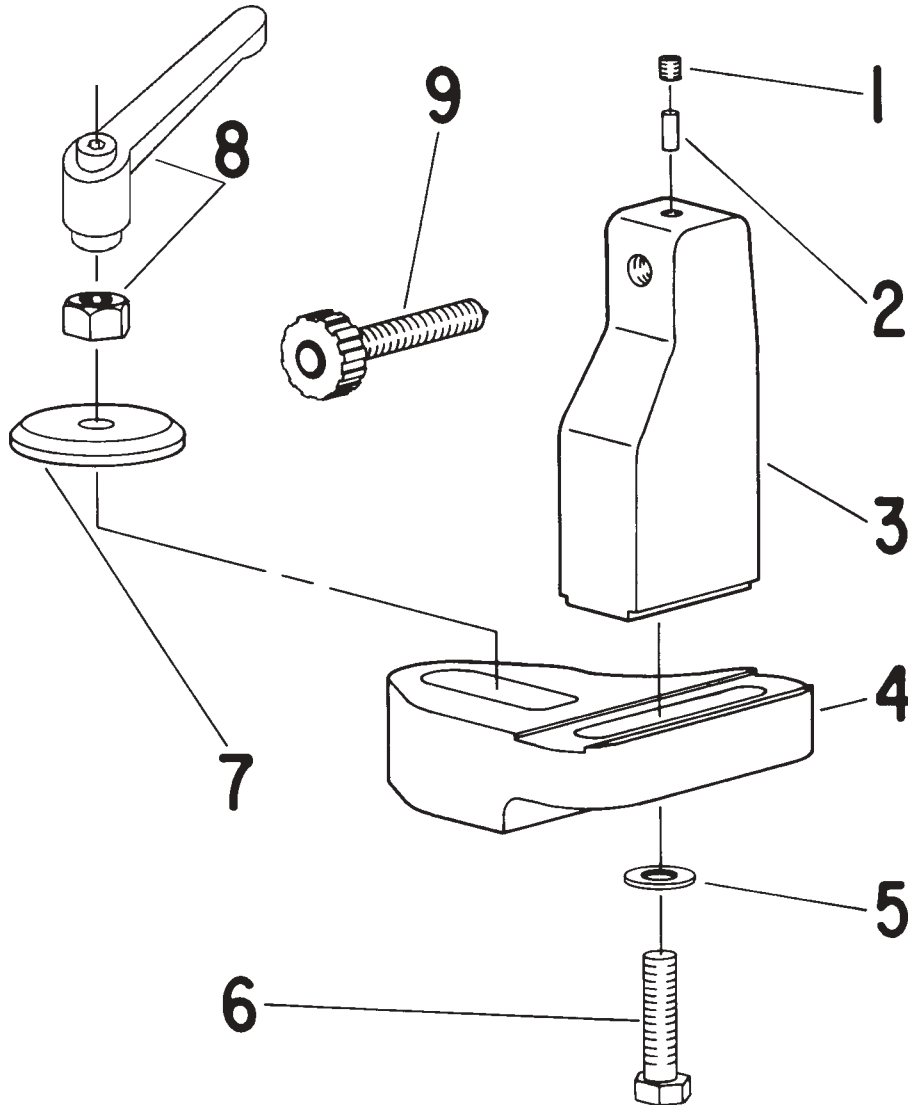


Fig. No.	Part No.	Name
1.	08001	Screw—Set
2.	04253	Slug—Friction
3.	11460	Post—Diamond Holder
4.	11421	Base—Dressing Tool
5.	25403	Washer

Fig. No.	Part No.	Name
6.	09106	Screw—Hex Hd. Cap
7.	54443	Washer
8.	09590	Nut—3/8" (Older Units)
	66223A	Lever 5/16" Thread (Newer Units)
9.	1715	Diamond—Dressing
	63283	Ass'y—Complete (Includes Fig. 1-6 & 9)

## SIoux TOOLS INC.

2901 FLOYD BOULEVARD ■ PO BOX 507 ■ SIOUX CITY, IOWA 51102-0507 ■

Printed In U.S.A.