

This all started when I acquired a Coronet Major Lathe a few weeks ago - until I got it home and checked all of the bits that came with it, I didn't realize how lucky I had been, given the price I paid for it.

It had loads of attachments, some of which I could identify (planer / thicknesser, saw, combi table, motor with speed reduction gearbox etc) and some others that I couldn't as they were quite a jumble (see **Plate 1**).



Plate 1 - a Jumble of bits.

I started to strip, clean & adjust where required and found the machine in really good condition. I painted the stripped bits as I went with some Tekaloid coach enamel (I use this stuff on any of my machines as it really is the dogs). I bought this in RAL 3005 colour which is, I am given to understand, the original factory applied colour.

I knew that I was missing a part or two but I didn't know precisely what said parts were or what they looked like (you don't know what you don't know). I tried all over to get a parts list or an exploded diagram of the major and accessories but there doesn't appear to be one available (unless someone can tell me differently) and I bought a manual from Derek Pyatt in the hope that I could figure out exactly how attachments such as the planer are fitted to the machine. I have since downloaded every photo of the Major that I could lay my hands on and have studied each photo for clues as to how it all goes together but I was still in the dark with some of the components.

I hit a problem, which held up the whole shooting match, in that I was missing the circular threaded collar that fastens the planer onto the Mounting Bar. I did try D. Pyatt but unfortunately he didn't have one.



Plate 2 - Mounting bar showing the threaded stud for attaching the Planer

So, I measured the threaded 'stud' which protrudes from the mounting bar (See **Plate 2**) and found it is $\frac{3}{4}$ " x 20 TPI (threads per inch) which is a BSC (British Standard Cycle) thread. At $\frac{3}{4}$ " Diam., this fine thread may seem out of place however I have to say the Coronet design is first class and when you consider that this is the one and only fastener which attaches the planer to the main body of the machine, then this fine a thread should not work loose whereas a coarser thread, such as BSF or Whitworth, possibly would.

I did think about buying a Saw Table Mounting Bar I saw (sic) at £33 on eBay which was complete with threaded collar but I reckoned this was an expensive way to get what I needed particularly so when I have a half decent workshop at home. I came up with what I thought was a cunning plan to solve the problem and considered unscrewing the threaded 'stud' from the bar and either making an adaptor piece or turning up a new threaded stud - this meant tapping out the hole in the main casting but at least it would be a thread that I have a tap / die for. It also meant turning up a threaded collar (I had a bit of EN8 steel ideal for the purpose) however, before I started with this idea which I think remains very feasible, I had a poke around in my odds & ends box of taps & dies and lo & behold, I found a $\frac{3}{4}$ " x 20 TPI tap. Bingo - problem solved. I only needed to make a threaded nut and a washer or two on my Myford ML7 lathe which would complete the job.

As I didn't consider you specifically need a circular collar, I used a spare piece of Hex bar (on which a $1\frac{1}{8}$ " AF spanner fits) and in the scrap bin I found a couple of 5.7mm thick washers (see **Plate 4**), left over from some laser hole cutting and used these. The Hex bar I bored out to 18mm ID and then tapped it $\frac{3}{4}$ " BSC (see **Plate 3**) and it all fitted beautifully on the bar stud (see **Plate 5**).



Plate 3 - Tapping the nut



Plate 4 - Completed mounting nut and 5.7mm thick washer

Something which really frustrated me was that I could not find anywhere a photo or diagram showing exactly how the planer is attached to the mounting bar. I must have trawled through hundreds of photos to no avail. So, I have included a photo here (**Plate 5**) taken from underneath which shows exactly how the planer is mounted which I hope others may find useful.

FYI:

I used another washer on the other side of the planer mounting to line up the motor / planer pulleys.

FYI-2

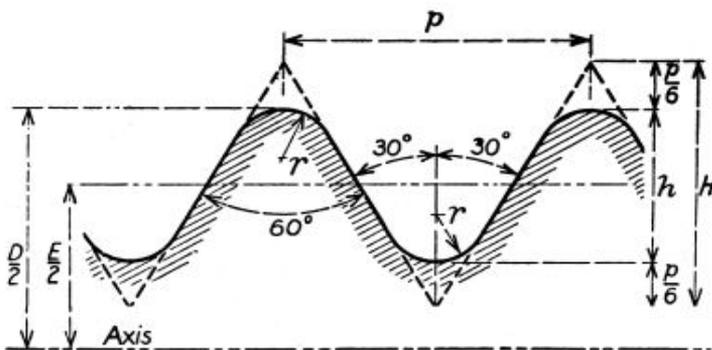
Within the next few weeks, I intend to replace the planer bearings and will do a write-up of how I went about it and which bearings I found to fit.

Just in case you decide to follow the route I took, or perhaps get someone to do it for you, **Diag.1** shows the BSC threadform; you can buy taps or dies of this size through RDG Tools / Chronos at <https://www.rdgtools.co.uk/> / <https://www.chronos.ltd.uk/>



Plate 5 - Completed mounting nut and 5.7mm thick washer

If you find you need any further info you can contact me at mail@butnben.net or via Pete at the Boleyn Workshop.



Diag. 1 - BSC Threadform

FYI: There is also a UNEF (Unified Extra Fine) thread which has the same 60° threadform (see Diag. 1)

Footnote

I am also missing the nut to fasten the saw blade onto the main spindle which is a LH thread. I don't need the saw at the moment but I will need to find a nut fairly soon. I don't fancy trying to make a LH nut on the Myford as screwcutting is not really my main forte, so if anyone has one for sale I would appreciate a call.