Kit consists of the above components. Check to make sure you received everything.
Place the column on the floor with the top away from you. Place the key in the saddle's slot as shown above. The vertical slot will not be used.

Place the adaptor block over the pin on the saddle so that its slot mates with the key. The set screw on the block should be down.
Tighten the set screw with an allen wrench. The adaptor block will be drawn down tight onto the saddle. The key will project out of the side as shown here.
The torch mounting bracket comes unpainted. Prime it and paint it the color you wish. Allow it to thoroughly dry.
When the bracket's paint has fully dried, bolt it to the four holes at the bottom of the column as shown. You will use the four 10-32 socket head cap screws, flat washers, and nuts that were supplied. The bracket will be close to the end of the lead screw, but will clear it. You may have to turn the hand wheel at the top of the column so the saddle does not prevent access to the column's holes.
Insert the 1" I.D. shaft collar's stud in the 3/8" hole at the bottom of the bracket as shown. The shaft collar's set screw can be on either side. Secure the shaft collar using the supplied 3/8" nut and flat washer. Leave it slightly loose so you can adjust the angle of the torch when it is installed.
Bolt the adaptor block to the motor mount bracket as shown here. Use the two 5/16" bolts and flat washers that were supplied. Note that the set screw in the block will be down, and the square key will be up.
This is what the set up will look like after the adaptor block has been bolted to the motor mounting plate.
Place the end of the torch into the shaft collar, and tighten the set screw down. Do not over-tighten the shaft collar, or you may damage your torch. The 3/8" nut holding the shaft collar in place should be loose enough for the collar to be rotated during installation of the torch. Place the 1 1/2" U-bolt around your torch handle, and through the outer slot in the left end of the bracket. Secure it with the supplied 1/4" nuts and flat washers, adjusting its position in the slots so the torch tip is vertical. Then tighten down the nut on the shaft collar's stud.

You will be able to switch consumables with the torch in place by loosening the shaft collar's set screw. Use the hand wheel at the top of the column to adjust tip-to-work distance.