

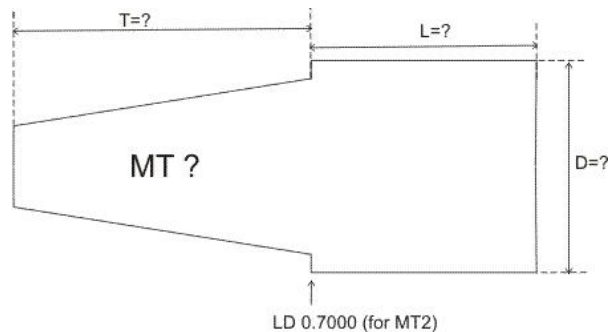


China Lathe Tailstock Accessories

Tailstock accessories for benchtop lathes: the adapters have a Morse taper on one side and a boring that fits cutting tools on the other side.

We also offer Morse dead/live centers, machinable end Morse tapers, alignment centers (Buddy bars), and customized designs (Jacobs adapter, Brown & Sharp, etc. <http://www.lathecity.com/CustomDesigns/index.html>).

See photos and complete list of parts on our website.



Typical application: Accessory for benchtop / tabletop lathes. Adapter mounts in a Morse arbor, e.g., in the tailstock spindle of a tabletop lathe. Perhaps someone recognized that more time is lost clamping center drills and drill bits in Jacobs drill chucks than is necessary. These simple, affordable, and useful accessories give one a fast tool-change system.

Available sizes

Tailstock center drill holders. We offer three different adapters for #1 to #3 center drills. The adapters are long enough (~3") to

reach over a cross-slide typical for benchtop systems. The center drills (not included) are held in place by a steel auxiliary set screw (included). You will be amazed how much time you will save using these snap-on adapters for center drills.



Morse taper – extended dead center. This accessory has a Morse taper at one end and a ~30° pin (taper) at the other end. The steel pieces can be used as a dead center. The length of the center can be customized. These pieces are cut from (non-hardened) steel, but the pin end will wear out over time (as usual, use cutting oil when using dead centers). However, any (hobby) machinist can easily sharpen the pin end. We also offer versions which have a tool steel pin inserted.



Morse taper – extended concave-dead center. We also offer an extended dead center with a concave end, which is useful when turning odd-shaped pieces.

Pricing: One may consider that a single Jacobs drill chuck for a benchtop systems costs \$40 and more. In addition, Morse tapers are difficult to cut. We explain how this can be done (also on a small lathe) in vol. 1 of the LatheCity book series. However, it's tricky. We do offer a Morse taper cutter also for China import lathes.

Procedure: Extend the tailstock spindle by about ¼"-1/2". For best fit, *slightly* (and carefully) slam the taper adapter in the spindle *by hand*. To remove the taper, pull back the spindle. Typically, taper arbors/spindles have an internal draw bar, which will push out the taper.

Safety Notes, Trouble Shooting, and Disclaimer: General safety rules for machine/power tools are in place. For an extended list of safety notes, consult the literature or go to our website. You can download free of charge a safety booklet, which is also typically included (free of charge) for first-time customers. Here is the link:

<http://www.lathecity.com/Books/Safety-Booklet-Lathe-City.pdf>

Cutting tools such as center drills can break. The fragments may travel at great speed over large distances. Therefore, use protective clothing including, most importantly, safety glasses for metal work.

The adapter may start to rotate when the center drill gets stuck in the work piece. Therefore, make sure that the setscrews do not stick out of the adapter. In any case, switch the lathe off. Do not try to stop the rotating adapter with your hands. Make sure that the adapter is properly inserted in the Morse arbor – the quill typically needs to be moved out somewhat. Use cutting oil.

Using a deadcenter can result in over-heating the work piece and the adapter. Switch the lathe off, and cool down the pieces.

We do not warrant that any accessories can be used for any particular application. Usage of accessories or damage caused is at the risk of the customer. Neither LatheCity nor its owner shall be liable for damage arising from unprofessional use or misuse of LatheCity accessories.

Max RPM 100-1800.

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Further technical notes

Morse taper: Please note the length and end style of Morse taper varies, depending on application and lathe model.

Sherline: The standard version we offer has a taper length of ~0.8" for short benchtop tailstock spindles. Other sizes are available on request as custom designs. A Morse #0 taper has per definition a larger end with an O.D. of ~0.36".

China lathe: MTs are reduced length and have a taper length of about 1.5" (MT3) and 1.25" (MT2). MTs are cut off at the SD end. The MT2 end is tapped to insert #10-32 screw. This screw can be adjusted such that the MT2 end pops out of the tailstock. We use this design since it is compatible with 98% of all tabletop lathes. Most tailstock and headstock spindles of China import lathes are reduced length.

Setscrews: auxiliary holes for small OD setscrews are drilled through. However, only one setscrew is required.

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