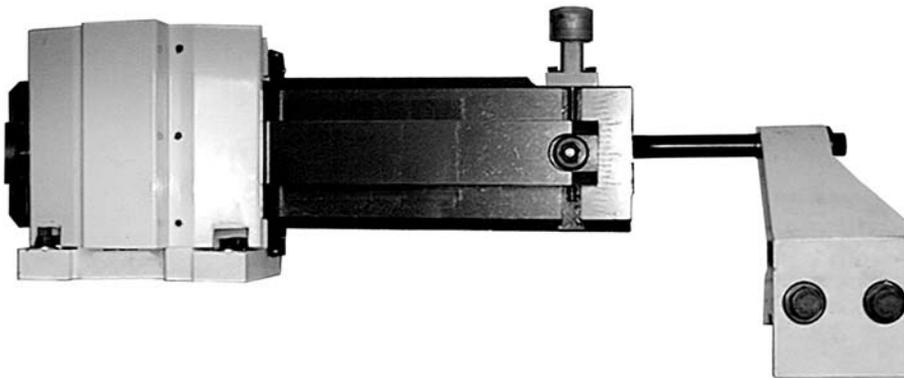




Assembly Instructions and Parts Manual

Taper Attachment Kit for ZX Lathes

Model TAK-ZX



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Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

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Product Listing with Warranty Period

90 Days – Parts; Consumable items; Light-Duty Air Tools
1 Year – Motors; Machine Accessories; Heavy-Duty Air Tools; Pro-Duty Air Tools
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools

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Warnings

For your own safety, read this instruction manual before operating the tool.

Wear Eye Protection

- **KEEP GUARDS IN PLACE** and in working order.
- **REMOVE ADJUSTING KEYS AND WRENCHES.** Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
- **KEEP THE WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- **DO NOT USE IN A DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
- **KEEP CHILDREN AWAY.** All visitors should be kept safe distance from the work area.
- **MAKE THE WORKSHOP KID PROOF** with padlocks, master switches, or by removing starter keys.
- **DON'T FORCE THE TOOL.** It will do the job better and safer at the rate for which it was designed.
- **USE THE RIGHT TOOL.** Don't force a tool or attachment to do a job for which it was not designed.
- **USE THE PROPER EXTENSION CORD.** Make sure you extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in the line voltage resulting in loss of power and overheating. **For runs up to 25 feet, use a 14 AWG or larger gauge cord. For runs up to 50 feet, use a 12 AWG or larger cord. Runs over 50 feet are not recommended.** If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.
- **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
- **ALWAYS USE SAFETY GLASSES.** Also use face or dust masks if the cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- **SECURE WORK.** Use clamps or a vise to hold the work when its practical. It's safer than using your hand and it frees both hands to operate the tool.
- **DON'T OVERREACH.** Keep proper footing and balance at all times.
- **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- **DISCONNECT TOOLS** before servicing; when changing accessories, such as blades, bits cutters, and the like.
- **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure the switch is in the off position before plugging in the machine.
- **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause a risk of injury.
- **NEVER STAND ON A TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
- **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
- **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
- **NEVER LEAVE THE TOOL RUNNING UNATTENDED. TURN THE POWER OFF.** Don't leave the tool until it comes to a complete stop.

Before Assembly

1. Unpack the taper attachment from the box.
2. Disassemble the taper attachment and clean thoroughly with a mild solvent.
3. Lightly oil all surfaces with machine tool oil.

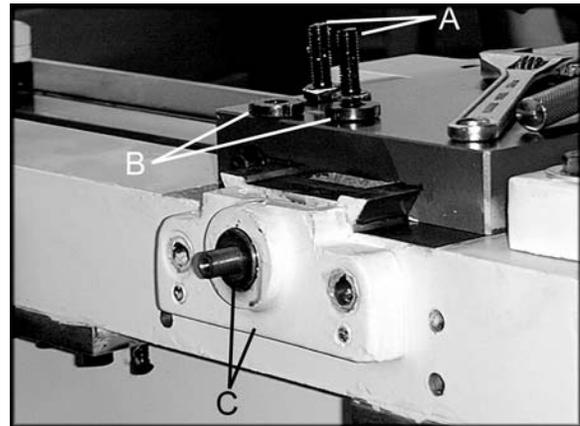


Figure 1

Assembly

1. Remove two hex bolts (A, Figure 1) from the bracket.
2. Remove the two cross feed nuts (B, Figure 1) while holding the cross feed handle.
3. Remove the outer bearing and block (C, Figure 1).
4. Remove the inner bearing assembly from behind the block. (Figure 2).
5. Attach the taper attachment main body to the lathe bed with four M10x50 hex socket cap screws and four washers (A, Figure 3). Don't tighten the screws all the way at this time.
6. Install the inner bearing and feed block leaving it loose for adjustment (A, Figure 4). Fasten the set collar, on the feed block, with a hex socket cap screw. Install the taper slide rest leaving it loose for adjustment (B, Figure 4).

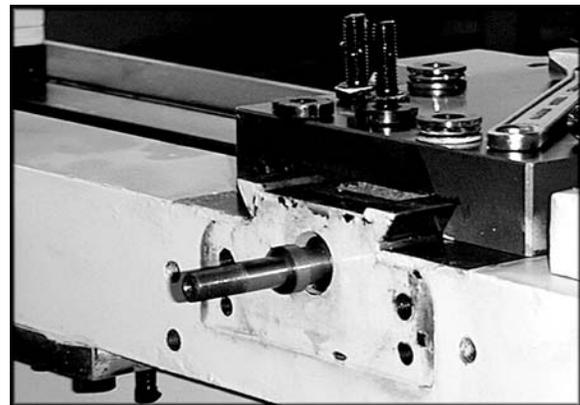


Figure 2

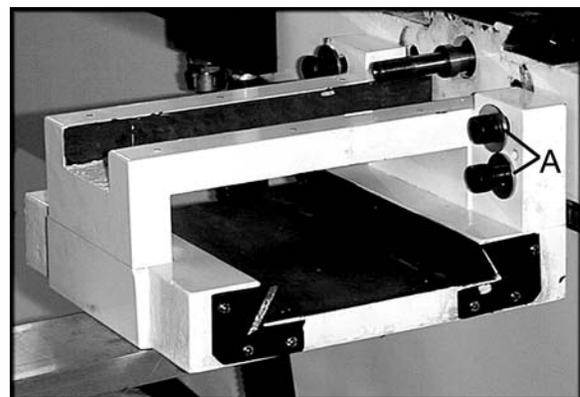


Figure 3

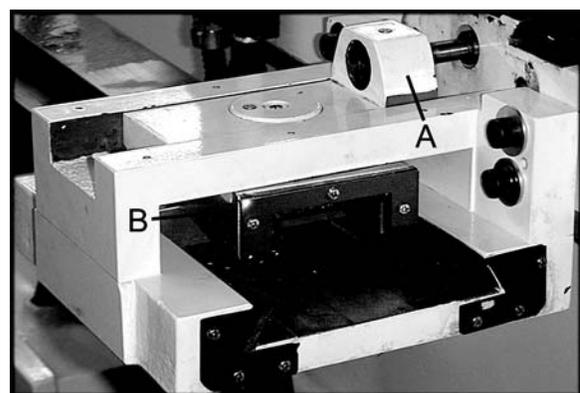


Figure 4

7. Center the cross feed screw (A, Figure 5) to the hole in the feed block. Turn the cross feed handle to make sure there is no resistance.

8. Tighten four M10x50 hex socket cap screws on the taper attachment main body after the cross feed screw has been centered.

9. Install and level the longitudinal slide from end to end using a dial indicator. Keep the interior slide block centered on the lead screw. The slide assembly is level when it is less than .005" from end to end (A, Figure 6).

Note: Remove slide and make sure cross feed screw stays centered and passes freely through the taper slide. You may have to repeat steps 7-9 until the cross feed screw is centered and the longitudinal slide is level.

10. Replace the outer bearing and cross feed nuts.

11. Drill and pin two holes in the taper body. It is recommended that drilling and pinning be performed. If you decide not to drill and pin, the alignment and leveling procedure will have to be followed if the taper attachment is removed and re-installed.

12. Lubricate the longitudinal slide with oil. Install slide and set degree to "0".

13. Install the long gib and screw (A, Figure 7). Install the short gib and screw (B, Figure 7). There should be no play and no binding when turning the cross feed hand wheel.

14. Install the bracket (A, Figure 8), for the clamp rod, under the longitudinal slide with two hex socket cap screws.

15. Thread the adjusting bar (B, Figure 8) into the bracket.

16. Fasten the clamp (C, Figure 8) to the lathe bed beyond the length of the clamp rod. Do not tighten at this time.

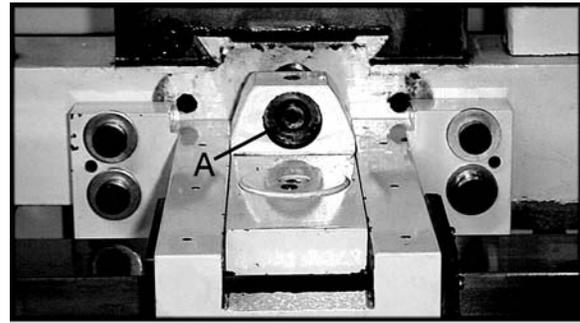


Figure 5

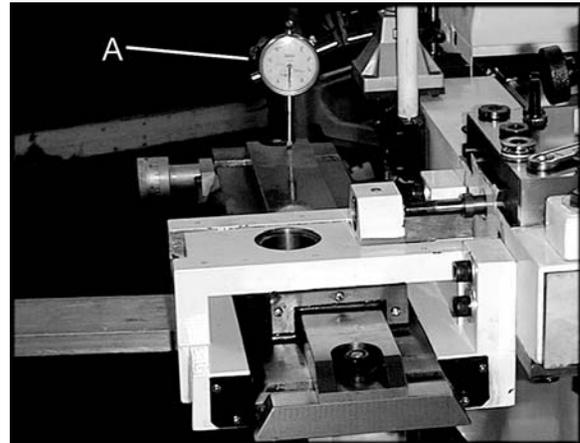


Figure 6

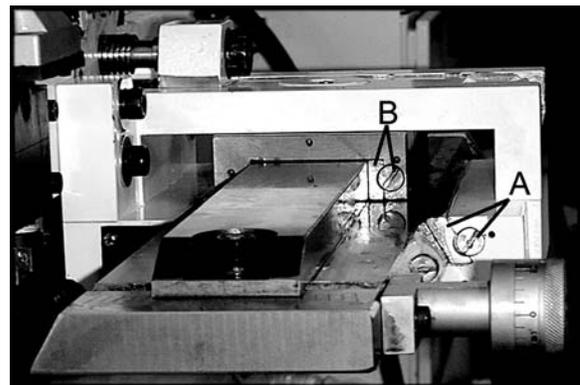


Figure 7

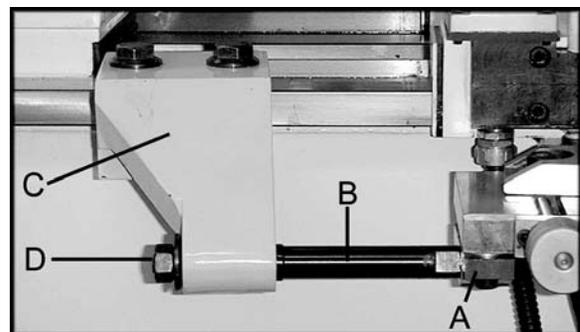


Figure 8

17. Slowly move the carriage back until the clamp rod is through the hole in the clamp.

Note: If the clamp rod is not low enough, use shims, and adjust accordingly.

18. Install the washer and nut (D, Figure 8). Tighten all bolts.

19. Completely oil the taper attachment to protect the metal.

20. Install the top shield with six hex socket screws (Figure 9).

Note: The cover shield may need to have notches cut to allow enough room for the mounting bolts and pins.

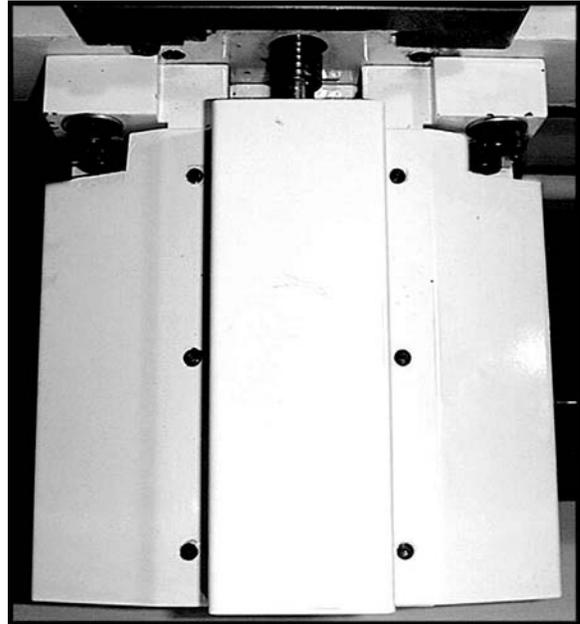
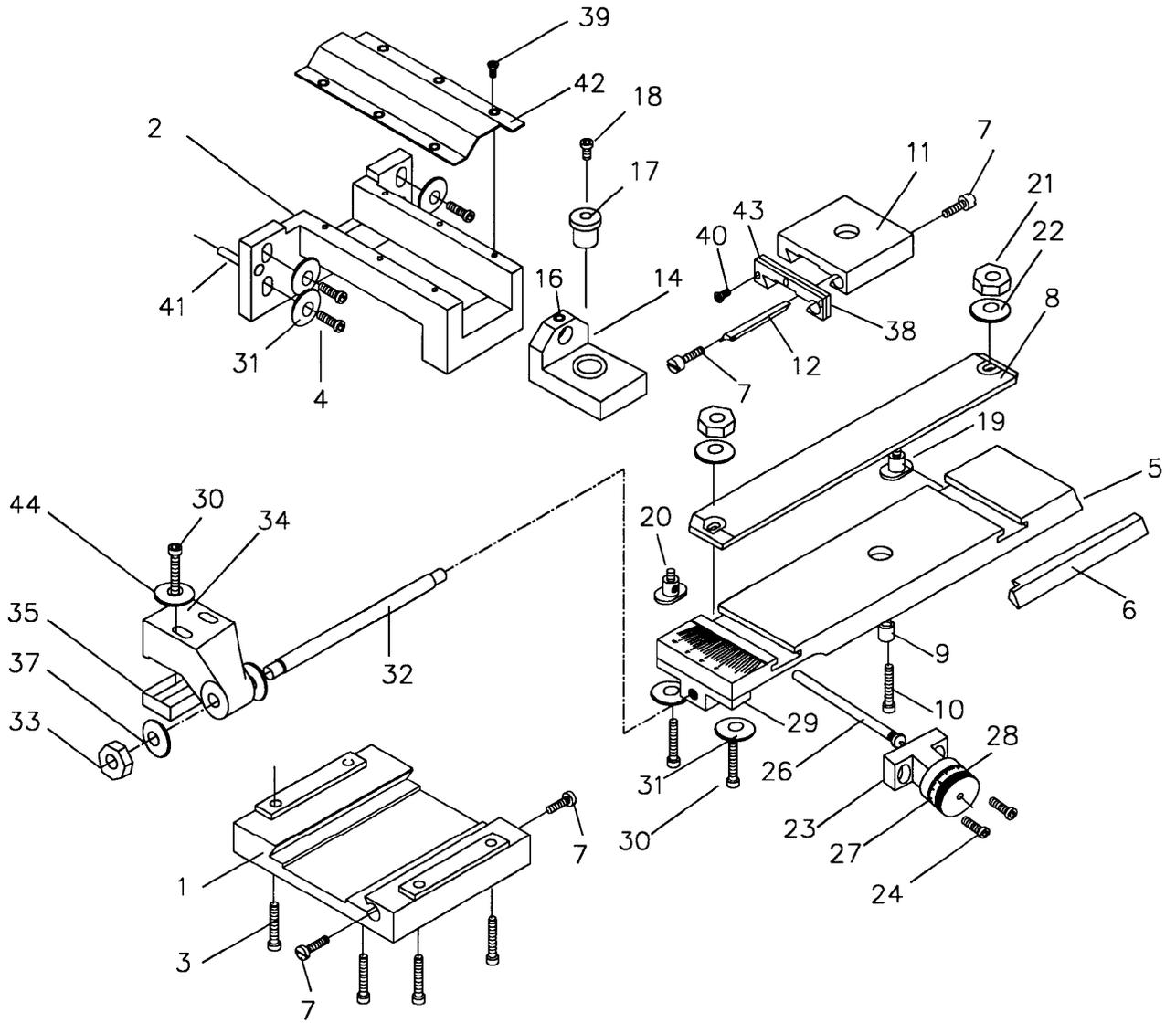


Figure 9

Replacement Parts

To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

TAK-ZX Taper Attachment Kit – Exploded View



TAK-ZX Taper Attachment Kit – Parts List

Index No	Part No	Description	Size	Qty
1	84-3001-00	Slide Base		1
2	84-3002-00	Slide Bracket		1
3	TS-1505071	Hex Socket Cap Screw	M10x50	4
4	TS-1505081	Hex Socket Cap Screw	M10x45	4
5	84-3003-00	Longitudinal Slide		1
6	84-3004-00	Gib Strip		1
7	84-3005-00	Adjusting Screw		4
8	84-3006-00	Taper Slide		1
9	84-3007-00	Setting Collar		1
10	TS-1504031	Hex Socket Cap Screw	M8x16	1
11	84-3008-00	Taper Slide Rest		1
12	84-3009-00	Gib Strip		1
14	84-3011-00	Feed Block		1
16	84-3011-00-02	Ball Cup	1/4"	1
17	84-3012-00	Setting Collar		1
18	TS-1504051	Hex Socket Cap Screw	M8x25	1
19	84-3013-00	Clamping Screw		1
20	84-3013-00-01	Clamping Screw		1
21	84-3013-00-02	Nut		2
22	84-3014-00	Washer		2
23	84-3015-00	Bearing Housing		1
24	TS-1503051	Hex Socket Cap Screw	M6x20	2
26	84-3016-00	Screw		1
27	84-3017-00	Dial		1
28	84-3017-00-01	Pin		1
29	84-3018-00	Bracket		1
30	TS-1491031	Hex Head Screw	M10x25	2
31	84-3018-00-02	Washer		6
32	84-3019-00	Adjusting Bar		1
33	TS-1540081	Nut	M16	1
34	84-3020-00-01	Bracket		1
35	84-3021-00	Clamping Block		1
37	84-3022-00	Washer		3
38	84-3026-00	Wiper		2
39	84-3028-00-01	Cross Head Screw	M4x8	6
40	84-3026-00-01	Cross Head Screw	M8x45	6
41	84-3027-00	Taper Pin		2
42	84-3028-00	Dust Cover		1
43	84-3029-00	Case Wiper		2
44	84-3020-00-01	Washer		2



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