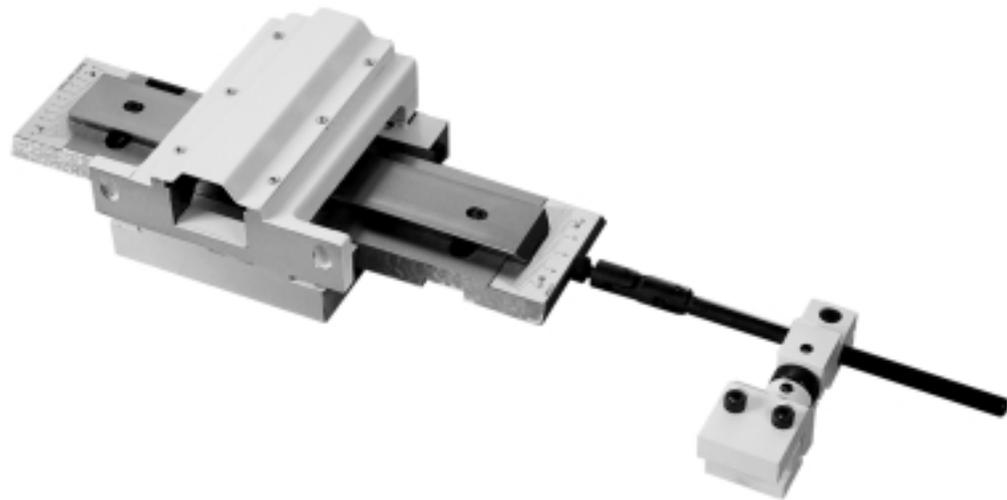




OWNER'S MANUAL

TAK-GHW Taper Attachment Kit



JET EQUIPMENT & TOOLS, INC.
A WMH Company
www.jettools.com

P.O. BOX 1349
Auburn, WA 98071-1349
e-mail jet@jettools.com

Phone:253-351-6000
Fax: 1-800-274-6840
M-321520 1/01

Important Information

**1-YEAR
LIMITED WARRANTY**

**JET offers a one-year limited
warranty on this product**

REPLACEMENT PARTS

Replacement parts for this tool are available directly from JET Equipment & Tools. To place an order, call 1-800-274-6848. Please have the following information ready:

1. Visa, MasterCard, or Discover Card number
2. Expiration date
3. Part number listed within this manual
4. Shipping address other than a Post Office box.

REPLACEMENT PART WARRANTY

JET Equipment & Tools makes every effort to assure that parts meet high quality and durability standards and warrants to the original retail consumer/purchaser of our parts that each such part(s) to be free from defects in materials and workmanship for a period of thirty (30) days from the date of purchase.

PROOF OF PURCHASE

Please retain your dated sales receipt as proof of purchase to validate the warranty period.

LIMITED TOOL AND EQUIPMENT WARRANTY

JET makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follows: 1 YEAR LIMITED WARRANTY ON THIS JET PRODUCT. Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities or to a lack of maintenance. JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD SPECIFIED ABOVE FROM THE DATE THE PRODUCT WAS PURCHASED AT RETAIL. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MECHANABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY OR FOR INCIDENTAL, CONTINGENT, SPECIAL OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU. To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an authorized service station designated by our Auburn office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, JET will either repair or replace the product or refund the purchase price, if we cannot readily and quickly provide a repair or replacement, if you are willing to accept such refund. JET will return repaired product or replacement at JET's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of JET's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights, and you have other rights, which vary, from state to state.

JET Equipment & Tools • P.O. Box 1349, Auburn, WA 98071-1349 • (253) 351-6000

Assembly

Note: numbers in parenthesis (#) refer to the breakdown and part's list.

1. Remove the splash guard from the backside of the lathe.
2. Remove the taper attachment from the box.
3. Remove the dust cover (29) held in place with six screws (5).
4. Loosen and remove gib screws (16 & 24). Do not adjust or remove gib screw (24A); this will aid assembly when putting the taper attachment together.
5. Remove the longitudinal slide assembly (6 & 11) from the slide base.
6. Thoroughly clean all parts of the taper attachment with cleaning solvent.
7. Remove two nuts (A, Fig. 1) and the bearing cap (B, Fig. 1) from the end of the cross slide screw (C, Fig. 1)
8. Remove the thrust bearing assembly from the cross feed screw.
9. Remove two hex socket cap screws (D, Fig. 1) and the block (E, Fig. 1).
10. Attach the main body (A, Fig. 2) to the carriage with two M10 x 30 hex socket cap screws, and two M10 flat washers (B, Fig. 2). Tighten the hex cap screws to hold the main body in place but loose enough to allow adjustment with a dead blow hammer, or rubber mallet.
11. Place the cross slide block (A, Fig. 3) onto the taper slide rest (22).
12. Position the main body so that the hole in the cross slide block (B, Fig. 3) lines up with the cross slide screw (C, Fig. 3).
13. Push the cross slide block to engage the cross slide screw through the hole in the slide. It is important to get the slide to pass over the cross slide screw smoothly. Use a rubber mallet, or a dead blow hammer to position the main body so that the slide passes smoothly over the cross slide screw without lifting it.

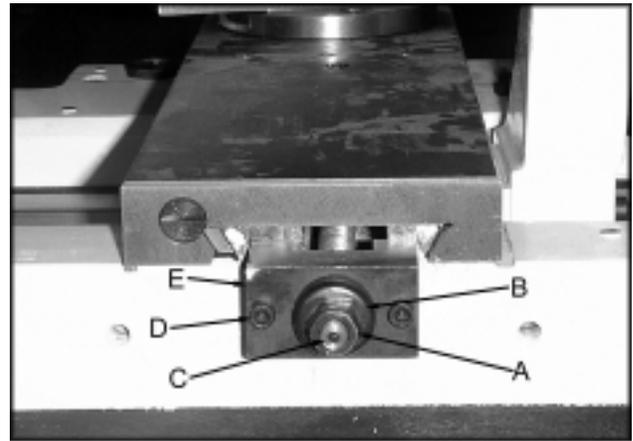


Fig. 1

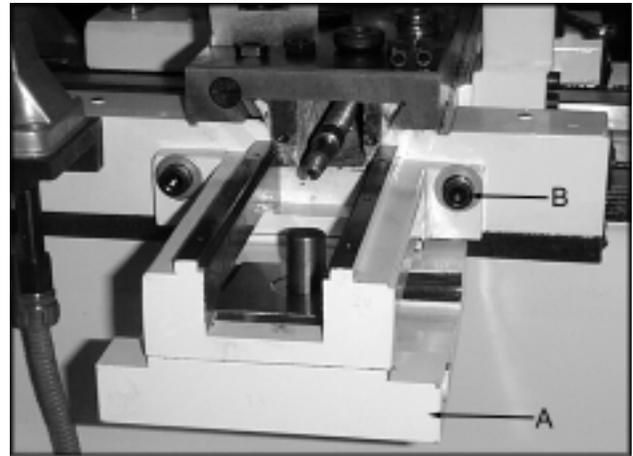


Fig. 2

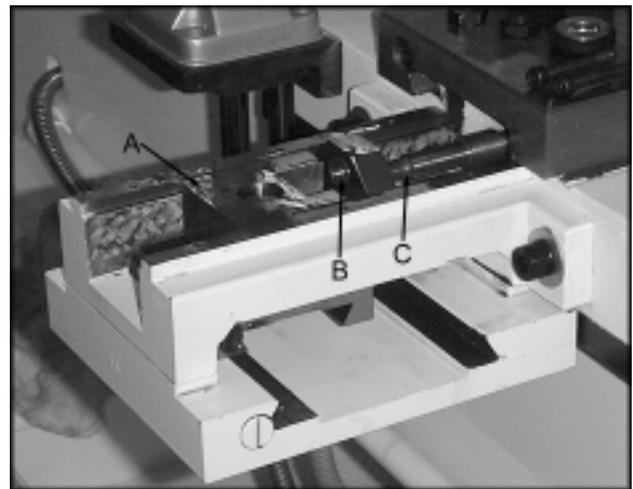


Fig. 3

14. Make sure the inner bearing assembly is in place before re-assembly, no spacer. The smaller, inner diameter bearing goes on first.

15. Place the longitudinal slide (A, Fig. 4) into the main body.

16. Using a dial indicator with a magnetic base (B, Fig. 4) attached to the lathe bed, level the longitudinal slide to the bed. The slide assembly is level when it is less than .005" from end to end. Keep the cross slide block centered on the lead screw. Use a rubber mallet, or a dead blow hammer to position the main body so that the cross slide block passes smoothly over the lead screw and that the longitudinal slide is level.

Note: repeat steps 13 & 16 until the longitudinal slide is level and the cross slide block passes smoothly over the cross slide screw.

17. Tighten two M10 x 30 hex socket cap screws that hold the main body in place.

18. Re-check the longitudinal slide for level.

19. Clean and lightly oil all gib surfaces that were previously removed.

20. Replace the taper slide, gibs and gib screws.

21. Check to make sure the slide moves easily and without excessive play.

22. Replace the outer bearing assembly (A, Fig. 5). The smaller inner diameter bearing goes on first.

23. Install two hex nuts (B, Fig. 5). Tighten the inner nut first to snug up the bearing assembly. Turn the cross slide handle and check for smooth rotation. Tighten the jam nut to hold the adjustment.

Note: It is not necessary, but a good idea to drill and pin the taper in place through the slide bracket (3N).

24. Replace the dust cover.

25. Thread the lock down linkage (A, Fig. 6) into the end of the slide assembly (B, Fig. 6).

26. Place the clamp (C, Fig. 6) onto the lathe bed and tighten two hex socket cap screws (D, Fig. 6).

27. Line up the hole in clamp with the lock down linkage (E, Fig. 6) and insert. Tighten the hex socket cap screw (F, Fig. 6).



Fig. 4

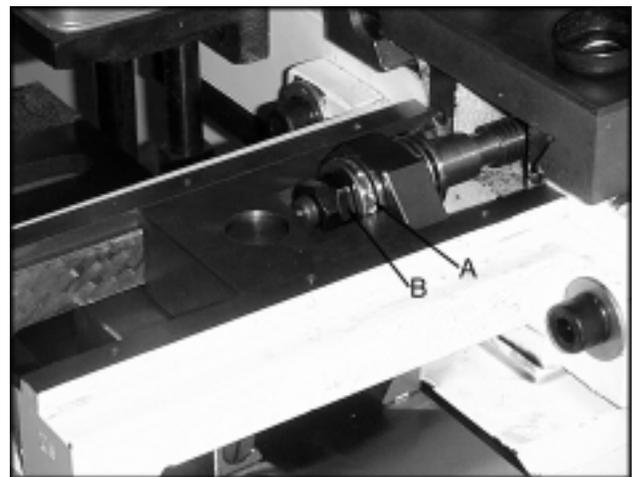


Fig. 5

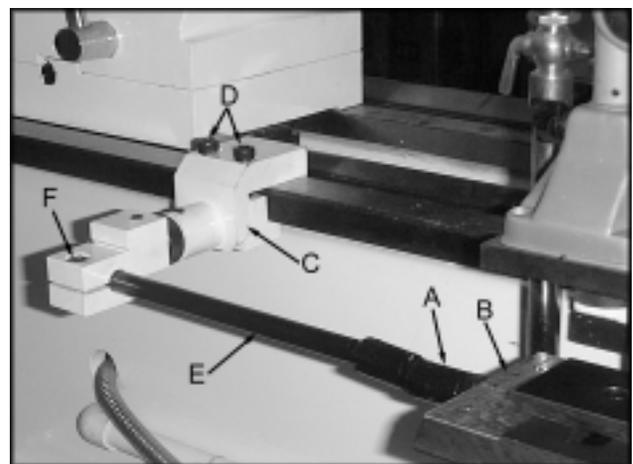


Fig. 6

28. Using a dial indicator mounted to the carriage indicate along the tool post, while moving the carriage, (Figure 7). You are checking to see that the taper slide is parallel to the movement of the carriage.

Note: You will need to loosen hex socket cap screws (12 & 13). This will allow you to turn the adjusting screw (18).

29. When the taper slide is parallel make sure the screws (12 & 13) are tight, and mark the zero point with a chisel.

- These taper attachments are designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a taper attachment, do not use until proper training and knowledge have been obtained.
- Tighten the clamp bracket (59N) only when using the taper attachment. You may want to remove the clamp bracket when not using the taper attachment.

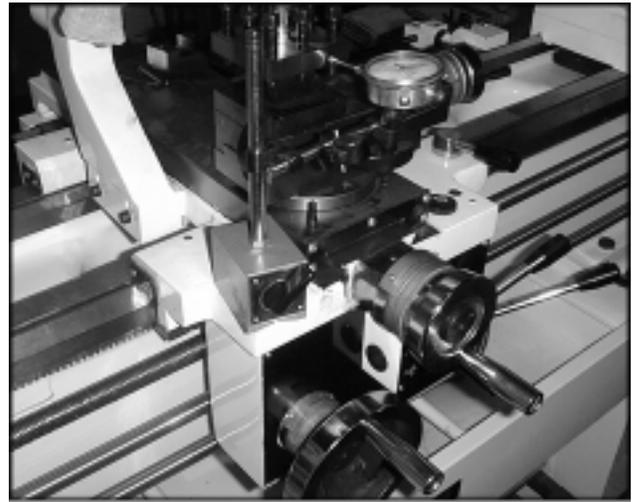


Fig. 7

Parts List for the TAK-GHW Taper Attachment Kit

Index No.	Part No.	Description	Size	Qty.
1	TAK1340A-1	Slide Base		1
2	TS-1504081	Hex Socket Cap Screw	M8 x 40	4
3N	TAK1340W-3N	Slide Bracket		1
4	TS-1505041	Hex Socket Cap Screw	M10x 30	2
5	TAK1340A-5	Screw	M5x 8	6
6	TAK1340A-6	Longitudinal Slide		1
7	TAK1340A-7	Taper Indicator Plate		1
8	TAK1340A-8	Rivet		2
9	TAK1340A-9	Angle Indicator Plate		1
10	TAK1340A-10	Rivet		2
11	TAK1340A-11	Taper Slide		1
12	TS-1503031	Hex Socket Cap Screw	M6 x 12	1
13	TS-1503051	Hex Socket Cap Screw	M6 x 20	1
14	TAK1340A-14	Axle		1
15	TAK1340A-15	Gib Strip		1
16	TAK1340A-16	Adjusting Screw		2
17	TAK1340A-17	Adjusting Nut		1
18	TAK1340A-18	Adjusting Screw		1
19	TAK1340A-19	Adjusting Knob		1
20	TAK1340A-20	Spring Pin	3 x 14	1
21	TAK1340A-21	Clamping Plate		1
22	TAK1340A-22	Taper Slide Rest		1
23	TAK1340A-23	Gib Strip		1
24	TAK1340A-24	Adjusting Screw		1
24A	TAK1340A-24	Adjusting Screw		1
25	TAK1340A-25	Cross Slide Block		1
26	TS-1503051	Hex Socket Cap Screw	M6 x 20	2
27	TAK1340A-27	Feed Block		1
29	TAK1340A-29	Dust Cover		1
50	TAK1340A-50	Universal Joint		1
51	TAK1340A-51	Spring Pin	4 x 19	2
52	TAK1340A-52	Universal Joint		1
53	TAK1340A-53	Hex Nut		1
54	TAK1340A-54	Adjusting Shaft		1
55	TAK1340A-55	Lock Block		1
56	TS-1524011	Set Screw	M8 x 8	1
57	TS-1504041	Hex Socket Cap Screw	M8 x 20	1
58	TAK1340A-58	Eccentric Shaft		1
59N	TAK1340W-59N	Clamp Bracket		1
60	TS-1524011	Set Screw	M8 x 8	1
61N	TAK1340W-61N	Clamp Block		1
62	TS-1504081	Hex Socket Cap Screw	M8 x 40	2