



## Alignment Bar for MT2 Headstocks & Tailstocks

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**Size:** MT2 to MT2 also written as 2MT to 2MT Double pin end that fits in Morse Taper 2 Tailstocks and Morse Taper 2 Headstocks. Fits in all lathes with Morse Taper 2 headstock and tailstock. Can be used on wood lathes and/or metal cutting lathes.

**Purpose of that tool:** If one wants to machine work pieces with a small run-out (high centricity), the work piece must be perfectly center drilled and turned. Having a rotatable headstock (or adjustable tailstock) is great, but it has the disadvantage to loose perfect headstock-tailstock alignment. Our alignment bars can help.

**Included:** One alignment bar MT2 to MT2; this one page manual; safety booklet

### Specs & details:

- MT2 to MT2 double pin
- Reduced length ANSI size Morse taper
- Total length approximately 5.5"
- Taper length approximately 1.75"
- Largest diameter approximately 0.75"
- Solid steel
- MTs are reduced length and have a taper length of about 1.75". MTs are cut off at the small diameter end. One MT2 end is tapped to insert a #1/4-20 screw (standard size). This screw can be adjusted such that the MT2 bar pops out of the tailstock. We use this design since it is compatible with 98% of all lathes. Most tailstock and headstock spindles are

reduced length. If you need this feature, insert a screw and adjust the screw length such that the alignment bar pops out of your tailstock when the tailstock quill is retracted.

- For alignment you may need to move with the carrier/cross-slide as close to the headstock as you can and extend the tailstock spindle by about one inch. This depends on the width of your cross-slide, however. If you have a very (!) large lathe then this buddy bar may be too short to reach over the cross slide. Contact us in advance.
- **This is an alignment bar and NOT an adapter. Switch the lathe off when using this alignment bar!**

### Other sizes:

Other sizes can be made or are already available

MT0-MT0 is used on Craftsman with retrofitted spindles (original Craftsman would need a slightly different size)

MT1-MT1 also used on some modified Craftsman lathes

MT0-MT0 UNIMAT's with LatheCity spindle package (original UNIMAT has a pin arbor/spindle)

MT0-MT0, or MT1-MT1 apparently also used on some other lathes (Harbor Freight? - check your manual)

MT1-MT0 Sherline with standard/original spindles (most common size)

MT1-MT1 retrofitted Sherline

MT2-MT3 most small China import bench lathes (most common size)

UNIMAT pin alignment bar for original UNIMAT SL DB

Design details (diameter of stock rod used) may deviate from the image shown which does not affect the function of the accessory. All dimensions are approximate. The buddy bar is machined on a CNC lathe, typically from LeadLoy or C1018. Other options on request. The tapers are of reduced length and have no tang. Every piece is test fitted in ANSI standard arbors. Our CNC lathes have a runout of 0.0004”-0.0006”.

**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. Use safety glasses rated for metal work. LatheCity shall not be liable for any damage caused by unprofessional use of LatheCity accessories. Max RPM 1800 for most accessories, some accessories have max RPM of 100 if indicated! Replace set screws with Nyclock screws in case that heavy vibrations can be expected. We do not guaranty a particular TIR or particular application. Any legal action brought against LatheCity/Uwe Burghaus shall be tried in the State of North Dakota in Fargo, USA. **WARRANTY:** we do not provide any warranty for our products. In no event shall LatheCity's liability exceed the purchase price paid for the product. We shall in no event be liable for death, injuries to persons or property or incidental, contingent, special or consequential damage arising from the use of our products. None of our accessories or custom designs is intended to be used for transportation applications including but not limited to cars, motorcycles, airplanes, roller skates, bicycles, agriculture vehicles, etc., for civilian or military applications. Similarly, none of our accessories or custom designs is intended to be used as components of weapons including but not limited to firearms for civilian or military applications. We herewith explicitly exclude any warrantee or liability if LatheCity products were used directly or indirectly or misused directly or indirectly for the above-mentioned applications (transportation, weapons). Trademarks used in our products (books, manuals, eBay listings, Amazon listing, web sites, etc.): All trademarks and copyrights are the property of their respective owners. US export limitations/laws need to be obeyed for all LatheCity products.

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**Returns of custom designs or customized designs/tools.** We do NOT accept returns of custom designs or customized items. Significant deviations of specifications only would warrant returns of custom designs. Also in that case we do not reimburse shipping costs. Product details may deviate from images shown without compromising the function of the tool. For example, stock diameters/length may differ. All dimensions if included are approximate. Specific manuals will usually not be provided for custom designs.

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