

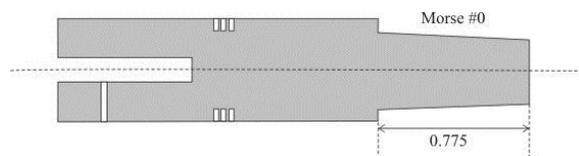


Benchtop Lathe Tailstock Accessories

Tailstock accessories for benchtop lathes: the adapters have a Morse #0 taper on one side and a boring that fits cutting tools on the other side.

We also offer Morse #0 dead centers and customized designs.

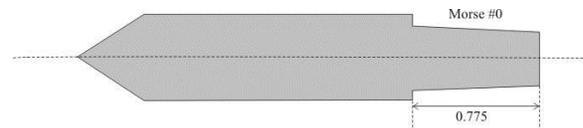
See photos and complete list of part numbers below.



Typical application: Accessory for benchtop / tabletop lathes. Adapter mounts in a Morse #0 arbor, e.g., in the tailstock spindle of a small 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.

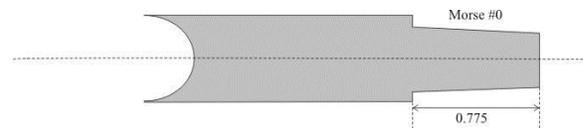
Available sizes

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 #0 taper – extended dead center.

This accessory has a Morse #0 taper at one end and a ~30° pin (taper) at the other end. The steel pieces can be used as a dead center. The adapters are long enough (~3") to reach over a cross-slide typical of benchtop systems (replacing an expensive Morse arbor – taper adapter). 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. (When working mostly with aluminum, we have used these pieces for a year without significant sign of wear.)



Morse #0 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 \$60 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.

Procedure: Extend the tailstock spindle by about $\frac{1}{4}$ ". 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.

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 overheating 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.

Returns in resalable conditions are accepted within 30 days after shipment. All shipping costs will be covered by the customer. No restocking fees, no questions asked. No returns of custom designs or customized designs. No returns of bulk orders. General sells

and business terms as given on our web site are active.

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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. Our version is tailored towards small benchtop lathes. 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 ".

Typically, LatheCity accessories are made from aluminum (Al), unless otherwise noted, which keeps the prices low and is durable enough. In addition, the aluminum adapters are guaranteed not to damage, e.g., threads. Looking at rusting pieces made by other vendors out of "stainless" steel ... Well, this does not happen with aluminum adapters.

We do not coat our accessories with a (black) oxide since this has no function, but just increases the costs. Typically, all surfaces are milled or polished, but small scratches may be apparent even on new adapters. These are tools and not jewelry or furniture.

We do test all products thoroughly (typically for at least a year) before offering them for sell.

Don't hesitate to contact us if you have any questions regarding the compatibility of our products with your system.

LatheCity accessories, manuals, software, and books are copyrighted by U. Burghaus (LatheCity).

Application		Part #
	Holds #1 center drills (O.D. 1/8) (This one is typically cut from steel.)	P/N A0001
	Holds #2 center drills (O.D. 3/16) Aluminum	P/N A0002
	Holds #3 center drills (O.D. 1/4) Aluminum	P/N A0003
	Set including #1, #2, and #3 center drill holder. Aluminum / steel	P/N A0004
Blank.		P/N A0005
Extended dead center (pin end) Steel		P/N A0006
		P/N A0007
Extended dead center (concave end) aluminum		

Prices are per single piece unless otherwise noted. Allen wrench keys are not included. **Cutting tools are not included.** Set screws included. We use standard screw sizes whenever possible. Therefore, spare set screws etc. are available from a good (local) hardware store. #10-32 (3/16"-32) steel set screws are used for most of our products (use a 3/32 Allen hex wrench key). Holders for small diameter cutting tools such as #1 center drills come with #5-40 (1/8"-40) set screws (use a 1/16" Allen hex wrench key). Both sizes are fairly standard. Design details may deviate from the images shown here. Typically, but not always, O.D. 1/2" Al rounds are used (#1 center drill adapters have smaller O.D.). Typically, only the extended dead center is cut from steel. Length of adapters amounts to ~3". When using the blank holder, typically, reamers are required to bore the hole for the cutting tool or the cutting tool will not run perfectly true. The boring must be perfectly centered. (If one makes a holder for a one-at-a-time application, then drill the hole with the very same cutting tool used later on.) We will not take back messed-up blanks. Custom sizes upon request (starting at \$30/piece). No returns of custom designs.

We reserve the right to change these prices any time. The current price list is on our website.