



## Morse Taper #2 to 1" – 8 TPI by ~1.5"

### Wood Lathe Spindle

**Included** in the package offer are one (reduced length) Morse Taper #2 spindle with a 1" – 8 TPI threaded bolt end, thread length about 1.5" long, nut, and washer. Backend tapped for ¼-20 drawbar (not included). The spindle only option comes without the nut and washer. Included are also a safety booklet and this manual. The threaded end has no shoulder unless a nut is used. Don't use the spindle without a nut. These are right hand threads, i.e., don't reverse RPM.

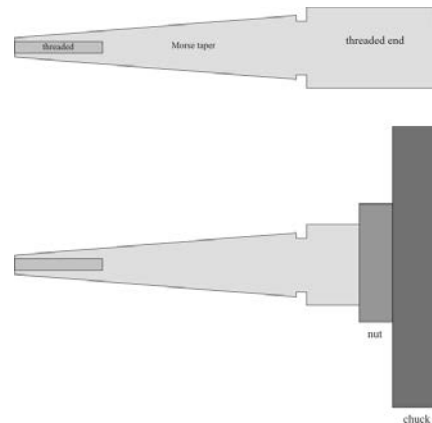


**Size** MT2 1"-8TPI x 1.5", RH, steel

**Typical application** May be used as a spindle for wood lathes.

**Procedure** Insert taper end in spindle of wood lathe. Secure with draw bar if required. Screw nut on spindle end. Screw

chuck on spindle end. Hold nut with wrench and screw lathe chuck against the nut which will act as a shoulder. You may want to use a washer.



**TIR-total indicator runout** The runout (TIR) may not be sufficient for a metal lathe. The piece is machined on a metal lathe with TIR of 0.0006"-0.0004". However, we cannot predict the TIR of the adapter, on a wood lathe it will unlikely be better than 0.002".

**Advantage of the design** Putting a shoulder on the spindle would be significantly more expensive. We can do that as a custom design, but \$60. If you need a shoulder to hold a chuck (and you will) then use a nut and eventually a washer. Tighten the nut against the

chuck. The thread length (1.5") is long enough for most chucks which require only 1" thread length. 1-8TPI nuts should be available locally in a good hardware store, but we also offer these together with the spindle. In addition, various chucks are in circulation which require different thread length. This spindle has an "adjustable" thread length.

These are right hand threads, i.e., don't reverse RPM or you will screw off the chuck and nut. Don't turn a chuck without clamping the jaws on their own or on a work piece or the jaws of the chuck may fly off.



Shown here is a MT3 spindle which does have a small shoulder, but the setup is the same as for the MT2 spindle. Use a nut as a shoulder and tighten it against the chuck. Don't turn a chuck which is not tightened against a shoulder. That chuck will fly off.

**Drawbar.** The spindles are taped at the backend for 1/4-20 bolts which can be used to fix a drawbar. A drawbar is common on metal lathes. It is a bolt or threaded rod which is inserted through the backend of the spindle to secure the spindle. This may not be necessary for wood lathes, but it is highly recommended using a drawbar.

**Safety/Disclaimer:** Adapters are not cutting tools in themselves. Still, general safety rules for machine tools are in place. For an extended list of safety notes, consult the literature or go to our website for a free download of a safety booklet (<http://www.lathecity.com/Books/Safety-Booklet->

[Lathe-City.pdf](#)). We do not warrant that any accessories can be used for any particular application. Damage on equipment (particularly damage on threads by over tightened screws) caused by usage of accessories is the customer's responsibility. Make sure that auxiliary screws are tight at all times. If you encounter heavy vibrations then replace the steel set-screws with Nylock (vibration tolerant) set-screws. Hobby machinists tend to stick their nose too close to the machinery. Use safety glasses and protective clothing. This manual does not replace books about metal working and/or proper training. Adapters may start to rotate. In that case, switch the lathe off. Do not try to stop the rotating adapter with your hands. For screw on type tools, make sure that the adapter is properly screwed onto a shoulder. For screw on type adapters, do not reverse RPM of the lathe or you will unscrew the adapter. The lathe spindle needs to turn towards you standing on the front side of the lathe. Neither LatheCity nor its owner shall be liable for damage arising from unprofessional use or misuse of LatheCity accessories. Max RPM 1800. 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 LaheCity'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.

**Returns** in resalable conditions are accepted within 30 days (Factory Direct) or 14 days (eBay/Amazon) 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. No returns of mess-up machinable parts. General sells and business terms as given on our web site are active. Customer covers all shipping costs and credit card fees (2-3%) raised by e.g. PayPal also when reimbursing payments. Note that the return rate of LatheCity products is below 1%.

Design details may deviate from the image shown which does not affect the function of the accessory.

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