

## **TAILSTOCK ALIGNMENT BAR**

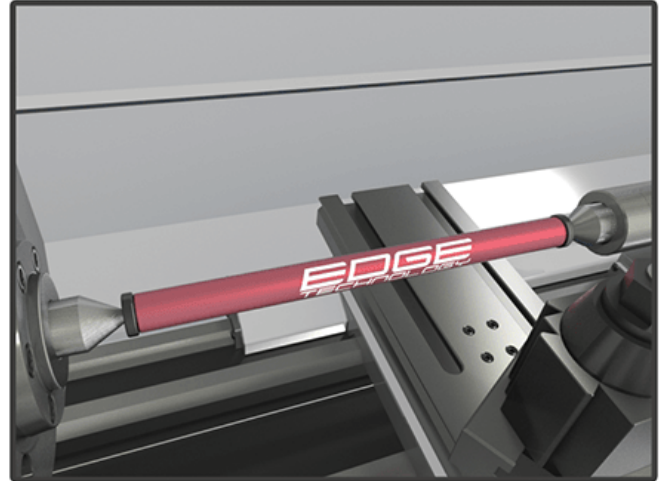
### **OWNER'S MANUAL**

THE TAILSTOCK ALIGNMENT BAR IS DESIGNED TO AID IN THE ALIGNMENT OF THE TAILSTOCK TO THE HEADSTOCK. IMPROPER ALIGNMENT WILL RESULT IN TAPERED WORK PIECES. THE ENDS OF THE ALIGNMENT BAR ARE PRECISION GROUND AFTER ASSEMBLY FOR SUPERIOR ACCURACY.

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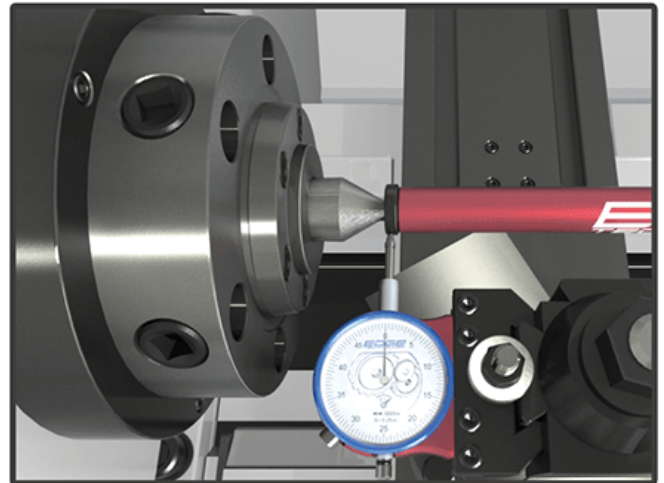
#### **STEP 1**

- INSTALL TAILSTOCK ALIGNMENT BAR BETWEEN CENTERS AS SHOWN.



#### **STEP 2**

- ATTACH A TRAVEL STYLE INDICATOR TO THE CROSS SLIDE PORTION OF THE LATHE. THE IMAGE SHOWS OUR TOOL POST INDICATOR BEING USED FOR THIS STEP, BUT ANY MAGNETIC BASE INDICATOR HOLDER WILL WORK.
- ALIGN THE INDICATOR TIP WITH ALIGNMENT BAR END ON THE HEAD STOCK SIDE. USE CROSS SLIDE TO DEPRESS THE INDICATOR BY ABOUT 0.050".
- ZERO THE INDICATOR FACE.



#### **STEP 3**

- WITHOUT MOVING THE CROSS SLIDE, MOVE THE CARRIAGE UNTIL THE INDICATOR TIP IS ALIGNED WITH THE OPPOSITE END OF THE ALIGNMENT BAR.
- ADJUST THE TAILSTOCK UNTIL THE INDICATOR READS ZERO.

#### **NOTE:**

- IT IS POSSIBLE TO USE THIS TOOL TO POSITION THE TAILSTOCK FOR CUTTING SLIGHT TAPERS. THE DISTANCE BETWEEN THE ALIGNMENT BAR ENDS IS 12". THE AMOUNT OF TAPER PER FOOT IS READ DIRECTLY FROM THE INDICATOR AS THE TAILSTOCK IS ADJUSTED.

