

1640 TAILSTOCK RISER BLOCK

Alignment Instructions

Before you can use the tailstock and riser block you must align the extension. To help you align the extension there is a lifting block supplied with the riser block.

Attach the extension to the outboard end of the 1640 and tighten the bolts so that they are loose enough that you can move the extension.

Put the riser block on the machine and then put on the lifting block as shown in the pictures.

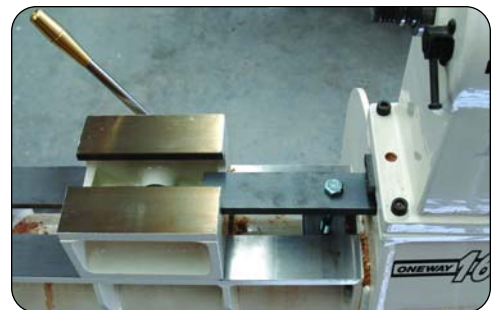
Put the tailstock on the riser block and put the live center in. Thread the small aluminum cone onto the live center. Extend the quill until the aluminum cone enters the hole at the end of the spindle. Look carefully at the cone in the hole and you should see if the extension has to go up, down, right or left.

Move it up and down by tightening or loosening the bolt of the supplied lifting block. Move it right or left by tapping with your hand or a rubber mallet. The extension should move easily, if it doesn't you have the bolts a little too tight.

As the alignment gets closer, wind the tailstock in further to make it easier to see small differences. When you have the live center cone making even contact with the spindle bore you are finished the alignment process.

Tighten the bolts that hold the extension in place and remove the lifting block.

The extension and riser block are now ready to use.



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If you have any problems following or understanding these instructions, please call Kevin on 1.800.565.7288 or email him at kevinclay@oneway.ca