



MODEL T10282 UNIVERSAL TAILSTOCK FOR 3" & 4" ROTARY TABLES INSTRUCTIONS

Introduction

The Model T10282 Universal Tailstock is designed to work with 3" and 4" rotary tables. This tailstock enables the operator to support longer workpieces in the rotary table while maintaining a high degree of accuracy.

Specifications

Maximum Dead Center Horizontal Travel..... 1"
Dead Center Height Range 2 $\frac{1}{4}$ "–3 $\frac{3}{8}$ "
Dead Center Diameter..... $\frac{5}{8}$ "
Mounting T-Bolt Size Required..... $\frac{3}{8}$ "
Dimensions.....4 $\frac{1}{4}$ " x 3 $\frac{1}{8}$ " x 3 $\frac{3}{4}$ "
Net Weight.....2 lbs.

NOTICE

This instruction sheet is designed to give information on the basic operations of this tool. However, it is in no way comprehensive of all of the applications for this tailstock. We strongly recommend that you read books, trade magazines, or get formal training to maximize the potential of your equipment.

Refer to **Figure 1** and the following descriptions to better understand the components of the tailstock.

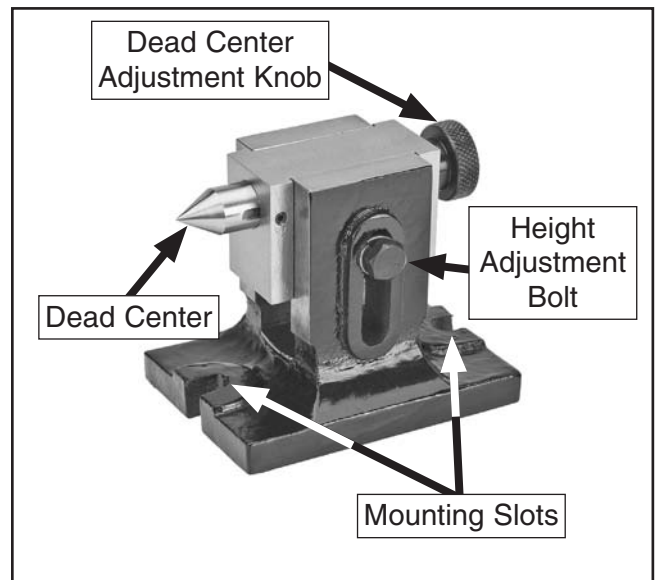


Figure 1. Model T10282 identification.

Dead Center: Provides support for longer workpieces extending from the rotary table.

Dead Center Adjustment Knob: Extends and retracts the dead center for a total travel of 1".

Mounting Slots: Allows the tailstock to be mounted to a slotted table with $\frac{3}{8}$ " T-bolts.

Height Adjustment Bolt: Provides height adjustment when aligning the dead center with the rotary table spindle center line.

NOTICE

It is extremely important to align the dead center tip with the rotary table spindle center line in the Y and Z axes. If axes are not properly aligned, the depth, size, parallelism and overall trueness of the workpiece will be compromised.

Operations

1. Place the rotary table on the mill table and align its face or work-holding accessory to the line of mill table travel, then secure it in place.
2. Position the tailstock on the mill table with the center tip pointing to the rotary table, then loosely secure it to the table.

Important: *The workpiece will have to be center-drilled in at least one end to be used with the tailstock center. If the workpiece is to be mounted between centers, then both ends need to be drilled.*

3. Slide the tailstock toward the rotary table so that you can mount and hold the workpiece in place.

Note: *Keep the center retracted into the tailstock as much as possible to provide greater workpiece stability.*

4. Use an indicator mounted on the mill spindle to test the top and side alignment of the workpiece.
5. Make adjustments to the height of the tailstock center or the lateral position of the tailstock body, if necessary. Then fully tighten the tailstock mounting fasteners.
6. Repeat **Steps 4–5** until you are satisfied with the workpiece alignment to the mill spindle.

Maintenance

Use a vacuum to remove chips from the tailstock, then use mineral spirits to wipe away built-up grime.

Periodically, remove the height adjustment bolt and the center block from the tailstock. Fully extend the dead center, then apply a thin coat of light machine oil to the length of the dead center, and the unpainted cast iron surfaces of the center block and tailstock.

