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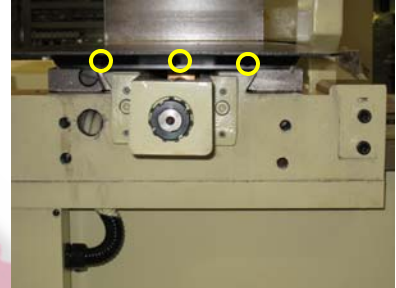
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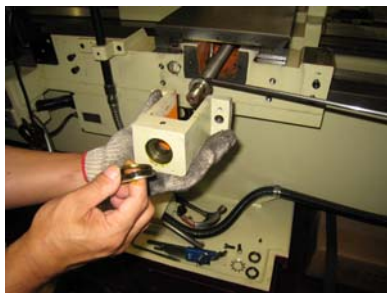
PROCEDURE TO INSTALL 24" /29" LATHE TAPER TURNING ATTACHMENT

1. Loosen the three M5 screws, take off cover from machine.



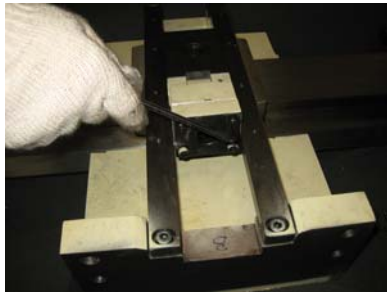
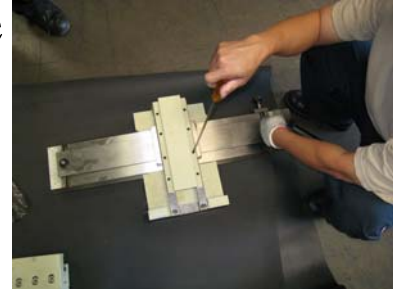
2. Loosen first locking nut. Then loosen the spring washer, take off second locking nuts.

3. Loosen 2 M8 screws, take out crossfeed screw bracket.



4. Slide out bracket. Take off bearing on crossfeed screw bracket. Keep support bearing.

5. Take off cover of body of the taper turning attachment. Loosen eight M5 screws.



6. Loosen four M6 screws. Take out shaft bush.

7. Insert shaft bush on crossfeed screw, with the circular pocket facing outside.



8. Place bearing in the pocket.

9. Screw on locking nut. Make it hand tight, but allow the bracket to move free.





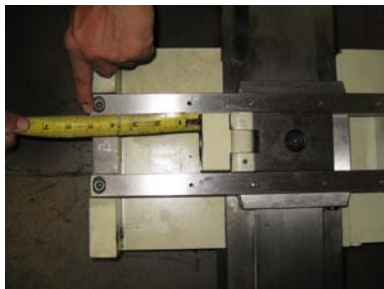
10. Put back spring washer face outwards. Put back second locking nut.

11. Use hammer and screw to tighten.



12. Punch one spike of the spring washer back to the lock washer setting groove.

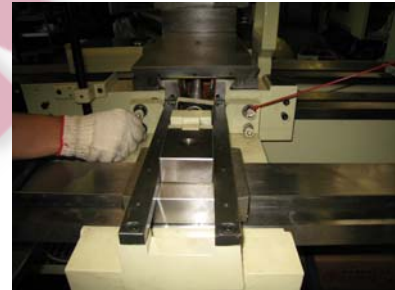
13. Measure the distance from the connecting block to the body; it should be 5 inches (See figure on left). Measure the crank of the cross-feed lead screw from the face of the rear cross slide to face of the shaft bush; leave about 4 inches of space (See figure on right).





14. Bring in the taper turning attachment and align it with the screw and the body of the taper turning attachment.

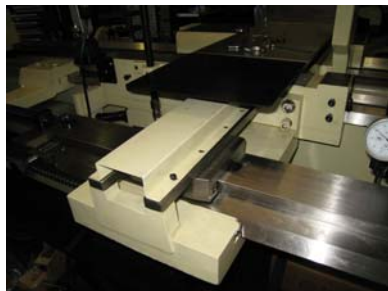
15. Align the two surfaces. Tighten the four M12 screws evenly but not too tight (See figure on right). Attach taper turning attachment to machine.



16. Crank the crossfeed leadscrew into contact. Move the bracket to contact surface and tighten the 4 M6 screws. Make sure crossfeed moves smoothly, if not you have to redo (loose the four M6 screws, realign the four M12 screws; use trial and error to make sure for free movement of cross slide.)



17. Use dial indicator to align the level of the slide plate. Move the apron 8 inches left or right to make sure it is zero to zero. (Adjust the four M12 screws.)



18. Tighten eight M5 screws on cover of the taper turning attachment. Put back the cover of the cross slide by tighten three M5 screws.

19. Tighten three M12 screws for clamp bracket.



20. Connect the connecting rod to the shaft. Tighten the M6 screw when using taper turning attachment.