



Figure 28

## NO. 7114 TELESCOPIC TAPER ATTACHMENT

The Clausing telescopic taper attachment is of sturdy construction, precision machined and easy to operate. Capacity is 4" maximum taper per foot and 10" maximum travel at one setting.

### TO OPERATE:

1. Mount work in the lathe – whenever possible the cut should be from the small diameter toward the large diameter.
2. Set point of tool bit on exact center line.
3. Lathe cross slide and taper slide should move freely, but with no up or down play. Adjust the tension with the gib screws in the cross slide and support bracket.
4. Position taper attachment so it is about in the center of the work. Lock clamp bracket to lathe bed.
5. Move the carriage by hand to make sure there is sufficient travel to complete the taper cut. If there isn't, adjust the compound rest, move the carriage or the taper attachment to a different position.
6. Set the taper bar to taper desired – graduations on left end of bar are marked in degrees (graduations indicate included angle) – the right end in inches per foot.
7. To set the attachment for taper desired –
  - A. Loosen the two lock screws (A, fig. 28) on each end of taper bar.
  - B. Turn taper adjusting screw (B) to taper desired.
  - C. Tighten the two taper bar lock screws (A).
  - D. Be sure clamp bracket (C) is locked to lathe bed.
8. Engage feed with tool approximately 1" away from beginning of cut to be sure backlash is removed before tool commences to cut.

Caution: When taper attachment is not in use, loosen clamp (C) so it will slide freely along lathe bed with the movement of the carriage and lock taper bar at zero degrees.