



## #719001, Model JWL-SA, TAILSTOCK SWING AWAY



**WARNING** – To reduce the risk of serious injury:

- Read and understand all instructions and warnings in lathe manual and Swing Away instructions before operating.
- Replace warning labels if they become obscured or removed.
- Always wear eye protection.
- Tighten knob on Swing Away before using lathe. Knob must remain tightened while Swing Away is in upright position.
- Securely tighten tailstock clamp handle before moving Swing Away.
- Do not allow Swing Away to swing freely; maintain firm grasp on Swing Away throughout movement.
- Keep fingers away from pivot pin area while moving Swing Away.
- Never release tailstock clamp handle unless Swing Away is in upright position with knob tightened.
- Failure to comply with the above warnings may result in serious or even fatal injury, or damage to machine.

**WARNING:** This product can expose you to chemicals including lead and cadmium which are known to the State of California to cause cancer and birth defects or other reproductive harm, and phthalates which are known to the State of California to cause birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov>.

**WARNING:** Drilling, sawing, sanding or machining wood products generates wood dust and other substances known to the State of California to cause cancer. Avoid inhaling dust generated from wood products or use a dust mask or other safeguards for personal protection. Wood products emit chemicals known to the State of California to cause birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov/wood>.

NOTE: This accessory is intended only for use with 14-, 16-, and 18-inch Jet Lathes. It will mount to JET lathe models JWL-1440VS/1640EVS/1840EVS/1840DVR. It can also be used on earlier models JWL-1642 and -1442, but may require modifications such as drilling additional holes.

### Contents of container:

- 1 Swing Away
- 2 Socket head cap screws, 3/8 x 1-1/4 in.
- 2 Lock washers, 3/8 in.
- 2 Flat washers, 3/8 in.
- 1 Instruction sheet

Tools required (not provided): 5mm, 8mm hex wrenches

### Assembly

Refer to parts breakdown for any assembly clarification. Numbers in parentheses refer to index numbers in parts list.

1. Make sure threaded holes in end of lathe bed are clean.
2. Confirm proper clearance around lathe for Swing Away function.
3. Remove stop bolt from lathe bed and store for future use. (**NOTE:** Always reinstall stop bolt when tailstock is on lathe bed and Swing Away is not engaged.)
4. Mount Swing Away to lathe bed with provided screws and washers (#9/10/11, Figure 1). Do not tighten yet.

5. Align top surface of Swing Away with lathe bed ways. (Use a straight edge to check.) Turn set screws (#13) as needed to help achieve parallelism.
6. When properly aligned, **firmly tighten** screws (#9).
7. Slide tailstock onto Swing Away, and check for smooth transition of tailstock across joint. Make further adjustments as needed until tailstock transitions smoothly. When done, make sure screws (#9) are securely tightened.

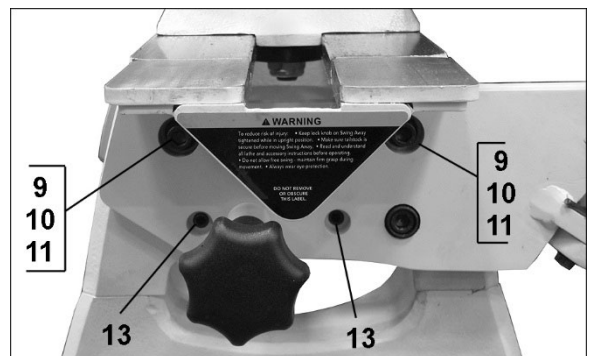


Figure 1

### JET

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## Operation

1. Slide tailstock onto Swing Away, and securely tighten tailstock clamp handle.
2. Grasp tailstock handwheel with one hand and slightly push toward lathe to relieve pressure on Swing Away. Loosen knob (#5) with other hand.
3. Swing tailstock gently downward, maintaining control throughout movement.
4. To return Swing Away to operating position, pull tailstock up; steady it with one hand and tighten knob with other hand. (Knob is under spring pressure – push in while rotating.) *Keep hands away from pinch points.*

## Maintenance

Keep Swing Away clean of sawdust and debris.

Periodically apply light coat of oil or paste wax to the way surfaces of Swing Away to prevent rust and promote smooth tailstock movement.

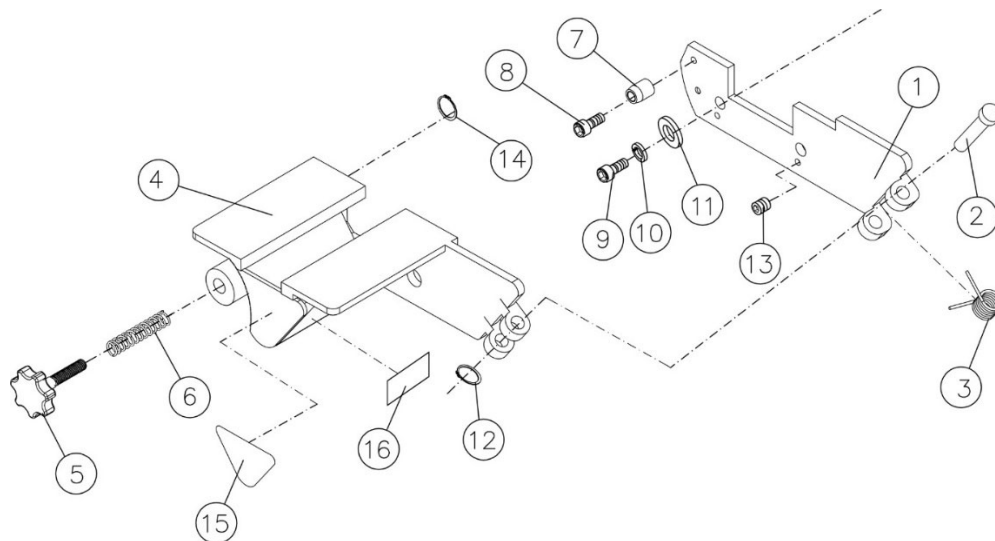
Periodically apply oil to spring and pivot pin area.

## Specifications

Model number ..... JWL-SA  
 Stock number ..... 719001  
 Main material ..... steel plate  
 Net weight ..... 16 lb. (7.3 kg)  
 Shipping weight ..... 17.8 lb. (8 kg)

*Specifications were current at time of publication, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligation*

## Parts Breakdown for #719001, JWL-SA Tailstock Swing Away



Index No	Part No	Description	Size	Qty
1		Front Plate		1
2	PMSA-102	Pivot Pin		1
3	PMSA-103	Twist Spring		1
4		Rear Plate		1
5	PMSA-105	Knob		1
6	PMSA-106	Spring		1
7	PMSA-107	Guide Pin		1
8	TS-0209011	Socket Head Cap Screw	3/8"-16x1/2"	1
9	TS-0209061	Socket Head Cap Screw	3/8"-16x1-1/4"	2
10	TS-0720091	Spring Washer	3/8"	2
11	TS-0680041	Flat Washer	3/8"	2
12	PMSA-112	C-Ring	S-11	1
13	TS-0271051	Set Screw	3/8"-16x1/2"	2
14	PMSA-114	C-Ring	S-9	1
15	LM000169	Warning Label		1
16	LM000168	ID Label, JWL-SA		1

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET.

Some parts are shown for reference only, and may not be available individually.