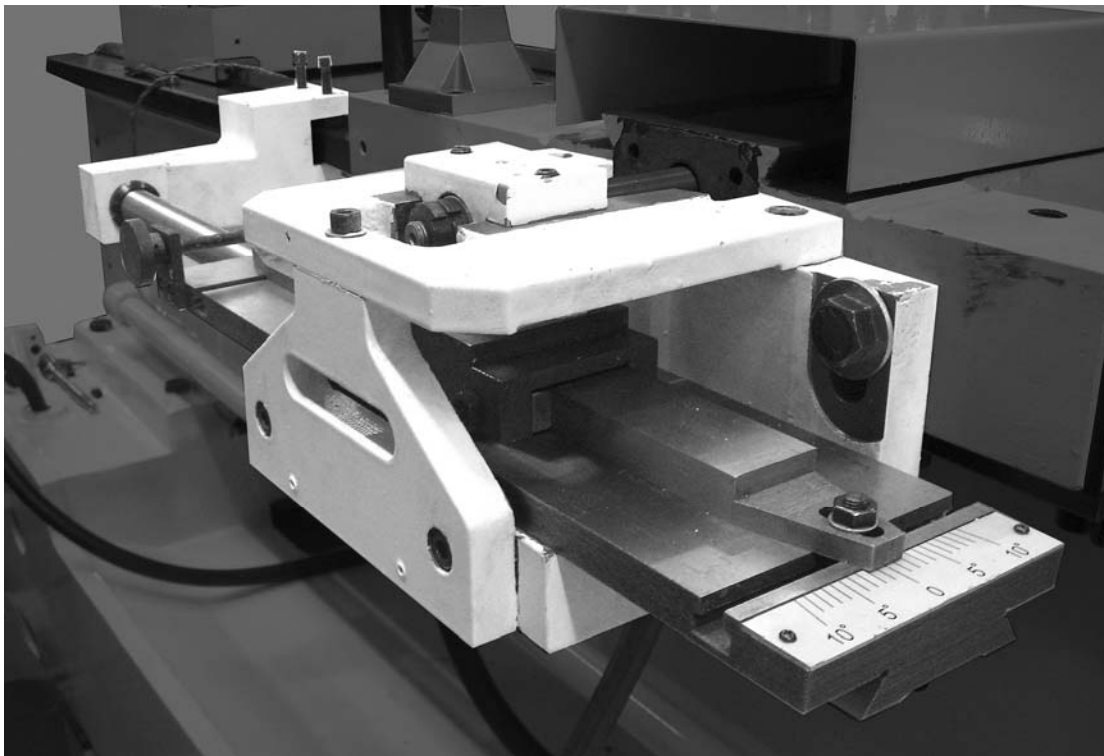




Assembly Instructions and Parts Manual Taper Attachment for ZH Lathes



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Part No. M-321293

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21. Slowly move carriage back until clamp rod is through hole in the clamp. Install outer nut (M) on rod. Tighten clamp bracket (O) and clamp rod (N) at the same time, making sure not to pull down on slide.
22. Verify that assembly is tight, and cross slide does not bind.
23. The taper attachment is assembled and ready for use. Verify that it has been thoroughly oiled for proper operation and protection of exposed metal surfaces.

⚠WARNING Read and understand all contents of your lathe manual before operating taper attachment.

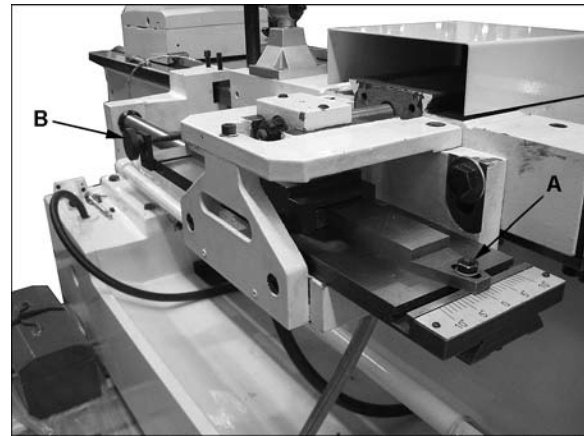


Figure 12

6.0 Operation

To use taper attachment, tighten screws on clamp. Loosen screws when taper attachment is not in use; this allows standard turning operations without requiring removal of the taper attachment.

6.1 Setting taper angle

1. Loosen screws (A, Figure 12) at each end of slide.
2. Use fine adjustment knob (B, Figure 12) to set angle according to scale at end of slide.

Note: Scale settings will be sufficient for most work, but for close tolerances use a dial indicator and test bars.

3. Tighten the two screws (A) when desired angle is achieved.

6.2 Gib Adjustments

Refer to exploded view, section 16.1.1.

1. To adjust the slide gib (#21), loosen nuts (#23) and turn screws (#22), as needed.
2. To adjust the larger gib (#7) turn the BB

7.0 Replacement Parts

To order parts or reach our service department, call 1-800-274-6848 Monday through Friday (see our website for business hours, www.waltermeier.com). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

7.1.1 Taper Attachment (#321293) for ZH Lathes – Parts List

Index No	Part No	Description	Size	Qty
1	C6266C-15103	Clamp		1
2	GB83-M10x40	Square Cap Bolt	M10x40	2
3	C6266C-15102	Bracket		1
4	ZX-Q118	Round Nut	M24x1.5	2
5	C6266C-15707	Clamp Rod		1
6	C6266C-15711	Adjusting Bolt		2
7	C6266C-15710	Gib		1
8	GB118-10x40	Taper Pin	10x40 mm	2
9	CL1640ZX-0204	Hex Cap Bolt	M16x55	2
10	C6266C-15104	Slide Base		1
11	C6266C-15106	Bracket		1

12	GB118-6x40	Taper Pin	6x40 mm	2
13	TS-1505021	Hex Socket Cap Screw	M10x20	4
14	C6266C-15708	Feed Block		1
15	GB1155-6	Oil cup	6 mm	3
16	GB77-M10x14	Hex Socket Set Screw	M10x14	2
17	C6266C-15105	Positioning Plate		1
18	TS-1504061	Hex Socket Cap Screw	M8x30	1
19	C6266C-15709	Positioning Pin		2
20	C6266C-15107	Taper Slide Rest		1
21	C6266C-15108	Slide Gib		1
22	GB75-M8x30	Slotted Cylindrical End Set Screw	M8x30	2
23	TS-1540061	Hex Nut	M8	4
24	TS-1550061	Plain Washer	8 mm	2
25	C6266C-15702	Guide Plate		1
26	C6266C-15701	T-Bolt		2
27	C6266C-15101	Longitudinal Slide		1
28	C6266C-15301	Angle Scale		1
29	GB827-3x8	Rivet	3x8 mm	2
30	GB71-M8x18	Slotted Set Screw	M8x18	1
31	GB75-M6x8	Recessed Head Set Screw	M6x8	1
32	C6266C-15705	Positioning Plate		1
33	C6266C-15704	Screw		1
34	TS-209203	Roll Pin	3x20 mm	1
35	C6266C-15706	Knob		1
36	GB65-M6x16	Countersink Head Screw	M6x16	2
37	C6266C-15703	Guiding Block		1
38	TS-155010	Washer	16 mm	2

7.1.2 Taper Attachment (#321293) for ZH Lathes – Exploded View

