ONEWAY MANUFACTURING

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Quality Products, Designed by Woodturners for Woodturners.

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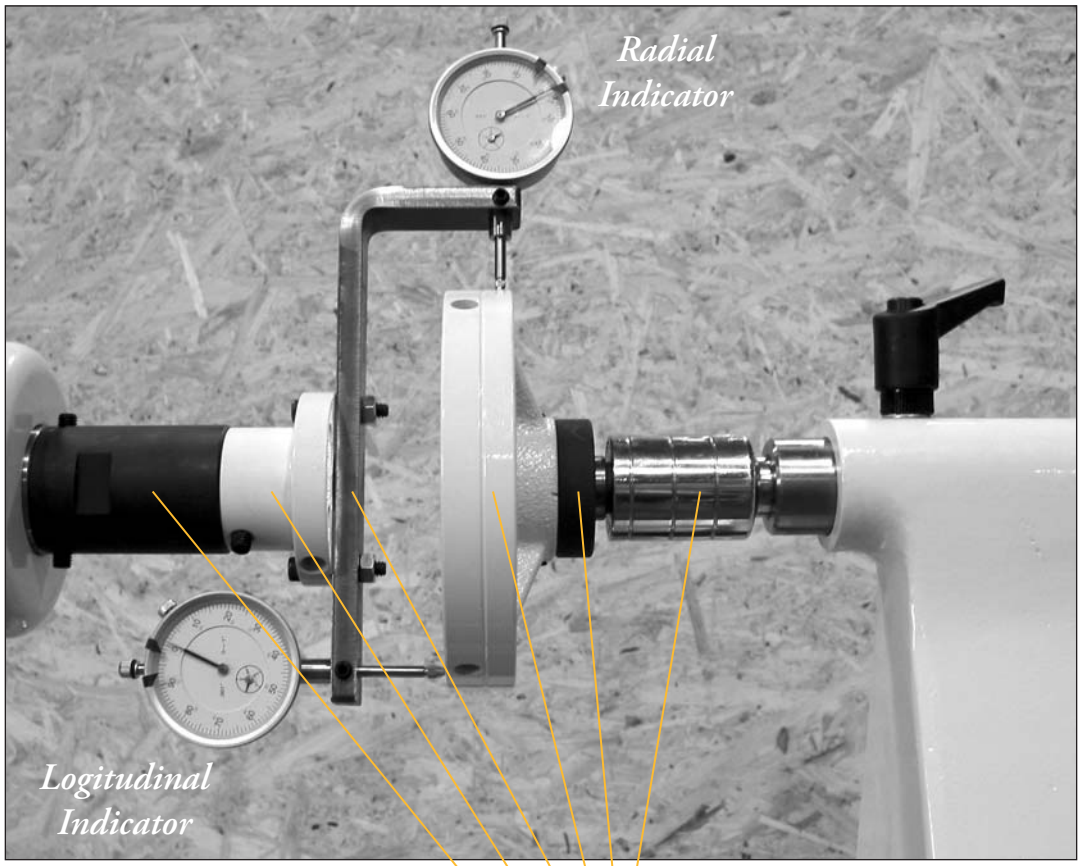
Riser Block Alignment Kit

The alignment kit (shown below) is used to align the headstock with your tailstock (situated on a Riser Block) on the outboard side of your lathe.



Spindle Extension
3” Faceplate
Alignment Bracket (indicators installed)
6” Faceplate
Live Center Adaptor
No. 3 Live Center

Alignment Instructions

Congratulations on your purchase of a Tailstock Riser Block. In order for it to work, it must be aligned with the spindle.

To set up:

1. Set your Riser Block on the out board extension.
2. Mount your Tailstock on the Riser Block and clamp.
3. Insert your Oneway Live Center into the Tailstock.
4. Screw the face plate adaptor to the Live Center.
5. Screw your 6" Face Plate to the face plate adaptor.
6. Screw the spindle extension to the out board side of your Headstock.
7. Mount 3" Face Plate to the indicator bracket with the two M6 x 35 flathead screws & nuts.
8. Screw the 3" Face Plate (with bracket attached) to the spindle extension on the out board side.
9. Using the Tailstock Handwheel, move the tailstock assy (with face plate attached) forward to where the Radial Indicator hole centers on the position over the Face Plate (as shown on the photo enclosed).
10. Set the top (Radial) indicator as shown, and tighten with the nylon point set screw. Do **not** over tighten.
11. Rotate the Spindle and read the total indicator travel.
    Half this travel is the shim pack you will need to insert between your mounting plate and side rails of your large out board.
    You have 2 - .187 thick shims
    4 - .062 thick shims
    6 - .015 thick shims
    2 - .010 thick shims
    This shim pack (Part # 3277) will allow shimming to max run out .010.
12. Insert and clamp the second indicator (Longitudinal) as shown.
    Set zero at the bottom and rotate to top position. Run out will not be much and this can be tweaked with your rear jack legs at the final adjusting stage.
13. Check the front and rear position. There should be enough play in the bolt holes to make side-way adjustment. Read and adjust using the Radial Indicator.
14. Now make longitudinal alignment using the read out on the face of the Face Plate. Bump the rear of the outboard back and forth (perpendiclar to the bedways) as needed to obtain less than .010 TIR (Total Indicator Reading).
15. Recheck and adjust radial. Recheck and adjust side to side (Longitudinal).
16. If you are comfortable with the process, drilling and reaming 4 holes and inserting straight or taper dowels in the mounting plate will allow removal and re-installing of the out board accurately without the need to repeat the above alignment process.