

### SPECIAL ACCESSORIES

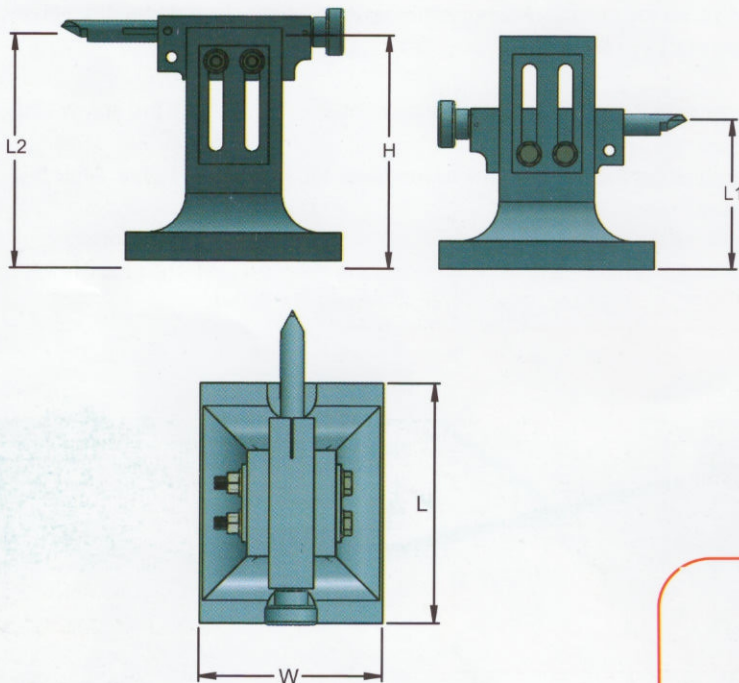
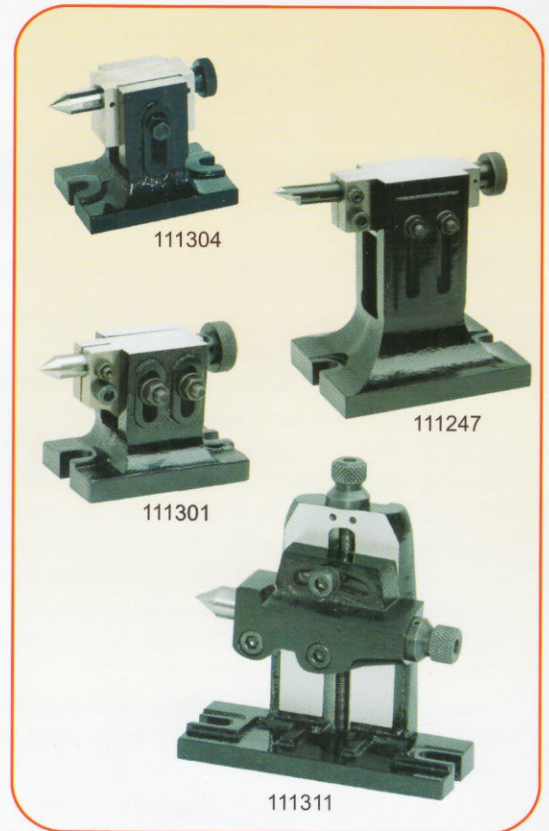
The height can be varied when working with different index centers, while the angle of inclination can be changed for various machining applications. In addition, the tip of the center is finely rotatable. Clamping is made by tightening of bolts

#### Order No. & Dimensions for Tail Stock Unit mm/in.

| Order No. R | Center Height |     |         |     | Suitable for                                   |
|-------------|---------------|-----|---------|-----|--|
|             | Maximum       |     | Minimum |     |  |
|             | Inch          | mm  | Inch    | mm  |  |
| 111301      | 6.1/4         | 108 | 3.3/16  | 80  | 110242, 110239, 110241                         |
| 110247      | 8             | 200 | 4.3/4   | 120 | 110243, 110244                                 |
| 111304      | 3.3/8         | 85  | 1.1/2   | 38  | 111300, 111305, 111310, 110239, 110275, 110280 |
| 111311      | 3.3/8         | 85  | 1.1/2   | 38  | 111300, 111305, 111310, 110239, 110275, 110280 |

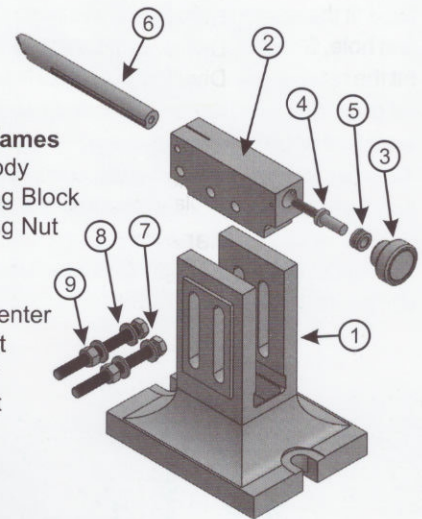
#### To install the Tailstock to your Milling Table:

- Secure the Rotary Table in the vertical position on the Milling Table.
- Install the Tailstock onto the milling table so the dead center of the Tailstock is inline with the center of the Rotary Table. Slots are provided for keys to help with alignment of centers.
- Align the dead center of the Tailstock by loosening the hex bolts located on the side of the Tailstock. With a precision level or indicator (depending on tolerance of work being performed), make the dead center parallel to the horizontal plane and on center with Rotary Table center.



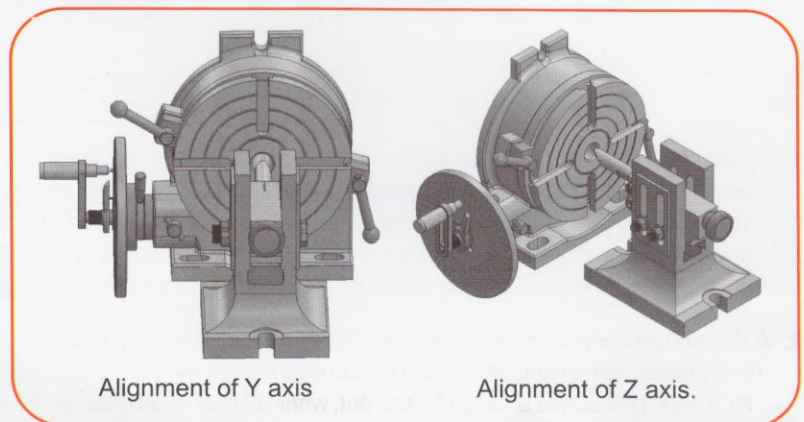
#### Part No. Parts Names

- 01 Main Body
- 02 Adjusting Block
- 03 Adjusting Nut
- 04 Stud
- 05 Ring
- 06 Dead Center
- 07 Hex Bolt
- 08 Washer
- 09 Hex Nut



#### Dimensions (inches)

|                                 | 111301        | 110247        |
|---------------------------------|---------------|---------------|
| Base Length (L)                 | 5-1/2         | 7-1/4         |
| Base Width (W)                  | 3-1/2         | 5-1/2         |
| Base Height (H)                 | 4-3/8         | 7-7/8         |
| Height min/max (L1/L2)          | 3-1/8 / 4-1/8 | 5-1/4 / 7-7/8 |
| Spindle Horizontal Displacement | 1             | 1-1/16        |



Alignment of Y axis

Alignment of Z axis.