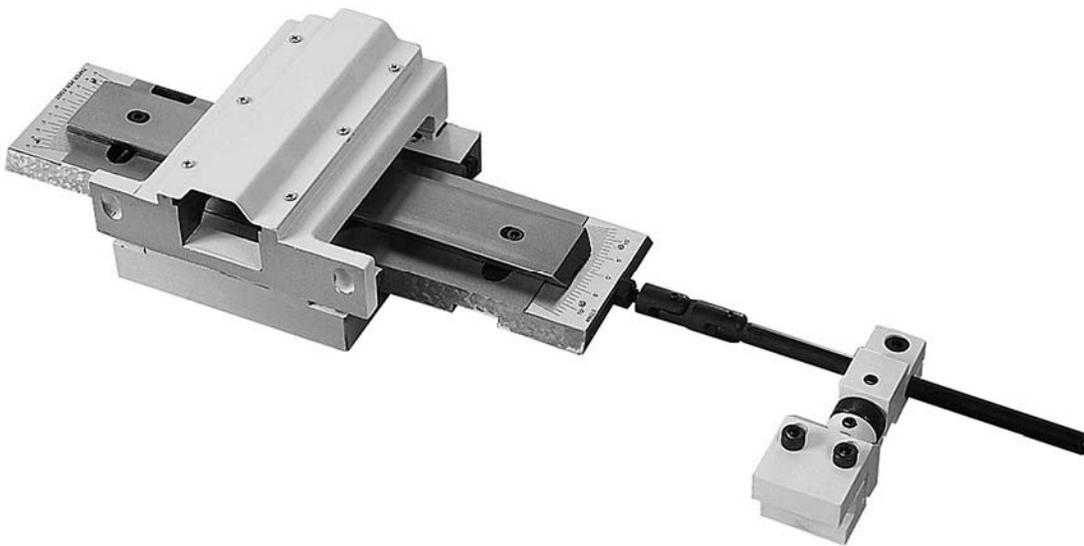




# Assembly Instructions and Parts Manual

## Taper Attachment Kit for GHW Lathes

Model TAK-GHW



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# Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

## Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

## Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

## What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance.

## Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

## How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

## More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

## How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

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## Product Listing with Warranty Period

90 Days – Parts; Consumable items; Light-Duty Air Tools
1 Year – Motors; Machine Accessories; Heavy-Duty Air Tools; Pro-Duty Air Tools
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools

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# Assembly

**Note:** numbers in parentheses (#) refer to the exploded view and parts list.

1. Remove the splash guard from the backside of the lathe.
2. Remove the taper attachment from the box.
3. Remove the dust cover (29) held in place with six screws (5).
4. Loosen and remove gib screws (16 & 24). Do not adjust or remove gib screw (24A); this will aid assembly when putting the taper attachment together.
5. Remove the longitudinal slide assembly (6 & 11) from the slide base.
6. Thoroughly clean all parts of the taper attachment with cleaning solvent.
7. Remove two nuts (A, Figure 1) and the bearing cap (B, Figure 1) from the end of the cross slide screw (C, Figure 1)
8. Remove the thrust bearing assembly from the cross feed screw.
9. Remove two hex socket cap screws (D, Figure 1) and the block (E, Figure 1).
10. Attach the main body (A, Figure 2) to the carriage with two M8 x 30 hex socket cap screws, and two M8 flat washers (B, Figure 2). Tighten the hex cap screws to hold the main body in place but loose enough to allow adjustment with a dead blow hammer, or rubber mallet.
11. Place the cross slide block (A, Figure 3) onto the taper slide rest (22).
12. Position the main body so that the hole in the cross slide block (B, Figure 3) lines up with the cross slide screw (C, Figure 3).
13. Push the cross slide block to engage the cross slide screw through the hole in the slide. It is important to get the slide to pass over the cross slide screw smoothly. Use a rubber mallet, or a dead blow hammer to position the main body so that the slide passes smoothly over the cross slide screw without lifting it.

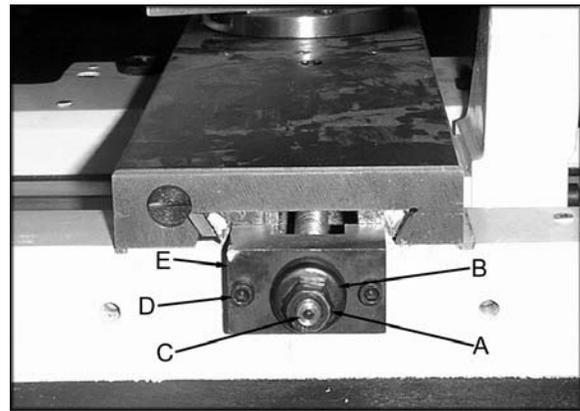


Figure 1

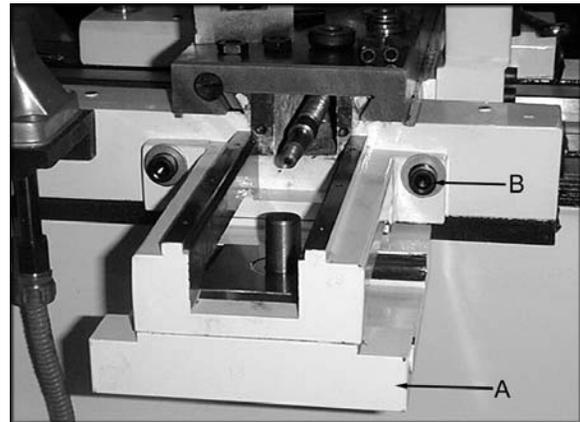


Figure 2

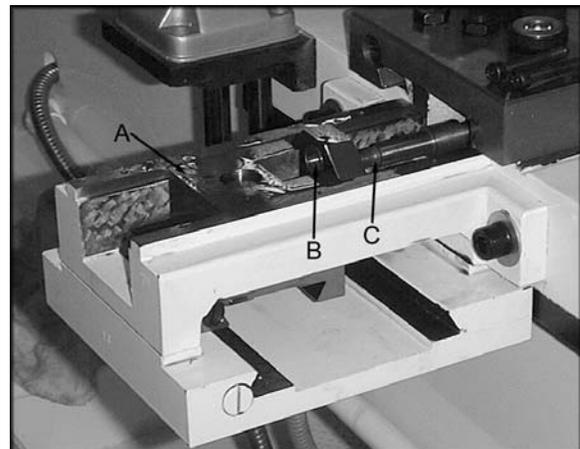


Figure 3

14. Make sure the inner bearing assembly is in place before re-assembly, no spacer. The smaller, inner diameter bearing goes on first.
15. Place the longitudinal slide (A, Figure 4) into the main body.
16. Using a dial indicator with a magnetic base (B, Figure 4) attached to the lathe bed, level the longitudinal slide to the bed. The slide assembly is level when it is less than .005" from end to end. Keep the cross slide block centered on the lead screw. Use a rubber mallet, or a dead blow hammer to position the main body so that the cross slide block passes smoothly over the lead screw and that the longitudinal slide is level.

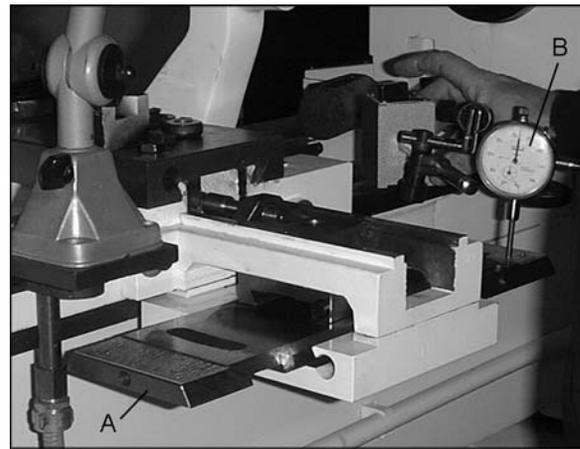


Figure 4

**Note:** repeat steps 13 & 16 until the longitudinal slide is level and the cross slide block passes smoothly over the cross slide screw.

17. Tighten two M10 x 30 hex socket cap screws that hold the main body in place.
18. Re-check the longitudinal slide for level.
19. Clean and lightly oil all gib surfaces that were previously removed.
20. Replace the taper slide, gibs and gib screws.
21. Check to make sure the slide moves easily and without excessive play.
22. Replace the outer bearing assembly (A, Figure 5). The smaller inner diameter bearing goes on first.
23. Install two hex nuts (B, Figure 5). Tighten the inner nut first to snug up the bearing assembly. Turn the cross slide handle and check for smooth rotation. Tighten the jam nut to hold the adjustment.

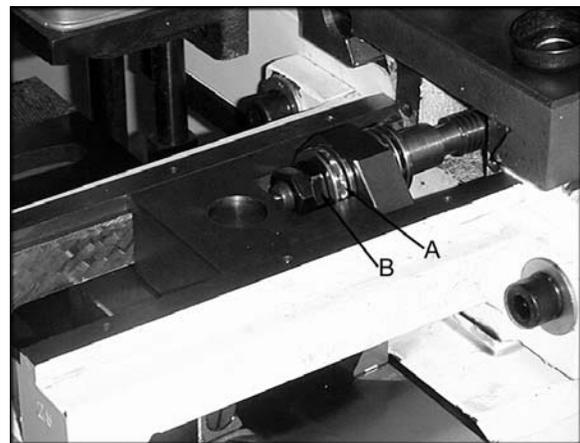


Figure 5

**Note:** It is not necessary, but a good idea to drill and pin the taper in place through the slide bracket (3N).

24. Replace the dust cover.
25. Thread the lock down linkage (A, Figure 6) into the end of the slide assembly (B, Figure 6).
26. Place the clamp (C, Figure 6) onto the lathe bed and tighten two hex socket cap screws (D, Figure 6).
27. Line up the hole in clamp with the lock down linkage (E, Figure 6) and insert. Tighten the hex socket cap screw (F, Figure 6).

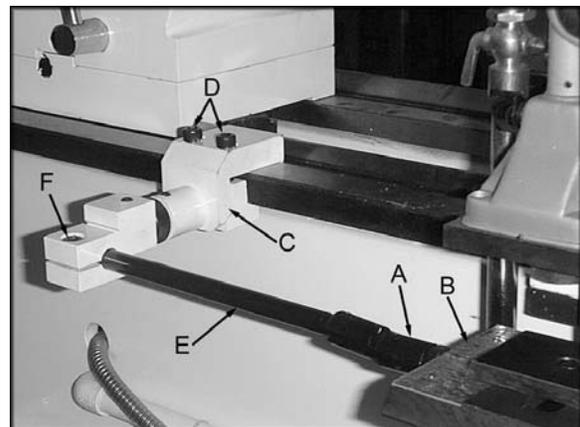


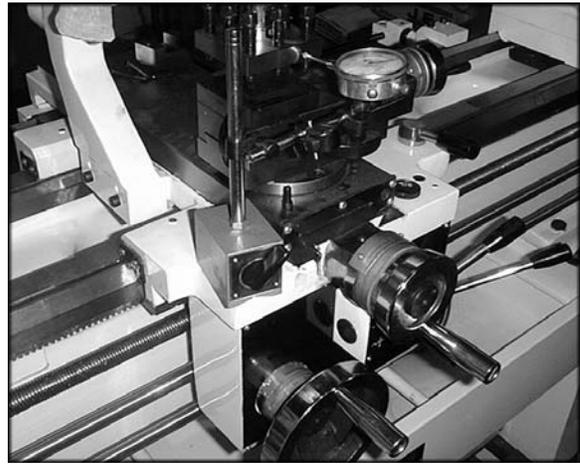
Figure 6

28. Using a dial indicator mounted to the carriage indicate along the tool post, while moving the carriage, (Figure 7). You are checking to see that the taper slide is parallel to the movement of the carriage.

**Note:** You will need to loosen hex socket cap screws (12 & 13). This will allow you to turn the adjusting screw (18).

29. When the taper slide is parallel make sure the screws (12 & 13) are tight, and mark the zero point with a chisel.

- These taper attachments are designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a taper attachment, do not use until proper training and knowledge have been obtained.
- Tighten the clamp bracket (59N) only when using the taper attachment. You may want to remove the clamp bracket when not using the taper attachment.

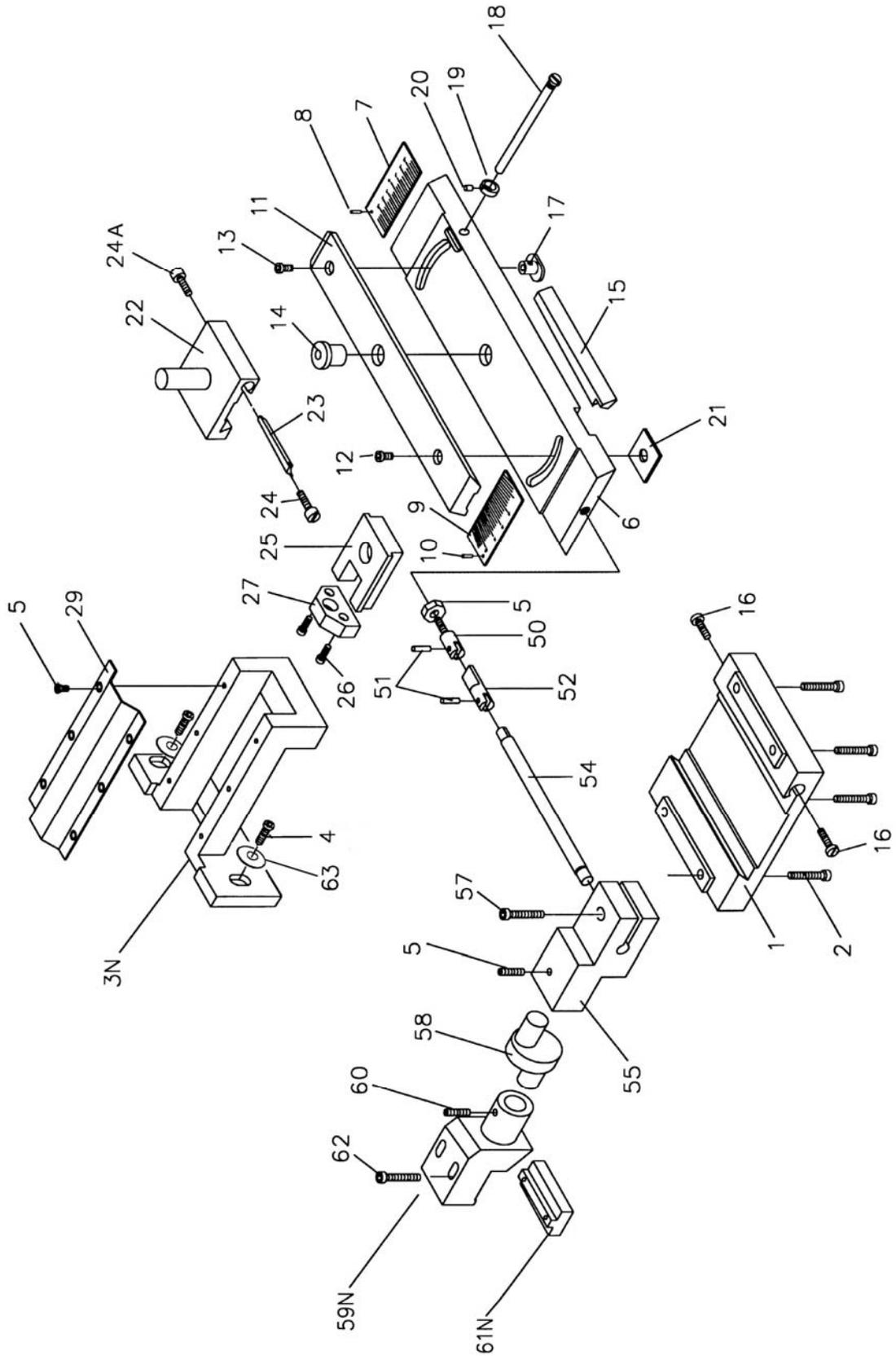


*Figure 7*

## Replacement Parts

To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

# TAK-GHW Taper Attachment Kit – Exploded View



## TAK-GHW Taper Attachment Kit – Parts List

Index No	Part No	Description	Size	Qty
1	TAK1340A-1	Slide Base		1
2	TS-1504081	Hex Socket Cap Screw	M8 x 40	4
3N	TAK1340W-3N	Slide Bracket		1
4	TS-1504061	Hex Socket Cap Screw	M8x 30	2
5	TAK1340A-5	Screw	M5x 8	6
6	TAK1340A-6	Longitudinal Slide		1
7	84-0004-00	Taper Indicator Plate		1
8	TAK1340A-8	Rivet		2
9	TAK1340A-9	Angle Indicator Plate		1
10	TAK1340A-10	Rivet		2
11	TAK1340A-11	Taper Slide		1
12	TS-1503031	Hex Socket Cap Screw	M6 x 12	1
13	TS-1503051	Hex Socket Cap Screw	M6 x 20	1
14	TAK1340A-14	Axle		1
15	TAK1340A-15	Gib Strip		1
16	TAK1340A-16	Adjusting Screw		2
17	TAK1340A-17	Adjusting Nut		1
18	TAK1340A-18	Adjusting Screw		1
19	TAK1340A-19	Adjusting Knob		1
20	TAK1340A-20	Spring Pin	3 x 14	1
21	84-0013-00	Clamping Plate		1
22	TAK1340A-22	Taper Slide Rest		1
23	TAK1340A-23	Gib Strip		1
24	TAK1340A-24	Adjusting Screw		1
24A	TAK1340A-24	Adjusting Screw		1
25	TAK1340A-25	Cross Slide Block		1
26	TS-1503051	Hex Socket Cap Screw	M6 x 20	2
27	TAK1340A-27	Feed Block		1
29	TAK1340A-29	Dust Cover		1
50	TAK1340A-50	Universal Joint (includes #52,54)		1
51	TAK1340A-51	Spring Pin	4 x 19	2
52	TAK1340A-52	Universal Joint (re: TAK1340A-50)		1
53	TAK1340A-53	Hex Nut		1
54	TAK1340A-54	Adjusting Shaft (re: TAK1340A-50)		1
55	TAK1340A-55	Lock Block		1
56	TS-1524011	Set Screw	M8 x 8	1
57	TS-1504041	Hex Socket Cap Screw	M8 x 20	1
58	TAK1340A-58	Eccentric Shaft		1
59N	TAK1340W-59N	Clamp Bracket		1
60	TS-1524011	Set Screw	M8 x 8	1
61N	TAK1340W-61N	Clamp Block		1
62	TS-1504081	Hex Socket Cap Screw	M8 x 40	2
63	TS-1550061	Flat Washer	M8	2



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