



On-line manual
(You will get a more detailed version with the tool)

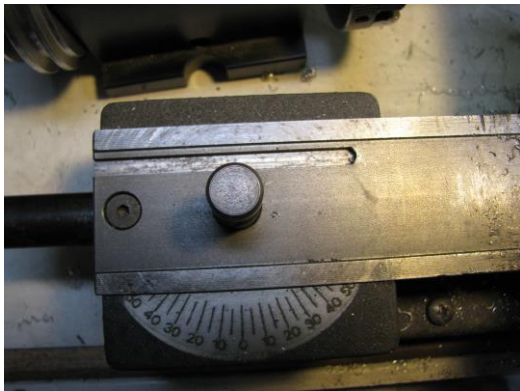
Benchtop Lathe Accessories

Morse Taper Key for Sherline Lathes

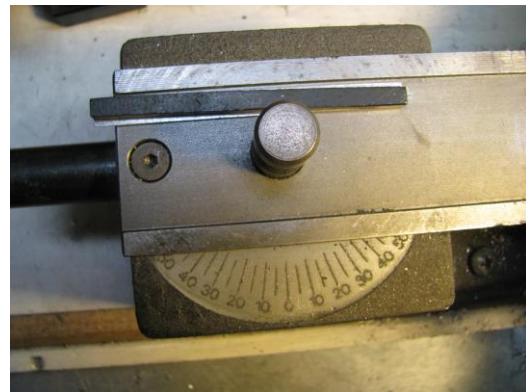
Machine Morse #0 and Morse #1 taper

Typical application: Machine Morse taper on your Sherline lathe.

Included: One Morse taper key, safety booklet, and manual.



Empty keyway in the lathe bed of Sherline's lathe.



Morse taper key inserted. Black side up.

Procedure: Replace the headstock alignment key with the Morse taper key. The black side of the Morse taper key should face upwards. Start machining; see the example below.

FAQ

Can I cut larger Morse taper? In principle yes, but you will run into size limitations which can result in unstable and dangerous working conditions. We do offer an adjustable tailstock center which can

help with machining larger sizes. Main application is machining Morse #0 and Morse #1 taper on the Sherline lathe.

Can I also cut Morse arbors? Nope, not with the key you have. Since the headstock and lathe bed have a keyway milled in, the key is not perfectly mirror symmetric. Thus, one needs a different key for cutting arbors. However, this is a not so frequent application since arbors are anyhow better cut using reamer. Therefore, we presently offer only taper keys and no arbor keys. We can make arbor keys as a custom design. Contact us if that is interesting.

Can you make this also for an UNIMAT? Nope, UNIMAT uses and alignment pin. One would need to redo the entire lathe for using an alignment key. However, we do offer a mechanical protractor for an UNIMAT.

I have a China lathe do you have...? Yes, we do offer Morse taper cutter also for China import type lathes.

Does this work on the short and long Sherline lathe? Yes, our Morse taper key works with all Sherline lathe models as far as we can say. The keyway needs to be 3/16".

Safety Notes: General safety rules for machine/power tools are in place. For an extended list of safety notes, consult the literature or go to our website. You can download free of charge a safety booklet, which is also typically included (free of charge) for first-time customers.

Use protective closing including, most importantly, **safety glasses** for metal work.

Disclaimer: **This manual does not replace training and/or books about metalwork.**

While machining parts, all relevant safety precautions need to be obeyed. This

manual has been written carefully and all procedures have been thoroughly tested. However, as always, the author and manufacturer cannot guarantee that the procedures are perfect and error-free. In addition, it is impossible to predict and prevent all the possible problems that might be encountered when working with a lathe. **Using a motor tool can be dangerous and the proper use is the responsibility of the user. Neither the author nor manufacturer shall be liable for damage arising from unprofessional use.** If you are not perfectly comfortable working with power tools, then don't do it! In this case, take a metal working class rather than following a do-it-yourself outline. Or, find a different hobby. We cannot jump in if you make a mistake that results in harm to yourself or damage to the tools you use. Don't use broken or damaged tools, perhaps purchased cheaply at a secondhand store or who knows where. **Thoughtful work will be your responsibility.**

The author makes no representations or warranties with respect to the accuracy or completeness of the contents.

The author is not a professional machinist or engineer. In fact, the author holds a PhD in physics and teaches physical chemistry at a college. Therefore, no information provided herein represents professional advice or best practices in machining. All information is provided to help hobbyists and other non-professionals gain a better understanding of using mini benchtop tools for hobby type work.

This manual and accessories features a particular lathe model. However, none of the statements or procedures may coincide with the lathe manufacturer's

opinion or interests. If the accessory was purchases via a retailer then the retailer's customer service will be in charge of

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