

**SHERLINE  
PRODUCTS**  
INCORPORATED 1974

# #1 Morse Taper Removal Tool

P/N 1156

### Purpose and Use of the Taper Removal Tool

Throughout the years, some customers have asked for a way to remove tapered tools like drill chucks, boring heads or the WW Collet Adapter from the spindle without having to hit the drawbolt with a hammer or use a knockout bar, fearing it might knock their headstock out of alignment. This simple removal ring screws onto the 3/4-16 thread on the Sherline headstock spindle nose. To remove a tool that is drawn into the #1 Morse taper, **first loosen the drawbolt a few turns**. Turn the removal ring counter-clockwise until it contacts the top face of the tool to be removed. Then use one Tommy bar to keep the spindle from turning and the other in the hole of the removal tool to break loose the taper.

### Using the Shim Washers

Two thin washers are provided to slip on each other to prevent the male taper from turning in the spindle while it is pushed out.

### Removing a Drill Chuck

A special “C” shaped, Release Ring Spacer allows it to be used to remove drill chucks as well. To remove a drill chuck, slip the Release Ring Spacer onto the spindle shaft between the removal ring and the top of the drill chuck. Loosen the chuck drawbolt a few turns. It will clear the hex portion of the #1 Morse arbor and allow the ring to push directly on the back of the chuck. Rotate the removal ring counter-clockwise to thread it down until it contacts the Release Ring Spacer. Use one Tommy bar to rotate the ring and the other in a hole in the spindle to keep it from turning. This should give you the leverage you need to pop the taper loose. Once loose, slowly remove the drawbolt while supporting the chuck so it doesn't drop out of the headstock.

### CAUTION

Unscrewing the removal tool may also unscrew the chuck from the arbor as it breaks the taper loose. Once the chuck is removed be sure to re-tighten the arbor.

Thank you,  
Sherline Products Inc.

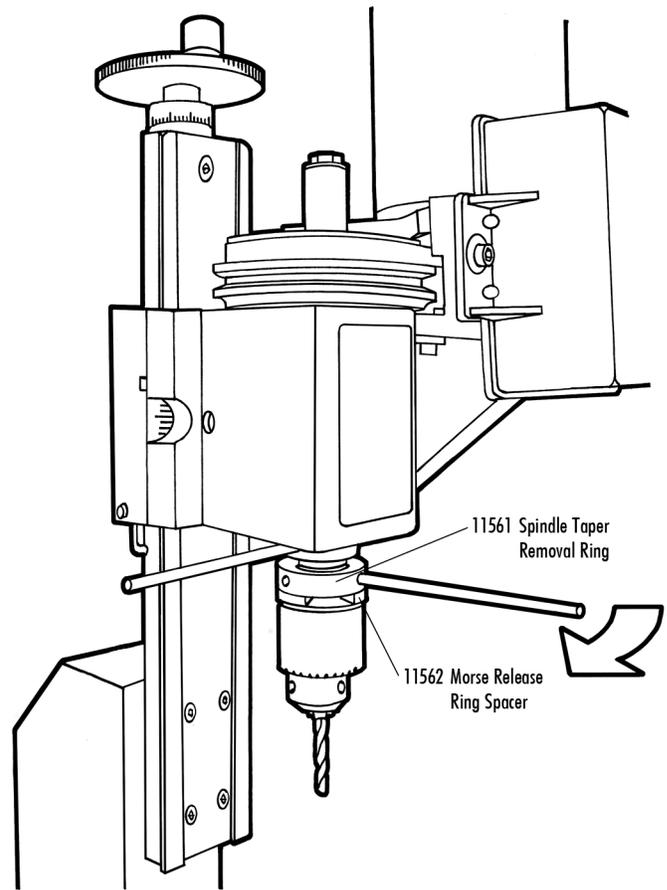


FIGURE 1—While holding the Tommy bar in the spindle, rotate the removal ring to push down on the drill chuck.

### #1 Morse Taper Removal Tool Parts List

NO. REQ.	PART NO.	DESCRIPTION
1	11561	Spindle Taper Removal Ring
1	11562	#1 Morse Release Ring Spacer
2	11824	Shim Washers
2	40580	Tommy Bars