

Crosslide Accessory Plate

P/N 3017

Use of the Crosslide Accessory Plate

Though fitted to the lathe, this is actually an accessory designed for milling. The table on the mill is thicker than the table on the lathe because of the greater forces transferred to the table in milling and the requirement for stiff setups. When using the vertical milling column on the lathe, the table can be "beefed up" with the addition of this plate which adds 1/2" (12.7mm) of thickness to the table. It also serves as a tooling plate which protects the surface of your lathe table from damage. It should be removed for lathe turning otherwise the tool post will be holding the cutting tool a 1/2" too high. Also, clearance over the table would be needlessly reduced by the same amount.

When you add the crossslide accessory plate to your lathe table, the 10-32 screws should be tightened in a crisscross pattern as seen below in Figure 1.

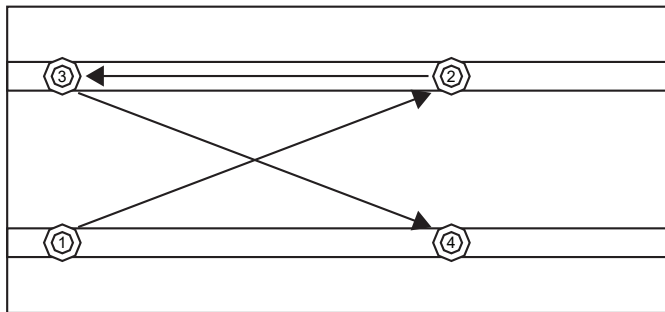


Figure 1—Screw tightening pattern as seen from the top view of the crossslide accessory plate.

The Crosslide Accessory Plate Works Well on the Mill

1. On the mill, it can be used to extend the length of the mill table. This extension is used mostly for mounting the rotary table vertically without losing usable travel on the table.
2. If you use the crossslide accessory plate on the mill table with the rotary table and you are using the adjustable tailstock, you can use two of these (one on each end) to keep the centerline height of both the rotary table and the adjustable tailstock the same.

Thank you,
Sherline Products Inc.

Specifications:

- Plate size: 2.75" x 6" x 0.5"
- T-slots: 1.5" on centers
- Mounting holes on center with T-slots, first set: 0.5" in from end, other set 3.5" on center from first set

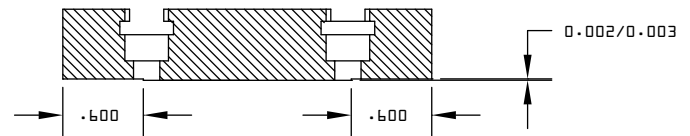


Figure 2—Cross section of the crossslide accessory plate

NOTE: The reason for the .002-.003 x .600 flats is because when the accessory plate was flat all the way across, tightening the screws would cause the crossslide to bow slightly and lock up.

Parts List

NO. REQ.	PART NO.	DESCRIPTION
1	30171	Crosslide Accessory Plate
4	30565	10/32 Modified T-nuts
4	40510	10/32 x 3/8" SHC Screws