



**SHERLINE  
PRODUCTS**  
INCORPORATED 1974

## Sherline Mill Extended Headstock Spacer Block

P/N 1299

### Use of the Extended Headstock Spacer Block

Having the option to extend the Headstock further out can sometimes allow surfaces to be machined that could not otherwise be reached without breaking down the setup and re-clamping the part. The standard P/N 1297 headstock spacer moves the spindle out an additional 1-1/4". The P/N 1299 extended spacer moves the spindle out twice that distance, or approximately 2.5". In many cases, it is much easier to increase your machinable surface area by using this spacer than it is to re-clamp the part. Precisely machined keyways keep the headstock accurately aligned. Laser engraved scales to indicate head tilt angle duplicate those on the standard headstock mounting. Also included is a precision ground alignment key.

### Using one block vs. stacking two together

With the additional bed length of the model 2000 mill and the advent of longer optional bases and tables, it has sometimes been necessary to stack two spacer blocks together in order to achieve enough throat distance to work on a larger part. Alignment becomes more of an issue when you start bolting multiple pieces together. In order to alleviate this situation, Sherline now offers what is in effect a "double" spacer block as all one piece. This extends the usable work area while maximizing rigidity and accuracy of the setup. The extended spacer block is not intended for use on the Sherline lathe.

### Installing the Spacer Block

Like the P/N 1297 standard headstock spacer block, the P/N 1299 extended spacer block is installed over the mill column saddle pin. A precision ground alignment key is installed between the spacer block and the saddle. A second alignment key is installed between the spacer block and the headstock. If the headstock is to be aligned in any position other than straight up and down, the second alignment key is not installed so the headstock can be rotated on the pin. When in the desired position, the cone point set screw in the side of the block is tightened using a 5/32" hex key. The point of the set screw engages a tapered groove in the pin, pulling the headstock down onto the alignment key as the screw is tightened. Note that the pins are slightly loose in both the saddle and the spacer block. This is the way they are designed, as the proper function of the pin is simply to pull the headstock down onto the alignment key and to let the keyway do the aligning rather than the pin.

Thank you,  
Sherline Products Inc.