

SHERLINE
PRODUCTS
INCORPORATED 1974

Riser Plate for 8" Crossslide

P/N 1294

About the Riser Plate for 8" Crossslide

We designed the headstock riser plate P/N 12940 at the request of several of our customers who replaced our 6" crossslide with the thicker 8" crossslide P/N 60880 (manual) and P/N 67036 (CNC). Most of these customers are using our lathe as a chucker lathe with gang-tooling. The problem that they were facing is that we only make two tool posts that are shorter so they will be on center when you use the 8" crossslide or 13" mill table in place of the 6" crossslide. **NOTE:** We do not recommend using the 13" mill table as a crossslide.

By using this riser plate, we have raised the headstock to match the additional thickness of the 8" crossslide. Therefore, all of our standard tool posts will now be on centerline with the headstock.

Be advised that the tailstock will not align with the headstock when using this spacer. Therefore, you will not be able to turn parts between centers. Additionally, some of our other accessories, such as the thread cutting attachment P/N 3100, will also not work when you are using this spacer.

To use the riser plate you must first do the following: (*FIGURE 1:* see exploded view below for part identification)

1. Remove the headstock from the lathe.
2. Remove both P/N 40510 10-32 screws so you can remove the lathe base from the lathe bed.
3. Once the lathe base is removed you will need to remove the P/N 40900 82 degree 10-32 screw from the headstock end of the bed. This will allow you to remove P/N 40370 leadscrew support.
4. Pull the leadscrew support out.
5. Remove the P/N 40240 pivot pin.
6. Insert the new pivot pin P/N 12941 in place of the original pivot pin.
7. Slide the leadscrew support back into place (with the 5/8" diameter cutout facing down towards the lathe base). If you have the sliding shaft P/N 15090 and the fixed shaft P/N 15430 inside your leadscrew support, you will need to install them again. If you need help with this installation, read the instructions for the thread cutting attachment ([P/N 3100inst.pdf](#)).

8. Insert the 82 degree x 10-32 screw into the leadscrew support.
 9. Mount the lathe bed onto the lathe base.
 10. Insert the two P/N 40510 10-32 screws into the base.
- SPECIAL NOTE:** DO NOT OVERTIGHTEN these screws, or you will strip out the threads!
11. Mount the riser plate onto the lathe bed using the headstock key P/N 40260. The headstock key that is in the bed will need to be pulled back a bit since the keyway slot in the riser block does not go to the same depth. This means that your head key will stick out a bit more, but that is OK.
 12. Mount your headstock onto the riser plate using the original head key.

You should be ready to start making chips.

Thank you,
Sherline Products Inc.

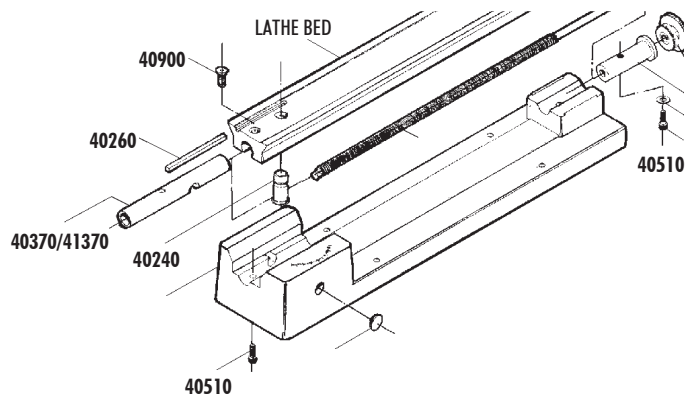


FIGURE 1

Parts List

NO. REQ.	PART NO.	DESCRIPTION
1	12940	Riser Plate for 8" Crossslide
1	12941	Pivot Pin for 8" Crossslide
1	40260	Head Key

The material for the riser plate is 6061 aluminum that is anodized.
Dimensions: .270" x 2.75" x 3.0" (H x W x D)