



DIVISION, ATLAS PRESS COMPANY  
KALAMAZOO, MICHIGAN 49001

**NO. 7127  
HAND LEVER  
TAILSTOCK ATTACHMENT**

for  
5900 SERIES CLAUSING 12" LATHES

FEBRUARY 1966

FILE NO. 7127-1

1  
2

**MOUNTING**

1. Remove complete tailstock screw and bearing assembly.

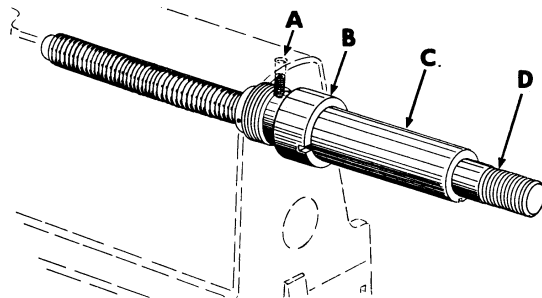


Figure 1

2. Enlarge oil hole (A, Fig. 1) with a No. 7 drill and thread with 1/4" - 20 N.C. tap.
3. Install retaining ring on ram (C) and slide ram screw (D) into ram.
4. Insert ram and screw assembly into bearing (B) and install bearing (B) into tailstock -- tighten securely.
5. Insert 1/4" - 20 x 3/8" socket set screw in hole (A) and tighten securely.

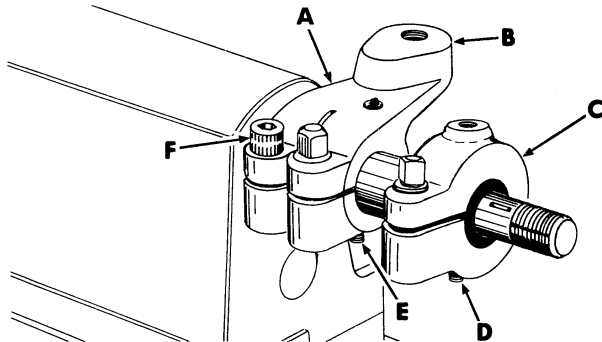


Figure 2

6. Install bracket (A, Fig. 2) on bearing. Align slot in ram with hole in bottom of bracket. Turn headless set screw (E) into bracket until dog point enters slot in ram. Adjust screw so ram slides freely and lock in place with nut. Turn bracket until pad (B) is level and lock in place with screw (F).
7. Place collar (C) on the end of ram. Align hole in bottom of collar with slot in ram. Turn headless set screw (D) into collar until dog point enters slot in ram -- lock in place with nut.

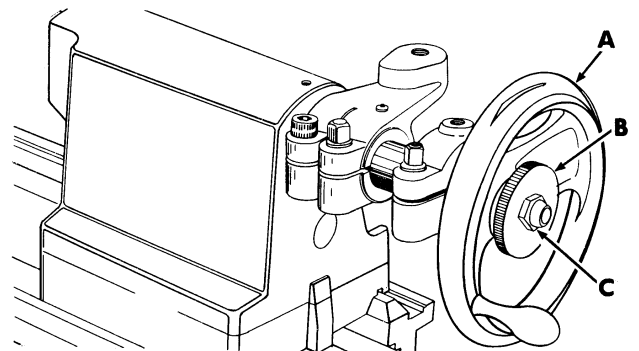


Figure 3

8. Assemble key, tailstock handwheel (A, Fig. 3), washer, knurled knob (B) and lock nut (C) on ram screw. Tighten lock nut enough to permit knurled knob 1/2 turn for locking and unlocking purposes.

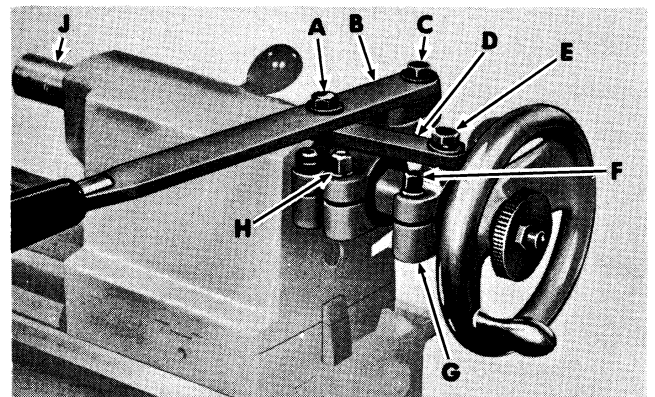


Figure 4

9. Bolt lever (B, Fig. 4) to link (D) with screw (A). Bolt lever and link to bracket and collar with screws (C) and (E).
10. Replace standard tailstock ram (J).
11. Adjust lock screw (H) until ram slides freely.
12. To set ram travel:
  - A. Loosen lock screw (F).
  - B. Move collar (G) on ram until desired travel is obtained and tighten lock screw (F).

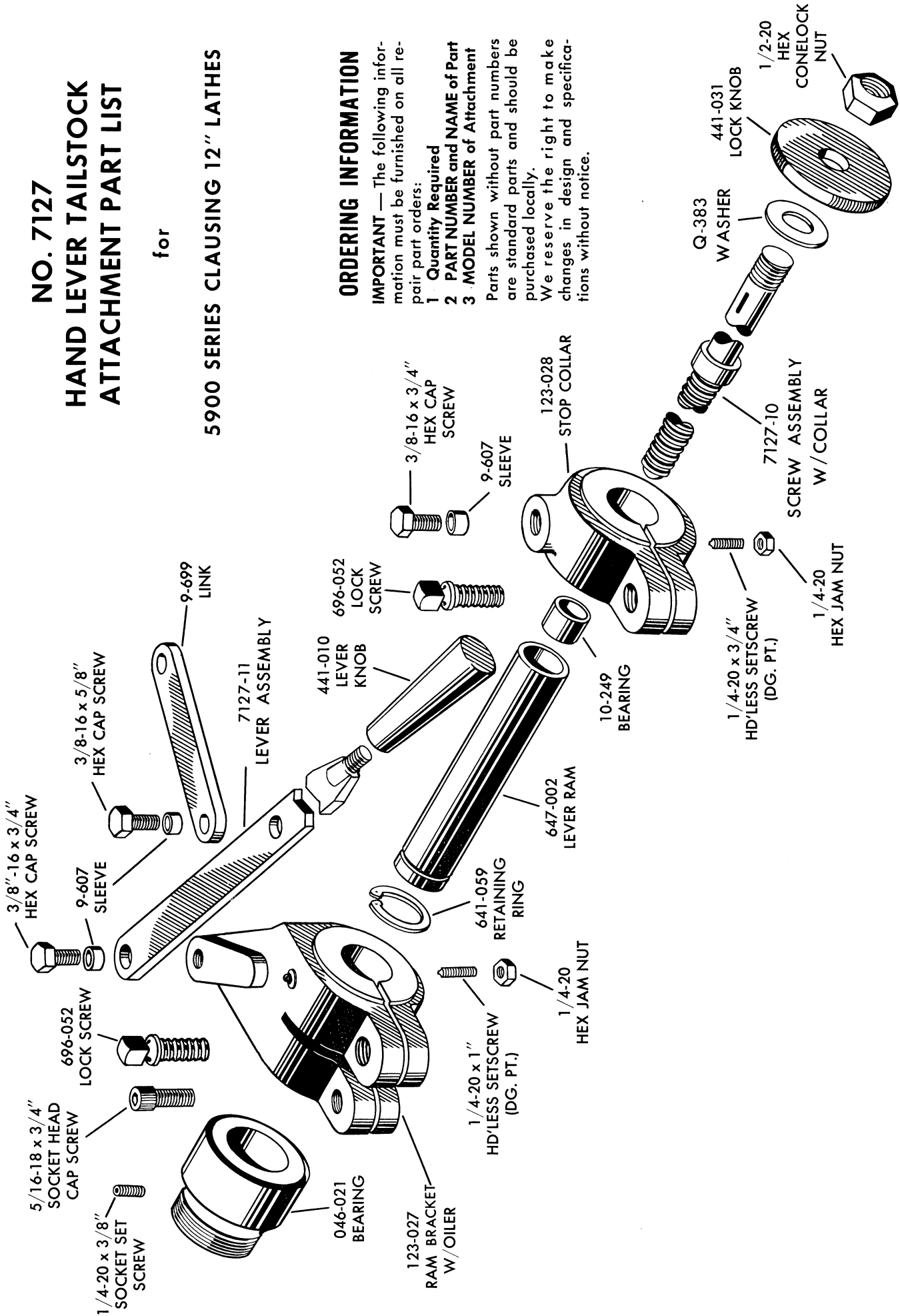
CAUTION: Excessive tightening may break collar.

**IMPORTANT:** Lubricate all moving parts with S.A.E. No. 20 oil.

# NO. 7127 HAND LEVER TAILSTOCK ATTACHMENT PART LIST

for

5900 SERIES CLAUSING 12" LATHES



## ORDERING INFORMATION

**IMPORTANT** — The following information must be furnished on all repair part orders:

1. **Quantity Required**
2. **PART NUMBER and NAME of Part**
3. **MODEL NUMBER of Attachment**

Parts shown without part numbers are standard parts and should be purchased locally.

We reserve the right to make changes in design and specifications without notice.