



For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

MODELS T10502, T10556, & T26300 TAPER ATTACHMENT INSTRUCTIONS

Introduction

This taper attachment provides precision outside and inside tapers up to 12" without having to off-set the tailstock.

Another feature is the ability to use the attachment without disengaging the cross slide. This allows the taper attachment to be functional at any time by simply tightening the bed clamp bracket. However, the taper attachment does not interfere with other turning operations.

This taper attachment features scales at both ends, reading inches-of-taper per foot and angle of taper. An adjustment knob with fine threads achieves precise control when setting tapers.

Identification

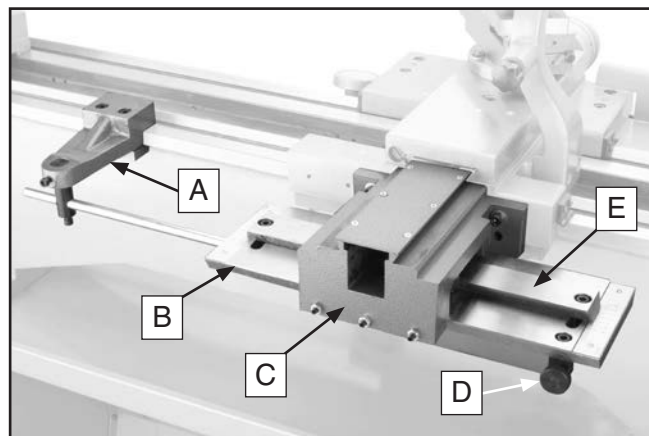


Figure 1. Taper attachment identification.

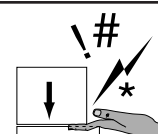
- A. Bed Clamp:** Secures the taper attachment to a specific position on the bedway and enables the use of the taper attachment.

- B. Slide Table:** Connects to the bed clamp and provides a stable platform for the pivot bar.
- C. Body:** Houses the pivot and slide blocks that connect to the cross slide.
- D. Taper Adjustment Knob:** Adjusts the angle of the pivot bar for the desired taper.
- E. Pivot Bar:** Provides an angled dovetail path to guide the tooling for the desired taper.

Specifications

Model T10556.....	for G4002, G4003, & G4003G
Model T10502.....	for G0709
Model T26300	for G0750G
Maximum Taper Length.....	9"
Taper Per Inch Range	0"– ±3"
Inch Scale Divisions	$\frac{1}{2}$ "
Taper Angle Range	0°– ±5°
Angle Scale Divisions.....	1°
Construction	Cast Iron, Steel
Shipping Weight	60 lbs.

! WARNING



This taper attachment is heavy! Get assistance when installing it on the lathe. To reduce the risk of crushing injuries, wear boots with toe protection and keep hands and fingers away from all pinch points.

Inventory

This taper attachment was carefully packed when it left our warehouse. If you discover the taper attachment is damaged after you have signed for delivery, *please immediately call Customer Service at (800) 523-4777 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the contents.

Box Contents (Figure 2):	Qty
A. Slide Table & Body Assembly	1
B. Bed Clamp Rod.....	1
C. Bed Clamp Pivot Shaft w/Cap Screw.....	1
D. Work Lamp Extension Shaft	1
E. Handwheel Handle w/Shoulder Screw.....	1
F. Alternate Leadscrew Rear Bracket.....	1
G. Bed Clamp Block w/Cap Screws.....	1
H. Bed Clamp Bracket w/Cap Screw	1
I. Cross Feed Handwheel & Leadscrew Assembly.....	1
J. Hardware Bag (Not Shown)	
— Roll Pins 6 x 30mm.....	2
— Cap Screws M8-1.25 x 25.....	2
— Cap Screws M8-1.25 x 16.....	2
— Cap Screw M8-1.25 x 12.....	1
— Cap Screws M6-1 x 25.....	2
— Cap Screw M6-1 x 14.....	1

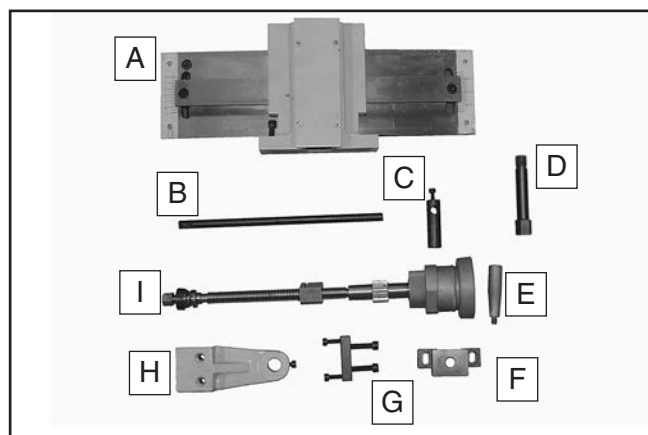


Figure 2. Shipping inventory.

Required for Setup

The items listed below are required to successfully set up and prepare this taper attachment for operation. The installation is intended to be semi-permanent and will take 1–2 hours.

Description	Qty
• Another Person	1
• Safety Glasses	1 Per Person
• Cleaner/Degreaser	As Needed
• Disposable Shop Rags.....	As Needed
• Oil Can w/General Machine Oil.....	1
• Grease NLGI#2	As Needed
• Drill & Drill Bit $\frac{9}{32}$ "	1 Each
• Bottoming Hand Tap M8-1.25.....	1
• Precision Ruler	1
• Phillips Screwdriver #0	1
• Phillips Screwdriver #2	1
• Wrench 14mm	1
• Wrench & Socket 17mm.....	1 Each
• Hex Wrench 2.5mm.....	1
• Hex Wrench 4mm.....	1
• Hex Wrench 5mm.....	1
• Hex Wrench 6mm.....	1
• Deadblow Hammer.....	1

Assembly & Installation

1. DISCONNECT LATHE FROM POWER!
2. Remove the back splash from the rear of the lathe by removing the (4) Phillips head screws and flat washers that secure it.
3. Remove the compound rest from the cross slide by removing the (2) hex nuts shown in **Figure 3**.

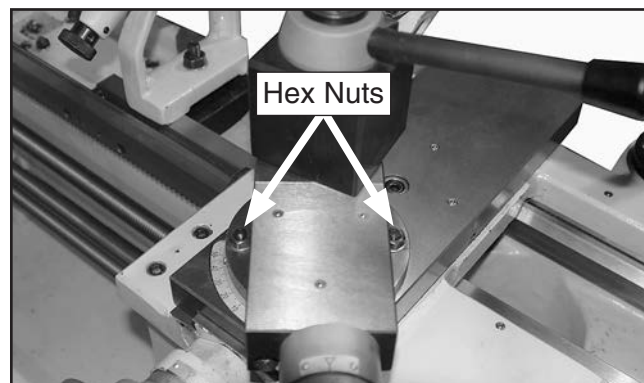


Figure 3. Hex nuts that secure the compound rest.



NOTICE

Keep track of fasteners removed. Some will be needed for re-installing components.

4. Remove the cross slide rear cover by removing the (2) cap screws shown in **Figure 4**.

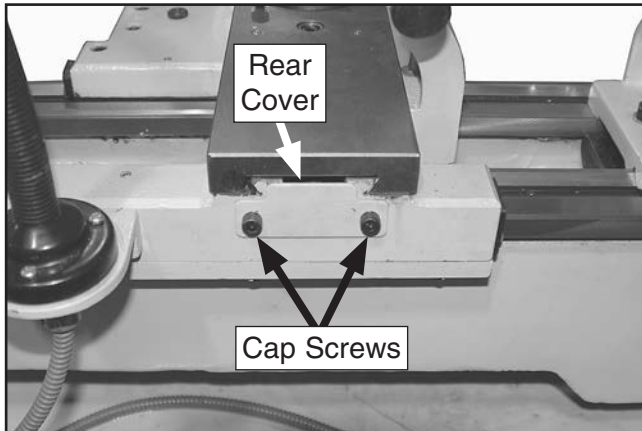


Figure 4. Cross slide rear cover location.

5. Remove the cap screw shown in **Figure 5**. This cap screw secures the cross slide to the leadscrew nut.

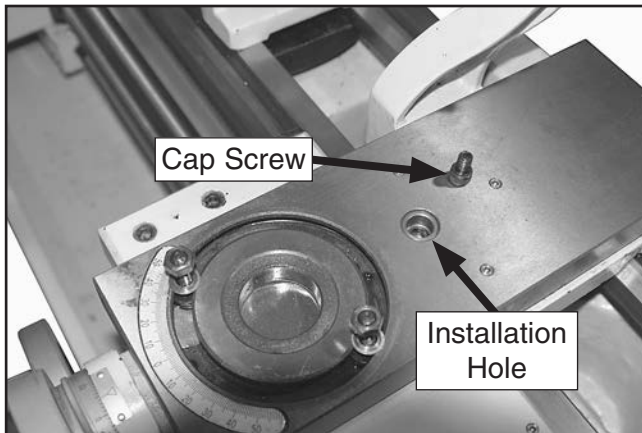


Figure 5. Cap screw removed that secures cross slide to leadscrew nut.

6. Rotate the cross slide handwheel clockwise until the leadscrew nut exits the rear of the cross slide and can be removed (see **Figure 6**).

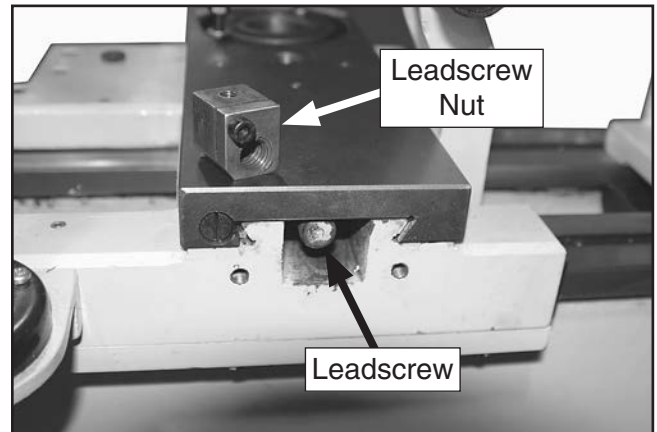


Figure 6. Leadscrew nut removed from cross slide leadscrew.

7. Loosen the set screw on the cross slide handwheel retainer (see **Figure 7**), and rotate the retainer counterclockwise to unthread and remove it from the handwheel.

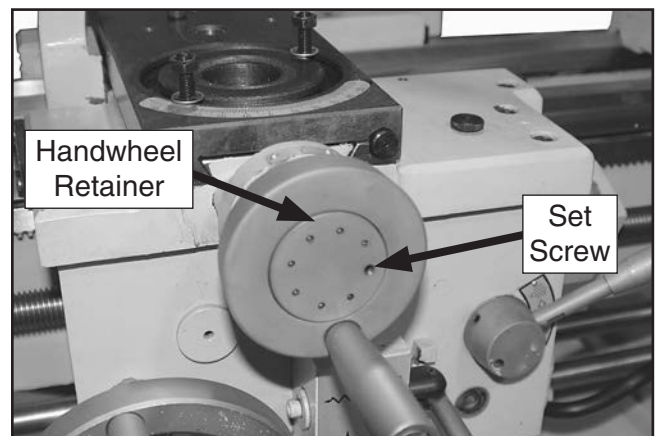


Figure 7. Handwheel retainer set screw location.



8. Slide the handwheel and graduated dial assembly off the leadscrew, then remove the two cap screws that secure the handwheel bracket to the cross slide (see **Figure 8**).

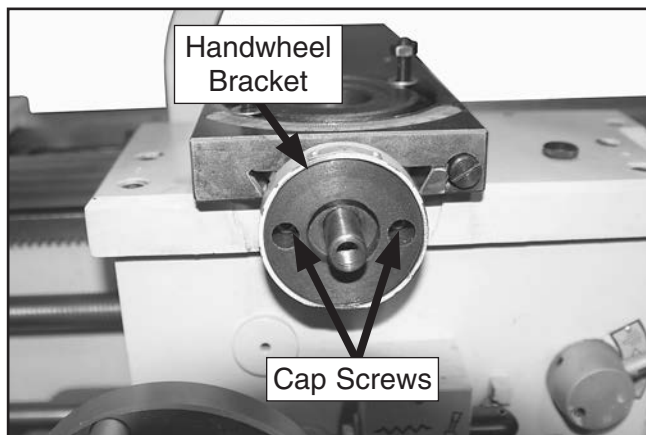


Figure 8. Handwheel bracket cap screw locations.

9. Pull the handwheel bracket and leadscrew assembly from the front of the cross slide (see **Figure 9**).

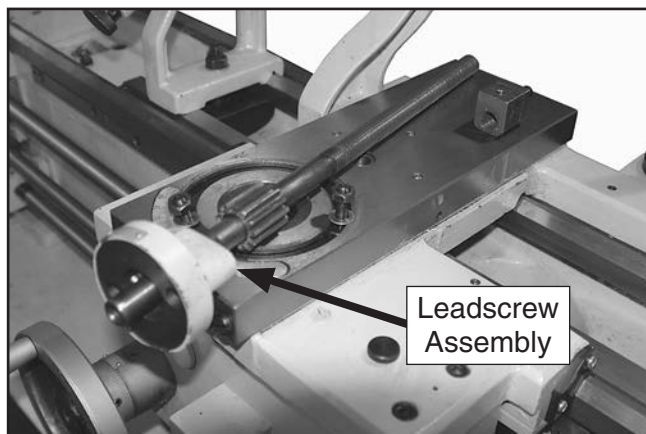


Figure 9. Cross slide leadscrew assembly removed.

10. Remove the work lamp and bracket assembly from the rear of the saddle, and set it aside for now. It is not necessary to disconnect the wires at this time.

Note: For the Model G0709, the bracket assembly also includes the coolant nozzle.

11. Remove the cross slide from the saddle by sliding it off the dovetail way (see **Figure 10**).



Figure 10. Cross slide removed from saddle.

12. Remove the top cover from the taper attachment body (see **Figure 11**), then remove the block assembly.

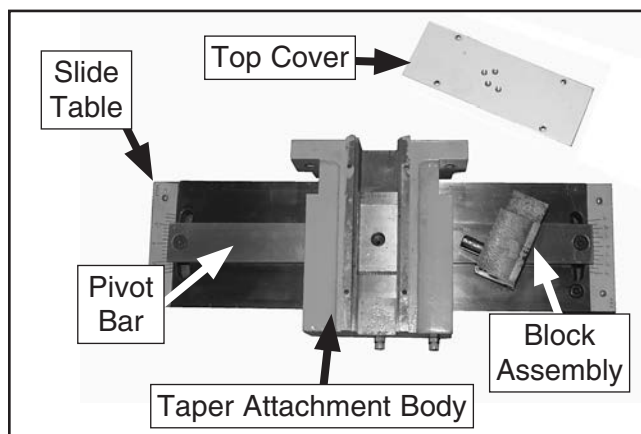


Figure 11. Top cover and block assembly removed from taper attachment body.

Note: To accomplish this step, you may have to loosen the block assembly with a dead-blow hammer.

13. Slide the taper attachment body off the pivot bar.



14. Loosely re-install the top cover on the attachment.
15. Have another person align and hold the body against the rear of the saddle, then use a punch to mark the saddle through the attachment holes.

Note: The taper attachment body is properly aligned when the sides of the internal ways are evenly aligned with those of the saddle and the top cover is flush with or slightly lower than the saddle dovetail ways (see **Figure 12**).

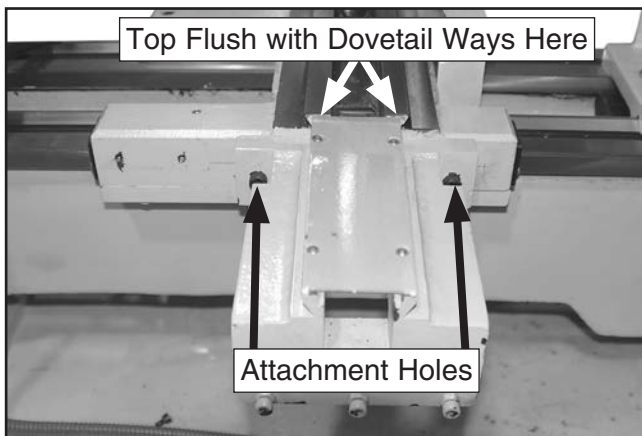


Figure 12. Taper attachment body properly aligned with saddle.

16. Drill and tap holes at the two marks you made in **Step 15**. The tapped holes should accept M8-1.25 x 25 cap screws.
17. Mount the attachment body to the saddle, as shown in **Figure 12**.
18. Remove the top cover from the taper attachment.

19. Loosen the (2) cap screws on the block assembly you removed from the body in **Step 12**, then separate the pivot and alignment blocks, as shown in **Figure 13**.

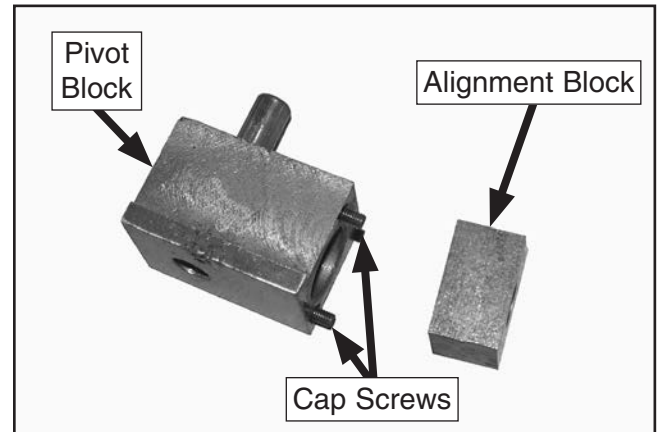


Figure 13. Pivot and alignment blocks separated.

20. If the alternate leadscrew rear bracket is installed on the taper attachment leadscrew (see **Figure 14**), then remove it now.

Important: Make a note of the order of the components in front of and behind the bracket, and keep this information for future use. If you remove the taper attachment later, the taper attachment leadscrew and handwheel can remain installed by re-installing the bracket and the components in the same order. The bracket is mounted to the saddle in the same manner as the taper attachment body.

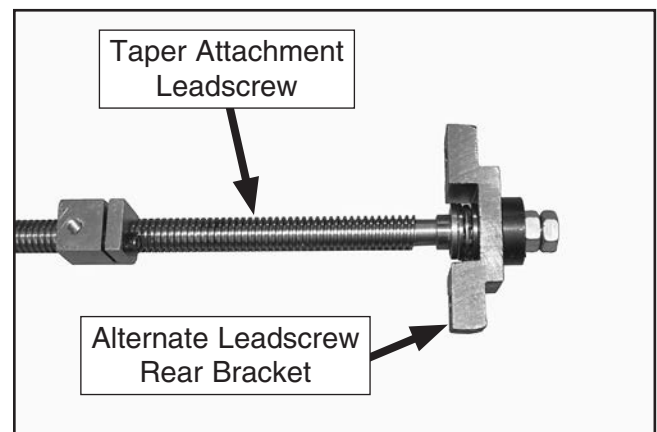


Figure 14. Alternate leadscrew rear bracket on taper attachment leadscrew.



21. Keeping the component order on the end of the taper attachment leadscrew the same as it was shipped (minus the alternate bracket), install the alignment block you removed in **Step 20** between the bearing cap and hex nuts, as shown in **Figure 15**.

Note: Hand-tighten the first hex nut, then tighten the second hex nut against the first to secure the installation.

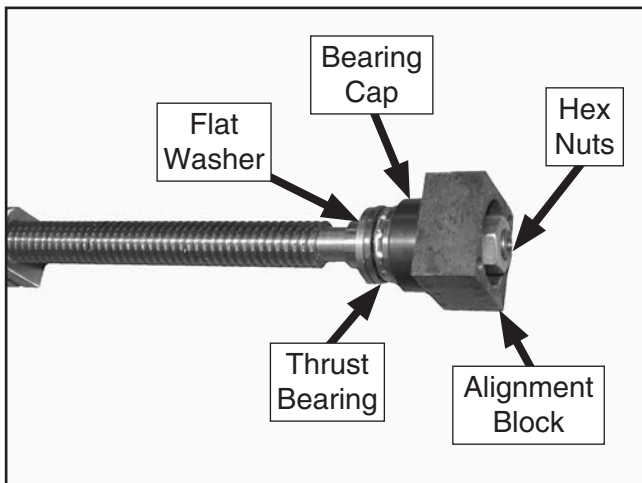


Figure 15. Alignment block installed on taper attachment leadscrew.

22. Remove the handwheel and graduated dial from the taper attachment leadscrew assembly in the same manner as instructed in **Steps 7–8**.
23. Rotate the alignment block at the end of the leadscrew (see **Figure 15**) so the orientation of the threaded holes will match the orientation of the cap screws in the pivot block when it is installed inside the taper attachment body (see to **Step 31** and **Figure 20** on **Page 7** for orientation reference).

24. Slide the leadscrew assembly into the saddle with the threaded hole in the leadscrew nut facing up, as shown in **Figure 16**.

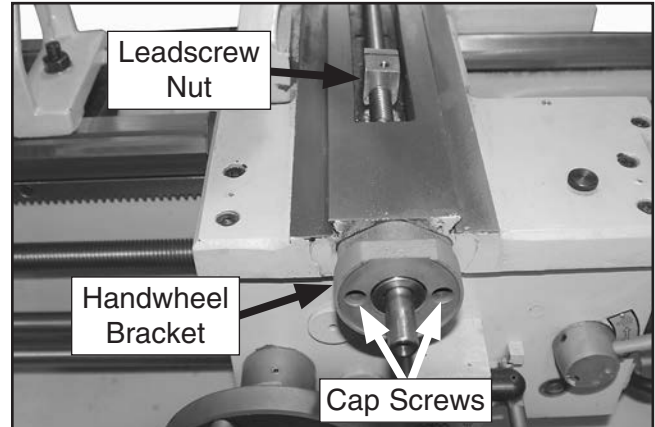


Figure 16. Taper attachment leadscrew assembly installed.

25. Secure the handwheel bracket in place with (2) M8-1.25 x 16 cap screws.
26. Re-install the handwheel and graduated dial assembly, then attach the handle.

Note: Be sure to install the handwheel and graduated dial assembly that came with the taper attachment. As shown in **Figure 17**, there is a critical difference in thickness between the two.

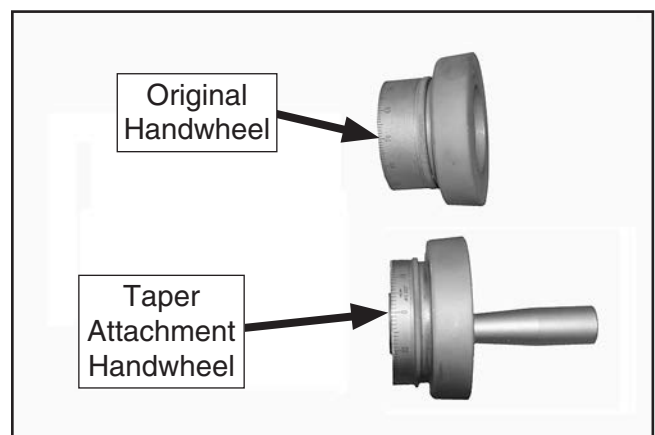


Figure 17. Handwheel comparison.



27. Slide the cross slide back onto the saddle dovetail.
28. Use the cross slide handwheel to position the leadscrew nut so the hole in the cross slide aligns with the threaded hole in the top of the leadscrew nut.

29. Secure the cross slide to the leadscrew nut with the cap screw removed in **Step 5**.

Note: Only tighten the cap screw until it is snug. Overtightening it could interfere with cross slide movement.

30. Orient the angle scale of the slide table toward the tailstock, then slide the pivot bar dovetail through the slide block underneath the taper attachment body, as shown in **Figure 18**.

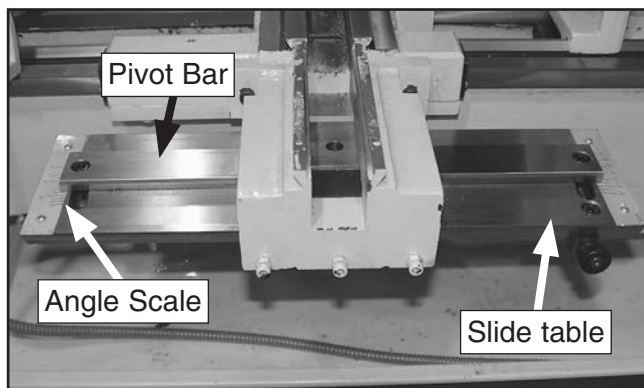


Figure 18. Slide table re-installed.

31. Re-install the pivot block into the taper attachment body so that you can access the cap screws from the outside (see **Figure 19**).

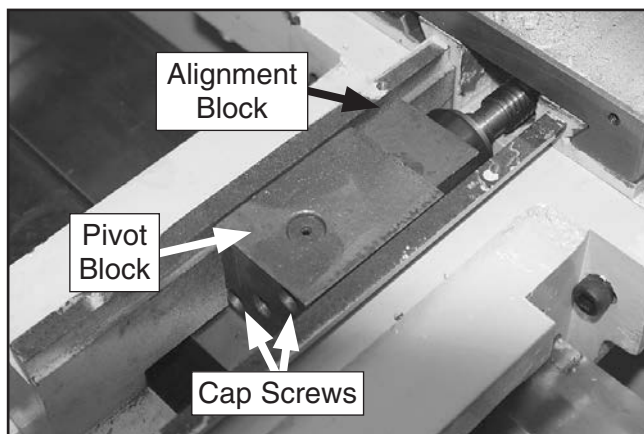


Figure 19. Pivot and alignment blocks re-installed.

32. Use the cross slide handwheel to extend the end of the leadscrew into the taper attachment body so the alignment block is against the pivot block, as shown in **Figure 19**.

33. Thread the cap screws through the pivot block into the alignment block to secure it.

34. Re-install the taper attachment top cover.

35. Attach the bed clamp bracket and bed clamp block to the bedway between the tailstock and taper attachment, using (2) M10-1.5 x 30 cap screws and (2) M6-1 x 35 cap screws, as shown in **Figures 20–21**. Leave the bracket loose enough on the bedway so that you adjust its position.

Note: Use the bottom cap screws to bring the bracket level with the bedway, then use the top cap screws to secure the bracket in place.

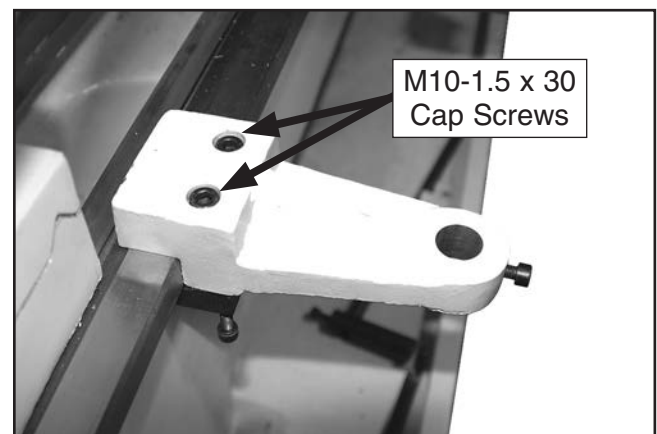


Figure 20. Bed clamp bracket and block attached to bedway (top view).

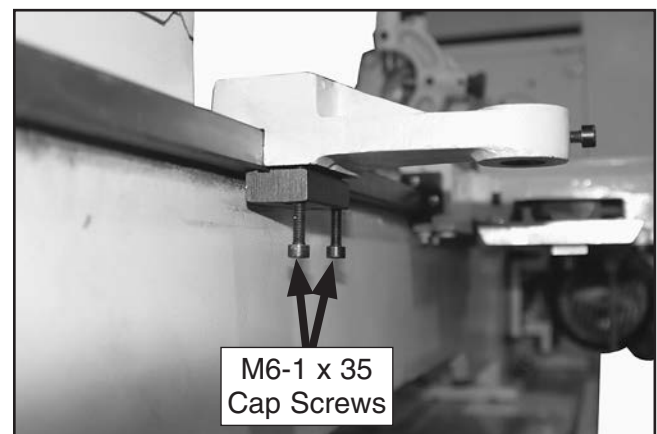


Figure 21. Bed clamp bracket and block attached to bedway (bottom view).



36. Attach the flattened end of the bed clamp rod to the underside of the slide table, as shown in **Figure 22**, with (1) M6-1 x 20 cap screw.

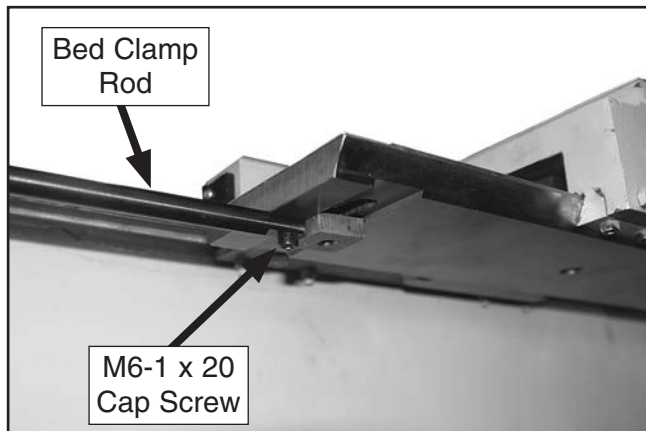


Figure 22. Bed clamp rod attached to slide table.

37. Insert the round end of the bed clamp rod into the bed clamp pivot shaft, then insert the pivot shaft into the bottom of the bed clamp bracket, as shown in **Figure 23**.

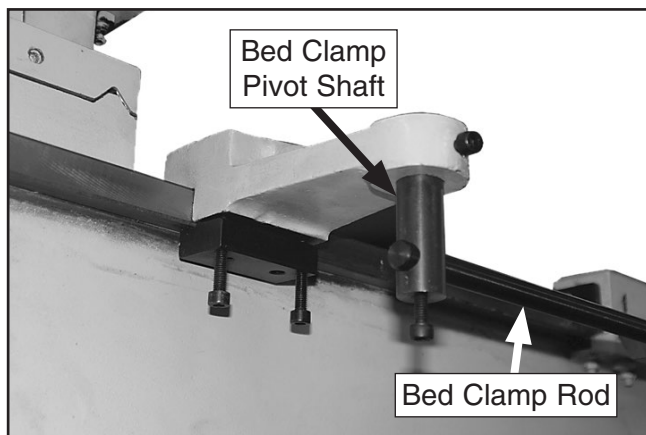


Figure 23. Bed clamp pivot pin installed.

38. Tighten the bed clamp bracket cap screws to secure it in position on the bedway.
39. Move the carriage toward the spindle as far as possible.

Note: Adjust components as necessary to expose as much of the pivot bar as possible on the tailstock side of the taper attachment body.

40. Mount a dial indicator magnetic base on top of the saddle so that the indicator needle is resting on the pivot bar at the tailstock end, as shown in **Figure 24**, then zero the indicator.

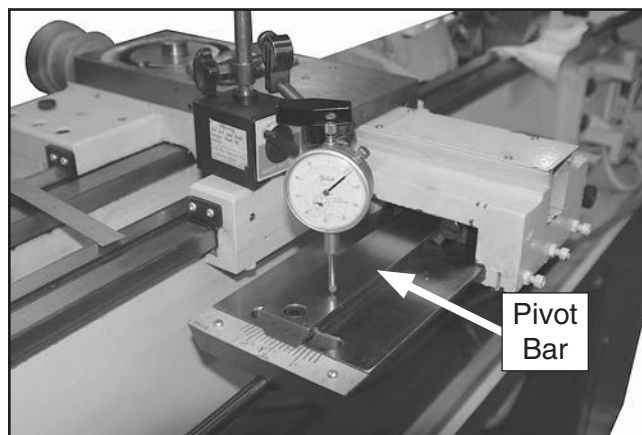


Figure 24. Using a dial indicator to measure slide table tilt.

41. Move the carriage toward the tailstock as far as possible.

—If the indicator reading is 0.010" or less, the tilt of the slide table is considered acceptable. Proceed to **Step 36**.

—If the indicator reading is greater than 0.010", proceed with the next step.

42. Loosen the cap screws that secure the taper attachment body to the saddle, then rotate the taper attachment assembly left or right to correct the tilt. Retighten the cap screws and repeat **Step 41**.



43. Separate the lamp base from the lamp bracket, as shown in **Figure 25**.

Disconnect the wires at the lamp terminal bar, on the side coming from the electrical box.

Note: For the Model G0709, the coolant nozzle position does not need changing.

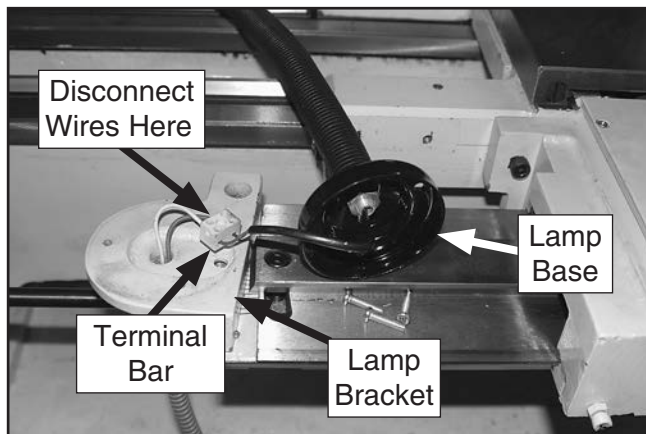


Figure 25. Lamp base and bracket separated.

44. Unthread the cable strain relief from the lamp bracket, then feed the wires through the work lamp extension shaft.
45. With the wires inserted through the bracket hole and accessible from the top of the bracket, thread the extension shaft into the second bracket hole, then reconnect the strain relief (see **Figure 26**).

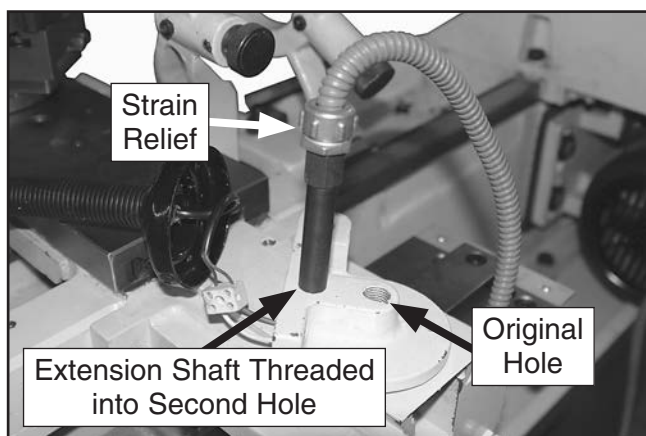


Figure 26. Extension shaft threaded into second hole of lamp bracket.

46. Reconnect the wires to the lamp terminal bar, re-attach the lamp base to the lamp bracket, then re-attach the bracket to the saddle using the (2) M6-1 x 10 cap screws removed in **Step 10**, as shown in **Figure 27**.

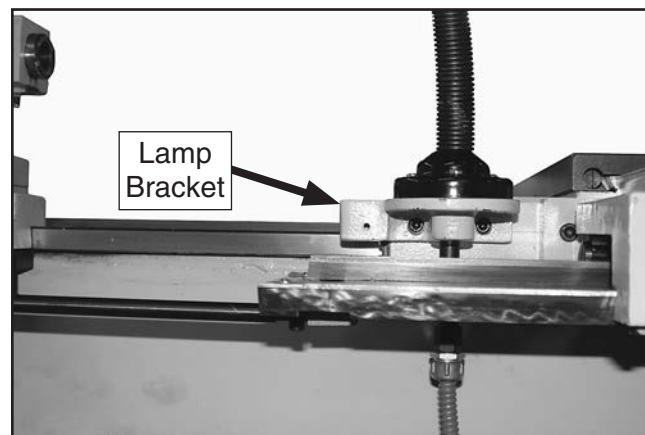


Figure 27. Lamp assembly reattached to saddle.

47. Re-install the compound rest and back splash on the lathe to complete the taper attachment assembly procedure.



Determining Amount of Taper

The amount of taper is expressed either in increments per length, such as 1" per foot, or degrees of angle.

In **Figure 28**, the increments of taper per length of the taper is calculated by subtracting the small workpiece diameter (**A**) from the large diameter (**B**) per the taper length (**C**).

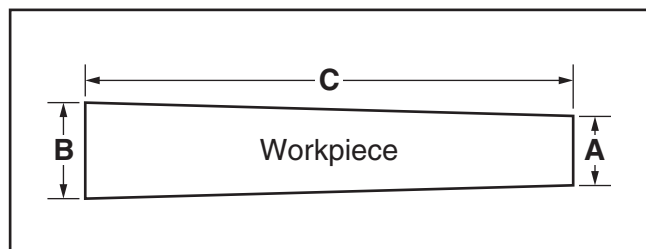


Figure 28. Measuring increments per length of taper.

For example, if

$$A = 2"$$

$$B = 3\frac{1}{2}"$$

$$C = 12"$$

then the amount of taper would be calculated with the formula $B - A$ per C , as follows:

$$3\frac{1}{2}" - 2" \text{ per } 12", \text{ or } 1\frac{1}{2}" \text{ per } 12"$$

In this case, you would set the inches-per-foot scale at $\pm 1\frac{1}{2}$.

In **Figure 29**, the angular amount of taper is determined by the angular measurement between the sides of the finished taper.

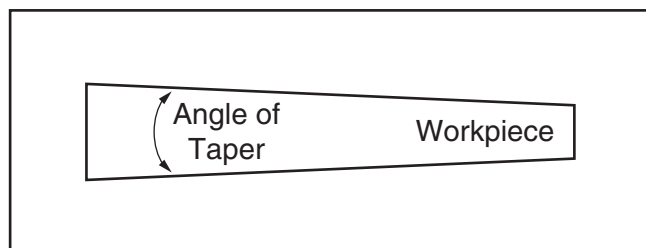


Figure 29. Taper determined by angular measurement.

In this case, the angular scale on the tailstock end of the slide table would be set at the desired angle of the taper.

Direction of Taper

The direction of taper is controlled by which way you rotate the pivot bar.

For instance, if the headstock end of the pivot bar is rotated toward the bedway, as shown in **Figure 30**, the small end of the taper will be at the tailstock end.

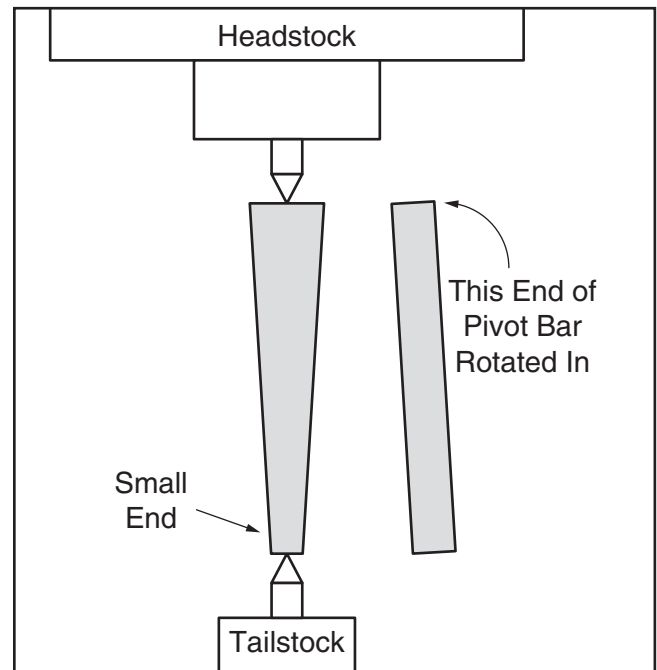


Figure 30. Direction of taper in relation to pivot bar rotation.

Operation

1. DISCONNECT LATHE FROM POWER!
2. Mount the workpiece between centers.
3. Loosen the bed clamp bracket cap screws (see **Figure 31**), position the tooling at approximately the center of the workpiece, then retighten the cap screws.

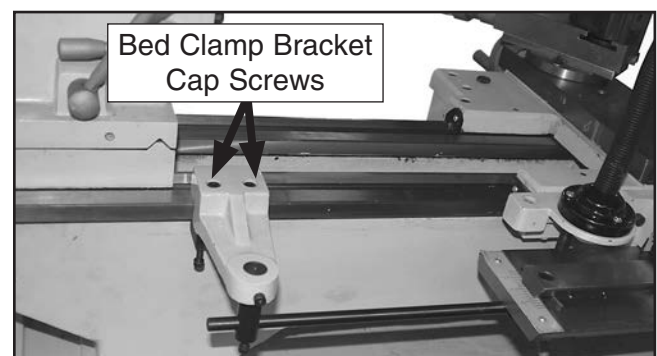


Figure 31. Location of bracket cap screws.



4. Make sure each end of the bed clamp rod is firmly secured.
5. Loosen the cap screw at each end of the pivot bar (see **Figure 32**).

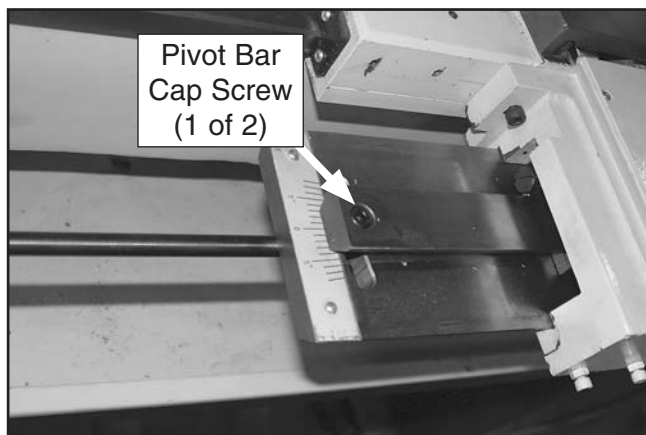


Figure 32. Pivot bar cap screw (1 of 2).

6. Determine the amount of taper (refer to the previous page for more information).
7. Use the slide table scales and the taper adjustment knob (see **Figure 33**) to adjust the pivot bar for the desired taper.

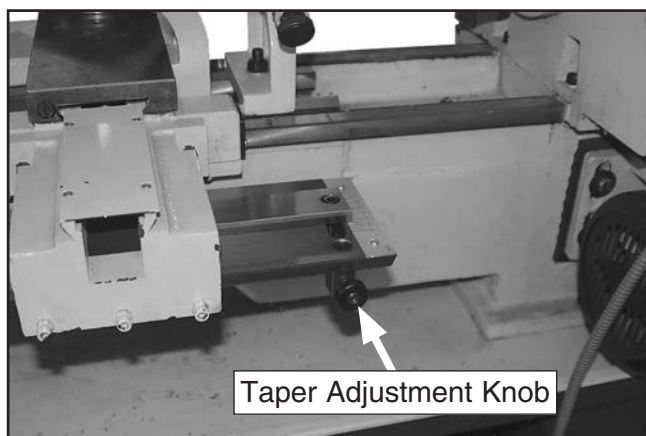


Figure 33. Location of taper adjustment knob.

8. Retighten the cap screw on each end of the pivot bar to secure the setting.
9. Move the carriage by hand to make sure there is the proper amount of travel to turn the taper. Make adjustments to the taper attachment as necessary.

NOTICE

There is always a certain amount of back-lash in the taper attachment. To prevent inconsistent turning results, always start each pass with the tool approximately $\frac{1}{2}$ " behind the starting point on the workpiece.

To disengage the taper attachment:

1. Loosen the bed clamp bracket cap screws (see **Figure 34**) so the bed clamp bracket can freely travel along the bedway.

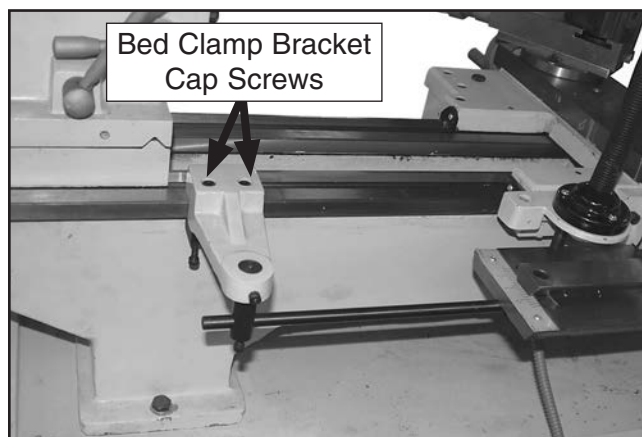
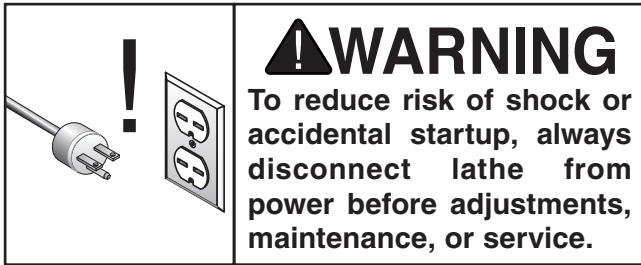


Figure 34. Location of bed clamp bracket cap screws.

2. Loosen the cap screws at each end of the pivot bar, rotate the taper adjustment knob (see **Figure 33**) to center the bar on the scales, then retighten the cap screws.



Maintenance



For optimum performance from the taper attachment, follow the maintenance schedule below and follow specific instructions given in this section.

Daily

- Check/correct loose mounting fasteners.
- Clean debris and grime from all attachment surfaces.
- Clean/lubricate unpainted surfaces of slide table and dovetail ways.
- Correct any other unsafe condition.

Monthly

- Disassemble, clean, and lubricate pivot block, alignment block, and internal ways inside the attachment body.

Cleaning & Protecting

Typically, the easiest way to clean debris and grime from the attachment is to use a wet/dry shop vacuum that is dedicated for this purpose. The small chips left over after vacuuming can be wiped up with a slightly oiled rag. Avoid using compressed air to blow off chips, as it may drive them deeper into moving surfaces and could cause sharp chips to fly into your face or hands.

To keep the unpainted surfaces of the slide table and dovetail ways rust free and in top condition, apply a thin coat of quality way oil after cleaning them.

Lubricating Slide Table & Dovetail Ways

After cleaning the surfaces of the slide table and pivot bar (see **Figure 35**), apply a thin coat of a quality way oil to these surfaces (see **Page 16** for an offering from Grizzly). Slide the attachment body back and forth along the slide table to distribute the oil along the dovetail ways.

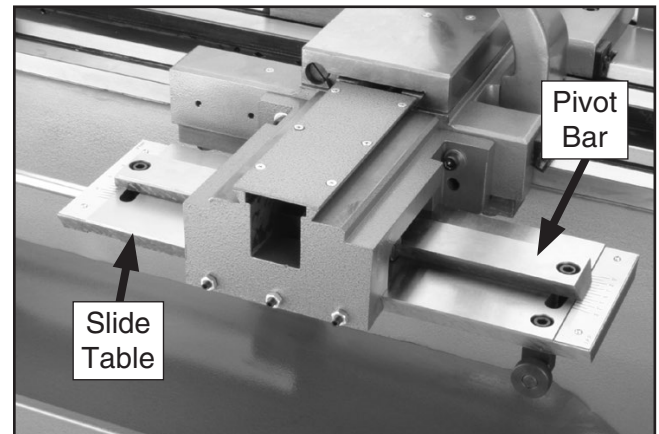


Figure 35. Slide table and pivot bar.

Lubricating Pivot Block, Alignment Block, & Internal Ways

1. Remove the top cover from the attachment body, disconnect the pivot block from the alignment block, then remove the pivot block (see **Figure 36**).

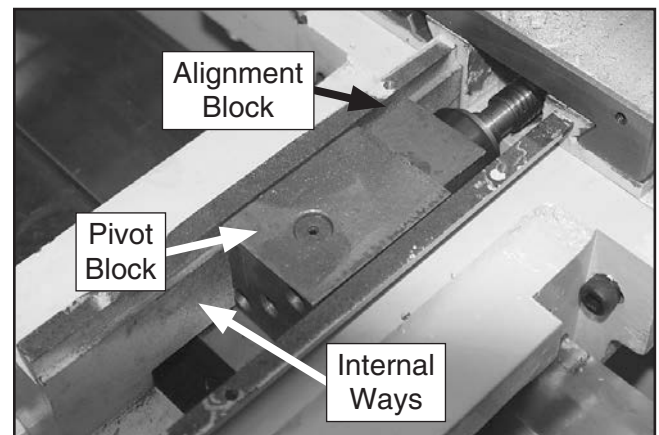


Figure 36. Internal lubrication points of taper attachment body.

2. Clean the pivot block, alignment block, and internal ways of the attachment body with mineral spirits and shop rags.
3. When dry, apply a thin coat of NLGI#2 grease to all surfaces of the blocks and internal ways, then re-assemble the parts.



Calibrating Scales

There is a small amount of side-to-side adjustment in the slide table angular and inch-per-foot scales that allow for precise calibration with the pivot bar (see **Figure 37**).

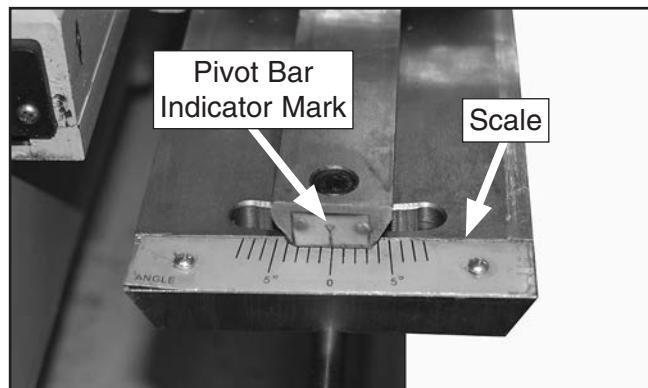


Figure 37. Pivot bar indicator mark and slide table scale.

Tool Needed	Qty
Phillips Screwdriver #2	1

To calibrate the slide table scales:

1. Adjust the pivot bar so that the indicator marks aligns with the “0” marks on the scales.
2. Turn a length of round stock and measure the amount of taper, if any, from one end to the other.

—If there is no taper on the round stock and the pivot bar indicator marks align with the “0” mark on each scale, no further adjustment is required.

—If there is no taper on the round stock but the pivot bar indicator marks do not align with “0” mark on each scale, continue with the next step.

—If there is a taper on the round stock, adjust the pivot bar to remove the taper, then repeat this step.

3. Loosen the Phillips head screws that secure the scales, and shift them until the “0” marks align with the pivot bar indicator mark, then retighten the screws.
4. To recheck the settings, repeat **Step 2**.

Gib Adjustment

The goal of adjusting the gib screws is to remove sloppiness or “play” from the ways without over-adjusting them to the point where they become stiff and difficult to move.

In general, loose gibs cause poor finishes and inaccurate tapers; however, over-tightened gibs cause premature wear and make it difficult to move the carriage and cross slide.

Tool Needed	Qty
Standard Screwdriver #2	1

Internal Gib

The internal gib is tapered and held in position by a screw at each end (see **Figure 38**). To adjust this gib, turn one screw $\frac{1}{4}$ turn clockwise and the other screw $\frac{1}{4}$ turn counterclockwise, so both screws move in the same direction and the same amount. Test the feel of the setting by moving the carriage, and adjust the gib screws as necessary to make it tighter or looser.

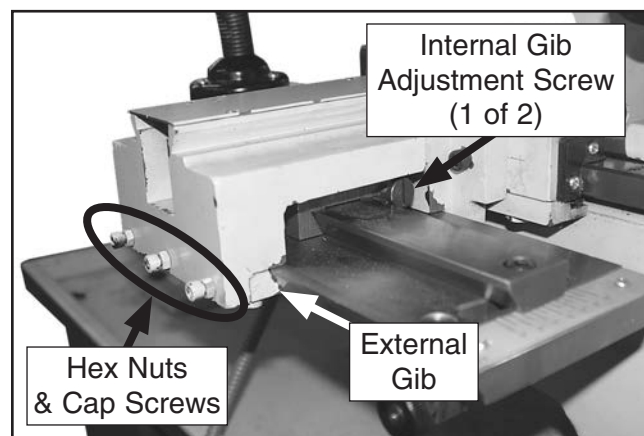


Figure 38. Locations of gib components.

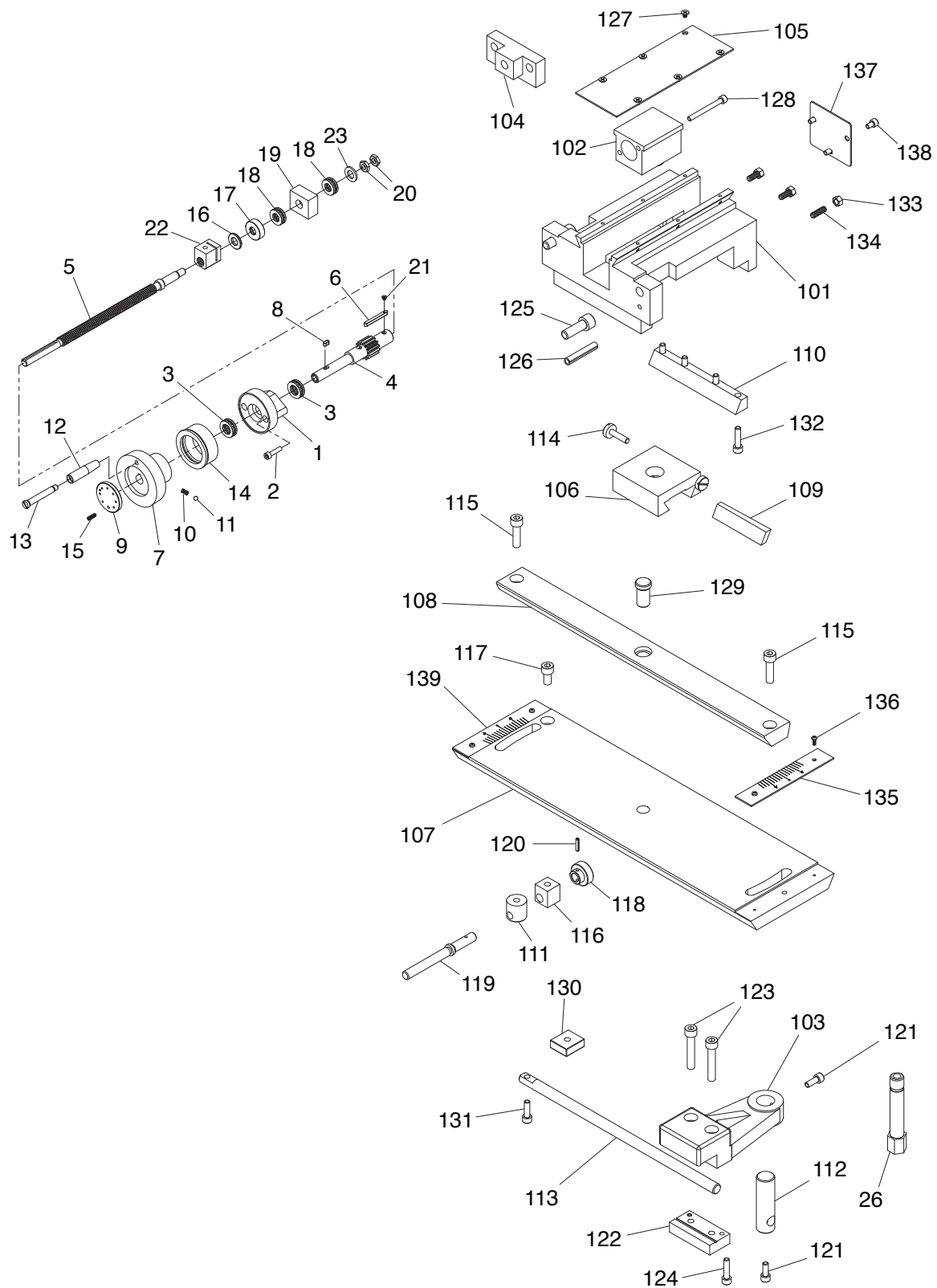
Tools Needed	Qty
Wrench 10mm	1
Hex Wrench 5mm.....	1

External Gib

The external gib is wedge-shaped and is held in position by three cap screws (see **Figure 38**). To adjust this gib, loosen the hex nuts and turn the cap screws in equal amounts. Test the feel of the setting by moving the carriage, and adjust the cap screws as necessary to make it tighter or looser. When satisfied with the movement, retighten the hex nuts to secure the setting.



Parts Diagram



Parts List

REF	PART #	DESCRIPTION
1	PT10556001	HANDWHEEL BRACKET (T10556 & T26300)
1	PT10502001	HANDWHEEL BRACKET (T10502)
2	PCAP06M	CAP SCREW M6-1 X 25
3	P51102	THRUST BEARING 51102
4	PT10556004	GEAR SHAFT 14T (T10556)
4	PT10502004	GEAR SHAFT 14T (T10502)
4	PT26300004	GEAR SHAFT 14T (T26300)
5	PT10556005	CROSS SLIDE LEADSCREW (T10556 & T26300)
5	PT10502005	CROSS SLIDE LEADSCREW (T10502)
6	PT10556006	ALIGNMENT KEY W/ONE HOLE
7	PT10556007	HANDWHEEL (T10556 & T26300)
7	PT10502007	HANDWHEEL (T10502)
8	PK06M	KEY 5 X 5 X 10
9	PT10556009	HANDWHEEL RETAINER
10	PT10556010	COMPRESSION SPRING 0.7 X 5 X 10
11	PSTB003M	STEEL BALL 6MM
12	PT10556012	HANDWHEEL HANDLE
13	PT10556013	SHOULDER SCREW M8-1.25 X 16 75L
14	PT10556014	GRADUATED DIAL (T10556 & T26300)
14	PT10502014	GRADUATED DIAL (T10502)
15	PSS117M	SET SCREW M5-.8 X 16 CONE-PT
16	PT10556016	THRUST WASHER
17	PT10556017	SPACER
18	P51101	THRUST BEARING 51101
19	PT10556019	ALIGNMENT BLOCK
20	PN50M	HEX NUT M10-1.5 THIN
21	PFH49M	FLAT HD SCR M3-.5 X 6
22	PT10556022	CROSS SLIDE LEADSCREW NUT
23	PW06M	FLAT WASHER 12MM
26	PT10556026	WORK LAMP EXTENSION SHAFT
101	PT10556101	BODY
102	PT10556102	PIVOT BLOCK
103	PT10556103	BED CLAMP BRACKET (T10556 & T26300)
103	PT10502103	BED CLAMP BRACKET (T10502)
104	PT10556104	ALTERNATE LEADSCREW REAR BRACKET

REF	PART #	DESCRIPTION
105	PT10556105	TOP COVER
106	PT10556106	SLIDE BLOCK
107	PT10556107	SLIDE TABLE
108	PT10556108	PIVOT BLOCK
109	PT10556109	GIB
110	PT10556110	CLAMP BAR
111	PT10556111	PIVOT SHAFT
112	PT10556112	BED CLAMP PIVOT SHAFT
113	PT10556113	BED CLAMP ROD
114	PT10556114	GIB ADJUSTMENT SCREW
115	PCAP13M	CAP SCREW M8-1.25 X 30
116	PT10556116	SHAFT MOUNTING BLOCK
117	PCAP11M	CAP SCREW M8-1.25 X 16
118	PT10556118	KNURLED KNOB
119	PT10556119	TAPER ADJUSTMENT SHAFT
120	PRP02M	ROLL PIN 3 X 16
121	PCAP01M	CAP SCREW M6-1 X 16
122	PT10556122	BED CLAMP BLOCK
123	PCAP45M	CAP SCREW M8-1.25 X 45
124	PCAP48M	CAP SCREW M6-1 X 35
125	PCAP72M	CAP SCREW M10-1.5 X 30
126	PRP05M	ROLL PIN 5 X 30
127	PFH27M	FLAT HD SCR M4-.7 X 6
128	PCAP109M	CAP SCREW M5-.8 X 50
129	PT10556129	PIVOT BLOCK PIN
130	PT10556130	BED CLAMP ROD STOP BLOCK
131	PCAP02M	CAP SCREW M6-1 X 20
132	PCAP06M	CAP SCREW M6-1 X 25
133	PN01M	HEX NUT M6-1
134	PSS134M	SET SCREW M6-1 X 20 CUP-PT
135	PT10556135	TPF SCALE PLATE
136	PS79M	PHLP HD SCR M3-.5 X 8
137	PT10556137	REAR COVER
138	PCAP03M	CAP SCREW M5-.8 X 8
139	PT10556139	ANGLE SCALE PLATE



Accessories

NOTICE

Refer to our website or latest catalog for additional recommended accessories.

T23962—ISO 68 Moly-D Way Oil, 5 gal.

T23963—ISO 32 Moly-D Machine Oil, 5 gal.

Moly-D oils are some of the best we've found for maintaining the critical components of machinery because they tend to resist run-off and maintain their lubricity under a variety of conditions—as well as reduce chatter or slip. Buy in bulk and save with 5-gallon quantities.



Figure 39. ISO 68 and ISO 32 machine oil.

T23964—Armor Plate with Moly-D Multi-Purpose Grease, 14.5 oz. (NLGI#2 Equivalent)

Armor Plate with Moly-D is a rich green moly grease that provides excellent stability and unsurpassed performance under a wide range of temperatures and operating conditions. Armor Plate grease is entirely unique due to the fact that the moly in it is solubilized which provides superior performance to other greases containing the black solid form of molybdenum disulfide.



Figure 40. T23964 Armor Plate with Moly-D Multi-Purpose Grease

T24802—iGaging® Digital Indicator & Magnetic Base Set

Includes iGaging® 3-reading digital indicator, which has a range of 0–6"/150mm, and can read and convert in inch, metric, and fractions. Fine adjustment magnetic base has 85 lbs. of pull power. Magnetic indicator back for position indicator on metal surfaces. Protective case included.



Figure 41. Model T24802 iGaging® Digital Indicator & Magnetic Base Set.

G9766—29 Piece HSS Metric Drill & Tap Set

We offer a set of taps with all the drill bits necessary to produce perfectly tapped holes. Each size has three tapes which include a starting taper tap, a secondary intermediate tap, and a finishing bottom tap. These are great taps for those hard-to-tap materials. Sizes: M3-0.5, M4-0.7, M5-0.8, M6-1.0, M8-1.25, M10-1.5, and M12-1.75. Includes tap handle and storage case.



Figure 42. Model G9766 Drill & Tap Set.

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