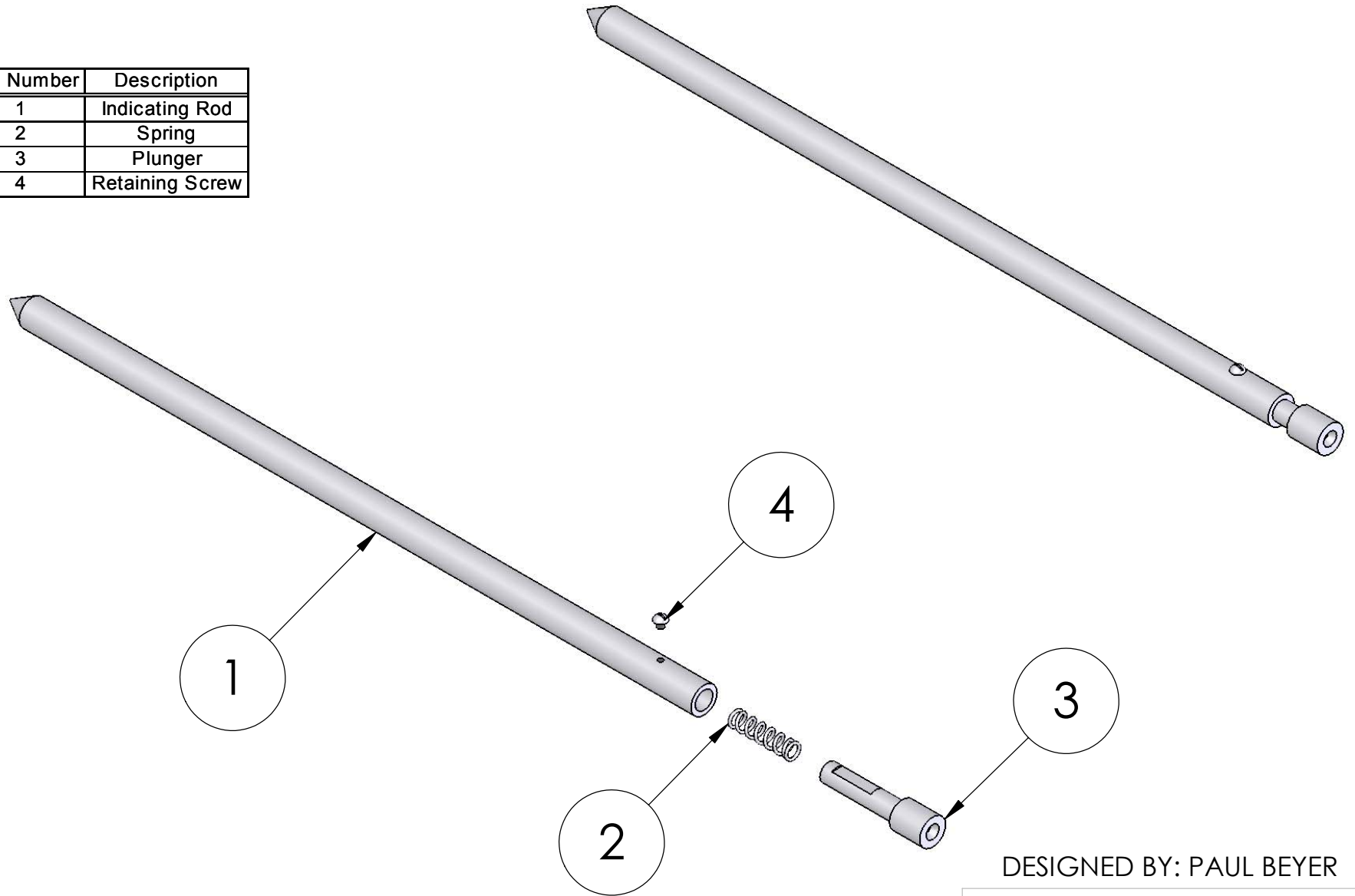


| Part Number | Description |
|-------------|-----------------|
| 1 | Indicating Rod |
| 2 | Spring |
| 3 | Plunger |
| 4 | Retaining Screw |



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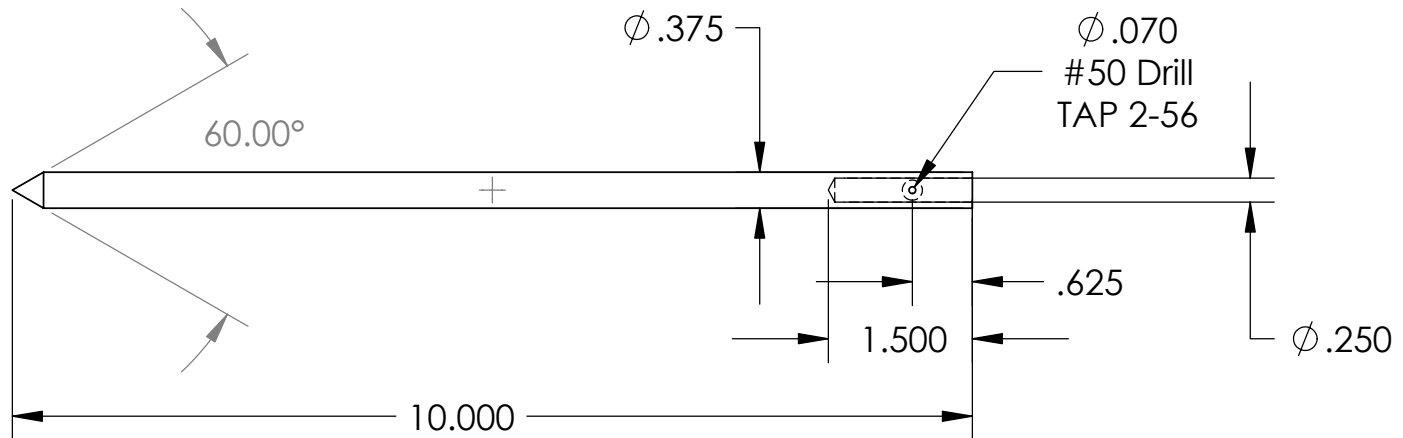
LATHE CENTERING TOOL

DRAWN BY: N.P. SKINNER

Thursday, June 01, 2006 REV 1

SCALE: 1:1.5 INCHES SHEET 1 OF 5

NOTES:
MATERIAL - DRILL ROD or CRS
POLISH TAPERED END TO CREATE A SUITABLE SURFACE FOR INDICATING



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INDICATING ROD

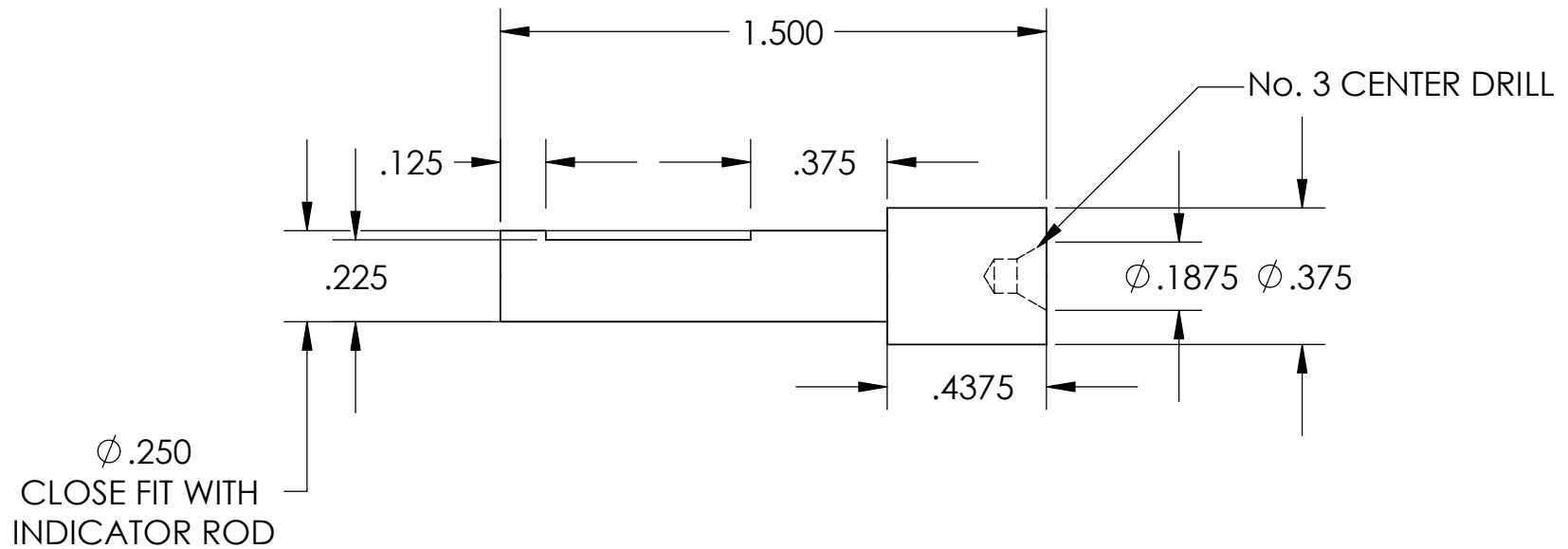
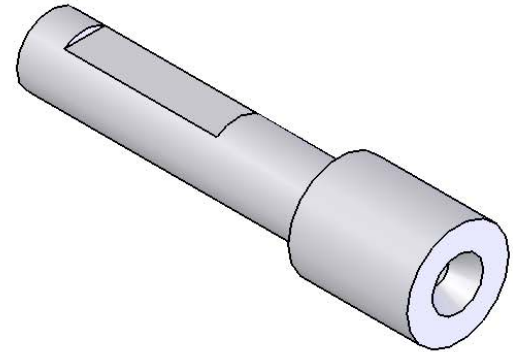
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SCALE: 1:2 INCHES SHEET 2 OF 5

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NOTES:
MATERIAL - DRILL ROD or CRS



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PLUNGER

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SCALE: 2:1 INCHES SHEET 3 OF 5

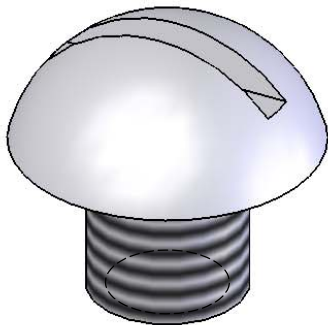
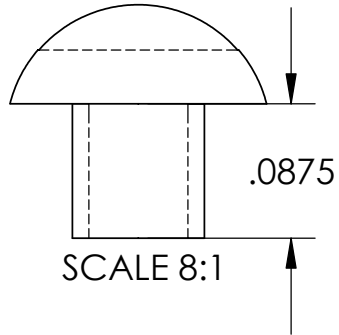
Upstate New York Home Shop Metalworkers
<http://www.gooseberryfarm.com/metalworking>

NOTES:

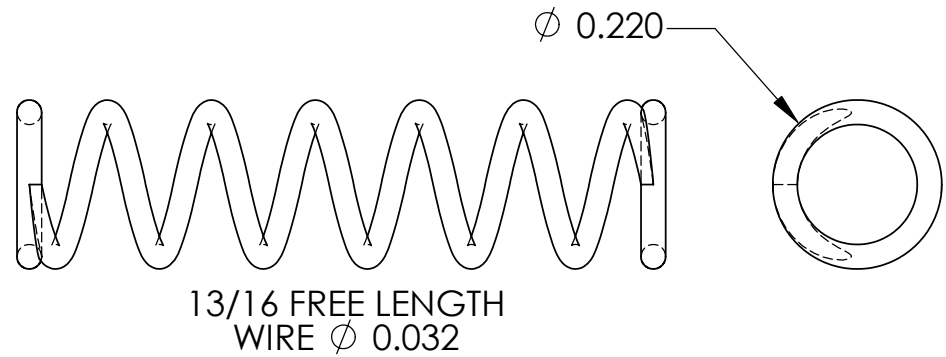
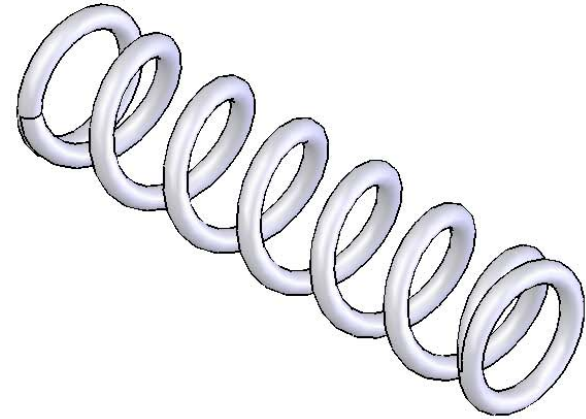
SCREW - 2-56

ADJUST LENGTH SO PLUNGER DOES NOT BIND

SPRING - MUST BE STRONG ENOUGH TO HOLD ASSEMBLY BETWEEN THE TAILSTOCK AND WORKPEICE FOR FULL PLUNGER TRAVEL



SCALE 10:1



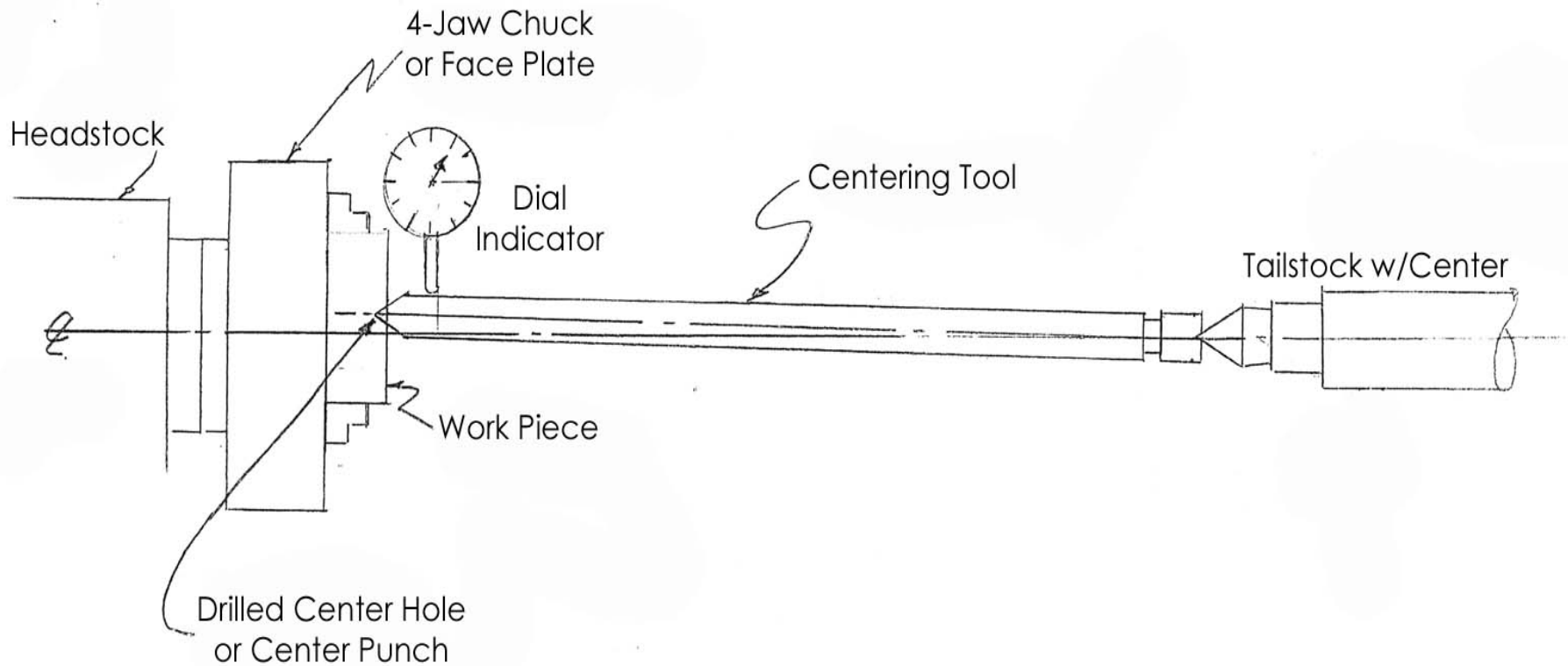
DESIGNED BY: PAUL BEYER

SPRING AND SCREW

DRAWN BY: N.P. SKINNER

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SCALE: 4:1 INCHES SHEET 4 OF 5



CENTERING PROCEDURE

1. Mount workpiece on a faceplate or in a 4-jaw chuck
2. Center workpiece by eye as closely as possible (within 1/16") without the centering tool in place. Recall face plates and 4-jaw chucks have concentric rings to help in centering.
3. Position the centering tool between the workpiece and tailstock. Adjust tailstock center so the plunger is approximately halfway depressed. Lock the tailstock and quill in place.
4. Adjust the workpiece to an acceptable amount of runout. During adjustment frequently check the plunger to make sure it has not bottomed out.

ILLUSTRATIONS AND INSTRUCTIONS
BY PAUL BEYER

USAGE PROCEDURE

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Thursday, June 01, 2006 REV 1

SHEET 5 OF 5

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