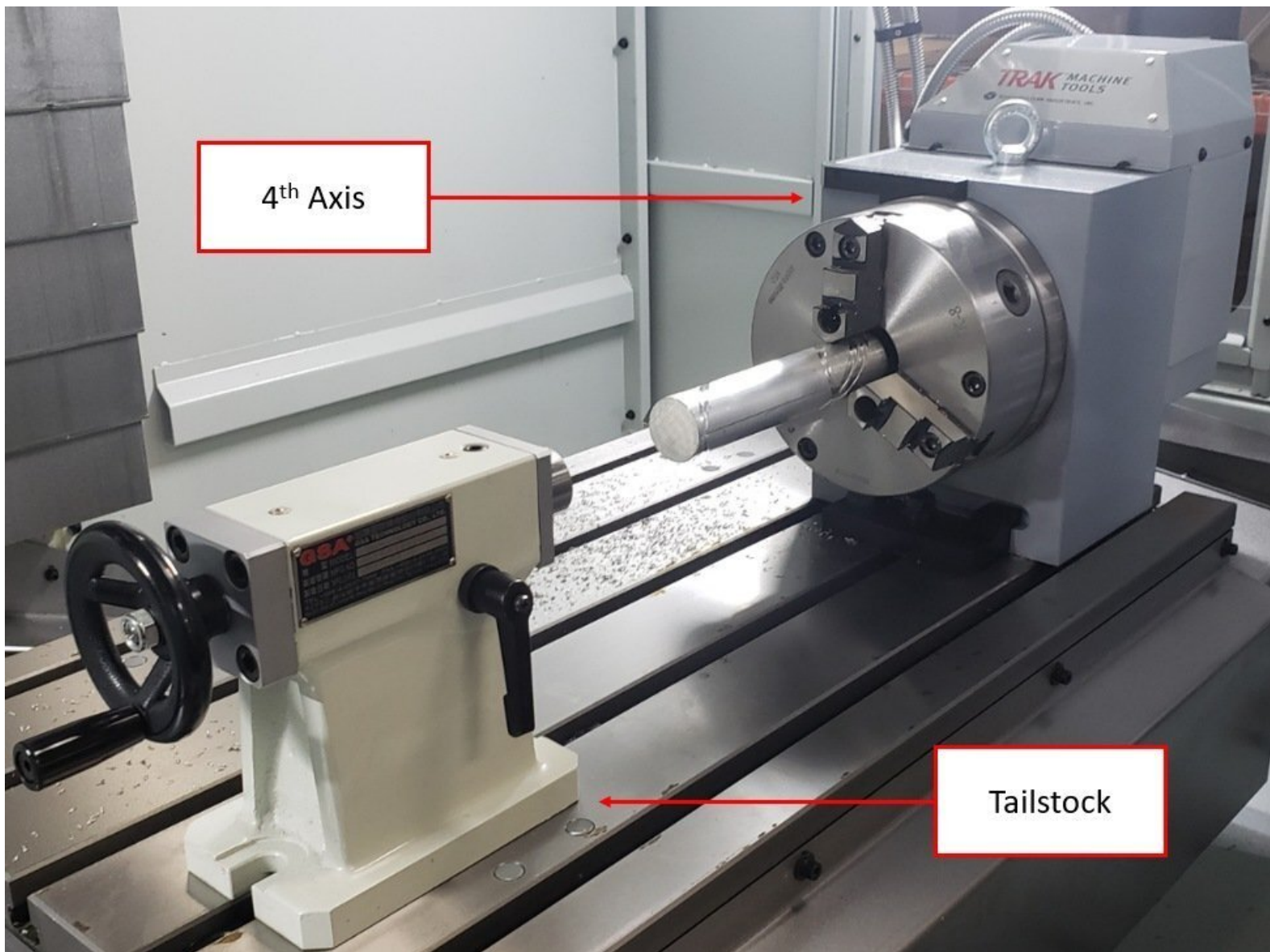




TMC 4th Axis - FST Tailstock Installation

This guide details how to install a tailstock in conjunction to the 4th Axis on the TMC machine.

Written By: Trent Plungas





PARTS:

- [31539](#) (1)

Tailstock Option - 4th Axis - TMC

- [23792](#) (2)

T Bolt - 5/8 - 11 X 2.5

- [23793](#) (2)

Flange Nut 5/8 - 11

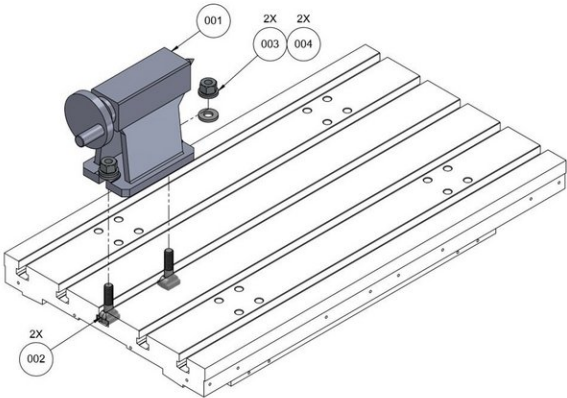
- [23794](#) (2)

Washer - 5/8 OD 1.375 X ID .656 X .17 - .20 THK

- [27061-1](#) (1)

Tailstock - 4th Axis - TS - A160

Step 1 — Part Number: 31539 Document - Tailstock Option - 4th Axis



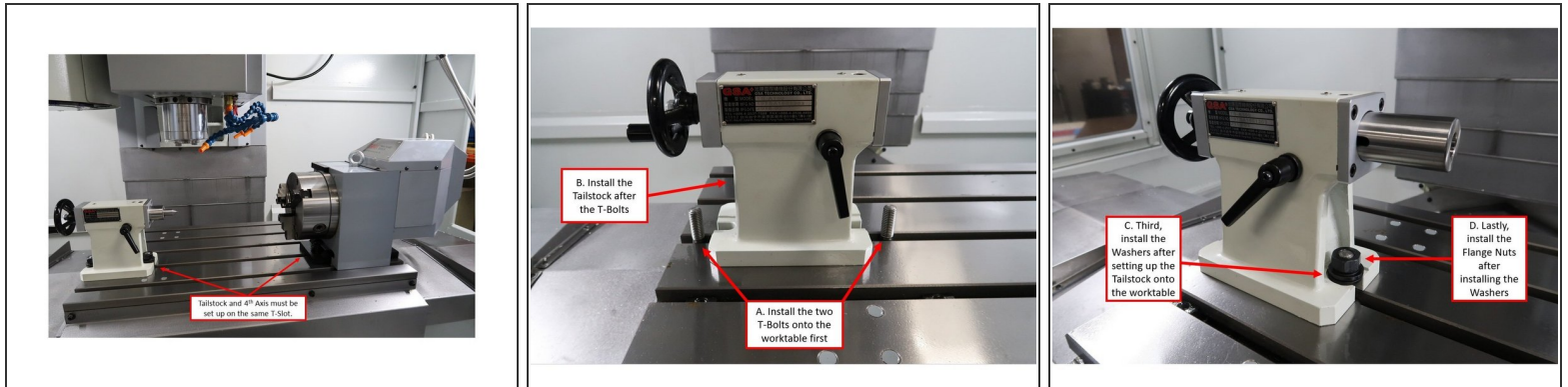
The diagram shows an exploded view of a tailstock assembly. Component 001 is a large cylindrical housing. Component 002 is a small pin or screw. Component 003 is a small washer or spacer. Component 004 is a small nut or cap screw. The assembly is shown mounted on a rail system.

PART NUMBER:		DRAWN BY: DH 12/17/2020	
31539		ENGINEER: DH 12/17/2020	

Item No.	Part Number	Description	Detail	Type	QTY.	Item Length	Category	MFG Part Number	Manufacturer
001	27051-1	TAILSTOCK 4TH AXIS TS-A160		Normal	1		Purchased		
002	23752	T BOLT 5/8-11 X 2.5		Normal	2		Purchased		
003	23753	FLANGE NUT 5/8-11		Normal	2		Purchased		
004	23754	WASHER 5/8 OD 1.375 X ID .656 X 17-20 THK		Normal	2		Purchased		
005	31539-D0C	TAILSTOCK OPTION 4TH AXIS-TMC		Normal	1				

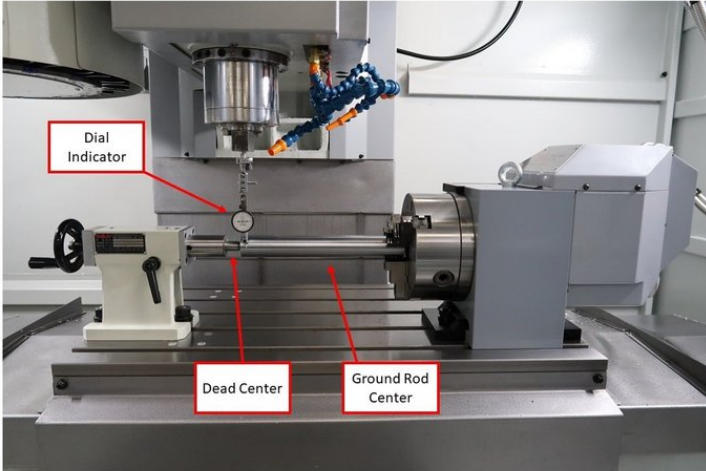
- Please refer to the Part Number: 31539, Tailstock Option-4th Axis-TMC document that is provided at the bottom of this guide for more information regarding installation of the tailstock.
- Customers are responsible for tramming both the 4th Axis unit and the tailstock based on their operations.

Step 2 — Set Up Tailstock Across 4th Axis Unit



- Clean and degrease the worktable by wiping it with a clean rag and WD-40.
- Upon proper installation of the 4th Axis unit on the TMC, the tailstock must be set up across the 4th Axis on the same T-slot on the worktable. Both the 4th Axis and the tailstock have a key to drop in and slide to any position, on any T-slot.
- Make sure that both the keys for the 4th Axis and the tailstock are aligned with a reasonable amount of distance away from each other to perform work based on the customer's operations.
- Set up tailstock by installing (A) the two T-Bolts (Part Number: 23792) onto the worktable first, then (B) the tailstock (Part Number: 27061-1), then (C) the two washers (Part Number: 23794), and finally, (D) the two flange nuts (Part Number: 23793) on the front and back of the tailstock. Do not overtighten the assembled nuts onto the worktable.

Step 3 — Use Dead Center, Ground Rod Center, & Dial Indicator for more Precise Measurements



- If the customer requires more precise measurements, it is highly recommended that they use a ground rod center that is inserted into the chuck, and is held by a dead center on the tailstock end in order to conduct measurements with a dial indicator. This would be based on the customer's needs.