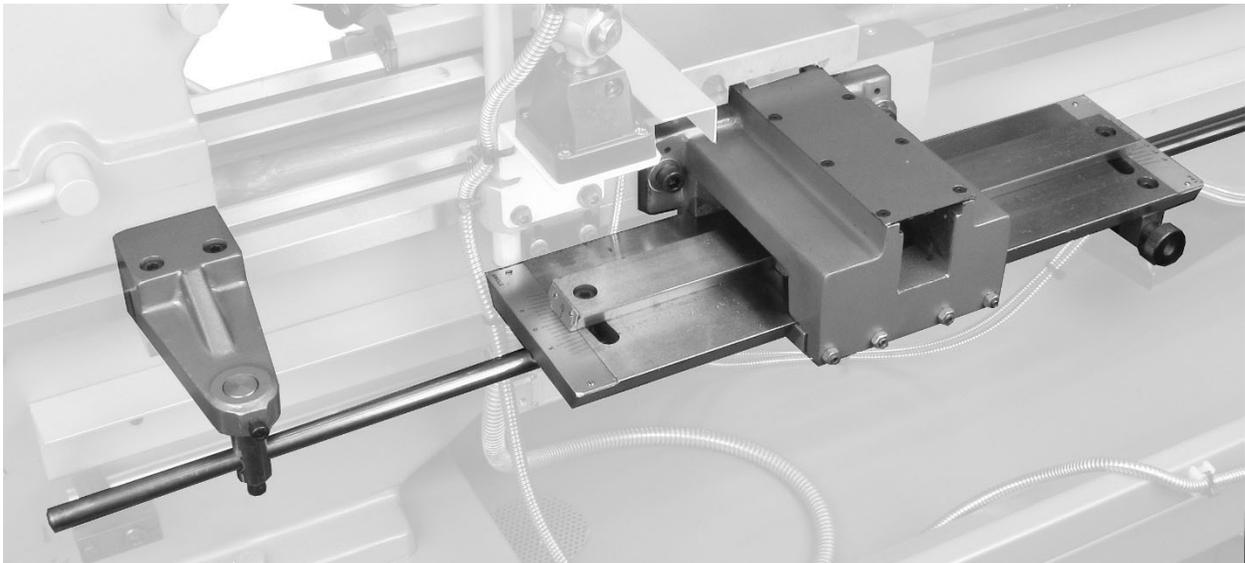




# Assembly Instructions and Parts Manual Taper Attachment for 13" and 14" Lathes

Fits JET lathe models E-1340VS, E-1440VS, EVS-1440B



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## 1.0 IMPORTANT SAFETY INSTRUCTIONS

### **WARNING – To reduce risk of injury:**

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace warning labels if they become obscured or removed.
4. JET metalworking lathes are designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a metalworking lathe, do not use until proper training and knowledge have been obtained.
5. Do not use this product for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear ANSI approved safety glasses or face shield while using the lathe. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating lathe, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Do not wear loose clothing. Confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Make certain switch is in OFF position before connecting the machine to the power supply.
10. Make certain the machine is properly grounded.
11. Make all machine adjustments or maintenance with the machine unplugged from the power source.
12. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
13. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after completion of maintenance.
14. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
15. Provide for adequate space surrounding work area and non-glare, overhead lighting.
16. Keep the floor around the machine clean and free of scrap material, oil and grease.
17. Keep visitors a safe distance from the work area. Keep children away.
18. Make your workshop child proof with padlocks, master switches or by removing starter keys.
19. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
20. Maintain a balanced stance at all times so that you do not fall into a rotating spindle or other moving parts. Do not overreach or use excessive force to perform any machine operation.
21. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
22. Use recommended accessories; improper accessories may be hazardous.
23. Maintain tools with care. Keep cutting tools sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
24. Turn off machine before cleaning. Use a brush to clear away chips or debris — do not use bare hands.
25. Do not stand on the machine. Serious injury could occur if the machine tips over.

26. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
27. Remove loose items and unnecessary work pieces from the area before starting the machine.
28. Do not use in dangerous environment. Do not use power tools in damp or wet location, or expose them to rain. Keep work area well lighted.

**⚠ WARNING:** This product can expose you to chemicals including lead and cadmium which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov>.

**⚠ WARNING:** Some dust, fumes and gases created by power sanding, sawing, grinding, drilling, welding and other construction activities contain chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead based paint
- crystalline silica from bricks, cement and other masonry products
- arsenic and chromium from chemically treated lumber

Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as dust masks that are specifically designed to filter out microscopic particles. For more information go to <http://www.p65warnings.ca.gov/> and <http://www.p65warnings.ca.gov/wood>.

**SAVE THESE INSTRUCTIONS**

**⚠WARNING** Read the entire contents of this manual before assembling or operating the taper attachment. Also, thoroughly familiarize yourself with all operation, maintenance and safety instructions that accompany the lathe to which the taper attachment will be mounted. Failure to comply may cause serious injury.

## Assembly

Numbers in parentheses (#) correspond to Figures and to index numbers in exploded view.

- Carefully remove taper attachment from box. Do not discard any packing material until taper attachment is assembled and operating properly. If any damage or missing parts are identified, contact your distributor immediately.
- Remove splash guard from lathe.
- Remove two nuts (A, Figure 1) and bearing cap (B, Figure 1) from end of cross slide screw (C, Figure 1).
- Remove the two thrust bearings from cross feed screw.
- Remove two hex socket cap screws (D, Figure 1) and the block (E, Figure 1). Set these items aside; do not discard them.

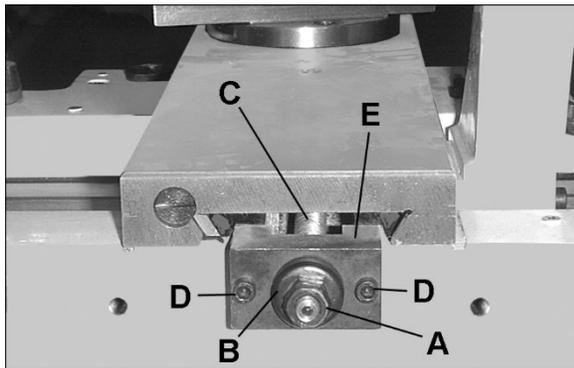


Figure 1

- On the taper attachment, remove eight flat head screws (#37) and remove cover (#6). See Figure 2.
- Loosen screws (#4) to separate yoke (#3) from block (#2).
- Install block (#2, with thrust bearings #1 installed) onto cross screw. See Figure 2.
- Reinstall nuts (A, Figure 2) onto end of cross screw. Tighten inner nut first to snug up bearing assembly. Turn cross slide handle and check for smooth rotation. Tighten outer nut to secure the adjustment.

NOTE: It is recommended that two persons perform the following steps, one to hold and help align the taper attachment, the other to secure the fasteners.

- Hold taper attachment so that hole in yoke (#3) aligns with cross screw. Secure yoke to block (#2) with the two screws (#4).

NOTE: Top surface of block (#2) must be *even with or lower than* top surface of yoke (#3). If needed, rotate block (#2) 180-degrees to achieve this position.

- Attach base casting (#5) to predrilled holes in carriage with M8x30 hex socket cap screws, and flat washers (#38/39, Figure 2). Tighten the cap screws enough to hold base in position but loose enough to allow adjustment with rubber mallet.

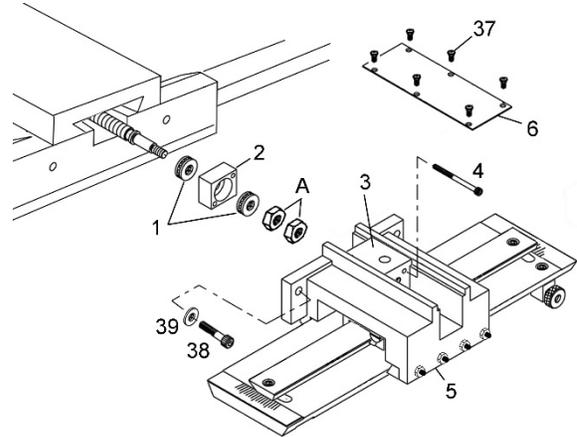


Figure 2

- Install clamp to bedway, along with rod and pivot, as shown in Figure 3. Secure rod to end of slide base with screw (#35). Tighten screws (#14,25,35)

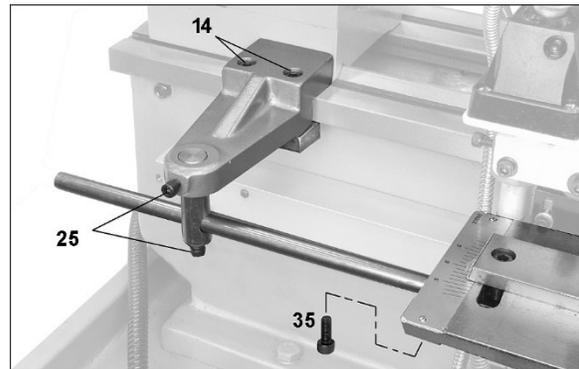


Figure 3

- Attach a dial indicator with magnetic base to lathe bed (Figure 4), and level the longitudinal slide to the bedway. The slide assembly is level when deviation is less than 0.005" from end to end. Use rubber mallet or dead blow hammer to nudge base casting as needed, until slide is level with bedways.

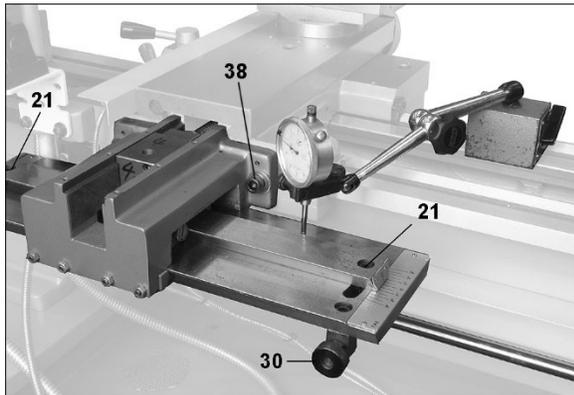


Figure 4

14. Securely tighten two screws (38, Figure 4) to hold base casting in place.
15. Move carriage along bed to verify that slide moves easily and without excessive play.

Test the angle scale setting, as follows:

16. Loosen screws at each end of taper bar, (#21, Figure 4) and rotate knurled knob (#30) to set taper bar at 0-degrees. Tighten screws.
17. Set top slide on lathe to 0-degrees and lock in position.
18. Attach a magnetic-based dial indicator to carriage and indicate against tool post, while moving carriage. See Figure 5.

19. Taper slide should be parallel to carriage movement. If indicator variation occurs during the carriage travel, make further checks and adjustments as needed.

20. Reinstall cover (#6, Figure 2).

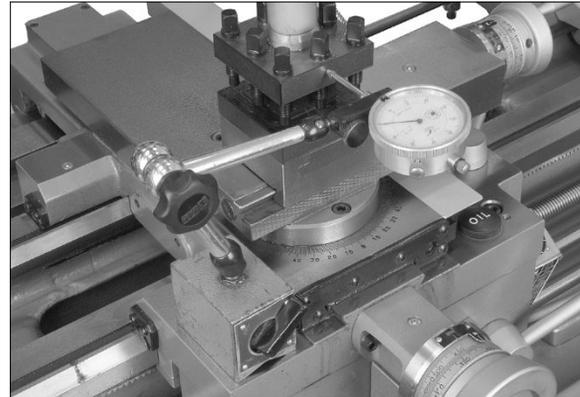


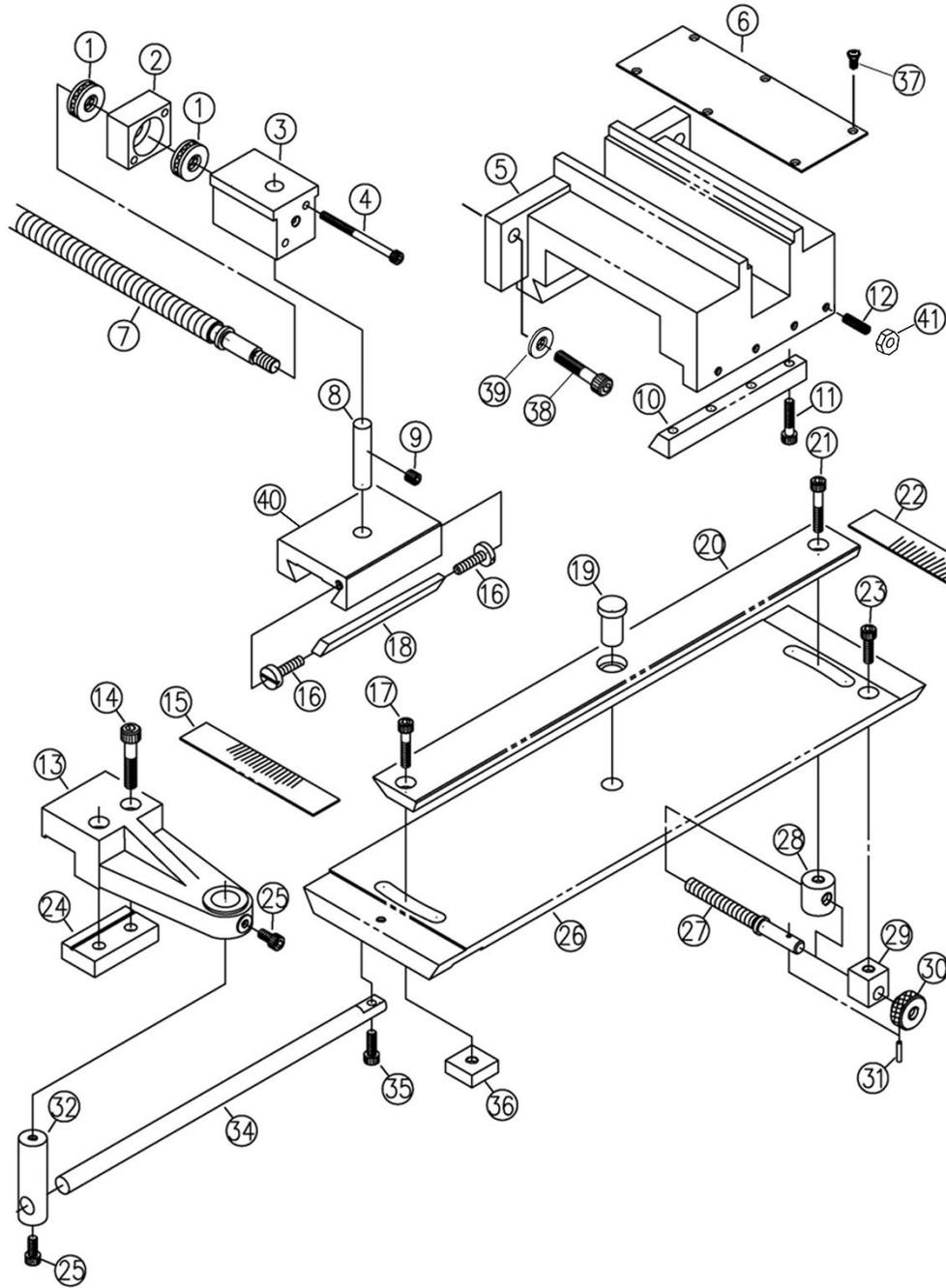
Figure 5

## Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET. Some parts are shown for reference only, and may not be available individually.

# 892035 Taper Attachment Assembly – Exploded View



## 892035 Taper Attachment Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
.....	892035	Taper Attachment Assembly (#1 thru 41)		1
1	E1440VS-J01	Thrust Bearing	51101	2
2	E1440VS-J02	Feed Block	52x20x35mm	1
3	E1440VS-J03	Yoke	60x42x41.5mm	1
4	E1440VS-J04	Socket Head Cap Screw	M5x65mm	2
5	E1440VS-J05	Base	175x180x85mm	1
6	E1440VS-J06	Cover	170x63x1.2mm	1
7	E1440VS-J07	Lead Screw	Ø5/8"x405mmL	1
8	E1440VS-J08	Shaft	Ø12x50Lmm	1
9	TS-1524011	Set Screw	M8x8mm	1
10	E1440VS-J10	Gib	130x18.86(10.2)x15mm	1
11	TS-1503061	Socket Head Cap Screw	M6x25mm	4
12	TS-1523061	Set Screw	M6x20mm	4
13	E1440VS-J13	Bracket	159x60x40mm	1
14	TS-1504081	Socket Head Cap Screw	M8x40mm	2
15	E1440VS-J15	Angle Plate	128x25x1.2mm	1
16	E1440VS-J16	Gib Screw		2
17	TS-1503071	Socket Head Cap Screw	M6x30mm	1
18	E1440VS-J18	Gib	110x7.27x5.57mm	1
19	E1440VS-J19	Pivot Pin		1
20	E1440VS-J20	Slide Bar (with riveted indicator plates)	420x40x15mm	1
21	TS-1503081	Socket Head Cap Screw	M6x35mm	1
22	E1440VS-J22	Inch Scale Plate (Travel per Foot)	126x25x1.2mm	1
23	TS-2236181	Socket Head Cap Screw	M6x18mm	1
24	E1440VS-J24	Strip	80x31x13mm	1
25	TS-1503031	Socket Head Cap Screw	M6x12mm	2
26	E1440VS-J26	Base	460x130x18mm	1
27	E1440VS-J27	Screw	Ø3/8"(Ø9.525)x105mmL	1
28	E1440VS-J28	Nut	Ø22x22L mm	1
29	E1440VS-J29	Screw Block	19x19x22mm	1
30	E1440VS-J30	Knurled Nut	Ø28(Ø20)x19L mm	1
31	E1440VS-J31	Pin	3x15mm	1
32	E1440VS-J32	Pivot	Ø3/4"x65mmL	1
34	E1440VS-J33	Rod	Ø1/2"x300mmL	1
35	TS-1503041	Socket Head Cap Screw	M6x16mm	1
36	E1440VS-J35	Block	25x25x10mm	1
37	TAK1340A-5	Flat Head Screw	M5x8	6
38	TS-1504061	Hex Socket Cap Screw	M8x30	2
39	TS-1550061	Flat Washer	M8	2
40	E1440VS-J39	Slide Block		1
41	TS-1540041	Hex Nut	M6	4

# Warranty and service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

## Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

## Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

## What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

## Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

## How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

## More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

## How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

## Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

## Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.