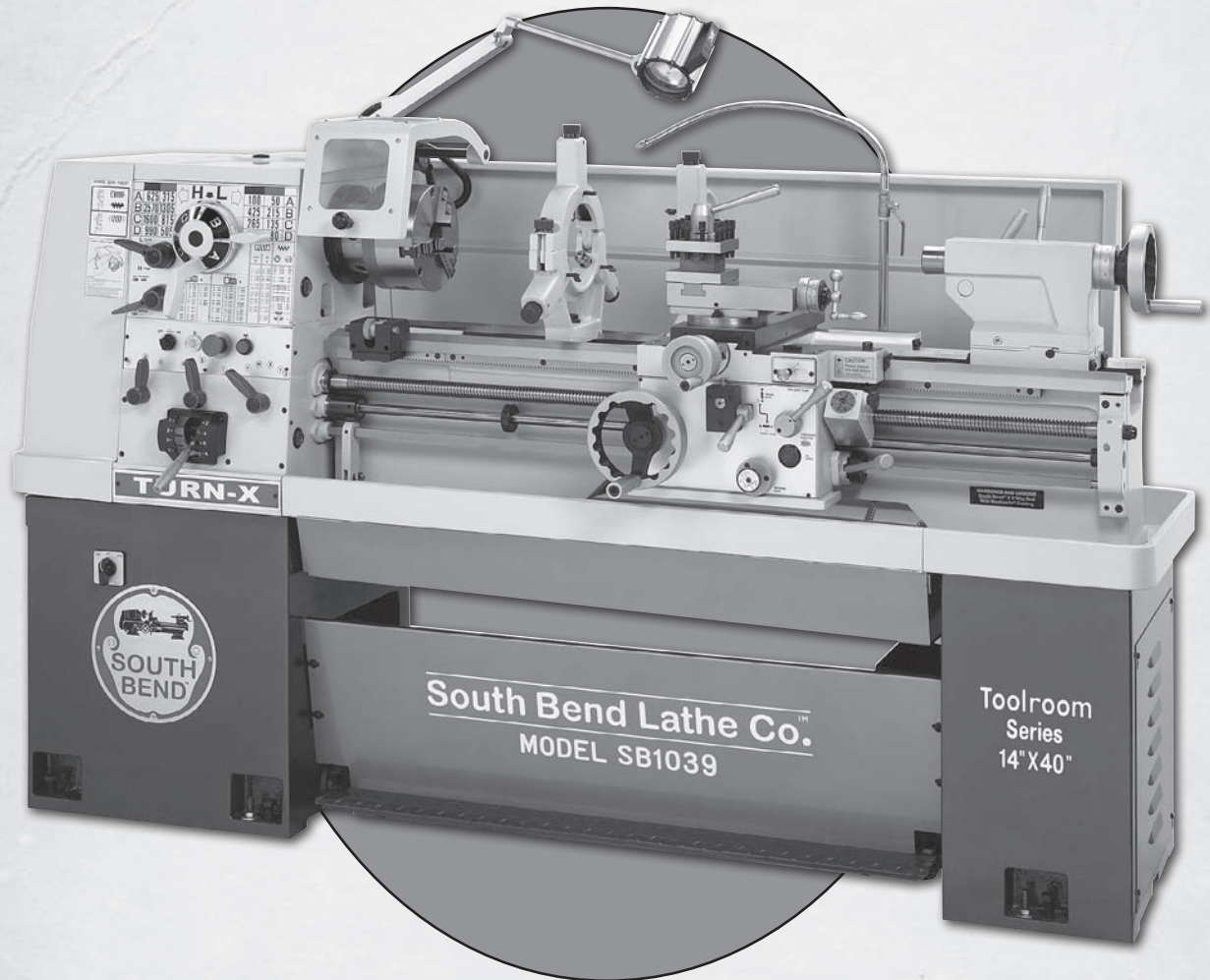




**14" X 40"**  
**16 SPEED TOOLROOM LATHE**  
**MODEL SB1039**



**OWNER'S MANUAL**

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**South Bend Lathe Co.™**

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*Hundreds of Thousands of Lathes Sold With a Tradition of Quality Since 1906!*



# Scope of Manual

This manual helps the reader understand the machine, how to prepare it for operation, how to control it during operation, and how to keep it in good working condition. We assume the reader has a basic understanding of how to operate this type of machine, but that the reader is not familiar with the controls and adjustments of this specific model. As with all machinery of this nature, learning the nuances of operation is a process that happens through training and experience. If you are not an experienced operator of this type of machinery, read through this entire manual, then learn more from an experienced operator, schooling, or research before attempting operations. Following this advice will help you avoid serious personal injury and get the best results from your work.

# Manual Feedback

We've made every effort to be accurate when documenting this machine. However, errors sometimes happen or the machine design changes after the documentation process—so the manual may not exactly match your machine. If a difference between the manual and machine leaves you in doubt, contact our customer service for clarification.

We highly value customer feedback on our manuals. If you have a moment, please share your experience using this manual. What did you like about it? Is there anything you would change to make it better? Did it meet your expectations for clarity, professionalism, and ease-of-use?

**South Bend Lathe, Inc.**  
**c/o Technical Documentation Manager**  
**P.O. Box 2027**  
**Bellingham, WA 98227**  
**Email: [manuals@southbendlathe.com](mailto:manuals@southbendlathe.com)**

# Updates

For your convenience, any updates to this manual will be available to download free of charge through our website at:

**[www.southbendlathe.com](http://www.southbendlathe.com)**

# Customer Service

We stand behind our machines. If you have any service questions, parts requests or general questions about your purchase, feel free to contact us.

**South Bend Lathe Co.**  
**P.O. Box 2027**  
**Bellingham, WA 98227**  
**Fax: (360) 676-1075 (International)**  
**Fax: (360) 734-1639 (USA Only)**  
**Email: [cs@southbendlathe.com](mailto:cs@southbendlathe.com)**

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# About This Machine

## Foreword

*"The screw cutting engine lathe is the oldest and most important of machine tools and from it all other machine tools have been developed. It was the lathe that made possible the building of the steamboat, the locomotive, the electric motor, the automobile and all kinds of machinery used in industry. Without the lathe our great industrial progress of the last century would have been impossible."* —**How To Run a Lathe**, 15th Edition, South Bend Lathe.

The lathe represented in this manual is a modern day version of the screw cutting lathes that trace their roots back to the 1700's, which were themselves technological improvements of the bow lathe that can be traced back thousands of years to the ancient Egyptians.

Now, almost 300 years later, these modern "screw cutting" lathes are not just a piece of refined machinery, but a culmination of human ingenuity and knowledge embodied into the design and synergy of thousands of interworking parts—some of which represent the life's work and dreams of many inventors, mechanical engineers, and world-class machinists—including the likes of Leonardo da Vinci, Henry Maudsley, and the founders of South Bend Lathe, John and Miles O'Brien.

And now the torch is passed to you—to take the oldest and most important type of machine tool—and carry on the tradition. As the operator of a South Bend Lathe, you now join the ranks of some very famous and important customers, such as Henry Ford, who used the machines he purchased to help him change the world.

## Capabilities

This 16-Speed Toolroom Lathe is built for daily use in a busy industrial setting. Loaded with many nice features and high-precision parts, this lathe excels at making fine tools, dies, thread gauges, jigs, and precision test gauges—however, it is by no means delicate. Thick castings, heavy weight, and quality construction throughout provide the necessary brawn for demanding production and manufacturing tasks.

## Features

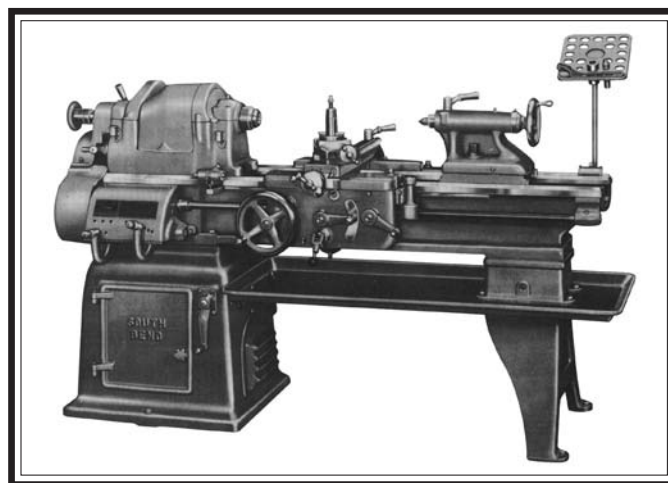
As the name implies, this lathe features 16 spindle speeds that are controlled with convenient levers on the front of the headstock. This allows the operator to quickly set the correct spindle speed within the available range of 50–2570 RPM.

The bed of this lathe is constructed with Meehanite castings that have been precision hardened and ground in the traditional 3-V prismatic design—long used on South Bend Lathes for accuracy, durability, and rigidity.

The headstock features quick change gear controls and an adjustable clutch mechanism for the feedrod that can be set to prevent damage in the event of a crash.

To further ensure a high degree of accuracy, this lathe is equipped with NTN spindle bearings. The spindle is the D1-5 camlock type with an MT#5 taper and 1.57" bore. The tailstock quill has an MT#3 taper and offers 4.5" of travel.

Finally, this toolroom lathe is packed with standard features, such as a complete cutting fluid system, easy-to-clean chip drawer, one-shot way lubrication system, included steady and follow rests, chuck guard adjustable work lamp, foot brake, and powered cross feed.



16" South Bend Precision Toolroom Lathe  
(Circa 1958)

# General Identification

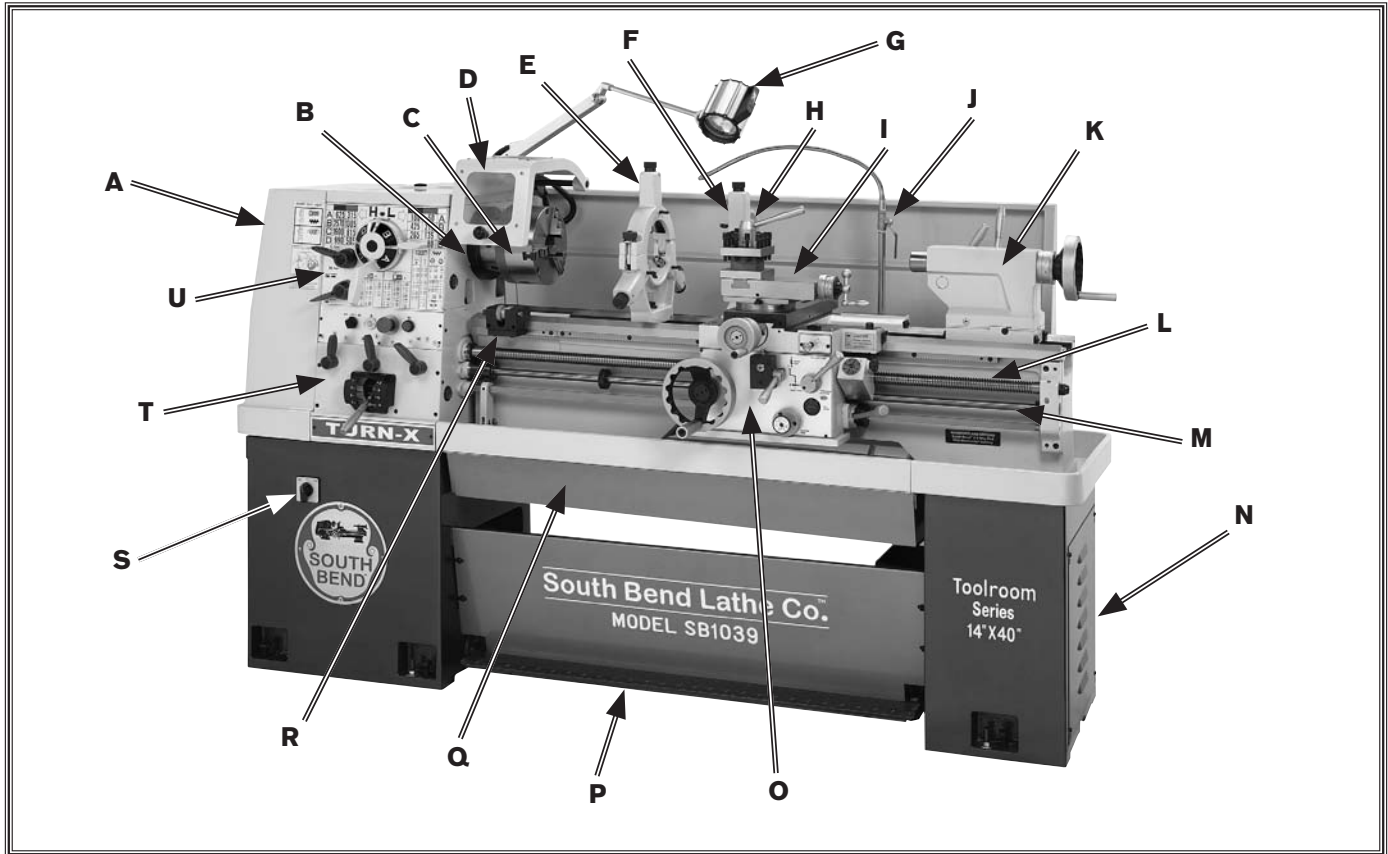


Figure 1. Model SB1039 identification.

- |  |  |
|--|--|
| <b>A.</b> Headstock                                  | <b>L.</b> Longitudinal Leadscrew                                 |
| <b>B.</b> D1-5 Camlock MT#5 Spindle                  | <b>M.</b> Feedrod  |
| <b>C.</b> 3-Jaw Chuck 8"                             | <b>N.</b> Cutting Fluid Reservoir & Pump Access                  |
| <b>D.</b> Chuck Guard w/Safety Switch                | <b>O.</b> Apron & Saddle (see <b>Page 29</b> for details)        |
| <b>E.</b> Steady Rest                                | <b>P.</b> Brake Pedal  |
| <b>F.</b> Follow Rest                                | <b>Q.</b> Chip Drawer  |
| <b>G.</b> Halogen Work Lamp                          | <b>R.</b> Micrometer Stop  |
| <b>H.</b> 4-Way Tool Post                            | <b>S.</b> Spindle Motor 2-Speed Switch                           |
| <b>I.</b> Compound Rest                              | <b>T.</b> Quick Change Controls (see <b>Page 28</b> for details) |
| <b>J.</b> Cutting Fluid Nozzle & Valve               | <b>U.</b> Headstock Controls (see <b>Page 28</b> for details)    |
| <b>K.</b> Tailstock (see <b>Page 30</b> for details) |  |

## **⚠️ WARNING**

Serious personal injury could occur if you connect the machine to power before completing the setup process. **DO NOT** connect power until instructed to do so later in this manual.

## **⚠️ WARNING**

Untrained users have an increased risk of seriously injuring themselves with this machine. Do not operate this machine until you have understood this entire manual and received proper training.



# Product Specifications



P.O. Box 2027, Bellingham, WA 98227 U.S.A.  
 PHONE: (360) 734-1540 • © South Bend Lathe Co.  
[www.southbendlathe.com](http://www.southbendlathe.com)

## Model SB1039 South Bend 14" x 40" 16 Speed Lathe 220V

### Product Dimensions

Weight..... 2420 lbs.  
 Width (side-to-side) x Depth (front-to-back) x Height..... 80-3/4 x 32-1/8 x 54-3/8 in.  
 Footprint (Length x Width)..... 80-3/4 x 19-1/2 in.

### Shipping Dimensions

Type..... Wood Slat Crate  
 Content..... Machine  
 Weight..... 2684 lbs.  
 Length x Width x Height..... 90 x 40 x 69 in.

### Electrical

Power Requirement..... 220V, 3-Phase, 60 Hz  
 Full-Load Current Rating..... 14.3A  
 Minimum Circuit Size..... 20A  
 Switch..... Magnetic with Thermal Protection  
 Switch Voltage..... 220V  
 Plug Included..... No  
 Recommended Plug/Outlet Type..... NEMA 15-20

### Motors

#### Main

Type..... TEFC Induction  
 Horsepower..... 5HP at 3450 RPM, 2.5 HP at 1725 RPM  
 Voltage..... 220V  
 Phase..... 3-Phase  
 Amps..... 14A/10A  
 Speed..... 3450/1720 RPM  
 Cycle..... 60 Hz  
 Number of Speeds..... Variable  
 Power Transfer ..... V-Belt & Gear  
 Bearings..... Shielded and Permanently Sealed

#### Coolant

Type..... TEFC Induction  
 Horsepower..... 1/8 HP  
 Voltage..... 220V  
 Phase..... 3-Phase  
 Amps..... 0.3A  
 Cycle..... 60 Hz  
 Number of Speeds..... 1  
 Power Transfer ..... Direct Drive  
 Bearings..... Shielded and Permanently Sealed

**Main Specifications****Operation Info**

Swing Over Bed.....	14.17 in.
Dist Between Centers.....	40 in.
Swing Over Cross Slide.....	8.66 in.
Swing Over Saddle.....	11.42 in.
Swing Over Gap.....	20.94 in.
Max Tool Bit Size.....	0.75 in.
Compound Travel.....	4 in.
Carriage Travel.....	36.5 in.
Cross Slide Travel.....	7 in.

**Headstock Info**

Spindle Bore.....	1.57 in.
Spindle Taper.....	MT#5
No of Spindle Speeds.....	16
Spindle Speeds.....	50 — 2570 RPM
Spindle Type.....	D1-5 Camlock
Spindle Bearings.....	NTN Tapered Roller
Spindle Length.....	20.87 in.
Spindle Length with 3-Jaw Chuck.....	28.74 in.
Spindle Length with 4-Jaw Chuck.....	30.71 in.

**Tailstock Info**

Tailstock Quill Travel.....	4.5 in.
Tailstock Taper.....	MT#3
Tailstock Barrel Diameter.....	1.968 in.

**Threading Info**

No of Longitudinal Feeds.....	17
Range of Longitudinal Feeds.....	0.002 — 0.067 in.
No of Cross Feeds.....	17
Range of Cross Feeds.....	0.001 — 0.034 in.
No of Inch Threads.....	45
Range of Inch Threads.....	2 — 72 TPI
No of Metric Threads.....	39
Range of Metric Threads.....	0.2 — 14 mm
No of Modular Pitches.....	18
Range of Modular Pitches.....	0.3 — 3.5 MP
No of Diametral Pitches.....	21
Range of Diametral Pitches.....	8 — 44 DP

**Dimensions**

Bed Width.....	9 in.
Leadscrew Diameter.....	1-1/8 in.
Leadscrew TPI.....	4
Leadscrew Length.....	59 in.
Steady Rest Capacity.....	5/16 — 4-5/16 in.
Follow Rest Capacity.....	5/8 — 3-1/8 in.
Faceplate Size.....	12 in.
Feed Rod Diameter.....	3/4 in.
Floor To Center Height.....	42-5/8 in.
Height With Leveling Jacks.....	54-3/8 in.

**Construction**

Base.....	Cast Iron
Headstock.....	Cast Iron
Headstock Gears.....	Flame Hardened Steel
Bed.....	Induction Hardened and Ground Cast Iron
Stand.....	Cast Iron
Paint.....	Urethane

**Other**

Country Of Origin .....	Taiwan (Some Components Made in USA and Japan)
Warranty .....	1 Year
Serial Number Location .....	ID Label on Rear Side of Left Stand
Assembly Time .....	Approximately 2 Hours
Sound Rating .....	76 dB

**Features**

Allen Bradley Electrical Components  
 Meehanite Casting, Signature South Bend Three V-Way Bed  
 Safety Chuck Guard with Micro-Switch Shut-Off  
 Halogen Work Light (24V/70W)  
 4-Way Tool Post  
 Complete Coolant System  
 Micrometer Carriage Stop  
 Threading Dial Indicator  
 NTN Japanese Spindle Bearing  
 Full Length Splash Guard  
 Front Removable Sliding Chip Tray  
 Headstock Gears Run in an Oil Bath  
 Completely Enclosed Universal Gearbox for Cutting Inch, Metric, Modular and Diametral Pitches  
 Jog Button and Emergency Stop

**Included Accessories**

10 in. 4-Jaw Independent Chuck D1-5  
 8 in. 3-Jaw Scroll Chuck (Mounted to 8 in. D1-5 Back Plate)  
 12 in. Faceplate D1-5  
 Follow Rest  
 Steady Rest with Roller Bearing Tips  
 #5 to #3 Morse Taper Spindle Sleeve  
 Two Morse Taper #3 Dead Centers (1 Carbon Steel and 1 Carbide-Tipped)  
 Six Leveling Pads  
 Service Tools  
 Tool Box  
 USA Written Manual




# Understanding Risks of Machinery

Operating all machinery and machining equipment can be dangerous or relatively safe depending on how it is installed and maintained, and the operator's experience, common sense, risk awareness, working conditions, and use of personal protective equipment (safety glasses, respirators, etc.).

The owner of this machinery or equipment is ultimately responsible for its safe use. This responsibility includes proper installation in a safe environment, personnel training and usage authorization, regular inspection and maintenance, manual availability and comprehension, application of safety devices, integrity of cutting tools or accessories, and the usage of approved personal protective equipment by all operators and bystanders.

The manufacturer of this machinery or equipment will not be held liable for injury or property damage from negligence, improper training, machine modifications, or misuse. Failure to read, understand, and follow the manual and safety labels may result in serious personal injury, including amputation, broken bones, electrocution, or death.

The signals used in this manual to identify hazard levels are defined as follows:

 <b>DANGER</b>	<i>Death or catastrophic harm WILL occur.</i>	 <b>CAUTION</b>	<i>Moderate injury or fire MAY occur.</i>
 <b>WARNING</b>	<i>Death or catastrophic harm COULD occur.</i>	<b>NOTICE</b>	<i>Machine or property damage may occur.</i>

## Basic Machine Safety

- 1. Owner's Manual:** All machinery and machining equipment presents serious injury hazards to untrained users. To reduce the risk of injury, anyone who uses THIS item MUST read and understand this entire manual before starting.
- 2. Personal Protective Equipment:** Operating or servicing this item may expose the user to flying debris, dust, smoke, dangerous chemicals, or loud noises. These hazards can result in eye injury, blindness, long-term respiratory damage, poisoning, cancer, reproductive harm or hearing loss. Reduce your risks from these hazards by wearing approved eye protection, respirator, gloves, or hearing protection.
- 3. Trained/Supervised Operators Only:** Untrained users can seriously injure themselves or bystanders. Only allow trained and properly supervised personnel to operate this item. Make sure safe operation instructions are clearly understood. If electrically powered, use padlocks and master switches, and remove start switch keys to prevent unauthorized use or accidental starting.
- 4. Guards/Covers:** Accidental contact with moving parts during operation may cause severe entanglement, impact, cutting, or crushing injuries. Reduce this risk by keeping any included guards/covers/doors installed, fully functional, and positioned for maximum protection.

- 5. Entanglement:** Loose clothing, gloves, neckties, jewelry or long hair may get caught in moving parts, causing entanglement, amputation, crushing, or strangulation. Reduce this risk by removing/securing these items so they cannot contact moving parts.
- 6. Mental Alertness:** Operating this item with reduced mental alertness increases the risk of accidental injury. Do not let a temporary influence or distraction lead to a permanent disability! Never operate when under the influence of drugs/alcohol, when tired, or otherwise distracted.
- 7. Safe Environment:** Operating electrically powered equipment in a wet environment may result in electrocution; operating near highly flammable materials may result in a fire or explosion. Only operate this item in a dry location that is free from flammable materials.
- 8. Electrical Connection:** With electrically powered equipment, improper connections to the power source may result in electrocution or fire. Always adhere to all electrical requirements and applicable codes when connecting to the power source. Have all work inspected by a qualified electrician to minimize risk.
- 9. Disconnect Power:** Adjusting or servicing electrically powered equipment while it is connected to the power source greatly increases the risk of injury from accidental startup. Always disconnect power **BEFORE** any service or adjustments, including changing blades or other tooling.
- 10. Secure Workpiece/Tooling:** Loose workpieces, cutting tools, or rotating spindles can become dangerous projectiles if not secured or if they hit another object during operation. Reduce the risk of this hazard by verifying that all fastening devices are properly secured and items attached to spindles have enough clearance to safely rotate.
- 11. Chuck Keys or Adjusting Tools:** Tools used to adjust spindles, chucks, or any moving/rotating parts will become dangerous projectiles if left in place when the machine is started. Reduce this risk by developing the habit of always removing these tools immediately after using them.
- 12. Work Area:** Clutter and dark shadows increase the risks of accidental injury. Only operate this item in a clean, non-glaring, and well-lighted work area.
- 13. Properly Functioning Equipment:** Poorly maintained, damaged, or malfunctioning equipment has higher risks of causing serious personal injury compared to those that are properly maintained. To reduce this risk, always maintain this item to the highest standards and promptly repair/service a damaged or malfunctioning component. Always follow the maintenance instructions included in this documentation.
- 14. Unattended Operation:** Electrically powered equipment that is left unattended while running cannot be controlled and is dangerous to bystanders. Always turn the power **OFF** before walking away.
- 15. Health Hazards:** Certain cutting fluids and lubricants, or dust/smoke created when cutting, may contain chemicals known to the State of California to cause cancer, respiratory problems, birth defects, or other reproductive harm. Minimize exposure to these chemicals by wearing approved personal protective equipment and operating in a well ventilated area.
- 16. Difficult Operations:** Attempting difficult operations with which you are unfamiliar increases the risk of injury. If you experience difficulties performing the intended operation, **STOP!** Seek an alternative method to accomplish the same task, ask a qualified expert how the operation should be performed, or contact our Technical Support for assistance.

## Additional Metal Lathe Safety

- 1. Clearing Chips.** Metal chips can easily cut bare skin—even through a piece of cloth. Avoid clearing chips by hand or with a rag. Use a brush or vacuum to clear metal chips.
- 2. Chuck Key Safety.** A chuck key left in the chuck can become a deadly projectile when the spindle is started. Always remove the chuck key after using it. Develop a habit of not taking your hand off of a chuck key unless it is away from the machine.
- 3. Tool Selection.** Cutting with an incorrect or dull tool increases the risk of accidental injury due to the extra force required for the operation, which increases risk of breaking or dislodging components that can cause small shards of metal to become dangerous projectiles. Always select the right cutter for the job and make sure it is sharp. A correct, sharp tool decreases strain and provides a better finish.
- 4. Securing Workpiece.** An improperly secured workpiece can fly off the lathe spindle with deadly force, which can result in a severe impact injury. Make sure the workpiece is properly secured in the chuck or faceplate before starting the lathe.
- 5. Chucks.** Chucks are very heavy and difficult to grasp, which can lead to crushed fingers or hands if mishandled. Get assistance when handling chucks to reduce this risk. Protect your hands and the precision-ground ways by using a chuck cradle or piece of plywood over the ways of the lathe when servicing chucks.
- 6. Safe Clearances.** Workpieces that crash into other components on the lathe may throw dangerous projectiles in all directions, leading to impact injury and damaged equipment. Before starting the spindle, make sure the workpiece has adequate clearance by hand-rotating it through its entire range of motion. Also, check the tool and tool post clearance, chuck clearance, and saddle clearance.
- 7. Speed Rates.** Operating the lathe at the wrong speed can cause nearby parts to break or the workpiece to come loose, which will result in dangerous projectiles that could cause severe impact injuries. Large or non-concentric workpieces must be turned at slow speeds. Always use the appropriate feed and speed rates.
- 8. Stopping Spindle by Hand.** Stopping the spindle by putting your hand on the workpiece or chuck creates an extreme risk of entanglement, impact, crushing, friction, or cutting hazards. Never attempt to slow or stop the lathe spindle with your hand. Allow the spindle to come to a stop on its own or use the brake.
- 9. Crashes.** Aggressively driving the cutting tool or other lathe components into the chuck may cause an explosion of metal fragments, which can result in severe impact injuries and major damage to the lathe. Reduce this risk by releasing automatic feeds after use, not leaving lathe unattended, and checking clearances before starting the lathe. Make sure no part of the tool, tool holder, compound rest, cross slide, or carriage will contact the chuck during operation.
- 10. Long Stock Safety.** Long stock can whip violently if not properly supported, causing serious impact injury and damage to the lathe. Reduce this risk by supporting any stock that extends from the chuck/headstock more than three times its own diameter. Always turn long stock at slow speeds.
- 11. Cutting Fluid Safety.** Cutting fluid is a very poisonous biohazard that can cause personal injury from skin contact alone. Incorrectly positioned cutting fluid nozzles can splash on the operator or the floor, resulting in an exposure or slipping hazard. To decrease your risk, change cutting fluid regularly and position the nozzle where it will not splash or end up on the floor.

## Preparation Overview

The purpose of the preparation section is to help you prepare your machine for operation. The list below outlines the basic process to follow to prepare the lathe for operation. Specific steps for each of these points will be covered in detail later in this section.

### The typical preparation process is as follows:

1. Unpack the lathe and inventory the contents of the box/crate.
2. Clean the lathe and its components.
3. Identify an acceptable location for the lathe and move it to that location.
4. Level the lathe and either bolt it to the floor or place it on mounts.
5. Assemble the loose components and make any necessary adjustments or inspections to ensure the lathe is ready for operation.
6. Connect the lathe to the power source.
7. Test run the lathe to make sure it functions properly and is ready for operation.

## Things You'll Need

To complete the preparation process, you will need the following items:

### For Lifting and Moving

- A forklift or other power lifting device rated for at least 3500 lbs.
- Lifting straps rated for at least 3500 lbs. each
- (Optional) Chain w/safety hook rated for at least 3500 lbs. each
- Two other people for moving machine
- Two 12" 2x6's
- Precision level

### For Power Connection

- A power source that meets the minimum circuit requirements for this machine (review the **Power Supply** section on **Page 12** for details)
- A qualified electrician to ensure a safe and code-compliant connection to the power source

### For Assembly

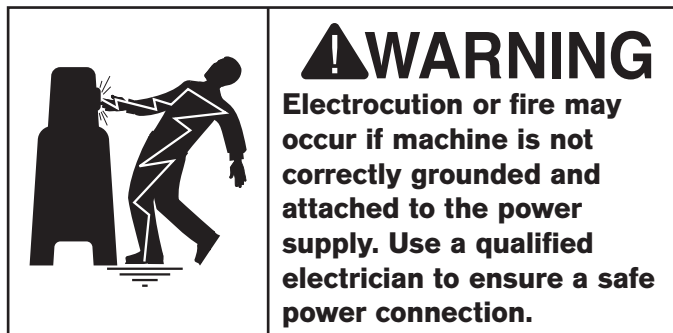
- Cotton rags
- Mineral spirits
- Quality metal protectant oil
- Safety glasses
- Wrench or socket 21mm
- Wrench or socket 19mm
- Floor mounting hardware as needed
- Standard screwdriver #2

# Power Supply Requirements

## Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed.

To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by a qualified electrician in accordance with all applicable codes and standards.



## Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

**Full-Load Rating at 220V ..... 14.3 Amps**

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements in the following section.

## Circuit Requirements

This machine is prewired to operate on a 220V power supply circuit that has a verified ground and meets the following requirements:

**Nominal Voltage ..... 220V/230V**  
**Cycle ..... 60 Hz**  
**Phase ..... 3-Phase**  
**Circuit Rating..... 20 Amps**  
**Connection.. Hardwire with Locking Switch**

A power supply circuit includes all electrical equipment between the main breaker box or fuse panel in your building and the incoming power connections inside the machine. This circuit must be safely sized to handle the full-load current that may be drawn from the machine for an extended period of time.



**Note:** The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure that the circuit is properly sized for safe operation.

## Grounding Requirements

In the event of certain types of malfunctions or breakdowns, grounding provides a path of least resistance for electric current—in order to reduce the risk of electric shock.

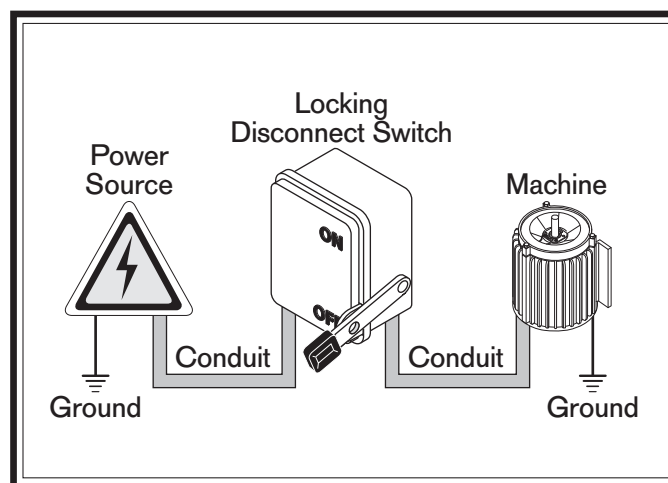
Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the machine is properly grounded. If you ever notice that a cord is damaged or worn, disconnect it from power, and immediately replace it with a new one.

### WARNING

**Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.**

As specified in the "Circuit Requirements" section on the previous page, the machine must be hardwired to the power source, using a locking switch (see **Figure 2**). The machine must also be connected to a grounded metal permanent wiring system; or to a system having an equipment-grounding conductor. Due to the complexity and high voltage involved, this type of installation **MUST** be done by a qualified electrician.



**Figure 2. Typical hardwire setup with a locking disconnect switch.**

## Unpacking

This item was carefully packaged to prevent damage during transport. If you discover any damage, please immediately call Customer Service at (360) 734-1540 for advice. You may need to file a freight claim, so save the containers and all packing materials for possible inspection by the carrier or its agent.

## Inventory

### Main Inventory 1: (Figure 3)

	Qty
A. Steady Rest Assembly.....	1
B. 12" Faceplate w/D1-5 Camlock Stud Set .....	1
C. 10" Four-Jaw Chuck w/Combo Jaws.....	1
D. 3-Jaw Chuck Key .....	1
E. Follow Rest Assembly .....	1

### Tool Box Inventory: (Figure 4)

	Qty
F. Tool Box .....	1
G. Open End Wrench 22/24mm .....	1
H. Open End Wrench 14/17mm .....	1
I. Open End Wrench 10/12mm .....	1
J. Phillips Screwdriver #2 .....	1
K. Standard Screwdriver #2.....	1
L. 8" 3-Jaw Chuck Reversed Jaws.....	3
M. Carbide-Tipped Dead Center MT#3.....	1
N. Tapered Spindle Sleeve MT#5-#3 .....	1
O. Dead Center MT#3.....	1
P. 4-Jaw Chuck Key .....	1
Q. Tool Post T-Wrench.....	1
R. Hex Wrench Set 1.5-10mm.....	1
S. Carriage Handwheel Handle.....	1
T. Cross Slide Handwheel Handle.....	1
U. Cast Iron Leveling Pads .....	8

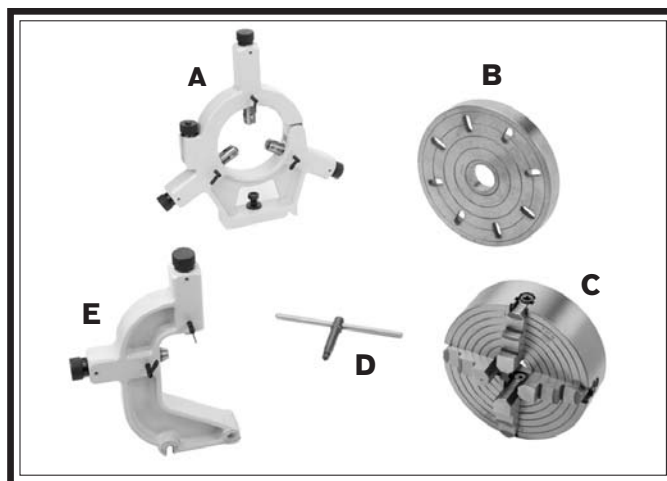


Figure 3. Main inventory.

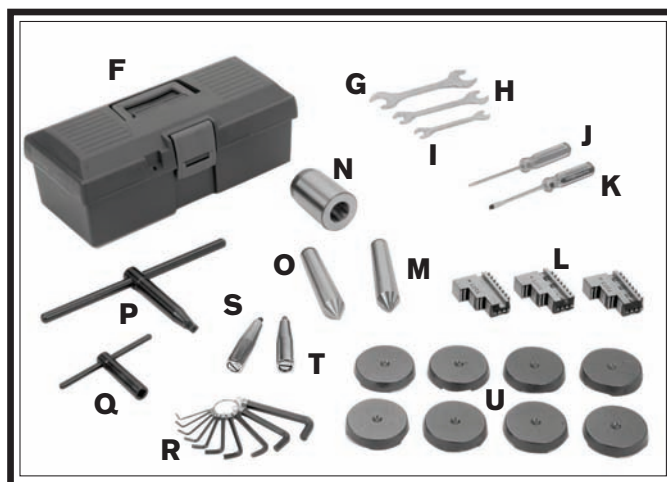


Figure 4. Toolbox inventory.

**Note:** Some inventory components may be shipped inside of the lathe electrical box. These items **MUST** be removed before connecting the lathe to the power source.

## Cleaning & Protecting

The unpainted surfaces are coated at the factory with a heavy-duty rust preventative that prevents corrosion during shipment and storage. The benefit of this rust preventative is that it works very well. The downside is that it can be time-consuming to thoroughly remove.

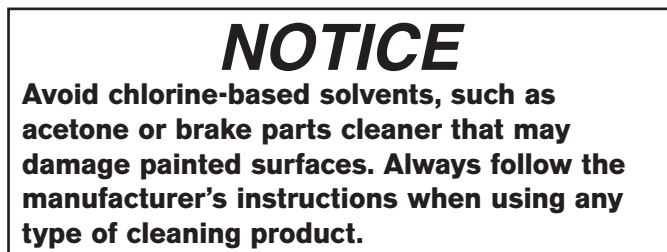
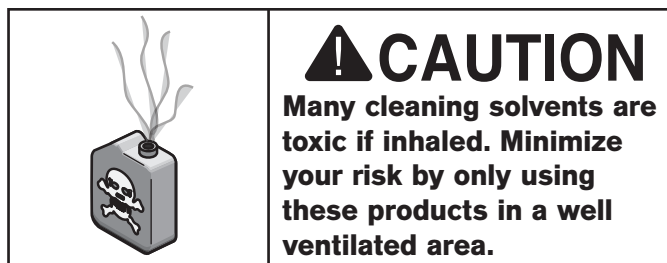
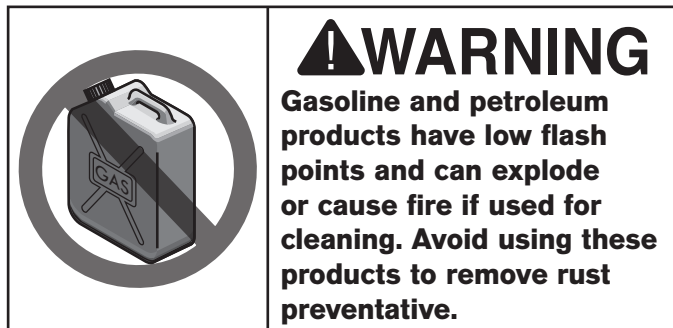
Be patient and do a careful job when cleaning and removing the rust preventative. The time you spend doing this will reward you with smooth-sliding parts and a better appreciation for the proper care of the unpainted surfaces.

Although there are many ways to successfully remove the rust preventative, we have cleaned thousands of machines and found the following process to be the best balance between efficiency and minimized exposure to toxic fumes or chemicals.

### Before cleaning, gather the following:

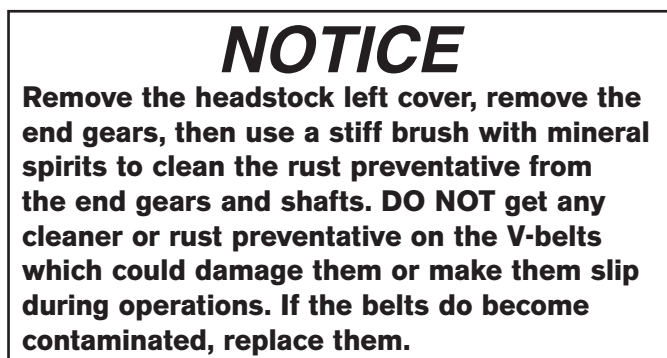
- Disposable rags
- Cleaner/degreaser (certain citrus-based degreasers work extremely well and they have non-toxic fumes)
- Safety glasses & disposable gloves

**Note:** Automotive degreasers, mineral spirits, or WD•40 can be used to remove rust preventative. Before using these products, though, test them on an inconspicuous area of a painted area to make sure they will not damage it.



### Basic steps for removing rust preventative:

1. Put on safety glasses and disposable gloves.
  2. Coat all surfaces that have rust preventative with a liberal amount of your cleaner or degreaser and let them soak for a few minutes.
  3. Wipe off the surfaces. If your cleaner or degreaser is effective, the rust preventative will wipe off easily.
- Note:** To clean off thick coats of rust preventative on flat surfaces, such as beds or tables, use a PLASTIC paint scraper to scrape off the majority of the coating before wiping it off with your rag. (Do not use a metal scraper or it may scratch the surface.)
4. Repeat Steps 2–3 as necessary until clean, then coat all unpainted surfaces with a quality metal protectant or light oil to prevent rust.



## Location

### Physical Environment

The physical environment where your machine is operated is important for safe operation and longevity of parts. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous or flammable chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature is outside the range of 41°–104°F; the relative humidity is outside the range of 20–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

### Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave access to a means of disconnecting the power source or engaging a lockout/tagout device.

### Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

### Weight Load

Refer to the **Machine Specifications** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

### Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual.

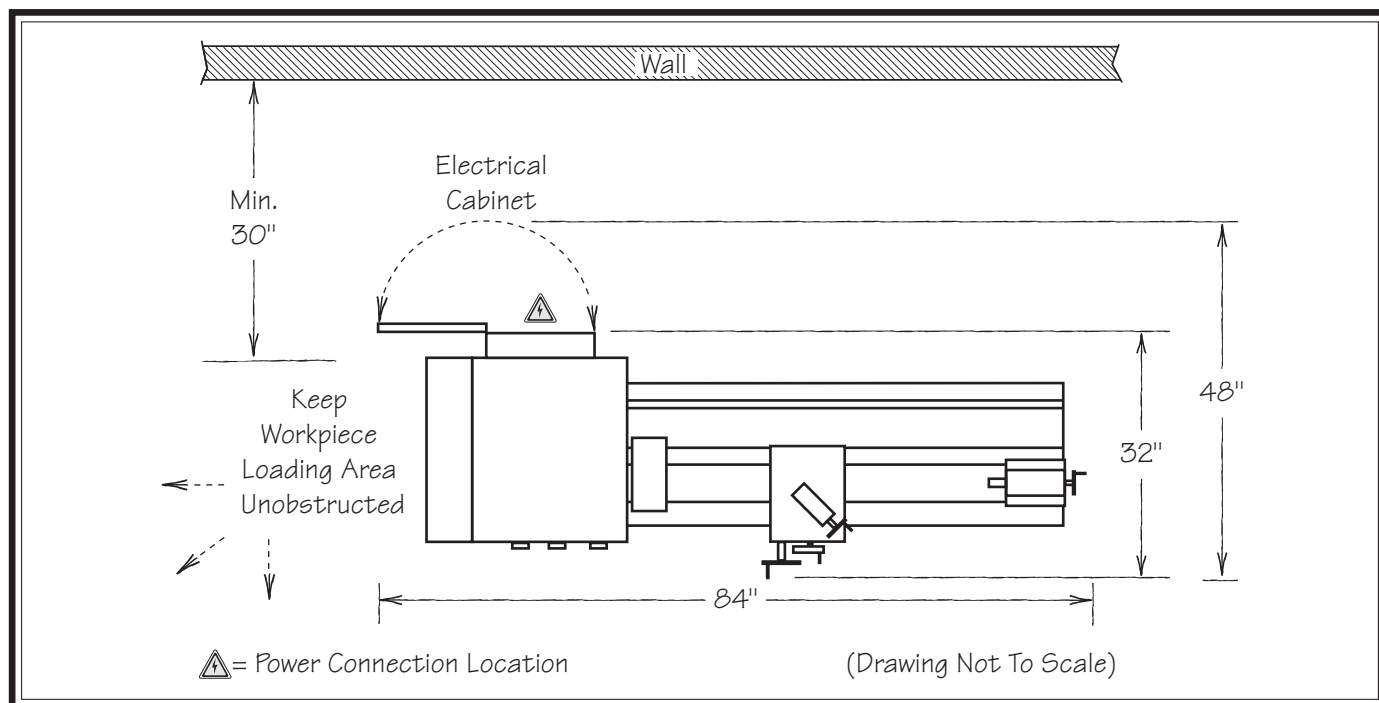
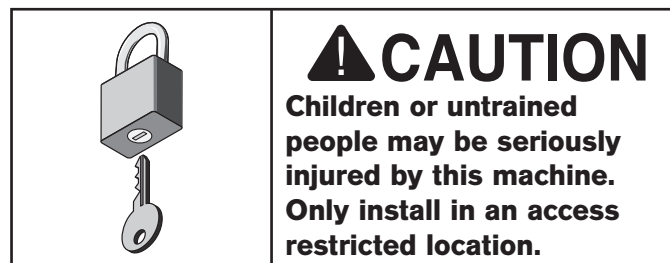
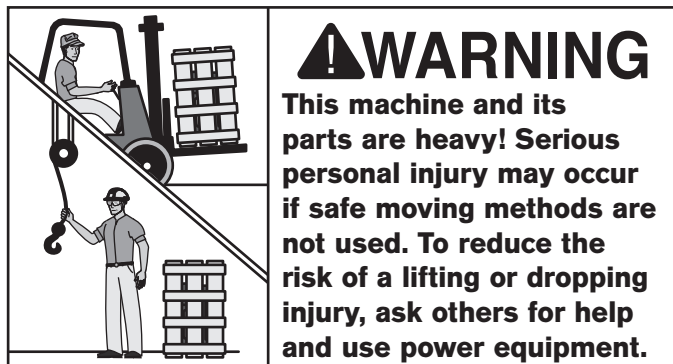


Figure 5. Space required for full range of movement.

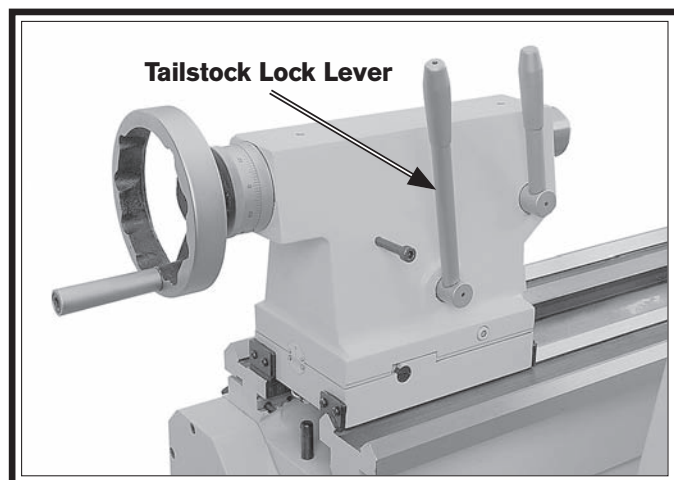
## Lifting & Moving



Do not attempt to lift or move this lathe without using the proper equipment or the necessary assistance from other people. Each piece of lifting equipment must be rated for at least 3500 lbs. to support dynamic loads that may be applied while lifting. Refer to the **Things You'll Need** subsection on **Page 11** for details.

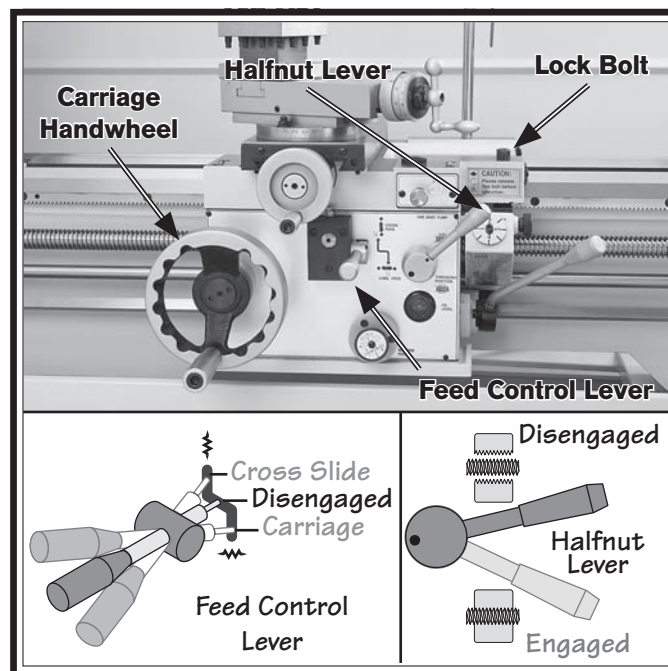
### To lift and move the lathe:

1. Remove the shipping crate top and sides, then remove the small components from the shipping pallet.
2. To balance the lifting load, loosen the tailstock lock lever (see **Figure 6**), move the tailstock to the end of the bedway, then lock it in place.



**Figure 6. Tailstock lock lever.**

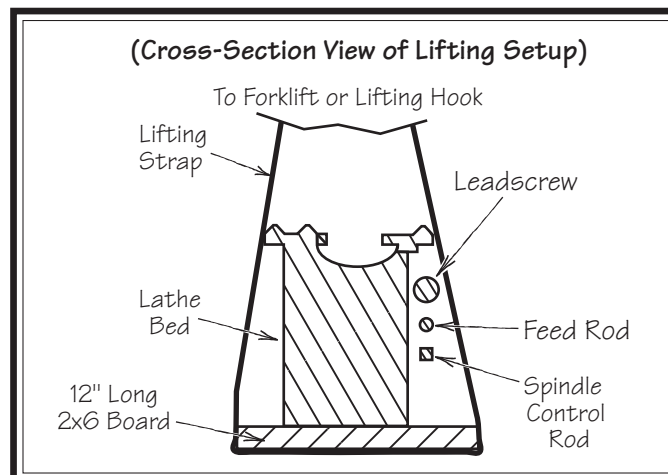
3. To further balance the load, loosen the carriage lock bolt (see **Figure 7**), disengage the halfnut lever, disengage the feed control lever, then use the carriage handwheel to move the carriage next to the tailstock.



**Figure 7. Carriage controls set for moving the carriage.**

4. Position a 12" long 2x6 board under each end of the bed, as illustrated in **Figure 8**, then wrap the lifting straps around the bottom of the 2x6's.

**Note:** The 2x6's extend the lifting straps away from the bottom of the bed to prevent machine damage from excessive strap pressure against the leadscrew, feedrod, and spindle control rod. Make sure to use them.



**Figure 8. Cross section of lifting setup.**

- Attach the lifting straps to the forklift forks or a hook and chain, as shown in Figures 9–10.

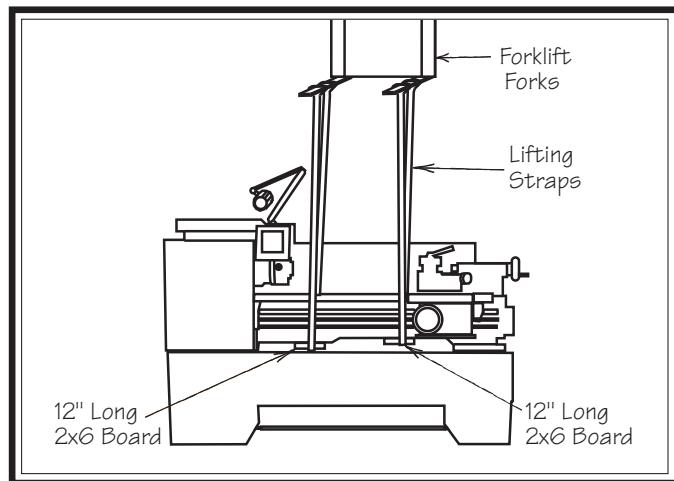


Figure 9. Lathe set up for lifting with forklift.

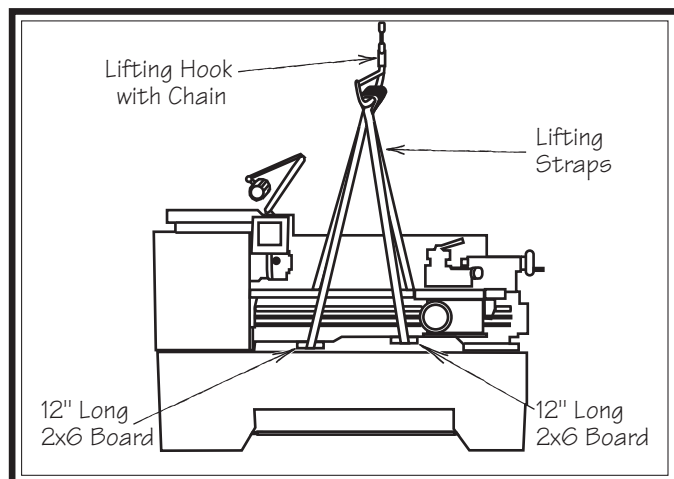


Figure 10. Lathe set up for lifting with hook and chain.

- Unbolt the lathe from the shipping pallet, then with two other people to help keep the lathe from swaying, raise it a couple of inches.
  - If the load is not well balanced, or you see any other difficulties with the lifting equipment, immediately lower the lathe to the pallet again. Resolve any lifting or balancing issues, then repeat this step.
- Lift the lathe enough to clear the shipping pallet and any small floor obstacles, then move it to the prepared location and lower it in place.

## Leveling & Mounting

You must level your machine and either use the included foot pads and leveling hardware or bolt your lathe to the floor. Because mounting your lathe to the floor with permanent hardware is an optional step and floor materials may vary, floor mounting hardware is not included.

### Leveling

#### **NOTICE**

**For accurate turning results and to prevent warping the cast iron bed and ways, the lathe bedways MUST be leveled from side to side and from front to back.**

**Re-check the bedways 24 hours after installation, two weeks after that, and then annually to make sure they remain level.**

Leveling machinery helps precision components, such as bedways, remain straight and flat during the lifespan of the machine. Components on a machine that is not level may slowly twist due to the dynamic loads placed on the machine during operation.

For best results, use a precision level that is at least 12" long and sensitive enough to show a distinct movement when a 0.003" shim (approximately the thickness of one sheet of standard newspaper) is placed under one end of the level.

See the figure below for an example of a high precision level.

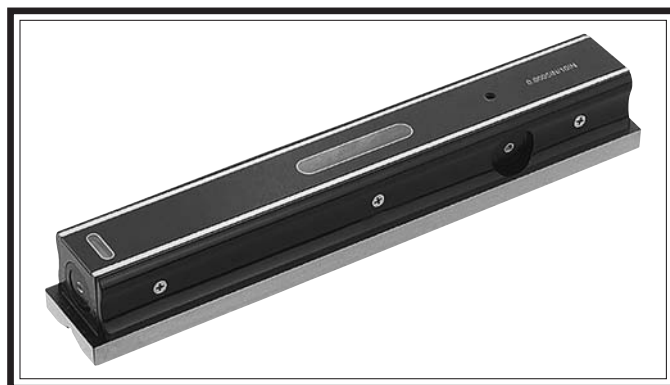
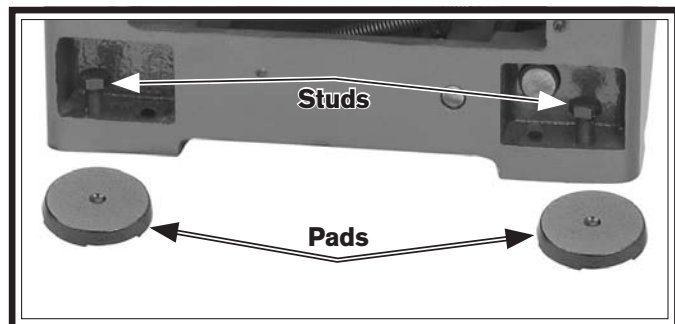


Figure 11. Example of a precision level.

To level the machine, use a precision level to make sure the bedways are level from side to side and from front to back.

- If using the included leveling pads (see **Figure 12**), place them under the six leveling stud locations, then adjust the studs to level the lathe.

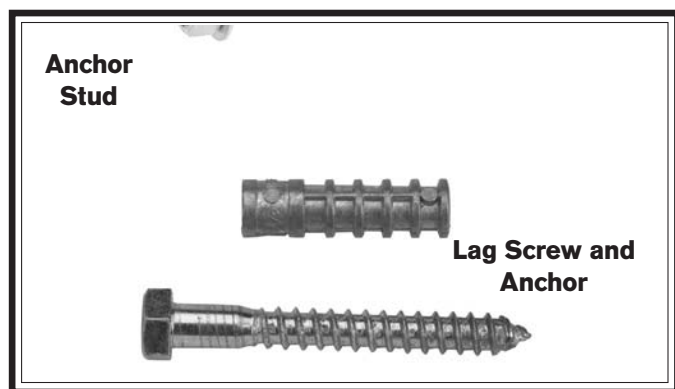


**Figure 12. Leveling pads and screws.**

- If using mounting hardware that does not allow for adjustment, level the lathe by placing metal shims between the lathe base and the floor before bolting it down.

## Bolting to Concrete Floors

Lag screws and anchors, or anchor studs (**below**), are two popular methods for bolting machinery to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best one for your specific application.



**Figure 13. Common types of fasteners for bolting machinery to concrete floors.**

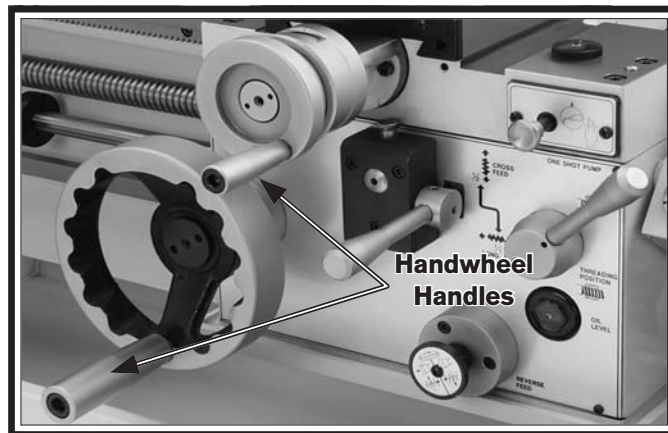
## NOTICE

Most electrical codes require that machines connected to the power source by fixed conduit **MUST** be secured to the floor.

## Assembly

With the exception of the handwheel handles, the lathe is shipped fully assembled.

To install the handwheel handles, thread the large handle into the carriage handwheel and the small handle into the cross slide handwheel, as shown in **Figure 14**.



**Figure 14. Handwheel handles installed.**

## Lubricating Lathe



The headstock, quick change gearbox, and apron oil reservoirs must have the proper amount of oil in them before the lathe can be operated for the first time.

Damage caused to the bearings and gears from running the lathe without oil in the gearboxes will not be covered under warranty. Refer to the **Lubrication** section, beginning on **Page 68**, for details on how to check and add oil.

In addition to the gearboxes, we also recommend that you lubricate all other points on the machine at this time. This can be accomplished by following the maintenance schedule on **Page 66**.

**Note:** If your lathe was shipped with oil in the gearboxes, do not change that oil until after the test run and break-in procedures.

## Adding Cutting Fluid

Add the cutting fluid of your choice now. For detailed instructions on where the cutting fluid reservoir is located and how to add fluid, refer to **Cutting Fluid System Service** subsection on **Page 72**.

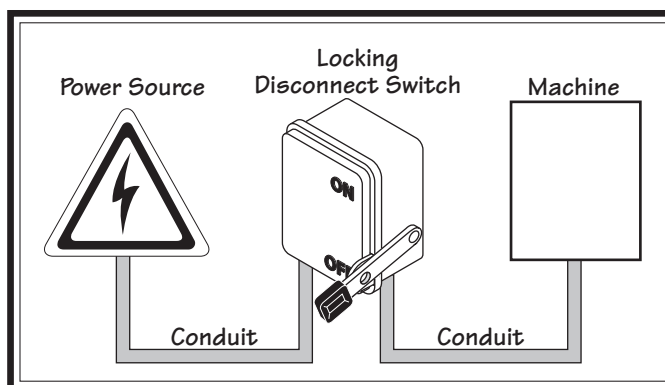
## Power Connection

Due to the complexity required for planning, bending, and installing the conduit necessary for a code-compliant hardwire setup, an electrician or other qualified person **MUST** perform this type of installation. Hardwire setups typically require power supply wires to be enclosed inside of a solid or flexible conduit, which is securely mounted at both ends with the appropriate conduit fittings. All work must adhere to the required electrical codes.

The hardwire setup for this machine must include a locking disconnect switch (see **Figure 15**) between the power source and the machine. This switch serves as the means to completely disconnect the machine from power to prevent electrocution from accidental startup during adjustments, maintenance, or service to the machine.

### **! DANGER**

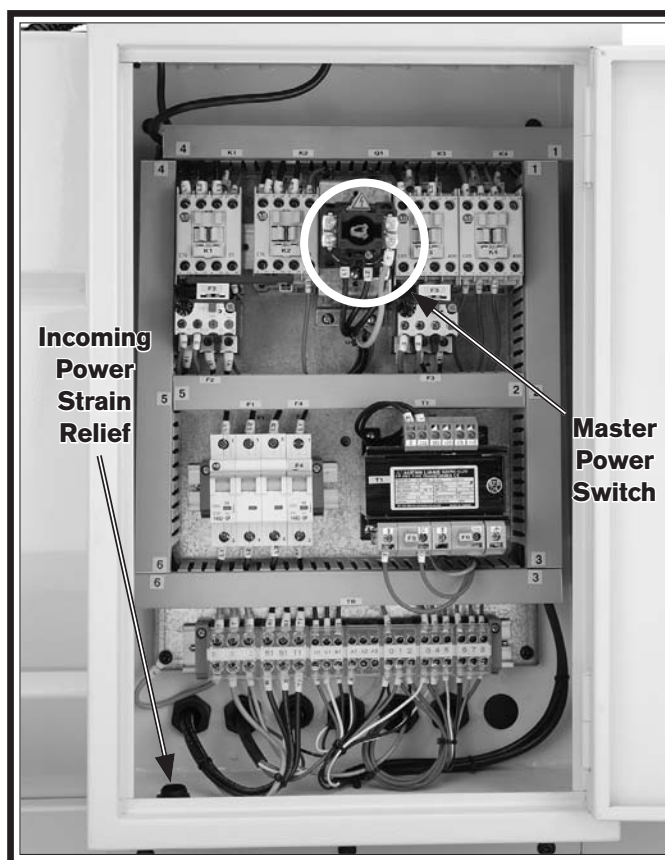
Electrocution or death will occur if you attempt this procedure with the power cord connected to the power source. The cord must be disconnected from power before performing this procedure.



**Figure 15. Typical hardwire setup with a locking disconnect switch.**

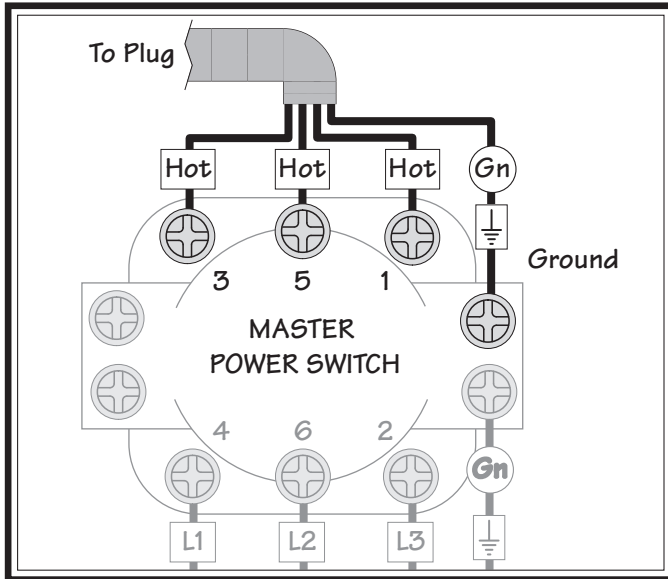
### To connect power cord to the lathe:

1. Make sure the master power switch is turned to the OFF position, then open the electrical cabinet door.
2. Thread the power cord through the strain relief, and up to the master power switch shown in **Figure 16**.



**Figure 16. Location to connect power inside main electrical cabinet.**

3. Connect the incoming hot and ground wires to the upper master power switch terminals, as illustrated in **Figure 17**.



**Figure 17.** Power connection at master power switch.

4. Make sure the power cord and wires have slack between the strain relief and terminal connections so that they do not bind, then tighten the strain relief to secure the cord.

**Note:** The strain relief must be tightened against the outer jacket of the cord. Avoid over-tightening the strain relief or it may crush the cord and cause a short.

5. Test the strain relief to ensure it is properly tightened by pulling the cord from outside the box with light-to-moderate force. When the strain relief is properly tightened, the cord will not move inside the cabinet.
6. Close and lock the main electrical box door.

## Test Run

After all preparation steps have been completed, the machine and its safety features must be tested to ensure correct operation. If you discover a problem with the operation of the machine or its safety components, shut the machine down, disconnect it from power, and do not operate it further until you have resolved the problem.

A **Troubleshooting** section is provided, starting on **Page 86**, to assist you with solutions if a problem occurs or if the lathe does not function as described in this section.

If you need additional help after reviewing the troubleshooting section, or you are not confident troubleshooting the machine on your own, contact our tech support at (360) 734-1540.

### To test run your machine:

1. Read and follow the safety instructions at the beginning of the manual, take all required safety precautions, and make sure all previous preparation steps discussed in this manual have been followed and completed.
2. Clear away all tools and objects used during assembly, lubrication, and preparation.
3. Make sure the master power switch shown in **Figure 18** is turned **OFF**.

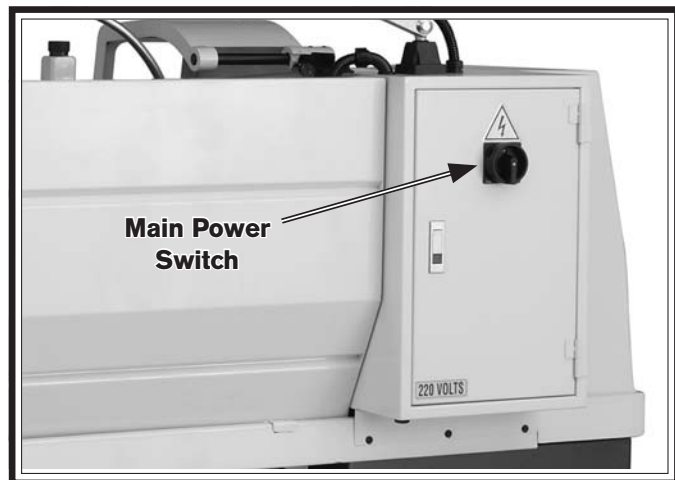


Figure 18. Location of the master power switch.

4. DISCONNECT LATHE FROM POWER!
5. Make sure that the chuck and jaws, if installed, are secure (refer to **Chuck and Faceplate Mounting** on **Page 31**), then lower the chuck guard.
6. Turn the cutting fluid switch (see **Figure 19**) to the OFF position, and point the fluid nozzle into the chip drawer.

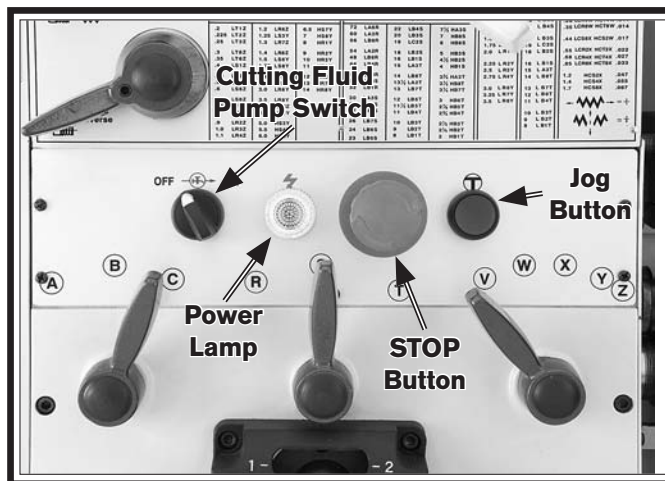


Figure 19. Control panel.

7. To ensure the carriage components do not unexpectedly move when the lathe is started, move the feed range lever to the neutral (middle) position (see **Figure 20**).

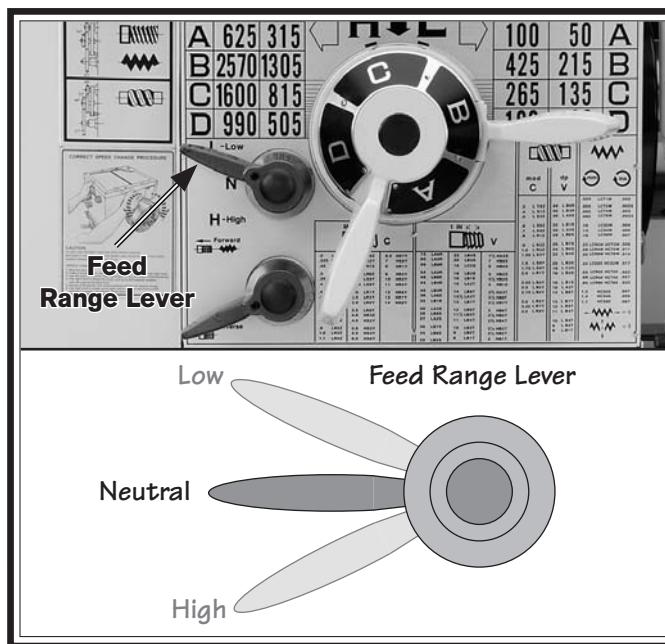


Figure 20. Feed range lever.

8. Turn the two-speed motor switch to the LOW position (see **Figure 21**).

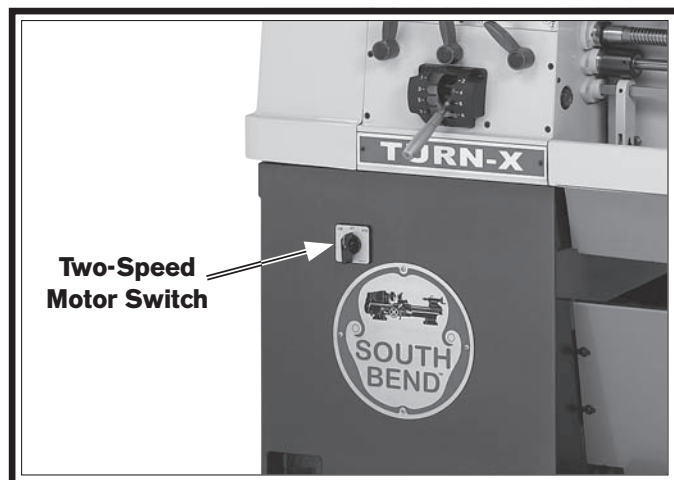


Figure 21. Location of the two-speed motor switch.

## NOTICE

Using the jog button to help mesh the headstock gears when changing the spindle speed or speed range could damage the gears and connected components. **DO NOT** use the jog button to help mesh the gears when changing spindle speeds or range!

**Note:** In the next step, use the chuck key to rock the chuck back-and-forth so that the gears will mesh as you make the adjustments. Be sure to remove the chuck key before continuing.

9. Set the spindle speed to 50 RPM by:
- Move the spindle speed spindle range lever so that the arrow on top of its hub is pointing toward the right-hand spindle speed chart (see **Figure 22**).
  - Set the spindle speed to 50 RPM by rotating the spindle speed lever so that the "A" on its hub is directly under the arrow on the headstock. This corresponds to the "A" in the right-hand spindle speed chart.

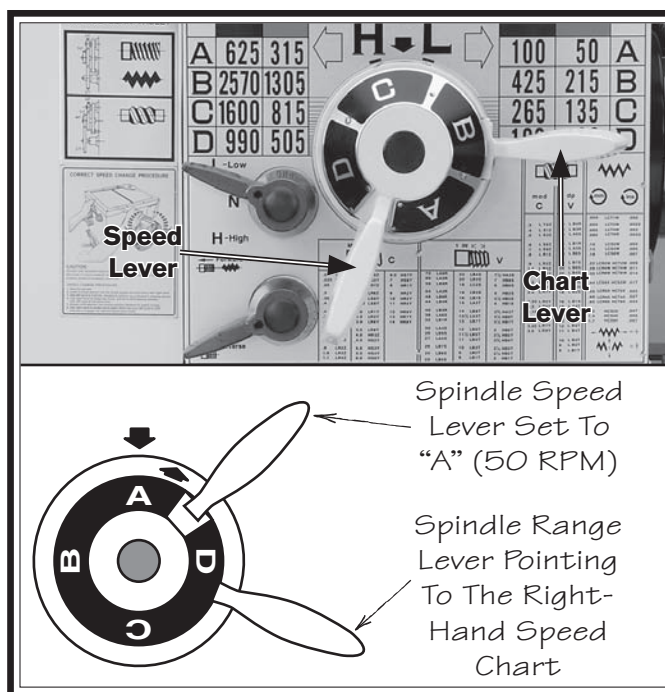


Figure 22. Spindle speed set to 50 RPM.

10. To allow the carriage to move freely when the handwheel is rotated, disengage the halfnut lever, put the feed control lever in disengaged position, and make sure the carriage lock bolt is loose (see **Figure 23**).

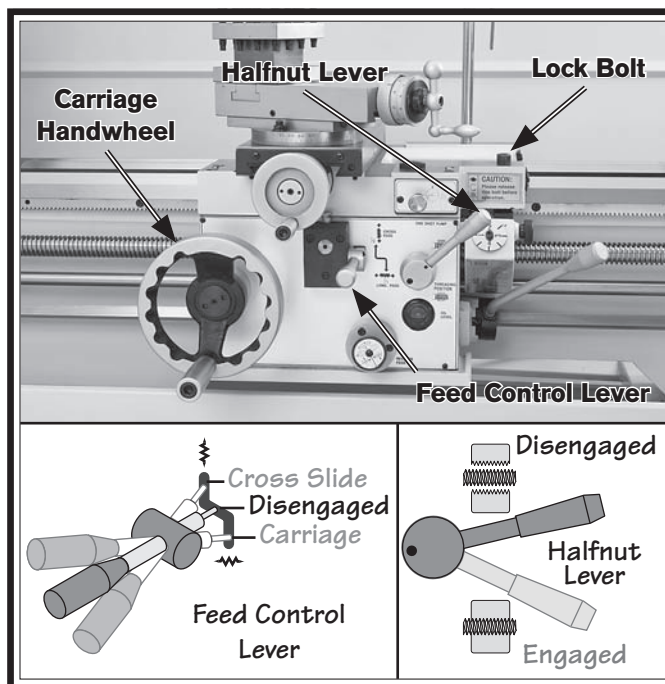
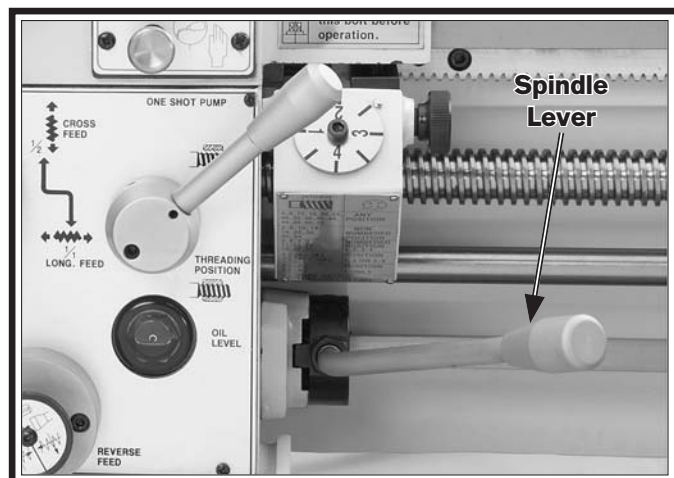


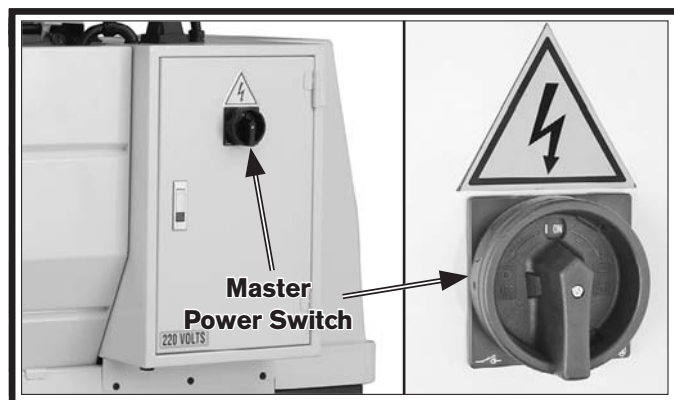
Figure 23. Carriage controls set for moving the carriage.

11. Move the spindle ON/OFF lever to the OFF (middle) position, as shown in **Figure 24**.



**Figure 24. Spindle ON/OFF lever in the OFF (middle) position.**

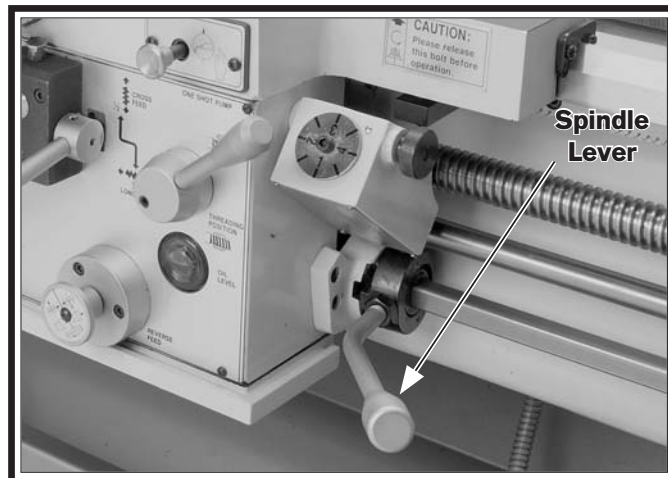
12. Press the STOP button on the control panel in to ensure the lathe does not unexpectedly start when connected to power in the next step.
13. Connect the lathe to the power source, then turn the master power switch to the ON position (see **Figure 25**).



**Figure 25. Master power switch turned ON.**

14. To reset the STOP button and enable power to the motor, twist the STOP button clockwise until it pops out. The power light on the control panel should illuminate (see **Figure 19** on **Page 22**).

15. Verify that the machine is operating correctly by pulling the spindle ON/OFF lever out and moving it down to start spindle rotation (see **Figure 26**).



**Figure 26. Spindle ON/OFF lever in down (forward) position.**

- When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.
  - Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.
16. With the spindle ON/OFF lever in the down position, the spindle should be rotating counterclockwise—down and toward you as you face the lathe.
- If the spindle and chuck are not rotating counterclockwise, the power supply is connected out-of-phase. Stop the machine, disconnect it from power, then follow the instructions in the **Correcting Phase Polarity Wiring** section on **Page 90**.

After correcting the wiring, repeat **Steps 12–16**.

17. Press the STOP button to turn the lathe **OFF**, then, without resetting the STOP button, try to restart the lathe with the spindle ON/OFF lever.
  - If the lathe does not start with the STOP button pressed in, the STOP button safety feature is working properly.
  - If the lathe does start with the STOP button pressed in, the STOP button safety is not operating correctly. This safety feature must operate properly before continuing operation. Use the spindle ON/OFF lever to stop the lathe, disconnect it from power, and call Tech Support for help.
18. Move the spindle ON/OFF lever to the OFF (middle) position, reset the STOP button by twisting it clockwise until it pops out, then restart spindle rotation.
19. Push the foot brake. The lathe should come to a quick stop.
  - If the brake pedal has no effect on the lathe, push the STOP button, and refer to the **Brake & Switch** subsection on **Page 80** to make any required adjustments.
20. Move the spindle ON/OFF lever to the OFF (middle) position. Remove the lathe headstock left cover. This activates a safety switch that should prevent the lathe from starting while this cover is removed.
21. Stand away from all the exposed gears on the side of the headstock, and attempt to start the lathe.
  - If the lathe starts with the end cover removed, the safety switch is not operating correctly. This safety feature must operate properly before continuing operation. Press the STOP button to turn the lathe **OFF**, disconnect it from power, and call Tech Support for help.
22. Push the STOP button in, move the spindle ON/OFF lever to the OFF position, then replace the headstock end cover.
23. Lift the chuck guard up—this will activate the chuck guard safety switch. Reset the STOP button and attempt to start the lathe.
  - If the lathe starts with the chuck guard in the up position, the safety switch is not operating correctly. This safety feature must operate properly before continuing operation. Press the STOP button to turn the lathe **OFF**, disconnect it from power, and call Tech Support for help.
24. Point the cutting fluid nozzle down into the chip drawer.
25. Re-start the lathe, use the cutting fluid pump switch on the control panel to start the pump, then open the valve. Verify that the cutting fluid flows from the nozzle, then turn the pump **OFF**.

Congratulations! The test run is complete. Turn the lathe **OFF** and perform the following **Spindle Break-In** procedure.

## NOTICE

**After the first 16 hours of use, the V-belts will stretch and seat into the pulley grooves. The V-belts must be properly re-tensioned after this period to avoid reducing their useful life. Refer to the V-Belts subsection on Page 80 for detailed instructions.**

## Spindle Break-In

The high-quality bearings and gears used in this lathe are manufactured to very close tolerances. Before subjecting the lathe to full loads, you must break it in—bearings will fully seat, gear teeth will find their normal wear pattern, and lubricant will be worked into the required areas.

### To perform the spindle break-in:

1. Successfully complete the **Test Run** procedure beginning on **Page 22**.
2. To ensure the carriage components do not unexpectedly move when the lathe is started, move the feed range lever to the neutral (middle) position (see **Figure 27**).

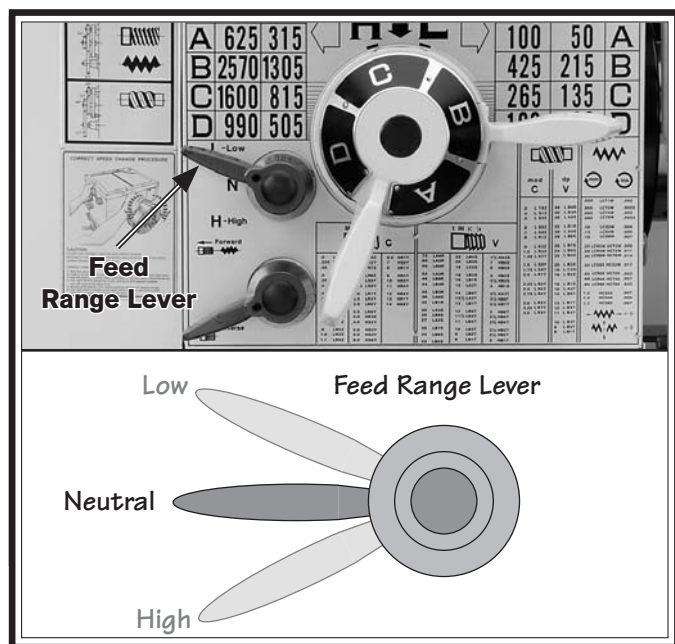


Figure 27. Feed range lever.

3. Set the spindle speed for 50 RPM (refer to the **Setting Spindle Speed** subsection on **Page 52** for detailed instructions).

## NOTICE

**Do not leave the lathe unattended during the Spindle Break-In procedure. If your attention is needed elsewhere during this procedure, stop the lathe and restart the procedure later from the beginning.**

4. Take all safety precautions, then run the lathe for 10 minutes.
5. Turn the lathe **OFF** and wait until the spindle is completely stopped.
6. Repeat **Steps 3–5** for each of the remaining 15 spindle speeds.
7. Set the spindle speed to 315 RPM and let the lathe run for a final 15 minutes to allow it to cool down, then turn the lathe **OFF**.
8. Change the oil in the headstock, quick change gearbox, and apron reservoirs as instructed in the **Lubrication** subsection on **Page 68**.
9. Check and, if necessary, re-tension the V-belts as instructed in the **V-Belt** subsection on **Page 80**.

The spindle break-in is complete. Continue with the following **Recommend Adjustments** subsection.

## Recommended Adjustments

For your convenience, the adjustments listed below have been performed at the factory.

However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure the best possible results from your new machine.

Step-by-step instructions for these adjustments can be found on the pages referenced below.

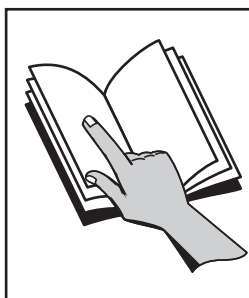
### Factory adjustments that should be verified:

- Tailstock alignment (**Page 45**).
- Compound and cross slide backlash adjustment (**Page 77**).
- Gib adjustments (**Page 76**).

## Operation Overview

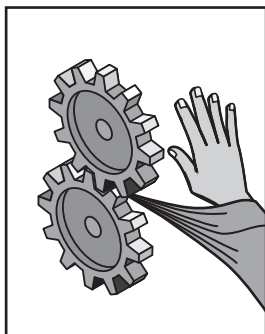
The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so they can more easily understand the controls discussed later in this manual.

**Note:** Due to the generic nature of this overview, it is not intended to be an instructional guide for performing actual machine operations. To learn more about specific operations and machining techniques, seek training from people experienced with this type of machine, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



### **!WARNING**

To reduce the risk of serious injury when using this machine, read and understand this entire manual before beginning any operations.



### **!WARNING**

Loose hair, clothing, or jewelry could get caught in machinery and cause serious injury or death. Keep these items away from moving parts at all times to reduce this risk.



### **!WARNING**

During operation, small metal chips may become airborne, leading to serious eye injury. Wear safety glasses to reduce this risk.

To complete a typical operation, the operator does the following:

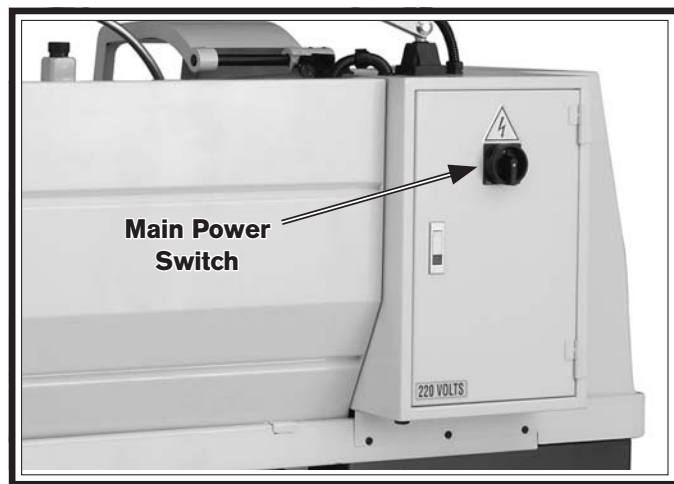
1. Puts on safety glasses, rolls up sleeves, removes jewelry, and secures any clothing, jewelry, or hair that could get entangled in moving parts.
2. Examines the workpiece to make sure it is suitable for turning, then mounts the workpiece in one of the chucks or on the faceplate, and removes the chuck key from the chuck.
3. Mounts the tooling, aligns it with the workpiece, then backs it away to establish a safe startup clearance.
4. Clears all setup tools from the lathe.
5. Checks for safe clearances by rotating the workpiece by hand at least one full revolution.
6. Moves slides to where they will be used during operation.
7. Sets the correct spindle speed for the operation.
8. If using power feed, selects the proper feed rate for the operation.
9. Turns the master power switch **ON**, resets the STOP button, then moves the spindle ON/OFF lever down to start spindle rotation.
10. Uses the carriage handwheels or power feed options to move the tooling into the workpiece for operations.
11. When finished cutting, moves the spindle ON/OFF lever to the OFF position, presses the foot brake to completely stop the spindle, then removes the workpiece.

## Controls & Components

Refer to **Figures 28–32** and the following descriptions to become familiar with the basic controls of this lathe.

### Master Power Switch

The master power switch enables power to all lathe components.

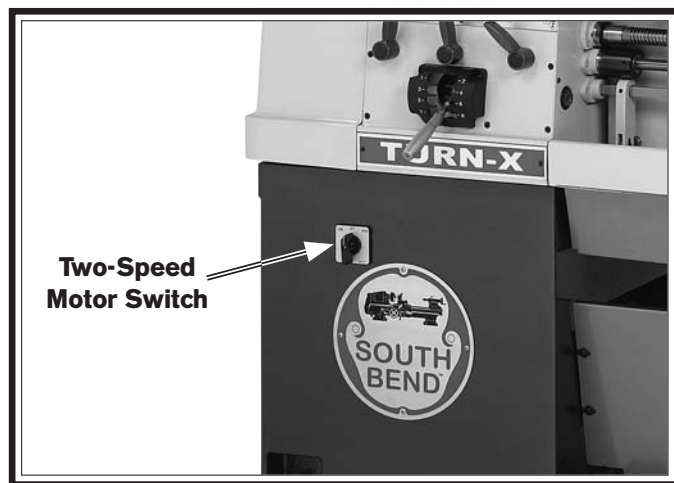


**Figure 28.** Location of the master power switch.

### Two-Speed Motor Switch

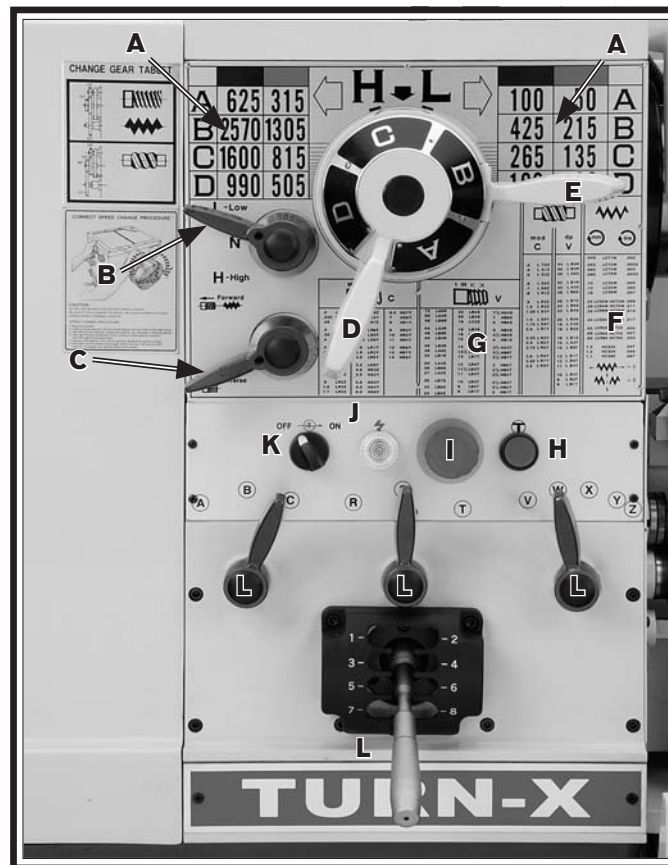
The two-speed motor switch has three positions:

- Low (left position)
- OFF (middle position)
- High (right position)



**Figure 29.** Location of the two-speed motor switch.

### Headstock Controls



**Figure 30.** Headstock controls.

- Spindle Speed Charts:** Displays the arrangement of the spindle range and spindle speed levers for each of the 16 spindle speeds.
- Feed Range Lever:** Shifts the quick change gearbox into low range, neutral, or high range.
- Feed Direction Lever:** Controls the direction of the leadscrew or feedrod.
- Spindle Speed Lever:** Selects one of the four available spindle speeds in the selected spindle speed chart.
- Spindle Range Lever:** Selects the speeds in the left- or right-hand spindle speed chart to be active.
- Feed Rate Charts:** Displays the configuration of the headstock controls for the available feed rates.

- G. Threading Charts:** Displays the configuration of the headstock controls for the available thread types and pitches.
- H. Jog Button:** Starts forward spindle rotation as long as it is pressed.
- I. STOP Button:** Cuts power to the spindle motor and cutting fluid pump.
- J. Power Light:** Illuminates when power is enabled to the spindle motor and cutting fluid pump.
- K. Cutting Fluid Switch:** Starts and stops the cutting fluid pump. Fluid flow is controlled by the valve on the cutting fluid nozzle.
- L. Quick Change Levers:** Sets the quick change gearbox configuration for feeding and threading operations.
- O. Cutting Fluid Valve Lever:** Controls the flow of cutting fluid from the nozzle.
- P. Saddle Oil Pump:** Draws oil from the apron reservoir and lubricates the bed ways underneath the saddle and the slide ways.
- Q. Carriage Lock Bolt:** Secures the carriage in place for greater rigidity and accuracy when using the cross slide or compound rest for the machining operation.
- R. Thread Dial:** Indicates when to engage the halfnut during inch threading operations.
- S. Spindle ON/OFF Lever:** Starts, stops and reverses direction of spindle rotation.
- T. Halfnut Lever:** Engages and disengages the halfnut for threading operations.
- U. Quick Change Feed Direction Knob:** Changes apron feed direction without having to stop the lathe and use the feed direction lever on the headstock.
- V. Feed Control Lever:** Engages and disengages the cross slide or carriage feed.
- W. Carriage Handwheel:** Moves the carriage side-to-side along the bed.
- X. Apron:** Houses the carriage gearing and controls.
- Y. Cross Slide Handwheel:** Moves the cross slide toward or away from the workpiece. Includes a direct-read graduated scale (distance represents amount of material removed from diameter of workpiece, which is half the amount of tool movement).

## Carriage Controls

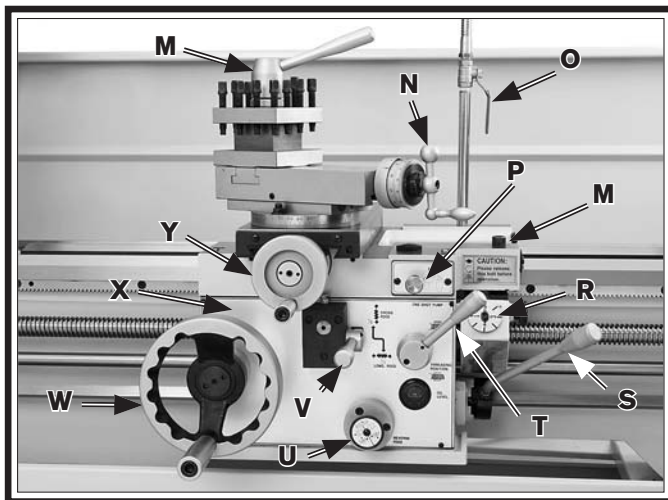


Figure 31. Carriage controls.

- M. 4-Position Tool Post Lever:** Locks the rotary tool post in four possible positions.
- N. Compound Rest Handwheel:** Controls the position of the cutting tool relative to the workpiece. Includes an indirect-read graduated scale (distance represents actual tool movement, which is twice the amount removed from the diameter of the workpiece).

## Tailstock Controls

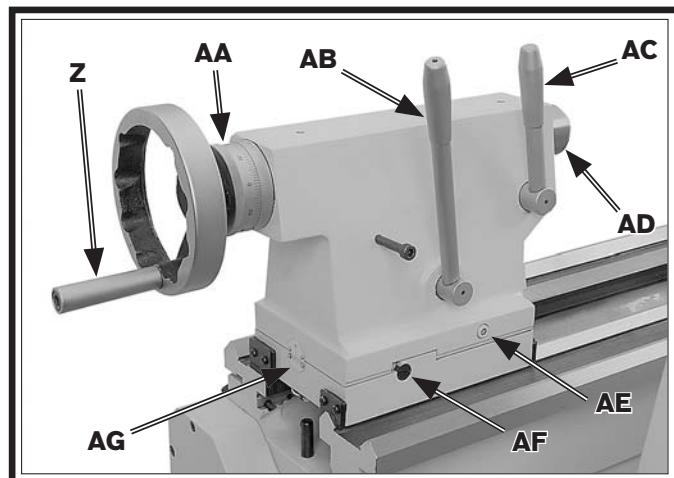


Figure 32. Tailstock controls.

- Z. Tailstock Handwheel:** Moves the quill toward or away from the spindle.
- AA. Graduated Scale:** Indicates quill movement in increments of 0.001".
- AB. Tailstock Lock Lever:** Secures the tailstock in place along the bedway.
- AC. Quill Lock Lever:** Locks the quill in position.
- AD. Quill:** Moves toward and away from the spindle and holds centers and tooling.
- AE. Tailstock Offset Screw:** Adjusts and secures the tailstock offset (1 of 2).
- AF. Gib Adjustment Screw:** Adjusts the tailstock gib that controls the side to side movement (1 of 2).
- AG. Offset Scale:** Indicates the distance of tailstock offset from the spindle centerline.

## Foot Brake

This lathe is equipped with a foot brake (see **Figure 33**) to quickly stop the spindle instead of allowing the spindle to coast to a stop on its own. Pushing the foot brake while the spindle is **ON** cuts power to the motor and stops the spindle.

After the foot brake is used, the spindle ON/OFF lever must be returned to the OFF (middle) position to reset the spindle switches, which will enable spindle rotation.

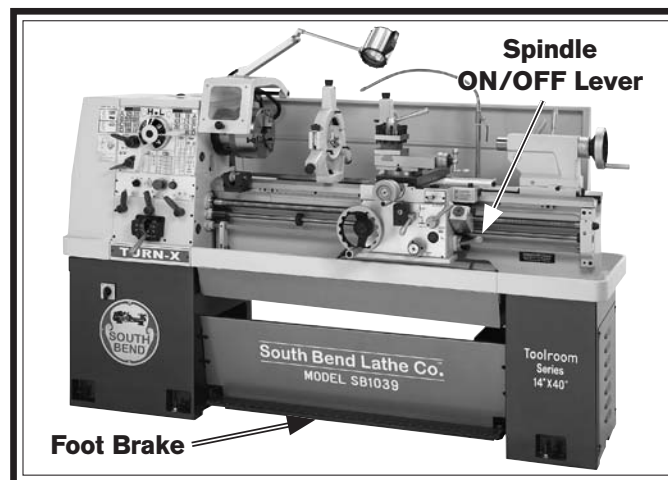


Figure 33. Foot brake and spindle ON/OFF lever.

# Chuck & Faceplate Mounting

This lathe is shipped with the 3-jaw chuck installed. This is a scroll-type chuck where all three jaws move in unison when the chuck key is used.

The included 4-jaw chuck features independent jaws, which are used for square or unevenly-shaped stock, and to mount work that needs to be adjusted to near zero total indicated runout.

If neither chuck can hold your workpiece, the cast iron faceplate has slots for T-bolts that hold standard or custom clamping hardware. With the correct clamping hardware, this faceplate will hold non-cylindrical parts.

The chucks and faceplate have a D-5 camlock mount. A chuck key is used to turn the locking cams to secure these devices to the spindle.

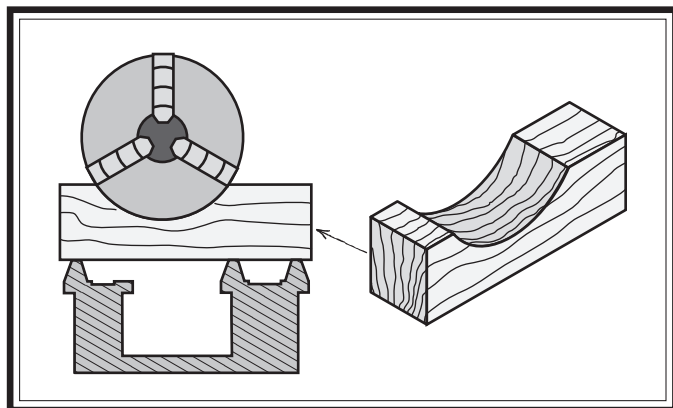
### Items Needed

### Qty

Dead Blow Hammer or Wood Block.....	1
Chuck Cradle or Plywood 3/4".....	1
Chuck Key .....	1

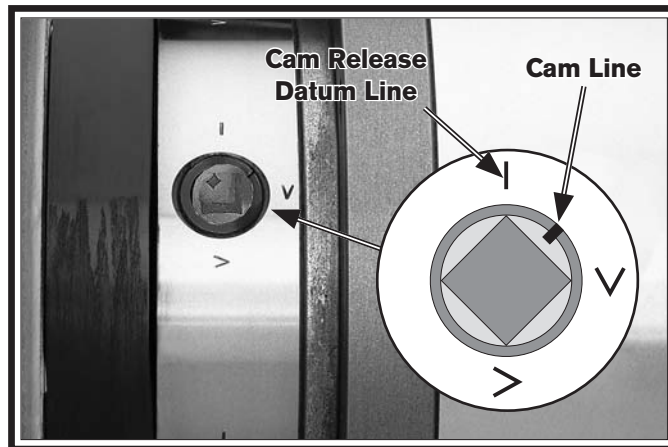
## Removing Chuck or Faceplate

1. DISCONNECT LATHE FROM POWER!
2. Lay a chuck cradle (see **Figure 34**) or plywood under the chuck or faceplate and over the bedway to protect the precision ground surfaces from damage and reduce injury if fingers get pinched.



**Figure 34** Wooden chuck support cradle.

3. Use the chuck key to turn the first camlock counterclockwise until the cam line aligns between the right "V" mark and the cam release datum line, as shown in **Figure 35**.

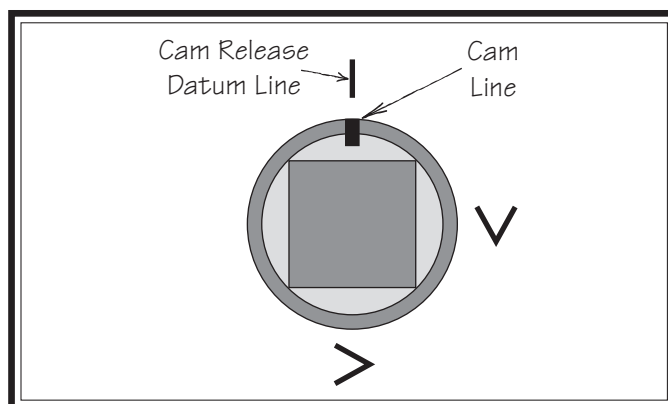


**Figure 35.** Camlock loosened halfway.

4. Repeat **Step 3** in an opposing star pattern around the spindle until all of the camlocks are in the same position. This ensures that chuck/faceplate will disengage from the spindle evenly.

**Note:** As you turn the camlocks, they will slightly rise up from the spindle body.

5. Start with the same camlock you began with in **Step 3** and rotate it counterclockwise so that the cam line is aligned with the cam release datum line, as illustrated in **Figure 36**.



**Figure 36.** Cam line aligned with cam release datum line.

6. While supporting the chuck/faceplate, rotate the other camlocks in the same opposing star pattern you used in **Step 4** to align the cam and datum lines.

7. While supporting the chuck/faceplate, remove the chuck key, then use a dead-blow hammer or a wood block to lightly tap around the circumference of the chuck or faceplate to break it free from the spindle taper and camlock sockets.
8. With a rocking motion, carefully remove the chuck or faceplate from the spindle nose, as shown in **Figure 37**.



**Figure 37.** Example of removing a 3-jaw chuck from a spindle nose.

### 3-Jaw Chuck Registration Marks

For the included 3-jaw chuck, the factory has adjusted each of the camlock studs so that they correctly fit into the specific spindle mounting holes. This ensures that the camlocks will engage each stud correctly.

After all the camlock studs were properly adjusted, the factory made matching registration marks on the side of the spindle and chuck backing plate (see **Figure 38**).

When re-installing the provided 3-jaw chuck on this lathe, always make sure that you align these registration marks with each other to ensure the correct fit.



**Figure 38.** Chuck registration marks aligned.

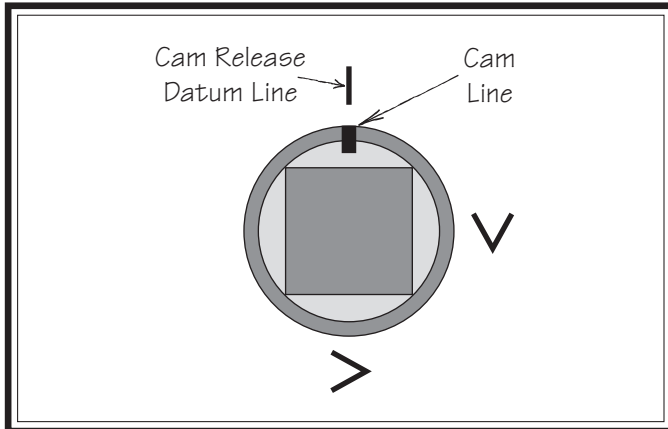
### Mounting Chuck or Faceplate

1. DISCONNECT LATHE FROM POWER!
2. Lay a chuck cradle (see **Figure 34** on the previous page) or plywood under the chuck or faceplate and over the bedway to protect the precision ground surfaces from damage and reduce injury if fingers get pinched.
3. Clean away debris and oily substances from the mating surfaces of the spindle and chuck or faceplate.
4. Inspect and make sure that all camlock studs are undamaged and clean, and that the camlock stud cap screws are in place and snug (see the **Installing & Adjusting Camlock Studs** on **Page 34** for additional information).

## NOTICE

**Never install a chuck or faceplate without having the camlock cap screws in place or fully tightened. If the cap screws are loose, the camlock studs may rotate with the camlocks, which could make the removal of the chuck or faceplate nearly impossible.**

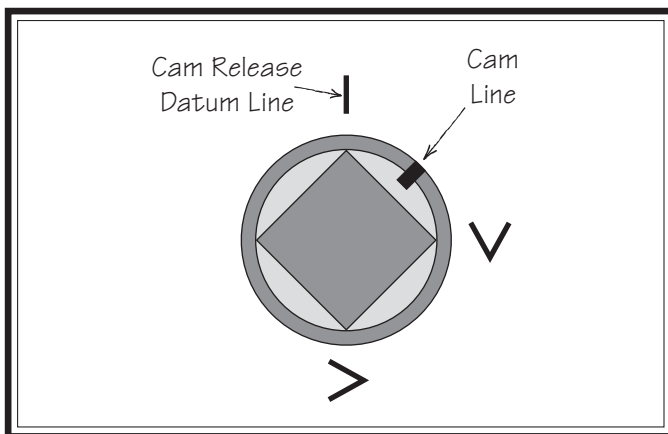
5. Make sure all of the cam lines on the side of the spindle are aligned with the cam release datum lines, as illustrated in **Figure 39**.



**Figure 39. Cam line aligned with datum line.**

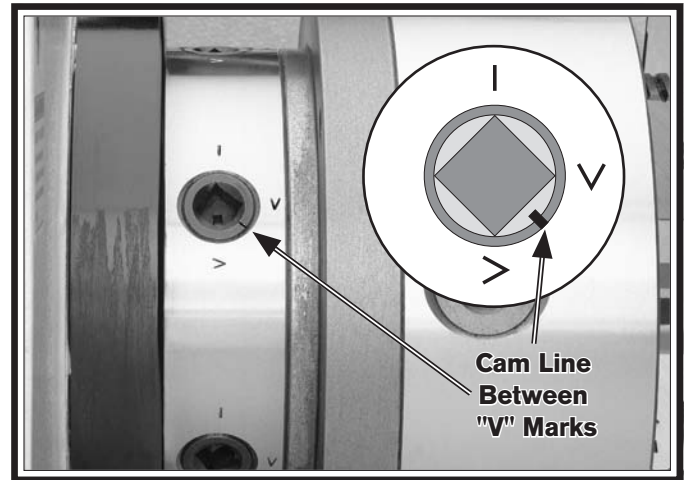
**Note:** If the chuck or faceplate has a registration mark that matches one on the spindle, align these marks when performing the next step.

6. Insert the camlock studs into the spindle mounting holes and hold the chuck or faceplate firmly in place during the next steps.
7. To evenly draw the chuck into the spindle, start with one camlock and tighten it so that the cam line is halfway between the datum line and the right-hand "V", as illustrated in **Figure 40**.



**Figure 40. Camlock rotated halfway to the first "V".**

8. Repeat **Step 7** in an opposing star pattern around the spindle until all of the camlocks are in the same position.
9. Rotate the camlock you started with in **Step 7** until the cam line is halfway between the "V" marks, as shown in **Figure 41**.



**Figure 41. Camlock fully tightened with the line between the "V" marks.**

10. In the same pattern used in **Step 7**, tighten the rest of the camlocks to bring the cam lines to the same position. This will snug the chuck or faceplate up to the spindle.

**Note:** If any of the cam lines do not fall between the "V" marks when the camlocks are tightened, you must adjust that camlock stud as instructed in the **Installing & Adjusting Camlock Studs** subsection on **Page 34**.

## Installing & Adjusting Camlock Studs

Each camlock stud must extend from the back of the chuck or faceplate the correct length and position to ensure the camlock will fully engage the stud. To achieve this setting is a process of trial-and-error.

**Note:** When the camlock studs are correctly installed and adjusted, and the chuck or faceplate mounts evenly onto the spindle, remember to make unique matching registration marks on the sides of the spindle and chuck/faceplate. This ensures that the correct spindle mounting hole is used by each stud when re-installing that chuck or faceplate (refer to **3-Jaw Chuck Registration Marks on Page 32** for more information).

### Tool Needed

Hex Wrench 6mm ..... 1

Qty

### To install or adjust camlock studs into a chuck or faceplate:

1. Lay the chuck or faceplate upside down on a protective, flat surface.
2. If installed, remove the locking cap screw adjacent to each of the six camlock mounting holes (see **Figure 42**).

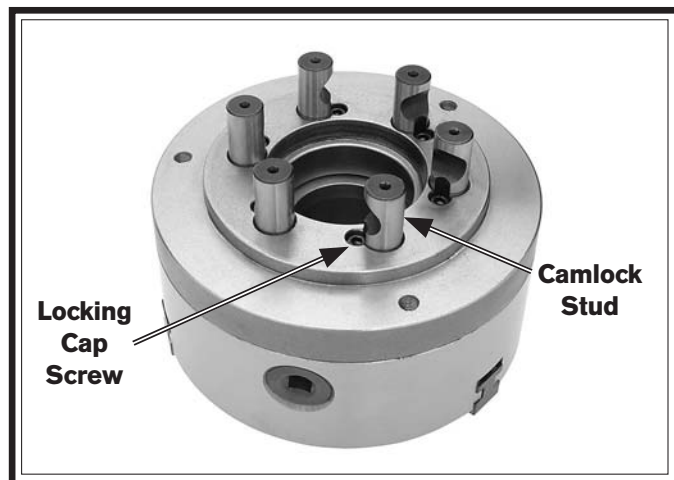


Figure 42. Chuck camlock studs and locking cap screws.

3. Thread each camlock stud into the chuck or faceplate until the depth mark shown in **Figure 43** is even with the surface of the chuck or faceplate and the curved indent on the side of the stud faces the locking cap screw hole, as illustrated in **Figure 44**. This is an initial adjustment.

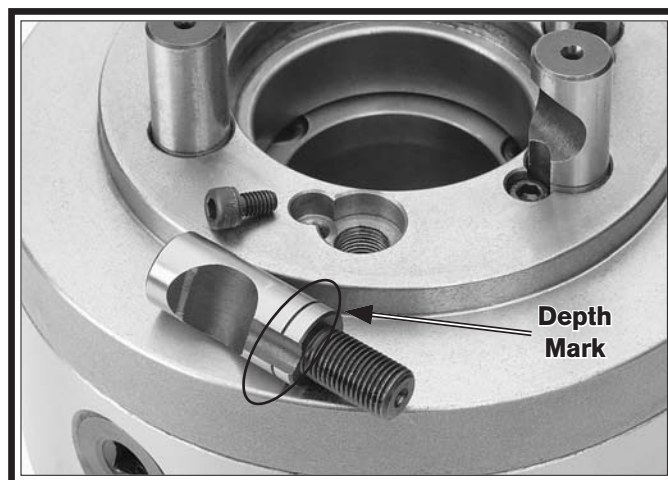


Figure 43. Camlock stud depth mark.

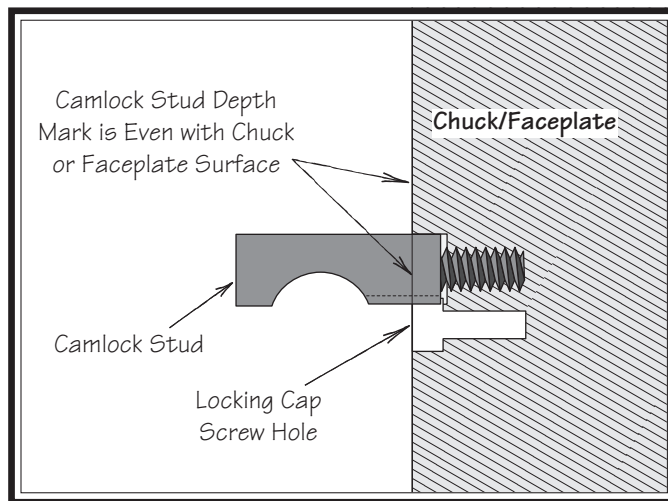
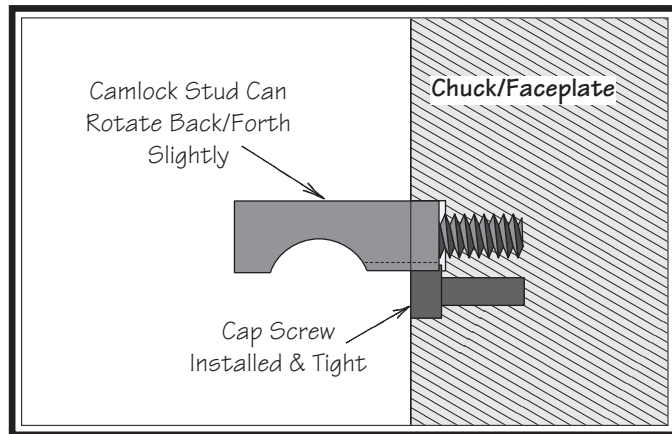


Figure 44. Initial adjustment of camlock stud.

4. Install and fully tighten the locking cap screws.

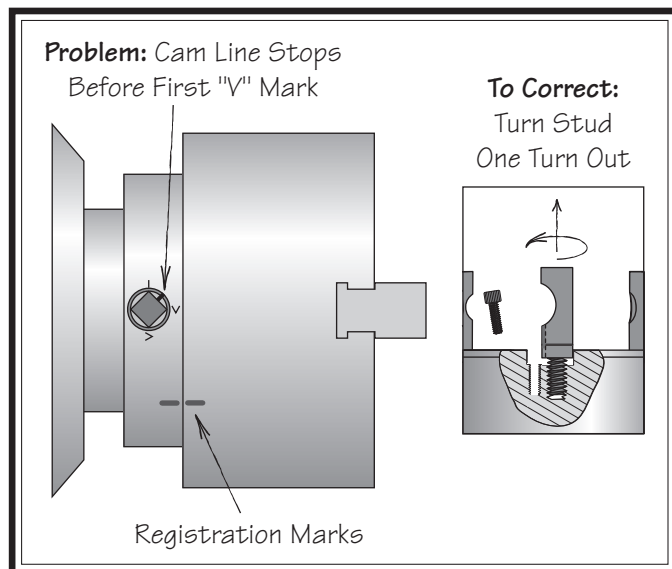
5. Make sure that the camlock studs can slightly rotate back and forth against the head of the locking cap screw (see **Figure 45**).



**Figure 45. Camlock stud and cap screw correctly installed.**

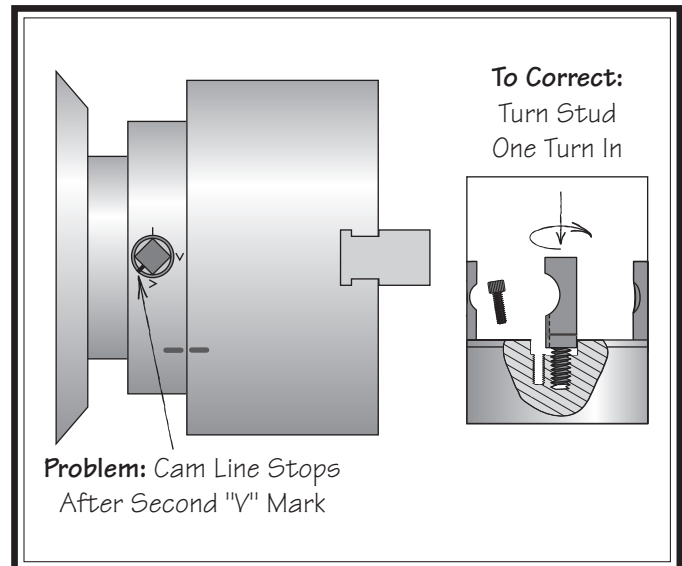
6. Install the chuck or faceplate onto the spindle and tighten the camlocks, as instructed in the **Mounting Chuck or Faceplate** subsection on **Page 32**. However, for this procedure fully tighten the locks in the second pass until they stop.

— If the cam line stops before the first "V" mark, the stud needs to be adjusted out by turning it counterclockwise one full turn (see **Figure 46**).



**Figure 46. Adjusting camlock stud out.**

- If the cam line stops after the second "V" mark, the stud needs to be adjusted in by turning it clockwise one full turn (see **Figure 47**).



**Figure 47. Adjusting camlock stud in.**

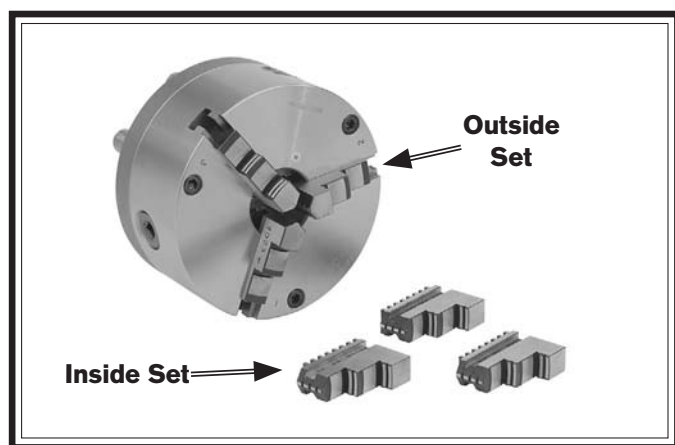
7. When you are satisfied that all the camlock studs are properly adjusted, make unique registration marks for that chuck or faceplate.

## 3-Jaw Chuck

Refer to the **Mounting Chuck or Faceplate** instructions on **Page 32** to mount the 3-jaw chuck to the spindle.

The 3-jaw scroll-type chuck included with this lathe features hardened steel jaws that move in unison to center a concentric workpiece.

There are two jaw sets provided—inside and outside (see **Figure 48**). The outside set holds the workpiece from the outside diameter, and the inside set centers the workpiece from the walls of an interior cavity.



**Figure 48. 3-jaw sets.**

## Changing Jaw Set

### Items Needed

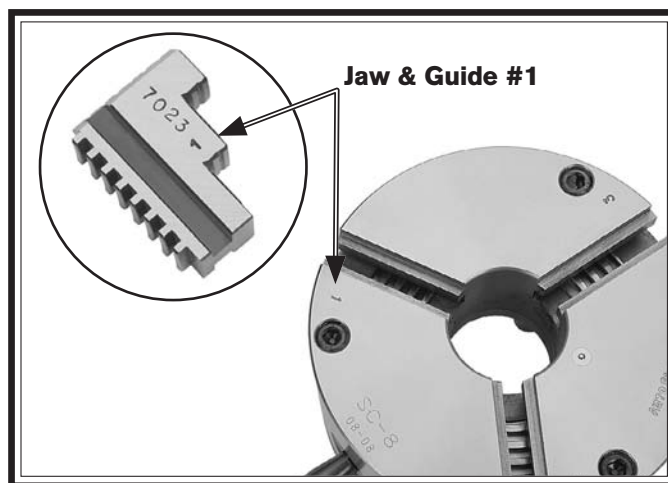
	Qty
Chuck Key .....	1
White Lithium Grease .....	As Needed

### To change the jaw set:

1. DISCONNECT LATHE FROM POWER!
2. Place a piece of wood over the ways to protect them from potential damage.
3. Insert the chuck key and turn it counterclockwise to back the jaws out and remove them.
4. Use mineral spirits to clean the debris and grime from the jaws and the jaw guides of the chuck.

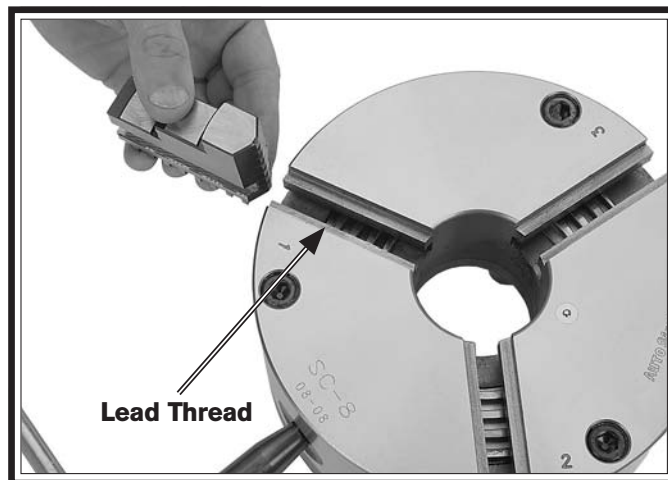
5. Apply a thin coat of white lithium grease to the surfaces of the removed jaw set, then store them in a safe place free of moisture and abrasives.

**Note:** The jaws and the jaw guides are numbered 1–3 (see **Figure 49**). Because the jaws are machined to close tolerances, they must be matched with the corresponding jaw guide by its number for a correct fit.



**Figure 49. Jaw and guide numbers.**

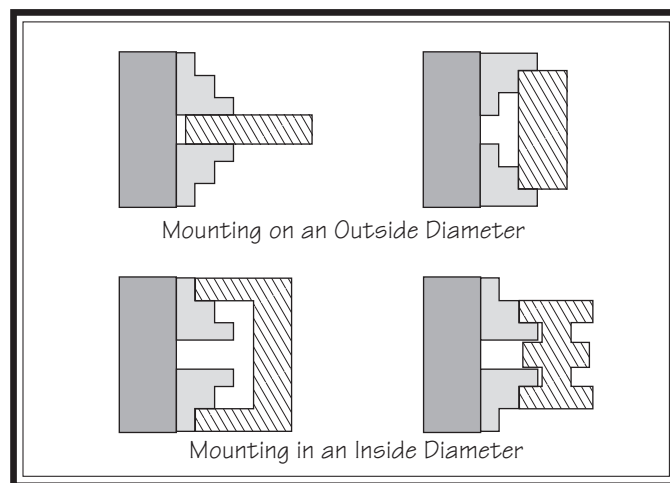
6. Rotate the chuck key clockwise until you see the tip of the scroll gear lead thread just begin to enter jaw guide #1 (see **Figure 50**).



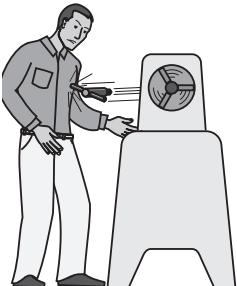
**Figure 50. Inserting jaw into guide #1.**

7. Insert jaw #1 into jaw guide #1 and hold the jaw against the scroll gear lead thread.
8. Rotate the chuck key clockwise one turn to engage the tip of the scroll gear lead thread into the jaw. Pull on the jaw—now it should be locked into the jaw guide.
  - If the jaw comes loose when you pull on it, correctly re-position the scroll gear lead thread and repeat **Steps 7–8**.
9. Repeat **Steps 6–8** with jaw #2, then jaw #3.
10. Rotate the chuck key clockwise until all the jaws come together in the center.
  - If the jaws meet evenly in the center of the chuck, they are installed properly.
  - If all the jaws do not come together evenly, then remove them and repeat this procedure until they do.

3. Open the jaws until the workpiece fits flat on the chuck face, the jaw steps, or into the spindle opening.
4. With help from another person or a holding device to support the workpiece, tighten the jaws until they make contact with the workpiece and it is centered. See **Figure 51** for examples of mounting a workpiece in a 3-jaw chuck.



**Figure 51. Examples of 3-jaw chuck mounting methods.**



⚠ **WARNING**

Securely mount the workpiece and remove the chuck key! Objects thrown from the lathe could cause death or serious personal injury to the operator or bystanders many feet away.

## Mounting Workpiece

Items Needed	Qty
Chuck Key .....	1
Chuck Cradle or Plywood 3/4" .....	1

### To mount a workpiece in the 3-jaw chuck:

1. DISCONNECT LATHE FROM POWER!
2. Place a chuck cradle or piece of plywood on the bedway below the chuck to protect the bedway surfaces.

5. Rotate the chuck by hand to make sure the workpiece makes even contact with all three jaws and spins evenly without any visible wobble.
  - If the workpiece is not held evenly or is off-center, repeat **Steps 3–5**.
6. After verifying that the workpiece is properly centered, fully tighten the jaws to make sure the workpiece is held securely, so it will not come loose during operation.

## 4-Jaw Chuck

Refer to the **Mounting Chuck or Faceplate** instructions on **Page 32** to mount the 4-jaw chuck to the spindle.

The 4-jaw chuck features independently adjustable hardened steel jaws for holding non-concentric or off-center workpieces. Each jaw can be independently removed from the chuck body and reversed for a wide range of work holding versatility.

### **⚠ WARNING**

**Because of the dynamic forces involved in machining a non-concentric or off-center workpiece, always use a low spindle speed to prevent the workpiece from breaking loose and being thrown from the lathe, which could cause death or serious personal injury.**

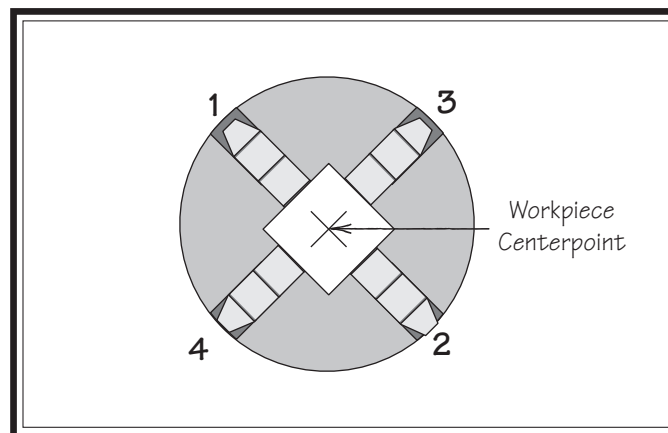
## Mounting Workpiece

Items Needed	Qty
Chuck Key .....	1
Chuck Cradle or Plywood 3/4" .....	1

### To mount a workpiece on the 4-jaw chuck:

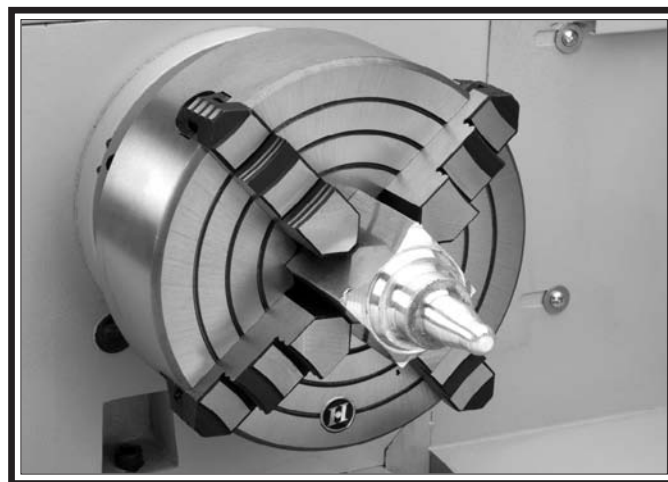
1. DISCONNECT LATHE FROM POWER!
2. Place a chuck cradle or plywood on the bedway below the chuck to protect the bedway surfaces.
3. Use the chuck key to open each jaw so the workpiece will lay flat against the chuck face, jaw steps, or into the spindle opening.
4. With the help from another person or a holding device, position the workpiece so it is centered in the chuck.

5. Tighten each jaw in small increments. After you have adjusted the first jaw, continue tightening in an opposing sequence, as shown in **Figure 52**.



**Figure 52. 4-jaw tightening sequence.**

6. After the workpiece is held in place by the jaws, turn the chuck by hand and pay attention to the workpiece alignment.
  - If the workpiece is not correctly aligned for your operation as you turn the chuck, make fine adjustments by slightly loosening one jaw and tightening the opposing jaw until the workpiece is correctly aligned (see **Figure 53** for an example).



**Figure 53. Example of non-concentric workpiece correctly mounted on the 4-jaw chuck.**

## Faceplate

Refer to the **Mounting Chuck or Faceplate** instructions on **Page 32** to mount the faceplate to the spindle.

The 12" faceplate included with your lathe offers a wide range of uses, including machining non-concentric workpieces, straight turning between centers, off-center turning, and boring.

The tools needed for mounting a workpiece will vary depending on the type of setup you have.

### **⚠️ WARNING**

**Machining non-concentric workpieces at a high speed could cause the workpiece to be thrown from the spindle with deadly force at the operator or bystanders. To reduce this risk, only machine non-concentric workpieces at low speeds and clamp counter-weights to the faceplate to balance it.**

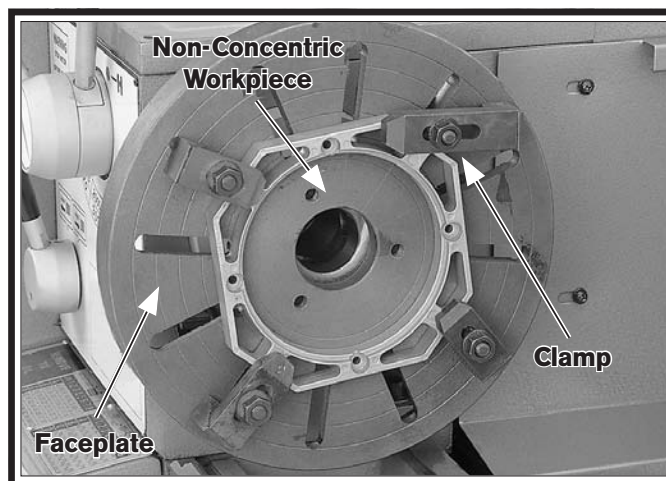
### **⚠️ WARNING**

**Failure to properly secure a workpiece to the faceplate could cause the workpiece to be thrown from the lathe with deadly force at the operator or bystanders. Use a minimum of **THREE** independent clamping devices to hold a non-concentric workpiece onto the faceplate.**

**To mount a non-concentric workpiece to the faceplate:**

- 1. DISCONNECT LATHE FROM POWER!**
- Protect the bedway with a piece of plywood.
- With the help from another person or a holding device to support the workpiece, position it onto the faceplate and clamp it in place with a minimum of three independent clamping devices (see **Figure 54** for an examples).

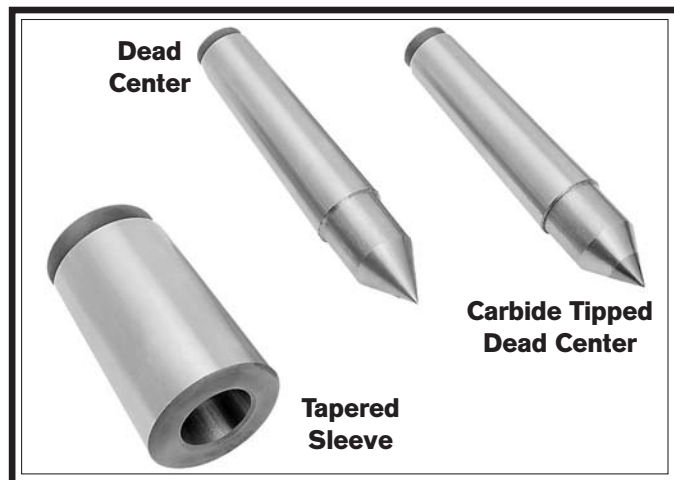
Be sure to take into account the rotational and cutting forces that will be applied to the workpiece when clamping it to the faceplate. If necessary, use counter-weights to balance the assembly.



**Figure 54. Example of workpiece clamped in a faceplate.**

## Centers

**Figure 55** shows the MT#3 dead centers included with the lathe. In addition, an MT#5-MT#3 tapered spindle sleeve is included for mounting centers in the spindle.



**Figure 55.** Tapered sleeve and dead centers.

### Dead Centers

A dead center is a one-piece center that does not rotate with the workpiece and is used to support long, slender workpieces.

Use the dead center in the spindle, where the workpiece rotates with the center and does not generate friction.

The carbide-tipped dead center can better withstand the effects of friction. Use this dead center in the tailstock where the workpiece will rotate against it and generate friction. The tip of the center must be generously lubricated with an anti-seize oil to avoid premature wear and maximize smooth operation. Using low spindle speeds will also reduce the heat and wear from friction.

### Live Centers

Although the dead center achieves a more accurate finished product, it requires low spindle speeds to avoid excessive heat from friction that could damage the center or workpiece. The live center has bearings that allow the center tip to rotate with the workpiece, and is installed in the tailstock quill for higher speeds, but with a slight bit of accuracy loss.

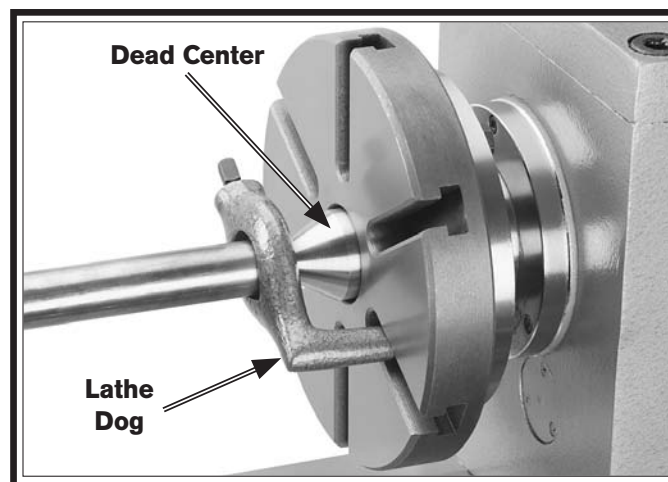
### Mounting Dead Center in Spindle

1. DISCONNECT LATHE FROM POWER!
2. Thoroughly clean and dry the tapered mating surfaces of the spindle bore, tapered sleeve, and the center, making sure that no lint or oil remains on the tapers.

**Note:** This will prevent the tapered surfaces seizing from operational pressures, which could make it very difficult to remove the center.

3. Mount a chuck or faceplate onto the spindle, whichever is correct for your operation.
4. Insert the center into the sleeve, then insert the sleeve into the spindle bore through the chuck or faceplate.

**Figure 56** shows an example of the dead center installed in the spindle, using a lathe dog and faceplate for turning between centers.



**Figure 56.** Example of using a dead center with a faceplate and lathe dog.

## Removing Center from Spindle

To remove the sleeve and center from the spindle, insert a piece of round bar stock or similar tool through the outboard end (on the left side of the headstock), then tap the sleeve loose.

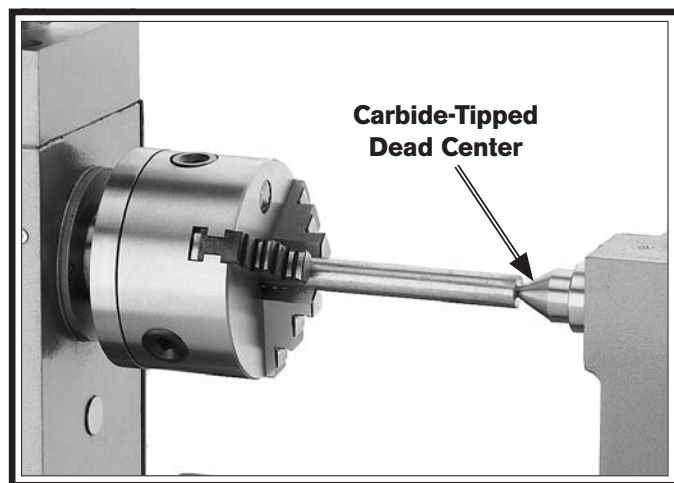
Hold onto the sleeve and center with a gloved hand or shop rag as you tap them loose to avoid dropping them and damaging the tip of the center or the bedways.

### NOTICE

**To avoid premature wear of the dead center or damage to the workpiece, use low spindle speeds and keep the tip of the dead center mounted in the tailstock well lubricated.**

## Mounting Center in Tailstock

Either a carbide-tipped dead center or live center can be used in the tailstock. Mounting instructions are the same for both. **Figure 57** shows an example of a dead center mounted in a tailstock.



**Figure 57.** Example of using a carbide-tipped dead center installed in the tailstock.

## To mount a center in the tailstock:

1. DISCONNECT LATHE FROM POWER!
2. Thoroughly clean and dry the tapered mating surfaces of the tailstock quill bore and the center, making sure that no lint or oil remains on the tapers.
3. Use the tailstock handwheel to feed the quill out from the casting approximately 1".

**Note:** Do not extend the quill more than 2" or stability and accuracy will be reduced.

4. Insert the center into the tailstock quill with a quick and firm motion.

## Removing Center from Tailstock

To remove the center from the quill, hold onto it with a gloved hand or shop rag, then rotate the tailstock handwheel counterclockwise to draw the quill back into the casting until the center releases.

If the center does not come loose by retracting the quill, extend the quill and use a drift key in the slot shown in **Figure 58** to remove the center.



**Figure 58.** Drift key slot in the side of the quill.

## Mounting Workpiece Between Centers

1. DISCONNECT LATHE FROM POWER!
2. Drill center holes in both ends of the workpiece.
3. Install a dead center in the spindle with a lathe dog and chuck or faceplate, then install a live center or carbide-tipped dead center in the tailstock.
4. Lubricate the workpiece center holes with anti-seize oil, then mount the workpiece on the centers and hold it in place with light pressure from the tailstock center.
5. Seat the center firmly into the quill by rotating the tailstock handwheel clockwise to apply pressure against the workpiece (see the example in **Figure 59**).

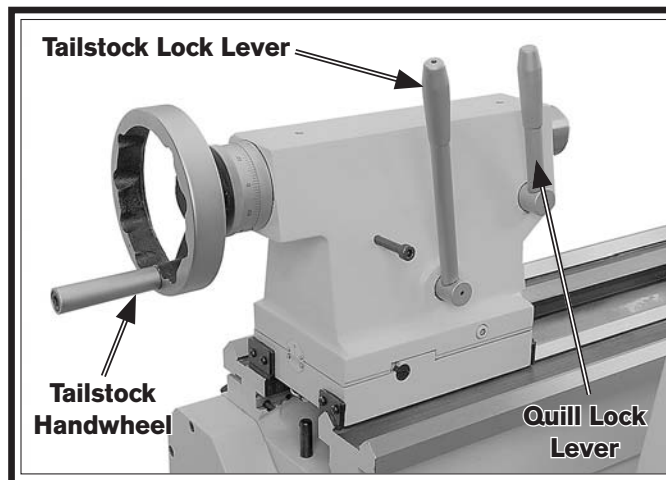
Only apply enough pressure to securely mount the workpiece between centers. Avoid over-tightening the center against the workpiece, or it may become difficult to remove later. Also, over-tightening will result in excessive friction and heat, which may damage the workpiece or center.



**Figure 59.** Example of a workpiece mounted between the centers.

## Tailstock

The tailstock (see **Figure 60**) can be used to support workpieces with the use of centers. It can also be used to drill or bore holes, or cut shallow tapers by using the offset adjustment.



**Figure 60.** Tailstock and quill lock levers in locked position.

## Positioning Tailstock

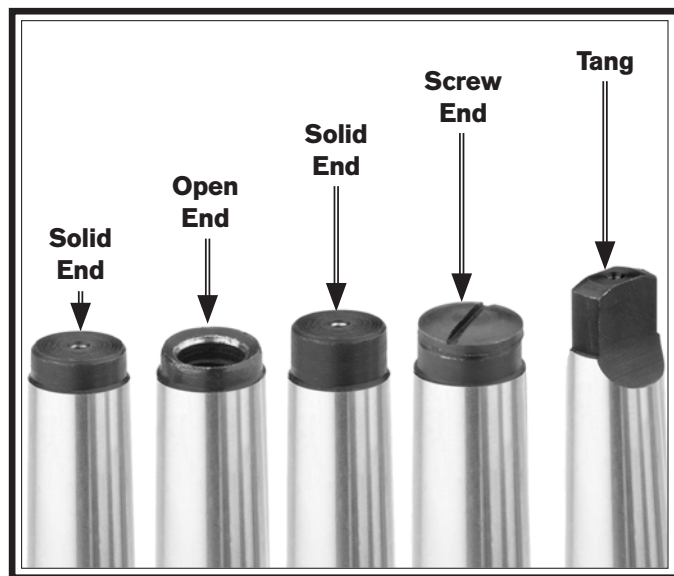
1. Pull the tailstock lock lever backward (away from the spindle) to unlock the tailstock from the bedway.
2. Slide the tailstock to the desired position.
3. Push the tailstock lock lever forward (toward the spindle) to lock the tailstock to the bedway.

## Using Quill

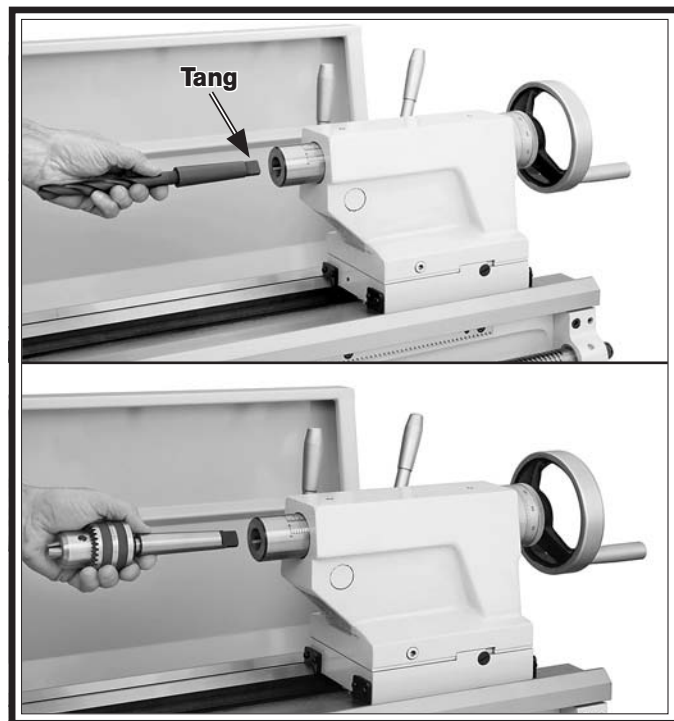
1. Release the quill lock lever.
2. Turn the tailstock handwheel clockwise to move the quill toward the spindle or counterclockwise to move it away from it.
3. Push the quill lock forward to lock the quill in place.

## Installing Tooling

This tailstock uses a quill with an MT#3 taper that has a lock slot in the back of the bore that accepts lock tang arbors and drill bits (see **Figures 61– 62** for examples).



**Figure 61. Types of tapered arbors and tooling.**



**Figure 62. Inserting MT#3 tools with lock tangs into the tailstock.**

However, other tooling without lock tangs, such as the four remaining tools shown in **Figure 61**, can still be used if the potential load will not override the strength of the MT#3 tapered fit. For example, smaller drill chucks, drill bits, and centers.

If the tooling has an open hole in the end but is too short to be exposed in the drift slot for removal, then a screw can be threaded into the end of the tool to provide a solid surface for the quill pin to push against when the quill is retracted for tool removal.

### To install tooling in the tailstock:

1. With the tailstock locked in place, unlock the quill, then use the handwheel to extend it approximately 1".
  2. Thoroughly clean and dry the tapered mating surfaces of the quill and the center, making sure that no lint or oil remains on the tapers.
- Note:** This will prevent the tapered surfaces seizing from operational pressures, which could make it very difficult to remove the tool.
3. If the tapered tool shaft has a tang, align it horizontally with the indent in the back of the quill before inserting it.
  4. With a firm and quick motion, insert the tool into the quill. Check to see if it is firmly seated by attempting to twist it—a firmly seated tool will not twist.

5. Unlock the tailstock and move it until the tip of the tool is close to, but not touching, the workpiece, then re-lock the tailstock.
6. Start spindle rotation, unlock the quill, then turn the tailstock handwheel clockwise to feed the tool into the workpiece.

## Removing Tooling

1. Use a shop rag to hold the tool.
2. Rotate the tailstock handwheel counterclockwise until the tool is forced out of the quill.

— If the tool does not come loose by retracting the quill, extend the quill and use a drift key in the slot shown in **Figure 63** to remove the tool.

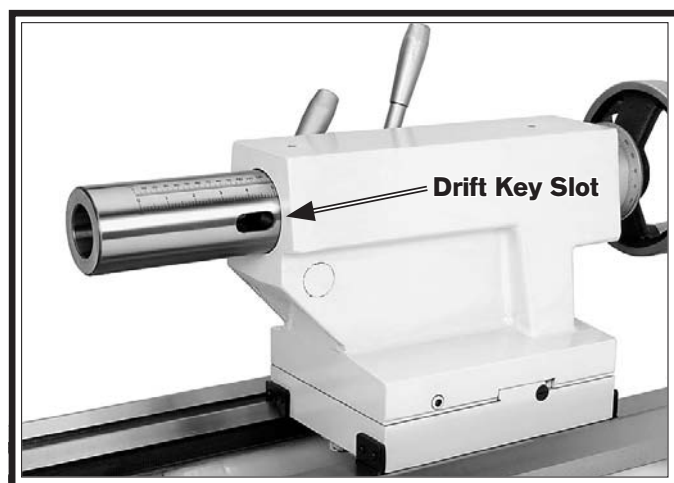


Figure 63. Drift key slot in the side of the quill.

## Offsetting Tailstock

The tailstock can be offset from the spindle centerline for turning tapers. Move the tailstock top casting toward the operator from the spindle centerline to make the workpiece smaller at the tailstock end. Conversely, position the tailstock top casting away from the operator from the centerline to machine a taper near the spindle end (see the illustration in **Figure 64**).

**Note:** The marks on the offset indicator are arbitrary. For a precise offset, use a dial indicator to check quill movement while adjusting the screws.

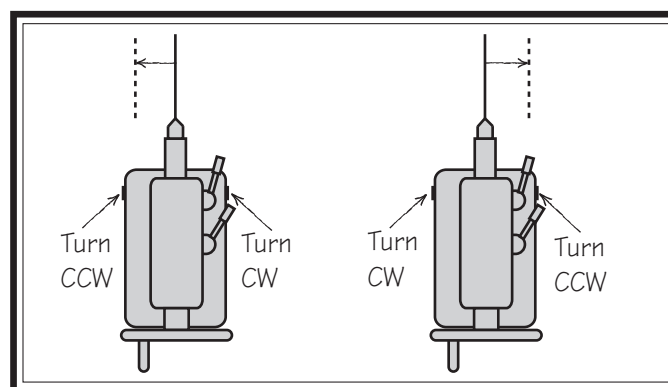


Figure 64. Set screw adjustment in relation to tailstock movement.

### Tools Needed

	<b>Qty</b>
Hex Wrench 6mm .....	1
Wrench 17mm .....	1

### To offset the tailstock:

1. Loosen the hex bolts underneath both ends of the tailstock to release the clamping pressure between the top and bottom castings (see **Figure 65**).

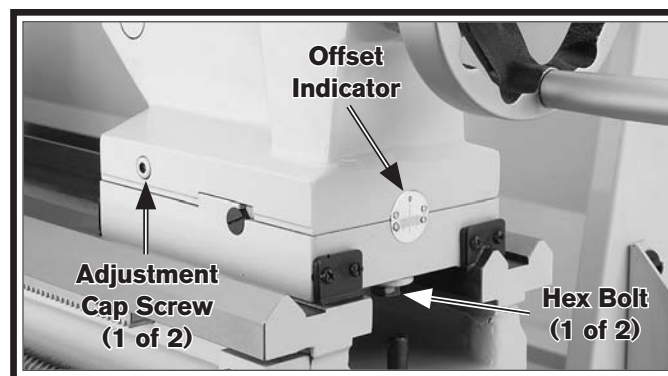


Figure 65. Tailstock offset controls.

2. Rotate the adjustment cap screws in opposite directions for the desired offset (see the illustration in **Figure 64**).
3. Retighten the clamping hex bolts underneath the tailstock to secure the offset.
3. Use the other piece of round stock to make a dead center, and turn it to a 60° point, as illustrated in **Figure 66**.

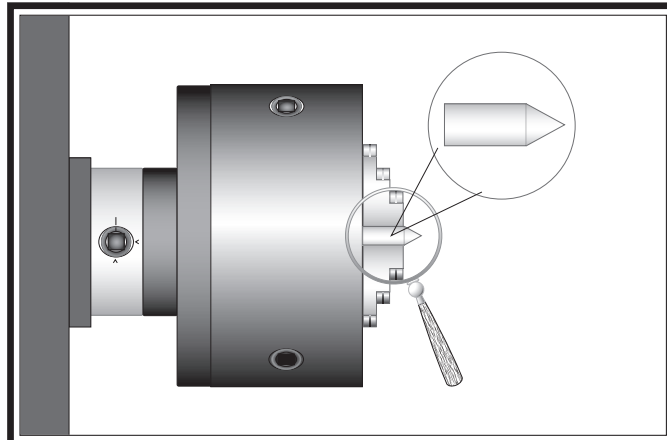
## Aligning Tailstock To Spindle Centerline

The tailstock was aligned to the spindle centerline at the factory. However, we recommend that you take the time to ensure that the tailstock is properly aligned to your own desired tolerances, especially if you have changed the offset to cut tapers.

Items Needed	Qty
Hex Wrench 6mm .....	1
Wrench 17mm .....	1
Round Stock 2" x 6" .....	2
Precision Level .....	1

### To align the tailstock offset to the spindle centerline:

1. Use the precision level to make sure the bedway is level from side to side and from front to back.
  - If the bedway is not level, correct this condition before continuing with this procedure (refer to **Leveling & Mounting** on **Page 18**).
2. Center drill both ends of one piece of round stock, then set it aside for use in **Step 5**.



**Figure 66.** Turning a dead center.

**Note:** As long as this dead center remains in the chuck, the point of the center will remain true to the spindle centerline. The point will have to be refinished whenever the center is removed and then returned to the chuck.

4. Install a center in the tailstock.
5. Attach a lathe dog to the test stock from **Step 2**, then mount it between the centers (see **Figure 67** for an example).

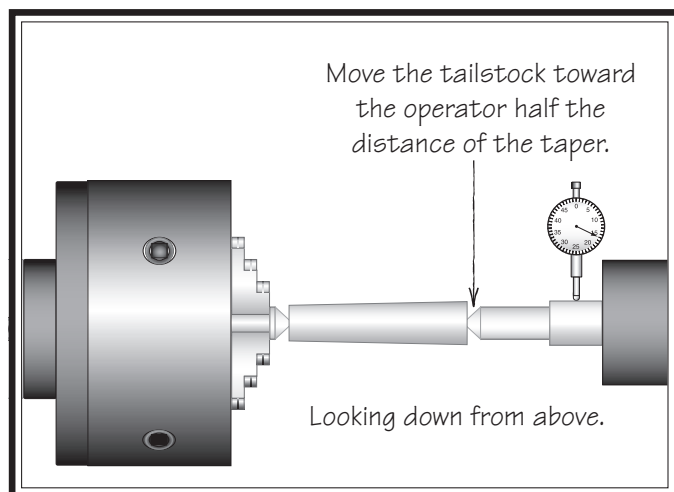


**Figure 67.** Example of stock mounted between the centers.

6. Turn 0.010" off the stock diameter.
7. Mount a test or dial indicator so that the plunger is on the tailstock quill.

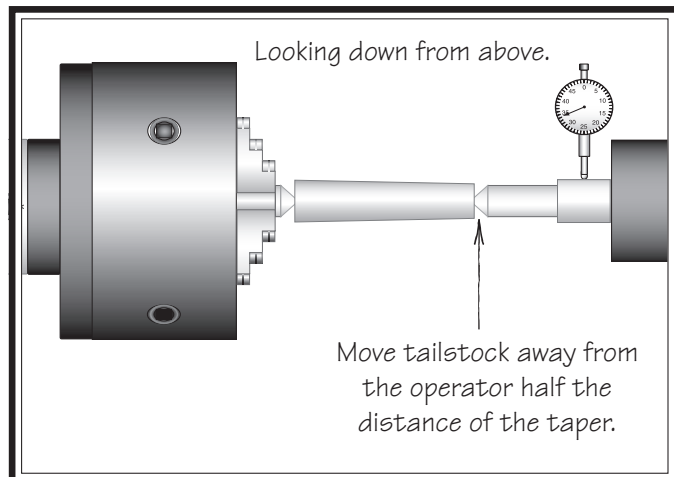
**Note:** If necessary in the following step, refer to **Offsetting Tailstock** on **Page 44** for detailed instructions.

8. Use calipers to measure both ends of the workpiece.
  - If the test stock is *thicker* at the tailstock end, move the tailstock *toward* the operator  $\frac{1}{2}$  the distance of the amount of taper (see **Figure 68**).



**Figure 68. Adjust tailstock toward the operator.**

- If the test stock is *thinner* at the tailstock end, move the tailstock *away* from the operator  $\frac{1}{2}$  the distance of the amount of taper (see **Figure 69**).



**Figure 69. Adjust tailstock away from the operator.**

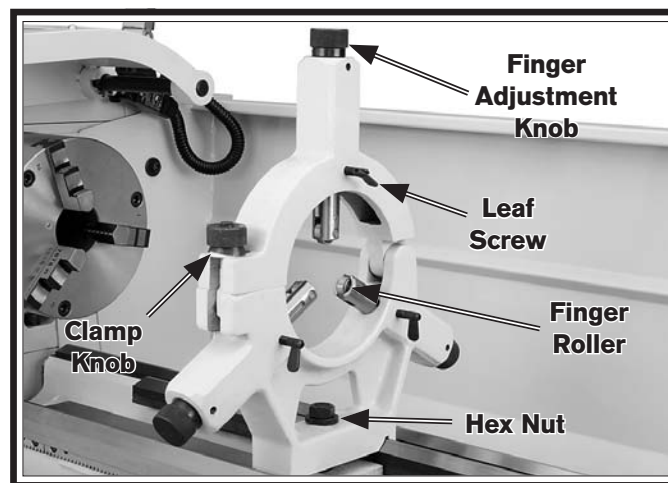
9. Repeat **Steps 6–8** until the desired accuracy is achieved.

## Steady Rest

The steady rest supports long shafts and can be mounted anywhere along the length of the bedway.

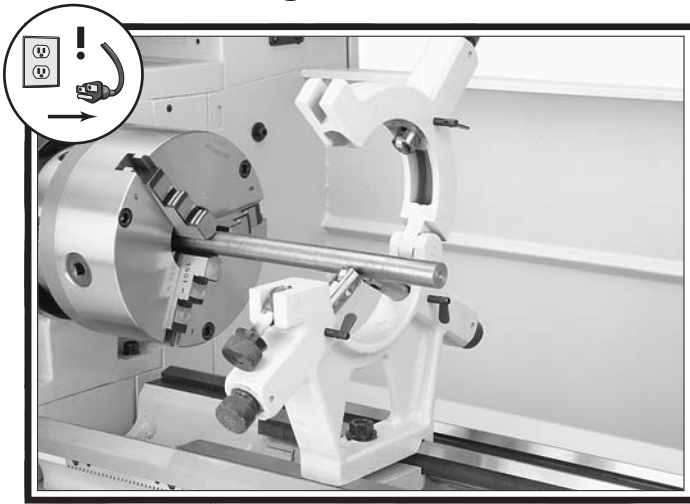
### To install and use the steady rest:

1. **DISCONNECT LATHE FROM POWER!**
2. Thoroughly clean the machined base of the steady rest so that it will sit evenly on the bedway, then place it on the lathe bedways so the triangular notch fits over the bedway prism.
3. Position the steady rest where required to properly support the workpiece, then tighten the hex nut shown in **Figure 70** to secure it in place.



**Figure 70. Steady rest components.**

- Loosen the clamp knob that secures the two halves of the rest and open the steady rest, as shown in **Figure 71**.



**Figure 71. Workpiece mounted in the steady rest.**

- Loosen the three leaf screws so the finger roller positions can be adjusted.
- Use the finger adjustment knobs to position the bottom two finger rollers so that the workpiece can rest on them in a straight line with the spindle, as shown in the example of **Figure 71**.
- Close the steady rest, then use the finger adjustment knobs to adjust all three finger rollers so that they just touch the workpiece without causing deflection.

**Note:** The finger rollers should properly support the workpiece along the spindle centerline but allow it to freely rotate.

- Tighten the three leaf screws to secure the settings.

## Follow Rest

The follow rest mounts to the saddle with two cap screws (see **Figure 72**). It is used on long, slender parts to prevent workpiece deflection from the pressure of the cutting tool during operation. Adjust the follow rest fingers in the same manner as the rollers on the steady rest.

**Note:** To reduce the effects of friction, lubricate the brass finger tips with an anti-seize oil during operation.

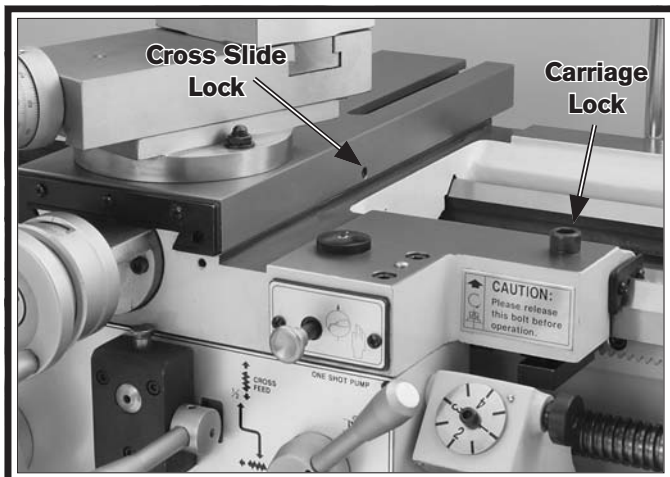


**Figure 72. Follow rest attachment.**

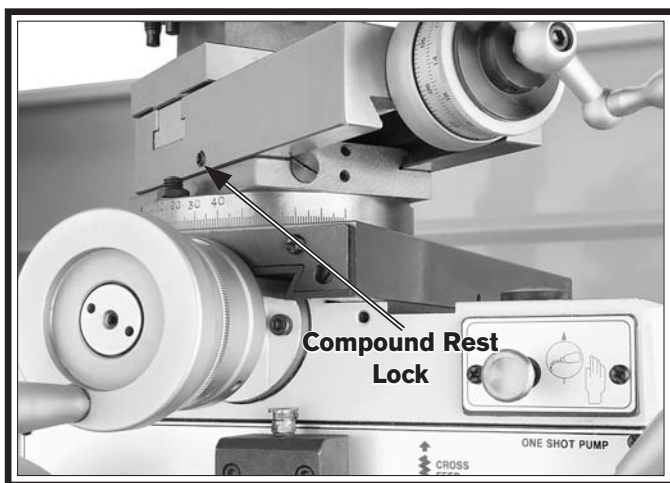
## Carriage & Slide Locks Compound Rest

The carriage, cross slide, and compound rest have locks that can be tightened to provide additional rigidity during operation, especially during heavy cuts.

See **Figures 73–74** to identify the locations of the locks for each device.



**Figure 73.** Location of carriage and cross slide locks.



**Figure 74.** Location of compound rest lock.

The compound rest handwheel has an indirect-read graduated scale. This means that the distance shown on the scale represents the actual distance the tool moves, which removes twice that amount of material from the diameter of the workpiece. The base of the compound rest has another graduated scale used for setting the tool to a specific angle.

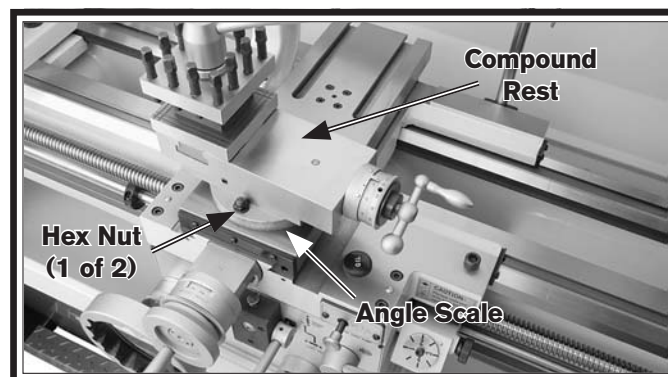
### Tool Needed

Wrench 14mm ..... 1

### Qty

### To set the compound rest at a certain angle:

1. Loosen the two hex nuts at the base of the compound rest (1 of 2 shown in **Figure 75**).



**Figure 75.** Compound rest.

2. Rotate the rest to the desired angle, as indicated by the scale at the base, then retighten the two hex nuts.

**Tip:** If setting up to cut external right-hand inch or metric threads, or internal left-hand threads for the first time, set the compound rest so its travel is perfectly parallel with the cross slide. Using a protractor, rotate the compound 29.5° counterclockwise and mark the new location on the cross slide. This mark will be the quick reference point for setting the offset angle. To mark for internal right-hand threads, or external left-hand threads, repeat this process, but rotate the rest 29.5° clockwise and mark the cross slide accordingly.

## Four-Way Tool Post

The four-way tool post is mounted on top of the compound rest and allows a maximum of four tools to be loaded simultaneously.

The four-way tool post is used to quickly index different tools to the workpiece, which is accomplished by loosening the top handle, rotating the tool post to the desired position, then retightening the handle to lock the tool into position.

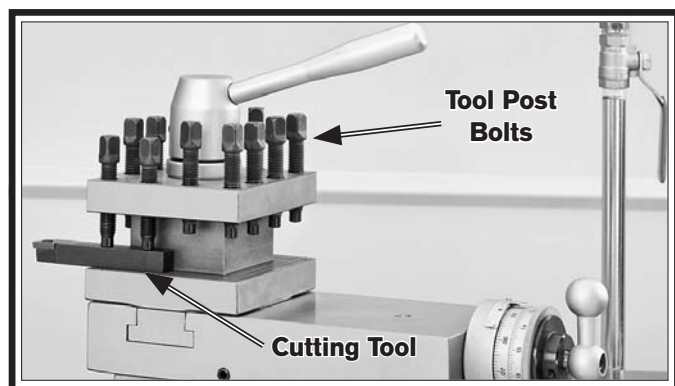
### Installing Tool

#### Tool Needed

Tool Post T-Wrench..... Qty  
Tool Post T-Wrench..... 1

#### To load the tool post:

1. Loosen the tool post bolts so that the cutting tool can fit underneath them (see **Figure 76**).



**Figure 76.** Example of tool mounted in tool post.

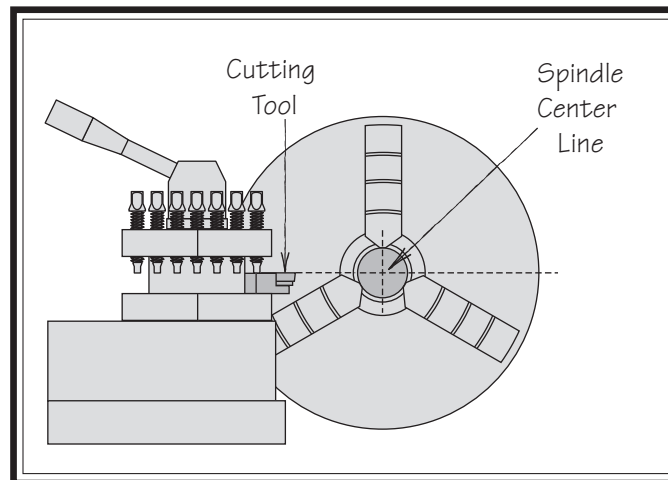
## ⚠ WARNING

**Over-extending a cutting tool from the tool post will increase the risk of it breaking during operation, which may cause metal pieces to be thrown at the operator or bystanders with great force. Only extend a cutting tool 2.5 times the width of its cross-section or less (e.g, 2.5 x 0.5" = 1.25").**

2. Firmly secure the cutting tool with at least two tool post bolts.
3. Check and adjust the cutting tool to the spindle centerline, as instructed in the next subsection.

## Aligning Cutting Tool with Spindle Centerline

For most operations, the cutting tool tip should be aligned with the spindle centerline, as illustrated in **Figure 77**.



**Figure 77.** Cutting tool aligned with spindle centerline (viewed from tailstock).

There are a number of ways to check and align the cutting tool to the spindle centerline. If necessary, use steel shims underneath the cutting tool to raise it. The shims should be as long and as wide as the cutting tool to properly support it.

#### Below are two common methods:

- Align the tip of the cutting tool with a center installed in the tailstock, as instructed on the next page. For this to work, the tailstock must be aligned to the spindle centerline (refer to **Aligning Tailstock To Spindle Centerline** on **Page 45** for detailed instructions).
- Make a facing cut on a piece of round bar stock. If the tool is above or below the spindle centerline, a nub will be left in the center of the workpiece. Adjust the height of the tool, then repeat the facing cut to check the adjustment. Repeat as necessary until the center of the workpiece face is smooth.

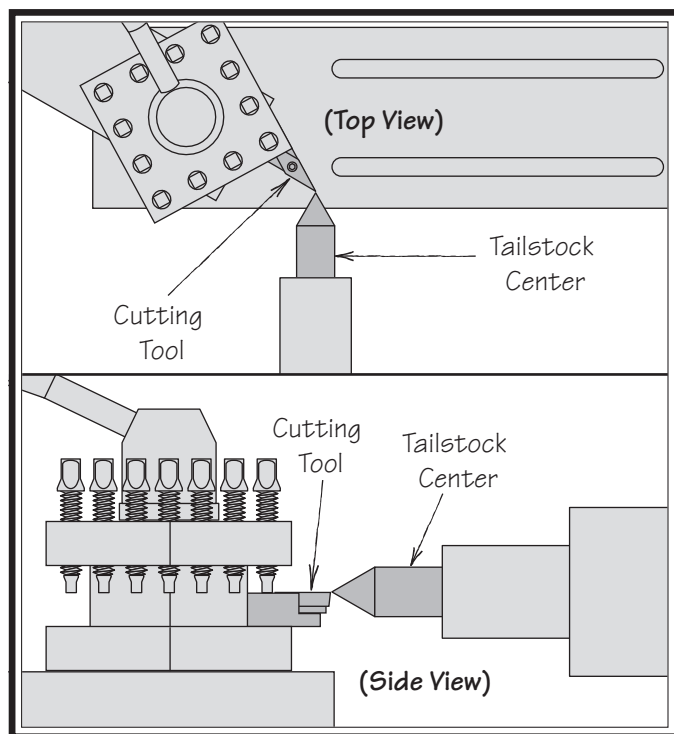
**Tools Needed**

	<b>Qty</b>
Tool Post T-Wrench.....	1
Steel Shims.....	As Needed
Cutting Tool.....	1
Fine Ruler.....	1
Tailstock Center.....	1

**To align the cutting tool with the tailstock center:**

1. Mount the cutting tool in the tool post, then secure the post so the tool faces the tailstock.
2. Install a center in the tailstock, and position the center tip near the cutting tool tip.
3. Lock the tailstock and quill in place.
4. Adjust the height of the cutting tool so that the tool tip is aligned vertically and horizontally with the center tip, as shown in **Figure 78**.

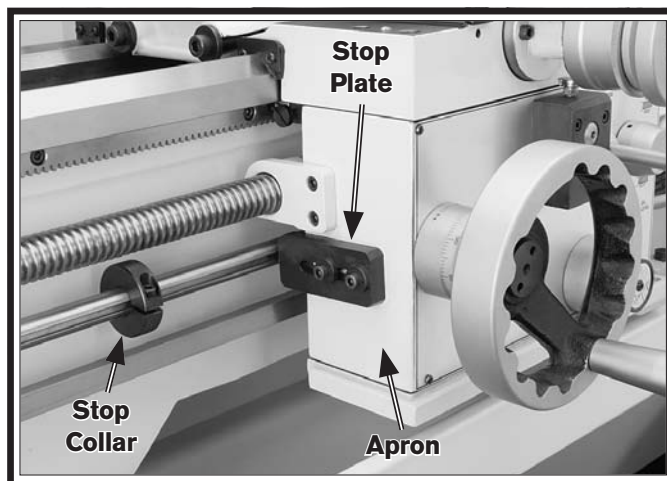
If necessary for vertical alignment, use steel shims that are equal to the length and width of the cutting tool.



**Figure 78. Cutting tool tip aligned with tailstock center.**

**Adjustable Feed Stop**

Use the adjustable feed stop collar (shown in **Figure 79**) to set the location where the carriage will be disengaged by the feedrod clutch. When the apron stop plate contacts the stop collar during a carriage feeding operation that uses the feedrod, the clutch disengages the feedrod and the carriage movement stops.



**Figure 79. Adjustable feedrod stop.**

**NOTICE**

The adjustable feed stop system is designed to stop longitudinal carriage movement at the desired location **ONLY** when the carriage is engaged with the feedrod. This uses the feedrod clutch to stop movement.

When the carriage is engaged with the leadscrew for threading operations, the adjustable feed stop system **WILL NOT** stop carriage movement—you must use the halfnut lever instead. Otherwise, the carriage can crash into the chuck, or if it contacts the stop, the leadscrew shear pin will break.

Before doing any threading operations, make sure to loosen the feed stop collar so it slides freely on the feedrod and will not interfere with carriage travel.

## Carriage Stop

Use the carriage stop as a guide to help judge when to stop carriage movement.

### NOTICE

The carriage stop on this lathe will **NOT** automatically stop the carriage during threading operations when the carriage is engaged with the leadscrew! Failure to heed this notice could result in the carriage crashing and causing severe machine or property damage.

Tools Needed	Qty
Hex Wrench 8mm .....	1

#### To adjust the carriage stop:

1. DISCONNECT LATHE FROM POWER!
2. Loosen the cap screws shown in **Figure 80**.

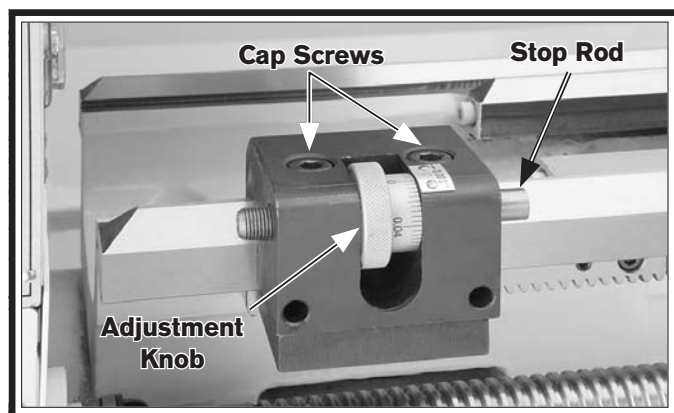


Figure 80. Carriage stop.

3. Use the carriage handwheel to position the carriage and cutting tool at the stop point that is right for your operation.
4. Use the adjustment knob to fine tune the position of the stop rod, then retighten the cap screws loosened in **Step 2**.
5. Move the carriage away from the stop rod, then move it back against the stop rod and verify that tooling will not make contact with chuck, jaws, or other components (rotate the chuck by hand to verify rotational clearance).

## Manual Feed

You can manually move the cutting tool around the lathe for facing or turning operations using the handwheels shown in **Figure 81** and described below.

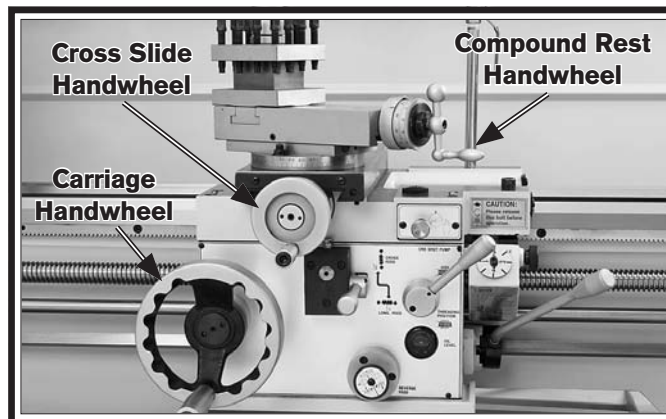


Figure 81. Carriage Controls.

### Carriage Handwheel

The carriage handwheel moves the carriage left or right along the bed. The graduated dial has 0.01" increments—one full revolution moves the carriage 0.80".

### Cross Slide Handwheel

The cross slide handwheel moves the tool toward and away from the work. Adjust the position of the graduated scale by holding the handwheel with one hand and turning the dial with the other. This slide has a direct dial, which means the amount read on the graduated dial is the total amount removed from the workpiece. The dial has 0.001" increments—one full revolution moves the slide 0.200".

### Compound Rest Handwheel

The compound rest handwheel controls the position of the cutting tool relative to the workpiece. The compound rest is adjustable for any angle within its range. Angle adjustment is secured by two nuts on the base of the compound. The graduated dial is an indirect dial, which means the workpiece amount removed is twice the amount read on the dial. The dial has 0.001" increments—one full revolution moves the slide 0.100".

## Spindle Speed

Using the correct spindle speed is important for safe and satisfactory results, as well as maximizing tool life.

To set the spindle speed for your operation, you will need to: 1) Determine the best spindle speed for the cutting task, and 2) configure the lathe controls to produce the required spindle speed.

### Determining Spindle Speed

Many variables affect the optimum spindle speed to use for any given operation, but the two most important are the recommended cutting speed for the workpiece material and the diameter of the workpiece, as noted in the formula shown in **Figure 82**.

<p>*Recommended Cutting Speed (FPM) x 12</p> <hr/> <p>Dia. of Cut (in inches) x 3.14</p> <p>= Spindle Speed (RPM)</p> <p>*Double if using carbide cutting tool</p>
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**Figure 82. Spindle speed formula for lathes.**

Cutting speed, typically defined in feet per minute (FPM), is the speed at which the edge of a tool moves across the material surface.

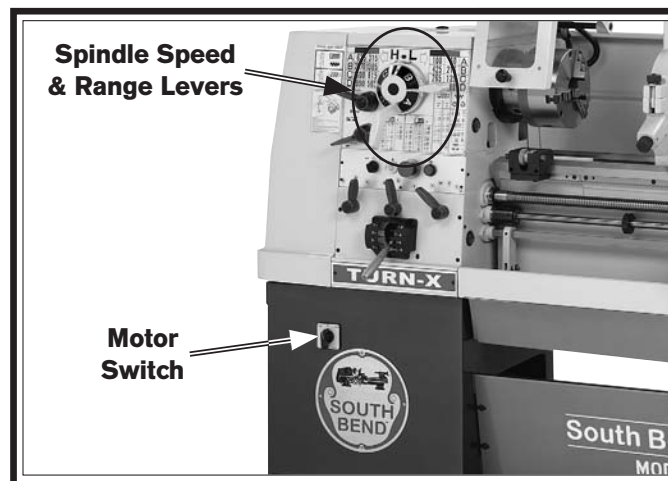
A recommended cutting speed is an ideal speed for cutting a type of material in order to produce the desired finish and optimize tool life.

The books **Machinery's Handbook** or **Machine Shop Practice**, and some internet sites, provide excellent recommendations for which cutting speeds to use when calculating the spindle speed. These sources also provide a wealth of additional information about the variables that affect cutting speed and they are a good educational resource.

Also, there are a large number of easy-to-use spindle speed calculators that can be found on the internet. All of these sources will help you take into account all the applicable variables in order to determine the best spindle speed for the operation.

## Setting Spindle Speed

Selecting one of the 16 spindle speeds available is a combination of configuring the two-speed motor switch, the spindle range lever, and the spindle speed lever shown in **Figure 83**.



**Figure 83. Spindle speed controls.**

The motor switch controls the speed of the spindle motor, either a low speed of 1725 RPM or a high speed of 3450 RPM.

The spindle speed and range levers control the gear configuration in the headstock to produce the selected spindle speed. The spindle range lever selects speeds in the left- or right-hand speed chart to be available for the spindle speed lever. The spindle speed lever selects one of the speeds available in the active chart and column.

## NOTICE

**If the spindle is rotating when attempting to change the spindle speed, the headstock gears will suffer damage! ALWAYS make sure the spindle is completely stopped BEFORE using the headstock control levers to make changes.**

## Configuration Examples

Using the controls on the lathe, follow along with these two examples for setting the spindle speed to gain a better understanding of this task on the Model SB1039.

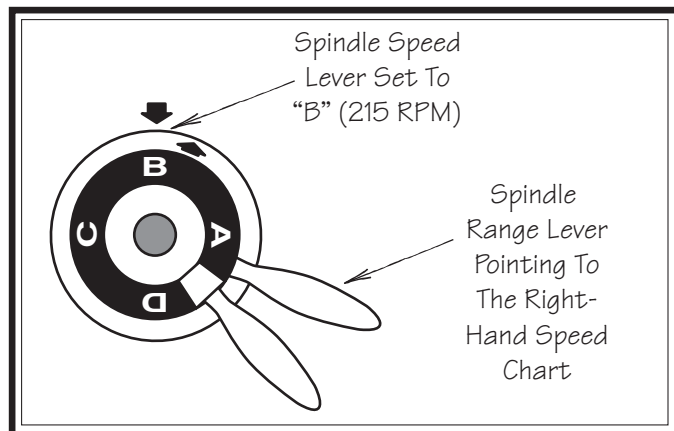
### Example 1: Spindle Speed of 215 RPM

1. Make sure the spindle is completely stopped and the spindle ON/OFF lever is in the OFF (middle) position.
2. Turn the motor switch (see **Figure 83**) to the low (left) position.

**Note:** The green color of the motor switch low position corresponds to the column in the right-hand speed chart with the green header that contains the speed of 215 RPM.

3. Move the spindle range lever to the right so that the arrow on top of its hub points toward the right-hand speed chart (see the illustrated in **Figure 84**).

**Note:** If necessary, use the chuck key to rock the spindle back-and-forth to help mesh the gears as you move the levers.



**Figure 84. Setting the spindle speed to 215 RPM.**

4. Position the spindle speed lever so that the "B" is directly under the arrow on the headstock.

**Note:** You will hear a distinctive "click" when the spindle speed lever is in the correct position.

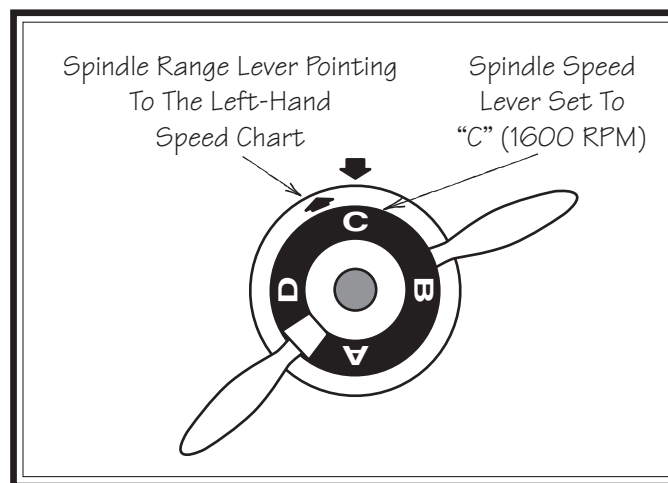
The lathe is now set for a spindle speed of 215 RPM.

### Example 2: Spindle Speed of 1600 RPM

1. Make sure the spindle is completely stopped and the spindle ON/OFF lever is in the OFF (middle) position.
2. Turn the motor switch to the high (right) position.

**Note:** The blue color of the motor switch high position corresponds to the column in the left-hand speed chart with the blue header that contains the speed of 1600 RPM.

3. Move the spindle range lever to the left so that the arrow on top of its hub points toward the left-hand speed chart (see the illustrated in **Figure 85**).



**Figure 85. Spindle speed set at 1600 RPM.**

4. Position the spindle speed lever so that the "C" is directly under the arrow on the headstock.

The lathe is now set for a spindle speed of 1600 RPM.

## Power Feed

On this lathe, both the carriage and cross slide have power feed capability when the carriage is engaged with the feedrod. The rate that these components move (feed rate) is controlled by how the levers are configured on the headstock and quick change gearbox, and the end gear arrangement.

Feed rate and spindle speed must be considered together. Keep in mind that the feed rate is expressed in the amount of travel per revolution of the spindle. The sources you use to determine the optimum spindle speed for an operation will also provide the optimal feed rate to use with that spindle speed.

Often, the experienced machinist will use the feeds and speeds given in their reference charts or web calculators as a starting point, then make minor adjustments to the feed rate (and sometimes spindle speed) to achieve the best results.

The carriage can alternately be driven by the leadscrew for threading operations. However, this section only covers the use of the power feed option for the carriage and cross slide components for non-threading operations. To learn how to power the carriage for threading operations, refer to the **Threading** subsection on **Page 59**.

## NOTICE

Even though there is a lock-out device in the apron to prevent the feed control lever and the halfnut lever from being engaged at the same time, this lock-out device could break with enough force. Attempting to engage these levers at the same time could cause severe lathe damage and will void the warranty.

## NOTICE

If the spindle is rotating when attempting to change the configuration of the headstock feed controls, the gears in the headstock and quick change gearbox will become damaged! **ALWAYS** make sure the spindle is completely stopped **BEFORE** using the headstock control levers to make changes.

## Power Feed Controls

Use **Figures 86–87** and the following descriptions to become familiar with the locations and functions of the controls that you will use to set up the correct power feed for your operation.

**Note:** Before using power feed, you may have to re-configure the end gears, depending on how they are set up. Refer to the **End Gears** subsection on **Page 57** for detailed instructions.

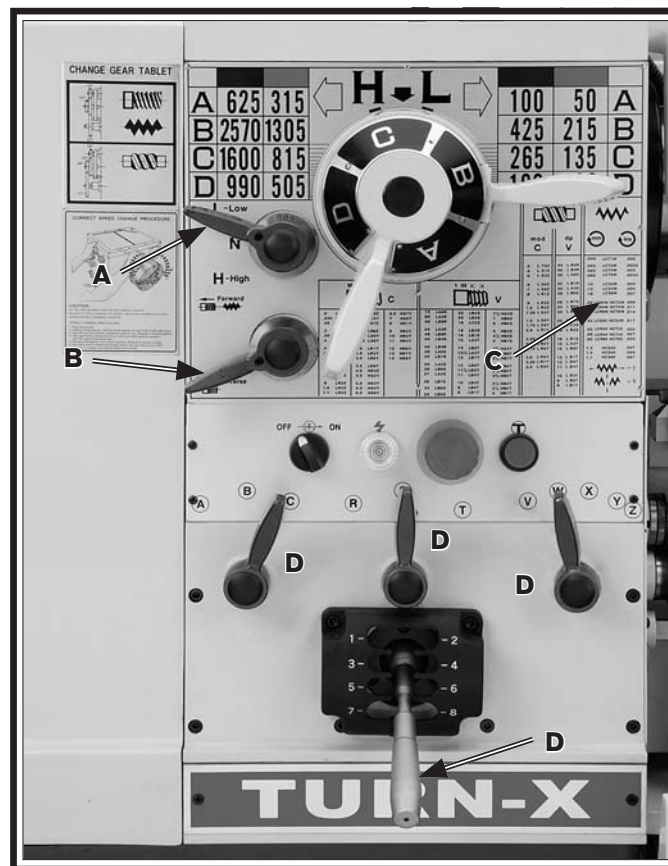


Figure 86. Power feed controls on the headstock.

**A. Feed Range Lever:** Selects the low or high feed rate range by re-aligning the headstock transfer gear. In the middle position, disables power feed.

**B. Feed Direction Lever:** When the lathe is stopped, selects the direction for power feed.

**Note:** When the lathe is running, use the quick change feed direction knob on the apron.

**C. Feed Rate Chart:** Displays the settings for the headstock and quick change gearbox controls for the selected feed rate. Refer to **Setting Feed Rate** subsection on the next page for detailed instructions.

**D. Quick Change Gearbox Feed Levers:** Configure the quick change gearbox gears for the feed rate selected.

— Left Lever Positions: A–C

— Middle Lever Positions: R–T

— Right Lever Positions: V–Z

— Bottom Lever Positions: 1–8

## NOTICE

Keep in mind that if spindle rotation is reversed, the power feed direction will also reverse. Always be aware of the actual direction of power feed during operation before engaging it.

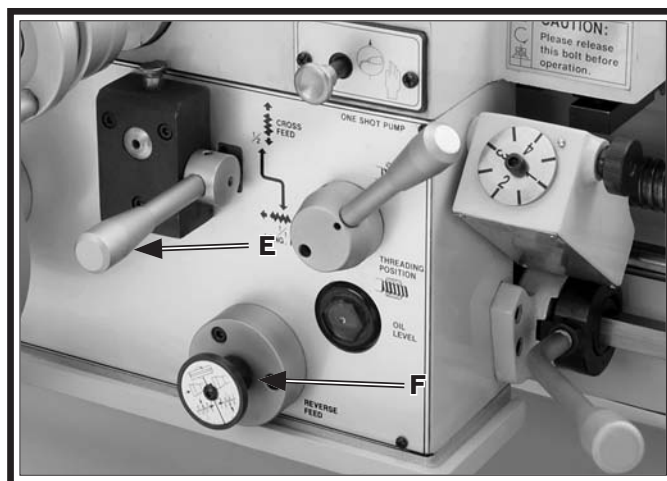


Figure 87. Apron power feed controls.

**E. Feed Control Lever:** Directs the power feed to either the cross slide or the carriage.

When the lever is down and the indent pin is pointing up, the cross slide is selected. Conversely, when the lever is up and the pin is pointing down, the carriage is selected.

In the middle position, the apron gears are disengaged from the feedrod and neither component will move.

**Note:** When using this lever, you may need to slightly rotate the handwheel of the component you are trying to engage, so that the apron gears can mesh.

**F. Quick Change Feed Direction Knob:** When the lathe is running, changes the feed direction.

The advantage of this knob is that you can quickly reverse power feed direction while the spindle is rotating—without having to turn the lathe off, waiting until the spindle is stopped, then using the feed direction lever on the headstock.

## NOTICE

Depending upon the combined configuration of the feed direction lever on the headstock and the quick change direction knob on the apron, the feed direction information printed on these devices may not be accurate. Always be aware of the actual direction of power feed before beginning the cutting operation.

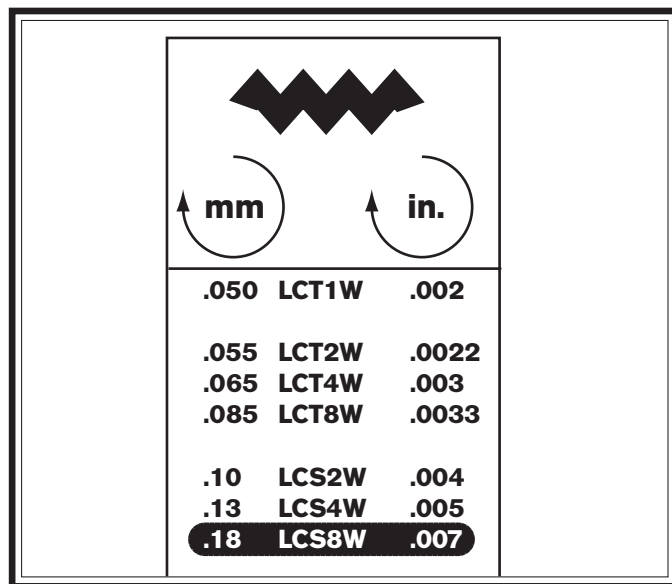
## Setting Feed Rate

The feed rate chart on the upper right of the headstock face displays the settings for the headstock feed controls for metric and inch feed rates.

Using the controls on the lathe, follow along with the example below to better understand how to set the lathe for the desired power feed rate.

### Example: Power Feed Rate of 0.18mm/rev

1. Make sure the end gears are in the standard configuration, which is applicable for general feed operations (refer to the **End Gears** subsection on the next page for detailed instructions).
2. Locate the line in the feed rate chart that lists the setting for 0.18mm of feed per revolution of the spindle, as illustrated in **Figure 88**.



mm		in.
.050	LCT1W	.002
.055	LCT2W	.0022
.065	LCT4W	.003
.085	LCT8W	.0033
.10	LCS2W	.004
.13	LCS4W	.005
<b>.18</b>	<b>LCS8W</b>	<b>.007</b>

Figure 88. Feed rate chart.

3. The configuration string of characters to the right of the selected feed rate (LCS8W) displays the positions to set the feed controls for a feed rate of 0.18mm/rev. (see **Figure 88**).

**Note:** In the next step, use the chuck key to rock the spindle back-and-forth to help mesh the gears as you make adjustments.

4. Position the controls as directed by the configuration string as follows (see **Figure 89**):
  - a) Move the feed range lever to the low (L) position.
  - b) Point the left quick change gearbox lever to the "C".
  - c) Move the middle quick change gearbox lever to the "S".
  - d) Position the bottom gearbox lever in the "8" slot.
  - e) Point the right gearbox lever to the "W".

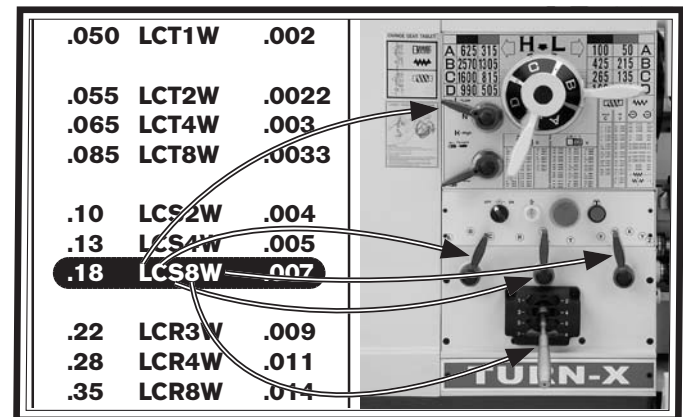


Figure 89. Power feed controls positioned for 0.18 mm/rev.

The lathe is now set up for a power feed rate of 0.18mm per spindle revolution.

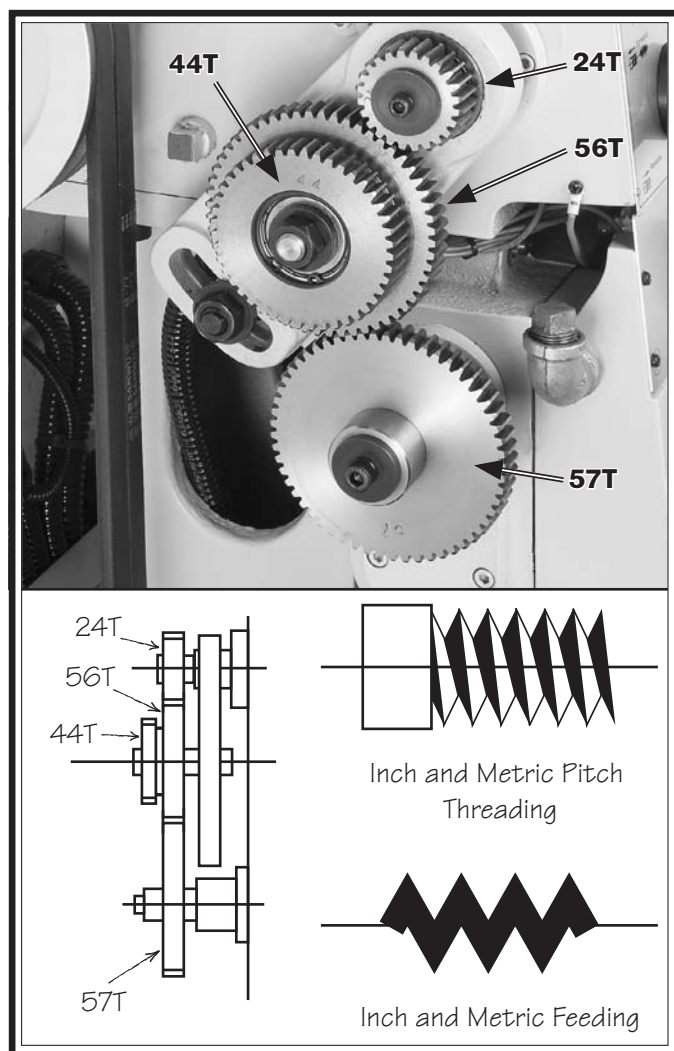
# End Gears

The end gears inside the headstock left cover can be setup for the standard or alternate configuration, depending upon the type of operation to be performed. The lathe is shipped with the end gears in the standard configuration.

## Standard End Gear Configuration

Use the standard end gear configuration for inch threading, metric threading and all general feed operations.

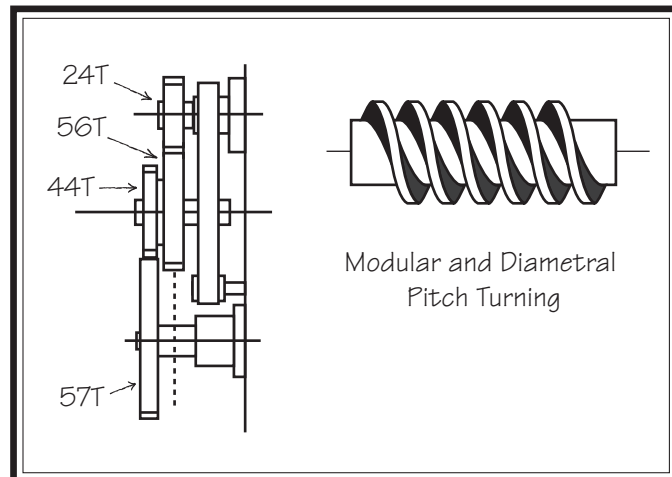
In this configuration, the 24T end gear is installed in the top position, the 44T/56T transposing gears in the middle position, and the 57T end gear in the bottom position, as shown in **Figure 90**. In this configuration the 56T and 57T gears are meshed.



**Figure 90. End gears in the standard configuration.**

## Alternate Configuration

The alternate end gear configuration is used when cutting modular or diametral threads. The 57T end gear is positioned on the outside so that it meshes with the 44T transposing gear instead of the 56T gear, as illustrated in **Figure 91**.



**Figure 91. Alternate end gear configuration.**

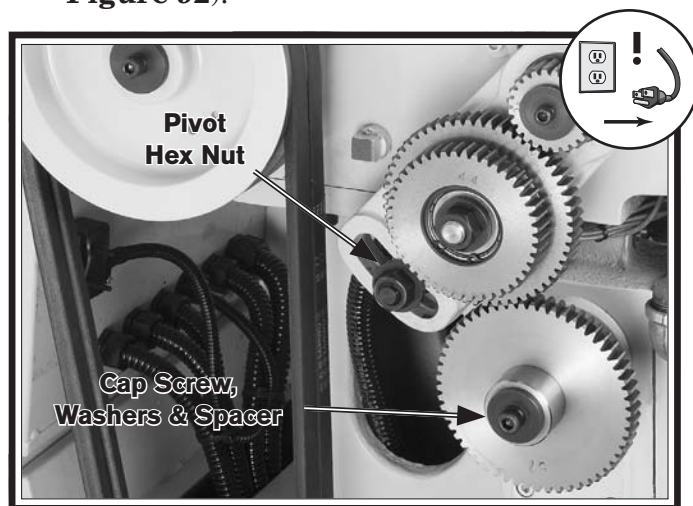
## Configuring End Gears

### Tools Needed

	Qty
Hex Wrench 6mm .....	1
Wrench 22mm .....	1

### To configure the end gears:

1. DISCONNECT LATHE FROM POWER!
2. Remove the headstock left cover.
3. Remove the cap screw, lock washer, and flat washer from the bottom 57T end gear (see **Figure 92**).



**Figure 92. End gear components.**

4. Loosen the pivot arm hex nut shown in **Figure 92**, then swing the pivot arm to the left so that 44T/56T gears are away from the 57T gear. Hand tighten the hex nut to keep the arm in place.
5. Use a stiff brush and mineral spirits to clean away the debris and grime from the gears and shafts, then lubricate these devices as instructed in the **End Gears** lubrication subsection on **Page 72**.
6. Making sure to keep the key seated in the shaft, remove the spacer and the 57T gear, then re-install them as follows:
  - For the standard end gear configuration, slide the 57T gear on first, then the spacer on the outside.
  - For the alternate end gear configuration, slide the spacer on first, then the gear.
7. Re-install the cap screw, lock washer, and flat washer you removed in **Step 3** to secure the spacer and 57T gear.

**Note:** DO NOT overtighten the cap screw—it merely holds the gear in place. Overtightening it will make it harder to remove later and may restrict the rotation of the gears.

8. Slide the pivot arm back so that either the 44T or the 56T meshes with the 57T gear, then retighten the pivot arm hex nut.

**Note:** Make sure to keep approximately 0.002" play between the gears.

9. Replace and secure the headstock left cover before connecting the lathe to power.

# Threading

The following subsections will describe how to use the threading controls and charts to set up the lathe for a threading operation. If you are unfamiliar with the process of cutting threads on a lathe, we strongly recommend that you read books, review industry trade magazines, or get formal training before attempting any threading projects.

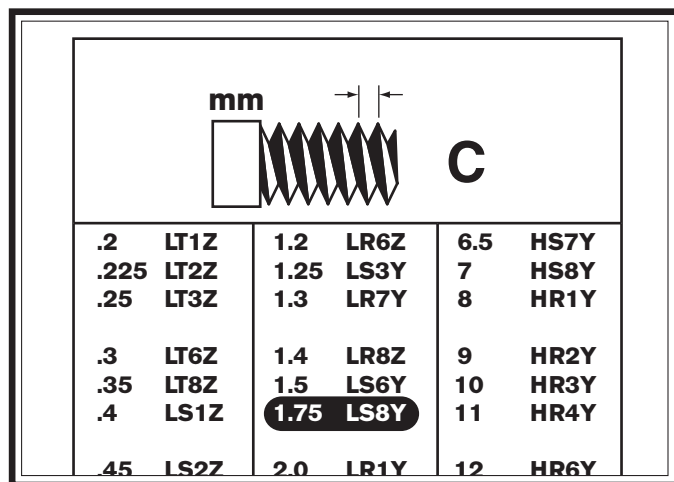
## Setting Threading Controls

The threading charts on the headstock face display the settings for metric, inch, modular, and diametral threading.

Using the controls on the lathe, follow along with the example below to better understand how to set up the lathe for the desired threading operation.

### Example: Metric Thread Pitch of 1.75

1. Make sure the end gears are in the standard configuration, which is used for all metric threading (refer to the **End Gears** subsection on **Page 57** for detailed instructions).
2. Locate the line in the metric thread chart that lists the setting for 1.75 threads per millimeter, as illustrated in **Figure 93**.



.2	LT1Z	1.2	LR6Z	6.5	HS7Y
.225	LT2Z	1.25	LS3Y	7	HS8Y
.25	LT3Z	1.3	LR7Y	8	HR1Y
.3	LT6Z	1.4	LR8Z	9	HR2Y
.35	LT8Z	1.5	LS6Y	10	HR3Y
.4	LS1Z	1.75	LS8Y	11	HR4Y
.45	LS2Z	2.0	LR1Y	12	HR6Y

Figure 93. Metric thread chart with 1.75 TPmm highlighted.

3. The configuration string of characters to the right of the selected thread pitch (LS8Y) displays the positions to set the threading controls for a metric thread pitch of 1.75 (see **Figure 93**).

**Note:** In the next step, use the chuck key to rock the spindle back-and-forth to help mesh the gears as you make adjustments.

4. Position the controls as directed by the configuration string (CLS8Y) as follows:
  - a) Move the "C" on the spindle speed lever hub directly under the arrow on the headstock.

**Note:** Each of the thread charts has a "C" or "V" in the header that is to be used for all of the listings in that chart.

  - b) Move the feed range lever to the low (L) position.
  - c) Point the left quick change gearbox lever to the "S".
  - d) Position the bottom gearbox lever in the "8" slot.
  - e) Point the right gearbox lever to the "Y".

The lathe is now set up to cut 1.75 TPmm threads.

## Apron Controls

The halfnut lever engages the carriage with the leadscrew which moves the carriage and cutting tool along the length of the workpiece for threading operations (see **Figure 94**).

**Important:** Make sure the feed control lever is in the disengaged (middle) position before attempting to engage the halfnut.

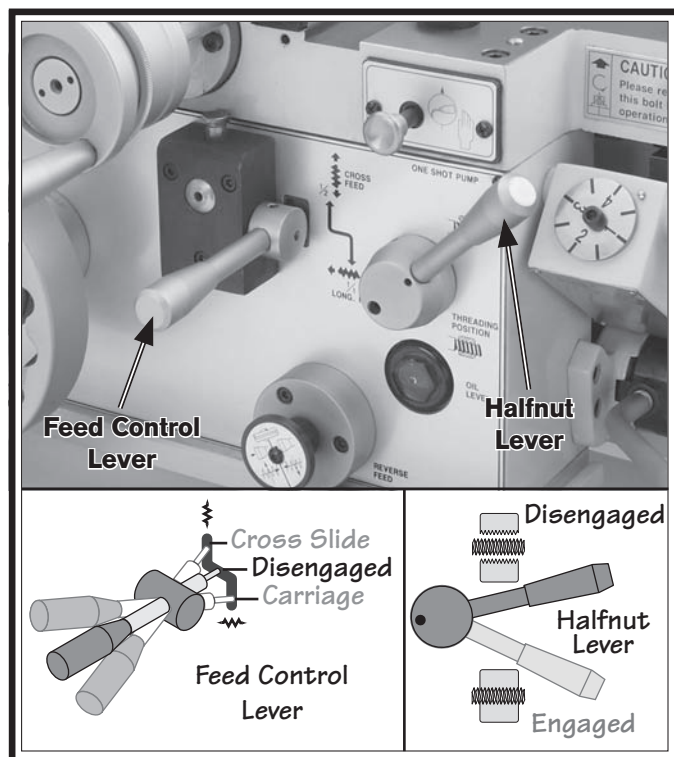


Figure 94. Apron threading controls.

## NOTICE

Attempting to engage the halfnut while the cross slide or carriage is engaged with the feedrod could cause severe damage to the lathe. Never attempt to engage the halfnut while the feed control lever is engaged.

## Thread Dial

The numbers on the thread dial are used with the thread dial chart to show when to engage the halfnut during inch threading. The thread dial gear must be engaged with the leadscrew for this to work. Loosen the knurled hand knob on the thread dial, pivot the dial gear toward the leadscrew so that it properly meshes with the leadscrew threads, then tighten the hand knob, as shown **Figure 95**.

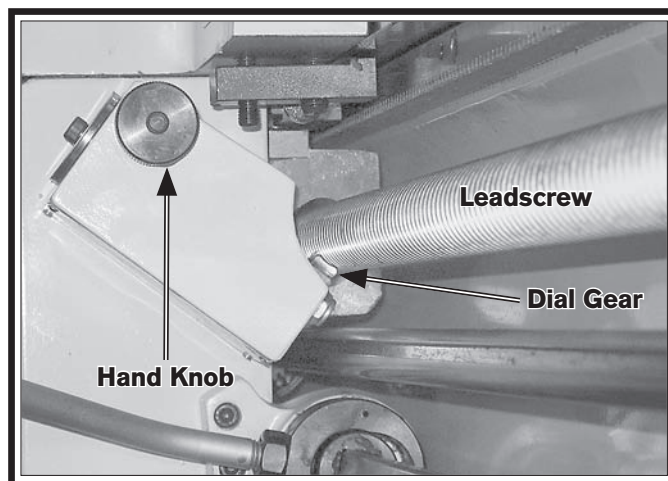


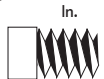

Figure 95. Thread dial engaged with the leadscrew.

## NOTICE

When threading, we recommend you use the slowest speed possible and make multiple light cuts. This will give you better control of when to engage/disengage the halfnut and prevent damaging your workpiece or the lathe.

## Thread Dial Chart

Find the TPI (threads per inch) that you want to cut in the left column of the thread dial chart (see **Figure 96**), then reference the dial number to the right of it. The dial numbers indicate when to engage the halfnut for a specific thread pitch. The thread dial chart can also be found on the front of the thread dial housing.

In.	
	
4,8,12,16,20,24, 28,32,36,40,44, 48,56,60,72	Any Position
2,6,10,14, 18,22,26, 30,54	Non-Numbered Position
3,5,7,9, 11,13,15, 19,23,27	Numbered Position 1,2,3,4
2½,3½,4½, 7½,11½,13½	Position 1,3 or 2,4
2¼,2¾, 3¼,3¾	Position 1 Only
2⅞	Same as Metric Threads

**Figure 96.** Thread dial chart.


**Note:** The thread dial is not used for metric threads, or diametral and modular gear turning. You must leave the halfnut engaged from the beginning until the threads/gears are complete for these types of operations.

The following examples explain how to use the thread dial chart.

### TPI Divisible By 4

For threading TPI divisible by four, use any line on the thread dial (see **Figure 97**).

TPI	
4,8,12,16,20,24, 28,32,36,40,44, 48,56,60,72	Any Position




**Figure 97.** Any position on the dial for threading TPI divisible by 4.

### Even TPI Not Divisible By 4

For even threading the TPI not divisible by 4, use any of the non-numbered lines on the thread dial (see **Figure 98**).

TPI	
2,6,10,14, 18,22,26, 30,54	Non-Numbered Position




**Figure 98.** Marks are selected on the dial for threading even TPI not divisible by 4.

### Odd Numbered TPI

For odd numbered TPI, use any of the numbered lines on the thread dial (see **Figure 99**).

TPI	
3,5,7,9, 11,13,15, 19,23,27	Numbered Position 1,2,3,4




**Figure 99.** Numbers are selected on the dial for threading odd numbered TPI.

### ½ Fractional TPI

Use any opposing number pairs—2/4 or 1/3 on the thread dial for ½ fractional TPI (see **Figure 100**). For example, to cut a 3½ thread, select 1 or 3 on the dial.

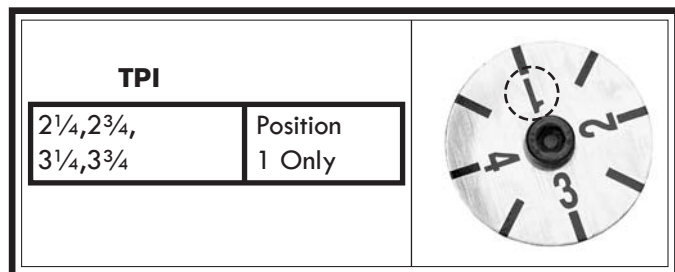
TPI	
2½,3½,4½, 7½,11½,13½	Position 1,3 or 2,4



**Figure 100.** Opposing number group are selected on dial for cutting ½ thread TPI.

**1/4 or 3/4 Fractional TPI**

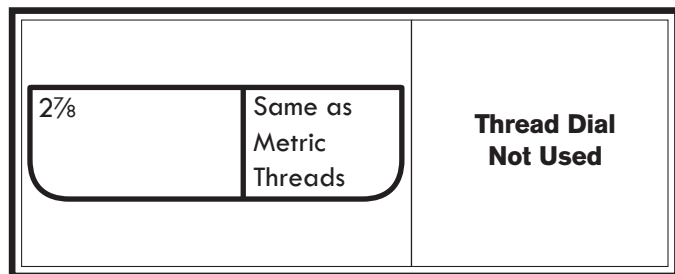
For TPI that have a 1/4 or 3/4 fraction, use position 1 on the thread dial (see **Figure 101**).



**Figure 101.** Position for 1/4 or 3/4 fractional TPI.

**2 7/8 TPI**

The thread dial is not used for 2 7/8 threading or metric threading (see **Figure 102**). The halfnut must stay engaged with the leadscrew throughout the entire threading operations.

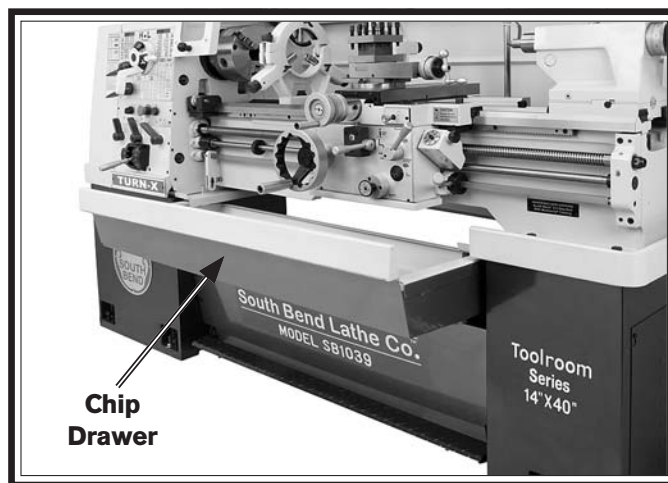


**Figure 102.** Halfnut stays engaged for 2 7/8 TPI.

# Chip Drawer

The chip drawer shown in **Figure 103** catches metal chips, swarf, and cutting fluid during the machining process. It easily slides open to provide access to swarf during cleanup.

Also, the chip drawer contains a screen that allows run-off cutting fluid to drain back into the reservoir.



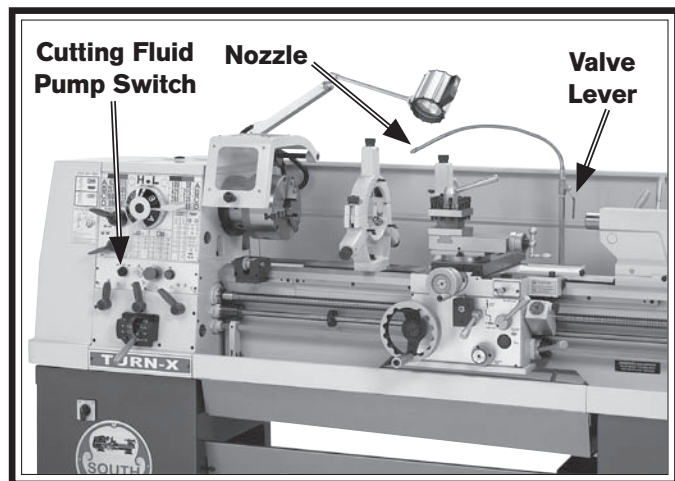
**Figure 103.** Chip drawer.

## ⚠ CAUTION

If pulled out quickly and more than half way, the drawer could fall out and hit your legs and feet, causing serious injury. Therefore, open the drawer slowly and avoid opening it more than half way.

# Cutting Fluid System


When the cutting fluid pump switch is turned **ON**, the fluid is delivered through the nozzle attached to the carriage, and the flow is controlled by the valve lever at the base of the nozzle (see **Figure 104**).



**Figure 104. Cutting fluid system controls and components.**


Always use high quality cutting fluid in the cutting fluid system and follow the manufacturer's instructions for diluting. The quick reference table shown in **Figure 105** can help you select the appropriate cutting fluid.

Refer to **Cutting Fluid System Service** on **Page 72** for detailed instructions on how to add or change fluid. Check the cutting fluid regularly and promptly change it when it becomes overly dirty or rancid, or as recommended by the fluid manufacturer.



**! WARNING**  
**BIOLOGICAL & POISON HAZARD!**

Use the correct personal protection equipment when handling cutting fluid. Follow federal, state, and fluid manufacturer requirements for proper disposal.



**NOTICE**

Running the pump without adequate fluid in the reservoir may permanently damage it, which will not be covered under warranty.

**To use the cutting fluid system on your lathe:**

1. Make sure the reservoir is properly serviced and filled with cutting fluid, and that you are wearing the necessary personal protection equipment.
2. Position the cutting fluid nozzle for your operation.
3. Use the control panel cutting fluid pump switch to turn the pump **ON**.
4. Adjust the flow of cutting fluid by using the valve lever near the base of the nozzle hose.

**Important:** Promptly clean any splashed fluid from the floor to avoid a slipping hazard.

Workpiece	Dry	Water Soluble Oil	Synthetic Coolants	Sulfurized Oil	Mineral Oil
Aluminum		X	X		
Brass	X	X	X		
Bronze	X	X	X		X
Cast iron	X				
Low Carbon Steel		X	X		
Alloy Metals		X	X	X	X
Stainless Steel		X	X	X	X

**General Note:** Cutting fluids are used for heavy-duty lathe operations and production turning. Oil-water emulsions and synthetic cutting fluids are the most common for typical lathe operations. Sulfurized oils often are used for threading. For small projects, spot lubrications can be done with an oil can or brush, or omitted completely.

**Figure 105. Cutting fluid selection table.**

## Accessories

This section includes the most common accessories available for your lathe, which may be available through your local South Bend Lathe Co. dealer. If you do not have a dealer in your area, please call us at (360) 734-1540 or email us at [cs@southbendlathe.com](mailto:cs@southbendlathe.com).

### SB1265—8" Backplate D1-5

### SB1227—8" 4-Jaw Chuck D1-5

### SB1309—8" 2-Piece 3-Jaw Chuck, Plain Back

### SB1279—10 Pc. Precision 5-C Collet Set

Set of 10 collets sized from  $\frac{1}{8}$ " -  $\frac{3}{4}$ ". Same quality as the individual collets, only packaged in one convenient set.



Figure 106. Model SB1279 10 Pc. 5-C Collet Set.

### SB1238—MT#3 High Performance Live Center

South Bend® brand live centers are the best centers in the industry made with pride and uncompromising quality.

- Shafts are made of alloy steel and vacuum heat treated to HRC60  $\pm$  1 for high rigidity and durability.
- Centers use a combination of roller bearings, thrust ball bearings and ball bearings.
- Applicable for CNC lathes and high speed turning.
- Waterproof design.
- 60° centers.

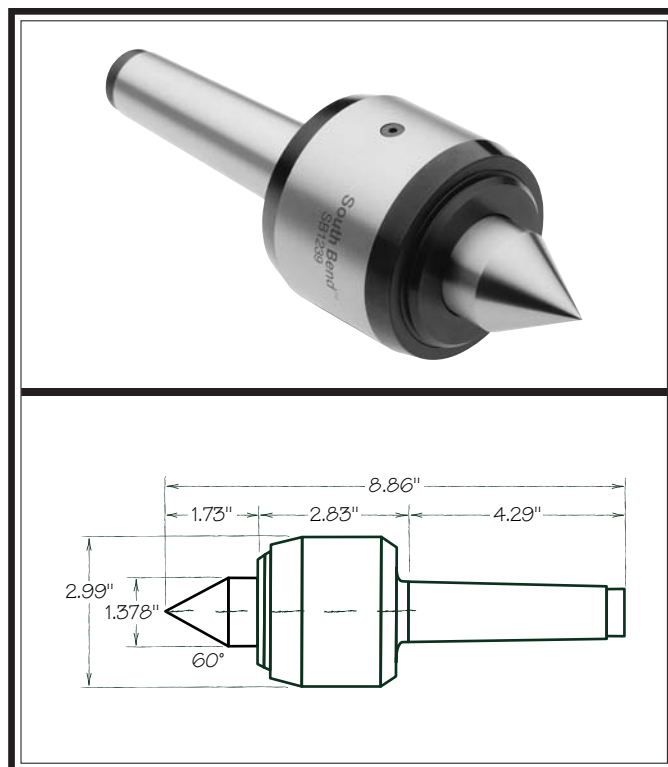


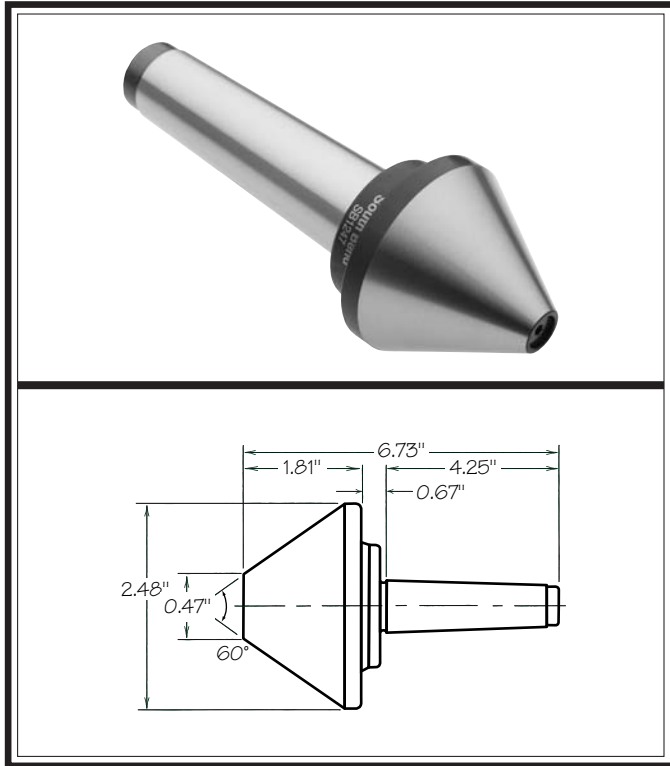
Figure 107. Model SB1239 High Performance Live Center.

### SB1242—MT#3 Long-Nose High-Performance Live Center

### SB1262—MT#3 Light-Duty Live Center

**SB1246—MT#3 Bull Nose Center**

- Cr-Mo steel; hardened to HRC60 ± 1
- Taper roller & ball bearing construction
- Great for turning pipes



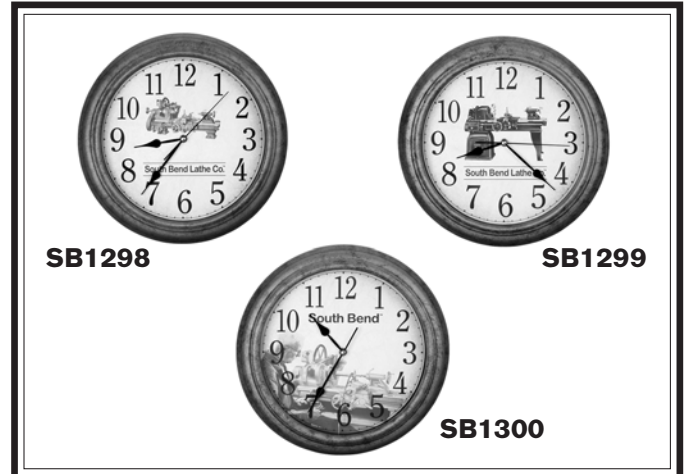
**Figure 108. SB1247 MT4 Bull Nose Center.**

**SB1298—SBL Bench Lathe Shop Clock**

**SB1299—SBL Toolroom Lathe Shop Clock**

**SB1300—SBL Lathe with Man**

These fine traditional shop clocks are constructed with a metal antique-finished frame. They are easy to read from a distance and measure 14" in diameter. Pictures just don't do them justice. They are very nice quality clocks and perfect for the South Bend Lathe aficionado.



**Figure 109. Antique-finished South Bend shop clocks.**

**SBL Gearhead T-Shirt**

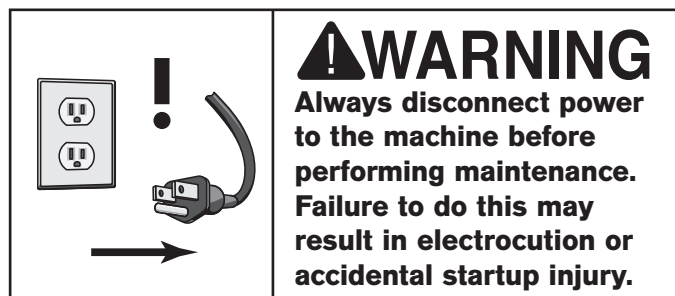
**SBL One Good Turn T-Shirt**

100% Cotton, preshrunk T-shirts, available in sizes S, M, L, XL, 2XL, 3XL.



**Figure 110. Official South Bend Lathe T-Shirts.**

# Maintenance Schedule



Each operator of this machine is responsible for ensuring proper care of the equipment. We strongly recommend all operators make a habit of following the daily maintenance procedures.

For optimum performance from this machine, this maintenance schedule must be strictly followed. Use the chart provided on **Page 67** to ensure this is done.

## Ongoing

To maintain a low risk of injury and proper machine operation, if you ever observe any of the items below, shut down the machine immediately and fix the problem before continuing operations:

- Loose mounting bolts or fasteners.
- Worn, frayed, cracked, or damaged wires.
- Guards removed.
- STOP button not working correctly or not requiring you to reset it before starting the machine again.
- A reduction in braking speed or efficiency.
- Oil level not visible in the sight glasses.
- Cutting fluid not flowing out.
- Any other unsafe condition.

## Daily, Before Operations

- Check/add headstock oil (**Page 68**).
- Check/add quick change gearbox oil (**Page 69**).
- Check/add apron oil (**Page 69**).
- Check/add cutting fluid (**Page 72**).
- Lubricate the ways (**Page 70**).
- Add oil to the ball oilers and oil cup (**Page 71**).
- Clean/lubricate the leadscrew (**Page 70**).
- Move the power feed control lever on the apron to disengage (to prevent crashes upon startup).

- Ensure carriage lock bolt is loose.

## Daily, After Operations

- Depress STOP button and shut **OFF** the master power switch (to prevent accidental startup).
- Vacuum/clean all chips and swarf from bed, slides, and chip drawer.
- Wipe down all unpainted or machined surfaces with an oiled rag.

## Monthly

- Drain and clean the cutting fluid reservoir, then add new fluid (**Page 72**).

## Semi-Annually

- Change the headstock oil (**Page 68**).
- Lubricate end gears (**Page 72**).

## Annually

- Change the apron oil (**Page 69**).
- Change the quick change gearbox oil (**Page 69**).

# Cleaning & Protecting

Regular cleaning is one of the most important steps in taking care of this lathe. We recommend that the cleaning routine be planned into the workflow schedule, so that adequate time is set aside to do the job right.

Typically, the easiest way to clean swarf from the bed ways and chip drawer is to use a wet/dry shop vacuum that is dedicated for this purpose only. 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.

Besides the ways, all other unpainted and machined surfaces should be wiped down daily to keep them rust-free and in top condition. This includes any surface that is vulnerable to rust if left unprotected (especially any parts that are exposed to water soluble cutting fluid). Typically, a thin film of oil is all that is necessary for protection.



## NOTICE

The following recommended lubrication schedules are based on light-to-medium usage. Keeping in mind that lubrication helps to protect the value and operation of the lathe, these lubrication tasks may need to be performed more frequently than recommended here, depending on usage.

Failure to follow reasonable lubrication practices as instructed in this manual could lead to premature failure of lathe components and will void the warranty.

## Lubrication

### Headstock

Oil Type .. Mobil DTE Light or ISO 32 Equivalent  
 Oil Amount ..... 7 Liters  
 Check/Add Frequency ..... Daily  
 Change Frequency ..... Every 6 Months

The headstock gearing is lubricated by an oil bath that distributes the lubricant with the motion of the gears, much like an automotive manual transmission.

### Checking Oil Level

The headstock reservoir has the proper amount of oil when the oil level in the sight glass is approximately halfway. The oil sight glass is located on the right side of the headstock, as shown in **Figure 111**.



Figure 111. Location of headstock oil sight glass.

### Adding Oil

The oil fill plug is located on top of the headstock, as shown in **Figure 112**.

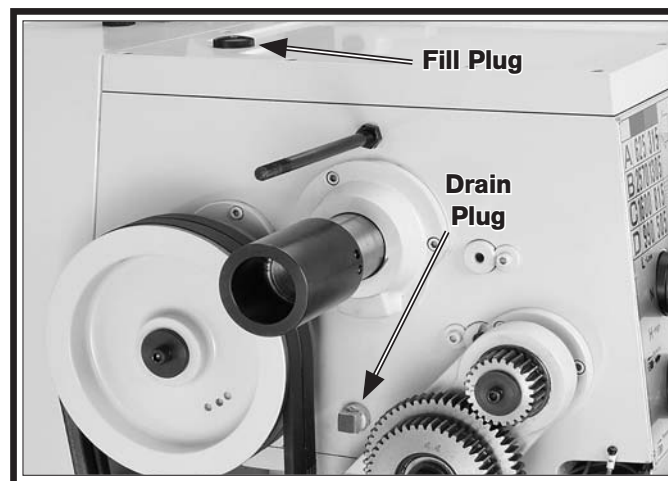


Figure 112. Headstock fill and drain plugs.

### Changing Oil

Items Needed	Qty
Wrench $\frac{5}{8}$ "	1
Catch Pan 7 Liter/2 Gallon	1

### To change the headstock oil:

1. DISCONNECT LATHE FROM POWER!
2. Remove the headstock left cover.
3. Remove the V-belts so that oil does not get on them, necessitating their replacement (refer to the **V-Belt** subsection on **Page 80** for detailed instructions).
4. Remove the fill plug on top of the headstock to allow the oil to drain more freely.
5. Place the catch pan under the headstock drain plug (see **Figure 112**), then remove the plug.
6. When the headstock reservoir is empty, replace the drain plug and clean away any oil that may have spilled.
7. Fill the headstock reservoir until the oil level is approximately halfway in the sight glass.
8. Replace and re-tension the V-belts, then secure the headstock left cover before re-connecting the power.

### Quick Change Gearbox

Oil Type ..... Mobil Vactra 2 or ISO 68 Equivalent  
 Oil Amount ..... 1 Liter/1 Quart  
 Check/Add Frequency ..... Daily  
 Change Frequency ..... Annually

#### Checking Oil Level

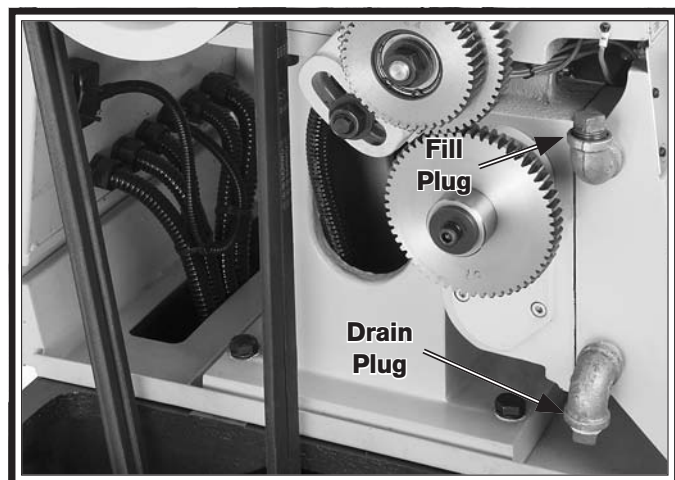
The quick change gearbox reservoir has the proper amount of oil when the oil level in the sight glass is approximately halfway. The oil sight glass is located on the right side of the gearbox, as shown in **Figure 113**.



**Figure 113. Location of quick change gearbox oil sight glass.**

#### Adding Oil

Use a 5/8" wrench to remove the quick change gearbox fill plug (see **Figure 114**), then add the oil until the level is approximately halfway in the gearbox oil sight glass.



**Figure 114. Locations of the quick change gearbox fill and drain plugs.**

### Draining Oil

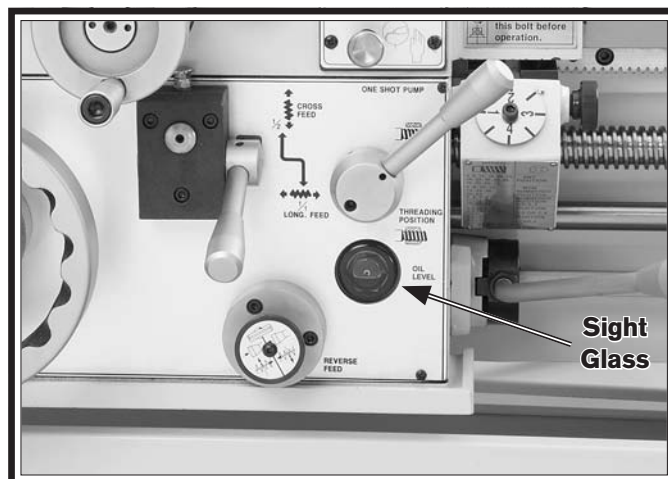
Place a catch pan under the quick change gearbox drain plug (see **Figure 114**), use a 5/8" wrench to loosen the fill plug and remove the drain plug, then allow the gearbox reservoir to empty.

### Apron

Oil Type ..... Mobil Vactra 2 or ISO 68 Equivalent  
 Oil Amount ..... 1.1 Liters/1.2 Quarts  
 Check/Add Frequency ..... Daily  
 Change Frequency ..... Annually

#### Checking Oil Level

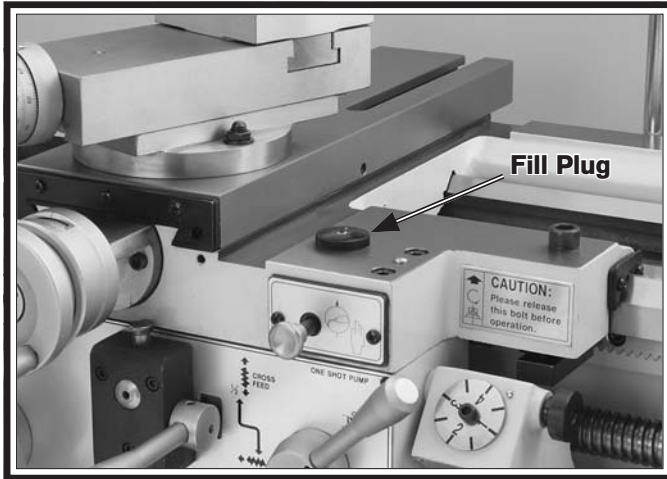
The apron oil sight glass is on the front of the apron, as shown in **Figure 115**. Maintain the oil volume so that the level is approximately halfway in the sight glass.



**Figure 115. Location of apron oil sight glass.**

**Adding Oil**

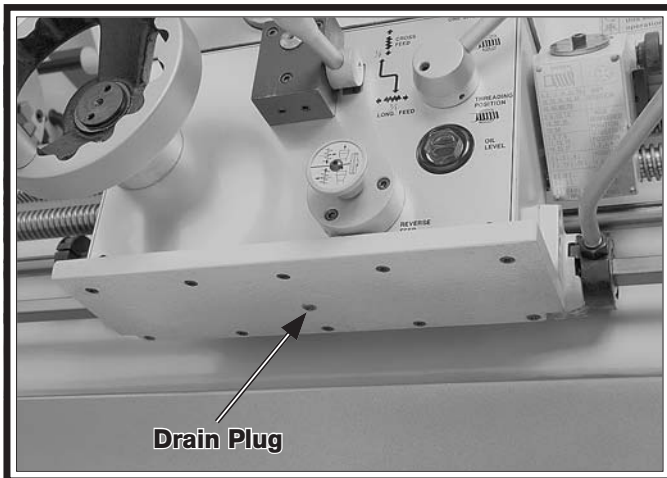
The apron twist-off fill plug is on top of the apron, as shown in **Figure 116**. Add the oil until the level is approximately halfway in the apron oil sight glass.



**Figure 116. Location of apron fill plug.**

**Draining Oil**

Place a catch pan under the apron drain plug shown in **Figure 117**, loosen the fill plug, then use a 6mm hex wrench to remove the drain plug and allow the apron reservoir to empty.



**Figure 117. Location of apron drain plug.**

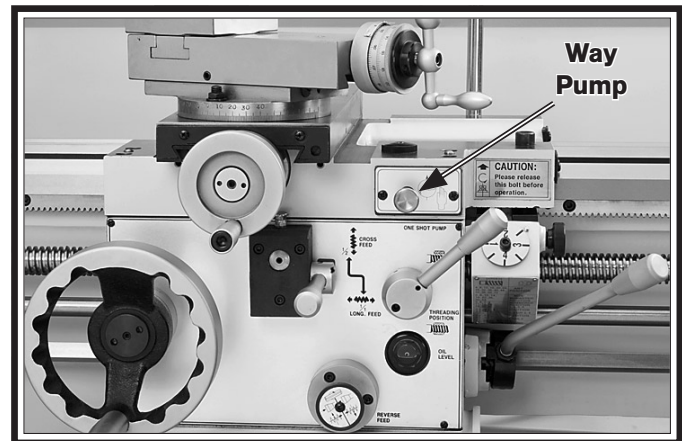
**Ways & Slides**

The way pump shown in **Figure 118** lubricates the saddle and cross slide ways with oil from the apron reservoir.

To use the way pump to lubricate the ways, pull the pump knob out for two or three seconds and then push it in. The pump draws oil from the apron reservoir and then forces it through drilled passages to the way guides.

Repeat this process and move the carriage and cross slide through their full path of movement to distribute oil along the way guides.

Lubricate the guides once before and once after operating the lathe. If the lathe is in a moist or dirty environment, increase the lubrication interval and make sure to keep the oil level full.



**Figure 118. Location of way pump on the apron.**

**Leadscrew**

Oil Type ..... Mobil Vactra 2 or ISO 68 Equivalent  
 Oil Amount ..... As Needed  
 Lubrication Frequency..... Daily

Before lubricating the leadscrew, clean it first with mineral spirits. A stiff brush works well to help clean out the threads. Make sure to move the carriage out of the way, so you can clean the entire length of the leadscrew.

Apply a thin coat of oil along the length of the leadscrew. Use a stiff brush to make sure the oil is applied evenly and down into the threads.

### Ball Oilers & Oil Cup

Oil Type .. Mobil DTE Light or ISO 32 Equivalent  
 Oil Amount ..... 1 or 2 Squirts/Fill  
 Lubrication Frequency..... Daily

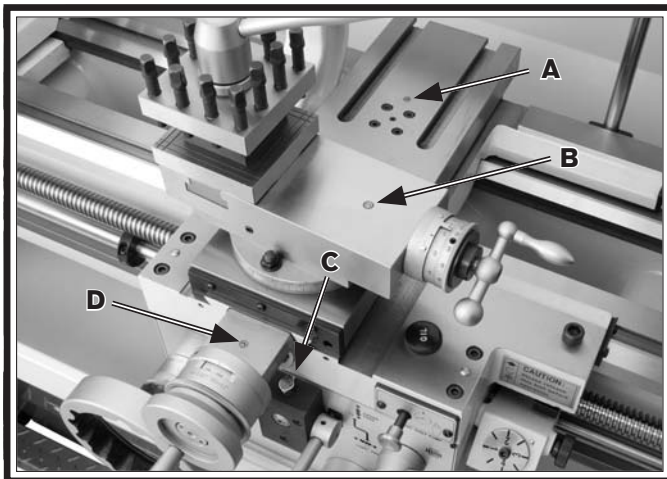
This lathe has seven ball oilers and one oil cup that should be oiled on a daily basis before beginning operation.

In order to properly squirt oil into these devices, you will need an oil can or gun. We recommend that you use an oiling device that has a plastic or rubber tip. Metal tips can damage the ball and spring inside the ball oilers.

Clean away debris and grime from around the oil device. For the ball oilers, depress the ball with the oil can tip and add oil until you see it exiting the seams of the component. This will ensure there is enough oil and purge any contaminants

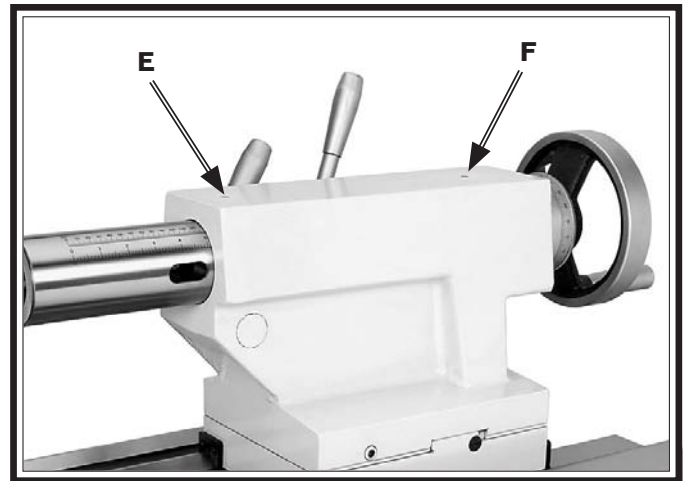
For the oil cup, lift the lid and fill the cup to the top. The oil will slowly drain into the gearing over time.

Refer to **Figures 119–121** and the following descriptions to identify the locations of each oil device.



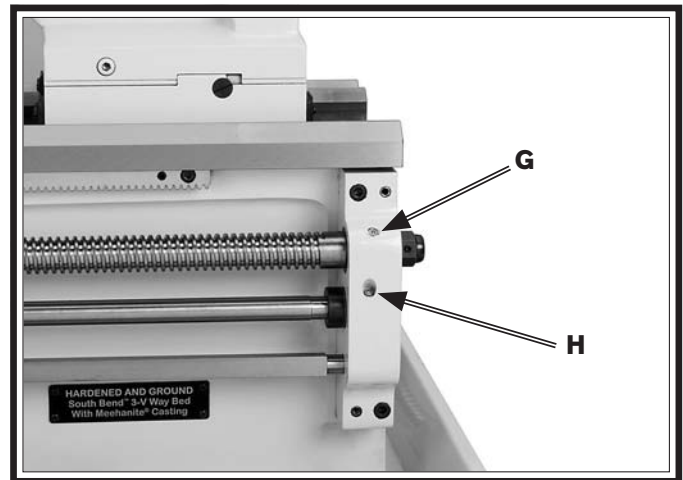
**Figure 119. Carriage ball oilers and oil cup.**

- A.** Cross Slide Leadscrew & Nut
- B.** Compound Rest Leadscrew & Nut
- C.** Feed Control Lever Gearing
- D.** Cross Slide Leadscrew Bearing



**Figure 120. Tailstock ball oilers.**

- E.** Quill Barrel
- F.** Quill Leadscrew & Nut



**Figure 121. Leadscrew and feedrod end bearing ball oilers.**

- G.** Leadscrew End Bearing
- H.** Feedrod End Bearing

## End Gears

Lubricant Type..... NLGI#2  
 Lubricant Amount..... Thin Coat  
 Frequency ..... Semi-Annually or When Swapping

Remove the end gears from the machine, then clean the gears and shafts (see **Figure 122**) with mineral spirits and a small, stiff brush. When they are dry, apply a thin coat of lubricant.

Wipe away any excess grease to prevent it from getting on the V-belts during operation. If the V-belts become contaminated with lubricant, the power transmission from the motor will be reduced and you will need to replace them.

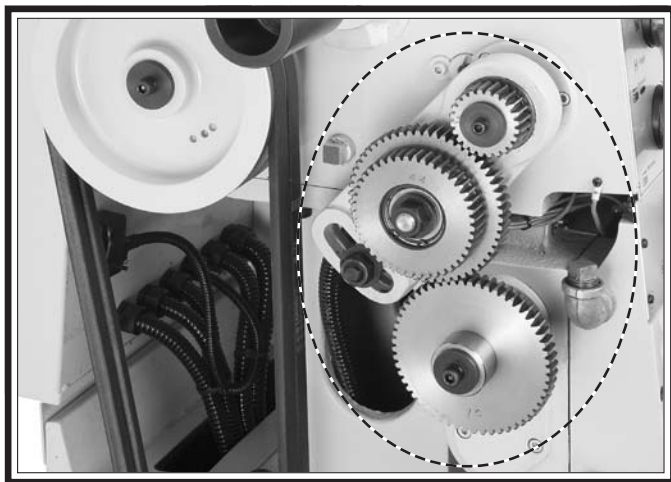


Figure 122. End gears.

## Cutting Fluid System Service

The cutting fluid system consists of a fluid reservoir, pump, and flexible nozzle. The pump pulls fluid from the reservoir and sends it to the valve, which controls the flow of cutting fluid to the work area. As the fluid leaves the work area, it drains into the chip drawer and through the catch pan back into the reservoir.

Use **Figure 123** to identify the locations of the cutting fluid system controls and components.

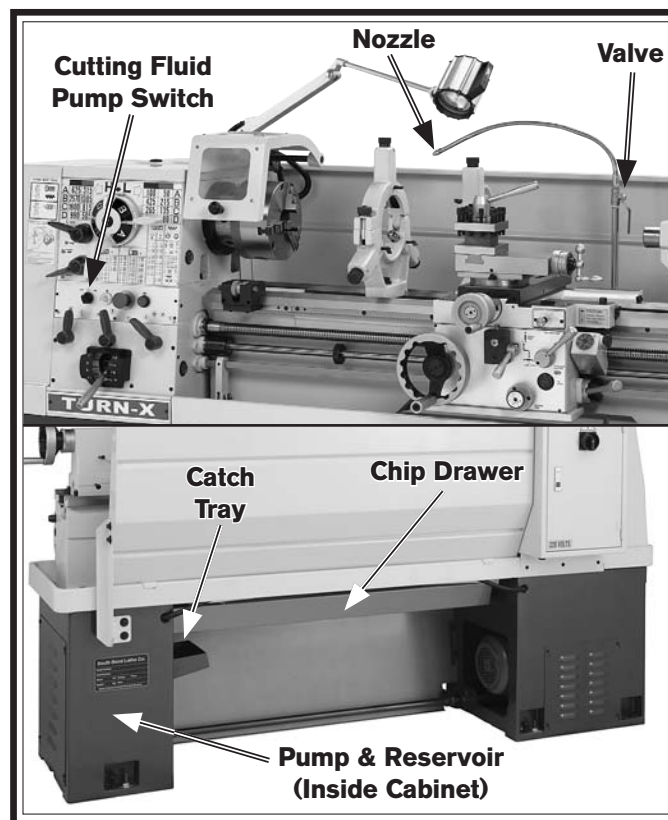


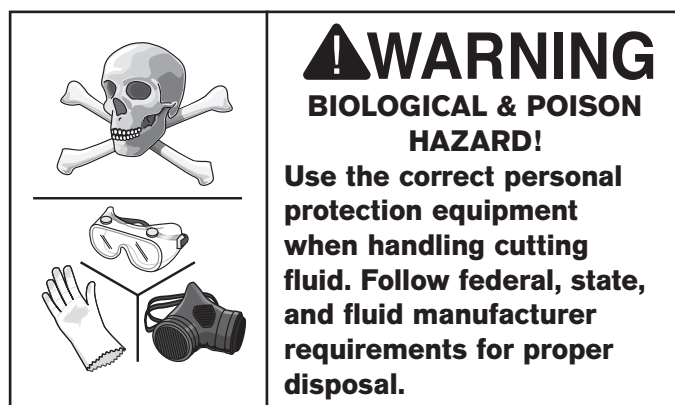
Figure 123. Cutting fluid system controls and components.

Although most swarf from machining operations falls into the chip drawer and stays there, some small chips drain into the reservoir. The pump uses a screen to prevent it from picking up the small swarf that ends up in the reservoir. However, since the swarf is spread throughout the cutting fluid system, cleaning the system on a regular basis is a requirement to maintain the life of the pump.

## Hazards

As cutting fluids age, dangerous microbes can proliferate and create a biological hazard. The risk of exposure to this hazard can be greatly reduced by replacing the old fluid on a monthly basis, as indicated in the maintenance schedule.

The important thing to keep in mind when working with the cutting fluid is to minimize exposure to your skin, eyes, and respiratory system by wearing the proper PPE (Personal Protective Equipment), such as splash-resistant safety glasses, long-sleeve non-absorbent gloves, protective clothing, and a NIOSH approved respirator.



## Adding Fluid

1. DISCONNECT LATHE FROM POWER!
2. Remove the side vented cover from the right cabinet, then slide the reservoir out, as shown in **Figure 124**.

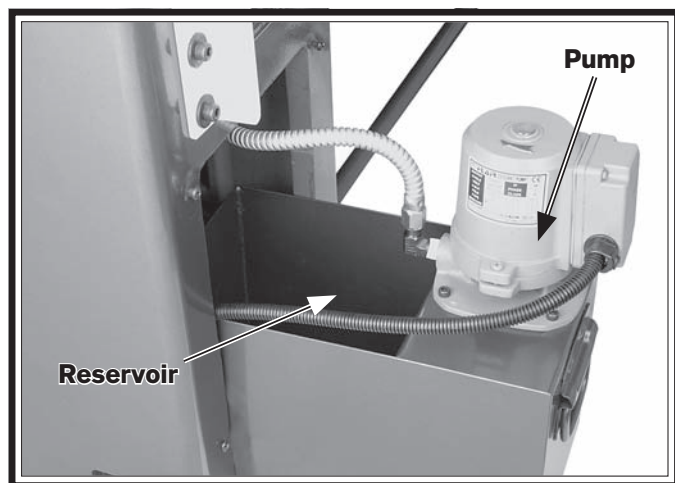


Figure 124. Cutting fluid reservoir and pump.

3. Pour cutting fluid into the reservoir until it is nearly full.
4. Slide the reservoir back into the cabinet and replace the vented cover.

## Changing Cutting Fluid

When you replace the old cutting fluid, take the time to thoroughly clean out the chip drawer, catch pan, and fluid reservoir. The entire job only takes about a ½ hour when you are prepared with the proper materials and tools. Make sure to dispose of all old fluid according to federal, state, and fluid manufacturer's requirements.

### Items Needed:

	<b>Qty</b>
Safety Wear ..... See <b>Hazards</b> section on this page	
New Cutting Fluid ..... Approximately 3 Gallons	
Empty 5-Gallon Bucket w/Lid .....	2
Phillips Screwdriver #2 .....	1
Wrench ¾" .....	1
Disposable Shop Rags .....	As Needed
Hose or Tubing ⅝" x 60" (Optional) .....	1 Piece
Magnets (Optional) .....	As Many As Desired

### To change the cutting fluid:

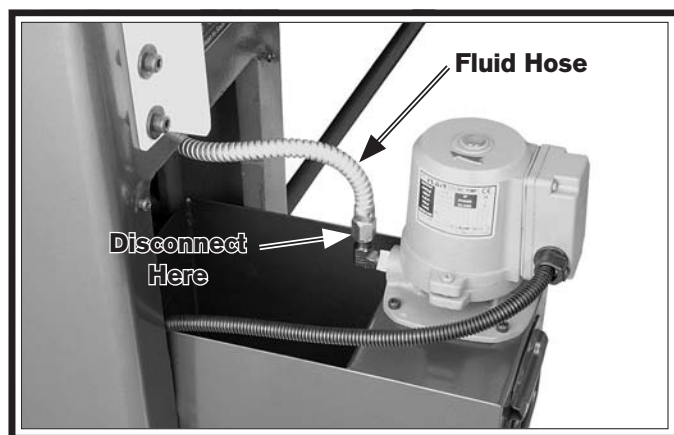
1. Position the cutting fluid nozzle over the splash guard so that it is pointing behind the lathe. If you have the optional hose, connect it to the end of the nozzle now.
2. Place the 5-gallon bucket behind the lathe and under the cutting fluid nozzle. If you have the optional hose, place the hose in the bucket. Otherwise, you may need to have another person hold the bucket up to the nozzle to prevent cutting fluid from splashing outside of the bucket.
3. Turn the cutting fluid pump **ON** and pump the old fluid out of the reservoir. Turn the pump **OFF** immediately after the fluid stops flowing.

## NOTICE

Running the pump without adequate fluid in the reservoir may permanently damage it, which will not be covered under warranty.

4. DISCONNECT LATHE FROM POWER!
5. Remove the side access panel from the right cabinet, then slide the cutting fluid reservoir out.
6. To enable the reservoir to be tipped in the next step, disconnect the fluid hose from pump (see **Figure 125**).

**Note:** The electrical conduit was purposely left long, so the reservoir can be removed without disconnecting wires from the pump. It is not necessary to disconnect the electrical wires from the pump.



**Figure 125. Fluid hose and connection.**

7. Pour out the remaining cutting fluid into your 5-gallon bucket and close the lid.
8. Clean out the swarf and residue from the chip tray, catch drawer, and reservoir bottom and put the waste in the second 5-gallon bucket. Wash out the reservoir with soapy water and drain it into the second 5-gallon bucket.

Dispose of the old cutting fluid and swarf according to federal, state, and fluid manufacturer's requirements.

9. Slide the reservoir partially into the base and re-connect the fluid hose (if removed).

**Tip:** Leave one or more magnets at the bottom of the reservoir to collect metal chips and make cleanup easier next time. This will also help keep small metal chips out of the pump.

10. Refill the reservoir with new cutting fluid, slide the reservoir completely into the base, then clean up any spilled fluid from the machine and floor.
11. Replace the access panel.
12. Connect the lathe to power and point the nozzle into the chip drawer.
13. Turn the cutting fluid pump **ON** to verify that fluid cycles properly, then turn it **OFF**.

**Note:** It may take a few seconds for the pump to start circulating the fluid. However, if the fluid does not start flowing within the first minute, turn the pump **OFF** to prevent damaging it. Try priming the pump manually by pouring cutting fluid down into the nozzle, then repeat **Step 13**.

## Machine Storage

To prevent the development of rust or corrosion, properly prepare the lathe for storage. When decommissioning this machine, use the steps in this section to ensure that it remains in good condition for later use.

### To prepare your machine for short-term storage (up to a year):

1. Pump out the old cutting fluid, and flush the lines and reservoir with warm, soapy water.
2. DISCONNECT LATHE FROM POWER!
3. Thoroughly clean all unpainted, bare metal surfaces, then apply a liberal coat of way oil.
4. Lubricate the machine as outlined in the lubrication section.
5. Cover and, if possible, place the machine in a dry area that is out of direct sunlight and away from hazardous fumes, paint, solvents, or gas. Fumes and sunlight can bleach or discolor paint and make plastic guards cloudy.
6. Once or twice a month, depending on the ambient humidity levels in the storage environment, wipe down the machine as outlined in **Step 3**.
7. Every few months, start the machine and run all gear-driven components for a few minutes. This will keep the bearings, bushings, gears, and shafts well lubricated and protected from corrosion, especially during the winter months.

### To prepare your machine for long-term storage (a year or more):

1. Run the lathe for 10 minutes to bring the gearboxes to operating temperature, then drain and refill all gearboxes with fresh oil.
2. Pump out the old cutting fluid, and flush the lines and reservoir with warm, soapy water.
3. DISCONNECT LATHE FROM POWER!
4. Thoroughly clean all unpainted, bare metal surfaces, then apply a liberal coat of way oil, a heavy grease, or rust preventative. Take care to ensure these surfaces are completely covered but that the rust preventative or grease is kept off of painted surfaces.
5. Lubricate the machine as outlined in the lubrication section.
6. Loosen or remove the V-belts so they do not become stretched during the storage period. (Be sure to also affix a maintenance note near the power button as a reminder that the belts have been loosened or removed.)
7. Place a few moisture absorbing desiccant packs inside of the electrical box.
8. Cover and, if possible, place the machine in a dry area that is out of direct sunlight and away from hazardous fumes, paint, solvents, or gas. Fumes and sunlight can bleach or discolor paint and make plastic guards cloudy.

## Gib Adjustment

The goal of adjusting the gib screws is to remove sloppiness in the sliding surfaces without over-adjusting them to the point where the movement becomes stiff and difficult.

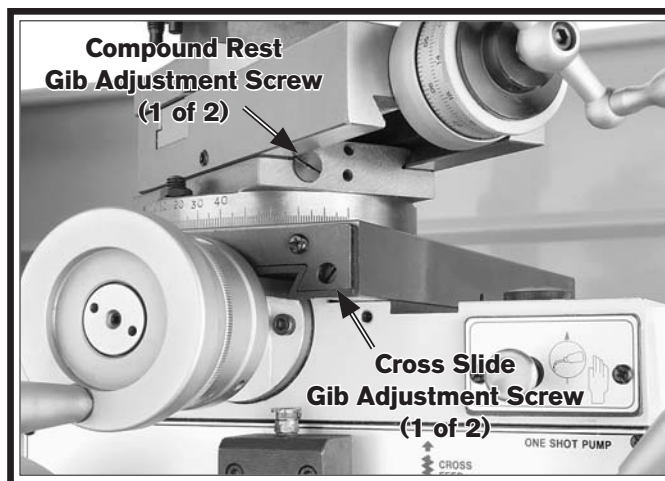
In general, loose gibs cause poor finishes and tool chatter. However, over-tightened gibs cause premature wear on the sliding surfaces, leadscrew and nut, and cause hesitation in movement when using the handwheels.

**Important:** Before adjusting the gibs, loosen the lock screw or bolt for the device so that the gibs can freely slide during adjustment.

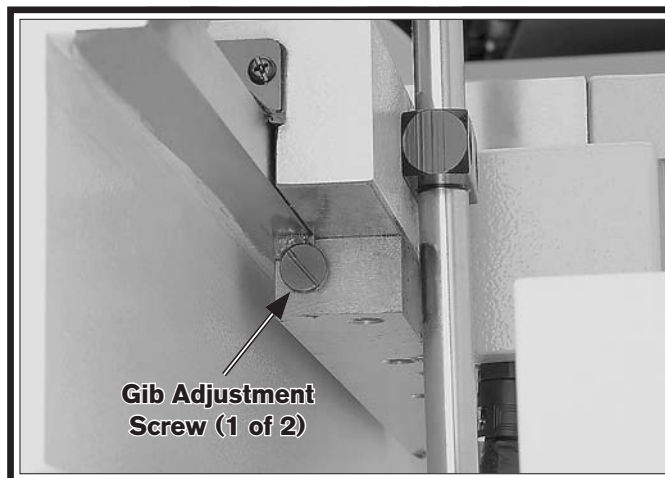
The gibs are tapered and held in position by a screw at each end. To adjust the gib, turn one screw a  $\frac{1}{4}$  turn clockwise and the other screw a  $\frac{1}{4}$  turn counterclockwise, so both screws move in the same direction and the same amount. Test the feel of the sliding component by turning the handwheel, then, if necessary, adjust the gib screws to make it tighter or looser.

The gib adjustment process usually requires some trial-and-error. Repeat the adjustment process as necessary until you find the best balance between loose and stiff movement. Most machinists find that the ideal gib adjustment is one where a small amount of drag or resistance is present yet the handwheels are still easy to move.

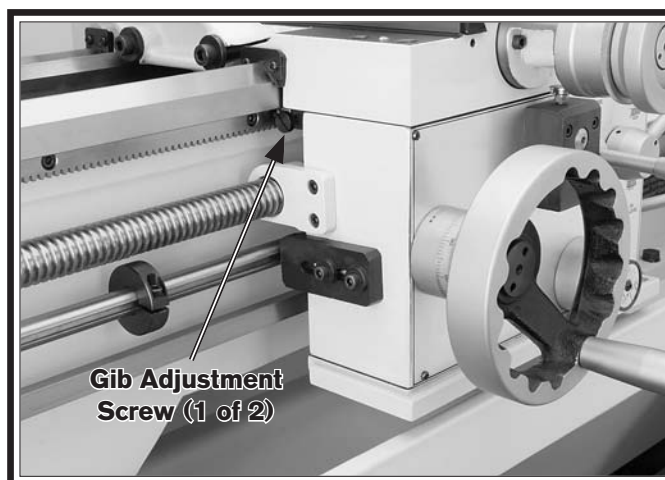
**Figures 126–130** show the location of the adjustment screws for each gib on this machine.



**Figure 126. Compound and cross slide gib adjustment screws.**

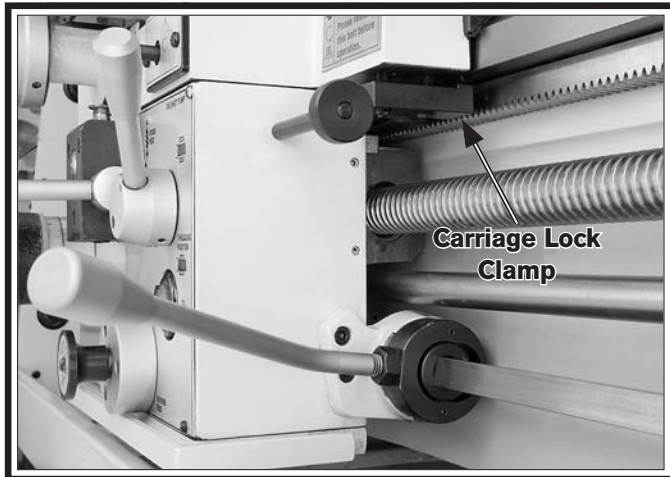


**Figure 127. One of two rear saddle gib adjustment screws.**



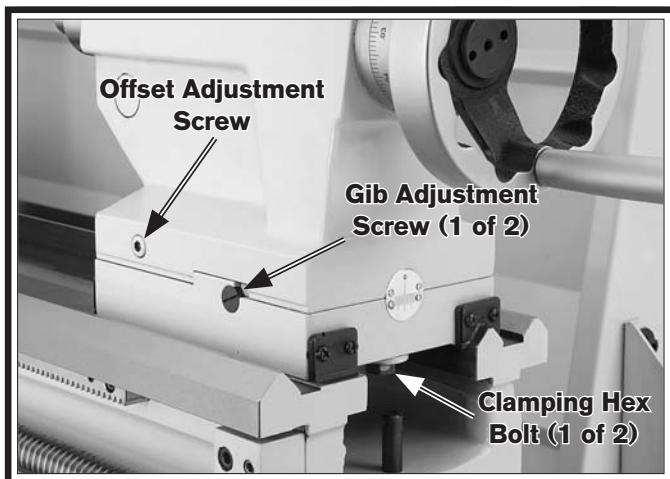
**Figure 128. Front saddle gib adjustment screw.**

**Note:** Remove the carriage lock clamp to access the saddle gib adjustment screw on the tailstock side (see **Figure 129**).



**Figure 129. Carriage lock clamp.**

**Note:** Before adjusting the tailstock gib, loosen the hex bolts underneath both ends of the tailstock (see **Figure 130**) to release the clamping pressure between the upper and lower castings. Test the gib adjustment by using the offset adjustment screws. When you are satisfied with the setting, retighten the clamping hex bolts.



**Figure 130. Tailstock gib adjustment controls.**

## Backlash Adjustment

Backlash is the amount of free play felt while switching rotation directions with the handwheel. This can be adjusted on the compound rest and cross slide leadscrews. Before beginning any adjustment, make sure that all associated components have been cleaned and lubricated.

### **NOTICE**

**Reducing backlash to less than 0.002" is impractical and can lead to accelerated wear of the wedge, nut, and leadscrew. Avoid the temptation to overtighten the backlash set screw while adjusting.**

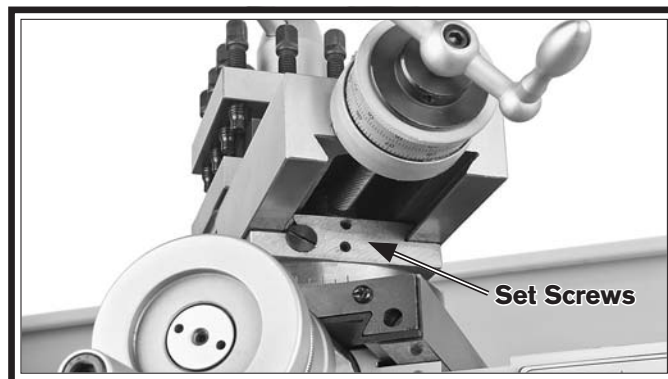
## Compound Rest

**Tools Needed:** **Qty**  
Hex Wrench 3mm ..... 1

The compound rest backlash is adjusted by tightening the set screws shown in **Figure 131**. When these screws are adjusted against the leadscrew nut, they offset part of the nut to remove play between the nut and leadscrew.

To adjust the backlash, rock the handwheel back-and-forth, and tighten the screws slowly until the backlash is at approximately 0.002"–0.003" as indicated on the handwheel dial.

If you end up adjusting the nut too tight, loosen the set screws, tap the compound rest a few times with a rubber or wooden mallet, and turn the handwheel slowly back-and-forth until it moves freely, then try again.



**Figure 131. Compound rest backlash adjustment set screws.**

## Cross Slide

### Tools Needed:

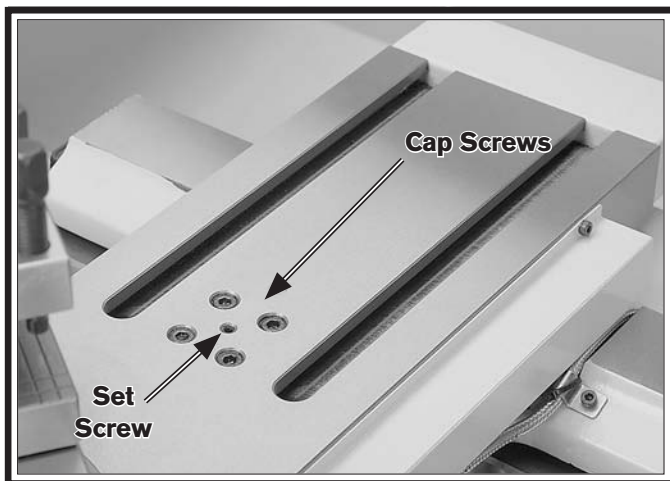
	Qty
Hex Wrench 3mm .....	1
Hex Wrench 5mm .....	1

The cross slide backlash is adjusted by loosening all four cap screws shown in **Figure 132**, then tightening the center set screw. This will push down on a wedge and force the leadscrew nut apart, taking up lash in the nut and leadscrew.

To adjust the backlash, remove the compound rest, then rock the cross slide handwheel back-and-forth and tighten the set screw slowly until the backlash is at approximately 0.002"–0.003" as indicated on the handwheel dial.

If you end up adjusting the nut too tight, loosen the set screw, tap the cross slide a few times with a rubber or wooden mallet, and turn the handwheel slowly back-and-forth, until the handle turns freely, then try again.

Remember to retighten the four cap screws when you are finished.



**Figure 132. Cross slide backlash adjustment screws.**

## Leadscrew End Play Adjustment

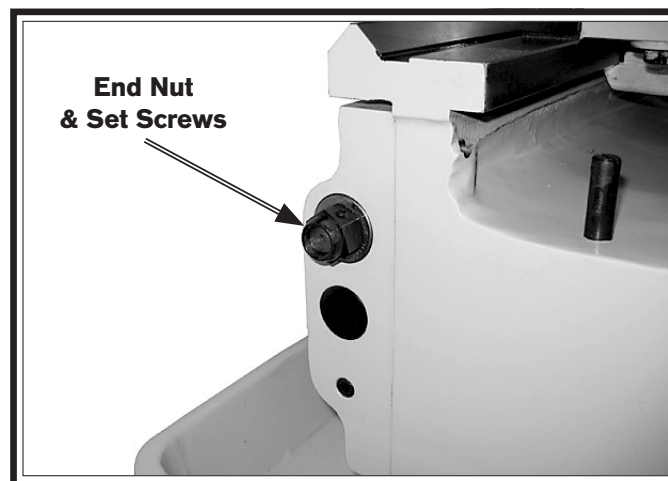
Over time, you may find that the leadscrew develops a small amount of end play. This lathe is designed so that leadscrew end play can be easily minimized by following this procedure.

### Tools Needed:

	Qty
Hex Wrench 3mm .....	1
Wrench 24mm .....	1

### To remove leadscrew end play:

1. DISCONNECT LATHE FROM POWER!
2. Loosen the two set screws in the leadscrew end nut (see **Figure 133**).



**Figure 133. Leadscrew end nut.**

3. Engage the halfnut with the leadscrew.
4. Rotate the carriage handwheel back slightly, then tighten the end nut at the same time until the end play is removed.
5. Retighten both set screws.

## Halfnut Adjustment

The halfnut can be tightened if it becomes loose from wear. The pressure the halfnut exerts on the leadscrew is controlled by a gib which is adjusted with two set screws.

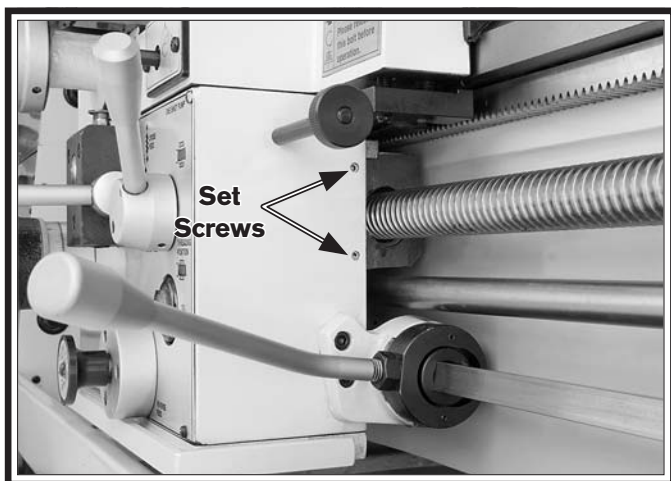
### Tool Needed:

Hex Wrench 3mm ..... 1

Qty

### To adjust the halfnut:

1. Disengage the halfnut.
2. Remove the thread dial.
3. Turn the two halfnut adjustment set screws, shown in **Figure 134**, clockwise about  $\frac{1}{8}$  of a turn.



**Figure 134. Halfnut gib adjustment.**

4. Engage/disengage the halfnut several times and notice how it feels (you may need to move the carriage handwheel slightly to get the halfnut to close).

The halfnut is correctly adjusted when it has a slight drag while opening and closing. The movement should not be too stiff or too sloppy.

5. Repeat **Steps 3–4**, if necessary, until you are satisfied with the halfnut adjustment. If the halfnut becomes too stiff, turn the set screws counterclockwise to loosen it.
6. Re-install the thread dial.

## Feedrod Clutch Adjustment

This lathe has an adjustable feed clutch that helps protect the drive train from overload or when using the adjustable feed stop. The feed clutch release point is adjusted at the factory. However, it can be easily re-adjusted depending on operator requirements.

### NOTICE

**Making the feed clutch too tight defeats its purpose and could lead to carriage crash and lathe damage.**

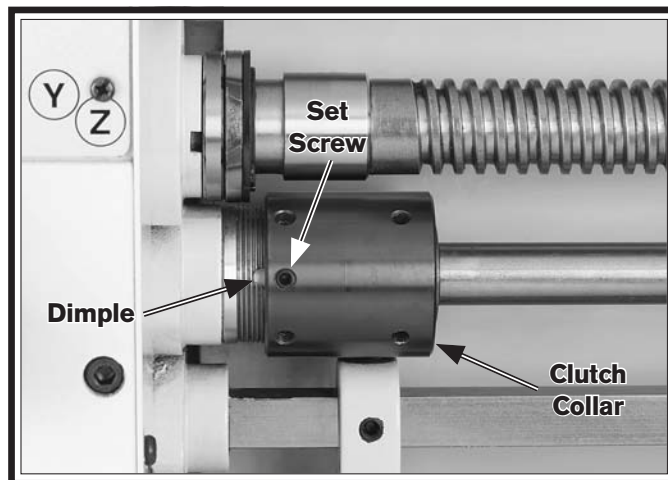
### Tool Needed:

Hex Wrench 3mm ..... 1

Qty

### To adjust the clutch release point:

1. DISCONNECT LATHE FROM POWER!
2. Move the feed range lever on the headstock to the neutral (middle) position.
3. Open the headstock left cover, then rotate the bottom end gear by hand until you can access the set screw in the clutch collar, as shown in **Figure 135**.



**Figure 135. Feedrod clutch collar.**

4. In case you need to return to the starting point, mark the set screw hole and the rotational position of the collar on the feedrod for a reference.
5. Remove the set screw.
6. Insert the hex wrench into one of the holes on the collar, then rotate the collar.
  - If you need to increase the release point, rotate the collar upward.
  - If you need to decrease the release point, rotate the collar downward.
7. Line up one of the available set screw holes on the collar with the nearest dimple in the feedrod, then re-install the set screw and fully tighten it.

## V-Belts

V-belts stretch and wear with use, so check them on a monthly basis to ensure optimal power transmission. Replace the V-belts as a matched set if even one of them shows signs of glazing, fraying, or cracking.

### Tools Needed:

	<b>Qty</b>
Phillips Screwdriver #2 .....	1
Open End Wrench 24mm.....	1

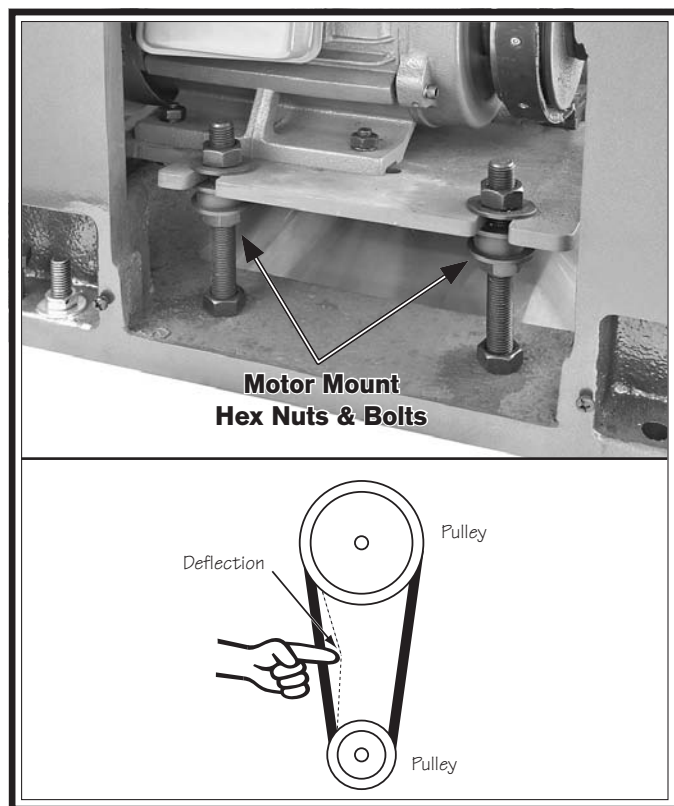
### To adjust the V-belts:

1. DISCONNECT LATHE FROM POWER!
2. Remove the headstock left cover and the motor access panel to expose the V-belts and pulleys (see **Figure 136**)



Figure 136. End gear cover and motor access panel.

- Adjust the hex nuts on the motor mount bolts shown in **Figure 137**, until there is approximately  $\frac{3}{4}$ " deflection of the V-belts when moderate pressure is applied midway between the pulleys.



**Figure 137. Adjusting V-belt tension.**

- Firmly tighten the hex nuts to secure the setting, then re-install the covers.

## Brake & Switch

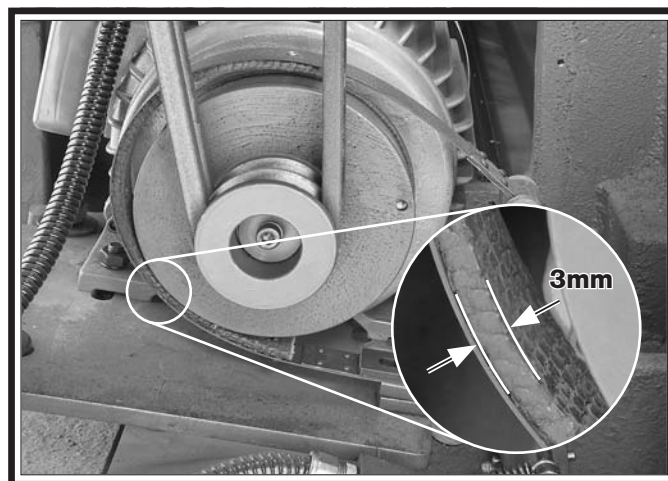
As the brake lining wears, the foot pedal develops more travel. If the brake band is not adjusted to compensate for normal wear, the limit switch will still turn the lathe off, but the spindle will not stop as quickly. It is especially important that the brake is kept properly adjusted so you can quickly stop the spindle in an emergency.

### Tools Needed:

	<b>Qty</b>
Phillips Screwdriver #2 .....	1
Hex Wrench 6mm .....	1

### To adjust the brake and brake switch:

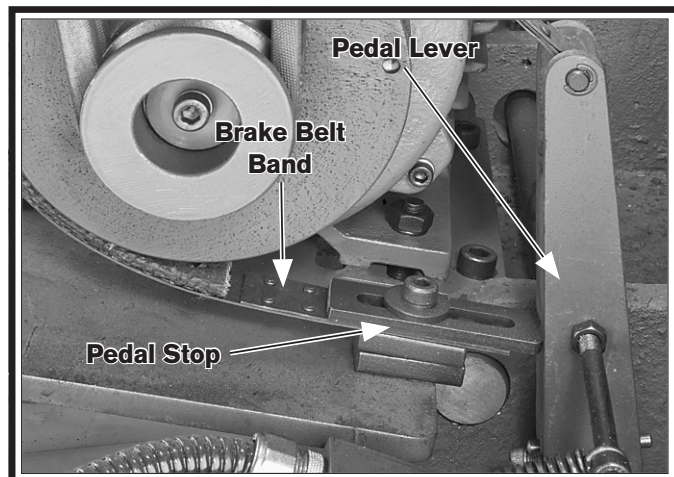
- DISCONNECT LATHE FROM POWER!
- Put on a respirator and eye protection to protect yourself from hazardous brake dust.
- Remove the motor access panel from the left cabinet.
- Measure the remaining brake band lining at the thinnest point, which is usually at the 8 o'clock position, as shown in **Figure 138**.



**Figure 138. Minimum brake belt thickness.**

When the brake band is new, the lining is approximately 6mm thick. If the lining thickness wears to 3mm or less, the brake band must be replaced. Otherwise, the rivets that secure the lining to the band will soon grind into the brake hub. If the hub becomes damaged, it must be replaced.

5. Remove the pedal stop shown in **Figure 139**.



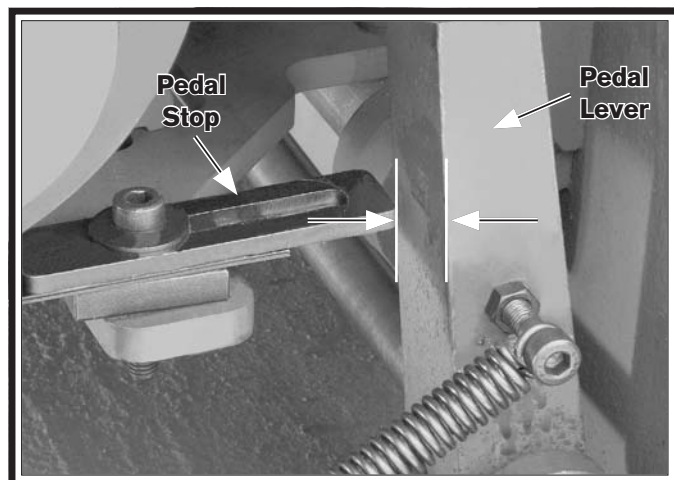
**Figure 139. Brake belt adjustment components.**

6. Move the brake band to the right one hole, and re-install the pedal stop, tightening the cap screw until it is just snug.

**Note:** If installing a new brake band, install the cap screw so there is one hole to the left for future brake adjustment.

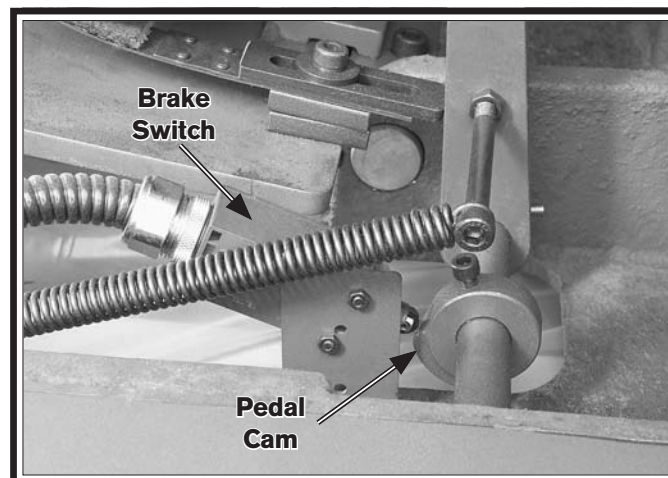
7. Firmly push the pedal lever to the right until it stops and the brake band is fully clamped around the brake hub.

8. Tap the pedal stop into position so there is approximately a 25mm gap between the pedal lever and the stop (see **Figure 140**), then firmly tighten the pedal stop cap screw.



**Figure 140. Brake pedal travel adjustment.**

9. Locate the brake switch shown in **Figure 141**.



**Figure 141. Brake switch and pedal cam.**

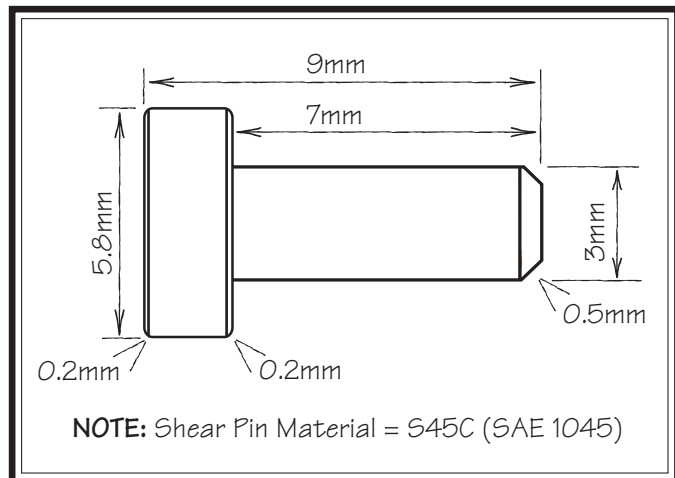
10. Push the pedal lever down to verify that the cam lobe pushes the brake switch plunger in. When pushed in, the switch should click.

— If the switch does not click, loosen the switch mounting screws, push the brake pedal all the way down, and move the switch closer to the lobe until it clicks. Secure the switch in place at this location.

**Note:** In the released position, there should be an approximate 3mm gap between the switch plunger and the cam lobe.

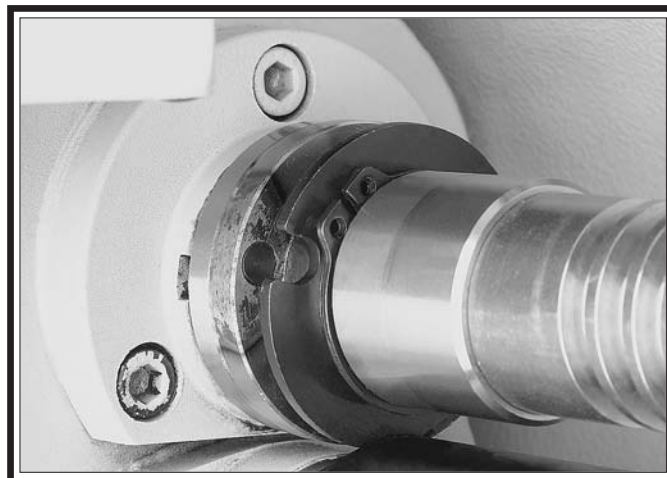
11. Re-install the motor access panel, connect the lathe to power, then test the brake pedal. If you are not satisfied with the brake performance, repeat this procedure until you are.

# Leadscrew Shear Pin Replacement



**Figure 142. Shear pin specifications.**

3. Put on safety glasses.
4. Move the retaining ring shown in **Figure 144** away from the shroud washer.



**Figure 144. Shear pin access.**

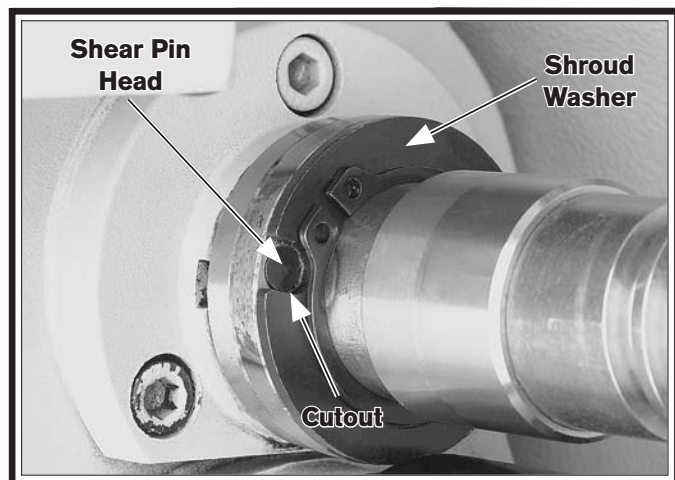
**Tools Needed:**

**Qty**

External Retaining Ring Pliers #1 .....	1
Magnet.....	1
Safety Glasses .....	1
Blow Gun w/Compressed Air.....	1
Light Machine Oil .....	As needed

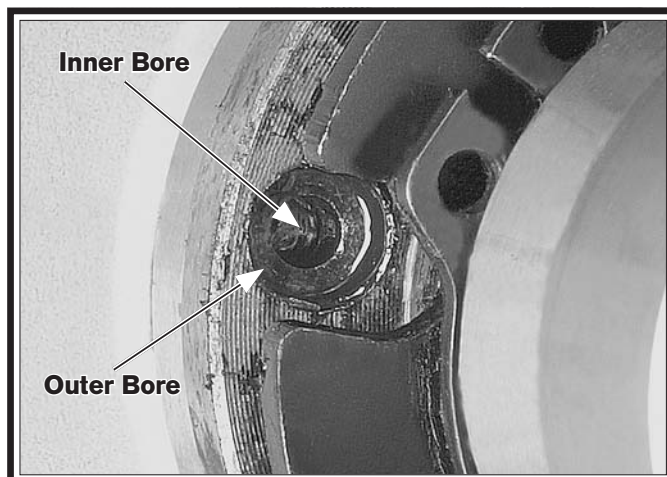
**To replace the shear pin:**

1. DISCONNECT LATHE FROM POWER!
2. Rotate the shroud washer on the leadscrew shown in **Figure 143**, so that the cutout lines up with the shear pin head.



**Figure 143. Shroud washer and shear pin alignment.**

5. To make enough room to remove the shear pin, move the shroud washer away from the shear pin and against the retaining ring, as shown in **Figure 144**.
6. Use the magnet to remove the shear pin head, then rotate the lathe spindle to line up the inner and outer bores, as shown in **Figure 145**. Next, use the magnet to remove the other half of the broken shear pin when it becomes visible.



**Figure 145. Shear pin bores aligned.**

7. Insert the blow gun tip into the shear pin hole, blow out the hole with compressed air, then put a drop of oil in the hole.

## NOTICE

If you fabricate your own shear pin replacement, make sure that you use the material and dimensions contained in Figure 142 on the previous page. Otherwise, the shear pin may not provide the intended protection and lathe damage could result.

8. Insert the new shear pin into the bore, as shown in Figure 146.

**Note:** If the pin does not freely slide into the bore, DO NOT use a hammer on the pin or you may permanently damage the shear mechanism and bore, which would make it nearly impossible to remove and install a new shear pin later.

Instead, take the time to carefully line up the two bores. You may need to file a slight chamfer on the end of the pin to make it easier to insert.



Figure 146. New shear pin installed in bore.

9. With the pin completely seated in the bore and the head flush with the leadscrew shoulder, slide the shroud washer against the shoulder, then rotate the washer 180° to completely cover the head of the shear pin, as shown in Figure 147.

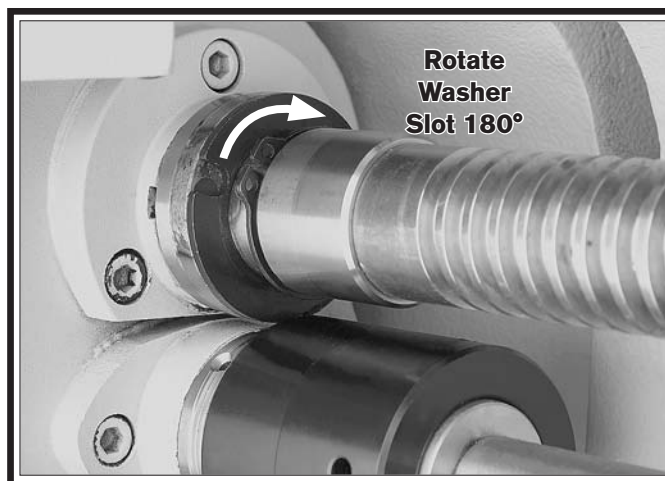


Figure 147. Shroud washer positioning.

10. Return the retaining ring against the shroud washer and position the retaining ring ears over the shear pin head, as shown in Figure 148. This will prevent the shear pin from falling out if the shroud washer should rotate during operation.

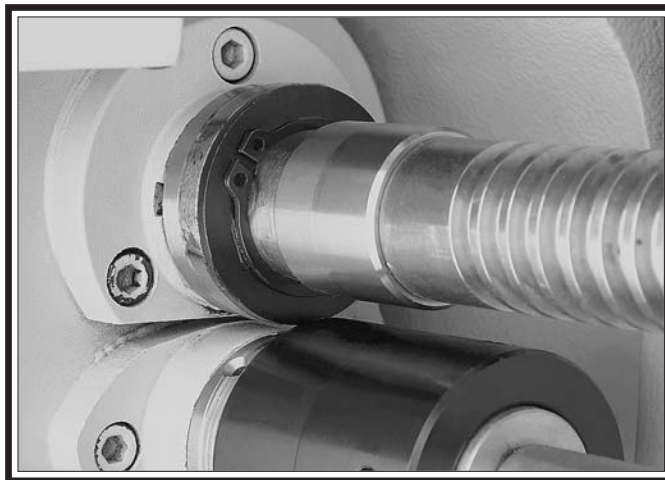
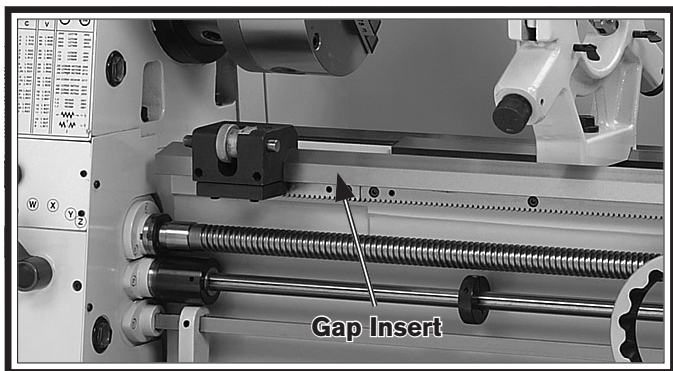


Figure 148. Retaining ring positioned with ears in front of pin access groove.

# Gap Insert Removal & Installation

The gap insert directly under the spindle (see **Figure 149**) can be removed to create additional space for turning large diameter parts.

The gap insert was installed, then ground flush with the bed at the factory to ensure a precision fit and alignment. Therefore, if the gap insert is removed, it may be difficult to re-install it with the same degree of accuracy.

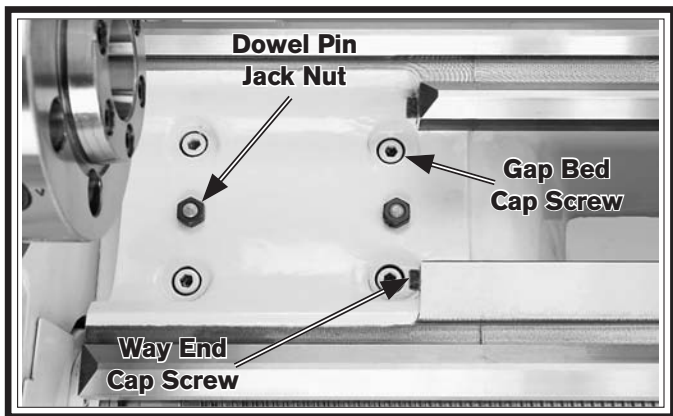


**Figure 149. Gap insert.**

<b>Tools Needed:</b>	<b>Qty</b>
Hex Wrenches 6mm .....	1
Hex Wrench 8mm .....	1
Wrench 17mm .....	1
Dead Blow Hammer.....	1

## Gap Removal

1. Remove the four gap bed cap screws, shown in **Figure 150**, that secure the gap insert to the bed.



**Figure 150. Fasteners holding gap in place.**

2. Remove the two way end cap screws.
3. Tighten the two dowel pin jack nuts until the pins are pulled free from the gap insert.
4. Tap the outside of the gap insert with a dead blow hammer to loosen it, then remove it.

## Gap Installation

1. Use mineral spirits and a clean lint-free rag to clean the mating surfaces of the gap, bed, and ways. If necessary, stone the mating surfaces to remove scratches, dings, or burrs.
2. Wipe a thin layer of light machine oil on the mating surfaces.
3. Place the gap insert into the gap and use a dead-blow hammer to align the insert with the lathe bed.
4. Back off the dowel pin jack nuts, and lightly tap the dowel pins back into their respective holes until they are seated. This process will further help align the gap insert and bed mating surfaces.
5. Install all fasteners and lightly snug them in place.
6. Mount a magnetic-based dial indicator to the top of the saddle to indicate alignment.
7. First test the peak of the two prisms of the gap insert that the saddle rides on, then test the flanks of the prisms. Alternately tighten the gap bed cap screws and tap the side of the gap insert into alignment.
8. Inspect the gap alignment 24 hours later to make sure the gap is still aligned. If not, loosen the gap bed cap screws and repeat **Step 7** until the insert is properly aligned.

If you need replacement parts, or if you are unsure how to do any of the solutions given here, feel free to call us at (360) 734-1540.

Symptom	Possible Cause	Possible Solution
Machine does not start or a circuit breaker trips.	<ol style="list-style-type: none"> <li>(First time operation only) Lathe is wired out of phase.</li> <li>Stop button is engaged or at fault.</li> <li>Spindle switch(es) are at fault.</li> <li>Power supply is switched <b>OFF</b> at master power switch or breaker.</li> <li>Wall fuse/circuit breaker is blown/tripped; short in electrical system; start-up load too high for circuit.</li> <li>Fuse has blown in machine electrical box due to thermal overload.</li> <li>One or more safety switches or brake switch are engaged.</li> <li>Thermal overload relay has tripped.</li> <li>Motor connection wired incorrectly.</li> <li>Safety/brake switch(es) at fault.</li> <li>Contactors not getting energized/has burned contacts.</li> <li>Wiring is open/has high resistance.</li> <li>Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>Correct out-of-phase wiring (refer to <b>Page 90</b> for details).</li> <li>Rotate button clockwise until it pops out to reset it for operation; replace if not working properly.</li> <li>Replace bad switch(es).</li> <li>Make sure master power switch and circuit breaker are turned <b>ON</b>.</li> <li>Verify circuit is rated for machine amp load; troubleshoot and repair cause of overload; replace weak breaker; find/repair electrical short.</li> <li>Replace fuse; determine if overload is due to heavy operation; ensure power source has high enough voltage and power cord is correctly sized.</li> <li>Verify electrical box door, chuck guard, spindle, and brake switches are not engaged.</li> <li>Turn the thermal relay cut-out dial to increase working amps and push the reset pin. Replace if tripped multiple times (weak relay).</li> <li>Correct motor wiring connections.</li> <li>Test all switches and replace as necessary.</li> <li>Test for power on all legs and contactor operation. Replace unit if faulty.</li> <li>Check for broken wires or disconnected/corroded connections, and repair/replace as necessary.</li> <li>Test/repair/replace.</li> </ol>
Loud, repetitious noise coming from lathe at or near the motor.	<ol style="list-style-type: none"> <li>Pulley set screws or keys are missing or loose.</li> <li>Motor fan is hitting the cover.</li> </ol>	<ol style="list-style-type: none"> <li>Inspect keys and set screws. Replace or tighten if necessary.</li> <li>Tighten fan, shim cover, or replace items.</li> </ol>
Motor overheats.	<ol style="list-style-type: none"> <li>Motor overloaded.</li> </ol>	<ol style="list-style-type: none"> <li>Reduce load on motor.</li> </ol>
Motor is loud when cutting, or bogs down under load.	<ol style="list-style-type: none"> <li>Excessive depth of cut or feed rate.</li> <li>Spindle speed or feed rate wrong for cutting operation.</li> <li>Cutting tool is dull.</li> </ol>	<ol style="list-style-type: none"> <li>Decrease depth of cut or feed rate.</li> <li>Refer to the feeds and speeds charts in <b>Machinery's Handbook</b> or a speeds and feeds calculator on the internet.</li> <li>Sharpen or replace the cutting tool.</li> </ol>

Symptom	Possible Cause	Possible Solution
Entire machine vibrates upon startup and while running.	<ol style="list-style-type: none"> <li>1. Workpiece is unbalanced.</li> <li>2. Loose or damaged V-belt(s).</li> <li>3. V-belt pulleys are not properly aligned.</li> <li>4. Worn or broken gear present.</li> <li>5. Chuck or faceplate is unbalanced.</li> <li>6. Gears not aligned in headstock or no backlash.</li> <li>7. Broken gear or bad bearing.</li> <li>8. Workpiece is hitting stationary object.</li> <li>9. Spindle bearings at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Re-install workpiece as centered with the spindle bore as possible.</li> <li>2. Re-tension/replace the V-belt(s) as necessary (see <b>Page 80</b>).</li> <li>3. Align the V-belt pulleys.</li> <li>4. Inspect gears and replace if necessary.</li> <li>5. Re-balance chuck or faceplate; contact a local machine shop for help.</li> <li>6. Adjust gears and establish backlash.</li> <li>7. Replace broken gear or bearing.</li> <li>8. Stop lathe immediately and correct interference problem.</li> <li>9. Reset spindle bearing preload or replace worn spindle bearings.</li> </ol>
Bad surface finish.	<ol style="list-style-type: none"> <li>1. Wrong spindle speed or feed rate.</li> <li>2. Dull tooling or poor tool selection.</li> <li>3. Tool height not at centerline.</li> <li>4. Too much play in gibs.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust for appropriate spindle speed and feed rate.</li> <li>2. Sharpen tooling or select a better tool for the intended operation.</li> <li>3. Adjust tool height to centerline (see <b>Page 49</b>).</li> <li>4. Tighten gibs (see <b>Page 76</b>).</li> </ol>
Tapered tool difficult to remove from tailstock quill.	<ol style="list-style-type: none"> <li>1. Quill is not retracted all the way back into the tailstock.</li> <li>2. Contaminants not removed from taper before inserting into quill.</li> </ol>	<ol style="list-style-type: none"> <li>1. Turn the tailstock handwheel until it forces the tapered tool out of quill.</li> <li>2. Clean the taper and bore and re-install tapered tool.</li> </ol>
Cross slide, compound, or carriage feed has sloppy operation.	<ol style="list-style-type: none"> <li>1. Gibs are out of adjustment.</li> <li>2. Handwheel is loose or backlash is high.</li> <li>3. Leadscrew mechanism worn or out of adjustment.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust gib screw(s) (see <b>Page 76</b>).</li> <li>2. Tighten handwheel fasteners, adjust handwheel backlash to a minimum (see <b>Page 77</b>).</li> <li>3. Adjust leadscrew to remove end play (see <b>Page 78</b>).</li> </ol>
Cross slide, compound, or carriage feed handwheel is hard to move.	<ol style="list-style-type: none"> <li>1. Dovetail slides loaded with shavings, dust, or grime.</li> <li>2. Gib screws are too tight.</li> <li>3. Backlash setting too tight (cross slide only).</li> <li>4. Bedways are dry.</li> </ol>	<ol style="list-style-type: none"> <li>1. Remove gibs, clean ways/dovetails, lubricate, and re-adjust gibs.</li> <li>2. Loosen gib screw(s) slightly, and lubricate bedways (see <b>Page 76</b>).</li> <li>3. Slightly loosen backlash setting (see <b>Page 78</b>).</li> <li>4. Lubricate bedways and handles.</li> </ol>
Cutting tool or machine components vibrate excessively during cutting.	<ol style="list-style-type: none"> <li>1. Tool holder not tight enough.</li> <li>2. Cutting tool sticks too far out of tool holder; lack of support.</li> <li>3. Gibs are out of adjustment.</li> <li>4. Dull cutting tool.</li> <li>5. Incorrect spindle speed or feed rate.</li> </ol>	<ol style="list-style-type: none"> <li>1. Check for debris, clean, and retighten.</li> <li>2. Re-install cutting tool so no more than <math>\frac{1}{3}</math> of the total length is sticking out of tool holder.</li> <li>3. Adjust gib screws at affected component (see <b>Page 76</b>).</li> <li>4. Replace or resharpen cutting tool.</li> <li>5. Use the recommended spindle speed.</li> </ol>

<b>Symptom</b>	<b>Possible Cause</b>	<b>Possible Solution</b>
Workpiece is tapered.	<ol style="list-style-type: none"> <li>1. Headstock and tailstock are not properly aligned with each other.</li> </ol>	<ol style="list-style-type: none"> <li>1. Realign the tailstock to the headstock spindle bore centerline (see <b>Page 45</b>).</li> </ol>
Chuck jaws will not move or do not move easily.	<ol style="list-style-type: none"> <li>1. Chips lodged in the jaws or scroll plate.</li> </ol>	<ol style="list-style-type: none"> <li>1. Remove jaws, clean and lubricate scroll plate, then replace jaws.</li> </ol>
Carriage will not feed, or is hard to move.	<ol style="list-style-type: none"> <li>1. Gears are not all engaged.</li> <li>2. Loose screw on the feed handle.</li> <li>3. Carriage lock is tightened down.</li> <li>4. Chips have loaded up on bedways.</li> <li>5. Bedways are dry and in need of lubrication.</li> <li>6. Carriage stop is interfering.</li> <li>7. Gibs are too tight.</li> <li>8. Gears or shear pin broken.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust gear levers.</li> <li>2. Tighten.</li> <li>3. Check to make sure the carriage lock bolt is fully released.</li> <li>4. Frequently clean away chips that load up during turning operations.</li> <li>5. Lubricate bedways and handles.</li> <li>6. Check carriage stop position, and adjust it as necessary (see <b>Page 51</b>).</li> <li>7. Loosen gib screw(s) slightly (see <b>Page 76</b>).</li> <li>8. Replace gears or shear pin (see <b>Page 83</b>).</li> </ol>
Gear change levers will not shift into position.	<ol style="list-style-type: none"> <li>1. Gears not aligned inside headstock.</li> </ol>	<ol style="list-style-type: none"> <li>1. Rotate spindle by hand with light pressure on the lever until gear falls into place.</li> </ol>

# Electrical Safety Instructions

These pages are accurate at the time of printing. In the constant effort to improve, however, we may make changes to the electrical systems of future machines. Study this section carefully. If you see differences between your machine and what is shown in this section, call Technical Support at (360) 734-1540 for assistance BEFORE making any changes to the wiring on your machine.

- Shock Hazard:** It is extremely dangerous to perform electrical or wiring tasks while the machine is connected to the power source. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. For your own safety, disconnect machine from the power source before servicing electrical components or performing any wiring tasks!
- Wire Connections:** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.
- Modifications:** Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.
- Motor Wiring:** The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.
- Circuit Requirements:** Connecting the machine to an improperly sized circuit will greatly increase the risk of fire. To minimize this risk, only connect the machine to a power circuit that meets the minimum requirements given in this manual.
- Capacitors/Inverters:** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.
- Wire/Component Damage:** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components before completing the task.
- Experiencing Difficulties:** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (360) 734-1540.

## WIRING DIAGRAM COLOR KEY

BLACK — Bk	BLUE WHITE — Bw	RED — Rd	PINK — Pk	WHITE — Wt
BLUE — Bl	GREEN — Gn	LIGHT BLUE — Lb	PURPLE — Pu	YELLOW GREEN — Yg
BROWN — Br	GRAY — Gy	ORANGE — Or	TUR-QUIOSE — Tu	YELLOW — Yl

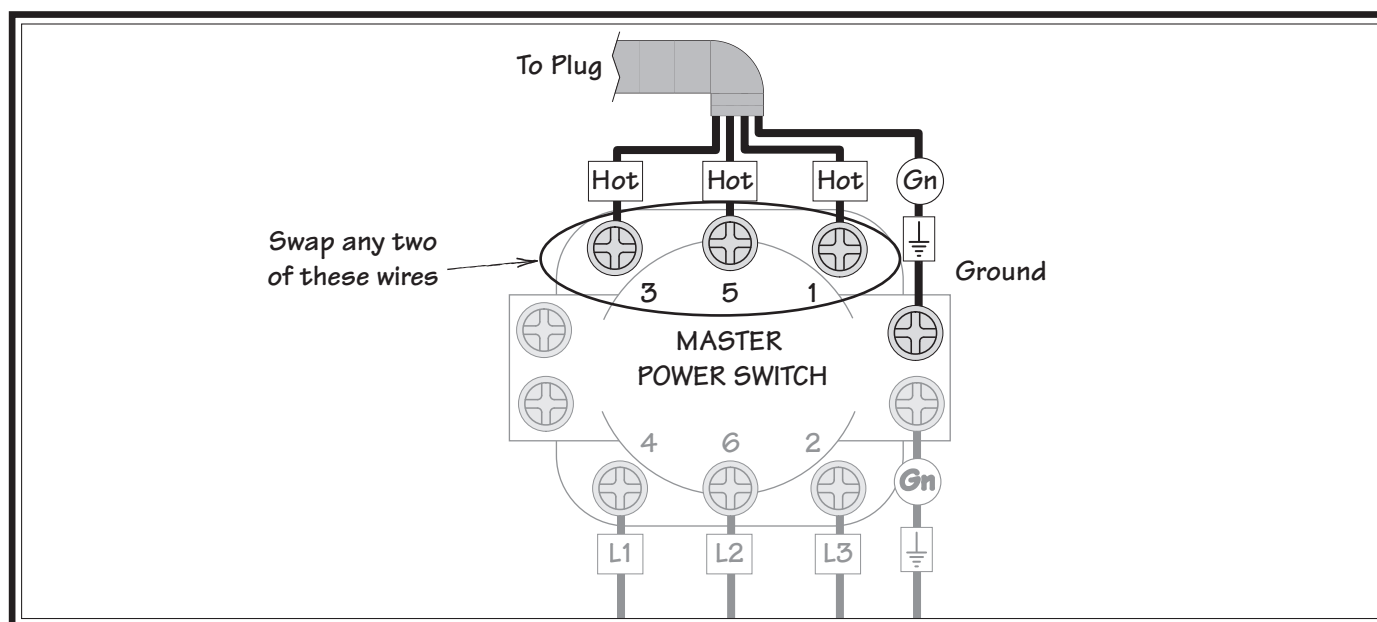
**NOTICE:** The photos and diagrams included in this section are best viewed in color. You can see them in color at [www.southbendlathe.com](http://www.southbendlathe.com).

## Correcting Phase Polarity Wiring

This sub-section is only provided for troubleshooting. If you discover during the test run that the lathe will not operate, or that the spindle runs backwards, the lathe may be wired out of phase. Without the proper test equipment to determine the phase of power source legs, wiring machinery to 3-phase power may require trial-and-error. Correcting this is simply a matter of reversing the positions where two of the incoming power source wires are connected.

### To correct wiring that is out of phase:

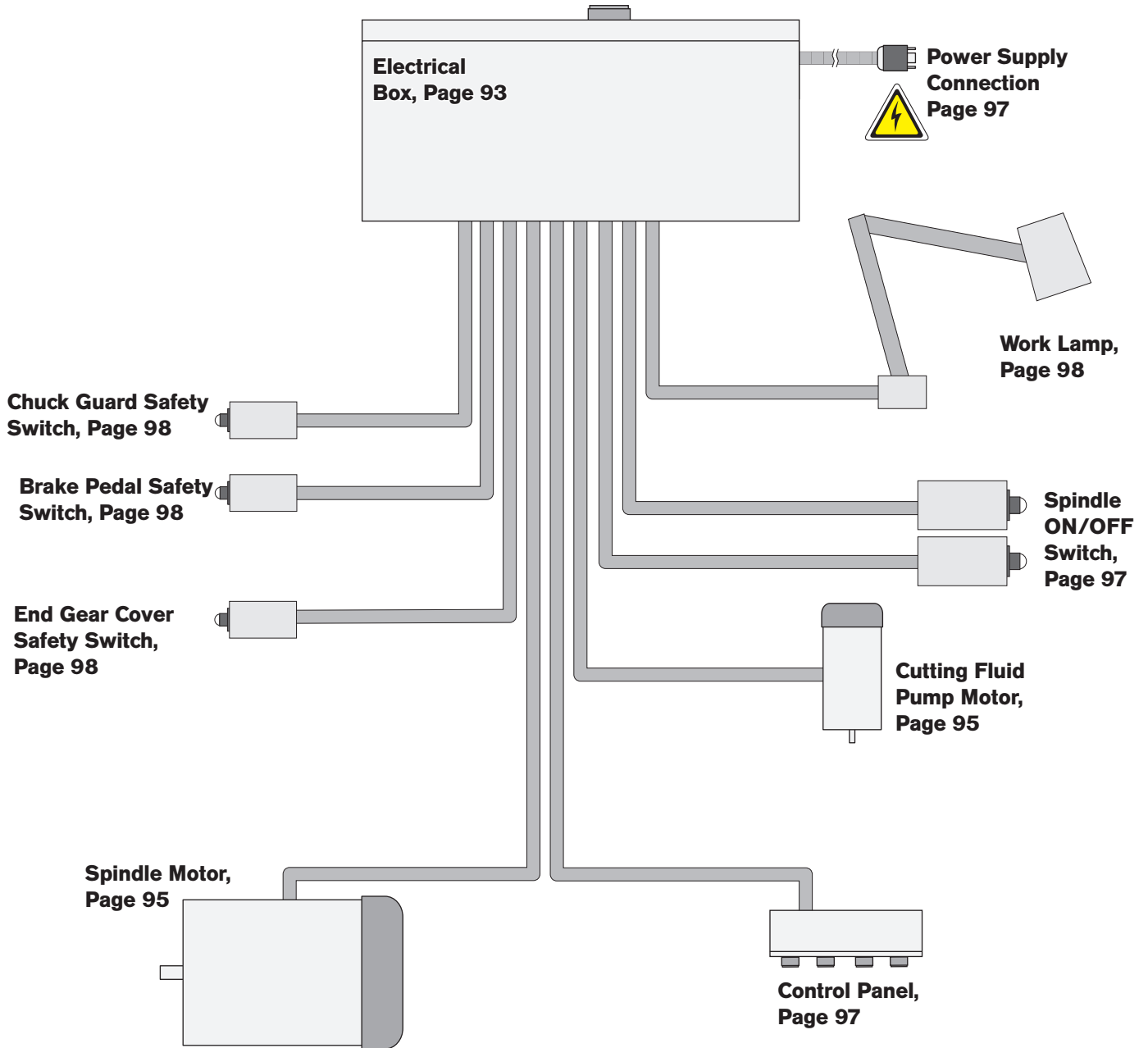
1. Push the STOP button, turn the master power switch to OFF, and disconnect the machine from power.
2. Open the electrical box and swap any two hot wires coming from the plug, as illustrated in **Figure 151**.



**Figure 151. Swapping L1 and L2 power connections to correct out-of-phase wiring.**

3. Close and latch the electrical box, and reconnect the machine to the power source.

# Wiring Overview



# Component Location Index

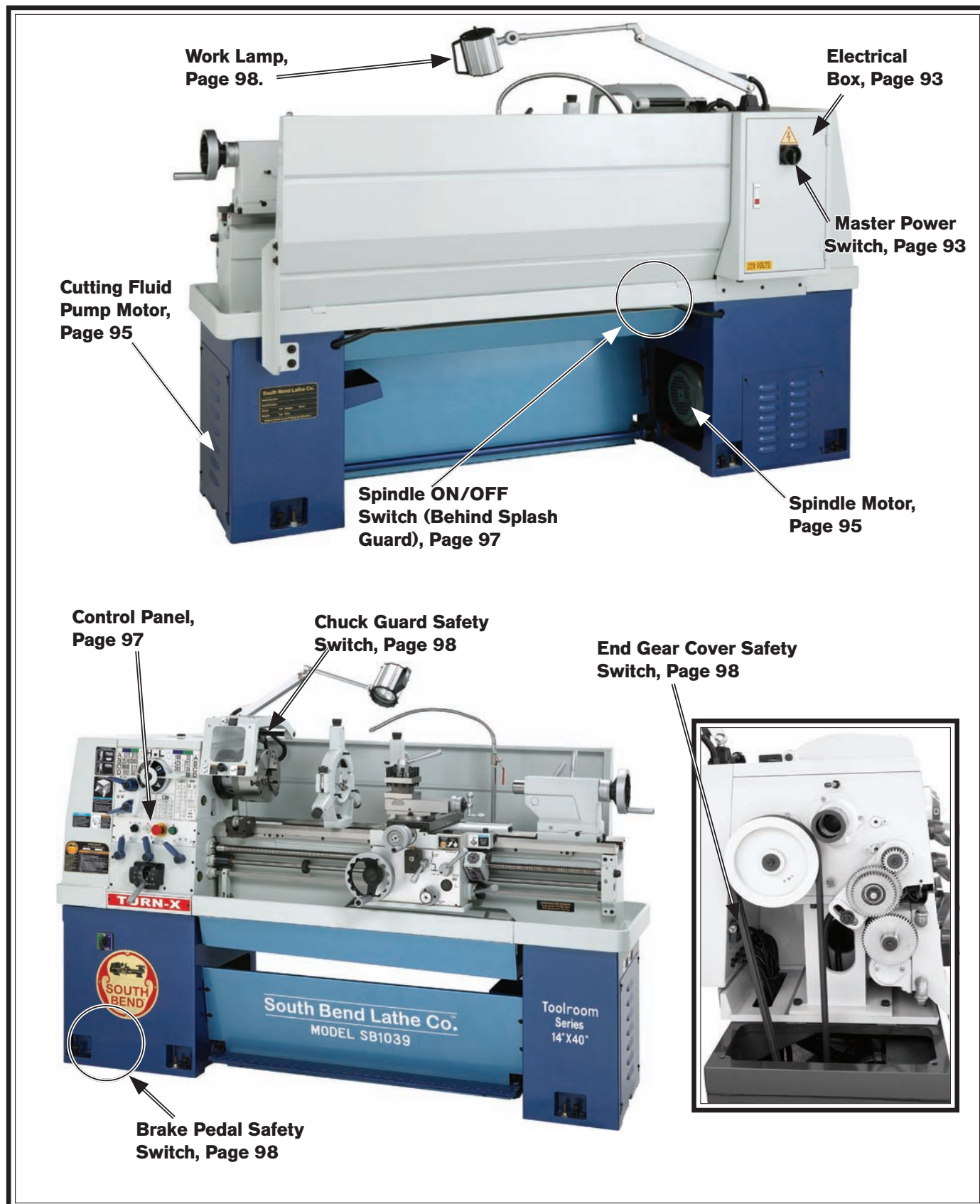
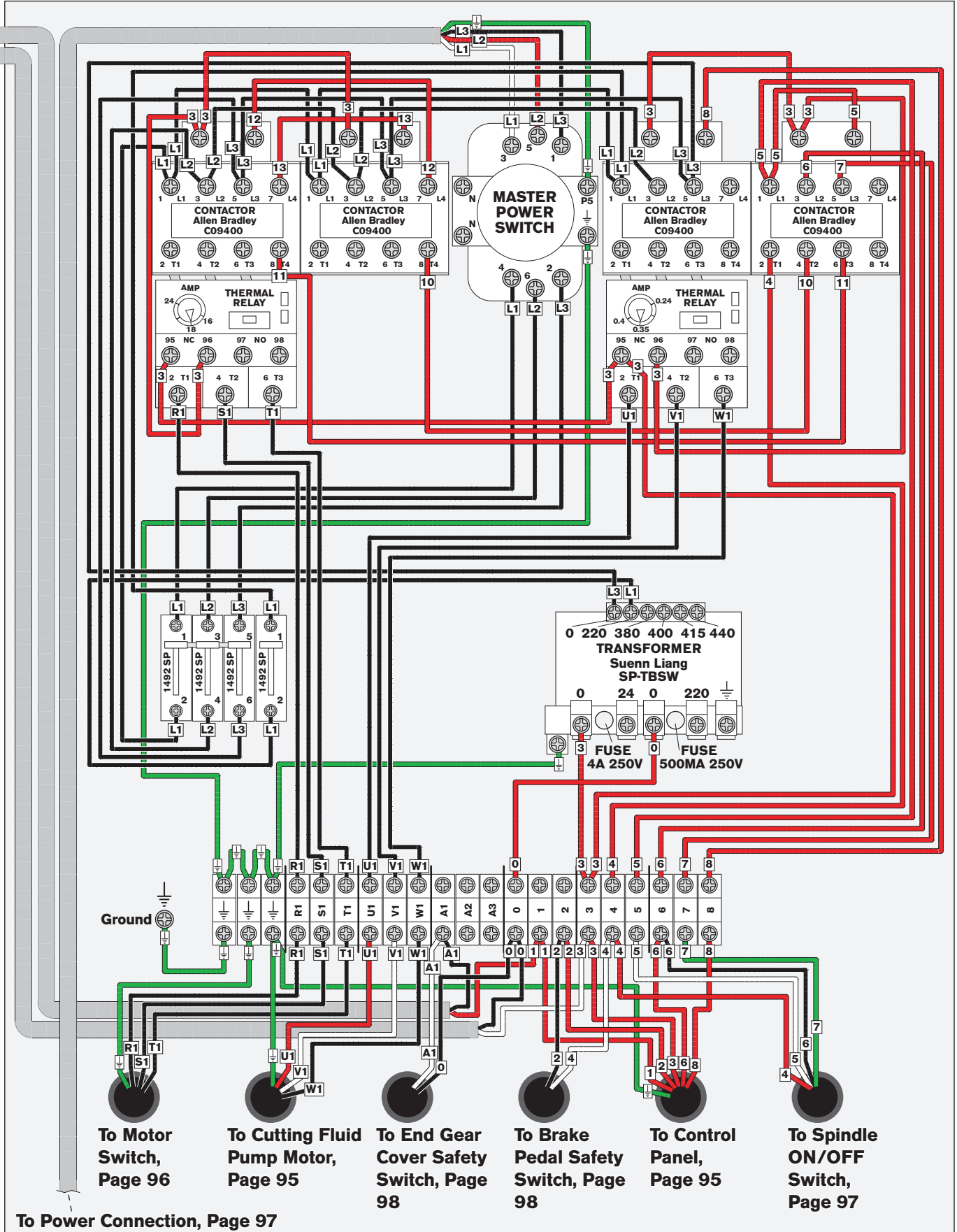


Figure 152. Component location index.

# Electrical Box Wiring

To Work Lamp, Page 97

To Chuck Guard Safety Switch, Page 97



# Electrical Box

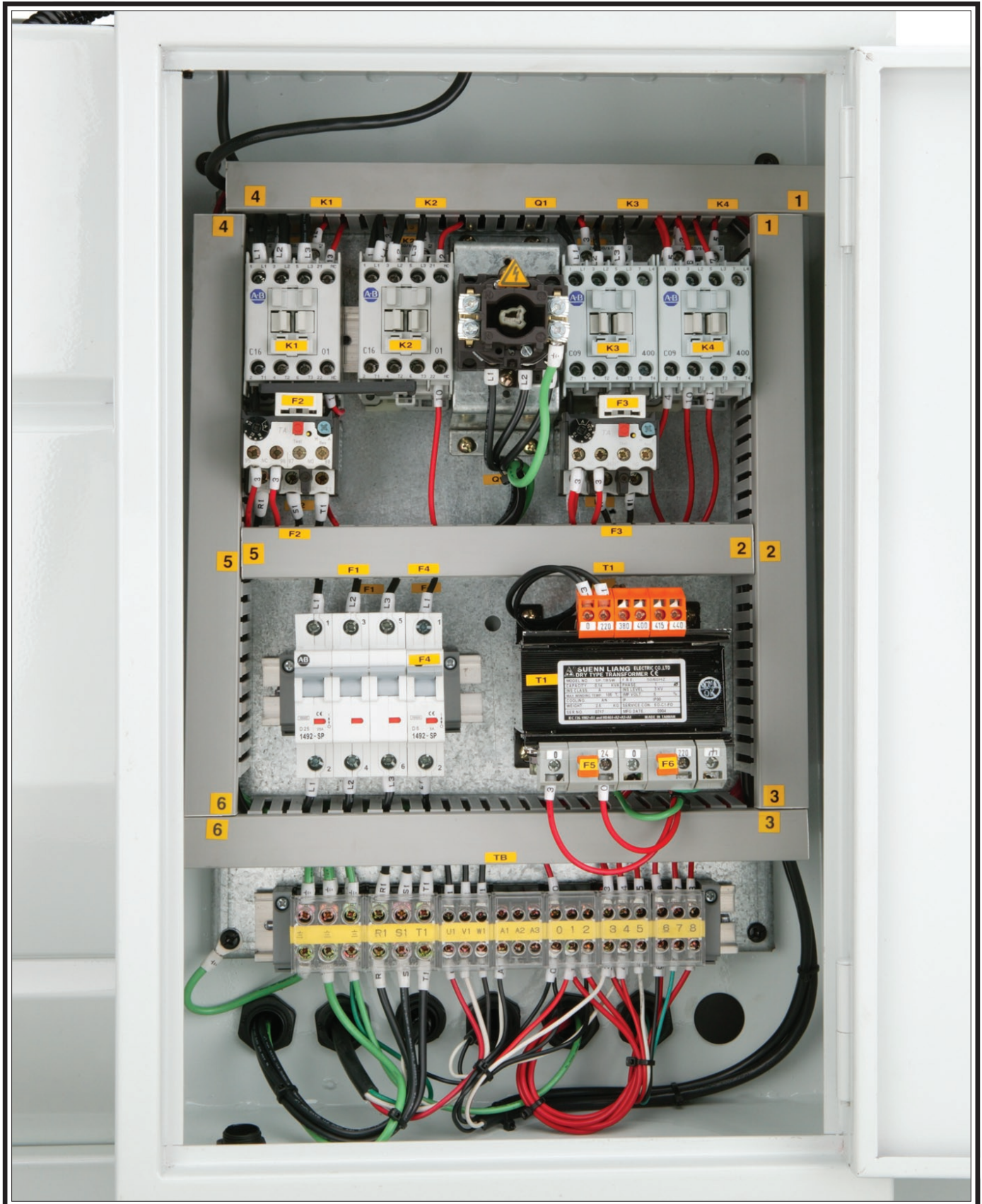


Figure 153. Electrical box.

# Spindle Motor

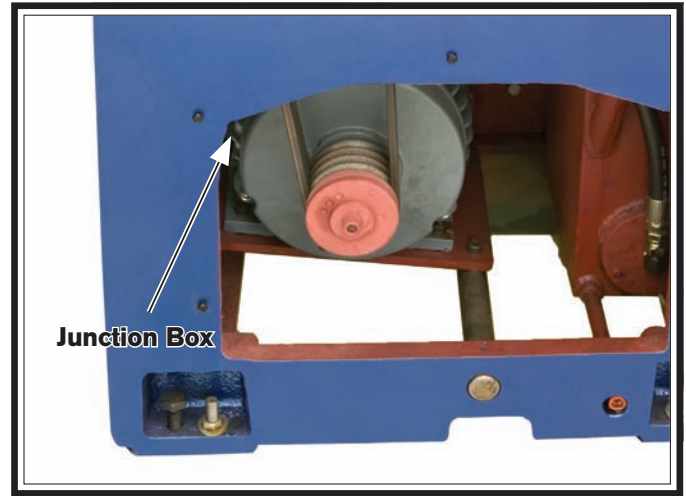
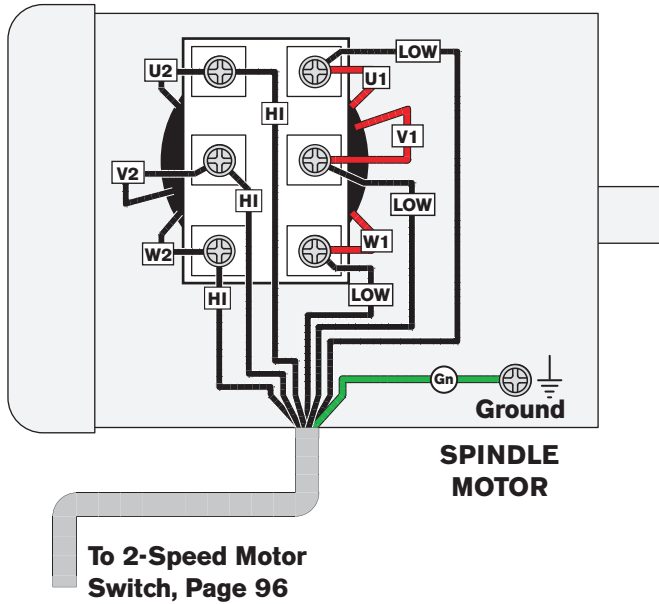


Figure 154. Spindle motor location.

# Cutting Fluid Pump Wiring

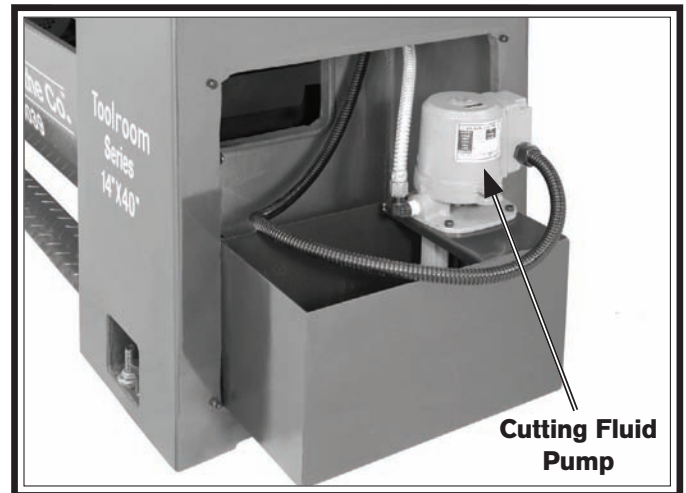
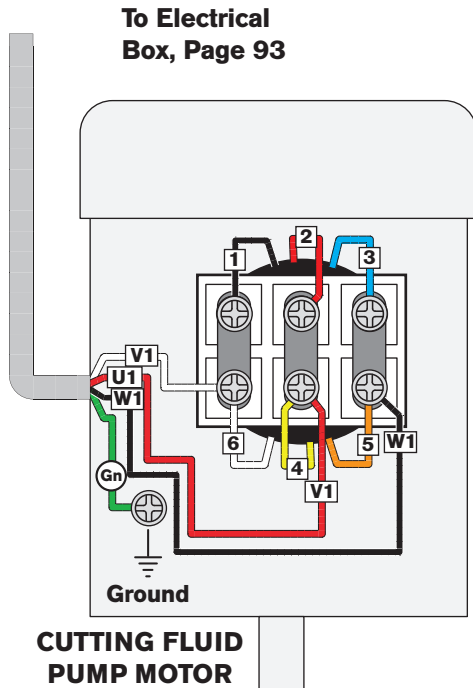


Figure 155. Cutting fluid pump location.

# 2-Speed Motor Switch

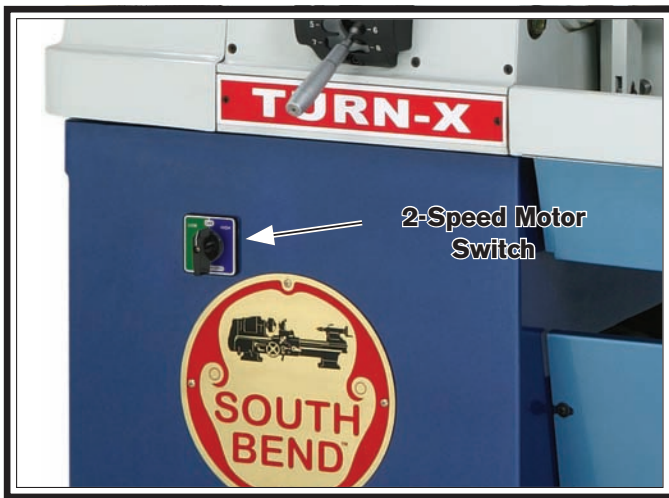
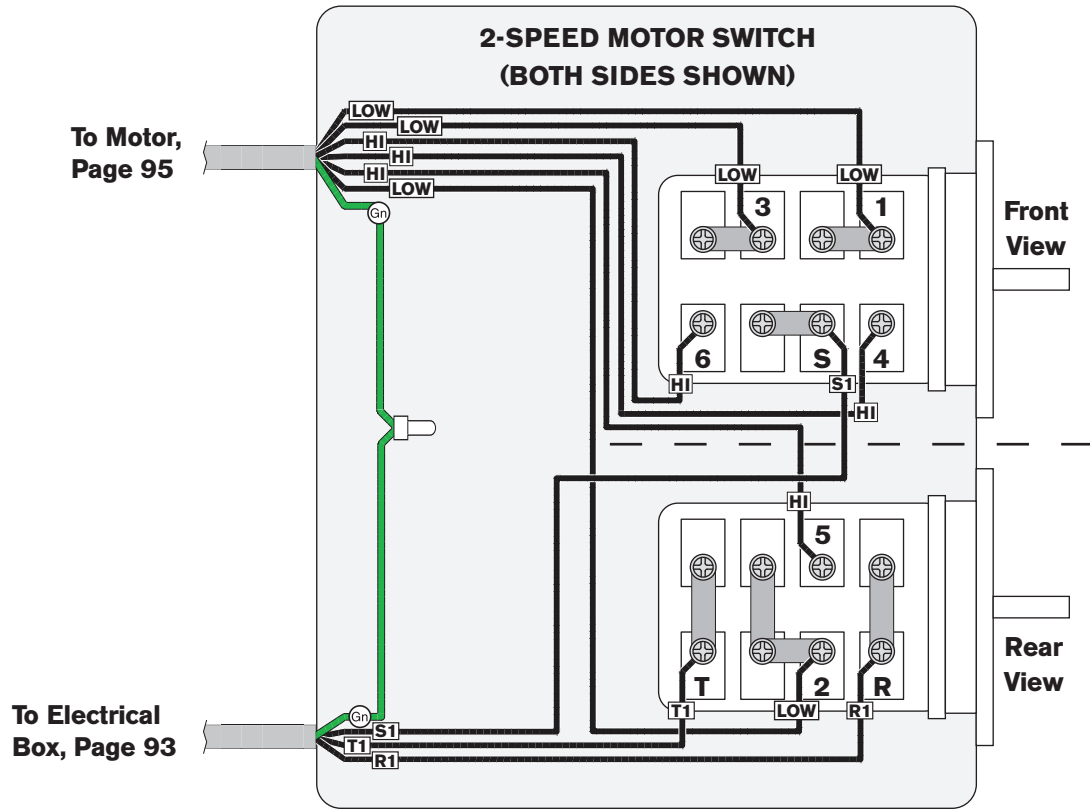


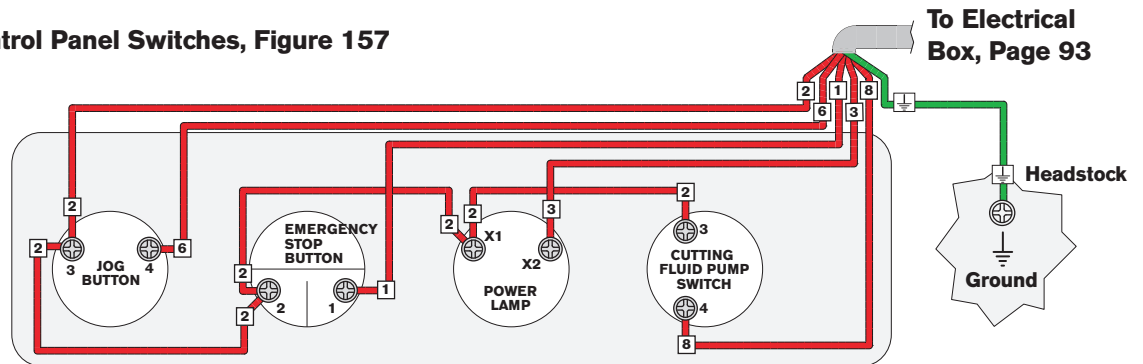
Figure 156. 2-Speed motor switch.

# Control Panel Wiring



Figure 157. Control panel location.

Control Panel Switches, Figure 157



# Spindle ON/OFF Switches

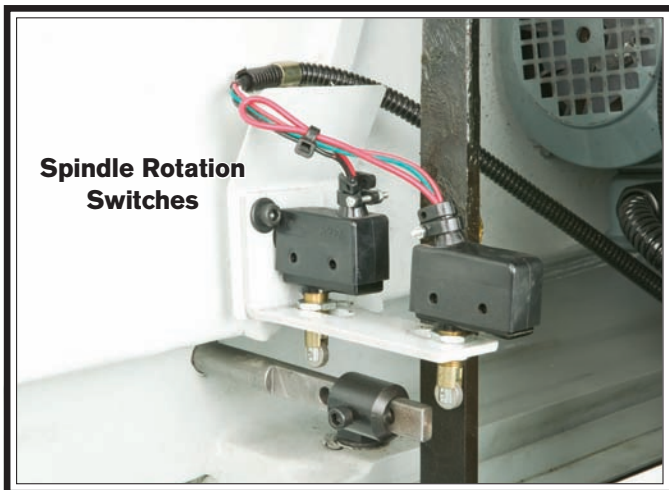
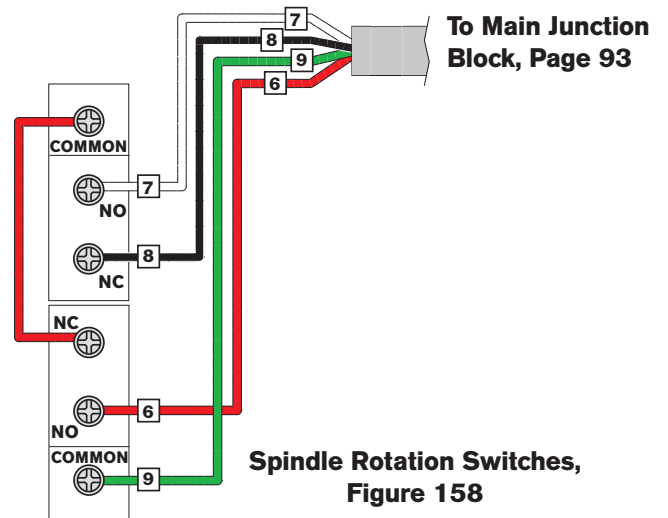


Figure 158. Spindle rotation switch location.



Spindle Rotation Switches, Figure 158

# Additional Component Wiring



Figure 159. End Gear Cover Safety switch location.

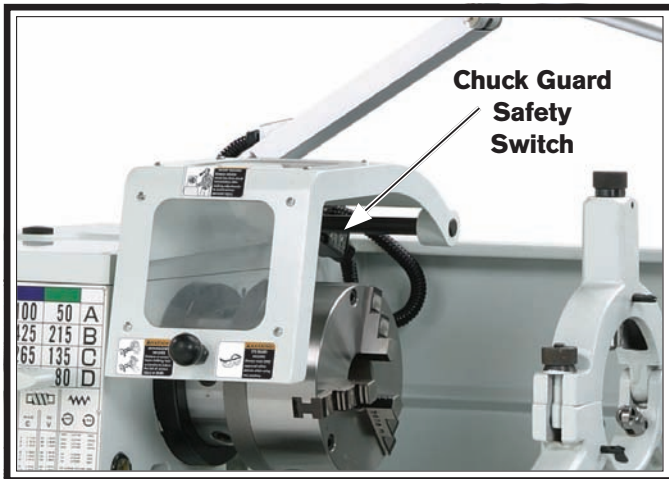
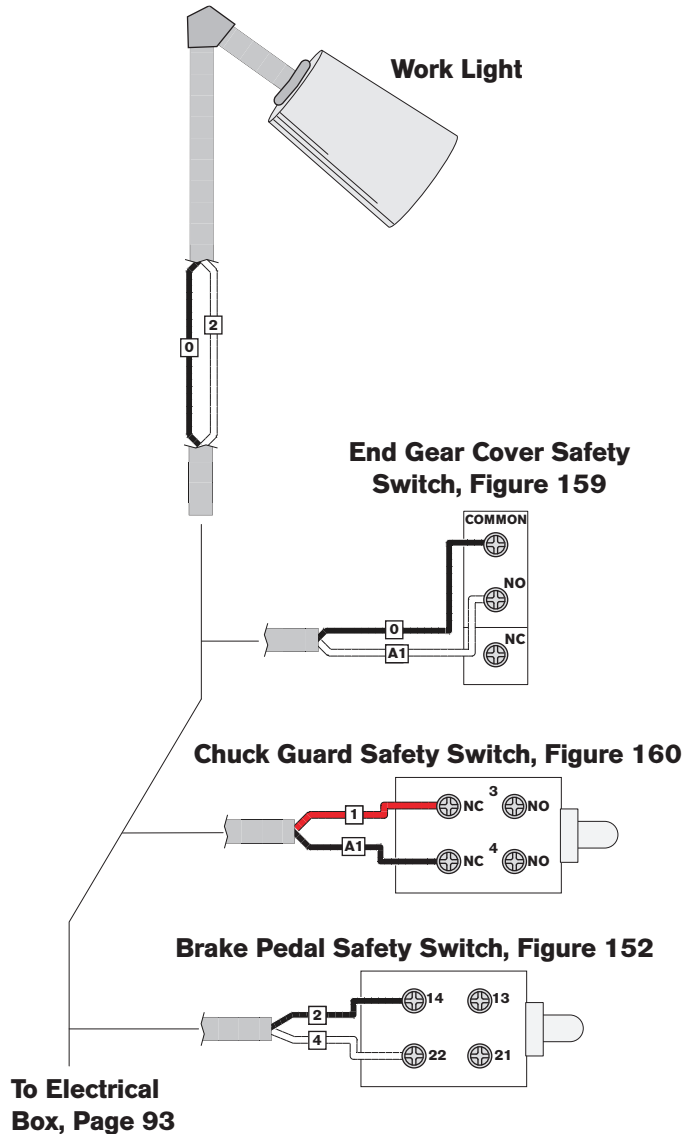
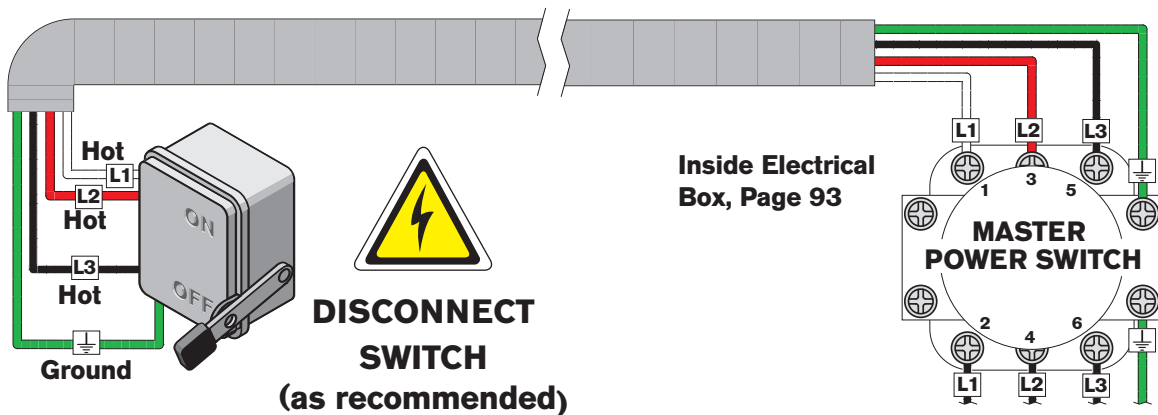


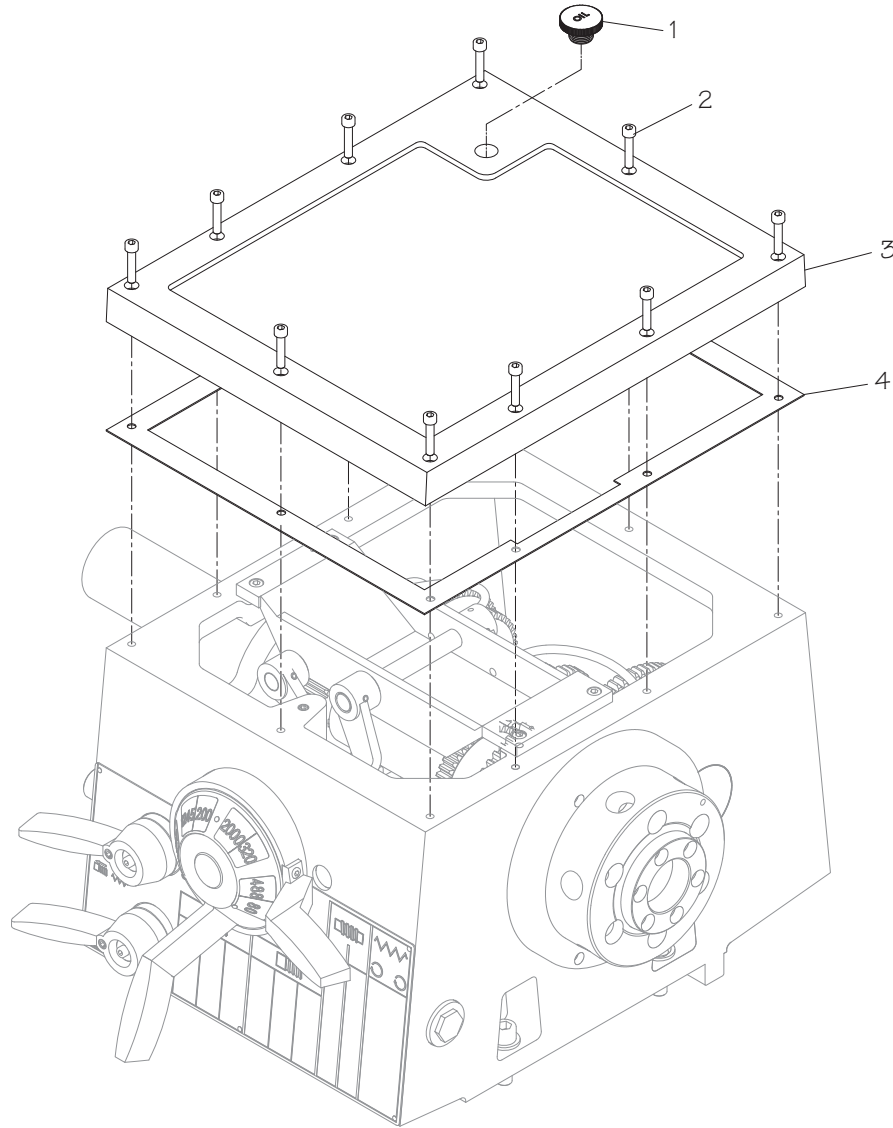
Figure 160. Chuck Guard Safety switch location.



# SB1039 220V Power Connection



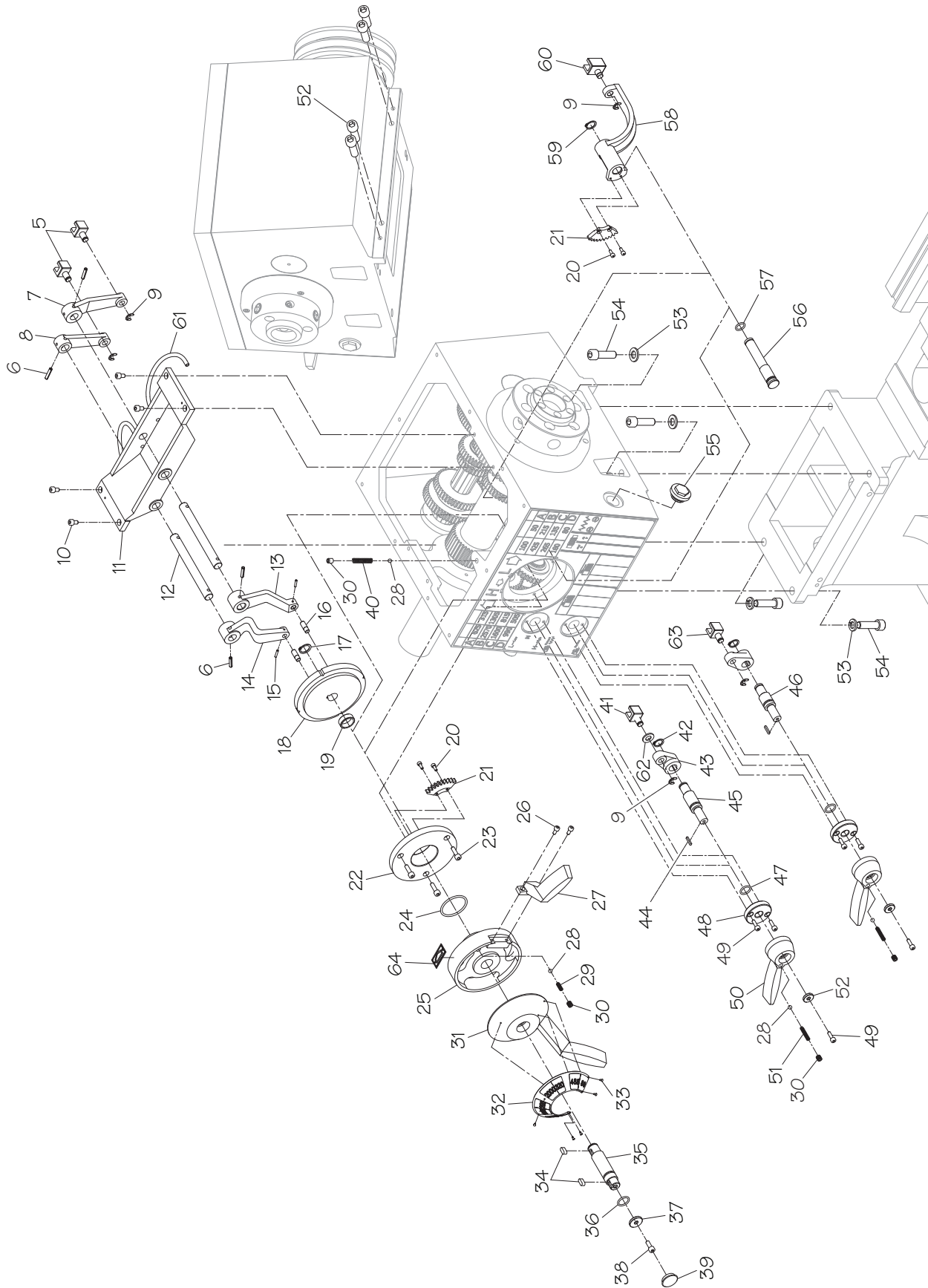
# Headstock Cover



REF	PART #	DESCRIPTION
1	PSB10390001	HEADSTOCK OIL FILL CAP
2	PCAP29M	CAP SCREW M6-1 X 40

REF	PART #	DESCRIPTION
3	PSB10390003	HEADSTOCK COVER
4	PSB10390004	HEADSTOCK COVER GASKET

# Headstock Controls

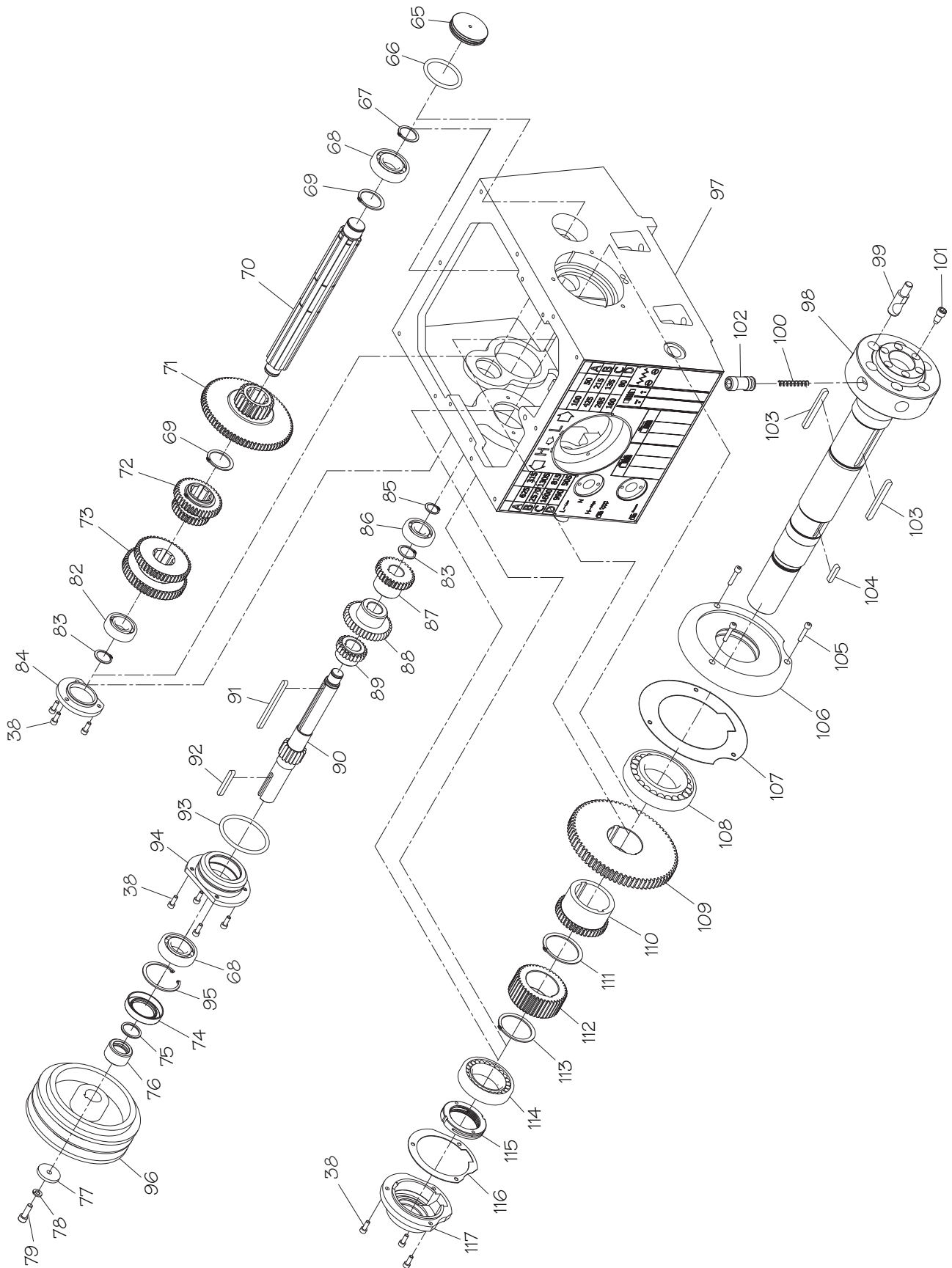


# Headstock Controls Parts List

REF	PART #	DESCRIPTION
5	PSB10390005	SPINDLE SPEED SHIFT FORK
6	PRPO6M	ROLL PIN 5 X 24
7	PSB10390007	RIGHT REAR SHIFT PIVOT ARM
8	PSB10390008	LEFT REAR SHIFT PIVOT ARM
9	PECO15M	E-CLIP 8MM
10	PCAP04M	CAP SCREW M6-1 X 10
11	PSB10390011	LUBRICATION TRAY
12	PSB10120026	SHIFT ROD
13	PSB10390013	RIGHT FRONT SHIFT PIVOT ARM
14	PSB10390014	LEFT FRONT SHIFT PIVOT ARM
15	PRPO2M	ROLL PIN 3 X 16
16	PSB10390016	STEP PIN
17	PRO7M	EXT RETAINING RING 18MM
18	PSB10390018	SHIFT CAM WHEEL
19	PSB10390019	SHIFT SHAFT BUSHING
20	PCAP17M	CAP SCREW M4-.7 X 10
21	PSB10390021	GEAR 40T
22	PSB10390022	CAM WHEEL END CAP
23	PCAP02M	CAP SCREW M6-1 X 20
24	PORPO44	O-RING 43.7 X 3.5 P44
25	PSB10120032	RANGE SELECTOR
26	PCAP50M	CAP SCREW M5-.8 X 10
27	PSB10120016	RANGE SELECTOR HANDLE
28	PSTB001	STEEL BALL 1/4
29	PSB10390029	COMPRESSION SPRING
30	PSS20M	SET SCREW M8-1.25 X 8
31	PSB10120031	SPEED SELECTOR HANDLE
32	PSB10390032	SPEED SELECTOR PLATE
33	PRIV001M	STEEL FLUTED RIVET 2 X 5MM
34	PK101M	KEY 6 X 6 X 14

REF	PART #	DESCRIPTION
35	PSB10390035	SHIFT SHAFT
36	PORPO18	O-RING 17.8 X 2.4 P18
37	PSB10390037	SHIFT SHAFT FLAT WASHER
38	PCAP01M	CAP SCREW M6-1 X 16
39	PSB10120508	SHIFT SHAFT END CAP
40	PSB10390040	COMPRESSION SPRING
41	PSB10390041	HIGH-LOW SHIFT FORK
42	PRO5M	EXT RETAINING RING 15MM
43	PSB10390043	PIVOT ARM
44	PK155M	KEY 3 X 3 X 18
45	PSB10390045	HIGH-LOW SHIFT SHAFT
46	PSB10120041	DIRECTION SHIFT SHAFT
47	PORPO16	O-RING 15.8 X 2.4 P16
48	PSB10390048	SHAFT END CAP
49	PCAP10M	CAP SCREW M5-.8 X 15
50	PSB10120044	SHIFT HANDLE
51	PSB10390051	COMPRESSION SPRING
52	PCAP92M	CAP SCREW M12-1.75 X 40
53	PLW05M	LOCK WASHER 12MM
54	PCAP92M	CAP SCREW M12-1.75 X 40
55	PSB10390055	OIL SIGHT GLASS 3/4"
56	PSB10120046	GEAR SHAFT
57	PORPO14	O-RING 13.8 X 2.4 P14
58	PSB10390058	LEVER ARM
59	PRO6M	EXT RETAINING RING 16MM
60	PSB10390060	SHIFT FORK
61	PSB10390061	LUBRICATION TUBE 6 X 270MM
62	PW04M	FLAT WASHER 10MM
63	PSB10390063	DIRECTION SHIFT FORK
64	PSB10390064	INDICATOR PLATE

# Headstock Internal Gears

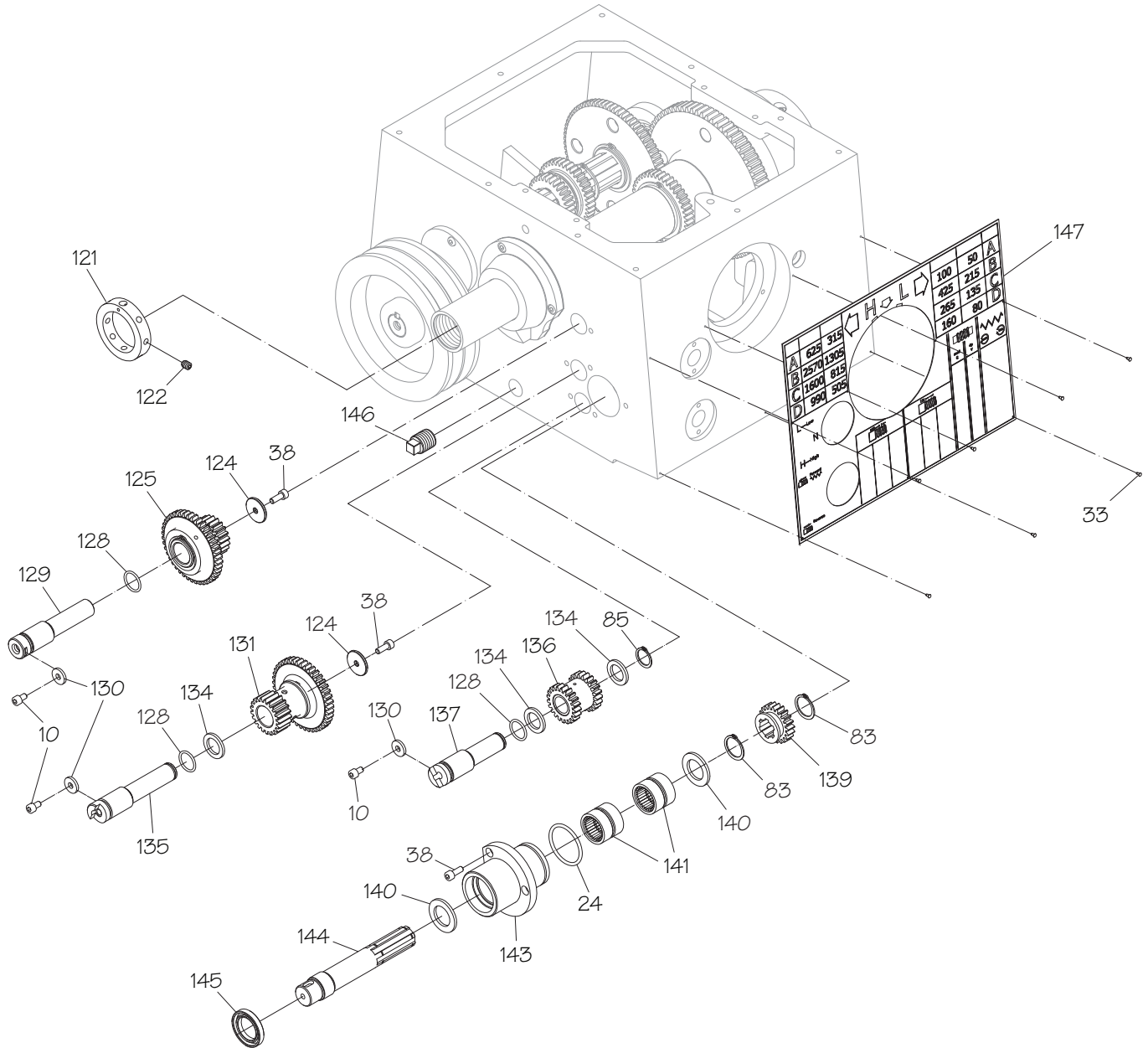


# Headstock Internal Gears Parts List

REF	PART #	DESCRIPTION
38	PCAP01M	CAP SCREW M6-1 X 16
65	PSB10390065	SHAFT END CAP
66	PORP055	O-RING 54.6 X 5.7 P55
67	PR15M	EXT RETAINING RING 30MM
68	P6206-OPEN	BALL BEARING 6206-OPEN
69	PR31M	EXT RETAINING RING 38MM
70	PSB10390070	SPLINED SHAFT
71	PSB10390071	COMBO GEAR 22T/72T
72	PSB10390072	COMBO GEAR 22T/38T
73	PSB10390073	COMBO GEAR 45T/52T
74	PSB10390074	OIL SEAL 40 X 62 X 12
75	PORP028	O-RING 27.7 X 3.5 P28
76	PSB10390076	PULLEY SHAFT SPACER
77	PSB10120079	SPINDLE PULLEY FLAT WASHER
78	PLW04M	LOCK WASHER 8MM
79	PCAP31M	CAP SCREW M8-1.25 X 25
82	P6205-OPEN	BALL BEARING 6205-OPEN
83	PR11M	EXT RETAINING RING 25MM
84	PSB10390084	DRIVE SHAFT END CAP
85	PR09M	EXT RETAINING RING 20MM
86	P6304-OPEN	BALL BEARING 6304-OPEN
87	PSB10390087	GEAR 30T
88	PSB10390088	GEAR 38T
89	PSB10390089	GEAR 22T
90	PSB10390090	SPINDLE PULLEY GEAR SHAFT 16T
91	PSB10390091	KEY 7 X 7 X 104

REF	PART #	DESCRIPTION
92	PSB10390092	KEY 7 X 7 X 53
93	PORP075	O-RING 74.6 X 5.7 P75
94	PSB10390094	FLANGE BEARING SEAT
95	PR38M	INT RETAINING RING 62MM
96	PSB10390096	SPINDLE PULLEY
97	PSB10390097	HEADSTOCK CASTING
98	PSB10390098	SPINDLE
99	PSB10390099	CAM LOCK BOLT
100	PSB10120016	CAM LOCK COMPRESSION SPRING
101	PSB10120082	SPINDLE HEAD CAP SCREW
102	PSB10120085	CAM LOCK
103	PSB10390103	KEY 10 X 6 X 85
104	PK109M	KEY 7 X 7 X 35
105	PCAP07M	CAP SCREW M6-1 X 30
106	PSB10390106	INBOARD SPINDLE BEARING COVER
107	PSB10120090	BEARING COVER GASKET
108	P30213-T	TAPERED ROLLER BEARING 30213 NTN
109	PSB10390109	GEAR 72T
110	PSB10390110	GEAR 41T
111	PR71M	EXT RETAINING RING 60MM
112	PSB10120097	GEAR 42T
113	PR91M	EXT RETAINING RING 56MM
114	P32011-T	TAPERED ROLLER BEARING 32011 NTN
115	PSB10390115	SPANNER NUT
116	PSB10120099	SPINDLE END CAP GASKET
117	PSB10120100	OUTBOARD SPINDLE END CAP

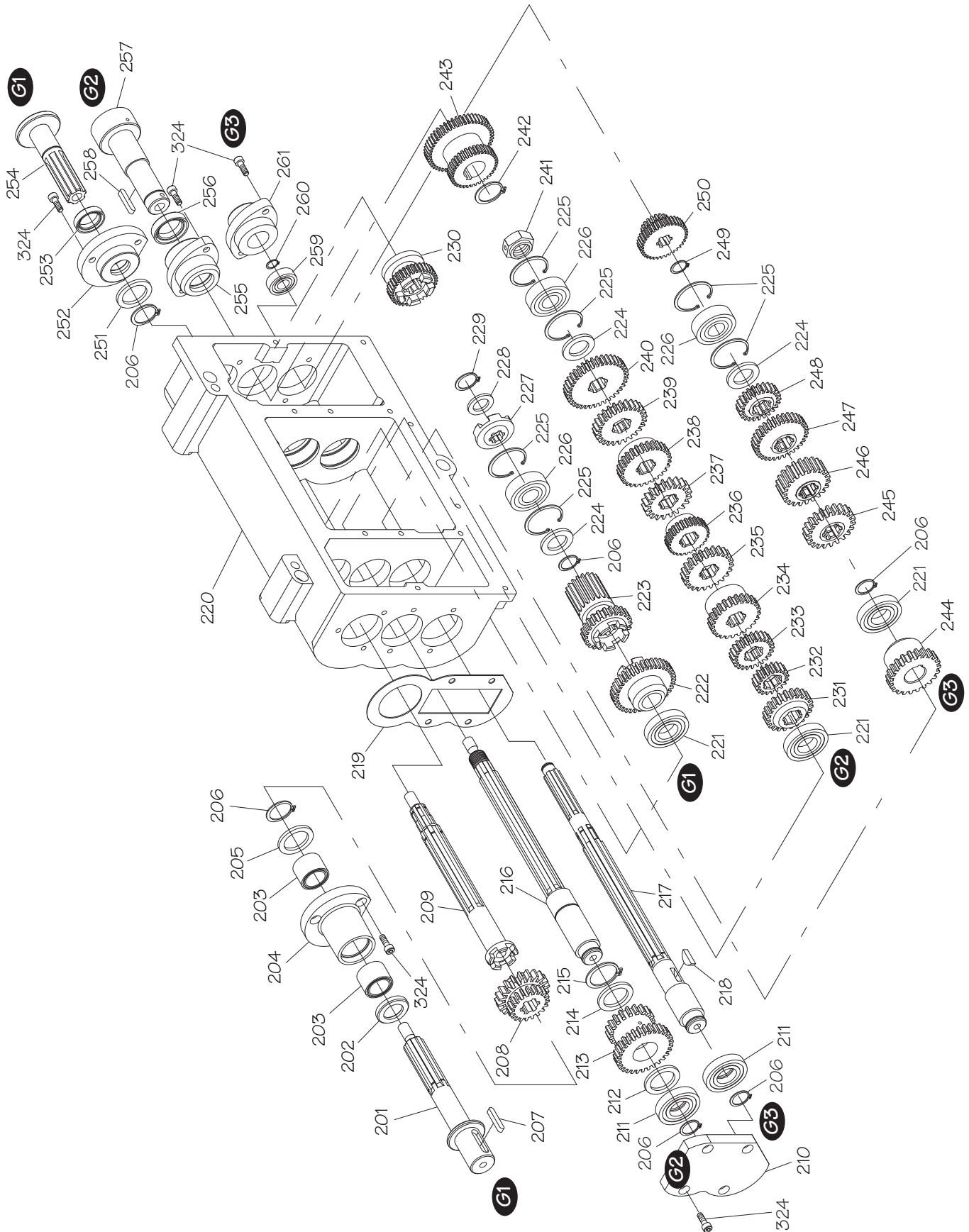
# Headstock Transfer Gears



REF	PART #	DESCRIPTION
10	PCAP04M	CAP SCREW M6-1 X 10
24	PORPO44	O-RING 43.7 X 3.5 P44
33	PRIV001M	STEEL FLUTED RIVET 2 X 5MM
38	PCAP01M	CAP SCREW M6-1 X 16
83	PR11M	EXT RETAINING RING 25MM
85	PRO9M	EXT RETAINING RING 20MM
121	PSB10390121	SPINDLE BALANCE SLEEVE
122	PSS30M	SET SCREW M10-1.5 X 10
124	PSB10390124	GEAR FLAT WASHER
125	PSB10390125	COMBO GEAR 21T/42T
128	PORPO21	O-RING 20.8 X 2.4 P21
129	PSB10120111	TOP GEAR SHAFT
130	PSB10390130	GEAR SHAFT FLAT WASHER

REF	PART #	DESCRIPTION
131	PSB10390131	COMBO GEAR 21T/42T
134	PSB10120115	THRUST WASHER
135	PSB10120116	MIDDLE GEAR SHAFT
136	PSB10390136	COMBO GEAR 21T/21T
137	PSB10120119	LOWER GEAR SHAFT
139	PSB10390139	GEAR 21T
140	PSB10120121	THRUST WASHER
141	PSB10390141	NEEDLE BEARING RNA-6904
143	PSB10120125	FLANGE BEARING SEAT
144	PSB10390144	SPLINED SHAFT
145	PSB10390145	OIL SEAL 28 X 44 X 7
146	PSB10390146	SQUARE HEAD OIL DRAIN PLUG 1/2 PT
147	PSB10390147	HEADSTOCK INFORMATION FRONT PANEL

# Quick Change Gearbox Gears

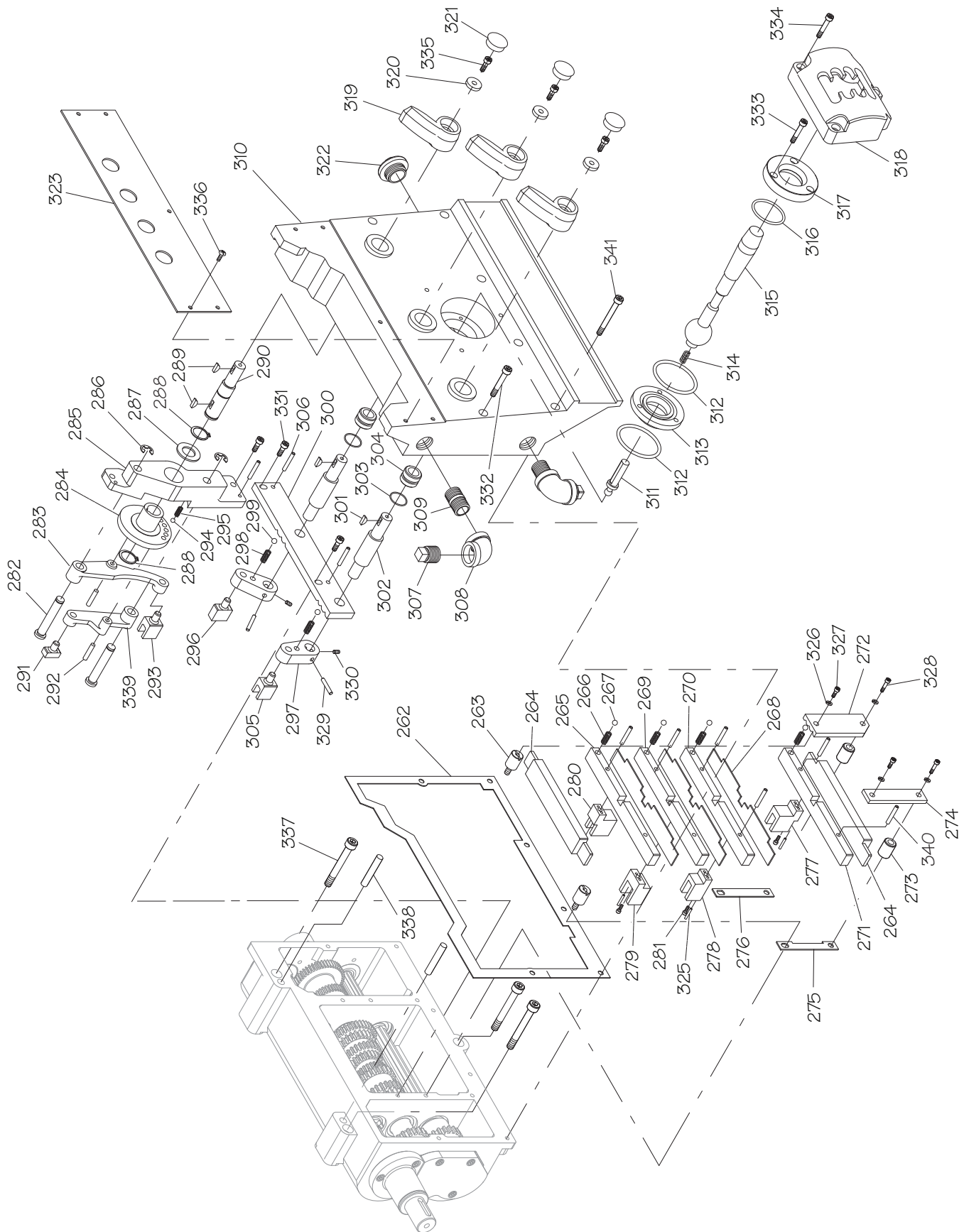


# Quick Change Gearbox Gears Parts List

REF	PART #	DESCRIPTION
201	PSB10120201	OUTBOARD SPLINED SHAFT (G1)
202	PSB10390202	OIL SEAL 20 X 32 X 5
203	PSB10390203	NEEDLE ROLLER BEARING TAF202820
204	PSB10120204	FLANGE BEARING SEAT
205	PSB10120205	THRUST WASHER
206	PRO9M	EXT RETAINING RING 20MM
207	PK109M	KEY 7 X 7 X 35
208	PSB10120208	COMBO GEAR 19T/20T
209	PSB10120209	CLUTCH SPLINED SHAFT (G1)
210	PSB10120210	OUTBOARD SHAFT END CAP
211	P16004ZZ	BALL BEARING 16004ZZ
212	PSB10120212	THRUST WASHER
213	PSB10120213	COMBO GEAR 19T/30T
214	PSB10120214	THRUST WASHER
215	PR11M	EXT RETAINING RING 25MM
216	PSB10120216	SPLINED SHAFT (G2)
217	PSB10120217	SPLINED SHAFT (G3)
218	PSB10390218	WOODRUFF KEY 5 X 19
219	PSB10120219	OUTBOARD END CAP GASKET
220	PSB10120220	GEARBOX CASTING
221	P16004ZZ	BALL BEARING 16004 ZZ
222	PSB10120222	CLUTCH GEAR 38T
223	PSB10120223	COMBO CLUTCH GEAR 23T/19T
224	PSB10120224	THRUST WASHER
225	PR23M	INT RETAINING RING 40MM
226	P6203ZZ	BALL BEARING 6203 ZZ
227	PSB10120227	CLUTCH
228	PSB10120228	THRUST BEARING
229	PRO6M	EXT RETAINING RING 16MM
230	PSB10120230	CLUTCH GEAR 35T
231	PSB10120231	GEAR 22T

REF	PART #	DESCRIPTION
232	PSB10120232	GEAR 19T
233	PSB10120233	GEAR 20T
234	PSB10120234	GEAR 24T
235	PSB10120235	GEAR 23T
236	PSB10120236	GEAR 27T
237	PSB10120237	GEAR 24T
238	PSB10120238	GEAR 28T
239	PSB10120239	GEAR 26T
240	PSB10120240	GEAR 38T
241	PSB10120241	SPANNER NUT
242	PR10M	EXT RETAINING RING 22MM
243	PSB10120243	COMBO GEAR 36T/50T
244	PSB10120244	GEAR 22T
245	PSB10120245	GEAR 22T
246	PSB10120246	GEAR 22T
247	PSB10120247	GEAR 33T
248	PSB10120248	GEAR 22T
249	PR18M	EXT RETAINING RING 17MM
250	PSB10120250	COMBO GEAR 20T/36T
251	PSB10120205	THRUST WASHER
252	PSB10120252	INBOARD FLANGE BEARING SEAT
253	PSB10390253	OIL SEAL 20 X 32 X 5
254	PSB10120254	INBOARD SPLINED SHAFT (G1)
255	PSB10120255	INBOARD FLANGE BEARING SEAT
256	PSB10390256	OIL SEAL 24 X 35 X 8
257	PSB10120257	INBOARD SHAFT (G2)
258	PK15M	KEY 5 X 5 X 35
259	P6001ZZ	BALL BEARING 6001ZZ
260	PRO3M	EXT RETAINING RING 12MM
261	PSB10120261	INBOARD FLANGE BEARING SEAT
324	PCAP26M	CAP SCREW M6-1 X 12

# Quick Change Gearbox Controls

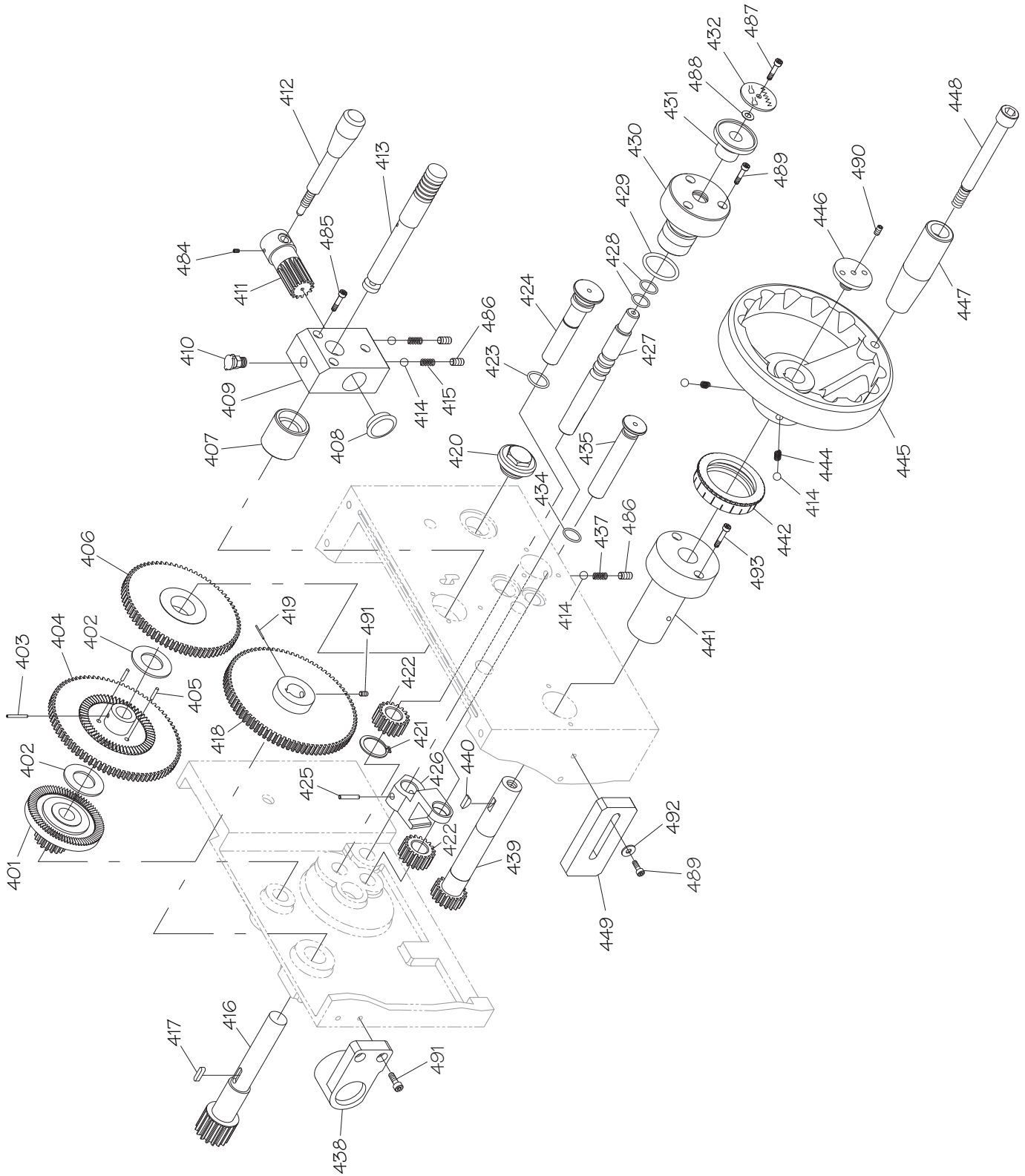


# Quick Change Gearbox Controls Parts List

REF	PART #	DESCRIPTION
262	PSB10120262	GEARBOX COVER GASKET
263	PSB10120263	PARTITION SCREW
264	PSB10120264	END PLATE
265	PSB10120265	UPPER FORK SUPPORT
266	PSB10120266	COMPRESSION SPRING 4 X 19MM
267	PSTB001	STEEL BALL 1/4
268	PSB10120268	FORK SUPPORT PARTITION
269	PSB10120269	UPPER MIDDLE FORK SUPPORT
270	PSB10120270	LOWER MIDDLE FORK SUPPORT
271	PSB10120271	LOWER FORK SUPPORT
272	PSB10120272	REVERSE STOP
273	PSB10120273	BRACKET SPACER
274	PSB10120274	LEFT SHOULDER PLATE
275	PSB10120275	LEFT SHOULDER PLATE BRACKET
276	PSB10120276	REVERSE STOP BRACKET
277	PSB10120277	LOWER SHIFT FORK
278	PSB10120279	MIDDLE SHIFT FORK
279	PSB10120279	LEFT UPPER SHIFT FORK
280	PSB10120278	RIGHT UPPER SHIFT FORK
281	PRP02M	ROLL PIN 3 X 16
282	PSB10120282	PIVOT ARM SHAFT
283	PSB10120283	OUTER RIGHT SHIFT PIVOT ARM
284	PSB10120284	SHIFT CAM
285	PSB10120285	RIGHT SHIFT BRACKET
286	PECO15M	E-CLIP 8MM
287	PSB10120287	SHAFT WASHER
288	PR18M	EXT RETAINING RING 17MM
289	PSB10390289	WOODRUFF KEY 4 X 13
290	PSB10120290	RIGHT SHIFT SHAFT
291	PSB10120291	RIGHT SHIFT PAD
292	PSB10120292	DOWEL PIN
293	PSB10120293	RIGHT SHIFT FORK
294	PSTB001	STEEL BALL 1/4
295	PSB10390266	COMPRESSION SPRING 4 X 19MM
296	PSB10120296	MIDDLE SHIFT PAD
297	PSB10120297	MIDDLE SHIFT PIVOT ARM
298	PSB10120298	COMPRESSION SPRING 6 X 13MM
299	PSTB001	STEEL BALL 1/4
300	PSB10120300	SHIFT SHAFT SUPPORT BRACKET
301	PSB10390289	WOODRUFF KEY 4 X 13

REF	PART #	DESCRIPTION
302	PSB10120302	LEFT SHIFT SHAFT
303	PORP018	O-RING 17.8 X 2.4 P18
304	PSB10120304	SHIFT SHAFT BUSHING
305	PSB10120305	LEFT SHIFT FORK
306	PRP24M	ROLL PIN 5 X 16
307	PSB10390307	SQUARE HD OIL PLUG 1/2 PT
308	PSB10390308	PIPE ELBOW 1/2 X 1/2 PT
309	PSB10390309	PIPE NIPPLE 1/2 X 1 PT
310	PSB10390310	GEARBOX FRONT COVER
311	PSB10120311	SELECTOR SHAFT
312	PORG040	O-RING 39.4 X 3.1 G40
313	PSB10120313	SELECTOR LEVER SUPPORT
314	PSB10390314	COMPRESSION SPRING 9 X 38MM
315	PSB10120315	SELECTOR LEVER
316	PORG030	O-RING 3.1 X 29.4 G30
317	PSB10120317	SELECTOR LEVER END CAP
318	PSB10120318	SELECTOR PLATE
319	PSB10120319	SHIFT LEVER
320	PSB10120314	SHIFT LEVER WASHER
321	PSB10120321	SHIFT LEVER END CAP
322	PSB10390322	OIL SIGHT GLASS
323	PSB10390323	CONTROL PANEL PLATE
325	PCAP15M	CAP SCREW M5-.8 X 20
326	PLW03M	LOCK WASHER 6MM
327	PCAP26M	CAP SCREW M6-1 X 12
328	PCAP48M	CAP SCREW M6-1 X 35
329	PRP04M	ROLL PIN 4 X 24
330	PSS03M	SET SCREW M6-1 X 8
331	PCAP02M	CAP SCREW M6-1 X 20
332	PCAP167M	CAP SCREW M6-1 X 70
333	PCAP38M	CAP SCREW M5-.8 X 25
334	PCAP26M	CAP SCREW M6-1 X 12
335	PCAP33M	CAP SCREW M5-.8 X 12
336	PS17M	PHLP HD SCR M4-.7 X 6
337	PCAP66M	CAP SCREW M8-1.25 X 65
338	PSB10390338	TAPER PIN #7 X 3-1/4"
339	PSB10390339	INNER RIGHT SHIFT PIVOT ARM
340	PSB10390340	DOWEL PIN
341	PCAP190M	CAP SCREW M6-1 X 80

# Apron Front View

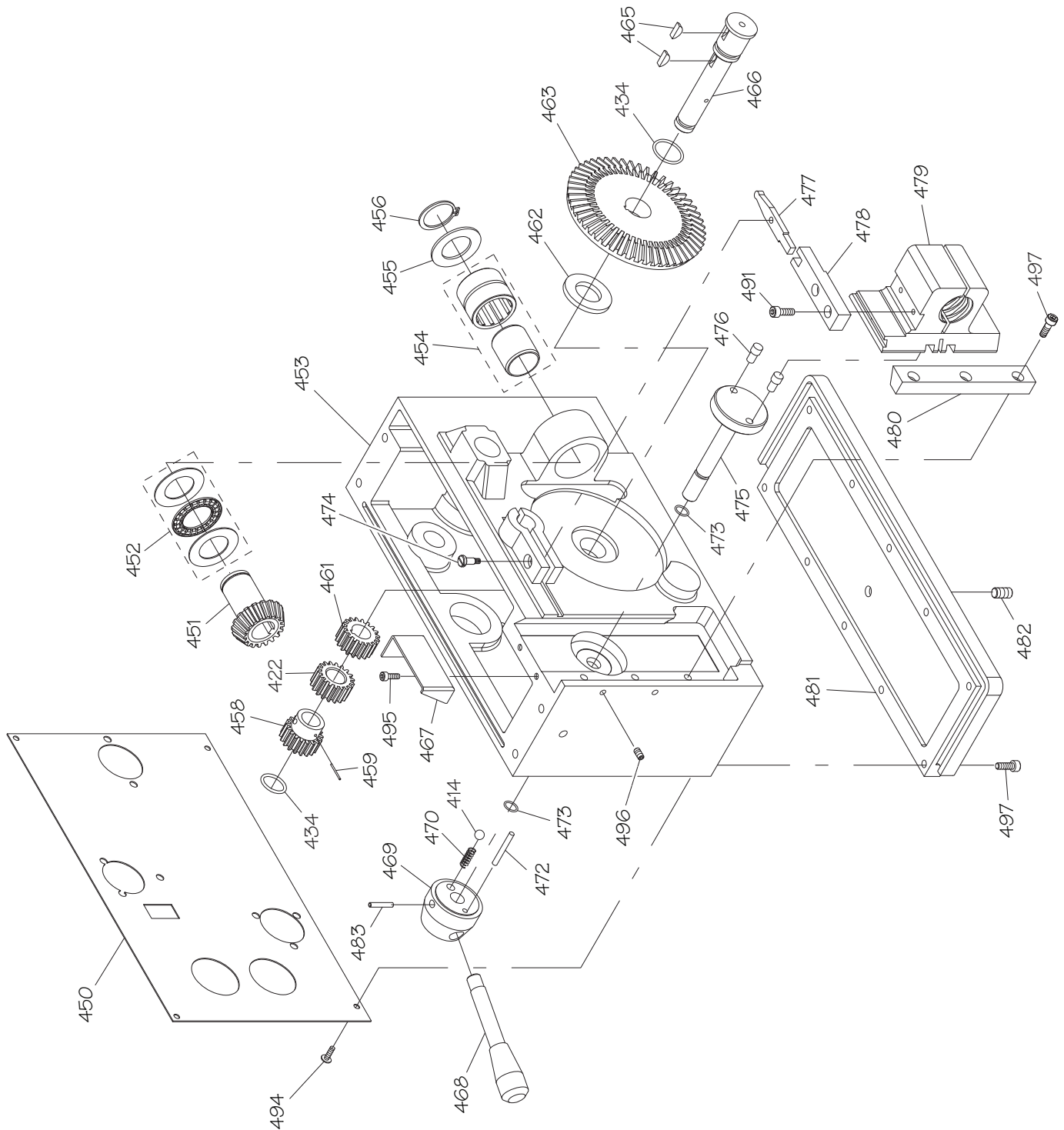


# Apron Front View Parts List

REF	PART #	DESCRIPTION
401	PSB10120501	COMBO GEAR 18T/60T
402	PSB10390402	THRUST WASHER
403	PRP20M	ROLL PIN 4 X 22
404	PSB10120504	COMBO GEAR 81T/60T
405	PSB10390405	DOWEL PIN 4 X 17
406	PSB10120506	COMBO GEAR 72T/60T
407	PSB10120507	GEAR SPACER
408	PSB10120508	CASTING PLUG
409	PSB10120509	FEED SELECTOR BRACKET
410	PSB10390410	OIL FILL CAP
411	PSB10120511	FEED SELECTOR SPLINED SHAFT
412	PSB10120512	FEED SELECTOR LEVER
413	PSB10120513	FEED SELECTOR PINION SHAFT
414	PSTB001	STEEL BALL 1/4
415	PSB10120515	COMPRESSION SPRING 6 X 13MM
416	PSB10120516	GEAR SHAFT 16T
417	PK14M	KEY 5 X 5 X 18
418	PSB10120518	GEAR 81T
419	PRP10M	ROLL PIN 5 X 36
420	PSB10390420	OIL SIGHT GLASS
421	PRO6M	EXT RETAINING RING 16MM
422	PSB10120522	GEAR 18T
423	PORP018	O-RING 17.8 X 2.4 P18
424	PSB10120524	RIGHT REVERSE FEED SHAFT
425	PRP04M	ROLL PIN 4 X 24
426	PSB10120526	REVERSE FEED PIVOT ARM
427	PSB10120527	REVERSE FEED CONTROL SHAFT
428	PORP016	O-RING 15.8 X 2.4 P16

REF	PART #	DESCRIPTION
429	PORP026	O-RING 25.7 X 3.5 P26
430	PSB10120530	REVERSE FEED SHAFT HOUSING
431	PSB10120531	REVERSE FEED KNOB
432	PSB10120532	REVERSE FEED DIRECTION PLATE
434	PORP012	O-RING 11.8 X 2.4 P12
435	PSB10120535	LEFT REVERSE FEED SHAFT
437	PSB10390266	COMPRESSION SPRING 4 X 19MM
438	PSB10121027	LEADSCREW STABILIZER
439	PSB10120539	CARRIAGE GEAR SHAFT 18T
440	PSB10390440	WOODRUFF KEY 5 X 19
441	PSB10120541	CARRIAGE GEAR SHAFT HOUSING
442	PSB10120542	CARRIAGE GRADUATED DIAL
444	PSB10120515	COMPRESSION SPRING
445	PSB10120545	CARRIAGE HANDWHEEL
446	PSB10120546	HANDWHEEL END CAP
447	PSB10120547	HANDWHEEL HANDLE
448	PSB10120506	HANDLE CAP SCREW
449	PW03M	BED STOP PLATE
484	PSS26M	SET SCREW M5-.8 X 6
485	PCAP79M	CAP SCREW M5-.8 X 35
486	PSS20M	SET SCREW M8-1.25 X 8
487	PS08M	PHLP HD SCR M5-.8 X 12
488	PW03M	FLAT WASHER 6MM
489	PCAP06M	CAP SCREW M6-1 X 25
490	PSS12M	SET SCREW M6-1 X 25
491	PCAP01M	CAP SCREW M6-1 X 16
492	PW03M	FLAT WASHER 6MM
493	PCAP38M	CAP SCREW M5-.8 X 25

# Apron Rear View

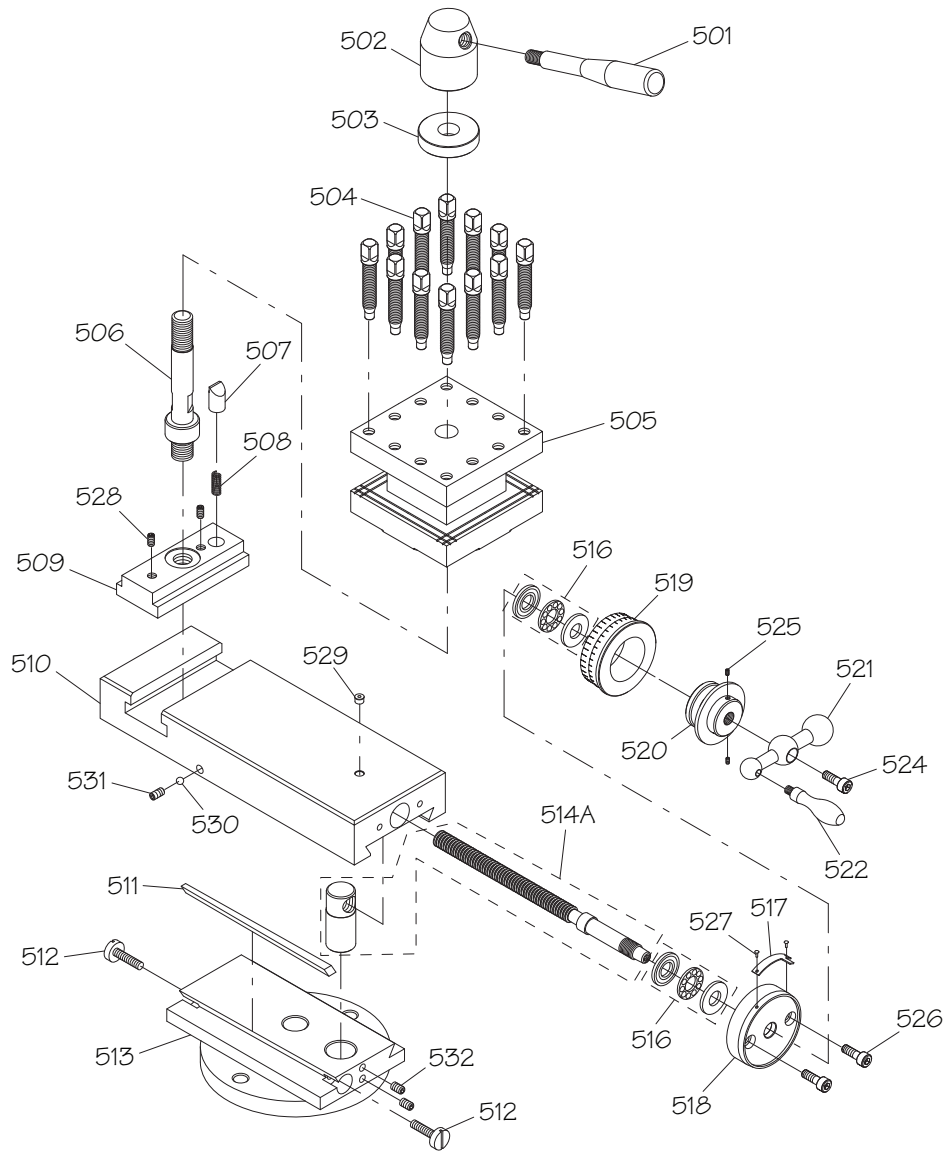


# Apron Rear View Parts List

REF	PART #	DESCRIPTION
414	PSTB001	STEEL BALL 1/4
422	PSB10120522	GEAR 18T
434	PORPO12	O-RING 11.8 X 2.4 P12
450	PW03M	FRONT APRON INFORMATION PANEL
451	PSB10120551	BEVEL GEAR 23T
452	PSB10390452	THRUST NEEDLE BEARING 2542-NTB/AS
453	PSB10120553	APRON CASTING
454	PSB10390454	CYLINDRICAL ROLLER BEARING 2930
455	PSB10120555	THRUST WASHER
456	PR11M	EXT RETAINING RING 25MM
458	PSB10120558	GEAR 18T
459	PRP88M	ROLL PIN 5 X 22
461	PSB10120561	GEAR 18T
462	PSB10120562	THRUST WASHER
463	PSB10120563	BEVEL GEAR 64T
465	PSB10390289	WOODRUFF KEY 4 X 13
466	PSB10120566	GEAR SHAFT
467	PSB10120567	OIL FENCE
468	PSB10120568	HALF-NUT LEVER

REF	PART #	DESCRIPTION
469	PSB10120569	LEVER HUB
470	PSB10390470	COMPRESSION SPRING 6 X 27MM
472	PRPO4M	ROLL PIN 4 X 24
473	PORPO20	O-RING 19.8 X 2.4 P20
474	PSB10120574	STEP SCREW
475	PSB10120575	HALF-NUT CAM SHAFT
476	PSB10120576	STEP PIN
477	PSB10120577	HALF-NUT PIVOT ARM
478	PSB10120578	PIVOT ARM BRACKET
479	PSB10120579	HALF-NUT
480	PSB10120580	HALF-NUT GIB
481	PSB10120581	APRON BOTTOM COVER
482	PSB10390482	OIL DRAIN PLUG 1/8 PT
483	PRP102M	ROLL PIN 4 X 36
491	PCAP01M	CAP SCREW M6-1 X 16
494	PS17M	PHLP HD SCR M4-.7 X 6
495	PCAP03M	CAP SCREW M5-.8 X 8
496	PSS02M	SET SCREW M6-1 X 6
497	PCAP24M	CAP SCREW M5-.8 X 16

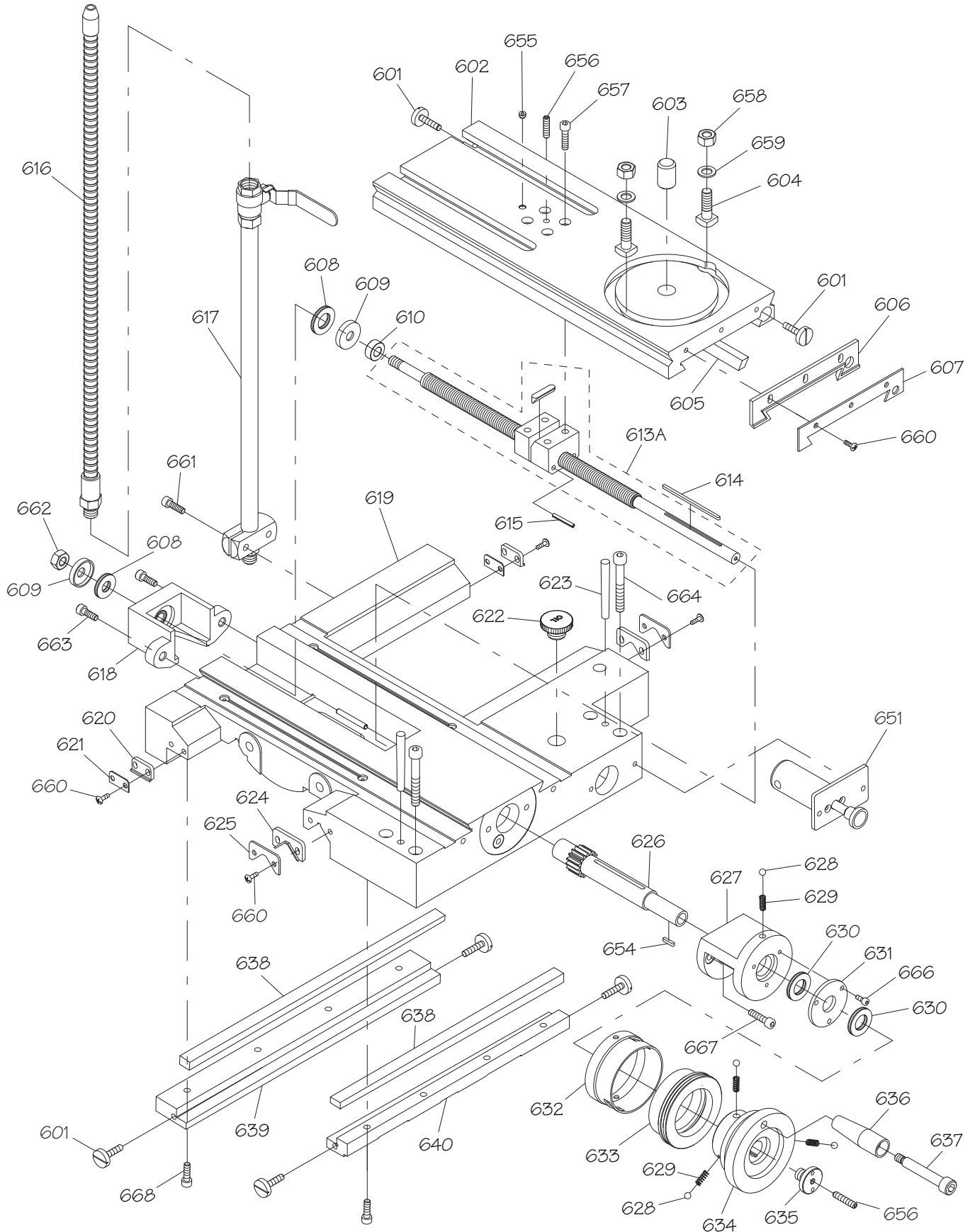
# Compound Rest & Tool Post



REF	PART #	DESCRIPTION
501	PSB10120901	POST LEVER
502	PSB10120902	POST LEVER HUB
503	PSB10120903	HUB THRUST WASHER
504	PSB10120904	TOOL POST BOLT
505	PSB10120905	POST BODY
506	PSB10120906	POST SHAFT
507	PSB10120907	TOOL POST PLUNGER
508	PSB10120908	COMPRESSION SPRING 6 X 27MM
509	PSB10120909	TOOL POST T-SLIDER
510	PSB10120910	COMPOUND SLIDE
511	PSB10120911	COMPOUND SLIDE GIB
512	PSB10121832	GIB ADJUSTMENT SCREW
513	PSB10120913	COMPOUND SLIDE PIVOT BASE
514A	PSB10390514A	COMPOUND SLIDE LEADSCREW W/NUT
516	P51101	THRUST BEARING 51101

REF	PART #	DESCRIPTION
517	PSB10120917	INDICATOR PLATE
518	PSB10120918	LEADSCREW BRACKET
519	PSB10120919	GRADUATED DIAL
520	PSB10390520	FLANGE BEARING SEAT
521	PSB10120922	BALL HANDLE
522	PSB10120923	HANDLE
524	PCAP04M	CAP SCREW M6-1 X 10
525	PSS03M	SET SCREW M6-1 X 8
526	PCAP02M	CAP SCREW M6-1 X 20
527	PRIV001M	STEEL FLUTED RIVET 2 X 5MM
528	PSS14M	SET SCREW M8-1.25 X 12
529	PLUBE001	TAP-IN BALL OILER 1/4
530	PSTB001	STEEL BALL 1/4
531	PSS16M	SET SCREW M8-1.25 X 10
532	PSS03M	SET SCREW M6-1 X 8

# Saddle Top View

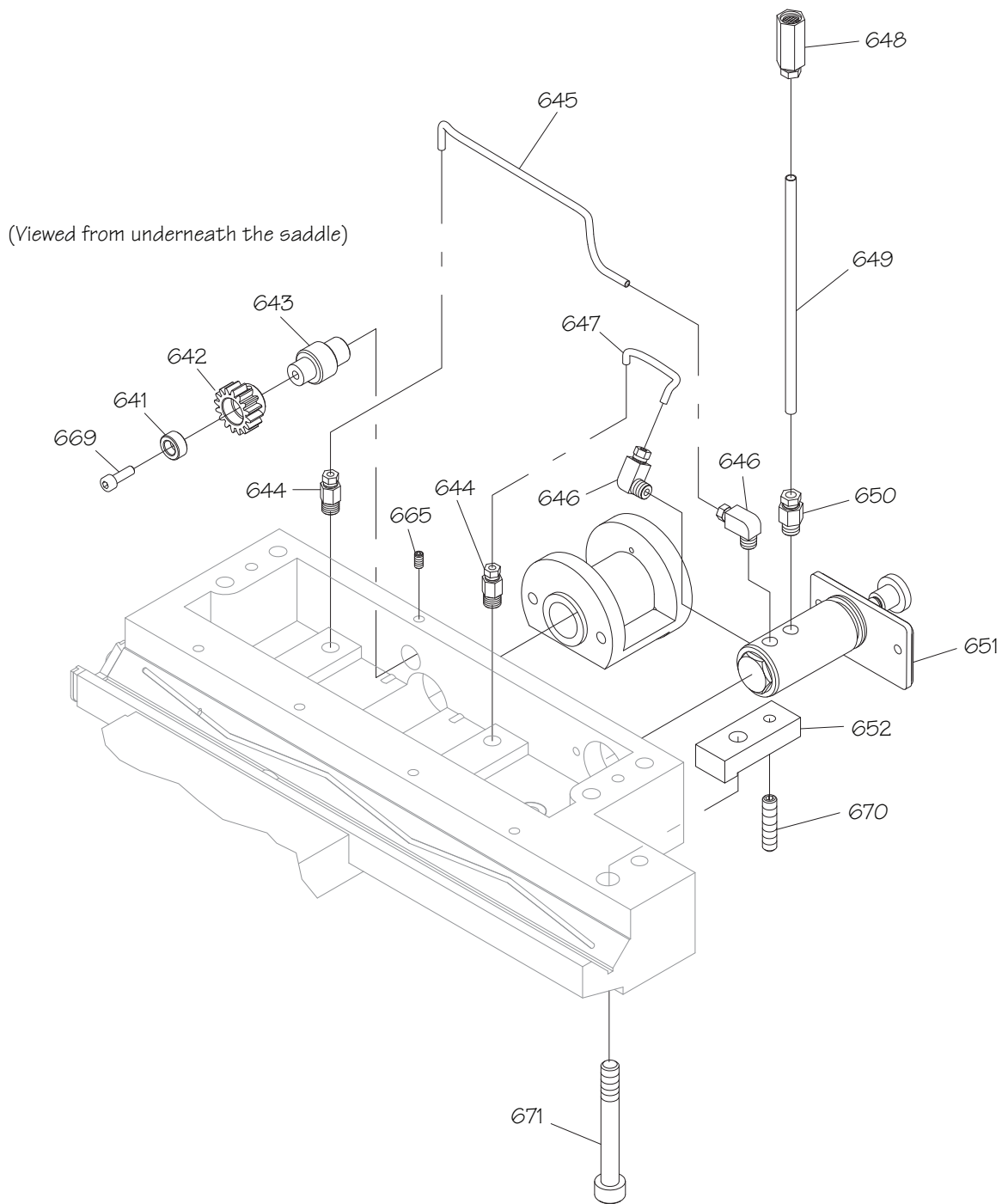


# Saddle Top View Parts List

REF	PART #	DESCRIPTION
601	PSB10390601	GIB ADJUSTMENT SCREW
602	PSB10121002	CROSS SLIDE
603	PSB10121003	COMPOUND SLIDE PIVOT PIN 18 X 28
604	PSB10121004	COMPOUND SLIDE PIVOT T-BOLT
605	PSB10121005	CROSS SLIDE GIB
606	PSB10120924	CROSS SLIDE WAY WIPER
607	PSB10120921	CROSS SLIDE WAY WIPER PLATE
608	PSB10390608	THRUST BEARING 1226-NTB/AS2
609	PSB10121009	BEARING SEAT
610	PSB10121010	LEADSCREW BUSHING
613A	PSB10390613A	CROSS SLIDE LEADSCREW W/NUT
614	PK168M	KEY 3 X 3 X 80
615	PRP28M	ROLL PIN 5 X 40
616	PSB10390616	CUTTING FLUID NOZZLE 3/8 PT X 24"
617	PSB10390617	CUTTING FLUID STAND PIPE ASSY 3/8 PT
618	PSB10121018	CROSS SLIDE END BRACKET
619	PSB10121019	SADDLE CASTING
620	PSB10390620	SADDLE STRAIGHT WAY WIPER
621	PSB10390621	SADDLE STRAIGHT WAY WIPER PLATE
622	PSB10390622	OIL FILL CAP 3/4 NF
623	PSB10390623	TAPER PIN #6 X 2-1/2"
624	PSB10121024	SADDLE V-WAY WIPER
625	PSB10121025	SADDLE V-WAY WIPER PLATE
626	PSB10121026	CROSS SLIDE GEAR SHAFT 22T
627	PSB10121027	GEAR SHAFT BRACKET
628	PSTB001	STEEL BALL 1/4
629	PSB10121029	COMPRESSION SPRING 6 X 15MM

REF	PART #	DESCRIPTION
630	PSB10390630	THRUST BEARING 1730-NTB/AS2
631	PSB10121031	PINION SHAFT END CAP
632	PSB10121032	GRADUATED DIAL HOUSING
633	PSB10390633	GRADUATED DIAL
634	PSB10121034	HANDWHEEL
635	PSB10121035	HANDWHEEL END CAP
636	PSB10121036	HANDWHEEL HANDLE
637	PSB10121037	HANDLE SCREW
638	PSB10121038	SADDLE GIB
639	PSB10121039	FRONT SADDLE GIB SUPPORT
640	PSB10121040	REAR SADDLE GIB SUPPORT
651	PSB10390651	SADDLE OIL PUMP ASSEMBLY
654	PK52M	KEY 3 X 3 X 15
655	PLUBE001	TAP-IN BALL OILER 1/4
656	PSS28M	SET SCREW M6-1 X 30
657	PCAP07M	CAP SCREW M6-1 X 30
658	PN02M	HEX NUT M10-1.5
659	PW04M	FLAT WASHER 10MM
660	PS08M	PHLP HD SCR M5-.8 X 12
661	PCAP06M	CAP SCREW M6-1 X 25
662	PN02M	HEX NUT M10-1.5
663	PCAP02M	CAP SCREW M6-1 X 20
664	PCAP35M	CAP SCREW M8-1.25 X 60
666	PCAP17M	CAP SCREW M4-.7 X 10
667	PCAP02M	CAP SCREW M6-1 X 20
668	PCAP02M	CAP SCREW M6-1 X 20

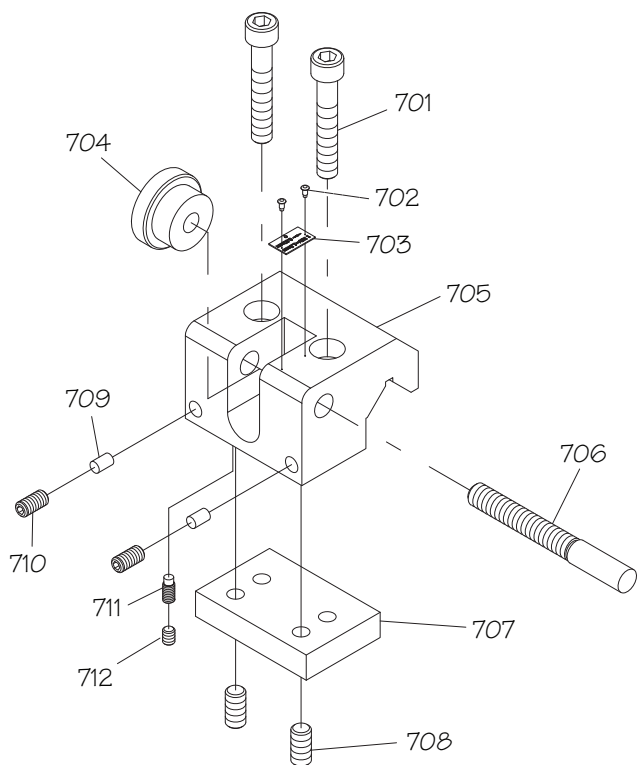
# Saddle Bottom View



REF	PART #	DESCRIPTION
641	PSB10121041	GEAR BUSHING
642	PSB10121042	GEAR 16T
643	PSB10121043	GEAR SHAFT
644	PSB10390644	STRAIGHT PIPE ADAPTER 1/8 PT X 4MM
645	PSB10390645	ALUMINUM OIL PIPE 4 X 260MM
646	PSB10390646	ELBOW PIPE ADAPTER 1/8 PT X 4MM
647	PSB10390647	ALUMINUM OIL PIPE 4 X 120MM
648	PSB10390648	OIL FILTER 6MM

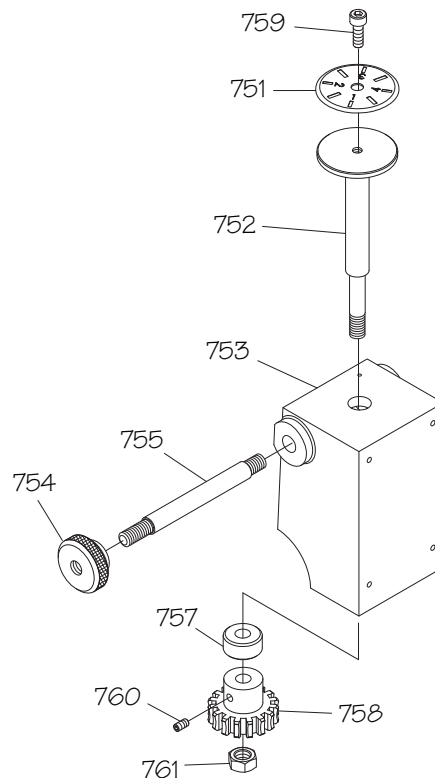
REF	PART #	DESCRIPTION
649	PSB10390649	ALUMINUM OIL PIPE 6 X 160MM
650	PSB10390650	STRAIGHT PIPE ADAPTER 1/8 PT X 6MM
651	PSB10390651	SADDLE OIL PUMP ASSEMBLY
652	PSB10121052	SADDLE STOP BLOCK
665	PSS03M	SET SCREW M6-1 X 8
669	PCAP24M	CAP SCREW M5-.8 X 16
670	PSS74M	SET SCREW M8-1.25 X 35
671	PCAP169M	CAP SCREW M12-1.75 X 75

# Bed Stop



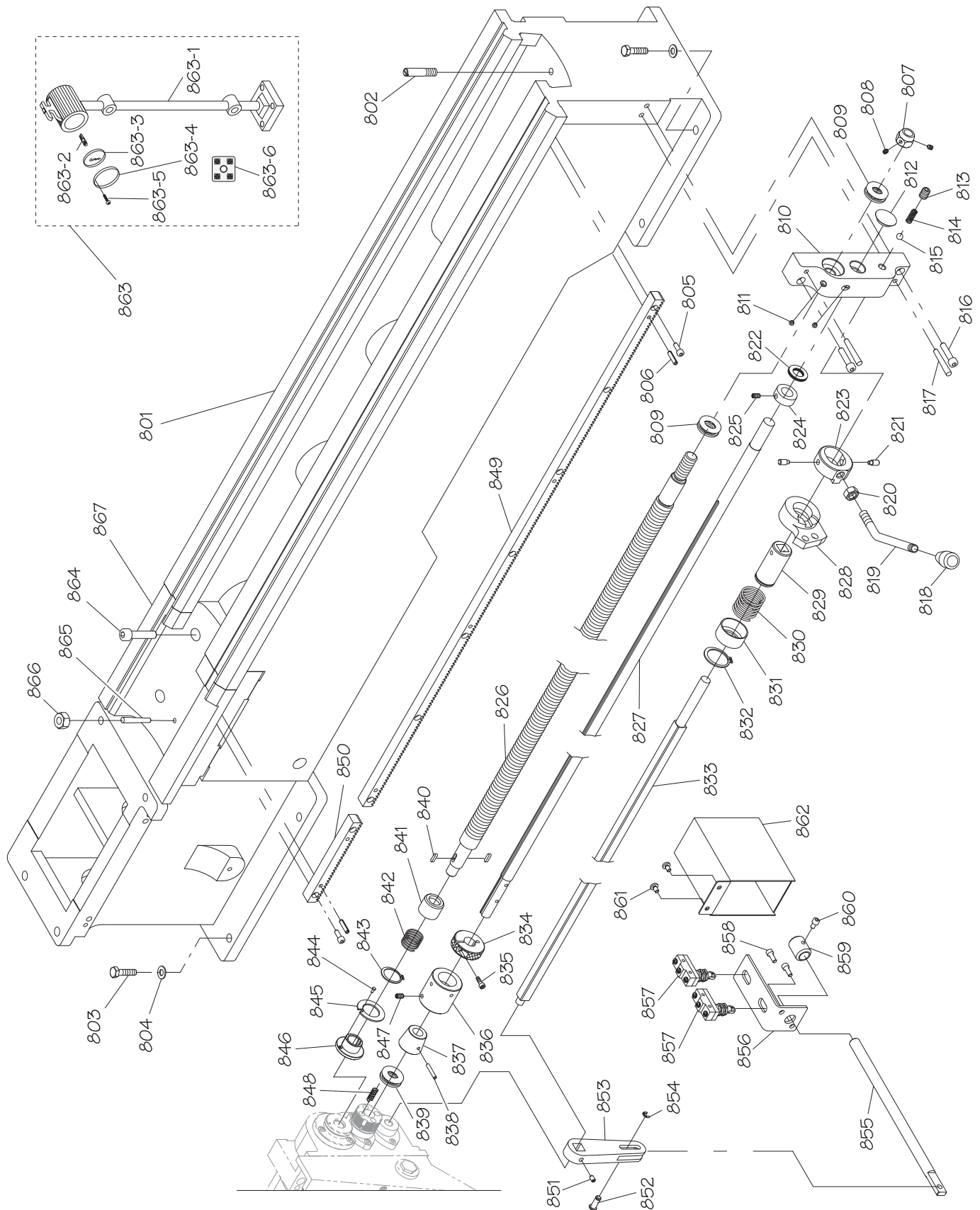
REF	PART #	DESCRIPTION
701	PCAP71M	CAP SCREW M10-1.5 X 60
702	PRIV001M	STEEL FLUTED RIVET 2 X 5MM
703	PSB10120803	INDICATOR PLATE
704	PSB10120804	MICROMETER DIAL
705	PSB10120805	BED STOP CASTING
706	PSB10120806	BED STOP ROD
707	PSB10120807	CLAMP PLATE
708	PSS10M	SET SCREW M10-1.5 X 20
709	PSB10120809	COPPER PLUNGER
710	PSS06M	SET SCREW M8-1.25 X 16
711	PSB10390711	DOG POINT SET SCREW M8-1.25 X 12
712	PSS14M	SET SCREW M8-1.25 X 12

# Dial Indicator



REF	PART #	DESCRIPTION
751	PSB10120701	DIAL PLATE
752	PSB10120702	PIVOT BOLT
753	PSB10120703	DIAL INDICATOR CASTING
754	PSB10120705	KNURLED KNOB
755	PSB10390755	DOUBLED-END LOCK STUD
757	PSB10120707	GEAR SPACER
758	PSB10120708	DIAL GEAR 16T
759	PCAP04M	CAP SCREW M6-1 X 10
760	PSS02M	SET SCREW M6-1 X 6
761	PNO3M	HEX NUT M8-1.25

# Bed & Shafts

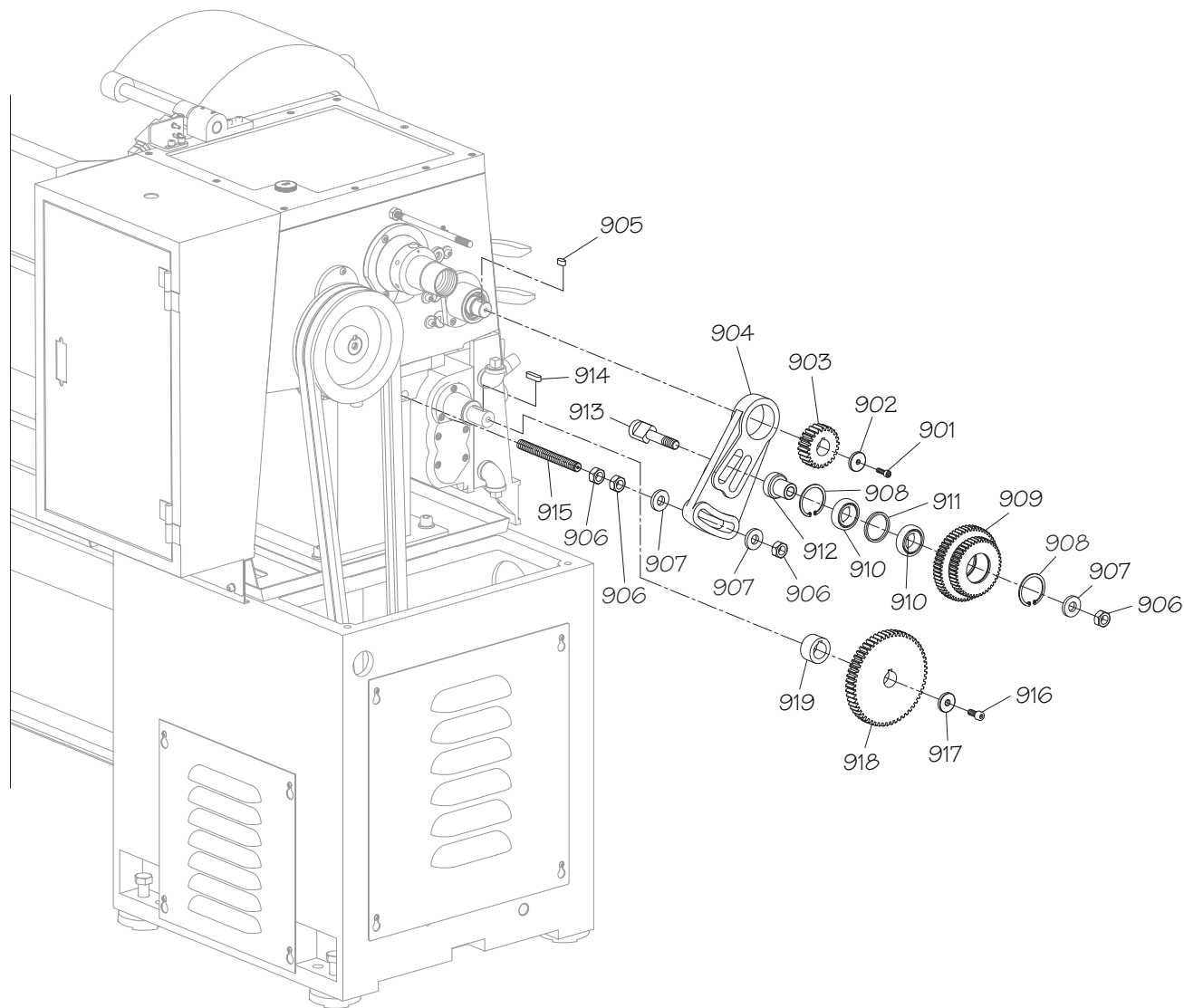


# Bed & Shafts Parts List

REF	PART #	DESCRIPTION
801	PSB10121201	BED
802	PSB10121202	BED STOP STUD
803	PB24M	HEX BOLT M12-1.75 X 45
804	PW06M	FLAT WASHER 12MM
805	PCAP02M	CAP SCREW M6-1 X 20
806	PRP93M	ROLL PIN 6 X 25
807	PSB10121227	LEADSCREW LOCK NUT
808	PSS03M	SET SCREW M6-1 X 8
809	P51203	THRUST BEARING 51203
810	PSB10121208	SHAFT END BRACKET
811	PLUBE001	TAP-IN BALL OILER 1/4
812	PSB10390812	FEED ROD END CAP
813	PSS15M	SET SCREW M12-1.75 X 12
814	PSB10390814	COMPRESSION SPRING
815	PSTB003	STEEL BALL 3/8
816	PCAP40M	CAP SCREW M8-1.25 X 35
817	PSB10390817	TAPER PIN #6 X 2"
818	PSB10390818	SPINDLE ON/OFF LEVER KNOB
819	PSB10121212	SPINDLE ON/OFF LEVER
820	PNO9M	HEX NUT M12-1.75
821	PSB10121211	STEP PIN
822	PSB10390822	THRUST BEARING 1831-NTB/AS2
823	PSB10121210	SPINDLE ON/OFF LEVER HUB
824	PSB10121209	LOCK COLLAR
825	PSS03M	SET SCREW M6-1 X 8
826	PSB10390826	LONGITUDINAL LEADSCREW 4 TPI
827	PSB10390827	FEED ROD
828	PSB10121214	SPINDLE LEVER SELECTOR BRACKET
829	PSB10121215	SPINDLE ROD SLEEVE
830	PSB10121216	SPINDLE ROD COMPRESSION SPRING
831	PSB10121217	SPINDLE ROD SPRING HOUSING
832	PR37M	EXT RETAINING RING 32MM
833	PSB10390833	SPINDLE ROD
834	PSB10121222	FEED ROD STOP COLLAR
835	PCAP02M	CAP SCREW M6-1 X 20
836	PSB10121223	FEED ROD CLUTCH COLLAR
837	PSB10121224	CLUTCH BUSHING

REF	PART #	DESCRIPTION
838	PSB10390838	TAPER PIN #4 X 1-1/4"
839	P51203	THRUST BEARING 51203
840	PK20M	KEY 5 X 5 X 15
841	PSB10121231	LEADSCREW SPRING HOUSING
842	PSB10121232	LEADSCREW SPRING
843	PR37M	EXT RETAINING RING 32MM
844	PSB10121234	LEADSCREW SHEAR PIN
845	PSB10121235	KEYED LEADSCREW WASHER
846	PSB10121236	LEADSCREW FLANGE WASHER
847	PSS02M	SET SCREW M6-1 X 6
848	PSB10390848	SPRING 8 X 32
849	PSB10390849	BED RACK
850	PSB10390850	GAP RACK
851	PSS14M	SET SCREW M8-1.25 X 12
852	PSB10390852	CAPTIVE PIN
853	PSB10390853	SPINDLE SWITCH PIVOT ARM
854	PECO9M	E-CLIP 6MM
855	PSB10390855	SPINDLE SWITCH LINKAGE ROD
856	PSB10390856	SPINDLE SWITCH BRACKET
857	PSB10390857	SPINDLE SWITCH
858	PCAP01M	CAP SCREW M6-1 X 10
859	PSB10390859	LOCK COLLAR
860	PCAP04M	CAP SCREW M6-1 X 10
861	PS68M	PHLP HD SCR M6-1 X 10
862	PSB10390862	SPINDLE SWITCH COVER BOX
863	PSB10161254	HALOGEN LAMP ASSEMBLY
863-1	PSB10161254-1	LAMP BODY
863-2	PSB10161254-2	HALOGEN BULB 24V
863-3	PSB10161254-3	LENS
863-4	PSB10161254-4	LENS RETAINER
863-5	PS55M	PHLP HD SCR M3-.5 X 10
863-6	PSB10161254-6	LAMP TERMINAL BLOCK 2P
864	PCAP64M	CAP SCREW M10-1.5 X 25
865	PSB1039865	GAP INSERT THREADED TAPER PIN
866	PNO3M	HEX NUT M8-1.25
867	PSB1039867	GAP INSERT

# End Gears



REF	PART #	DESCRIPTION
901	PCAP02M	CAP SCREW M6-1 X 20
902	PSB10121402	GEAR FLAT WASHER
903	PSB10390903	GEAR 24T
904	PSB10121404	PIVOT ARM
905	PK166M	KEY 7 X 7 X 15
906	PN32M	HEX NUT M14-2
907	PSB10121407	GEAR FLAT WASHER
908	PR25M	INT RETAINING RING 47MM
909	PSB10121409	COMBO GEAR 44T/56T
910	P6005ZZ	BALL BEARING 6005 ZZ

REF	PART #	DESCRIPTION
911	PSB10121411	THRUST WASHER
912	PSB10121412	SHAFT SLEEVE
913	PSB10121413	T-HEAD SHAFT
914	PK28M	KEY 7 X 7 X 30
915	PSB10121840	PIVOT ARM ALL-THREAD STUD
916	PCAP14M	CAP SCREW M8-1.25 X 20
917	PSB10390917	GEAR FLAT WASHER
918	PSB10121418	GEAR 57T
919	PSB10121419	GEAR SPACER

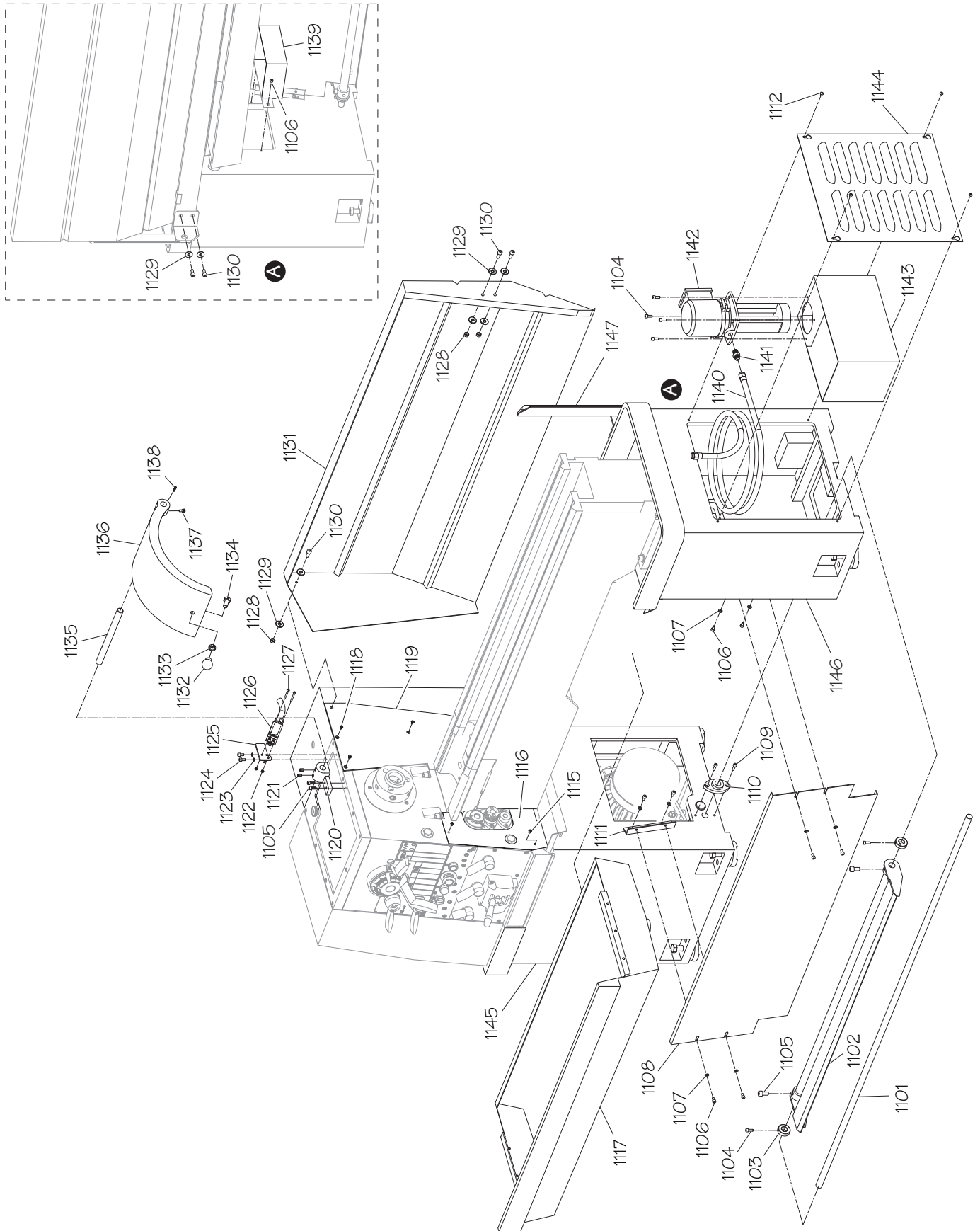


# Main Motor Parts List

REF	PART #	DESCRIPTION
1001	PSB10391001	HEADSTOCK LEFT COVER
1002	PSB10121505	KNURLED KNOB
1003	PVB76	V-BELT B76
1004	PSB10121520	DOUBLE-END STUD
1005	PNO2M	HEX NUT M10-1.5
1006	PS68M	PHLP HD SCR M6-1 X 10
1007	PSB10121522	LEFT CABINET SIDE ACCESS PANEL
1008	PNO3M	HEX NUT M8-1.25
1009	PSB10121524	SINGLE-END STUD
1010	PSB10121525	BRAKE PEDAL TENSION SPRING
1011	PCAP191M	CAP SCREW M8-1.25 X 120
1012	PSB10391012	MOTOR MOUNT PIVOT ROD
1013	PSB10391013	MOTOR MOUNT PLATE
1014	PCAP64M	CAP SCREW M10-1.5 X 25
1015	PCAP01M	CAP SCREW M6-1 X 16
1016	PSB10391016	BRAKE LINKAGE CAM COLLAR
1017	PSB10121512	BRAKE BELT PIVOT ARM
1018	PSB10391018	BRAKE BELT TOP CLAMP PLATE
1019	PWO1M	FLAT WASHER 8MM
1020	PCAP45M	CAP SCREW M8-1.25 X 45
1021	PECO15M	E-CLIP 8MM
1022	PSB10121507	MOTOR PULLEY FLAT WASHER
1023	PSB10121517	BRAKE BELT
1024	PSB10121518	BRAKE BELT PIVOT ARM CAPTIVE PIN
1025	PSB10391025	TAPER PIN #4 X 1-3/4"
1026	PSB10391026	BRAKE BELT BOTTOM CLAMP PLATE

REF	PART #	DESCRIPTION
1027	PSB10391027	MOTOR PULLEY
1028	PN13M	HEX NUT M16-2
1029	PSB10121532	ALL-THREAD STUD M16-2 X 170
1030	PSB10391030	MOTOR MOUNT STUD WASHER
1031	PSB10121534	RUBBER CUSHION RING
1032	PCAP26M	CAP SCREW M6-1 X 12
1033	PNO4M	HEX NUT M4-.7
1034	PCAP70M	CAP SCREW M10-1.5 X 45
1035	PWO4M	FLAT WASHER 10MM
1036	PSB10391036	BRAKE SWITCH BRACKET
1037	PSB10391037	BRAKE SWITCH
1038	PS51M	PHLP HD SCR M4-.7 X 30
1039	PSB10121209	CAST IRON FOOT PAD
1040	PB51M	HEX BOLT M16-2 X 50
1041	PSB10391041	RIGHT CABINET REAR ACCESS PANEL
1042	PCAP04M	CAP SCREW M6-1 X 10
1043	PWO3M	FLAT WASHER 6MM
1044	PSB10391044	ELECTRICAL CABINET W/DOOR-LATCH
1045	PWO1M	FLAT WASHER 8MM
1046	PCAP14M	CAP SCREW M8-1.25 X 20
1047	PS65M	PHLP HD SCR M4-.7 X 40
1048	PSB10391048	HEADSTOCK LEFT COVER SAFETY SWITCH
1049	PSB10391049	MOTOR 5/2.5HP 220V 3PH
1049-1	PSB10391049-1	MOTOR FAN COVER
1049-2	PSB10391049-2	MOTOR FAN
1049-3	PSB10391049-3	MOTOR JUNCTION BOX

# Cabinets & Panels

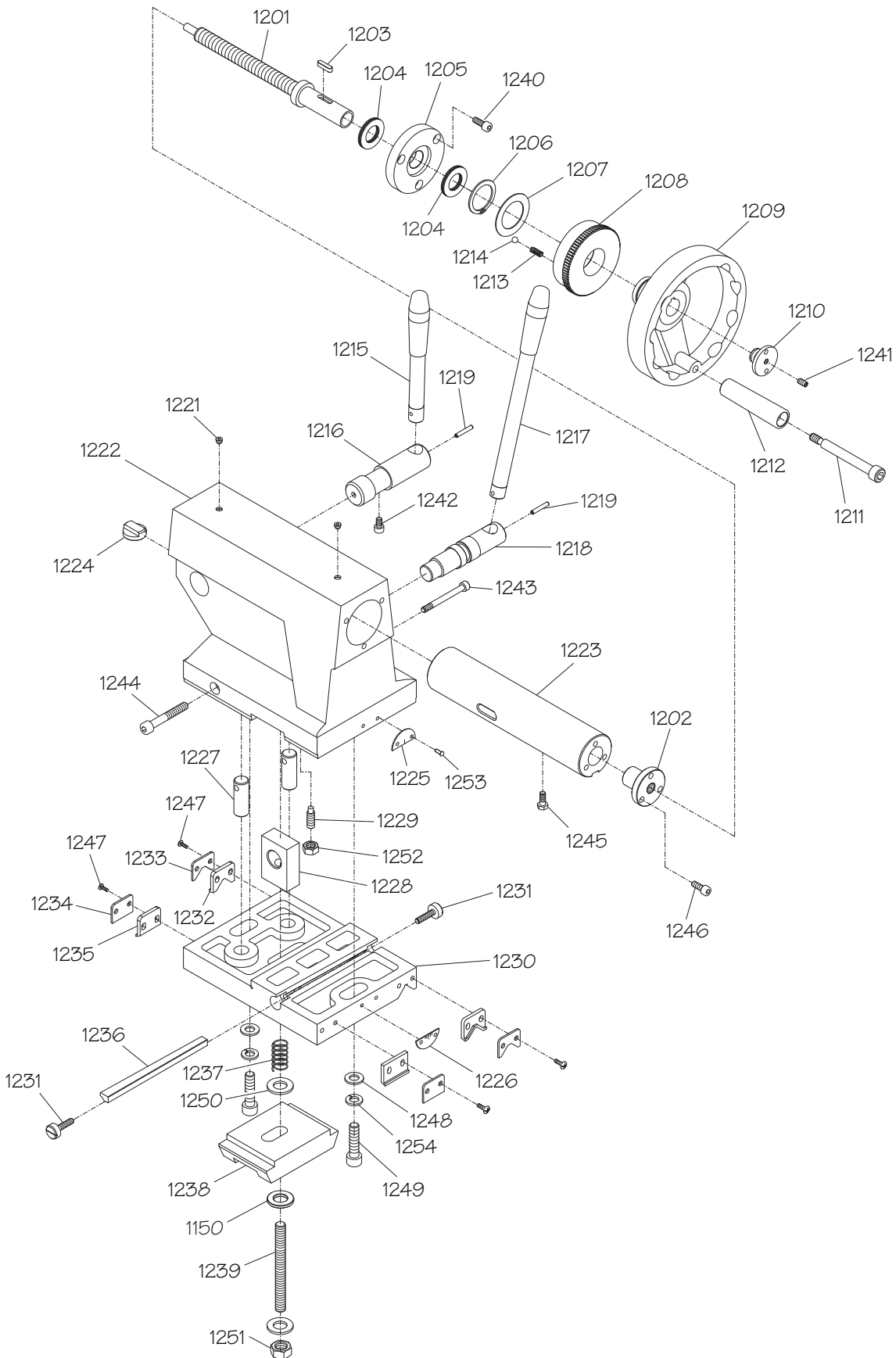


# Cabinets & Panels Parts List

REF	PART #	DESCRIPTION
1101	PSB10391101	BRAKE PEDAL SHAFT
1102	PSB10121605	BRAKE PEDAL
1103	PSB10121608	LOCK COLLAR
1104	PCAP01M	CAP SCREW M6-1 X 16
1105	PB56M	CAP SCREW M10-1.5 X 20
1106	PCAP04M	CAP SCREW M6-1 X 10
1107	PW03M	FLAT WASHER 6MM
1108	PSB10391108	CENTER PANEL
1109	PCAP02M	CAP SCREW M6-1 X 20
1110	PSB10391110	FLANGE BEARING
1111	PSB10391111	CENTER PANEL BRACKET
1112	PS68M	PHLP HD SCR M6-1 X 10
1115	PS05M	PHLP HD SCR M5-.8 X 8
1116	PSB10121619	SHAFT CLUTCH COVER
1117	PSB10391117	CHIP DRAWER
1118	PFH30M	FLAT HD SCR M5-.8 X 8
1119	PSB10391119	ACCESS PANEL
1120	PSB10391120	CHUCK GUARD PIVOT BRACKET
1121	PS514M	SET SCREW M8-1.25 X 12
1122	PNO4M	HEX NUT M4-.7
1123	PLW03M	LOCK WASHER 6MM
1124	PCAP26M	CAP SCREW M6-1 X 12
1125	PSB10121637	SAFETY SWITCH BRACKET

REF	PART #	DESCRIPTION
1126	PSB10121638	CHUCK GUARD SAFETY SWITCH
1127	PS65M	PHLP HD SCR M4-.7 X 40
1128	PNO3M	HEX NUT M8-1.25
1129	PW01M	FLAT WASHER 8MM
1130	PCAP14M	CAP SCREW M8-1.25 X 20
1131	PSB10391131	SPLASH GUARD
1132	PSB10391132	CHUCK GUARD KNOB
1133	PNO9M	HEX NUT M12-1.75
1134	PCAP129M	CAP SCREW M12-1.75 X 20
1135	PSB10121629	CHUCK GUARD PIVOT ROD
1136	PSB10391136	CHUCK GUARD
1137	PCAP26M	CAP SCREW M6-1 X 12
1138	PS534M	SET SCREW M5-.8 X 16
1139	PSB10391139	CUTTING FLUID CHUTE
1140	PSB10391140	CUTTING FLUID HOSE 3/8 PT X 72"
1141	PSB10391141	PIPE NIPPLE 3/8 PT X 3/8 PH
1142	PSB10391142	CUTTING FLUID PUMP 1/8HP 220V 3PH
1143	PSB10391143	CUTTING FLUID RESERVOIR
1144	PSB10391144	CUTTING FLUID ACCESS PANEL
1145	PSB10391145	LEFT CABINET
1146	PSB10391146	RIGHT CABINET
1147	PSB10391147	SPLASH GUARD SUPPORT

# Tailstock

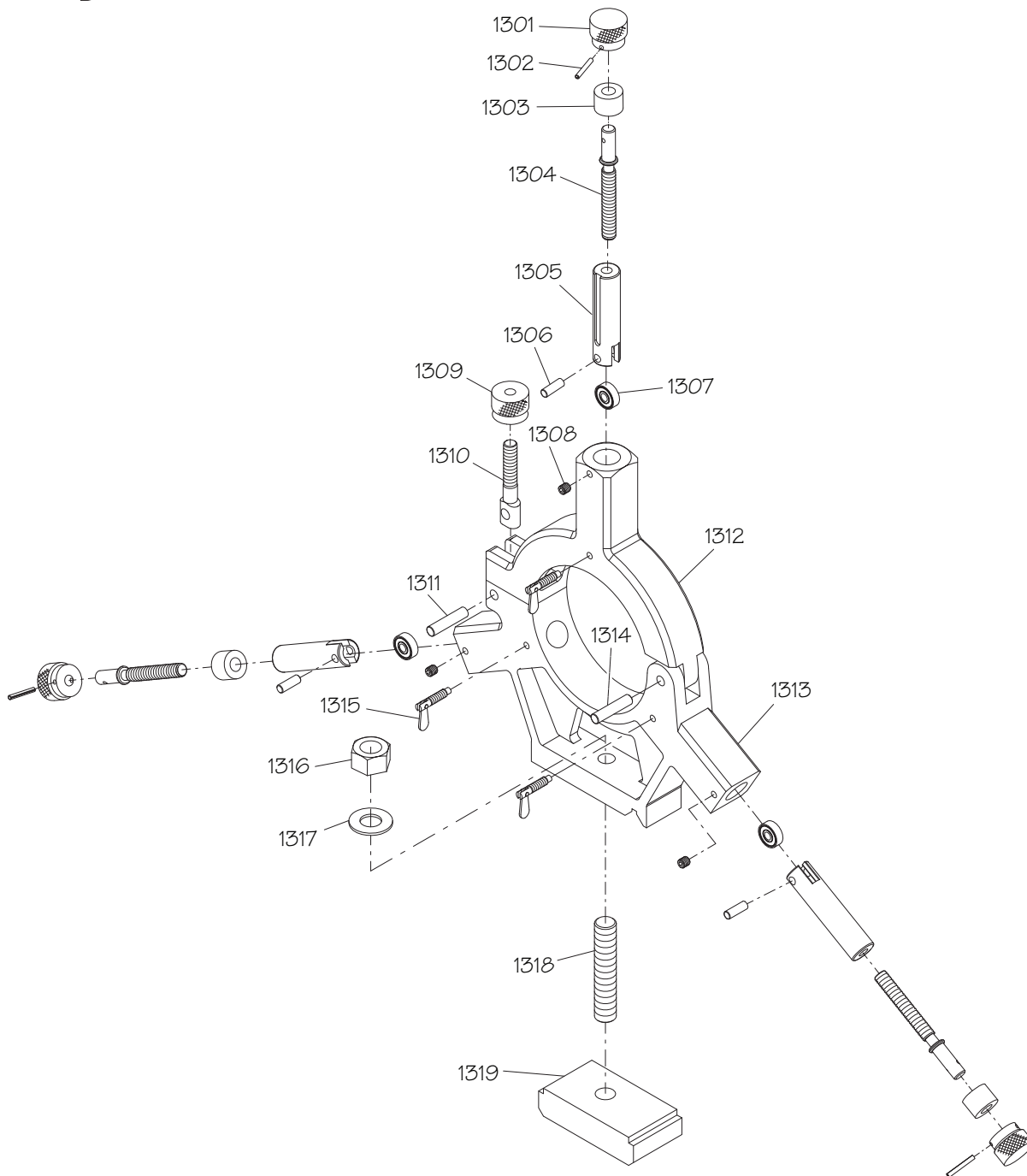


# Tailstock Parts List

REF	PART #	DESCRIPTION
1201	PSB10121801	TAILSTOCK LEADSCREW
1202	PSB10121802	TAILSTOCK LEADSCREW NUT
1203	PK34M	KEY 5 X 5 X 20
1204	PSB10391204	THRUST BEARING 2035-NTB/AS2
1205	PSB10121805	BEARING FLANGE SEAT
1206	PR37M	EXT RETAINING RING 32MM
1207	PSB10121807	THRUST WASHER
1208	PSB10121808	GRADUATED DIAL
1209	PSB10121809	QUILL HANDWHEEL
1210	PSB10121810	HANDWHEEL END CAP
1211	PSB10121811	HANDLE BOLT
1212	PSB10121812	HANDWHEEL HANDLE
1213	PSB10120515	COMPRESSION SPRING 6.2 X 16MM
1214	PSTB001	STEEL BALL 1/4
1215	PSB10121815	QUILL LOCK LEVER
1216	PSB10121816	QUILL LOCK LEVER CAM SHAFT
1217	PSB10121812	TAILSTOCK LOCK LEVER
1218	PSB10121818	TAILSTOCK LOCK LEVER CAM SHAFT
1219	PRP04M	ROLL PIN 4 X 24
1221	FLUBE001	TAP-IN BALL OILER 1/4
1222	PSB10391222	TAILSTOCK CASTING
1223	PSB10121824	QUILL
1224	PSB10121825	QUILL ALIGNMENT KEY
1225	PSB10121826	UPPER OFFSET PLATE
1226	PSB10121827	LOWER OFFSET PLATE
1227	PSB10121828	ALIGNMENT PIN
1228	PSB10121829	PIVOT BLOCK

REF	PART #	DESCRIPTION
1229	PSB10121830	DOG POINT SET SCREW
1230	PSB10121831	TAILSTOCK BASE
1231	PSB10121829	GIB ALIGNMENT SCREW M6-1 X 16
1232	PSB10121833	V-WAY WIPER
1233	PSB10121834	V-WAY WIPER PLATE
1234	PSB10391234	STRAIGHT WAY WIPER PLATE
1235	PSB10391235	STRAIGHT WAY WIPER
1236	PSB10121837	TAILSTOCK GIB
1237	PSB10121838	COMPRESSION SPRING 25 X 45
1238	PSB10121839	CLAMP PLATE
1239	PSB10122108	ALL-THREAD CLAMP STUD
1240	PCAP01M	CAP SCREW M6-1 X 16
1241	PSS04M	SET SCREW M6-1 X 12
1242	PCAP26M	CAP SCREW M6-1 X 12
1243	PCAP128M	CAP SCREW M8-1.25 X 70
1244	PCAP35M	CAP SCREW M8-1.25 X 60
1245	PB05M	HEX BOLT M6-1 X 8
1246	PCAP01M	CAP SCREW M6-1 X 16
1247	PS08M	PHLP HD SCR M5-.8 X 12
1248	PW04M	FLAT WASHER 10MM
1249	PCAP47M	CAP SCREW M10-1.5 X 40
1250	PW10M	FLAT WASHER 14MM
1251	PN32M	HEX NUT M14-2
1252	PNO3M	HEX NUT M8-1.25
1253	PRIV001M	STEEL FLUTED RIVET 2 X 5MM
1254	PLW06M	LOCK WASHER 10MM

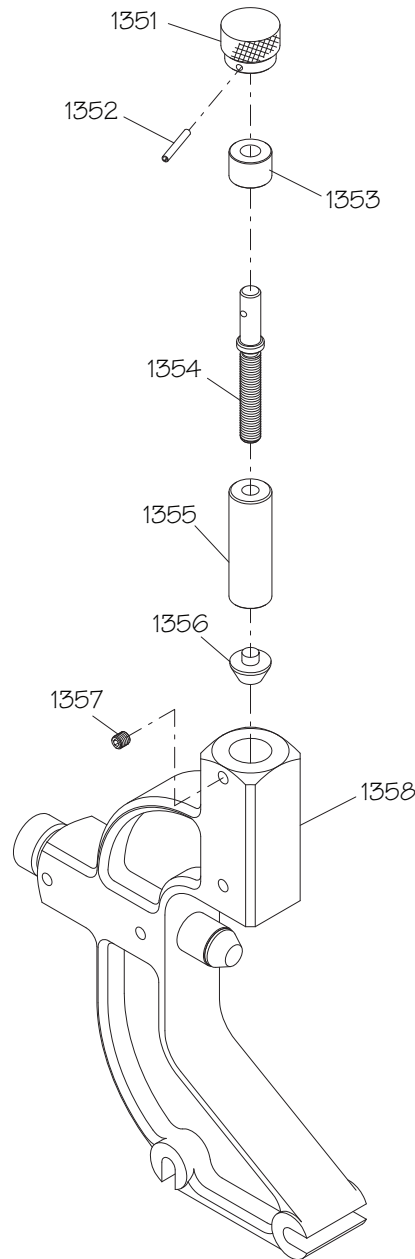
# Steady Rest



REF	PART #	DESCRIPTION
1301	PSB10122001	FINGER ADJUSTMENT KNOB
1302	PRP51M	ROLL PIN 4 X 40
1303	PSB10122003	BUSHING
1304	PSB10122004	FINGER ADJUSTMENT SCREW
1305	PSB10122005	FINGER
1306	PSB10122006	DOWEL PIN
1307	P627ZZ	BALL BEARING 627 ZZ
1308	PS620M	SET SCREW M8-1.25 X 8
1309	PSB10122009	CLAMP SCREW KNOB
1310	PSB10122010	CLAMP SCREW

REF	PART #	DESCRIPTION
1311	PSB10122011	DOWEL PIN
1312	PSB10122012	TOP STEADY REST CASTING
1313	PSB10122013	BOTTOM STEADY REST CASTING
1314	PSB10122014	HINGE PIN
1315	PSB10122015	DOG PT LEAF SCREW M8-1.25 X 25
1316	PN09M	HEX NUT M12-1.75
1317	PW06M	FLAT WASHER 12MM
1318	PSB10391318	ALL-THREAD STUD M12-1.75 X 75
1319	PSB10122019	CLAMP PLATE

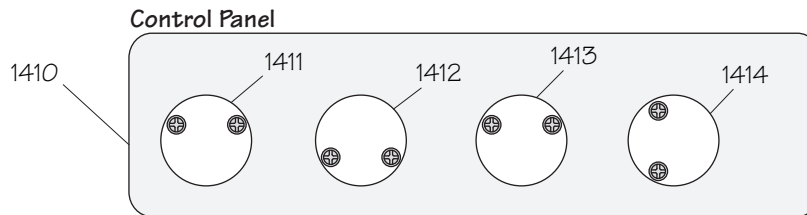
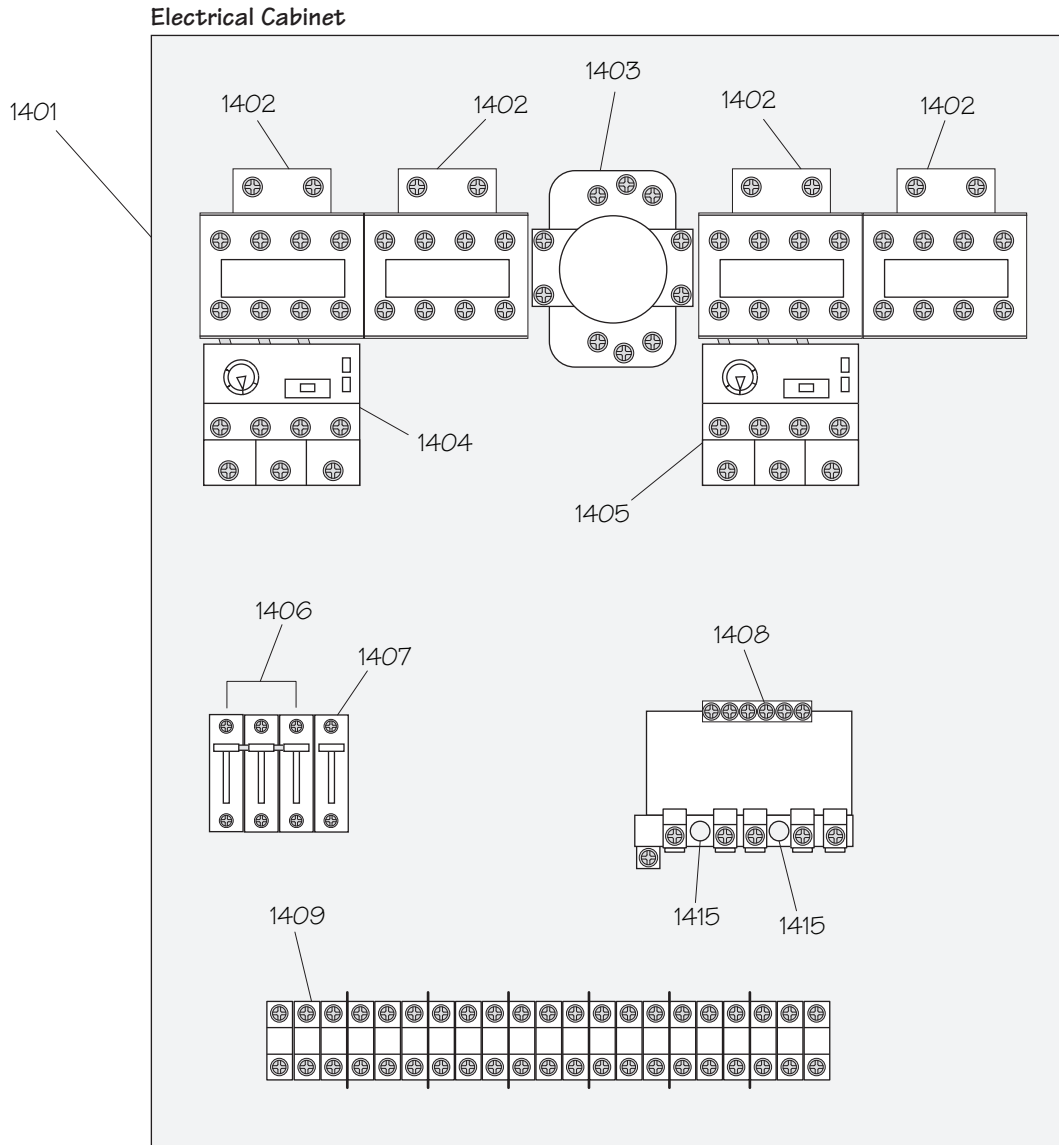
# Follow Rest



REF	PART #	DESCRIPTION
1351	PSB10122001	FINGER ADJUSTMENT KNOB
1352	PRP51M	ROLL PIN 4 X 40
1353	PSB10122003	BUSHING
1354	PSB10122104	FINGER ADJUSTMENT SCREW

REF	PART #	DESCRIPTION
1355	PSB10122105	FINGER
1356	PSB10122106	BRASS FINGER POINT
1357	PSG20M	SET SCREW M8-1.25 X 8
1358	PSB10122108	FOLLOW REST CASTING

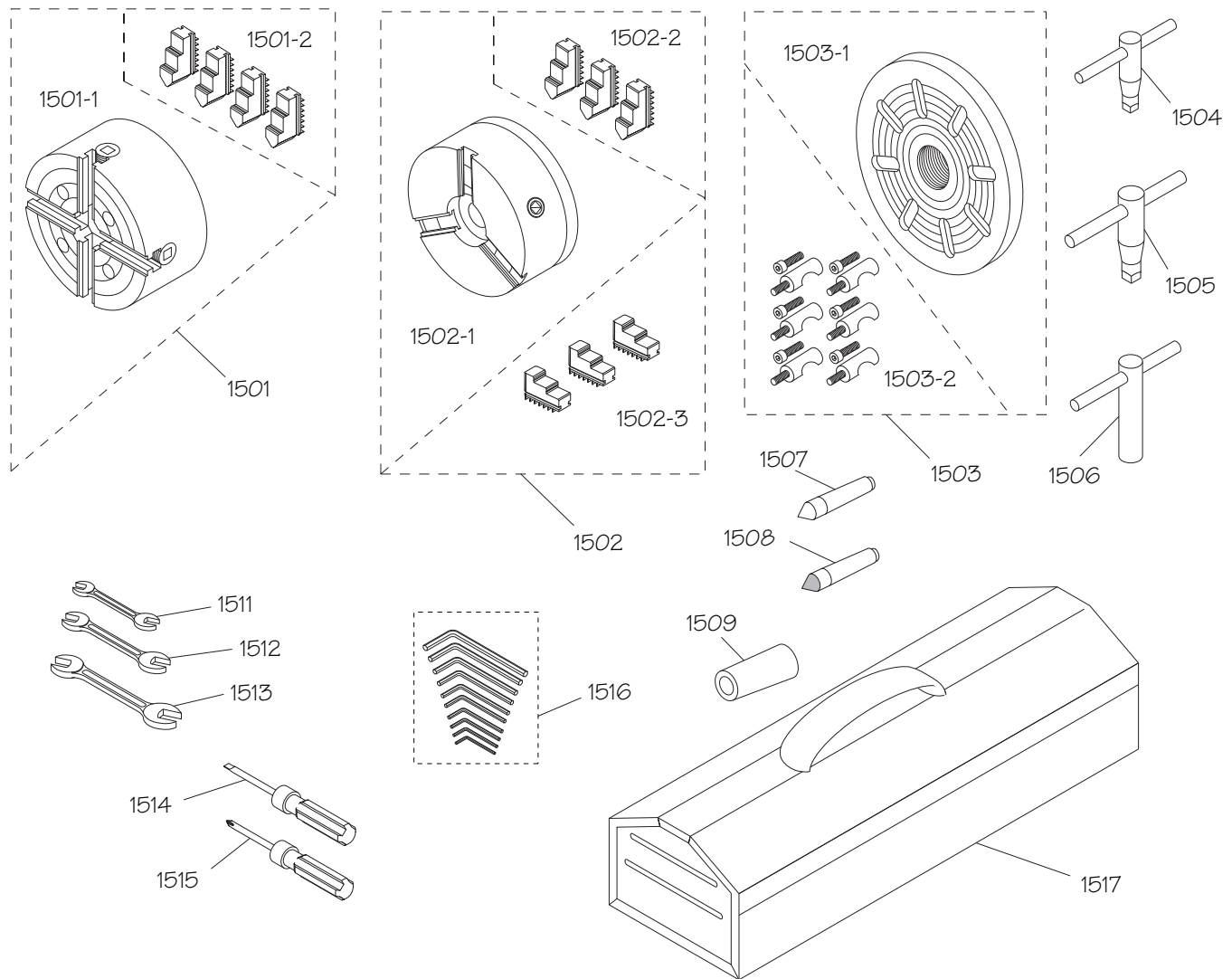
# Electrical Cabinet & Control Panel



REF	PART #	DESCRIPTION
1401	PSB10391401	ELECTRICAL BACKPLATE
1402	PSB10391402	CONTACTOR AB CO9400 220V
1403	PSB10391403	MASTER POWER SWITCH
1404	PSB10391404	OL RELAY AB 193-TAC24-A 16-24
1405	PSB10391405	OL RELAY AB 193-ATA40-A .24-.40
1406	PSB10391406	CIRCUIT BREAKER AB D25
1407	PSB10391407	CIRCUIT BREAKER AB D6
1408	PSB10391408	TRANSFORMER GUENN LIANG SP-TBSW

REF	PART #	DESCRIPTION
1409	PSB10391409	TERMINAL BLOCK 3 POST
1410	PSB10391410	CONTROL PANEL PLATE
1411	PSB10391411	JOG BUTTON
1412	PSB10391412	EMERGENCY STOP BUTTON
1413	PSB10391413	POWER LAMP
1414	PSB10391414	CUTTING FLUID SWITCH
1415	PSB10391415	FUSE ASSEMBLY 4A
1416	PSB10391416	FUSE ASSEMBLY 1/2A

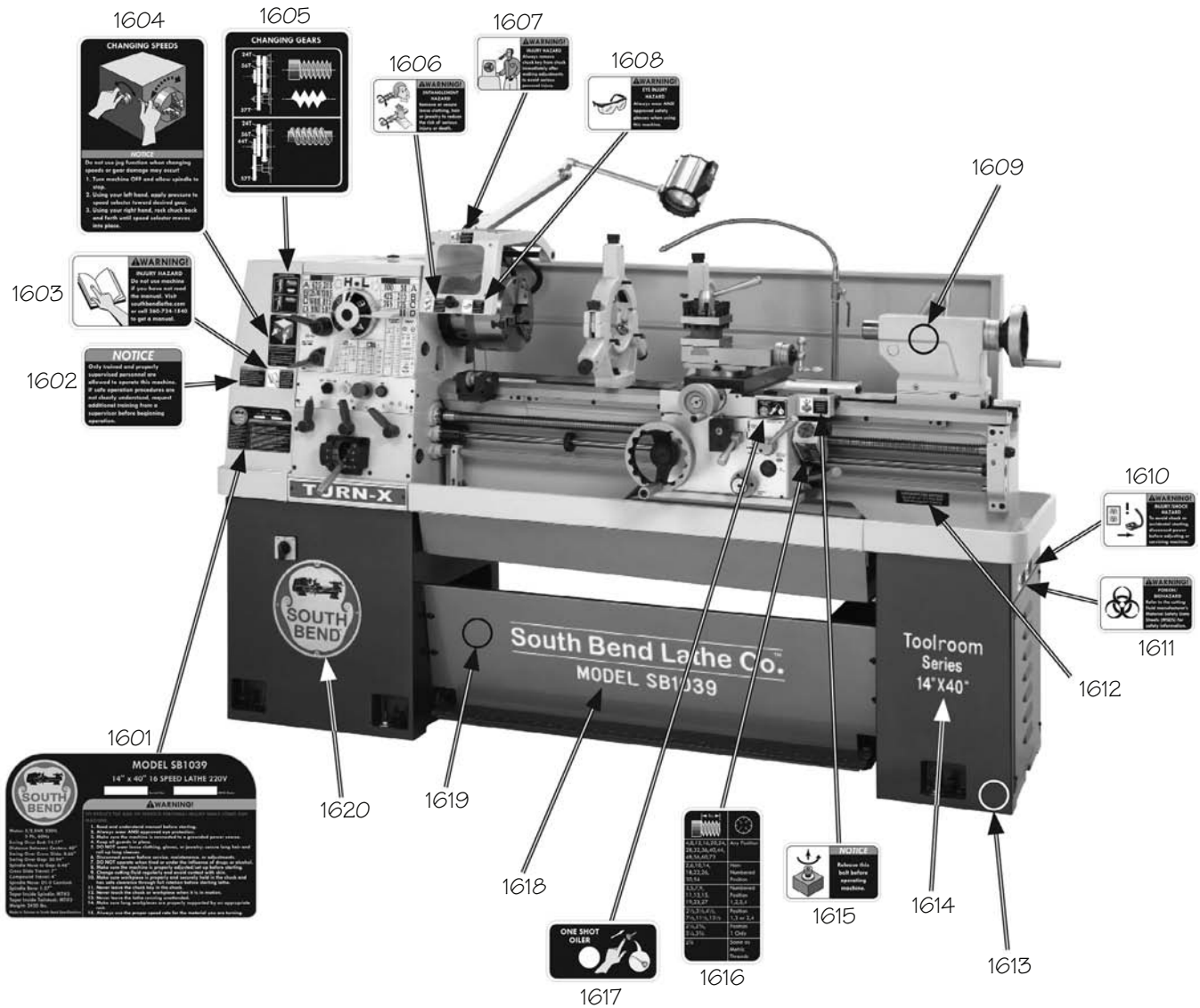
# Accessories



REF	PART #	DESCRIPTION
1501	PSB10122301	4-JAW CHUCK 10" ASSEMBLY
1501-1	PSB10122301-1	4-JAW CHUCK BODY 10"
1501-2	PSB10122301-2	4-JAW CHUCK JAW SET
1502	PSB10122302	3-JAW CHUCK 8" ASSEMBLY
1502-1	PSB10122302-1	3-JAW CHUCK BODY 8"
1502-2	PSB10122302-2	3-JAW CHUCK STANDARD JAW SET
1502-3	PSB10122310	3-JAW CHUCK REVERSIBLE JAW SET
1503	PSB10391503	FACEPLATE ASSEMBLY ASSEMBLY 12"
1503-1	PSB10391503-1	FACEPLATE BODY 12"
1503-2	PSB10391503-2	FACEPLATE CAMLOCK STUD SET
1504	PSB10122304	3-JAW CHUCK KEY
1505	PSB10122305	4-JAW CHUCK KEY

REF	PART #	DESCRIPTION
1506	PSB10122306	TOOL POST T-WRENCH
1507	PSB10122307	HSS TIP DEAD CENTER MT#4
1508	PSB10122308	CARBIDE TIP DEAD CENTER MT#4
1509	PSB10122309	SPINDLE SLEEVE MT#4/MT#6
1511	PWR1012	WRENCH 10/12MM
1512	PWR1417	WRENCH 14/17MM
1513	PWR2224	WRENCH 22/24MM
1514	PSDF2	SCREWDRIVER FLAT #2
1515	PSDP2	SCREWDRIVER PHILLIPS #2
1516	PAW1510M	HEX WRENCH SET 10PC 1.5-10MM
1517	PSB10122317	TOOLBOX

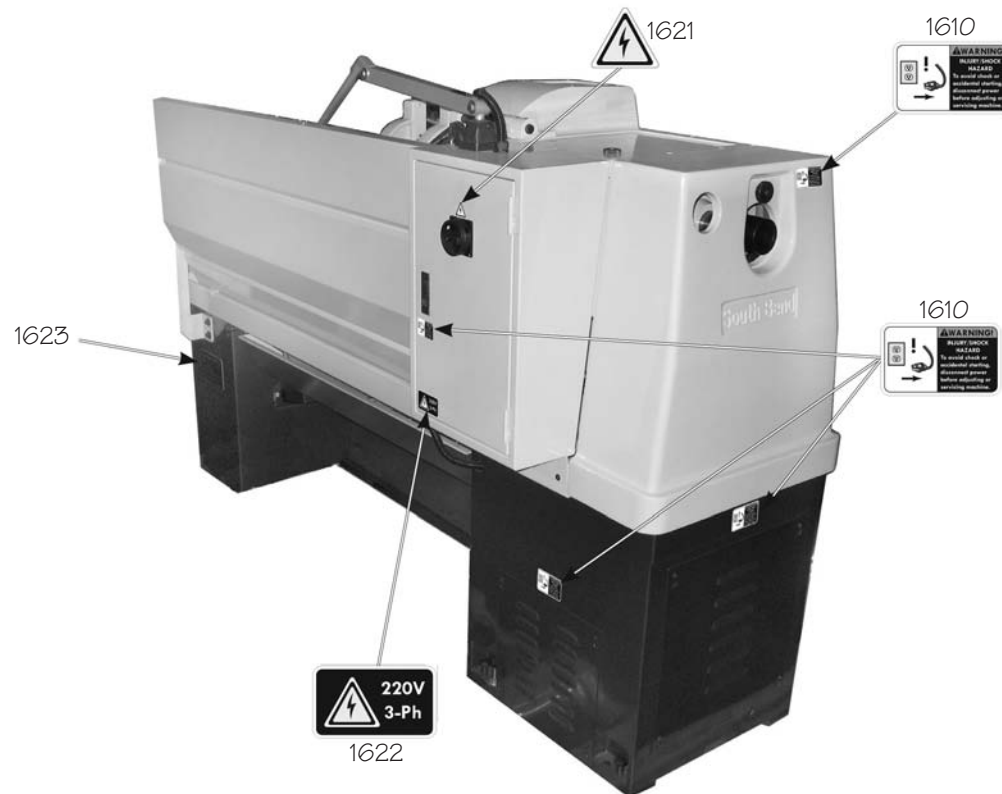
# Front Machine Labels



**⚠ WARNING**

The safety labels provided with your machine are used to make the operator aware of the machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of these safety labels. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact South Bend Lathe Co. at (360) 734-1540 or [www.southbendlathe.com](http://www.southbendlathe.com) to order new labels.

# Rear & Side Machine Labels



REF	PART #	DESCRIPTION
1601	PSB10391601	MACHINE ID LABEL
1602	PSBLABEL19	AUTHORIZED PERSONNEL NOTICE LABEL
1603	PSBLABEL01HS	READ MANUAL LABEL
1604	PSB10122408	CHANGING SPEED NOTICE LABEL
1605	PSB10122409	CHANGING GEARS LABEL
1606	PSBLABEL08HS	ENTANGLEMENT HAZARD LABEL
1607	PSB10122411	CHUCK KEY HAZARD LABEL
1608	PSBLABEL04HS	EYE INJURY HAZARD LABEL
1609	PSBPAINTO1	SB GRAY TOUCH-UP PAINT
1610	PSBLABEL02HS	DISCONNECT POWER LABEL
1611	PSBLABEL06HS	BIOHAZARD LABEL
1612	PSB10391612	BED/WAY DESCRIPTION LABEL

REF	PART #	DESCRIPTION
1613	PSBPAINTO3	SB DARK BLUE TOUCH-UP PAINT
1614	PSB10122415	TOOL ROOM SERIES LABEL
1615	PSB10122401	RELEASE BOLT NOTICE LABEL
1616	PSB10122402	THREAD DIAL CHART LABEL
1617	PSB10122403	ONE-SHOT OILER LABEL
1618	PSB10391618	SB MODEL NUMBER LABEL
1619	PSBPAINTO2	SB LIGHT BLUE TOUCH-UP PAINT
1620	SB1322	SOUTH BEND NAMEPLATE 255MM
1621	PSBLABEL15M	ELECTRICITY LABEL
1622	PSB10122423	220V 3-PHASE LABEL
1623	PSB10391623	MACHINE INFORMATION LABEL

## **Warranty**

This quality product is warranted by South Bend Lathe Company to the original buyer for one year from the date of purchase. This warranty does not apply to consumable parts, or defects due to any kind of misuse, abuse, negligence, accidents, repairs, alterations or lack of maintenance. We do not reimburse for third party repairs. In no event shall we be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our products.

We do not warrant or represent that this machine complies with the provisions of any law, act, code, regulation, or standard of any domestic or foreign government, industry, or authority. In no event shall South Bend's liability under this warranty exceed the original purchase price paid for this machine. Any legal actions brought against South Bend Lathe Company shall be tried in the State of Washington, County of Whatcom.

This is the sole written warranty for this machine. Any and all warranties that may be implied by law, including any merchantability or fitness, for any purpose, are hereby limited to the duration of this warranty. To take advantage of this warranty, contact us by mail or phone to give us the details of the problem you are having.

Thank you for your business and continued support.



**South Bend Lathe Co.  
P.O. Box 2027  
Bellingham, WA 98227**

**PHONE: (360) 734-1540 (Administrative Offices)**

**FAX: (360) 676-1075 (International)**

**FAX: (360) 734-1639 (USA only)**

**[southbendlathe.com](http://southbendlathe.com)**

