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WOOD LATHE

INSTRUCTION MANUAL

MODEL: MCS1000

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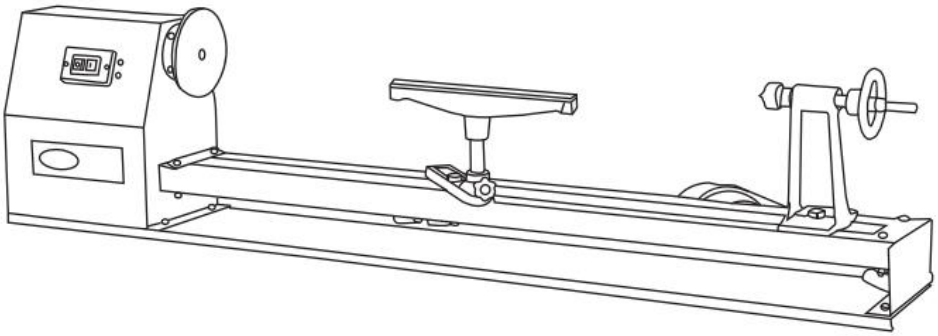


NEED HELP? CONTACT US!

Have product questions? Need technical support? Please feel free to contact us:

CustomerService@vevor.com

This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.

MATTERS NEEDING ATTENTION

The information contained in this handbook is intended as a guide to the operation of these machines and does not form part of any contract.The data it contains has been obtained from the machine manufacturer and from other sources. We strive to ensure the accuracy of this information and try to verify each item and each data, but we cannot guarantee the full accuracy of the information, which means that the equipment supply may differ in detail from the description of the instructions. Furthermore, development of the machine may mean that the equipment supplied may differ in detail from the descriptions herein. The responsibility therefore lies with the user to satisfy himself that the equipment or process described is suitable for the purpose intended.

QUALITY ASSURANCE

We will make every effort to ensure the quality of our products, and we promise to consumers that we will guarantee our products for one year, except for machine damage caused by improper operation of customers, and accidents resulting therefrom, or abnormal wear and damage caused by lack of maintenance.
In order to fulfill the warranty commitment, the product or part with quality problems, please return to us for verification, postage prepaid. Goods sent back should be accompanied by a note of the date of purchase and a written explanation of the quality of the product. After our inspection and confirmation, we will repair or replace their products, or refund the payment; If we fail to provide repair or replacement in a timely manner, we shall bear the costs arising from the repair or replacement of the products; If the damage is not due to the quality of the product, but due to the user's improper operation or other reasons, the cost shall be borne by the customer .

Our company reserves the right to make changes to this specification and product specifications. We will make continuous efforts to improve the quality of our products.

SAFETY WARNING

Symbol	Symbol Description
	Warning - To reduce the risk of injury, user must read instructions manual carefully.
	This symbol, placed before a safety comment, indicates a kind of precaution, warning, or danger. Ignoring this warning may lead to an accident. To reduce the risk of injury, fire, or electrocution, please always follow the recommendation shown below.
	Do not overload the machine Provide good stability and keep balance all times Avoid abnormal working postures! Make sure you stand squarely and keep balance at all times. Always stay focused when working. Reduce distortion sources in your working environment. The operation of the machine when being tired, as well as under the influence of alcohol, drugs or concentration influencing medicaments is forbidden. Do not climb onto the machine! The machine must be operated only by trained persons (knowledge and understanding of this manual), which have no limitations of motor skills compared with conventional workers. Do not allow other people, particularly children, to touch the machine or the cable. Keep them away from your work area. Make your workshop childproof. Make sure there is nobody present in the dangerous area. The minimum safety distance is 2m Wear suitable work clot

	Danger! Risk of personal injury or environmental damage! Risk of electric shock! Risk of personal injury by electric shock!
	Alternating current
	Never grab into the running machine! Remove chips and workpiece parts only if the machine is standing still! Never stop workpieces with the hand during run out! Never take measurements on a rotating workpiece!
	Do not wear safety gloves!
	Warning- Be sure to wear ear protectors when using this product.
	Warning- Be sure to wear eye protectors when using this product.
	Warning- Be sure to wear dust masks when using this product.
	Wear suitable work clothes! Do not wear loose clothing or jewelry as they might get caught in moving parts and cause severe accidents! Wear a hair net if you have long hair. Loose objects can become entangled and cause serious injuries!
	Never leave the machine running unattended! Before leaving the working area switch the machine off and wait until the machine stops. Always disconnect the machine prior to any actions performed at the machine. Avoid unintentional starting Do not use the machine with damaged switch

	The plug of an electrical tool must strictly correspond to the socket. Do not use any adapters together with earthed electric tools
	Each time you work with an electrically operated machine, caution is advised! There is a risk of electric shock, fire, cutting injury; Protect the machine from dampness (causing a short circuit) Use power tools and machines never in the vicinity of flammable liquids and gases (danger of explosion) Check the cable regularly for damage Do not use the cable to carry the machine or to fix the work piece Protect the cable from heat, oil and sharp edges Avoid body contact with earthed
	Before start working remove any nails and other foreign bodies from the workpiece Keep any machine that is not being used out of reach of children
	This product is of protection class III.
	FCC statement: This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions:(1)This device may not cause harmful interference, and (2)this device must accept any interference received, including interference that may cause undesired operation.
	Disposal information: This product is subject to the provision of European Directive 2012/19/EC. The symbol showing a wheelie bin crossed through indicates that the product requires separate refuse collection in the European Union. This applies to the product and all accessories marked with this symbol. Products marked as such may not be discarded with normal domestic waste, but must be taken to a collection point for recycling electrical and electronic devices

⚠ **WARNING:** Read all safety warnings, instructions, illustrations and specifications provided with this machine. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

1.The machine tool should be used by experienced personnel. If you are not familiar with the operation process of the lathe, do not use the machine tool at will. Use the instructions before operating.
2.Before starting the machine tool, the safety cover should be in the correct position.
3.Before starting the machine tool, please check whether the tool rest wrench and chuck key are removed.
4.Prevent the machine from starting accidentally. Turn off the motor power before clamping the workpiece or tool.
5.Don't force cut. Cutting according to the set cutting speed, cutting depth and feed speed.
6.Use the right tools. Use the correct tool or workpiece for machining.
7.Keep the tool sharp and clean to ensure normal and safe operation. Lubricate and replace accessories regularly.
8.Before adjusting or repairing the machine, be sure to disconnect the power supply.
9. Please check the safety performance of the machine before starting it. Check the performance of all moving parts. All parts must be installed correctly. Damaged parts must be repaired promptly.
10. When the machine is running, the operator shall not leave.
11. Keep the working place clean, dirty working environment is easy to lead to accidents.
12. Do not use the machine in dangerous environment.
Do not work in damp places. Ensure that electrical components are protected from moisture. Keep good lighting.
13. Children are prohibited from entering the work site, and non-operating personnel should keep a safe distance from the work area.

14. To keep children out of the work area. The door should be locked when leaving the workshop.
15. Dress appropriately. Don't wear loose clothing, gloves, ties, rings, bracelets, jewelry, etc. To be on the safe side, For the sake of safety, wearing non-slip shoes. If you have long hair, please wear a work hat.
16. Wear protective glasses when operating.
17. Pay attention to where you stand and keep your balance at all times.
18. Do not place your hands near the moving parts of the machine.
19. Do not perform any setting operations while the machine is running.
20. Read and understand all warning signs posted on the machine.
21. This manual is intended only to familiarize customers with the operation of the machine and is not a training manual.
22. Please obey these warnings or serious injury may result.
23. The machine will produce some harmful chemicals in the work of dust, sawing, grinding and drilling produced by grinding. To reduce the harm of these chemicals, please work in a well-ventilated place and wear safety devices. Such as particulate filter masks.

Remaining risk factors

W A R N I N G

- **It is important to ensure that each machine has remaining risks.**
- **In the execution of all work (even the simplest) greatest attention is required. A safe working depends on you!**

Even if the machine is used as required it is still impossible to eliminate certain residual risk factors totally. The following hazards may arise in connection with the machine´s construction and design:

- Risk of injury to the hands / fingers by the rotating workpioece during operation.
- Risk of injury due to sharp edges of the workpiece, especially in non-fixed with a suitable tool / device workpiece.
- Risk of injury: hair and loose clothing, etc. can be captured and wound up! Safety regulations must be observed with regard to clothing.
- Risk of injury due to contacting with live electrical components.
- Risk of injury due to dust emissions, treated with harmful agents workpieces
- Risk of injury to the eye by flying debris, even with safety goggles.
- Risk of injury to the hearing by prolonged labor without hearing protection.

Kickback is a sudden reaction. This causes the ejection of the tool to the direction of the operator.

These risk factors can be minimized through obeying all security and operation instructions, proper machine maintenance, proficient and appropriate operation by persons with technical knowledge and experience.

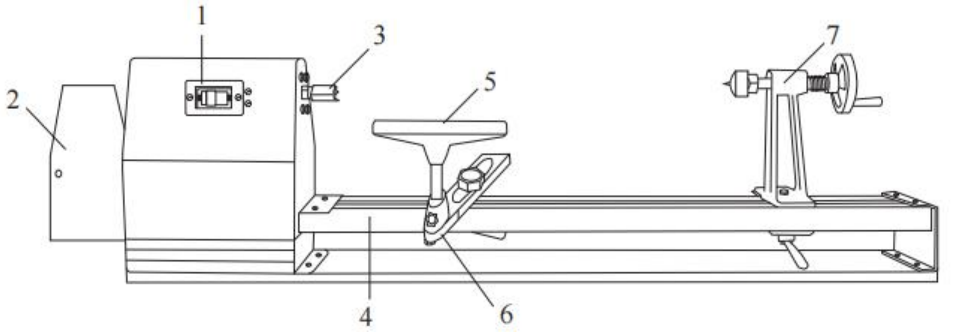
TECHNICAL PARAMETER

Voltage	230 V / 50 Hz	110 V / 60 Hz
Motor power	350W	
Spindle speeds	885/1245/1715/2425RPM	
Max. turning diamater	Ø 350 mm	
Spindle diameter	Ø 22	
Spindle thread	M18	
Distance between centers	970mm	
Tailostock spindle travel	10 mm	
Taper in Tail stock Spindle	MT1	
Weight	N.W：23Kg; G.W：28.2Kg	
Package Size	1545×300×435mm	

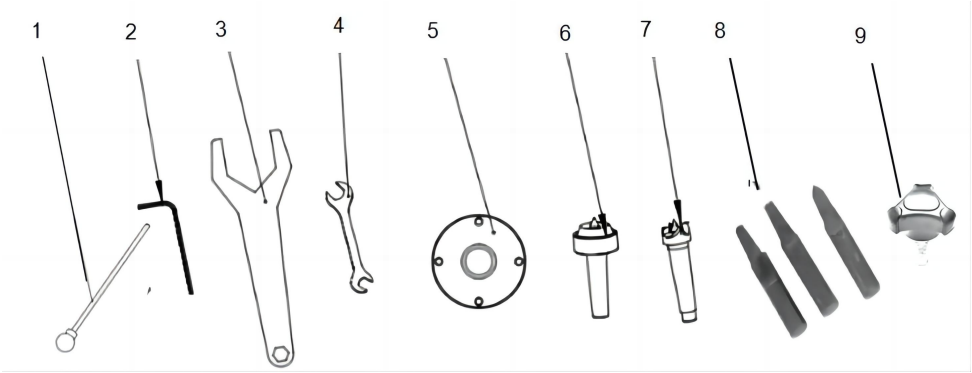
The general information given in this specification is not binding.

Know Your Wood Lathe: (Fig. 1)

1. ON/OFF SWITCH
Device to turn the wood lathe power on or off.
2. BELT AND PULLEY COVER
Cover for belt and pulley. Open this cover to reach the belt and pulley when changing the speed of drive center.
3. DRIVE CENTER
Holds workpiece for turning jobs.
4. BED RAILS
Rails for moving tailstock and toolrest.
5. TOOL REST
Stand holds tool when turning workpiece.
6. TOOL REST LOCK KNOB
Lock knob for height adjustment of tool rest.
7. TAIL STOCK ASSEMBLY
Works with drive center to hold workpiece for turning jobs



Standard accessories



PART NO.	DESCRIPTION	QTY
1	Rod injection	1
2	Hex wrench S3	1
3	Wrench	1
4	Fork wrench	1
5	Face Plate	1
6	Living center	1
7	Spur center	1
8	Lathe tool rest	3
9	Plastic handle	1

INTENDED USE

The machine must only be used for its intended purpose! Any other use is deemed to be a case of misuse.
To use the machine properly you must also observe and follow all safety regulations, the assembly instructions, operating and maintenance instructions lay down in this manual.
All people who use and service the machine have to be acquainted with this manual and must be informed about the machine's potential hazards.
It is also imperative to observe the accident prevention regulations in force in your area.
The same applies for the general rules of occupational health and safety.

The machine is used for: Turning wood.

Any manipulation of the machine or its parts is a misuse, in this case its sales partners cannot be made liable for ANY direct or indirect damage.
Even when the machine is used as prescribed it is still impossible to eliminate certain residual risk factors.

W A R N I N G

- **Use the machine never with defective or without mounted guard!**
- **The removal or modification of the safety components may result in damage to equipment and serious injury!**

HIGHEST RISK OF INJURY!

Ambient conditions

The machine may be operated:

Humidity	Max. 70%
Temperature	+5°C to +40°C (+41°F to +104°F)

The machine shall not be operated outdoors or in wet or damp areas. The machine shall not be operated in areas exposed to increased fire or explosion hazard.

Prohibited use

The operation of the machine outside the stated technical limits described in this manual is forbidden.

Operation of the machine function without emergency stop button or impeller box with open doors is prohibited.

The use of the machine not according with the required dimensions is forbidden.

The use of the machine not being suitable for the use of the machine and not being certified is forbidden.

The use of the machine for any purposes other than described in this user-manual is forbidden.

The unattended operation on the machine during the working process is forbidden!

It is not allowed to leave the immediate work area during the work is being performed.

UNPACKING AND CLEANING

1. Remove the woodworking lathe from the box
2. Check all the accessories of the machine tool according to the packing list.
3. Choose a location for the lathe that is dray, has good lighting and has enough room to be able to service the lathe on all four sides.
4. To avoid twisting the bed, the lathe's location must be absolutely flat and level. Bolt the lathe to the stand (if used).
5. Clean all rust protected surfaces using a mild commercial solvent, kerosene or diesel fuel. Do not use paint thinner, gasoline or lacquer thinner. These will damage painted surfaces. Cover all cleaned surfaces with a light film of 20W machine oil.

ASSEMBLY

Delivery content

Please check the product contents immediately after receipt for any eventual transport damage or missing parts. Claims from transport damage or missing parts must be placed immediately after initial machine receipt and unpacking before putting the machine into operation. Please understand that later claims cannot be accepted anymore.

Workplace requirements

The workplace has to fulfill the requirements.

The ground has to be even, in level and hard. It must be suitable at least to weight it with double weight per square meter than the machines net weight.

The chosen workplace must have access to a suitable electric supply net hat complies with the machines requirements.

Transport

The machine can be transported in package with a forklift.

The machine is very heavy. The machine shall be lifted from crate with a suitable lifting device only that is certified to be able to carry the machines load.

	**W A R N I N G**
	The lifting and transportation of the machine must only be carried out by qualified staff and must be carried out with appropriate equipment**.**

Preparation of the surface

Uncoated metal machine parts have been insulated with a greasy layer to inhibit corrosion.

This layer has to be removed. You can use standard solvents that do not damage the machine surface.

	**N O T I C E**
	● **Do not use solvents based on nitrite, aggressive solvents like break cleaners or scrubbing agents!** ● **These damage the machine surface.**

Power supply

	**A T T E N T I O N**
	When working with non-grounded machines: **Severe injury or even death may arise though electrocution!** **Therefore**: **The machine must be operated at a grounded power socket**

The connection of the machine to the electric power supply and the following checks have to be carried out by a respectively trained electrician only.

a. The electronic connection of the machine is designated for operation with a grounded power socket!
b. The mains supply must be secured with 16A:
c. If the connector plug doesn't fit or if it is defect, only qualified electricians may modify or re-new it!

d. The grounding wire should be held in green-yellow.
e. A damaged cable has to be exchanged immediately!
f. Check, whether the feeding voltage and the Hz comply to the required values of the machine. A deviation of feeding voltage of ±5% is allowed.
g. After connecting, check the right running direction!
h. Make sure that a possible extension cord is in good condition and suitable for the transmission of power. An undersized cord reduces the transmission of power and heats up.

OPERATING ADJUSTMENTS

ADJUSTING BELT TENSION

The lathe is packed with belt installed. However, it will need a adjustment prior to using.

1. Disconnect the lathe from power souce.
2. Loosen and remove the hex bolt with adjustable wrench. (as figure 1)
3. Press down on the belt with hand.The belt should move 1/2” when set properly. (as figure 2)

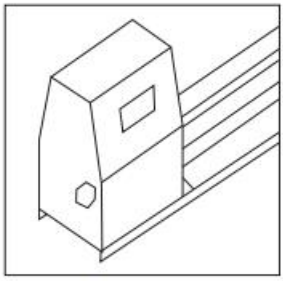


Figure 1

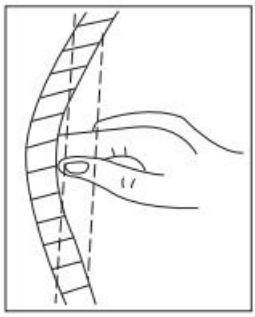
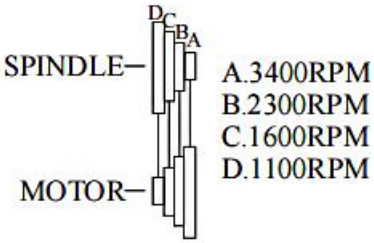


Figure 2

ADJUSTING SPEED

Four spindle speeds of 1100,1600,2300 and 3400 RPM (885, 1245, 1715, 2425) are available with lathe.Chart-1 illustrates which ster of the pullevs the belt must be placed to obtain four speed.Chart-2 illustrates the proper speeds for workpiece.

CHART-1



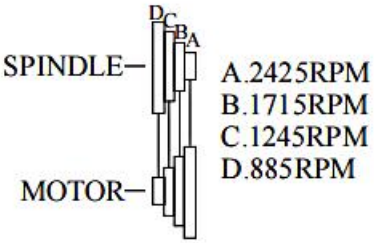
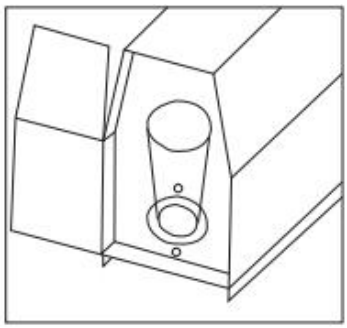


CHART-2

Roughing off	General cutting	Fine cutting	Finishing
1100RPM	1600RPM	2300RPM	3400RPM
885RPM	1245RPM	1715RPM	2425RPM

1. Disconnect the lathe from power source.
2. Open the belt and pulley cover.
3. Loosen the motor pulley by loosening the bolts with adjustable wrench(as figure)
4. Place”V”belt to correct position for desired speed.
5. Adjust “V”belt to proper tension and tighten the motor pulley.

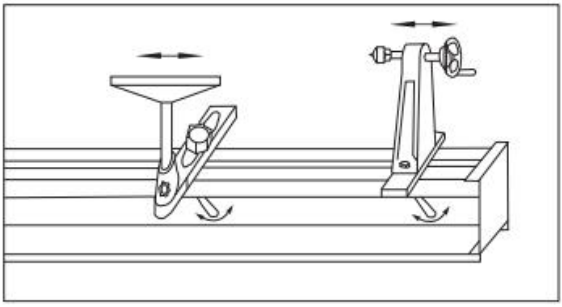
NOTE: For proper belt tension.press down on the belt with hand.The belt should move 1/2”when set properly



MOVING TAIL STOCK ASSWMBLY AND TOOL REST

The tail stock assembly and tool rest are held to the bed with lock handle right underneath the bed rails.To move them to new position:

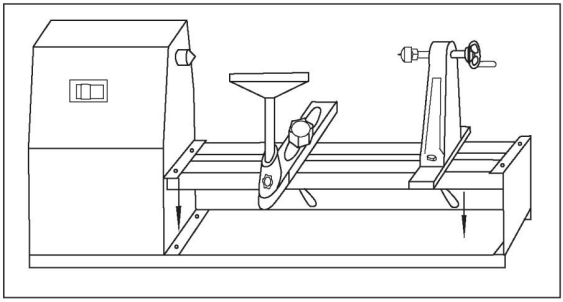
1. Disconnect the lathe from power source.
2. Loosen the lock handle with knob.
3. Slide the tail stock assembly or tool rest along the bed and retighten the lock handle. (as figure)



MOUNTING THE LATHE

The lathe must be mounted to firm supporting surface such as a stand or workbech when operating. To mount lathe:

1. Disconnect the lathe from power source.
2. Locate and mark where the lathe is to be mounted.(as figure)
3. Drill four(4) 5/16” diameter holes through work bench.
4. Place lathe on the workbench, aligning holes in bed with holes drilled in workbench.
5. Insert four bolts(sold separately) and tighted.



REMOVING TAIL STOCK SPINDLE

To remove the tail stock spindle from tail stock assembly:

1. Disconnect the lathe from power source.
2. Remove the hand wheel by loosening set screw with 1/8” hex wrench away from spindle.(as figure 1)
3. Unscrew tail stock spindle from tail stock assembly.(as figure 2)

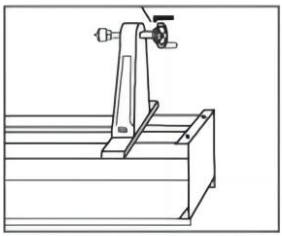


Figure 1

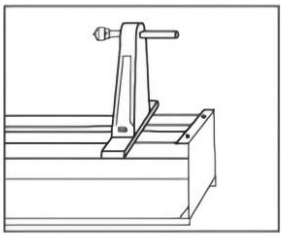


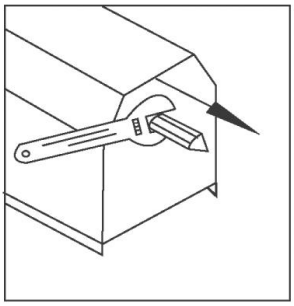
Figure 2

REMOVING DRIVE CENTER

Drive stock center must be removed to attach to stock when spindle turning. It also need to be removed when attaching faceplate for faceplate turning.

To remove drive center from driving spindle:

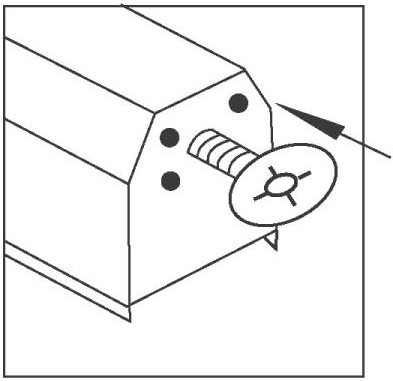
1. Disconnect the lathe from power source.
2. Use the wrench hold the flat neck of the driving spindle. then unscrew drive center counterwise.(as figure)



INSTALLING FACEPLATE

The faceplate is supplid with your lathe. To install the faceplate:

1. Disconnect the lathe from power source.
2. Remove drive center from driving spindle.
3. Align the center hole of faceplate to the thread of spindle.(as figure)
4. Screw faceplate into spindle.



ALIGNING CENTERS

If the centers are not in the lines,make the following adjustments:

1. Move the tail stock assembly close to the drive center assembly.(as figure 1)
2. Lock the tail stock assembly.
3. Loosen the four hex bolts around the drive center.(as figure 2)
4. Swing the drive center so that the two centers are in lines,then tighten the bolts.

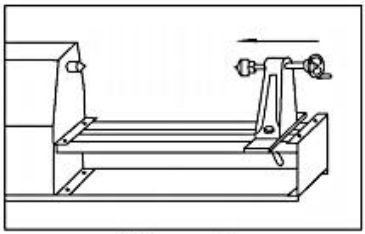


Figure 1

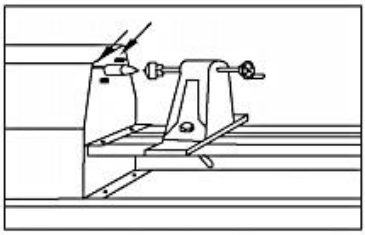


Figure 2

OPERATION

Device to be operated in a perfect state only. Inspect the device visually every time it is to be used. Check in particular the safety equipment, electrical controls, electric cables and screwed connection for damage and if tightened properly. Replace any damaged parts before operating the device.

SPINDLE TURNING

The following instruction will give a beginner a start on wood lathe operation. Use a piece of wood to check setting and to get the feel of the operations before attempting regular work.

WARNING Always keep hands away from Drive center or faceplate when the power is on.

1. Select a piece of wood.
2. Draw diagonal lines on ead to locate center. (as figure 1)
3. On the end, make a saw cut approximately 1/16” deep on each diagonal line.This is for the drive center.A mini hacksaw is useful for this.The other end is for the tail stock center.
4. Use a wooden (rubber)mallet or plastic hammer, drive the tail stock center into the wood.Remove the tail stock center.(as figure 2)
5. Drive the drive center into the other end of the wood.Make sure the spurs are in the saw cuts. Remove the drive center.
6. Clean the centers,the thread of the driving spindle and the thread hole of the tail stock body. Install the drive center into the driving spindle and the tail stock center into the tail stock body.
7. Place the wood between the centers and lock the tail stock body.
8. Move the tail stock center into the wood by turning the hand wheel.Make sure that the driving center and drive center are”seated” into the wood in the holes made in step 4 and 5.Rotate the wood by hand while turning the hand wheel.
9. Adjust the tool rest approximately 1/8” away from the corners of the wood and 1/8” above the center line. Lock the tool rest base and tool

rest.(as figure 3)

10.Rotate the wood by hand to make sure that the comers do not strike the tool rest.

11.Review the speed setting suggested in the speed selection chart.

12.Readjust frequently as in step 9 as the stock diameter is reduced.

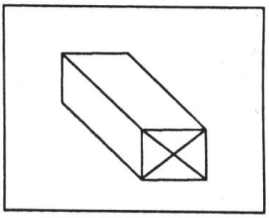


Figure 1

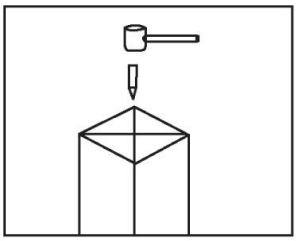


Figure 2

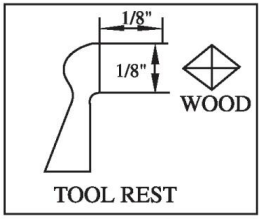


Figure 3

HAND POSITION

The position of your hands to the tool will be determined by the amount of leverage required.

The tool rest hand position is normally in a palm-up grip.The first finger acts as a guide, sliding along a tool rest as the cut is made.The palm-down grip can be utilized for heavy roughing applications.The heel of the hand or the little finger will serve as a guide.

ROUGHING A SPINDLE CYLINDER

The large gouge is used for this turning operation.Run the lathe at low speed for this operation.The cut should start about 2”from the end of the tail stock and will continue back toward the tail stock end. Each corresponding cut will take place about 3”to the left side of the first cut.This will continue until you reach a position 2” from the head stock center. You will then roll the gouge in the opposite direction,which will carry the cut to end of the spindle.

HOW TO USE A PARTING TOOL

The parting tool has one primary purpose:to cut straighe into the work piece as deep as desired or all the way through to make a cut-off.It

is,therefore,a very narrow tool(1/8” wide) and is shaped to cut its own clearance so that the edge will not be burned.When used for scraping, however, it should be backed off regularly to prevent overheating.
Unlike the gouge and skew,the parting tool is seldom held with the bevel against the work. As the amount of stock removed is small, a support for the bevel is not necessary. The tool is simply fed into the work at an angle(for cutting) , or pointed at the work piece center(for scraping).

HOW TO USE A SKEW

This tool is nearly always used to make finished cuts,to cut vees and beads,or to square shoulders. Properly ussed,it produces the best finish that can be obtained with a chisel.
It should be use very little for scraping , as this quickly dulls it.
For finish cutting, the skew is held with the cutting edge considerably in advance of the handle, bevel side down. Keep the skew well over the work, pull it back until the edge begins to cut, then swing the handle into position to advance the cut. Both the toe and the heel of the skew can be used for taking light cuts. Do not penetrate the wood too deeply without cutting clearances, as there is danger of burning the tip of the tool.

CUTTING A SHOULDER

A shoulder can be the side of a square portion left in the work piece,the side of a turned section, or the end of work piece. Most shoulders are perpendicular to the work axis, but a shoulder can be at any angle.
First, mark the position of the shoulder with a pencil held to revolving work piece. Then make a sizing cut via the parting tool,placing the cut about 1/16” outside the shoulder position. Cut to within 1/8” of the depth desired for the area outside the shoulder. If shoulder is shallow, the toe of the skew can be used to make the sizing cut.Do not going in deeper than 1/8”with the skew unless wider vees are cut to provide clearance for the tool.
Use the gouge to remove any waste stock outside of the shoulder.Smooth the section up to within 1/8” of the shoulder.Unless it is more than 1” high, it is best done with the 1/2” skew.
First, use the toe of the skew to remover the shavings from the side of the

shoulder down to the finished size. Hold the skew so the bottom edge of the bevel next to the shoulder will be very nearly parallel to the side of the shoulder. Made sure this is with the cutting edge turned away at the top, so that only the extreme toe will do the cutting.If the cutting edge is flat against the shoulder the chisel will run. Start with the handle low and then raise it to advance the toe into the work.Cut down to finished diameter of outside area, then clean out the corner by advancing the heel of the skew into it along the surface the outside area.Tilt the cutting edge, with the handle raised up, so that only the extreme heel does the cutting if the shoulder is at the end of work, process is called"aquaring the end." In this case, reduce the outer portion to a diameter about 1/4" larger than the tool center diameter. Saw off the waste stock later.

CUTTING COVES

Use a pencil mark to indicate the edges. Then rough it out to within ablut 1/8" of the desired finish surface by scraping with the gouge or round nose chisel.If the cove is to be very wide, sizing cuts can be made to plot the roughing out.Once it is roughed out, the cove can be finished in two cuts; one from each side to the bottom center.

At the start of either cut,gouge is held with handle high and the two sides of blade held between the thumb and forefinger of the tool rest handle, just behind the bevel. Position the fingers ready to roll the blade into cove.Hold blade so that bevel is a 90 degree angle to the work axis, with point touching the pencil line and pointed into work axis.

From this start, depress point slightly to start cut,then continue to move point down in an are toward the bottom center cove.A t the same time,toll chisel uniformly so that, at the end of the cut, it will be flat at the bottom of the cove. The object is to keep the extreme point of the gouge doing the cutting from start to finish.Reverse movements to cut the opposite side.

CUTTING VEES

Vee grooves can be cut with either the toe or heel of the skew.When the toe is used, the cutting action is exactly the same as in trimming a shoulder, except that the skew is tilted to

cut at the required bevel.Light cuts should be taken on one side first, then the other, gradually enlarging the vee to the requied depth and width.
When the heel is used, the skew is rotated down into the work,using the tool rest as a pivot.
Otherwise, cutting position and sequence of cuts is the same.As when using the toe, it is important that cutting be done only by the extreme end of cutting edge.If deep vees are planned, it is quicker to start them by making a sizing cut at the center of each vee. Vees can also be scraped with the spear point chisel or a three-sided file.

LAYING OUT THE PROJECT

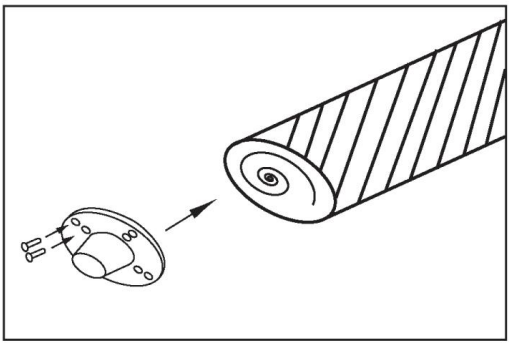
Make a layout first,to provide a visual patten to follow while working the turning.The pattern can be laid out in the same manner as spindle patterns.Templates can be held against the work for visual comparison.
Circles to locate the various critical points can be quickly scribed on the rotating work by using the dividers.

TURNING THE PROJECT

The first step is to remove as much wood as possible by boring into the center with the largest wood bit available. Be careful to measure in advance the depth to which the drill can be allowed to go.
Next, remove the bulk of the waste by scraping with the round-nose scraper or the bowl gouge.
Remove up to within 1/8” of finished size in this manner.Finish off the inside circumference by scraping with the round nose or left round scraper.
Smooth the bottom of the recess by scraping it flat nose scraper. Always try to position the part of the tool rest that supports the tool as close to the working surface as possible.

MOUNTING WORKPIECE TO THE FACEPLATE

You can directly mount the faceplate to the workpiece by fastening four(or eight) wood screws(sold separately). This is an easy process that should be used whenever possible.



	W A R N I N G
	Always make sure the workpiece is securely fastened to the faceplate or between centers.When faceplate is turning.always make sure the screw fasteners do not come in contact with the turning tool as work progresses

FACEPLATE TURNING

Turning which do not mount between centers require a faceplate for holding the workpiece.All workpiece of this type should slightly over-size to eliminate roughing cuts and vibration.

Operation instructions

	**A T T E N T I O N**
	Never switch the machine on while pressing the chisel against the material!

	**N O T I C E**
	● Before switching the machine on, make sure that the tool rest is firmly tightened ● Rotate the clamped workpiece each time before turning by hand to ensure that it runs freely and does not touch the rest tool! ● Thereby check also whether the workpiece is centred and tighten clamped! ● Make sure to guide and hold the chisel with both hands safe and tight during machining! ● Work only with well sharpened tools! ● Work large and unbalanced workpieces at low spindle speed only! ● Specifications regarding the maximum or minimum size of the workpiece must be observed! ● Workpieces with cracks may not be used! ● Only process selected woods without defects!

Operation

On-Off-switch

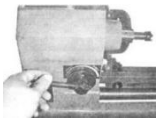
Switch on: Push the green button ("I") for 2 seconds. The machine begins to run.

Switch off: Push the red button ("0").

The machine does not stop immediately! Stay as long at the machine, until the workpiece is completely stopped (Do not stop the workpiece by hand!)

Speed adjustment

The speed can be set infinitely variable by turning the speed control lever.

	N O T I C E	
	You must move the lever to the lowest speed setting before turning the switch ON/OFF, otherwise the motor may not start!	

Tool rest

	N O T I C E
	The tool rest should be selected as close as possible to the workpiece! Height adjustment just below the centerline of the workpiece. Rotate the workpiece by hand and check that the workpiece can rotate freely before turning!

A T T E N T I O N

Perform all maintenance machine settings with the machine being disconnected from the power supply! Serious injury due to unintentional or automatic activation of the machine!

The machine does not require extensive maintenance. If malfunctions and defects occur, let it be serviced by trained persons only.
Before first operation as well as later on every 100 operation hours you should lubricate all connecting parts (if required, remove beforehand with a brush all swarfs and dust).
Check regularly the condition of the security stickers. Replace them if required.
Check regularly the condition of the machine.
The good condition and perfect adjustment of the guiding rollers is essential for a smooth band guidance and a clean cut.
Store the machine in a closed, dry location.

N O T I C E

Clean your machine regularly after every usage – it prolongs the machines lifespan and is a pre-requisite for a safe working environment.
Repair jobs shall be performed by respectively trained professionals only!

Maintenance plan

After each workshift:
Clean the machine and its parts with a strong jet of compressed air from wood dust and other material remains. Moving parts can also be cleaned with a brush or a soft brush. Apply a thin layer of lubricating oil to all moving parts of the machine.
After 50 hours of operation

Check the V-belts.
Determine for frayed belts cause. Check if uneven or rough surfaces and were built on the V-belt pulleys. Replace frayed or stretched belts!

Cleaning

After each workshift the machine has to be cleaned. Remove chips etc. with a suitable tool. Do not remove them by hand (cutting injury!). Remove dust as well.

N O T I C E

The usage of certain solutions containing ingredients damaging metal surfaces as well as the use of scrubbing agents will damage the machine surface!
Clean the machine surface with a wet cloth soaked in a mild solution .

Disposal

Do not dispose the machine in residual waste. Contact your local authorities for information regarding the available disposal options. When you buy at your local dealer for a replacement unit, the latter is obliged to exchange your old.

TROUBLE SHOOTING

BEFORE YOU START WORKING FOR THE ELIMINATION OF DEFECTS, DISCONNECT THE MACHINE FROM THE POWER SUPPLY.

Trouble	Possible cause	Solution
Noisy operation	a.Incorrect belt tension b.Loose pulley c.Loose bilt d.Bad bearing	a.Adjust tension b.Tighten pulley c.Adjust belt tension d.Replace bearing
Motor won't start	a.Power supply b.Motor connection c.Switch connections d.Motor windings burned e.Bad switch	a.Check power cord b.Check motor connections c.Check motor connections d.Replace motor e.Replace switch
Tool rest or tailstock difficult to move	a.Need Lubrication b.Bent bed rails c.Lock nut tightened	a.Lubrication with light oil b.Straighten bed rails c.Loosen lock nut

MANY POTENTIAL SOURCES OF ERROR CAN BE CLEARED BY THE EXPERTLY CONNECTION TO THE ELECTRICITY GRID.

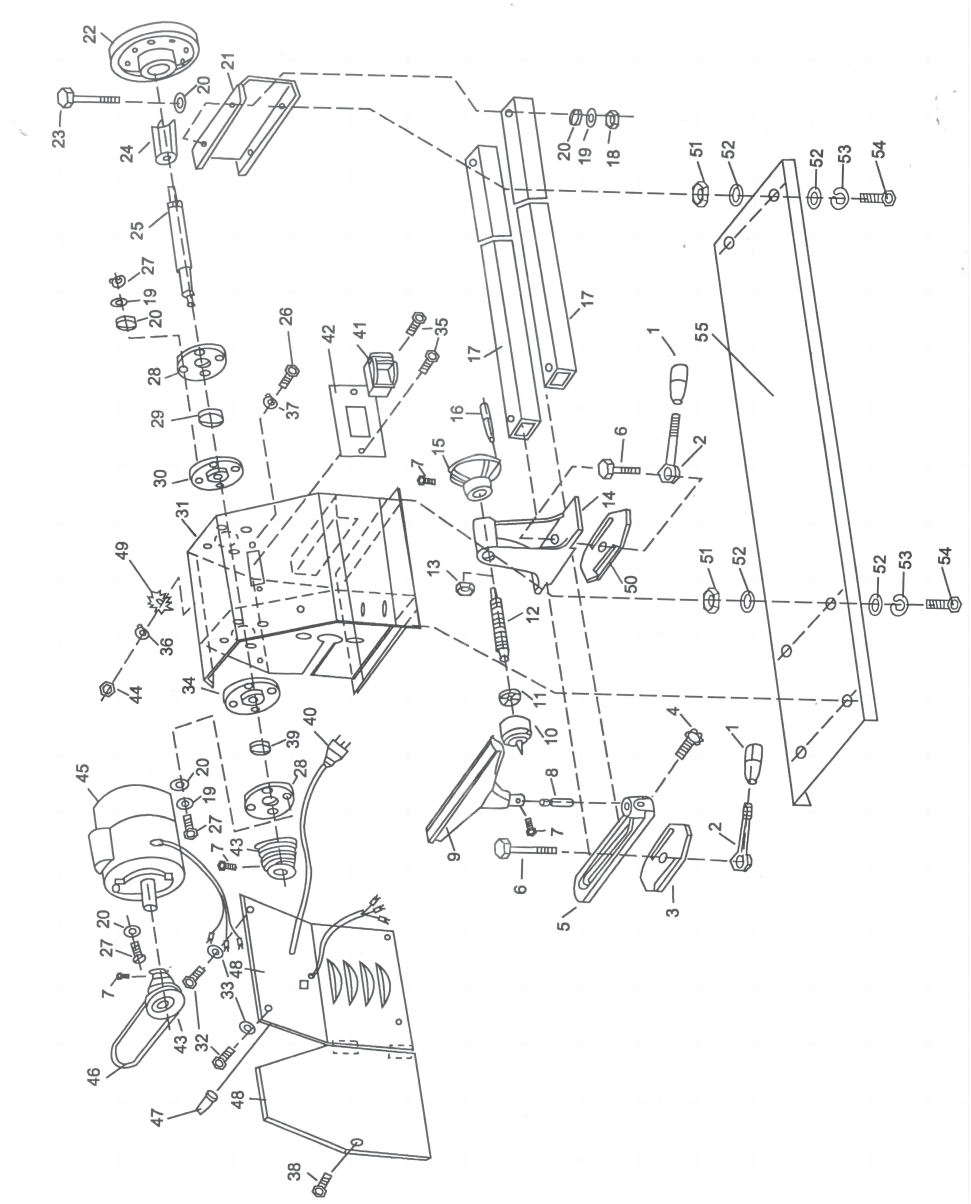
N O T I C E

Should you in necessary repairs not able to properly to perform or you have not the prescribed training for it always attract a workshop to fix the problem.

EXPLOSIONSZEICHNUNG / EXPLOSION DRAWING

INDEX NO	DESCRIPTION	SIZE	QTY
1	Lock handle knob		2
2	Lock handle		2
3	Clamp		1
4	Lock knob		1
5	Tool rest holder		1
6	Bolt	(M14x70)	2
7	Bolt	(M6x10)	4
8	Support bar		1
9	Tool rest		1
10	Center		1
11	Bearing	6201	1
12	Tail stock spindle		1
13	Screw	(M18)	1
14	Tail stock		1
15	Hand wheel		1
16	Hand wheel bar		1
17	Bed rail		2
18	Nut	(M8)	4
19	Spring washer	8	12
20	Washer	8	18
21	Supporter		1
22	Face plate		1
23	Bolt	(M8x55)	4
24	Drive center		1
25	Driving spindle		1
26	Bolt	(M4x10)	2
27	Screw	(M8x16)	10
28	Bearing washer		2
29	Bearing	6204	1

INDEX NO	DESCRIPTION	SIZE	QTY
30	Bcaring base		1
31	Cabinet		1
32	Bolt	(M5x12)	4
33	Washer	(5)	4
34	Bearing base		1
35	Blot	(M4x12)	2
36	Spring washer	(4)	2
37	Washer	(4)	2
38	Bolt	(M8x16)	1
39	Bcaring	6203	1
40	Plug		1
41	Switch		1
42	Switch board		1
43	Belt whecl		2
44	Nut	(M4)	2
45	Motor		1
46	Triangle belt	(0500)	1
47	Bush		1
48	Bclt and pulley cover		1
49	Bear washer	(4)	2
50	Clamp		1
51	Nut	(8)	6
52	Washer	(8)	12
53	Spring washer	(8)	6
54	Bolt	(M8x20)	6
55	Base plate		1



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