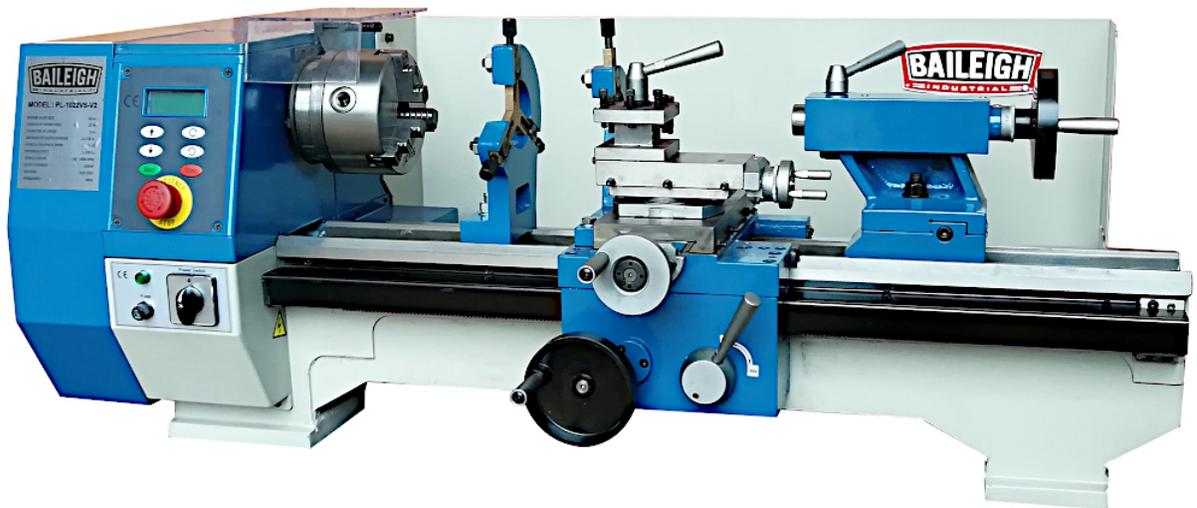




Operating Instructions and Parts Manual Lathe

Model PL-1022VS-V2



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2.0 Safety Instructions

⚠ WARNING

Failure to follow these rules may result in serious personal injury

1. FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE. Learn the machine's application and limitations as well as the specific hazards.
2. Only trained and qualified personnel can operate this machine.
3. Make sure guards are in place and in proper working order before operating machinery.
4. DO NOT bypass or defeat any safety interlock systems.
5. Remove any adjusting tools. Before operating the machine, make sure any adjusting tools have been removed.
6. Keep work area clean. Cluttered areas invite injuries.
7. Overloading machine. By overloading the machine, you may cause injury from flying parts. DO NOT exceed the specified machine capacities.
8. Do not force tool. Your machine will do a better and safer job if used as intended. DO NOT use inappropriate attachments in an attempt to exceed the machine's rated capacity.
9. Use the right tool for the job. DO NOT force a small tool or attachment to do the work of a large industrial tool. DO NOT use a tool for a purpose for which it was not intended.
10. Dressing material edges. Always chamfer and deburr all sharp edges.
11. Dress appropriately. DO NOT wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
12. Use eye protection. Always wear ISO approved protective eye wear when operating machinery. Wear a full-face shield if you are producing metal filings. Eye wear shall be impact resistant, protective safety glasses with side shields which comply with ANSI Z87.1 specification. Use of eye wear which does not comply with ANSI Z87.1 specification could result in severe injury from breakage of eye protection.
13. Do not overreach. Maintain proper footing and balance at all times. DO NOT reach over or across a running machine.
14. Stay alert. Watch what you are doing and use common sense. DO NOT operate any tool or machine when you are tired.
15. Check for damaged parts. Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
16. Observe work area conditions. DO NOT use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted. DO NOT use electrically powered tools in the presence of flammable gases or liquids.
17. Keep children away. Children must never be allowed in the work area. DO NOT let them handle machines, tools, or extension cords.
18. Keep visitors a safe distance from the work area.
19. Store idle equipment. When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
20. DO NOT operate machine if under the influence of alcohol or drugs. Read warning labels on prescriptions. If there is any doubt, DO NOT operate the machine.
21. Turn off power before checking, cleaning, or replacing any parts.
22. Be sure all equipment is properly installed and grounded according to national, state, and local codes.
23. Keep all cords dry, free from grease and oil, and protected from sparks and hot metal.
24. Inspect power and control cables periodically. Replace if damaged or bare wires are exposed. Bare wiring can kill! DO NOT touch live electrical components or parts.

Familiarize yourself with the following safety notices used in this manual:

⚠ CAUTION

This means that if precautions are not heeded, it may result in minor injury and/or machine damage.

⚠ WARNING

This means that if precautions are not heeded, it may result in serious injury or death.

⚠ DANGER

This means that if precautions are not heeded, it will result in serious or fatal, injury.

Save the Instructions

3.0 About This Manual

This manual is provided by Baileigh Industrial, covering the safe operation and maintenance procedures for a Baileigh Model PL-1022VS-V2 Lathe. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

Technical Support handles questions on setup, operation, schematics, warranty issues, and individual parts needed. Our Technical Support department can be reached at 920-684-4990.

If there are questions or comments, please contact your local supplier or Baileigh Industrial. We can also be reached at our web site: www.baileigh.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

WARNING

Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!

Register your product online -

<https://baileigh.com/product-registration>



4.0 Product Identification

4.1 Lathe

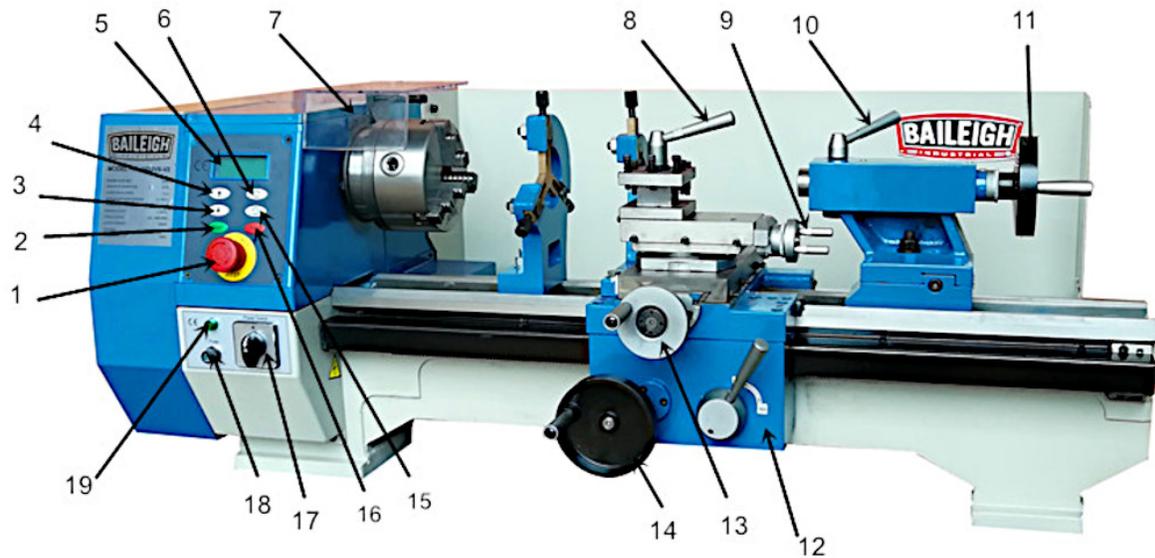


Figure 4-1

Please take time to become familiar with the controls and components on the lathe, the term and its location. These terms will be used throughout the manual and knowing them is essential to understanding the instructions and terminology used in this manual.

Table 4-1

Item	Description	Item	Description
1	Emergency Stop Switch	11	Tailstock Handwheel
2	Start Button	12	Half Nut Handle
3	Down Speed Button	13	Cross Slide Handwheel
4	Up Speed Button	14	Carriage Handwheel
5	Spindle Speed Display	15	Reverse Button
6	Forward Button	16	Stop Button
7	Chuck Guard	17	Power Change Switch Lathe or Mill
8	Cutter Rest Handle	18	Fuse Box
9	Compound Slide Handle	19	Lathe Power Indicator Light
10	Tailstock Quill Lock		

5.0 Specifications

Table 5-1

Model Number	PL-1022VS-V2
Stock Number	BA9-1228215
Motor and Electrical	
Lathe Motor	DC1000W, 230V, 6A, 3600RPM
Power Transfer	Belt Drive to Gear
Voltage	110V, 60Hz, 20A
General Specifications	
Distance Between Centers	21.65" (550mm)
Swing Over Bed	9.84" (250mm)
Swing Over Cross Slide	5.90" (150mm)
Swing Over Saddle	8.26" (210mm)
Cross Slide Travel	3.54" (90mm)
Compound Slide Travel	2.36" (60mm)
Carriage Travel	22.24" (565mm)
Width of Bed	5.31" (135mm)
Taper of Spindle Bore	MT#3
Maximum Turning Tool Size	0.39" x 0.39" (10 x 10mm)
Hole Through Spindle Bore	Ø0.787" (20mm)
Spindle Size	Ø2.04" x 0.43" (52 x 11mm)
Spindle Speed	Variable 100 – 2000 ±10%rpm
Spindle Bearings	Tapered Roller and Ball Bearing
Number of Longitudinal Feed	1
Range of Longitudinal Feed	0.0039, or 0.0078in/rpm (0.1 or 0.2mm/rpm)
Number of Inch Threads	8
Range of Inch Threads	8 – 40 TPI
Lead screw Diameter	Ø0.787" (20mm)
Steady Rest Capacity	0.236" – 1.574" (6 – 40mm)
Follow Rest Capacity	0.236" – 1.574" (6 – 40mm)
Faceplate Size	Ø8.661" (220mm)
Tailstock Taper	MT#2
Tailstock Barrel Diameter	Ø1.18" (30mm)
Tailstock Barrel Travel	2.36" (60mm)
Weights and Dimensions	
Dimensions (L x W x H)	43.31" x 23.62" x 33.86" (1100 x 600 x 860mm)
Shipping Weight	400lbs (181kgs)
Shipping Dimensions (L x W x H)	45.67" x 25.59" x 31.89" (1160 x 650 x 810mm)
Shipping Weight	466lbs (211kgs)

! WARNING

Read and understand the entire contents of this manual before attempting assembly or operation. Failure to comply may cause serious injury.

6.0 Setup and Assembly

6.1 Unpacking and Checking Contents

Your Baileigh machine is shipped complete. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.

! WARNING

SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.

! WARNING

If any parts are missing, **DO NOT** place the machine into service until the missing parts are obtained and installed correctly.

6.2 Cleaning

! WARNING

DO NOT USE gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.

! CAUTION

When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.

Your machine may be shipped with a rustproof waxy coating and/or grease on the exposed unpainted metal surfaces. Fully and completely remove this protective coating using a degreaser or solvent cleaner. Moving items will need to be moved along their travel path to allow for cleaning the entire surface. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces.

Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.

IMPORTANT: This waxy coating is NOT a lubricant and will cause the machine to stick and lose performance as the coating continues to dry.

6.3 Inventory

Table 6-1

Description	Quantity
Machine	1
3-Jaw Chuck 125 mm (in machine)	1
3-Jaw Chuck Key	1
Dead Center MT#3	1
External Jaws for 3-Jaw Chuck	3
Dead Center MT#2	1
Wrench	1, 42/52mm
Hex Wrenches	1ea, 2, 2.5, 3, 4, 5, 6, 8mm
Wrenches	1ea, 5.5/7mm, 8/10mm, 12/14mm, 17/19mm
V-belt O-813	1
Oiler	1
Gear	1ea, Z40/Z45/Z48/Z50/Z60/Z66/Z68/Z70/Z70/Z72/Z75
Wrench of Tool Post	1
Handle	2 sets
Socket Head Wrench	1
Fuse 20A	1
Gear Assembly, 40T	1
Face Plate	1
Live Center	1
Cross Screwdriver	1
Flat Blade Screwdriver	1

6.4 Transporting and Lifting

NOTICE

Lifting and carrying operations should be carried out by skilled workers, such as a truck operator, crane operator, etc. If a crane is used to lift the machine, attach the lifting chain carefully, making sure the machine is well balanced.

Follow these guidelines when lifting with truck or trolley:

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.



Figure 6-1

- Use a forklift with sufficient lifting capacity and forks that are long enough to reach the complete width of the machine.
- Remove the securing bolts that attach the machine to the pallet.
- Move the machine to the required position and lower gently to the floor.
- Level the machine so that all the supporting feet are taking the weight of the machine and no rocking is taking place.

6.5 Installation

IMPORTANT:

Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, worktables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.
- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they will not extend into any aisles.
- **LEVELING:** The machine should be sited on a level, concrete floor. Provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This machine distributes a large amount of weight over a small area. Make certain that the floor can support the weight of the machine, work stock, and the operator. The

floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.

- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.

6.5.1 Anchoring the Machine

- Once positioned, anchor the machine to the floor, as shown in the diagram. Use bolts and expansion plugs or sunken tie rods that connect through and are sized for the holes in the base of the stand.
- This machine requires a solid floor such as concrete at a minimum of 4" (102mm) thick. 6" (153mm) minimum is preferred.

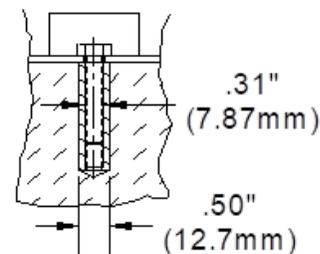


Figure 6-2

6.5.2 Mounting Dimensions

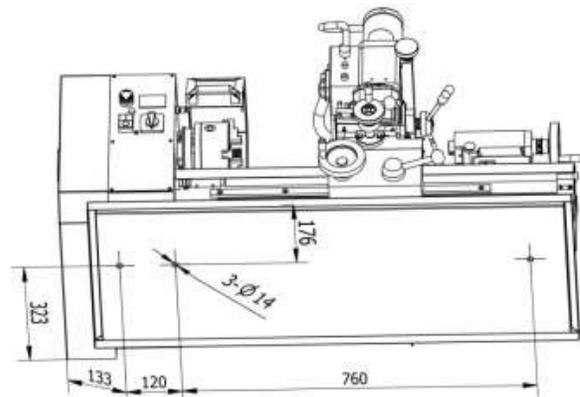


Figure 6-3

6.6 Assembly

⚠ WARNING

For your own safety, **DO NOT** connect the machine to the power source until the machine is completely assembled and you read and understand the entire instruction manual.

6.7 Belt Installation

The lathe drive belt needs to be installed prior to operation.

1. Lift and rotate (counterclockwise) the latch handle to release the door latch and swing the door open.
2. Using a clean cloth, wipe the pulley grooves to be sure they are clean and dry.



Figure 6-4

3. Loosen the idler pulley adjustment screw and rotate the idler pulley as needed to allow the belt to fit the motor and spindle pulleys.
4. Fit the belt onto the motor pulley fitting the V of the belt into the V-groove of the pulley.
5. Fit the belt onto the spindle pulley fitting the V of the belt into the V-groove of the pulley. Start the belt onto the pulley and rotate the spindle pulley by hand to work the belt onto the pulley.
6. Adjust the idler pulley to place tension onto the belt.

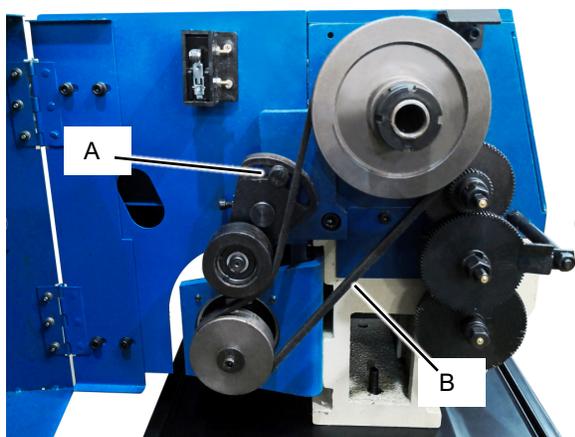


Figure 6-5

7. When properly tensioned, the belt will deflect 1/4" – 3/8" with moderate pressure on the longest span (B) between the pulleys.

8. Hold the idler pulley in this position and tighten the adjustment screw (A).
9. Close and latch the door for operation.

Note: The door has an interlock switch which will prevent the lathe from running if the door is not closed and latched.

7.0 Electrical Connections

⚠ CAUTION

HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!

Check if the available power supply is the same as listed on the machine nameplate.

⚠ WARNING

Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

7.1 Power Specifications

Your machine is wired for 115 volts, 60hz alternating current. Before connecting the machine to the power source, make sure the power source is OFF.

Before switching on the power, you must check the voltage and frequency of the power to see if they meet with the requirement, the allowed range for the voltage is $\pm 5\%$, and for the frequency is $\pm 1\%$.

7.2 Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with an amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your machines. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the machine.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

⚠ WARNING

In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.

- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the machine is properly grounded.
- Repair or replace damaged or worn cord immediately.

7.3 Extension Cord Safety

Extension cord should be in good condition and meet the minimum wire gauge requirements listed below:

Table 7-1

Amp Rating	Length		
	25ft	50ft	100ft
1-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No
	Wire Gauge		

An undersized cord decreases line voltage, causing loss of power and overheating. All cords should use a ground wire and plug pin. Replace any damaged cords immediately.

7.4 Power Cord Connection

1. Verify that the power switch is in the OFF position.
2. Unwrap the power cord and route the cord away from the machine toward the power supply.
 - a. Route the power cord so that it will NOT become entangled in the machine in any way.
 - b. Route the cord to the power supply in a way that does NOT create a trip hazard.
3. Connect the power cord to the power supply and check that the power cord has not been damaged during installation.
4. When the machine is clear of any obstruction. The main power switch may be turn ON to test the operation.
5. Turn the switch OFF when the machine is not in operation.

8.0 Operation

⚠ CAUTION

Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges.

⚠ CAUTION

When handling large heavy materials make sure they are properly supported.

8.1 Test Run Lathe

Before continuing to Operation, test run the lathe to make sure it runs properly.

1. Put on the proper PPE for the lathe operation!
2. Make sure the chuck key is NOT inserted in the chuck, and that the lathe chuck guard (7) is in the down position. Make this step a habit that you perform every time you start the lathe.

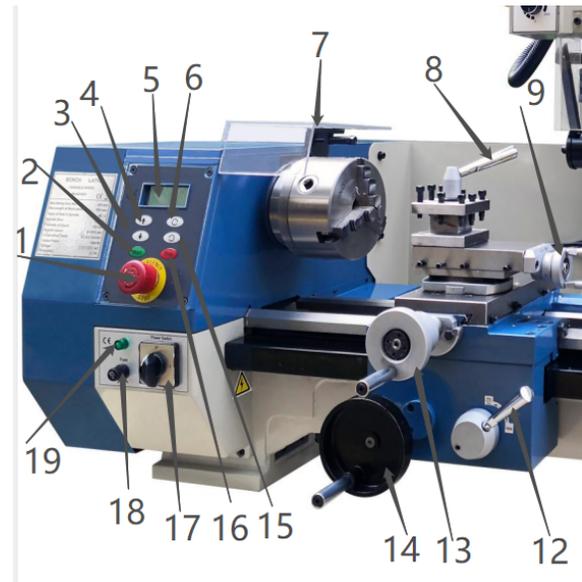


Figure 8-1

3. Familiarize yourself with the lathe controls (1 – 6, 15 – 19).
4. Clear all tools, components, packing material, etc. away from the cutter head.
5. Plug the machine into the power outlet!
6. Move the carriage feed lever (12) up to the disengage mode.
7. Twist and reset the emergency stop button (1).
8. Turn the Lathe / Mill selector switch (17) to the center "Neutral" position.
9. Turn the Lathe / Mill selector switch (17) to left (Lathe) position. The lathe power light (19) will illuminate. At the same time the spindle speed display (5) will light and show the number "0000".

Note: If it does not light up, unplug the machine and check the fuse, your power source, and the connections on the machine before attempting to start the lathe. Call our Tech Support department if you cannot easily resolve the issue.

10. Press the start button (2), the speed display will show "0100", then press forward button (15), the lathe will start and the spindle (chuck) should be turning clockwise.
11. To change the spindle RPM, press the up button (4) to increase the speed, and the down button (3) to decrease the speed. When either the up or down button is pressed one time and released, the speed will change by 10rpm. Pressing and holding the up or down button will change the speed quickly to either the minimum or maximum speed.
12. Allow the lathe to run for at least two full minutes to make sure it is running satisfactorily.
13. Pressing the reverse button (6) and the spindle will slow to a stop and then reverse rotation.
14. Pressing the stop button (16) will stop the spindle rotation. In the event of an emergency or unexpected condition, pressing the emergency stop (e-stop) button (1) will stop all lathe and mill operation.
15. Engage the half nut lever (12) to test the carriage feed operation. Disengage the half nut lever when not being used.
16. Verify that the carriage moves along the bed, then press the emergency stop button to turn the lathe OFF.

8.2 Lathe – General

This lathe will perform many types of operations that are beyond the scope of this manual. Many of these operations can be dangerous or deadly if performed incorrectly.

The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine. If at any time you are experiencing difficulties performing any operation, stop using the machine!

If you are an inexperienced operator, we strongly recommend that you read books, trade articles, or seek training from an experienced lathe operator before performing any unfamiliar operations. Above all, your safety should come first!

8.3 Removing/Installing Chuck or Faceplate

The lathe spindle nose mounting system uses a circular lock plate with slotted holes that are oversized at one end (keyholes). When the lock plate is rotated counterclockwise (as facing the chuck), the studs with mounting nuts can pass through the spindle nose. When the lock plate is rotated toward the back of the lathe, the oversized holes narrow to the size of the studs, allowing

the mounting nuts to be tightened against the back of the lock plate, thus, securing the chuck or faceplate.

To remove a chuck or faceplate from the lathe spindle nose:

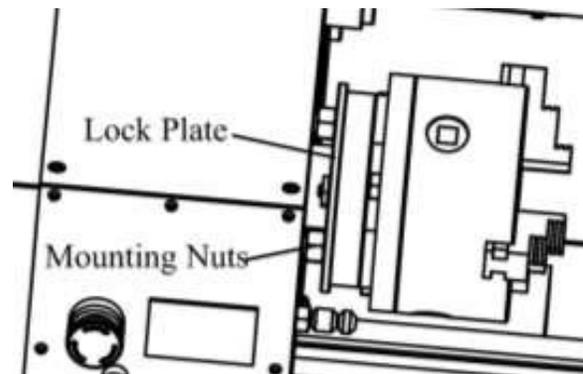


Figure 8-2

1. DISCONNECT LATHE FROM THE POWER SUPPLY!
2. Open the lathe chuck guard.
3. Move the carriage to the far end of the bed away from the chuck.
4. Place a piece of plywood over the bed ways to protect the chuck, the ways, and your hands.
5. Hold the chuck/faceplate with your hand or a chuck key, and using a 17mm wrench, loosen the three chuck mounting nuts on the back of the knurled lock plate. DO NOT back the nuts out all the way or they will scratch the metal cover when you rotate the lathe chuck.
6. Rotate the lock plate toward the front of the lathe.
7. Remove the chuck/faceplate from the spindle nose by pulling it out away from the spindle.

Note: The tolerances are tight, so you may need to tap the chuck/faceplate with a rubber mallet, rotate it $\frac{1}{4}$ of a turn, tap it, rotate it, and continue repeating this process until the chuck comes out. NEVER use a pry bar or steel hammer to remove the chuck or you will damage machine components!

To install a chuck/faceplate:

1. DISCONNECT LATHE FROM THE POWER SUPPLY!
2. Insert the three mounting studs into the back of the chuck and tighten them down. If you are switching chucks, take the mounting studs out of the previously removed chuck and use them in the chuck you are going to install. Also, make sure that a chuck mounting nut is on each of the studs.

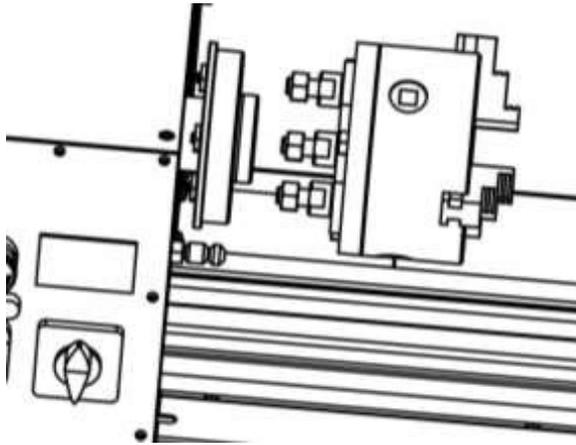


Figure 8-3

3. Make sure that the knurled lock plate is rotated all the way toward the front of the lathe.
4. Insert the chuck onto the spindle nose.
5. Rotate the knurled lock plate toward the back of the lathe until it stops. If the lock plate will NOT rotate more than a fraction of an inch, then the chuck is not completely inserted. Make sure the chuck is completely inserted so the lock plate can be rotated properly.
6. Hold the chuck/faceplate with your hand or a key. Using a 17mm wrench, snug the three chuck mounting nuts to the back of the knurled lock plate, then final tighten all three with even pressure.
7. Remove all wrenches and chuck keys from the chuck/spindle nose.
8. Move the lathe chuck guard down over the chuck before operating, or the lathe will not start.

8.4 Tailstock

Familiarize yourself with the tailstock components.

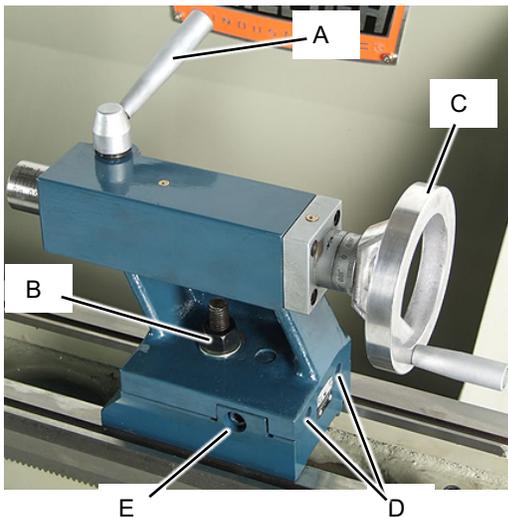


Figure 8-4

8.4.1 Tailstock Quill Clamping Lever (A)

Rotate the lever clockwise to lock the spindle and counterclockwise to unlock.

8.4.2 Tailstock Clamping Nut (B)

Turn the hex nut clockwise to lock and counterclockwise to unlock.

8.4.3 Tailstock Handwheel (C)

Rotate clockwise to advance the quill. Rotate counter-clockwise to retract the quill.

8.4.4 Tailstock Offset Clamping Screw(s) (D)

The set screw(s) (some models only use one screw) located on the end of the tailstock base are used to lock the tailstock at the desired angle.

8.4.5 Tailstock Offset Adjustment Screw (E)

The two setscrews (offset adjustment) on each side of the tailstock base, are used to push the tailstock side to side to the desired angle. The tailstock is then sandwiched between the two offset screws.

8.5 Dead Centers

To install the tailstock dead center:

1. Make sure the dead center and tailstock quill are clean and free of any dirt, dust, grease, or oil. Morse tapers will not interlock when dirt or oil are present on the mounting surfaces.
2. Loosen the quill clamping lever (A) 1/4 – 1/2 turn and extend the quill (C) approximately 1".
3. Tighten the clamping lever (A).
4. Slide the dead center by hand firmly into the tailstock quill as shown.

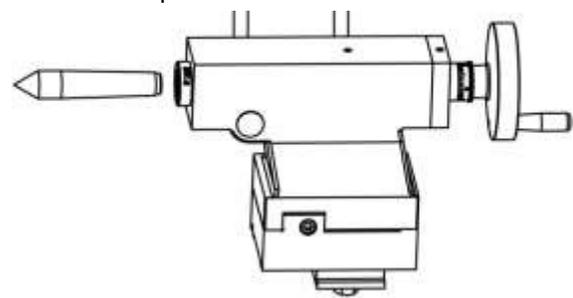


Figure 8-5

To remove the tailstock dead center:

1. Loosen the quill clamping lever (A) 1/4 – 1/2 turn.
2. Use the tailstock handwheel (C) to retract the tailstock quill all the way back into the tailstock until the handwheel will no longer turn (this will push the dead center out of the quill).
3. Pull the dead center out of the tailstock quill.

8.6 Tailstock Positioning

8.6.1 Longitudinal Positioning

To adjust the tailstock longitudinally:

1. Loosen the tailstock clamping nut (B).
2. Slide the tailstock into position along the bed, then tighten the clamp nut (B) to secure the tailstock in the new position.

8.6.2 Offset Positioning

The tailstock can be adjusted to a side angle of 5° by offsetting the tailstock. The angle depends on the length of the workpiece.

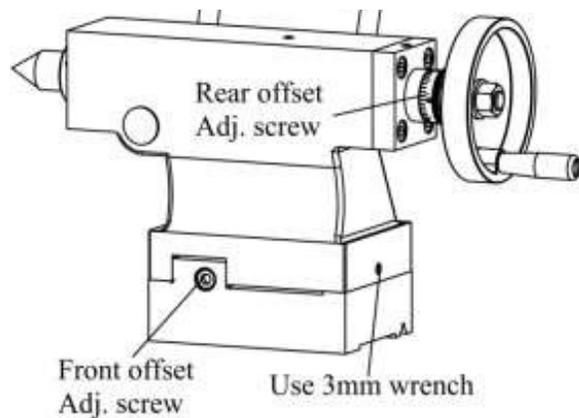


Figure 8-6

1. Loosen the tailstock clamping nut (B).
 2. Using a 3mm hex wrench, loosen the lock screw (D) at the end of the tailstock.
 3. Loosen the front adjusting screw (E) using a 6mm hex wrench and take up the same amount by tightening the rear adjusting screw (E, opposite side not shown) until the desired taper has been reached. The desired cross-adjustment can be read off the scale at the end of the tailstock.
 4. First retighten the set screw (D) at the end of the tailstock and then the two (front "E" and rear) adjusting screw to lock the tailstock in position.
 5. Slide the tailstock forward or aft as desired into position and tighten the locking nut (B) of the tailstock.
- The workpiece must be held between to centers and driven by a face plate and driver dog.
 - After taper turning, the tailstock should be returned to its original position according to the zero position on the scale of tailstock.

8.7 Cross Slide

The cross slide moves perpendicular to the longitudinal axis and features a scale on the handwheel that displays graduations of one-thousandth of an inch (0.002") or 0.05mm.

1. Using the handwheel, back the cross slide away from your starting point by at least 0.30", then move the cross slide forward to your starting point.

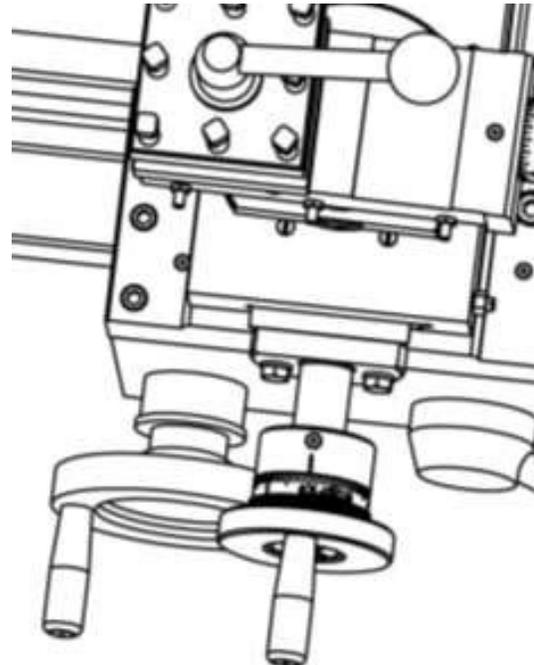


Figure 8-7

Note: This procedure will clear any free movement (or backlash) in the lead screw so your handwheel scale reading will be accurate.

2. Hold the handwheel still and turn the scale so the "0" mark lines up with the "0.000" mark on the cross slide. If you avoid backlash by continuing to move the cross slide in the same direction, the scale on the handwheel will be accurate.
3. After backing the cross slide away from the workpiece, remember to clear the backlash before moving the cross slide forward to the "0" mark for the next cut.

8.8 Compound Slide

Like the cross slide, the compound slide features a scale that displays graduations of one-thousandth of an inch (0.002") or 0.05mm.

Unlike the cross slide, the compound slide can be rotated to a set angle and then it can be moved back and forth along the axis of that angle.

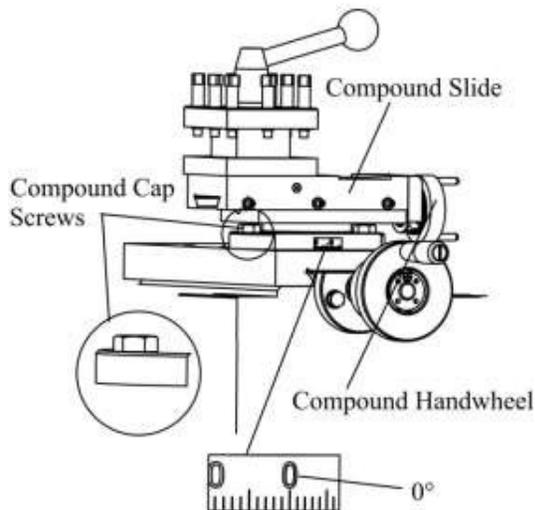


Figure 8-8

1. Loosen the compound cap screws to allow it to be rotated.
2. Rotate the compound slide to the angle needed for your procedure.
3. Tighten the compound cap screws and check the angle again to make sure it did not move.
4. Use the compound slide handwheel to move the tool back and forth along the axis of the new angle.
5. Like adjusting the cross slide handwheel, make sure the threads are engaging and all backlash has been cleared before you set the handwheel scale to "0", or it will not be accurate.

8.9 Carriage Handwheel

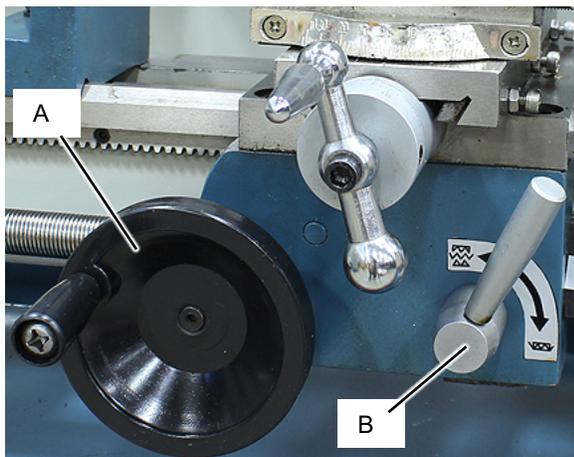


Figure 8-9

The carriage handwheel (A) moves the carriage left or right along the bed.

This manual control is necessary when setting up the machine for turning or when manual movement is desired during turning operations.

8.10 Half Nut Lever

The half nut can be engaged to produce power feed of the carriage. Lifting the half nut lever (B) to the up position disengages the half nut stopping the power feed. Pushing the half nut lever down will engage the half nut and engage the power feed.

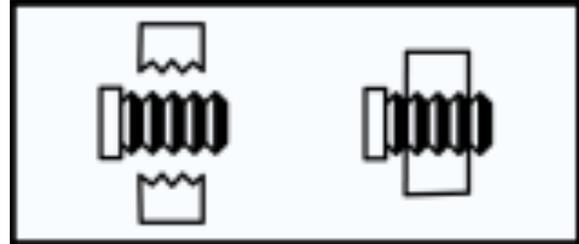


Figure 8-10

8.11 Carriage Lock

The carriage is supplied with a lock bolt on the front right-hand side of the saddle.

This bolt locks the carriage in place for increased rigidity when making face cuts.

This lock bolt must be loosened before attempting to move the carriage manually or with the power feed.

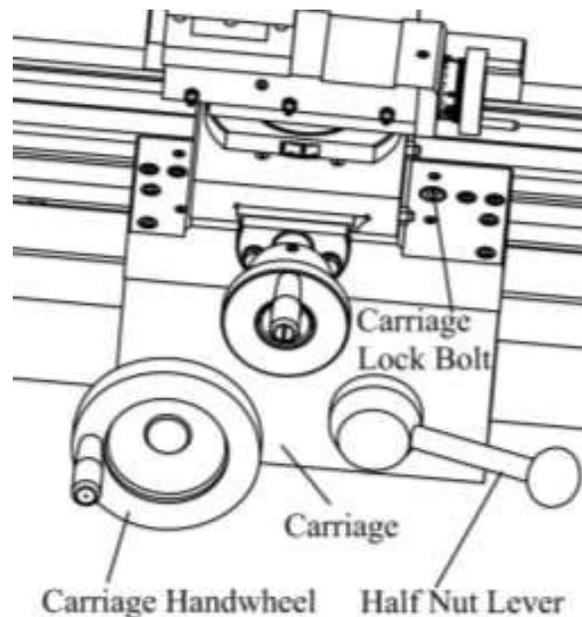


Figure 8-11

9.0 Threads and Change Gears

The Lathe can be geared for a variety of different feed rates, so charts are placed on the drive cover of the lathe that explain how to set up the gear combinations for each type of carriage feed application. Three applications are broken into two categories of charts-turning and threading.

9.1 Turning Chart

The speeds given on the turning chat represent standard speeds for most types of turning applications.

A=40	1/n"	Metric	
		0.005"	0.010"
C B		35 80	50 80
D E		90 30	66 30
F		100	100

Figure 9-1

9.2 Threading Charts

By arranging the gears as shown on the threading charts, you can set up the carriage feed to cut any of the thread pitches indicated.

This is how to read the feed rate charts:

- The box in the upper left-hand corner of each chart tells whether that chart represents carriage feed movement for metric or imperial threads.
- The boxes in the top row of each chart (excluding the box in the left-hand corner) shows the thread pitches listed on that chart.

1/n"	16			18			20		
	B	70	70	70					
D E	60 40	60 80	60 80	60 80	60 80	60 80	60 80	60 80	60 80
F	80	45	50						

mm	0.4			0.5			0.6		
	C B	68 80	68 80	68 80	68 80	68 80	68 80	68 80	68 80
D E	72 30	72 35	72 45	72 45	72 45	72 45	72 45	72 45	72 45
F	75	70	75						

Upper Adjustable Shaft →
Lower Adjustable Shaft →
Pivot Shaft →

Figure 9-2

- The boxes on the left-hand column (excluding the box in the upper left-hand corner) represent the gear positions on each shaft. The shafts are called out with arrows.
- Each shaft has room for two positions to mount the gears — a forward (outboard) position and a rear (inboard) position.
- Both forward and rear positions must be filled on the shaft for the gears to work properly. A good example of this is the blank spot to the Left of gear "F," as shown in the Pivot Shaft location in the chart above.
- Although the chart shows this as a blank spot, there should be a spacer in this position on the machine. This spacer is not listed on the chart, because the chart only reflects ACTIVE gear positions.

mm	1.25		1.5		1.75	
D	G 52	G 66	G 80			
F - E	75 80	75 80	70 80			
L	60 G	50 G	40 G			

Forward ↑ Rear ↑

Figure 9-3

Note: On some setups, smaller gears must be used as spacers on the adjustable shafts. In these situations, the smaller gears do not engage with the other gears.

The lines between gears "D" & "E" and gears "F" & "L" on the chart indicate where the gears should be engaged.

mm	0.4		0.5		0.6	
D	G 80	G 80	G 80			
F - E	30 80	30 60	30 50			
L	75 G	80 G	80 G			

Figure 9-4

10.0 Maintenance

⚠ WARNING

Make sure the electrical disconnect is OFF before working on the machine.

⚠ WARNING

Maintenance should be performed on a regular basis by qualified personnel.

⚠ WARNING

Always follow proper safety precautions when working on or around any machinery.

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- On a weekly basis clean the machine and the area around it.
- Lubricate threaded components and sliding devices.

- Apply rust inhibitive lubricant to all non-painted surfaces.

Note: Proper maintenance can increase the life expectancy of your machine.

10.1 Lubrication Lathe

This lathe has numerous moving metal-to-metal contacts that require proper lubrication to help ensure efficient and long-lasting operation.

Other than the lubrication points covered in this section, all other bearings are internally lubricated and sealed at the factory. Simply leave them alone unless they need to be replaced.

Before adding lubricant, clean away any debris and grime from the lubrication point to avoid contaminating the lubricant and increasing wear of the moving parts.

Note: The change gears and the ball oilers have the same lubrication

10.2 Ball Oilers

Lubricant	Frequency	Qty
ISO 68 or Equivalent Lubricant	Every 8 Hours of Operation	1 Squirt From Oil Can

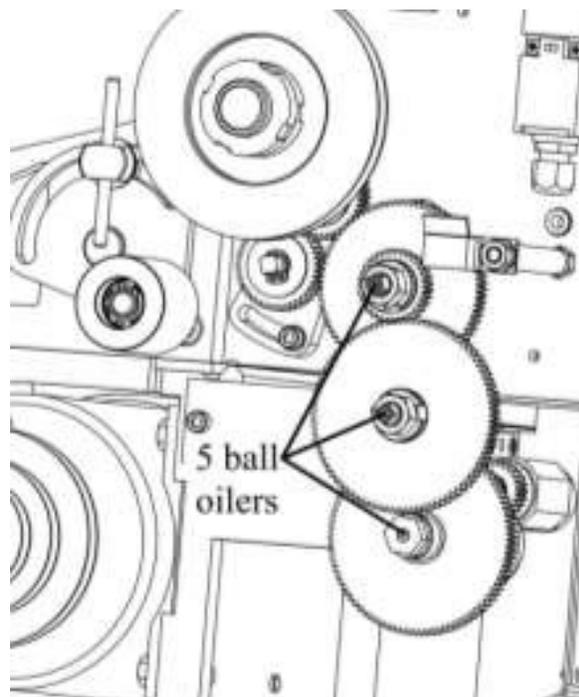


Figure 10-1

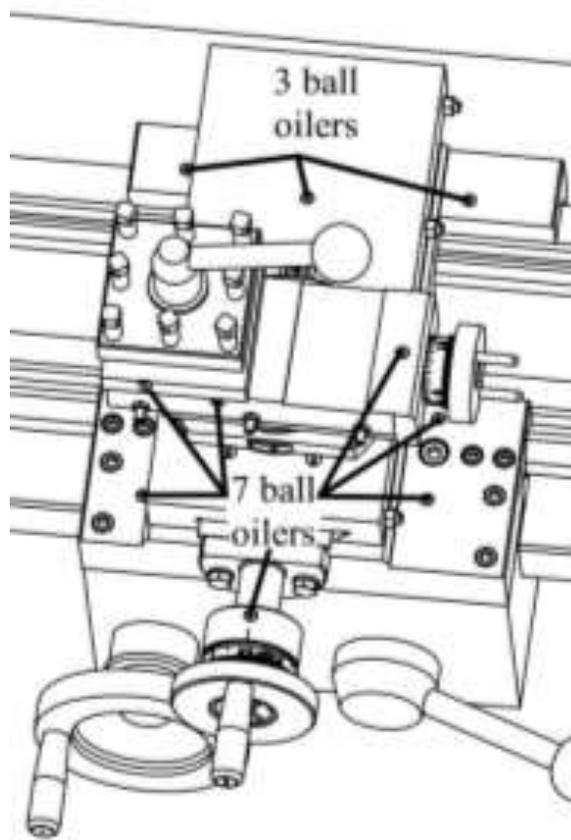


Figure 10-2

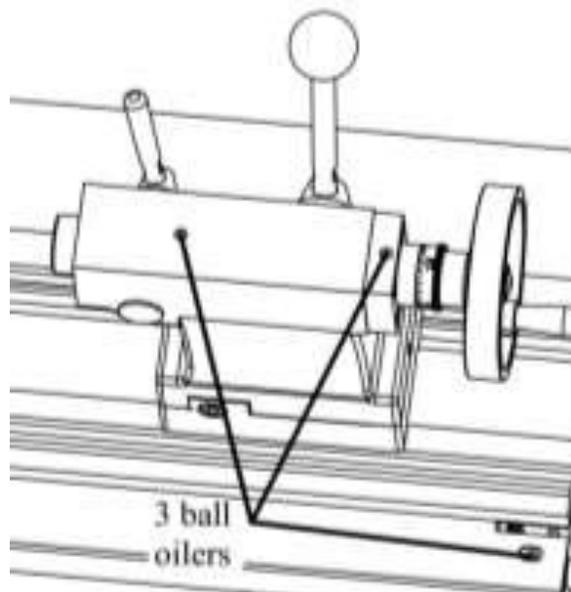


Figure 10-3

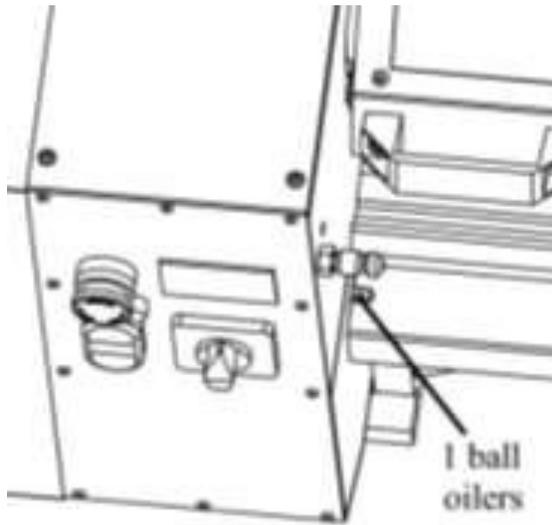


Figure 10-4

Carriage Gibs—There are four tensioning screws for both the front and rear saddle gibs.

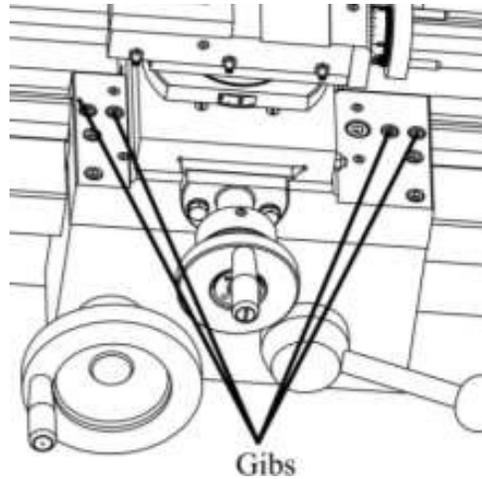


Figure 10-6

10.3 Gibs

There are three gib adjustments—the cross-slide gib, the compound slide gib, and the saddle gib.

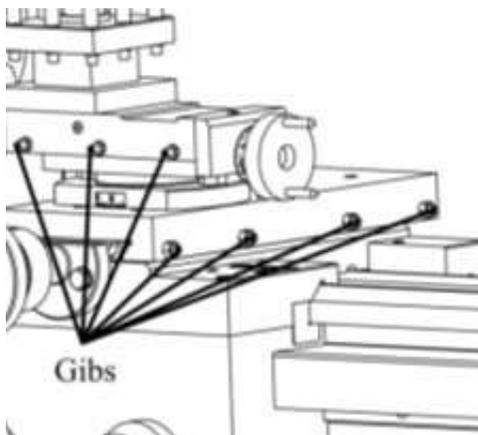


Figure 10-5

Cross-slide Gib—The gib on the cross-slide is adjusted by tightening or loosening the five gib screws located on the right-hand side of the slide. Before adjusting the gib screws, loosen their jam nuts.

The gib is held in place by the setscrews. DO NOT overtighten. The gib is properly adjusted when a slight drag is detected while turning the hand crank. This drag should be evenly distributed among the 4 setscrews, so adjust each screw evenly.

Compound Gib—The gib on the compound has four screws that maintain tension on the slide. These screws are held in place with retaining nuts.

To adjust, loosen the retaining nuts and then tighten the screws evenly to achieve a slight drag when turning the hand crank. When proper tension has been achieved, tighten the retaining nuts while maintaining the position of the screw with a hex wrench.

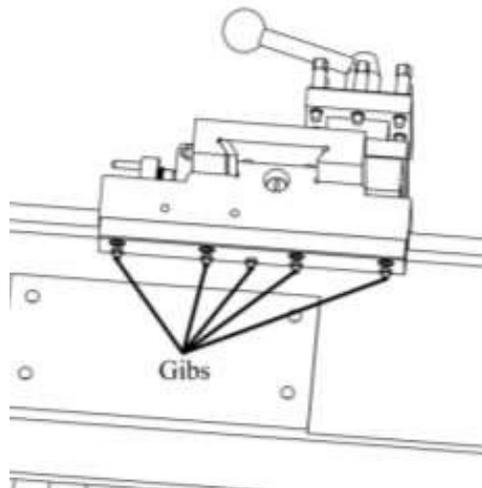


Figure 10-7

Before making adjustments to the saddle gib, ensure that the front lock lever is loose by turning it counterclockwise. It is important that the screws are tightened evenly. A slight drag should be detected while turning the hand crank at the end of the lathe.

10.4 Bearing Preload

This lathe is shipped from the factory with the spindle bearing preload properly adjusted. If the spindle ever develops excessive end-play and the workpiece finish suffers, you can adjust the bearing preload to remove the unnecessary end-play and improve the workpiece finish.

1. Run the lathe for approximately 20 minutes on high speed to bring the lathe to normal operating temperature.
2. DISCONNECT LATHE FROM POWER!
3. Loosen the two Spindle lock nut one full turn counterclockwise.

Note: Use the Wrench 42-52.

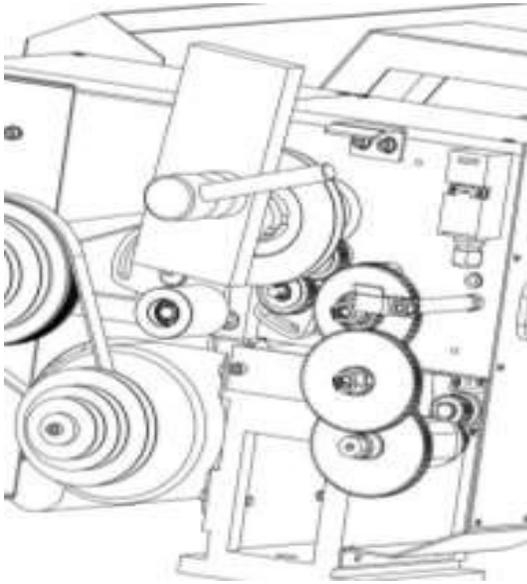


Figure 10-8

4. Place a wooden block over the outboard end of the spindle and hit it soundly with the heavy dead blow hammer.
5. Your goal is to slide the spindle forward just enough to introduce spindle endplay that you can feel by hand.
6. Clockwise to tighten the Spindle Lock Nut, Rotating the 3-Jaw Chuck with spindle, Check the spindle bearing preload, Spindle should be no gap, rotating with slight resistance. The need to repeatedly to loosen or tighten the Spindle Lock Nut adjustment.

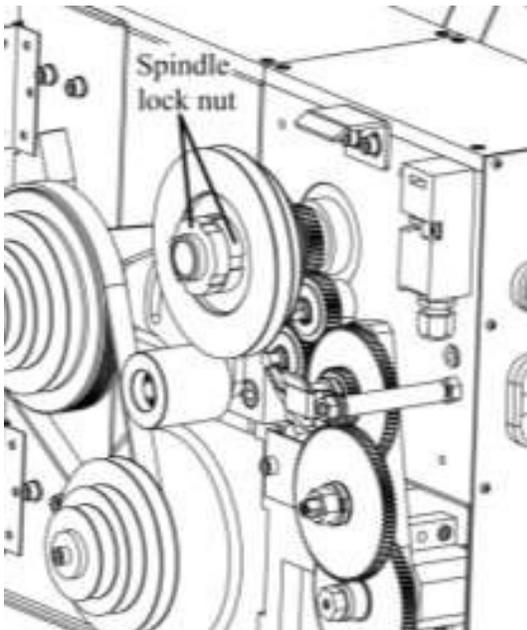


Figure 10-9

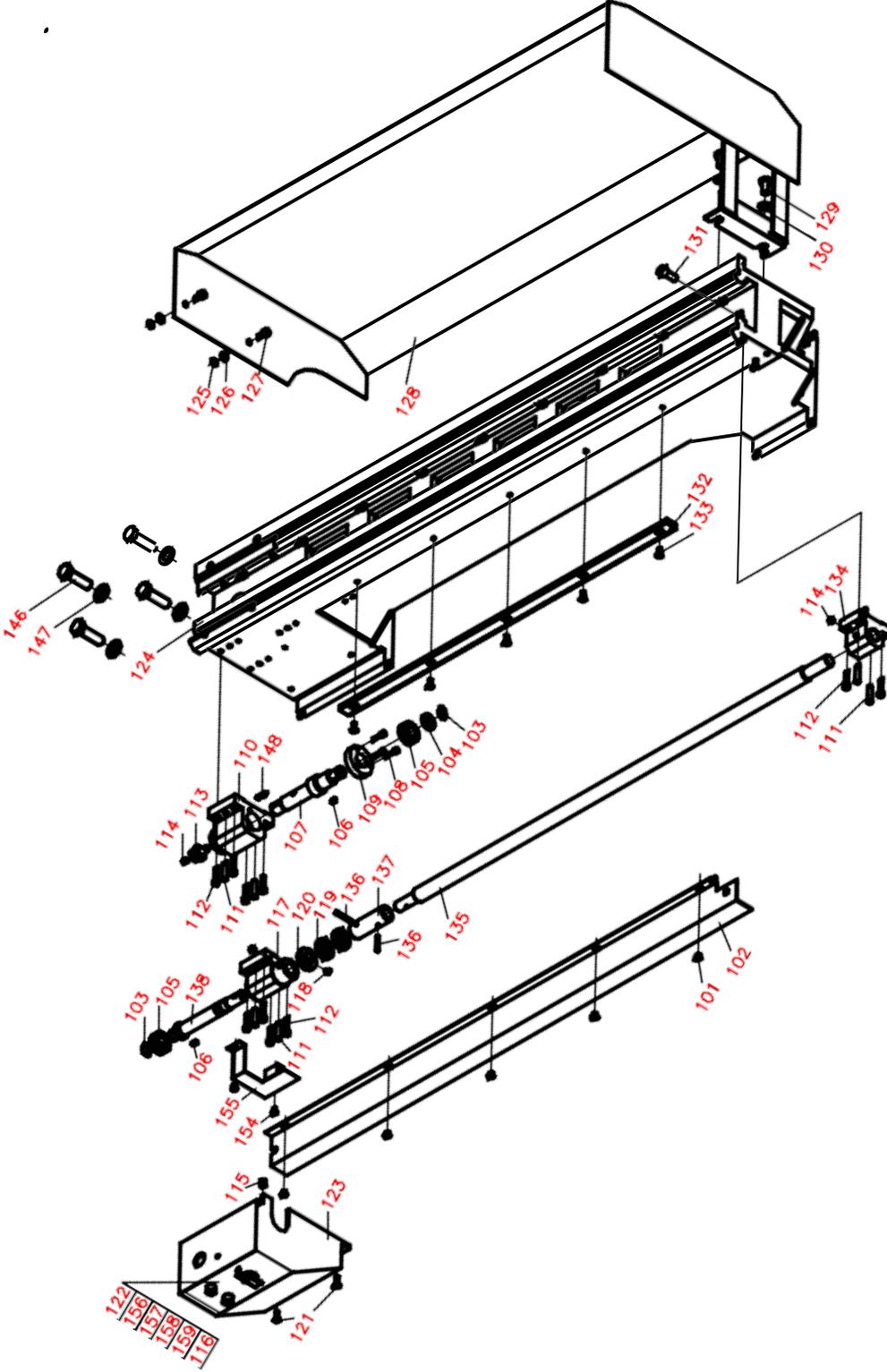
To confirm that the spindle bearings are correctly preloaded:

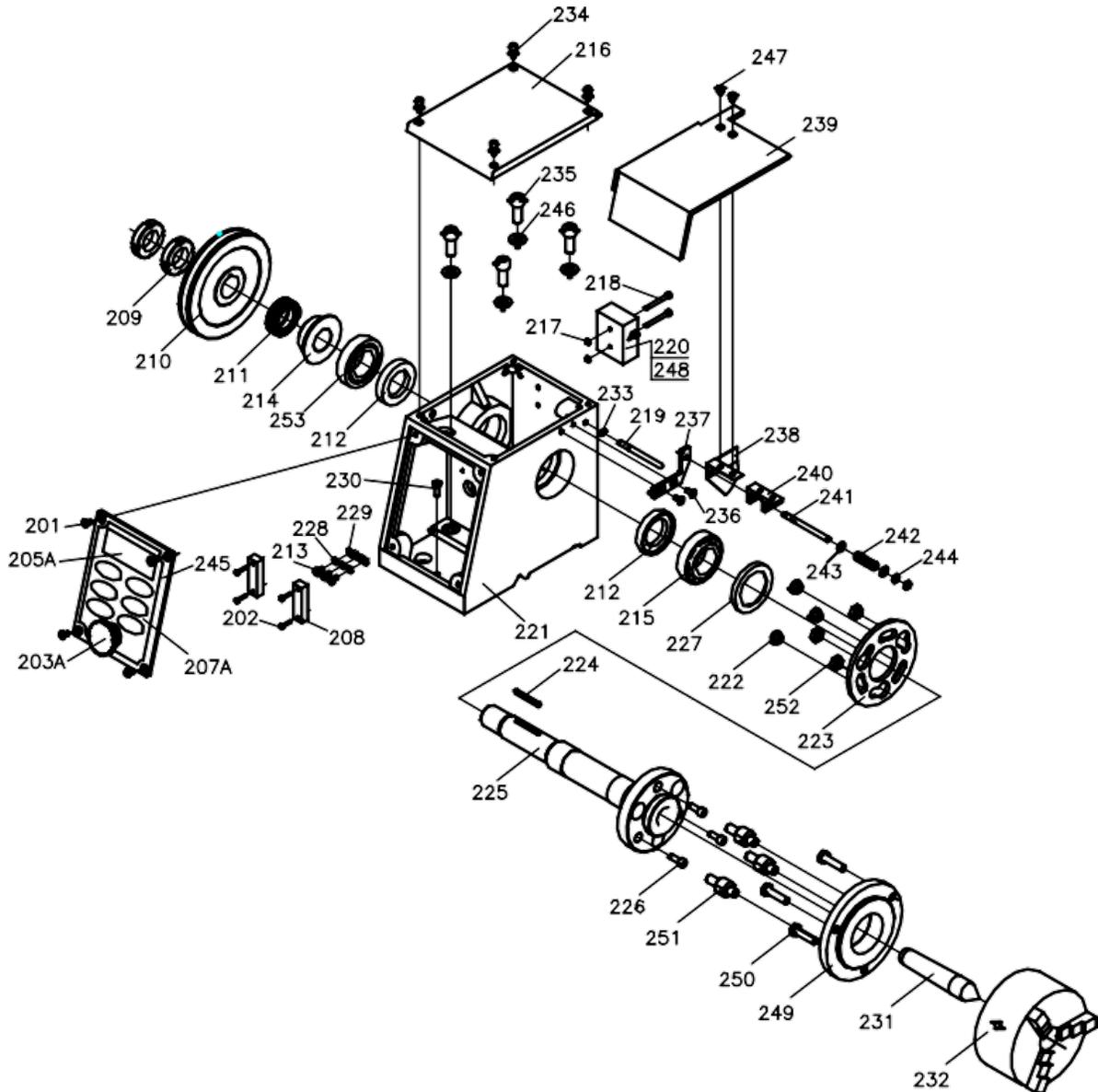
1. Reattach all removed lathe components and prepare it for operation.

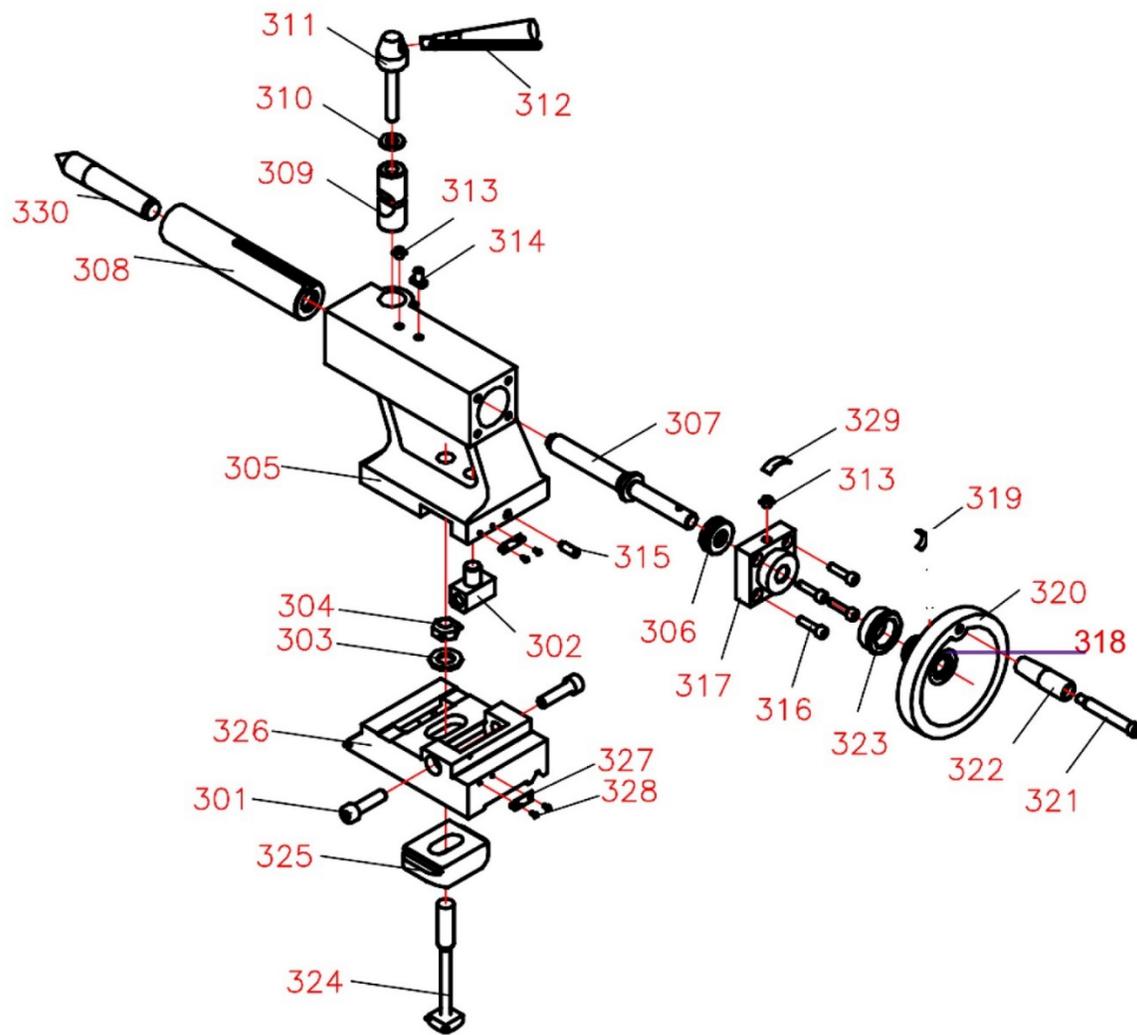
2. Install the chuck and tighten the jaws into the center.
3. Set the spindle speed to a medium setting.
4. Connect the lathe to power and turn the lathe spindle ON.
5. Let the lathe run for 20 minutes.
6. Turn the spindle OFF, disconnect the lathe from power, then check the temperature of the spindle.
7. If the spindle nose is slightly warm to the touch, you have correct bearing preload.
8. If the spindle nose is hotter than you can comfortably keep your hand on, the preload is too tight, and you must repeat the bearing preload adjustment procedure. When repeating the procedure, rotate the inner spanner nut a little less during Step 7 in the preceding instructions.

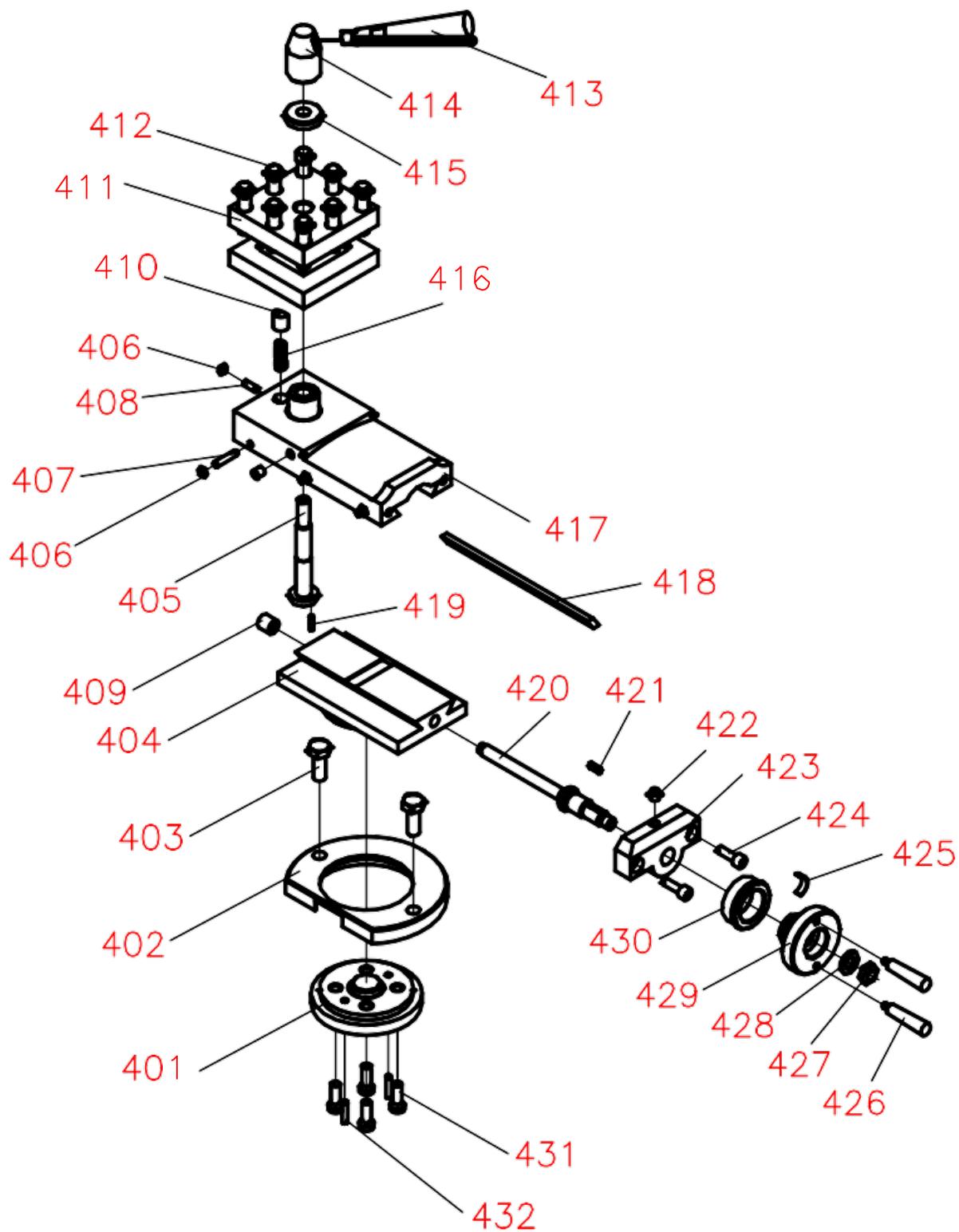
11.0 Replacement Parts

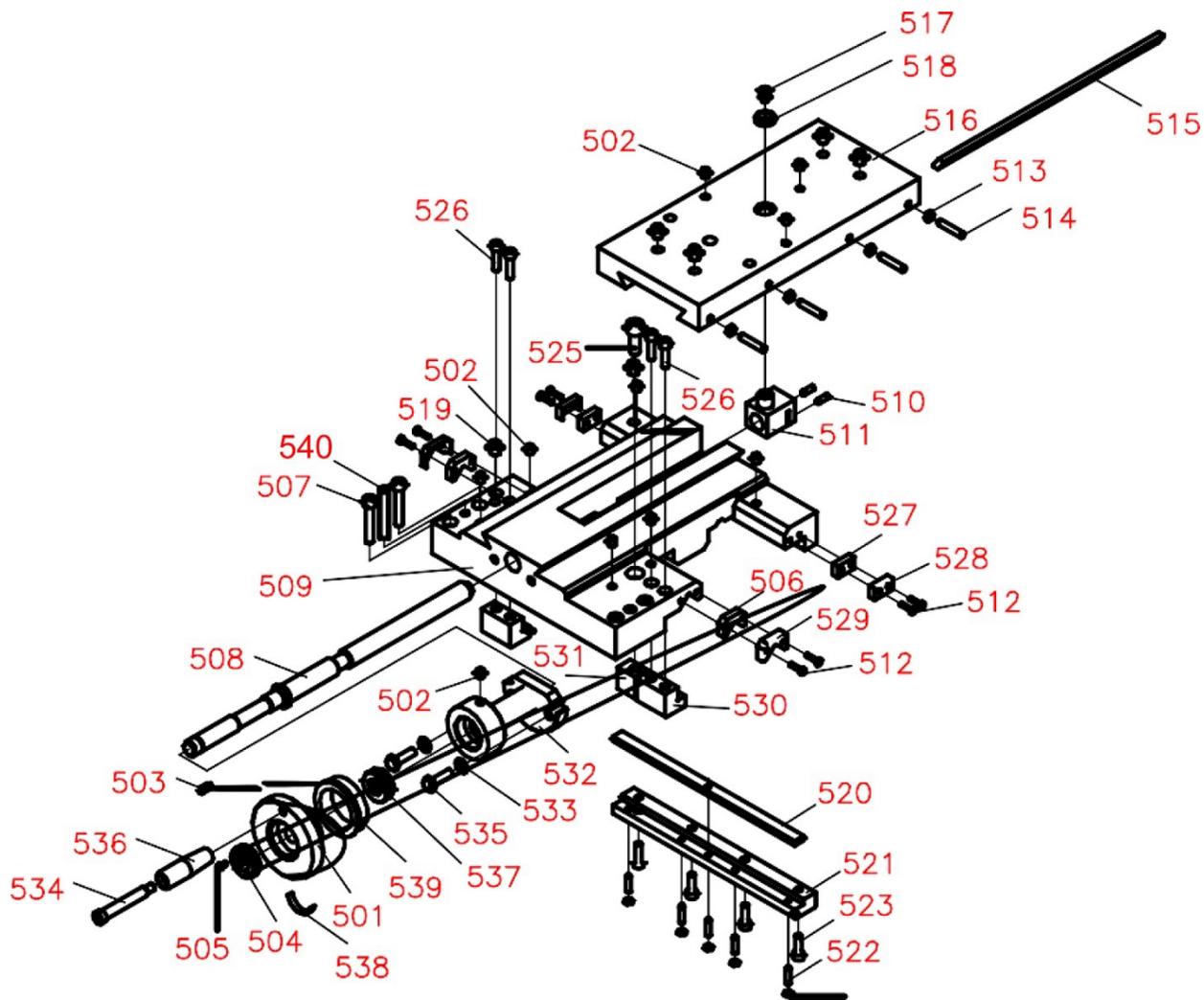
11.1.1 Lathe Assembly – Exploded View

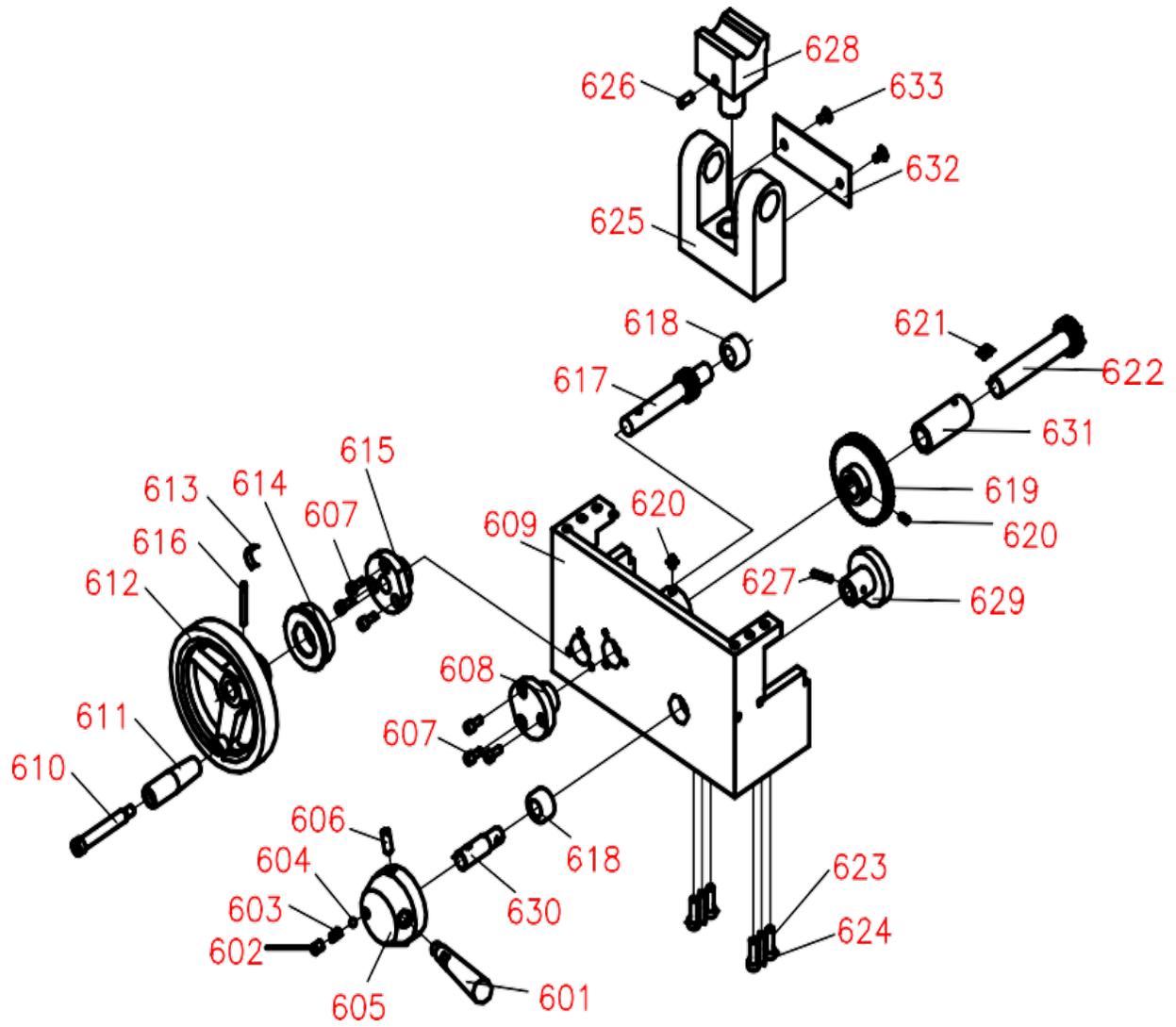


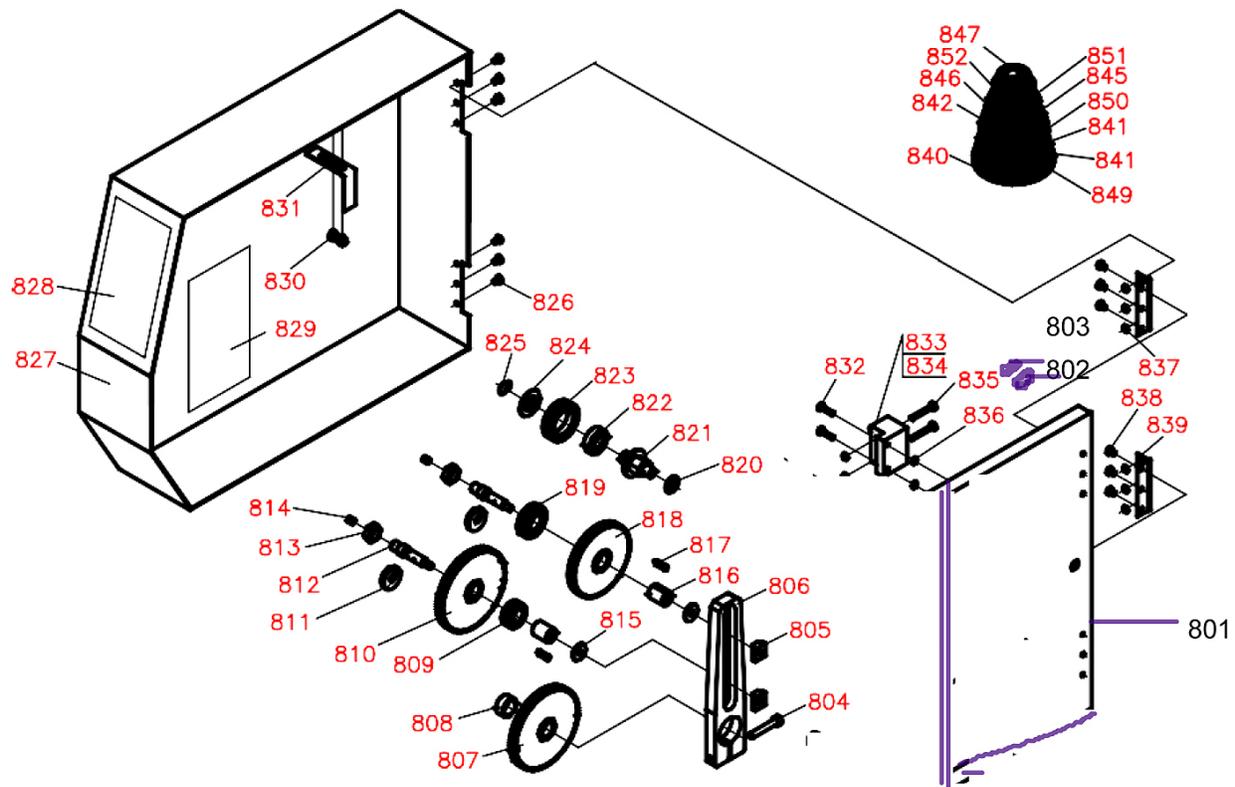


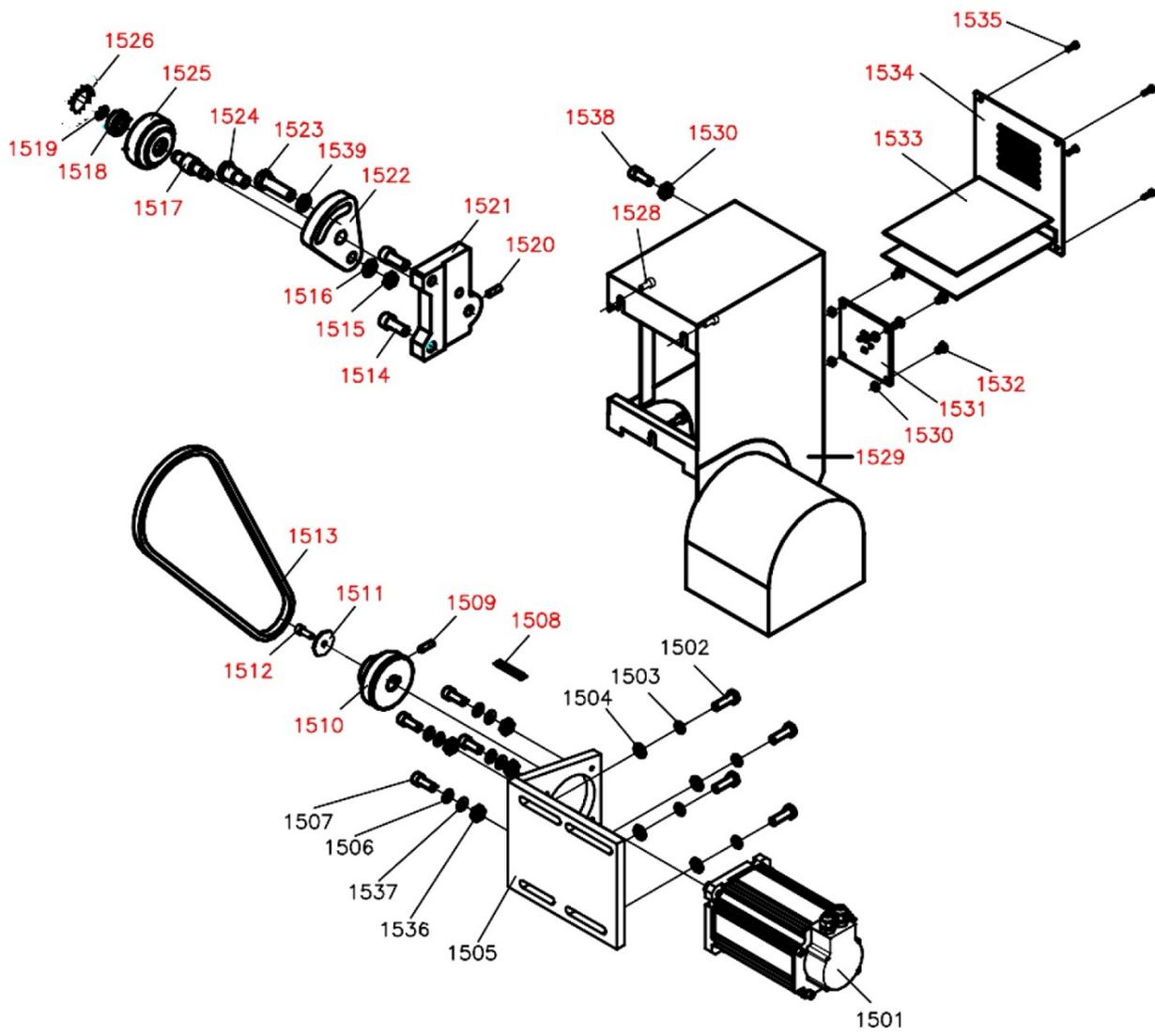












11.1.2 Lathe Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
101	**	MACH Screw, Flat HD	M5X6	5
102	**	Protecting Cover of Leadscrew		1
103	**	Retaining Rings, EXT	M14	2
104	**	Washer		1
105	**	Small Gear		2
106	BA1-9635	Flat Key	4X4X8	2
107	**	Change Gear Shaft		1
108	JT9-TS-1501051	Socket Head Cap Screw	M4X16	3
109	**	Adjusting Disc		1
110	**	Shaft Support		1
111	**	Taper pins with internal thread	6X26	6
112	JT9-TS-1502051	Socket Head Cap Screw	M5X20	10
113	**	Bolt (With Shoulder)		1
114	**	Fit Grease Fittings, Push	φ6	3
115	**	Block for Switch		1
116	JT9-TS-2284081	MACH Screw, Flat HD	M4X8	2
117	**	Leadscrew Support (Left)		1
118	**	Slotted Set Screws, Cone Point	M4X8	1
119	**	Round Nut	M27*1.5	2
120	**	Steel Washer		1
121	**	MACH Screw, Flat HD	M5X14	2
122	**	Switch Label		1
123	**	Shaft Protecting Cover		1
124	**	Bed		1
125	**	Hex Thin Nut	M6P1.0	2
126	**	Flat Washer	M6	2
127	JT9-TS-1503021	Socket Head Cap Screw	M6X10	2
128	BA9-1232654	Splash Guard		1
129	PM9-TS-2228161	Hex Cap Screw	M8X16	2
130	JT9-TS-1550061	Flat Washer	M8	2
131	JT9-TS-1504041	Socket Head Cap Screw	M8X20	1
132	BA1-10814	Gear		1
133	**	MACH Screw, Flat HD	M5X12	5
134	**	Leadscrew Support (Right)		1
135	**	Long Leadscrew		1
136	**	Taper pins	4X24	2
137	**	Joint Sleeve of Leadscrew		1
138	**	Joint Shaft of Leadscrew		1
146	JT9-TS-1492041	Hex Cap Screw	M12X40	3
147	**	Flat Washer	M12	3
148	**	Flat Key	4X4X16	1
154	**	Pan Head MACH Screw	M4X6	2
155	**	Protector for Small Gear		1
156	**	Green Lamp		1
157	**	Fuse Box		1
158	**	Fuse Box		1
159	**	Switch		1
201	CM9-TS-1534041	MACH Screw, Flat HD	M5X10	4
202	**	Pan Head MACH Screw	M3X14	4
203A	BA9-1229289			
	/BA9-1232789	Emergency Switch		1
205A	**	Digital Display		1
207A	**	Label		1
208	**	Electric Connector		2
209	**	Round Nut, M27 x 1.5		2
210	**	Spindle Pulley		1
211	**	Spindle Gear		1
212	**	Oil Ring		2
213	**	Pan Head MACH Screw	M5X8	3

Index No.	Part No.	Description	Size	Qty
214	**	Spacer		1
215	JT9-BB-32007	Tapered Roller Bearing	35X62X18mm	1
216	BA1-10815	Spindle Box Cover		1
217	**	Hex Thin Nut	M4P0.7	2
218	JT9-TS-1501091	Socket Head Cap Screw	M4X35	2
219	**	Pin Shaft		1
220	**	Box for Micro Switch		1
221	**	Head Stock Body		1
222	**	Fixing Nut		3
223	**	Rotate Spacer		1
224	**	Flat Key	4X4X40	1
225	**	Spindle		1
226	CM9-TS-1503041	Socket Head Cap Screw	M6X16	3
227	**	Front Bearing Cover		1
228	JT9-TS-2361051	Lock Washer	M5	3
229	**	External Tooth Lock Washers	M5	3
230	**	MACH Screw, Flat HD	M5X16	1
231	**	Spindle Center		1
232	BA1-10816	3-Jaw Chuck D=125		1
233	JT9-F207006	Retaining Rings, EXT	M6	1
234	JT9-TS-1502031	Socket Head Cap Screw	M5X12	4
235	JT9-TS-1505031	Socket Head Cap Screw	M10X25	4
236	CM9-TS-1534041	MACH Screw, Flat HD	M5X10	2
237	**	Support		1
238	**	Limit Block of Dust Bracket		1
239	BA9-1229290			
	/BA1-1954	Chuck Guard		1
240	**	Fixing Support		1
241	**	Small Shaft		1
242	**	Compress Spring		1
243	**	Flat Washer	M6	2
244	**	Hex Thin Nut	M6P1.0	2
245	**	Plate for Switches		1
246	**	Flat Washer	M10	4
247	**	MACH Screw, Flat HD	M5X8	2
248	**	Micro Switch		1
249	**	3-Jaw Chuck Flange		1
250	**	Hex Cap Screw	M8X30	3
251	**	Plug Bolt		3
252	BA1-4401	Hex Nut	M10P1.5	3
253	**	Bearing		1
301	JT9-TS-1504061	Socket Head Cap Screw	M8X30	2
302	**	Nut		1
303	**	Flat Washer	M12	1
304	JT9-TS-1540081	Hex Nut	M12P1.75	1
305	**	Tailstock Body		1
306	JT9-BB-51101	Thrust Bearing	12X26X9mm	1
307	**	Tailstock Leadscrew		1
308	**	Tailstock Sleeve		1
309	**	Tubular Clamp		1
310	**	Washer		1
311	BA1-10817	Clamp Bolt		1
312	BA1-10818	Handle		1
313	**	Oil Cup		2
314	**	T-Tap Flat Key, M12 x 12 x 7		1
315	**	Socket Set Screw, Long Dog Point	M6X16	1
316	JT9-TS-1502051	Socket Head Cap Screw	M5X20	4
317	**	Tailstock End Cover		1
318	**	Spring Pin	4X30	1
319	**	Spring Bow		1
320	**	Handle		1

Index No.	Part No.	Description	Size	Qty
321	BA1-10819	Handle Bolt		1
322	BA1-10820	Handle Sleeve		1
323	**	Index Ring		1
324	**	Square head bolts	M12X100	1
325	**	Tailstock Clamp Plate		1
326	**	Base		1
327	**	Zero Position Label		2
328	**	Rivet	2X4	4
329	**	Indicate Label		1
330	BA1-10821	Tailstock Center		1
401	**	Cutter Rest Revolving Dish Set		1
402	**	Clamp Disc		1
403	**	Hex Cap Screw, Reduced Shank	M8X20	2
404	**	Cutter Rest Revolving Dish		1
405	**	Cutter Rest Bold		1
406	**	Hex Thin Nut	M4P0.7	4
407	**	Socket Set Screw, Long Dog Point	M4X20	3
408	**	Socket Set Screw, Long Dog Point	M4X12	1
409	**	Fit Grease Fittings, Push	φ10	1
410	**	Fixing Pin		1
411	**	Square Cutter Rest		1
412	**	Square Set Screws, Long Dog Point	M8X30	8
413	BA1-10822	Handle		1
414	BA1-10823	Handle Base		1
415	**	Washer		1
416	**	Compression Spring	0.5x3.5x17mm	1
417	**	Cutter Rest Carriage		1
418	**	Wedge		1
419	**	Spring Pin	3X10	1
420	**	Cutter Rest Carriage Leadscrew		1
421	**	Flat Key	3X3X10	1
422	**	Fit Grease Fittings, Push	φ6	2
423	**	Leadscrew Support		1
424	JT9-TS-1502041	Socket Head Cap Screw	M5X16	2
425	**	Spring Plate		1
426	BA1-10824	Handle		2
427	**	Hex Nut	M8P1.25	1
428	JT9-TS-1550061	Flat Washer	M8	1
429	**	Cutter Rest Carriage Handle		1
430	**	Index Ring		1
431	**	Screw, M6 x 16		4
432	**	Spring Pin	4X16	2
501	**	Handle		1
502	**	Oil Cup, 6mm		10
503	**	Flat Key	4X4X12	1
504	**	Nut		1
505	**	MACH Screw, Flat HD	M3X6	1
506	**	Oil-Stopping Felt		2
507	JT9-TS-1503081	Socket Head Cap Screw	M6X35	4
508	BA9-1232902	Saddle Leadscrew		1
509	**	Saddle		1
510	**	Socket Set Screw, Long Dog Point	M4X12	2
511	**	Nut		1
512	**	Pan Head MACH Screw	M3X12	8
513	JT9-TS-1540031	Hex Nut	M5P0.8	4
514	**	Socket Set Screw, Long Dog Point	M5X25	4
515	**	Wedge		1
516	**	Cross Slide		1
517	CM9-TS-1534041	MACH Screw, Flat HD	M5X10	1
518	**	Washer		1
519	**	Slotted Set Screws, Cone Point	M8X10	6

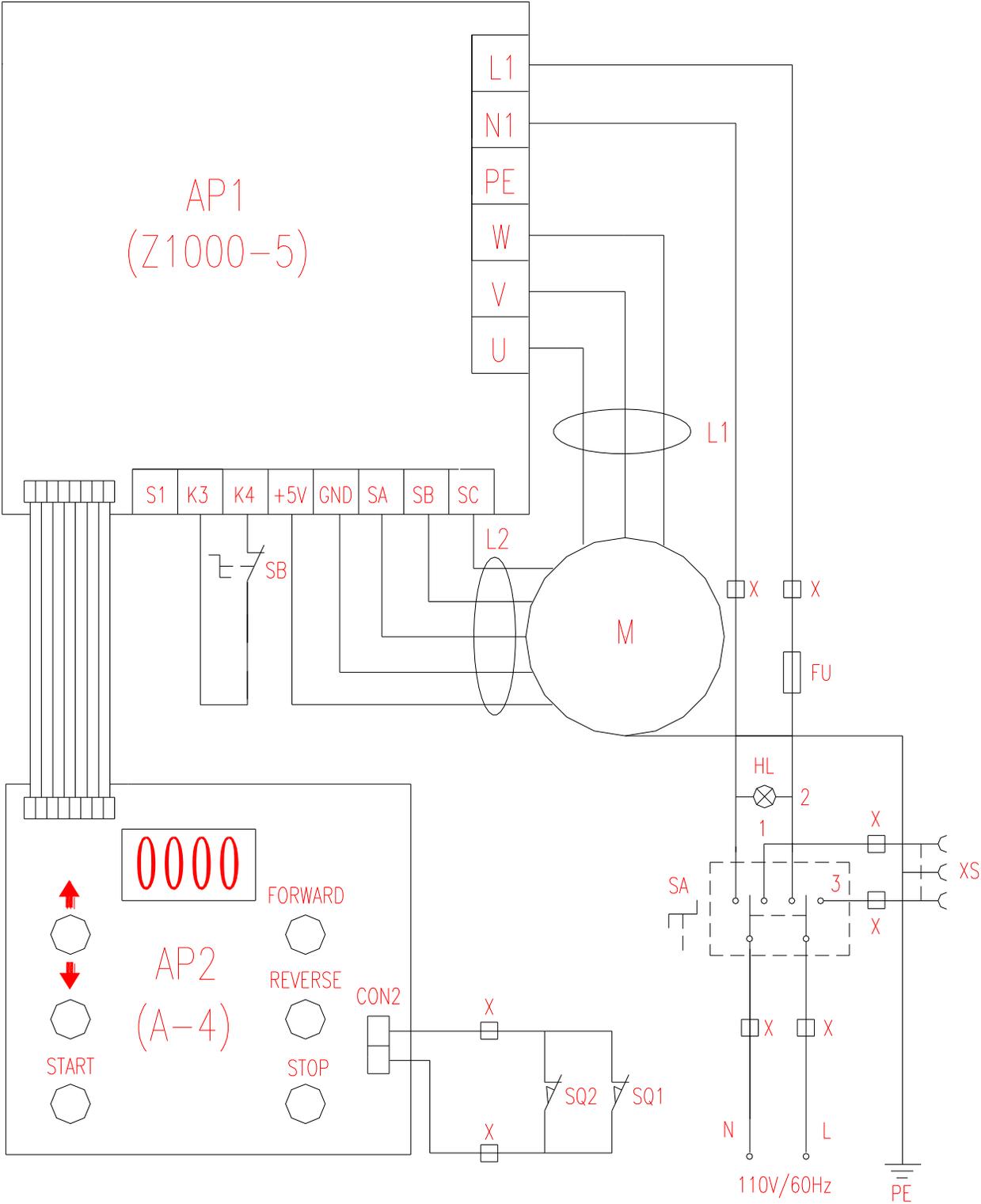
Index No.	Part No.	Description	Size	Qty
520	**	Rear-Clamp Plate Gib Strip		1
521	**	Saddle Rear-Clamp Plate		1
522	**	Socket Set Screw, Long Dog Point	M4X16	5
523	JT9-TS-1502041	Socket Head Cap Screw	M5X16	4
524	**	Hex Thin Nut	M4P0.7	5
525	JT9-TS-1504041	Socket Head Cap Screw	M8X20	1
526	JT9-TS-1502051	Socket Head Cap Screw	M5X20	4
527	**	Oil-Stopping Felt		2
528	**	Protecting Panel		2
529	**	Protecting Panel		2
530	**	Saddle Front-Clamp Plate		2
531	**	Braking Plate		1
532	BA9-1232903	Leadscrew Support		1
533	**	Flat Washer	M6	2
534	BA1-10825	Handle Bolt		1
535	JT9-TS-1482041	Hex Cap Screw	M6X20	2
536	BA1-10826	Handle Sleeve		1
537	JT9-BB-51101	Thrust Bearing	12X26X9mm	1
538	**	Spring Plate		1
539	**	Index Ring		1
540	**	Taper pins with internal thread	6X45	2
601	BA1-10827	Handle		1
602	**	Slotted Set Screws, Flat Point	M6X8	1
603	**	Compress Spring		1
604	**	Ball Bearings	Φ5mm	1
605	**	Handle Seat		1
606	**	Slotted Set Screws, Cone Point	M6X16	1
607	JT9-TS-1501031	Socket Head Cap Screw	M4X10	6
608	**	Flange Shaft Sleeve		1
609	**	Apron Body		1
610	BA1-10828	Handle Bolt		1
611	BA1-10829	Handle Sleeve		1
612	**	Handle		1
613	**	Spring Plate		1
614	**	Index Ring		1
615	**	Small Flange Shaft Sleeve		1
616	**	Spring Pin	4X30	1
617	**	Small Gear Shaft		1
618	**	Shaft Sleeve		2
619	**	Gear		1
620	**	Slotted Set Screws, Cone Point	M4X8	2
621	**	Flat Key	5X5X10	1
622	**	Gear Shaft		1
623	JT9-TS-1502041	Socket Head Cap Screw	M5X16	4
624	**	Taper pins	4X22	2
625	**	Nut Set		1
626	**	Roll Pin	5X12	1
627	**	Taper pins	3X20	1
628	**	Nut		1
629	**	Slotted Disc		1
630	**	Rotating Shaft		1
631	**	Shaft Sleeve		1
632	**	Moving Plate		1
633	JT9-TS-2284081	MACH Screw, Flat HD	M4X8	2
801	BA1-10830	Gear Box Support Plate		1
802	**	Washer	M8	6
803	PM9-TS-2228161	Hex Cap Screw	M8X16	6
804	JT9-TS-1503081	Socket Head Cap Screw	M6X35	1
805	**	Square Nut		2
806	**	Gear Rest		1
807	**	Gear Z:100 (I)		1

Index No.	Part No.	Description	Size	Qty
808	**	Washer		1
809	**	Gear Z:25		1
810	**	Gear Z:90		1
811	**	Open Washer		2
812	**	Bolt		2
813	JT9-TS-1540081	Hex Nut	M12P1.75	2
814	**	Fit Grease Fittings, Push	φ6	2
815	**	Washer		2
816	**	Bearing		2
817	**	Flat Key	4X4X16	2
818	**	Gear Z:80		1
819	**	Gear Z:33		1
820	**	Washer		1
821	**	Fixed Bolt		1
822	CM9-BB-6001ZZ	Bearing	6001-2Z	1
823	BA1-9458	Gear Z:40		1
824	**	Washer		1
825	**	Retaining Rings, EXT	M12	1
826	**	Pan Head MACH Screw	M4X8	6
827	BA9-1232899	Gear Box Cover		1
828	BA9-1232900	Main Label		1
829	BA9-1232901	Changing Gear Label		1
830	**	Pan Head MACH Screw	M5X6	2
831	**	Moving and Limit Wedge		1
832	**	Pan Head MACH Screw	M4X16	2
833	**	Protecting Box for Micro Switch		1
834	**	Micro Switch		1
835	**	Pan Head MACH Screw	M4X30	2
836	JT9-TS-1540021	Hex Nut	M4P0.7	4
837	**	Hex Thin Nut	M4P0.7	6
838	**	Pan Head MACH Screw	M4X6	6
839	**	Cover, 62*33*1mm		2
840	**	Gear Z:75		1
841	**	Gear Z:70		2
842	**	Gear Z:66		1
845	**	Gear Z:60		1
846	**	Gear Z:50		1
847	**	Gear Z:40		1
849	**	Gear Z:72		1
850	**	Gear Z:68		1
851	**	Gear Z:48		1
852	**	Gear Z:45		1
1501	**	Motor 1000W		1
1502	**	Hex Cap Screw	M8X30	4
1503	JT9-TS-2361082	Lock Washer	M8	4
1504	**	Flat Washer	M8	4
1505	**	Motor Connector		1
1506	**	Washer, M6		4
1507	JT9-TS-1503071	Socket Head Cap Screw	M6X30	4
1508	**	Flat Key	5X5X25	1
1509	**	Socket Set Screw, Flat Point	M5X12	1
1510	BA1-10831	Motor Pulley		1
1511	**	Check Ring		1
1512	JT9-TS-1503071	Socket Head Cap Screw	M6X30	1
1513	BA9-1229292			
	/BA1-1389	V Belt	V-813	1
1514	JT9-TS-1505031	Socket Head Cap Screw	M10X25	2
1515	**	Hex Thin Nut	M10P1.5	1
1516	**	Retaining Rings, EXT	M12	1
1517	**	Support Shaft		1
1518	**	Bearing	37X12X12mm	1

Index No.	Part No.	Description	Size	Qty
1519	**	Retaining Rings, EXT	M12	1
1520	**	Socket Set Screw, Cone Point	M6X16	1
1521	**	Support		1
1522	**	Support		1
1523	JT9-TS-1491041	Hex Cap Screw	M10X30	1
1524	**	Fixed Shaft		1
1525	**	Compress Wheel		1
1526	**	Retaining Ring, INT	M37	
1528	CM9-TS-1503031	Socket Head Cap Screw	M6X12	3
1529	BA9-1232655			
	/BA1-4067	Electric Protector		1
1530	**	Hex Thin Nut	M5P0.8	5
1531	**	Plug		1
1532	**	Pan Head MACH Screw	M5X8	4
1533	BA9-1229291	PC Board		1
1534	**	Seal Board		1
1535	**	Pan Head MACH Screw	M4X8	4
1536	CM9-TS-1540041	Hex Nut	M6P1.0	4
1537	JT9-TS-2361062	Lock Washer	M6	4
1538	**	Socket Set Screw, Flat Point	M5X12	1
1539	**	Flat Washer	M10	1
SRA	BA1-1727	STEADY REST ASSY (FULL)		
TSA	BA1-1728	TAILSTOCK ASSY (FULL)		

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

12.0 Lathe Wiring Diagram



13.0 Warranty and Service

Thank you for your purchase of a machine from Baileigh Industrial. We hope that you find it productive and useful to you for a long time to come.

Inspection & Acceptance. Buyer shall inspect all Goods within ten (10) days after receipt thereof. Buyer's payment shall constitute final acceptance of the Goods and shall act as a waiver of the Buyer's rights to inspect or reject the Goods unless otherwise agreed. If Buyer rejects any merchandise, Buyer must first obtain a Returned Goods Authorization ("RGA") number before returning any Goods to Seller. Goods returned without an RGA will be refused. Seller will not be responsible for any freight costs, damages to Goods, or any other costs or liabilities pertaining to Goods returned without an RGA. Seller shall have the right to substitute a conforming tender. Buyer will be responsible for all freight costs to and from Buyer and repackaging costs, if any, if Buyer refuses to accept shipment. If Goods are returned in unsalable condition, Buyer shall be responsible for full value of the Goods. Buyer may not return any special-order Goods. Any Goods returned hereunder shall be subject to a restocking fee equal to 30% of the invoice price.

Specifications. Seller may, at its option, make changes in the designs, **specifications**, or components of the Goods to improve the safety of such Goods, or if in Seller's judgment, such changes will be beneficial to their operation or use. Buyer may not make any changes in the specifications for the Goods unless Seller approves of such changes in writing, in which event Seller may impose additional charges to implement such changes.

Limited Warranty. Seller warrants to the original end-user that the Goods manufactured or provided by Seller under this Agreement shall be free of defects in material or workmanship for a period of twelve (12) months from the date of purchase, provided that the Goods are installed, used, and maintained in accordance with any instruction manual or technical guidelines provided by the Seller or supplied with the Goods, if applicable. The original end-user must give written notice to Seller of any suspected defect in the Goods prior to the expiration of the warranty period. The original end-user must also obtain an RGA from Seller prior to returning any Goods to Seller for warranty service under this paragraph. Seller will not accept any responsibility for Goods returned without an RGA. The original end-user shall be responsible for all costs and expenses associated with returning the Goods to Seller for warranty service. In the event of a defect, Seller, at its sole option, shall repair or replace the defective Goods or refund to the original end-user the purchase price for such defective Goods. Goods are not eligible for replacement or return after a period of 10 days from date of receipt. The foregoing warranty is Seller's sole obligation, and the original end-user's exclusive remedy, with regard to any defective Goods. This limited warranty does not apply to: (a) die sets, tooling, and saw blades; (b) periodic or routine maintenance and setup, (c) repair or replacement of the Goods due to normal wear and tear, (d) defects or damage to the Goods resulting from misuse, abuse, neglect, or accidents, (f) defects or damage to the Goods resulting from improper or unauthorized alterations, modifications, or changes; and (f) any Goods that has not been installed and/or maintained in accordance with the instruction manual or technical guidelines provided by Seller.

EXCLUSION OF OTHER WARRANTIES. THE FOREGOING LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED. ANY AND ALL OTHER EXPRESS, STATUTORY, OR IMPLIED WARRANTIES, INCLUDING BUT NOT LIMITED TO, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR PURPOSE ARE EXPRESSLY DISCLAIMED. NO WARRANTY IS MADE WHICH EXTENDS BEYOND THAT WHICH IS EXPRESSLY CONTAINED HEREIN.

Limitation of Liability. IN NO EVENT SHALL SELLER BE LIABLE TO BUYER OR ANY OTHER PARTY FOR ANY INCIDENTAL, CONSEQUENTIAL OR SPECIAL DAMAGES (INCLUDING, WITHOUT LIMITATION, LOST PROFITS OR DOWN TIME) ARISING FROM OR IN MANNER CONNECTED WITH THE GOODS, ANY BREACH BY SELLER OR ITS AGENTS OF THIS AGREEMENT, OR ANY OTHER CAUSE WHATSOEVER, WHETHER BASED ON CONTRACT, TORT OR ANY OTHER THEORY OF LIABILITY. BUYER'S REMEDY WITH RESPECT TO ANY CLAIM ARISING UNDER THIS AGREEMENT IS STRICTLY LIMITED TO NO MORE THAN THE AMOUNT PAID BY THE BUYER FOR THE GOODS.

Force Majeure. Seller shall not be responsible for any delay in the delivery of, or failure to deliver, Goods due to causes beyond Seller's reasonable control including, without limitation, acts of God, acts of war or terrorism, enemy actions, hostilities, strikes, labor difficulties, embargoes, non-delivery or late delivery of materials, parts and equipment or transportation delays not caused by the fault of Seller, delays caused by civil authorities, governmental regulations or orders, fire, lightning, natural disasters or any other cause beyond Seller's reasonable control. In the event of any such delay, performance will be postponed by such length of time as may be reasonably necessary to compensate for the delay.

Installation. If Buyer purchases any Goods that require installation, Buyer shall, at its expense, make all arrangements and connections necessary to install and operate the Goods. Buyer shall install the Goods in accordance with any Seller instructions and shall indemnify Seller against any and all damages, demands, suits, causes of action, claims and expenses (including actual attorneys' fees and costs) arising directly or indirectly out of Buyer's failure to properly install the Goods.

Work By Others; Safety Devices. Unless agreed to in writing by Seller, Seller has no responsibility for labor or work performed by Buyer or others, of any nature, relating to design, manufacture, fabrication, use, installation, or provision of Goods. Buyer is solely responsible for furnishing and requiring its employees and customers to use all safety devices, guards and safe operating procedures required by law and/or as set forth in manuals and instruction sheets furnished by Seller. Buyer is responsible for consulting all operator manuals, ANSI or comparable safety standards, OSHA regulations and other sources of safety standards and regulations applicable to the use and operation of the Goods.

Remedies. Each of the rights and remedies of Seller under this Agreement is cumulative and in addition to any other or further remedies provided under this Agreement or at law or equity.

Attorney's Fees. In the event legal action is necessary to recover monies due from Buyer or to enforce any provision of this Agreement, Buyer shall be liable to Seller for all costs and expenses associated therewith, including Seller's actual attorney fees and costs.

Governing Law/Venue. This Agreement shall be construed and governed under the laws of the State of Wisconsin, without application of conflict of law principles. Each party agrees that all actions or proceedings arising out of or in connection with this Agreement shall be commenced, tried, and litigated only in the state courts sitting in Manitowoc County, Wisconsin or the U.S. Federal Court for the Eastern District of Wisconsin. Each party waives any right it may have to assert the doctrine of "forum non conveniens" or to object to venue to the extent that any proceeding is brought in accordance with this section. Each party consents to and waives any objection to the exercise of personal jurisdiction over it by courts described in this section. Each party waives to the fullest extent permitted by applicable law the right to a trial by jury.

Summary of Return Policy:

- 10 Day acceptance period from date of delivery. Damage claims and order discrepancies will not be accepted after this time.
- You must obtain a Baileigh Industrial issued RGA number PRIOR to returning any materials.
- Returned materials must be received at Baileigh Industrial in new condition and in original packaging.
- Altered items are not eligible for return.
- Buyer is responsible for all shipping charges.
- A 30% re-stocking fee applies to all returns.

Baileigh Industrial makes every effort to ensure that our posted specifications, images, pricing, and product availability are as correct and timely as possible. We apologize for any discrepancies that may occur. Baileigh Industrial reserves the right to make any and all changes deemed necessary in the course of business including but not limited to pricing, product specifications, quantities, and product availability.

For Customer Service & Technical Support:

Please contact one of our knowledgeable Sales and Service team members at:
(920) 684-4990 or e-mail us at Baileigh-Service@jpwindustries.com



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