



Operations with a lathe

Name: _____



Starting lathe

1

Before starting the lathe, _____ that you turn the CSS function switch to OFF, turn the spindle speed dial to the minimum, and make sure the cross slide is _____.

2

_____ the master switch on the back of the lathe, and turn it to the "I" or the "ON" position, and the power lamp will light.

3

_____ the spindle ON/OFF lever to start/stop spindle and chuck rotation.

4

To stop a free wheeling chuck and cut power to the motor, _____ down on the foot brake.

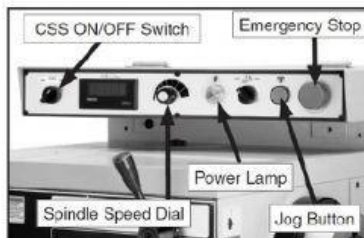
Move

make sure

backed out

Find

press





Operations with a lathe

OPERATION 2

Drilling with tailstock



To use a tapered drill chuck:

1

With the tailstock locked, _____ the quill lock lever.

2

Turn the quill feed handle clockwise to extend the quill about 5% inch out of the casting.

3

_____ a tapered drill arbor, or a tapered drill bit, into the quill until the taper is firmly seated and the tang is locked into the quill slot.

4

_____ the quill feed handwheel clockwise to feed the drill bit into the rotating workpiece.

5

To _____ the tooling from the tailstock, turn the quill feed handwheel counterclockwise until the tooling is _____ of the taper.

Turn

unlock

Insert

remove

pushed out



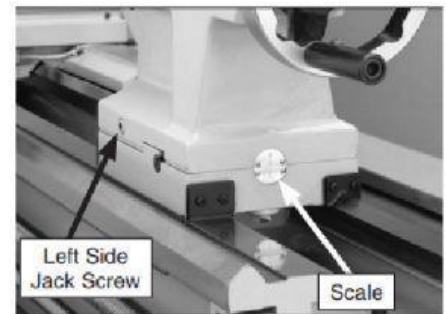
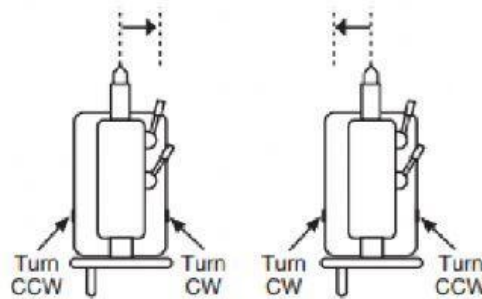
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OPERATION 3

Cutting tapers with tailstock

The tailstock can be offset left or right to cut tapers. To offset the tailstock:

1. _____ the tailstock in position, and _____ the left and right jack screws until the scale _____ the offset you _____.
2. When the offset is achieved, _____ the jack screws so the tailstock position is locked.



Lock

indicates

snug

adjust

want