



# Operations with a lathe

Name: \_\_\_\_\_

OPERATION

# 1

## 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.

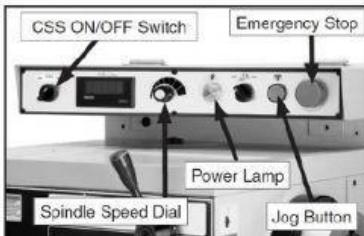
Move

make sure

backed out

Find

press



**LIVEWORKSHEETS**



# 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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# Operations with a lathe

OPERATION

# 3

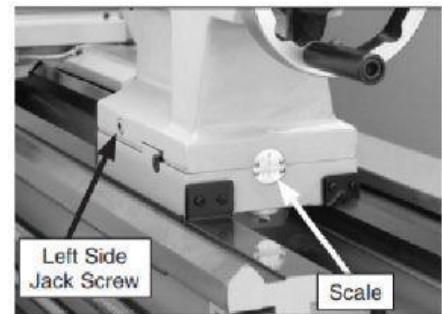
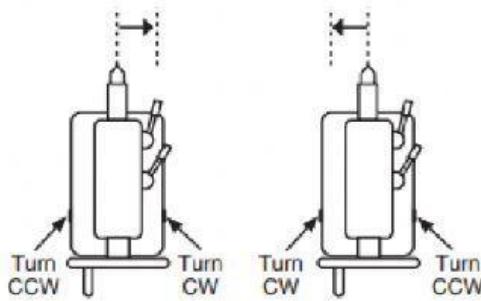
## Cutting tapers with tailstock

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



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