

# WAHUDA TOOLS

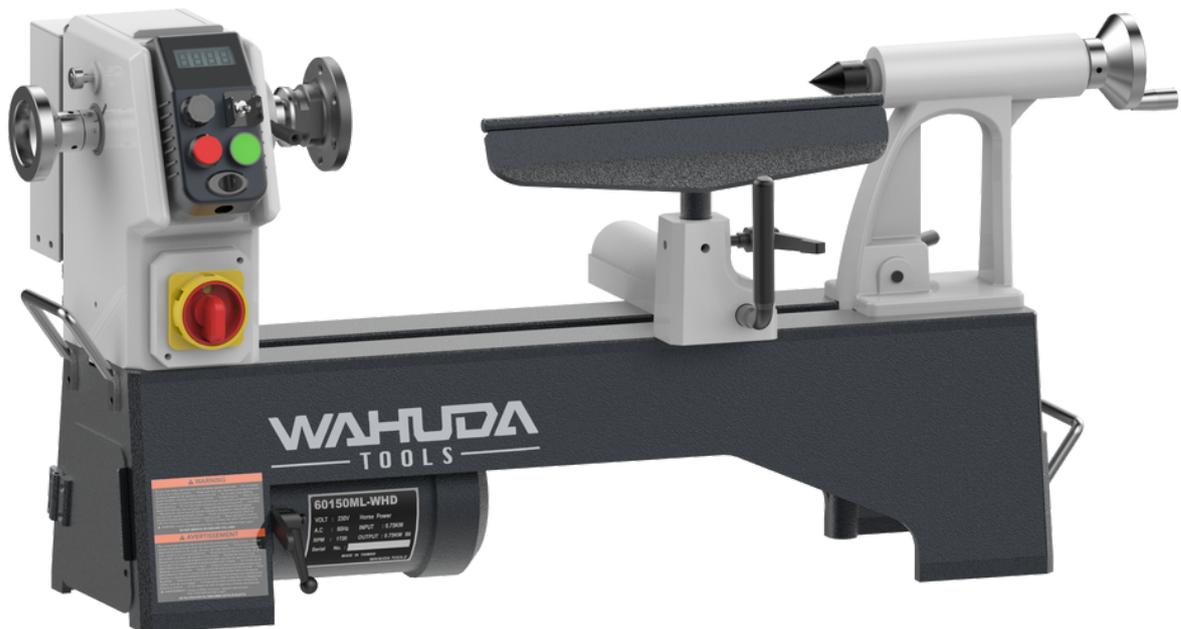
## User Manual

Read this manual before using machine to avoid serious injury and damage

# 60150ML-WHD

## 15" Variable Speed Woodworking Midi Lathe

*with Wired Remote and Digital Readout*



For technical support, email [techservices@wahudatools.com](mailto:techservices@wahudatools.com) or call at **877-568-8879**  
VER. 12.23.23

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## INTRODUCTION

This user manual is intended for use by anyone working with this machine. It should be kept available for immediate reference so that all operations can be performed with maximum efficiency and safety. Do not attempt to perform maintenance or operate this machine until you have read and understand the information contained in this manual. The drawings, illustrations, photographs, and specifications in this user manual represent your machine at time of print. However, changes may be made to your machine or this manual at any time with no obligation to WAHUDA.

# WARRANTY

## 2 - YEAR LIMITED WARRANTY

WAHUDA warrants its machinery to be free of defects in workmanship and materials for a period of two (2) years from the date of the original purchase by the original owner. This warranty applies to products sold in United States only. The warranty does not apply to any product used for professional or commercial production purposes nor for industrial or educational applications. Such cases are covered by our 1 year Limited Warranty with the Conditions and Exceptions.

Warranty does not include failures, breakage or defects deemed after inspection by an Authorized Service Center or our agent to have been directly or indirectly caused by or resulting from improper use, lack of or improper maintenance, misuse or abuse, negligence, accidents, damage in handling or transport, or normal wear and tear of any part or component. Examples are consumables such as inserts and knives or wear items like drive belts, bearings or brushes. Additionally, warranty is void if repairs or alterations are made to the machine by an unauthorized service center without the direct consent of WAHUDA.

To file a claim of warranty, call toll free 877-568-8879 or email [techservices@wahudatools.com](mailto:techservices@wahudatools.com) . Warranty applies to the original buyer only and cannot be transferred. Your machines date of purchase and serial number have already been registered with WAHUDA when shipped. If you purchased your machine from one of our authorized dealers, please go online at [www.wahudatools.com](http://www.wahudatools.com) and register your machine online. Thus, you will only need to provide your full name when contacting WAHUDA.

The defective units should be returned Freight prepaid to WAHUDA's Authorized Service Center for inspection. If the warranty claim is considered to be invalid due to exclusions listed above, WAHUDA will at your direction dispose of or return the product. In the event you choose to have the product returned you will be responsible for the handling and shipping cost of the return.

WAHUDA furnishes the above warranties in lieu of all other warranties, express or implied. WAHUDA shall not be liable for any special, indirect, incidental, punitive or consequential damages, including without limitation to loss of profits arising from or related to the warranty, the breach of any agreement or warranty, or the operation or use of its machinery, including without limitation damages arising from damage to fixtures, tools, equipment, parts or materials, direct or indirect loss caused by any other part, loss of revenue or profits, financing or interest charges, and claims by and third person, whether or not notice of such possible damages has been given to WAHUDA. Not Responsible for damages of any kind for any delay by or failure of WAHUDA to perform its obligations under this agreement or claims made a subject of a legal proceeding against WAHUDA more than one (1) year after such cause of action first arose.

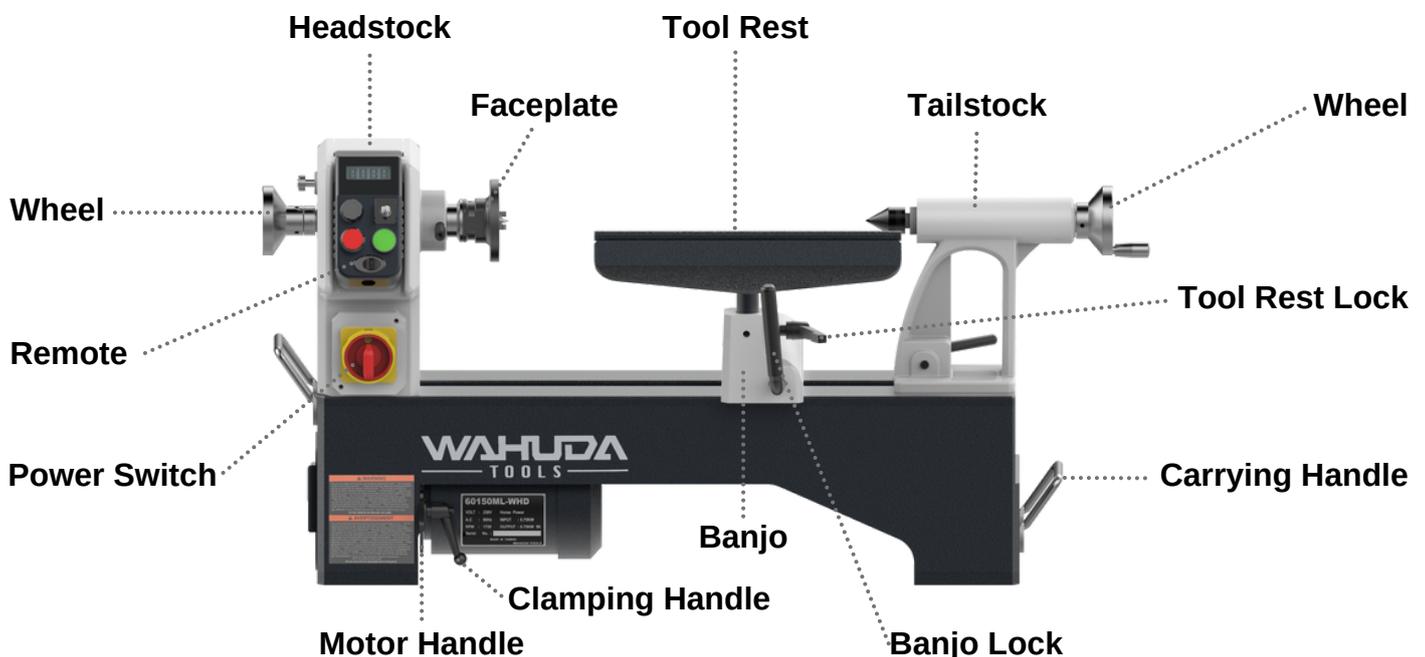
The validity, construction and performance of this Warranty and any sale of machinery by WAHUDA shall be governed by the law of the State of Tennessee, without regard to conflicts of law's provisions of any jurisdiction. Any action related in any way to any alleged or actual offer, acceptance or sale by WAHUDA or any claim related to the performance of and agreement including without limitation this Warranty, shall take place in the federal or state courts in Shelby County, Tennessee.

WAHUDA reserves the right to change the specifications of its machines without prior notice.

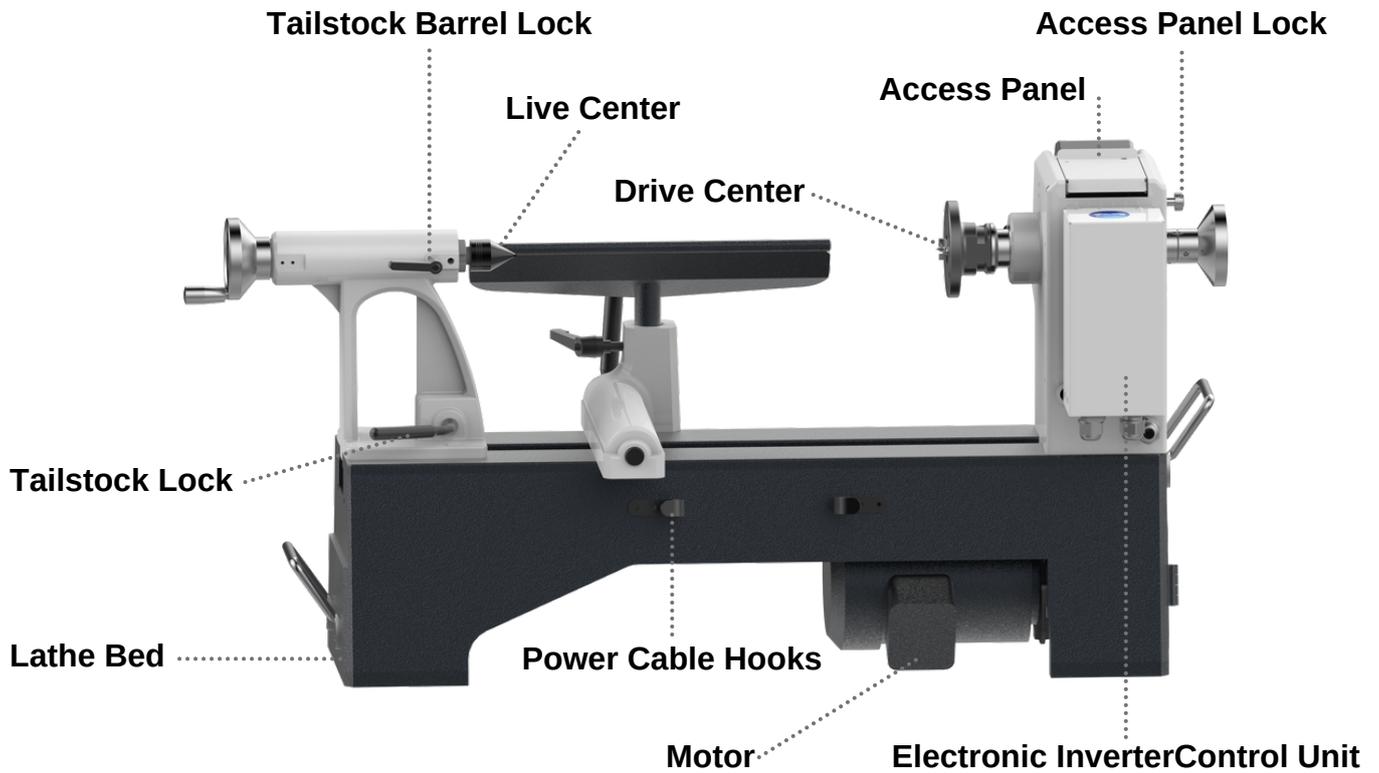
# PRODUCT SPECIFICATIONS

Motor power input Motor	230 V, 60 Hz, 1PH, AC, 16 Amp
(VFD inverter controlled)	110V, 60HZ, 3 PH, 1 HP, AC, 3 Amp, 1720 RPM
Lathe RPM Headstock Spindle	0 - 1000 / 0 - 1900 / 0 - 3700
Taper Drive Spindle Thread	2MT
Drive Spindle Hole Diameter	6" x 13"
Drive Spindle Hole Diameter	3/8"
Tailstock Spindle Taper	2MT
Distance Between Centers	16"
Max Diameter over Bed	15"
Tool Rest	14" width x 1" Post Diameter
Shipping Weight	172 lbs
Net Weight	150 lbs
Dimensions	32" L x 13" W x 17" H
Shipping Dimensions	35" L x 20" W x 25.6" H
Recommended 20 amp circuit	

# FEATURE IDENTIFICATION



# FEATURE IDENTIFICATION (cont.)



## WIRED REMOTE CONTROL WITH MAGNETIC BACK



# GENERAL SAFETY

**NOTE:** The **WARNING!** and **CAUTION!** symbols indicate a potentially hazardous situation which, if not avoided, COULD result in death or serious injury. READ THIS MANUAL completely before assembling and operating this machine.

**WARNING!** TO AVOID serious injury, death, or damage to the machine, please read, understand, and follow, all Safety and Operating Instructions before assembling and operating this machine. This manual is not totally comprehensive. It does not and cannot convey every possible safety and operational problem which may arise while using this machine. The manual will cover many of the basic and specific safety procedures needed in an industrial environment.

All federal and state laws, and any regulations having jurisdiction covering the safety requirements for use of this machine, take precedence over the statements in this manual. Users of this machine must adhere to all such regulations.

**WARNING!** Exposure to the dust created by power sanding, sawing, grinding, drilling and other construction activities may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. The dust may contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Always operate tool in well ventilated area and provide for proper dust removal. Use a dust collection system along with an air filtration system whenever possible. Always use properly fitting NIOSH/OSHA approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

**WARNING!** ALWAYS wear eye protection. Any machine can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are NOT safety glasses. ALWAYS wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

**WARNING!** ALWAYS wear hearing protection. Plain cotton is not an acceptable protective device. Hearing equipment should comply with ANSI S3.19 Standards.

**WARNING!** ALWAYS wear a NIOSH/OSHA approved dust mask to prevent inhaling dangerous dust or airborne particles.

ALWAYS keep the work area clean, well lit, and organized. DO NOT work in an area that has slippery floor surfaces from debris, grease, and wax.

## GENERAL SAFETY (cont.)

**CAUTION!** ALWAYS unplug the machine from the electrical receptacle when making adjustments, changing parts or performing any maintenance.

AVOID ACCIDENTAL STARTING. Make sure that the power switch is in the "OFF" position before plugging in the power cord to the electrical receptacle.

**WARNING!** AVOID a dangerous working environment. DO NOT use electrical tools in a damp environment or expose them to rain or moisture.

**WARNING!** CHILDPROOF THE WORKSHOP AREA by removing switch keys, unplugging tools from the electrical receptacles, and using padlocks.

**CAUTION!** DO NOT use electrical tools in the presence of flammable liquids or gasses.

DO NOT FORCE the machine to perform an operation for which it was not designed. It will do a safer and higher quality job by only performing operations for which the machine was intended.

**WARNING!** DO NOT stand on a machine. Serious injury could result if it tips over or you accidentally contact any moving part.

DO NOT store anything above or near the machine.

**WARNING!** DO NOT operate any machine or tool if under the influence of drugs, alcohol, or medication.

EACH AND EVERY time, check for damaged parts prior to using any machine. Carefully check all guards to see that they operate properly, are not damaged, and perform their intended functions.

Check for alignment, binding or breakage of all moving parts. Any guard or other part that is damaged should be immediately repaired or replaced.

**WARNING!** Ground all machines. If any machine is supplied with a 3-prong plug, it must be plugged into a 3-contact electrical receptacle. The third prong is used to ground the tool and provide protection against accidental electric shock. DO NOT remove the third prong.

**CAUTION!** Keep visitors and children away from any machine. DO NOT permit people to be in the immediate work area, especially when the machine is operating.  
KEEP protective guards in place and in working order.

## GENERAL SAFETY (cont.)

**CAUTION!** MAINTAIN your balance. DO NOT extend yourself over the tool. Wear oil resistant rubber soled shoes. Keep floor clear of debris, grease, and wax.

MAINTAIN all machines with care. ALWAYS KEEP machine clean and in good working order. KEEP all blades and tool bits sharp.

NEVER leave a machine running, unattended. Turn the power switch to the OFF position. DO NOT leave the machine until it has come to a complete stop.

REMOVE ALL MAINTENANCE TOOLS from the immediate area prior to turning the machine ON.

**WARNING!** STAY ALERT, watch what you are doing, and use common sense when operating any machine. DO NOT operate any machine tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.

**WARNING!** USE ONLY recommended accessories. Use of incorrect or improper accessories could cause serious injury to the operator and cause damage to the machine. If in doubt, DO NOT use it.

THE USE of extension cords is not recommended for 230V equipment. It is better to arrange the placement of your equipment and the installed wiring to eliminate the need for an extension cord. If an extension cord is necessary, refer to the chart in the Grounding Instructions section to determine the minimum gauge for the extension cord. The extension cord must also contain a ground wire and plug pin.

**CAUTION!** Wear proper clothing, DO NOT wear loose clothing, gloves, neckties, or jewelry. These items can get caught in the machine during operations and pull the operator into the moving parts. Users must wear a protective cover on their hair, if the hair is long, to prevent it from contacting any moving parts.

SAVE these instructions and refer to them frequently and use them to instruct other users.

**NOTE:** Information regarding the safe and proper operation of this tool is also available from the following sources:

Power Tool Institute  
1300 Summer Avenue  
Cleveland, OH 44115-2851  
[www.powertoolinstitute.org](http://www.powertoolinstitute.org)

American National Standards Institute  
23 West 43rd Street, 4th Floor  
New York, NY 10036  
[www.ansi.org](http://www.ansi.org)

National Safety Council  
1121 Spring Lake Drive  
Itasca, IL 60143-3201

ANSI 01.1 Safety Requirements for  
Woodworking Machines and the  
U.S. Department of Labor Relations  
[www.osha.gov](http://www.osha.gov)

# PRODUCT SAFETY

1. Serious personal injury may occur if normal safety precautions are overlooked or ignored. Accidents are frequently caused by lack of familiarity or failure to pay attention. Obtain advice from supervisor, instructor, or another qualified individual who is familiar with this machine and its operations.

Every work area is different. Always consider safety first, as it applies to your work area. Use this

2. machine with respect and caution. Failure to do so could result in serious personal injury and damage to the machine.

Prevent electrical shock. Follow all electrical and safety codes, including the National Electrical Code

3. (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only

**WARNING!** TO REDUCE the risk of electrical shock. DO NOT use this machine outdoors. DO NOT

4. expose to rain. Store indoors in a dry area.

STOP using this machine, if at any time you experience difficulties in performing any operation.

5. Contact your supervisor, instructor or machine service center immediately.

Safety decals are on this machine to warn and direct you to how to protector yourself or visitors from

6. personal injury. These decals MUST be maintained so that they are legible.

DO NOT leave the unit plugged into the electrical outlet. Unplug the unit from the outlet when not in

7. use and before servicing, performing maintenance tasks, or cleaning.

**WARNING!** DO NOT handle the plug or machine with wet hands

8. USE only accessories as described in this manual and recommended by WAHUDA.

9. DO NOT pull the jointer by the power cord. NEVER allow the power cord to come in contact with

10. sharp edges, hot surfaces, oil or grease.

ALWAYS turn the power switch "OFF" before unplugging the machine. DO NOT unplug the machine

11. by pulling on the power cord. ALWAYS grasp the plug, not the cord.

REPLACE a damaged cord immediately. DO NOT use a damaged cord or plug.

12. DO NOT use the machine as a toy. DO NOT use near or around children.

13. ENSURE that the machine sits firmly before using. If the machine wobbles or is unstable, correct the

14. problem by attaching to a bench top prior to operation.

This machine is designed to process wood ONLY.

15. INSPECT all stock before beginning operations ensuring that there are no foreign objects embedded

16. in the wood, loose knots, or knots that may become loose during operation.

**WARNING!** DO NOT attempt to remove jams until power is disconnected and all moving parts have

17. come to a complete stop.

## PRODUCT SAFETY (cont.)

18. MAKE SURE that there is adequate operating space before turning machine on.
19. DO NOT use “split” work stock
20. Always start at the lowest speed when starting a new task.
21. Check that the tool rest is at or slightly below the center line in the lathe before switching on the power
22. Rotate the work piece by hand to check that it is centralized, clear of the tool rest, that it is NOT split nor has loose knots.
23. Where lathes have the ability to be reversed, check that the machine will be rotating in the correct direction.
24. If your lathe has the facility to run in reverse, you MUST ensure that the mounting accessories, (chucks, faceplates, etc) can be locked onto the lathe mandrel. And in case of chucks, have some form of security device to prevent them from “unwinding” during reverse operation.
25. Make sure your tools are stored away from the turning area of the lathe. Do not reach over a rotating work piece at any time.
26. DO NOT “dig in” or try to take too large of cut.
27. DO NOT leave the lathe running unattended or leave the machine until it has stopped
28. Some turning tools may have specific sharpening angles that have been determined by the manufacturer. If re-sharpening, adhere to these angles to maximize the finish of your work.
29. If the work you are doing is liable to generate flying grit, dust or chips, wear the appropriate safety clothing, protective eye wear (Such as goggles or face mask).
30. If the work operation appears to be excessively noisy, wear hearing protection.
31. If you have long hair, wearing a cap, safety helmet, hairnet, or even a sweatband, will minimize the possibility of your hair being caught up in the rotating parts of the tool.
32. Snag hazards, such as rings, watches, etc, should also be removed.
33. Consideration to wearing non-slip footwear should be given.
34. DO NOT work with cutting tools of any description if you are tired, your attention is not focused, or you are being distracted. A deep cut, lost finger, or worse, is not worth it.
35. Carry out final tightness check on chuck, faceplate, work piece, tool rest, etc., and correct speed and direction have been selected.
36. ALWAYS USE COMMON SENSE when operating any machinery.

# GROUNDING INSTRUCTIONS

**WARNING!** This machine **MUST BE GROUNDED** while in use to protect the operator from electric shock. In the event of a malfunction or breakdown, **GROUNDING** provides the path of least resistance for electric current and reduces the risk of electric shock. The plug **MUST** be plugged into a matching electrical receptacle that is properly installed and grounded in accordance with **ALL** local codes and ordinances.

If a plug is provided with your machine **DO NOT** modify the plug. If it will not fit your electrical receptacle, have a qualified electrician install the proper connections to meet all electrical codes local and state. **ALL** connections must also adhere to **NEC** and **OSHA** mandates.

**WARNING!** **IMPROPER ELECTRICAL CONNECTION** of the equipment-grounding conductor can result in risk of electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment-grounding conductor. **DO NOT** connect the equipment-grounding conductor to a live terminal if repair or replacement of the electric cord or plug is necessary.

Check with a qualified electrician or service personnel if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

**WARNING!** Electrocutation or fire could result if this machine is not grounded properly or if the electrical configuration does not comply with local and state electrical codes.

**MAKE CERTAIN** the machine is disconnected from power source before starting any electrical work. **MAKE SURE** the circuit breaker does not exceed the rating of the plug and receptacle.

The motor supplied with your machine is a 115 volt, 60 hertz, single phase motor. Never connect the green or ground wire to a live terminal. A machine with a 115 volt plug should only be connected to an outlet having the same configuration as the plug.

**WARNING!** To reduce the risk of fire or electrical shock, use the proper gauge of extension cord. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw.

The smaller the gauge-number, the larger the diameter of the extension cord is. If in doubt of the proper size of an extension cord, use a shorter and thicker cord. An undersized cord will cause a drop in line voltage resulting in a loss of power and overheating.

**CAUTION!** **USE ONLY** a 3-wire extension cord that has a 3-prong grounding plug and a 3-pole receptacle that accepts the machine's plug. If you are using an extension cord outdoors, be sure it is marked with the suffix "W-A" ("W" in Canada) to indicate that it is acceptable for outdoor use.

## GROUNDING INSTRUCTIONS (cont.)

Make certain the extension cord is properly sized, and in good electrical condition. Always replace a worn or damaged extension cord immediately or have it repaired by a qualified person before using it.

Protect your extension cords from sharp objects, excessive heat, and damp or wet areas.

MINIMUM RECOMMENDED GAUGE FOR EXTENSION CORDS (AWG)				
115 VOLT OPERATION ONLY				
	25' LONG	50' LONG	100' LONG	150' LONG
0 to 6 Amps	18 AWG	16 AWG	16 AWG	14 AWG
6 to 10 Amps	18 AWG	18 AWG	14 AWG	12 AWG
10 to 12 Amps	16 AWG	16 AWG	14 AWG	12 AWG

## UNPACKING & INVENTORY

Check shipping carton and machine for damage before unpacking. Carefully remove packaging materials, parts and machine from shipping carton. Always check for and remove protective shipping materials around motors and moving parts. Lay out all parts on a clean work surface.

Please keep all packaging materials until the machine is properly running and all items have been accounted for. Also, please dispose of all packaging materials responsibly.

Any visible protective coatings, on metal surfaces only, can be removed by spraying WD-40 on a soft cloth and wiping the surfaces.

Apply a light coat of good quality paste wax over the lathe bed to allow the banjo and tailstock to glide smoothly across the bed and to prevent corrosion. Make sure to buff out the wax before assembly.

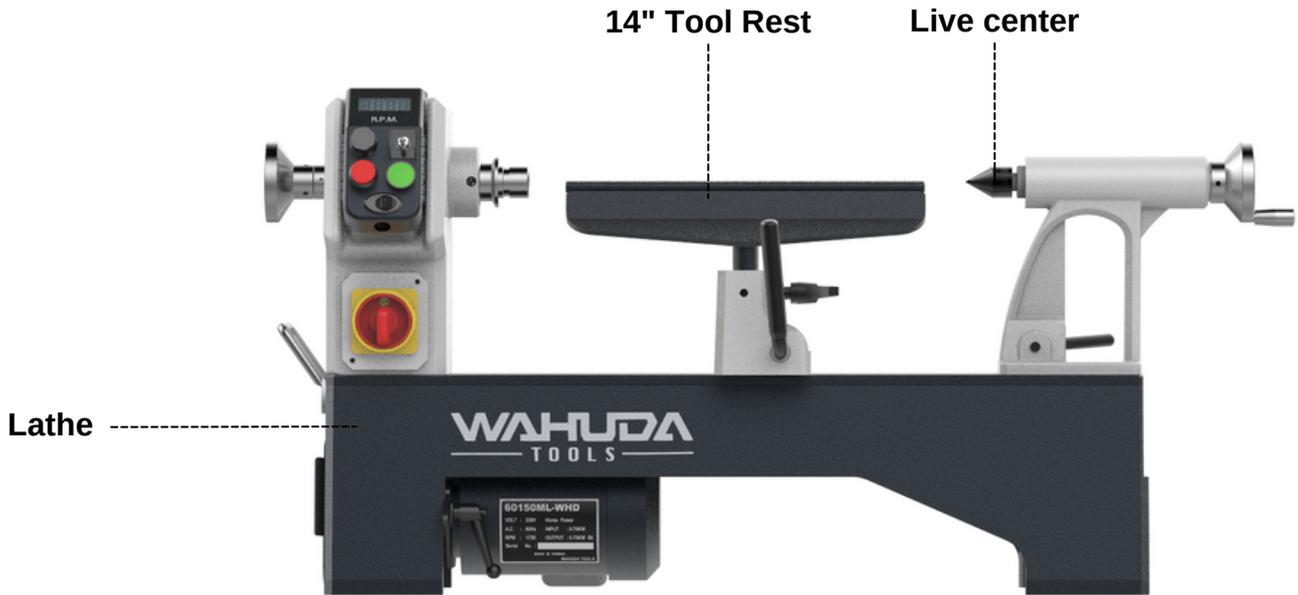
**NOTE: Some parts pictured may already be installed on your machine at the factory.**

Go through the entire manual before contacting WAHUDA.

Compare the items to inventory figures and verify that all items are accounted for. If any parts are missing, do not attempt to power on the machine.

**For missing parts, or shipping damage, contact WAHUDA at [techservices@wahudatools.com](mailto:techservices@wahudatools.com) or call 877-568-8879.**

# IN THE BOX



Face plate



Drive Center



Face Plate Lock Pin



Magnetic Index pin

(Can be stored on machine ,out of the way of moving parts)

Push Rod



Spanner Wrench



Carrying handle

(4ea 3/8"-16UNCx2" Screws for carrying handles pre-installed on lathe)

Hex Head Fasteners  
4ea 3/8"-16UNCx2"



Foot pad



4 mm allen key



3 mm allen key



2 mm allen key

# ASSEMBLY

**WARNING!** MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE BEFORE ASSEMBLY AND ADJUSTMENTS

**NOTE:** 95% of the machine comes fully assembled. If you need help assembling the remaining 5%, use the parts diagram and parts list at the back of this manual for assistance.

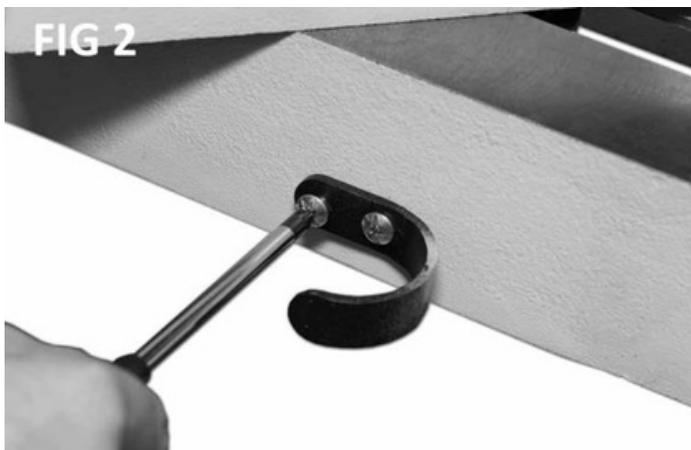
## CARRYING HANDLES

1. Locate the 1 carrying handle (Seen on Page 13 ) and 4 pre-installed screws to the right end of the lathe. See FIG 1 ( The left carrying handle locate is pre-installed to the left end of the lathe )



## POWER CABLE HOOKS

1. The 2 power cable hooks and 4 screws are pre-installed in the rear of the bed. See FIG 2 & 3



# ASSEMBLY & ADJUSTMENTS (cont.)

## FASTENING LATHE TO SUPPORTING SURFACE

If during operation there is any tendency for the lathe to tip over, slide, or walk on the supporting surface, the base of the lathe must be secured to the supporting surface with 4ea fasteners (See page 13) through the four threaded holes (3/8"x16 UNC) located in the feet of the lathe bed.

## ELECTRONIC INVERTER CONTROL UNIT

The electronic Variable Frequency Drive (VFD) inverter control, located on the rear of the machine, provides constant torque throughout the speed range of the machine. It has been adjusted and calibrated at the factory and should never need any adjustments. If adjustment is ever necessary, it **MUST** be done by a certified electrician. SEE FIG 4

**FIG 4**



# OPERATIONS

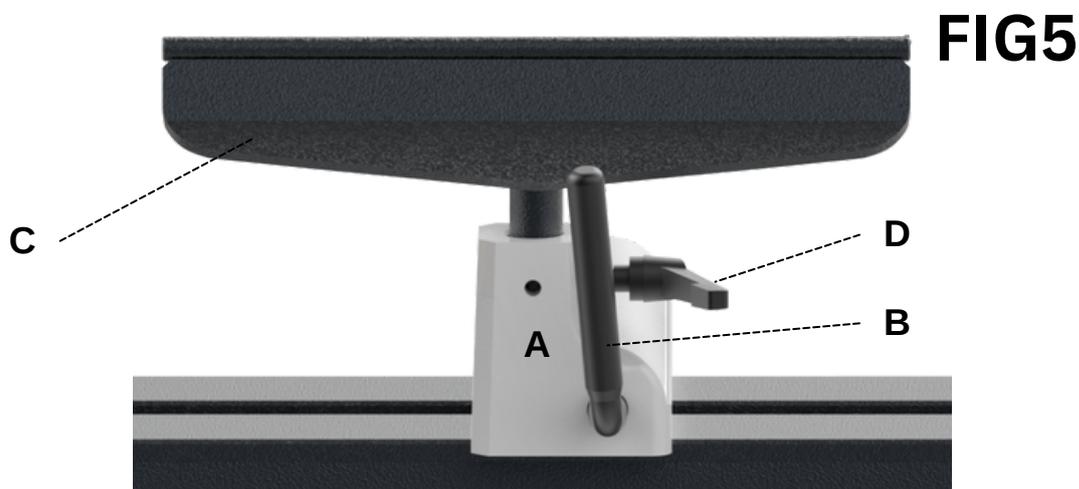
**NOTE:** This operations section was designed to give instructions on the basic operations of this planer. However, it is in no way comprehensive of every planer operation. It is strongly recommended that you read books, trade magazines, or get formal training to maximize the potential of your planer while minimizing the risks.

## ADJUSTING THE TOOL REST

The tool rest should be positioned as close as possible to the workpiece. It should be 1/8" below the centerline of the workpiece. Rotate the workpiece by hand to make certain you have proper clearance.

**WARNING!** MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

1. Position the banjo (A) on the bed by loosening the banjo lock handle (B) and sliding the banjo to the desired position. Tighten handle (B) to lock in place. SEE FIG 5
2. Adjust the height of the tool rest (C) by loosening the tool rest lock handle (D) and raising or lowering the tool rest. Tighten handle (D) to lock in place. SEE FIG 5



## ADJUSTING BANJO / TAILSTOCK CLAMPING PRESSURE

The clamping device on the banjo and tailstock are set at the factory and should not need adjustment. However, if adjustment is necessary, see instructions below.

1. Loosen clamping handle and slide the tailstock or banjo off the end of the bed. Tighten or loosen the nut beneath the tailstock or banjo and reinstall on bed. Test clamping pressure and repeat if necessary.

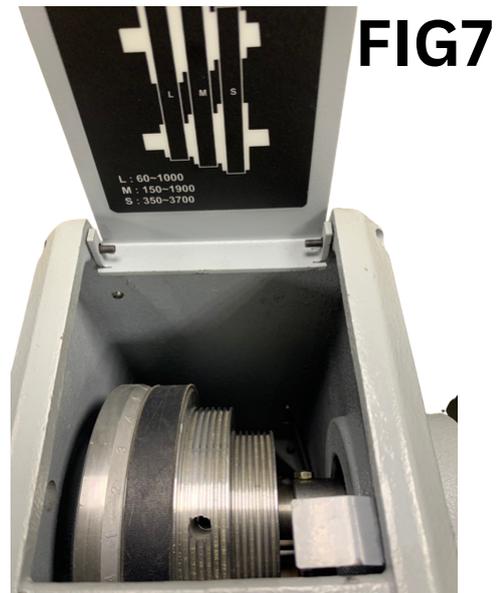
# OPERATIONS (cont.)

## CHANGING BELT SPEEDS

**WARNING!** MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

NOTE: The lowest speed pulley combination is furthest from the faceplate, i.e. smallest motor pulley diameter to largest spindle pulley diameter.

1. Open the magnetic access panel on the headstock . SEE FIG 6 & 7



2. To expose the motor pulleys, open the motor access door by grasping the knob and pulling it outwards. SEE FIG 8 & 9

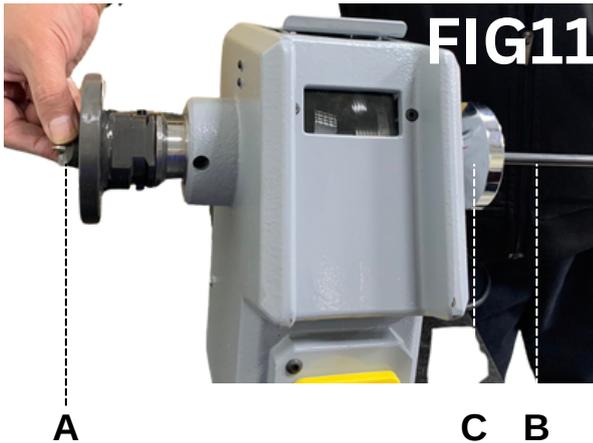


# OPERATIONS (cont.)

**WARNING! MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.**

## REMOVING AND INSTALLING THE DRIVE CENTER

1. To remove the drive center (A) locate the push rod (B) While holding the drive center, insert the push rod through the center hole of the headstock wheel (C) and push the drive center out. A light tap with a rubber mallet may be used. SEE FIG 11 & 12



2. To re-insert the drive center, place it in the hole in the faceplate, and while using a block of wood and a hammer, tap the drive center to “set” it in the headstock.

## REMOVING AND INSTALLING THE LIVE CENTER

1. To remove the live center (A) from the tailstock, insert the push rod through the hole in the tailstock wheel (B), and while holding the live center, push the live center out. A light tap with a rubber mallet may be used.
2. To re-install the live center, place it back in the hole, and while using a block of wood and a hammer, tap the live center to “set” it in the tailstock. SEE FIG 13

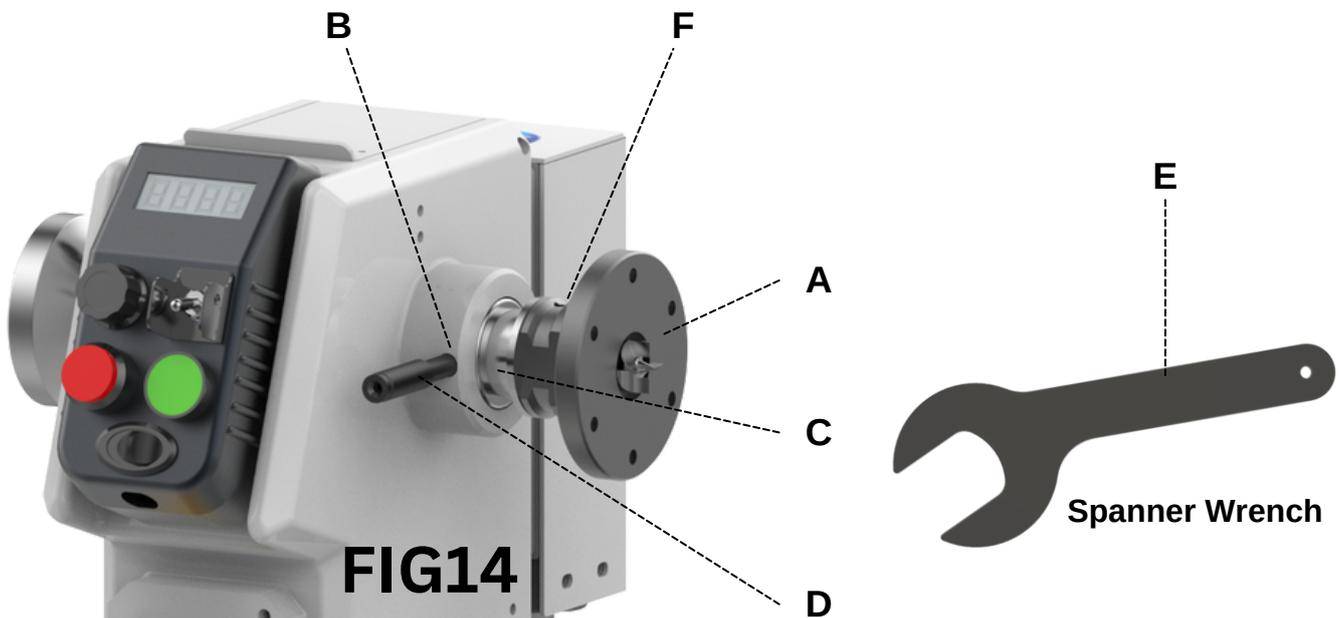


# OPERATIONS (cont.)

**WARNING!** MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

## REMOVING AND INSTALLING THE HEADSTOCK FACEPLATE

1. With the drive center already removed, (See instructions previous page) rotate the faceplate (A) until the machined hole in the shaft, as seen through the access hole (B) in the spindle lines up with the spindle (C). SEE FIG 14
2. Locate the Faceplate locking pin(D)
3. Using a hex wrench(E). loosen the two set screws (F) on the faceplate bosses.
4. While place a wrench over the faceplate bosses and turn counter-clockwise to remove the faceplate. SEE FIG 14
5. To re-install the faceplate, go through the instructions above in reverse order turning the faceplate clockwise to tighten.



# OPERATIONS (cont.)

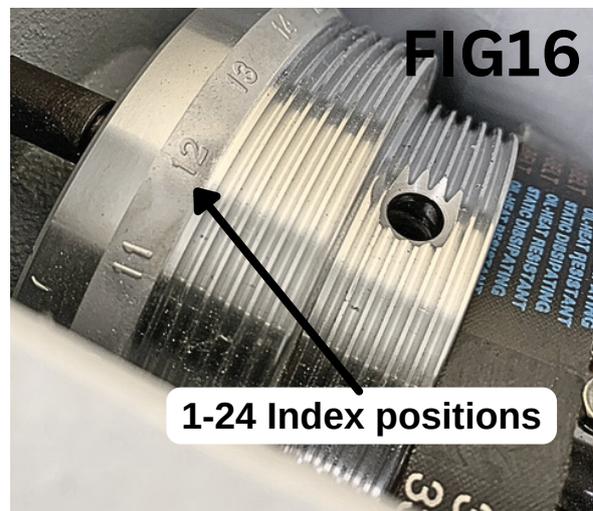
**WARNING! MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.**

## INDEXING OPERATION

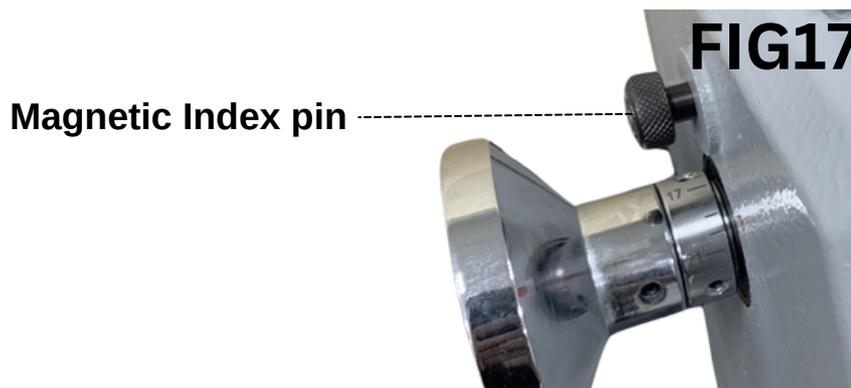
The indexing operation is useful for fluted columns, clock faces, and accurate hole positioning. The index pulley has 24 positions (15 degree) , when using the supplied magnetic index pin (See page 13 )

Open the access panel (FIG 6 & 7 page 17) Turn the headstock until the pre-drilled hole in the

1. headstock (A) lines up with one of the 24 pre-drilled hole positions on the index pulley. SEE FIG 15 & 16



2. Locate the magnetic indexing pin ( Seen on page 13) and insert the pin into the pre-drilled hole to lock the pulley to the desired position. SEE FIG 17
3. When indexing operations are completed, simply remove the magnetic indexing pin and store on the machine in a location where it can not cause any interference with operation.



# MAINTENANCE

**WARNING!** MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE BEFORE PERFORMING ANY MAINTENANCE PROCEDURES

## DAILY AFTER USE

Clean shavings away from the lathe bed and tool rest, etc.

## MONTHLY

Check the belt tension and adjust if necessary. See pages 17 and 18 for instructions.

Check for any build-up of wood shavings on the motor and pulleys and clean if necessary

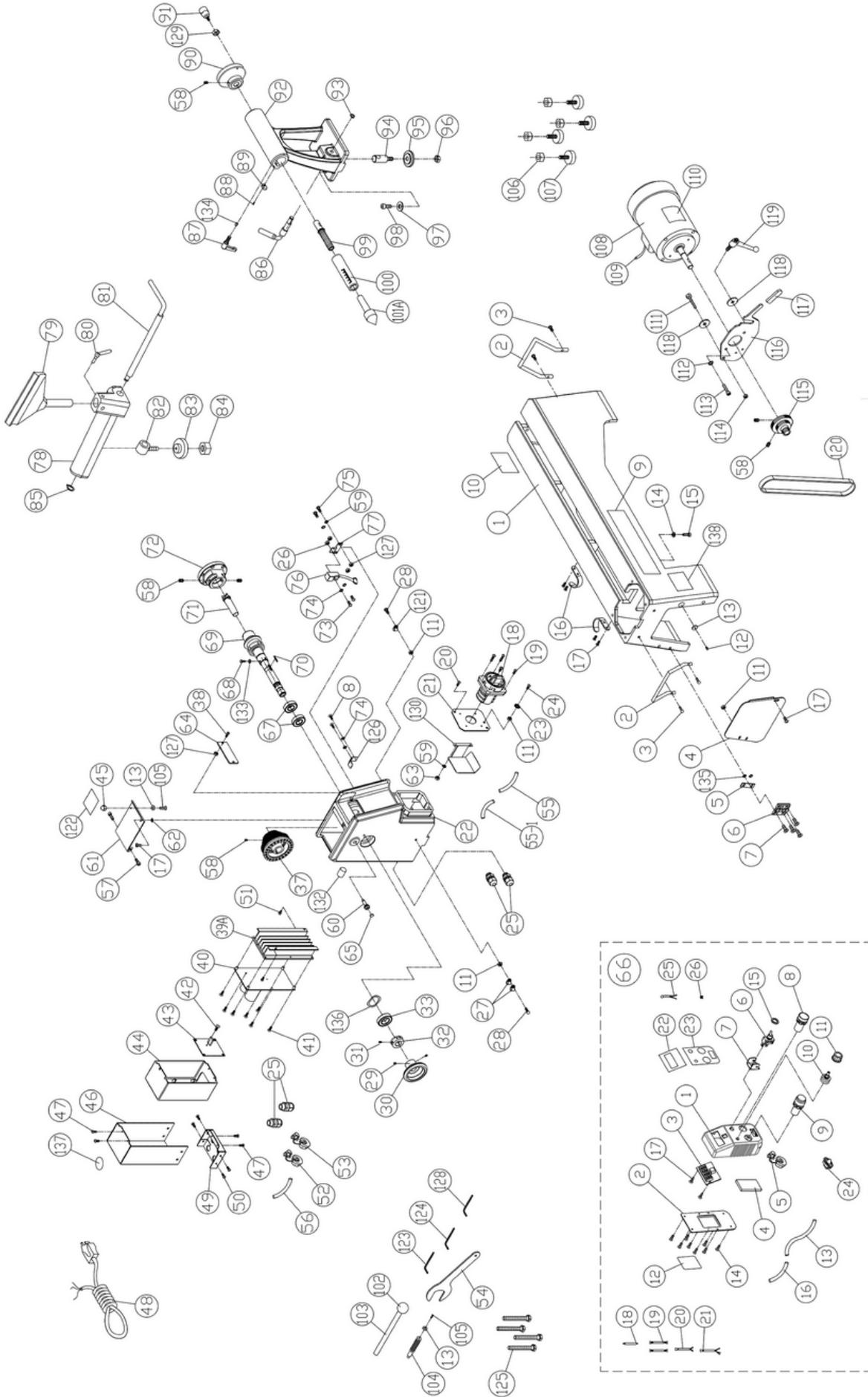
Using compressed air, lightly blow out the motor vents.

If the lathe will not be used for an extended period of time, place a light coat of wax over the bed and place a dust cloth over the lathe.

# TROUBLESHOOTING GUIDE

PROBLEM	LIKELY CAUSE	SOLUTION
Motor will not start.	Not plugged in. Blown circuit. Improper Voltage. Unit not turned on. Belt too tight	Check the power source. Replace fuse, reset breaker, or call electrician. Switch unit on. Adjust belt tension
Fuses or circuit breaker blows.	Short circuit in line cord or plug. Unit overloaded.	Call electrician to repair or replace cord or plug for damaged insulation and shorted wires. Reduce load. Operate on circuit separate from other appliances or motors or connect to circuit with adequate amp rating.
Motor fails to develop full power	Power supply circuit overloaded with lights, appliances, and other motors. Undersized or too long extension cord.	Reduce load on circuit. Increase wire sizes or reduce length of the circuit.
Motor overheats.	Motor overloaded during operation. Air circulation through the motor restricted.	Reduce load on motor; take lighter cuts. Clean out motor to provide normal air circulation.
Motor stalls or shuts off during a cut.	Motor overloaded during operation. Short circuit in motor or loose connections. Circuit breaker tripped.	Reduce load on motor; take lighter cuts. Call electrician to repair or replace connections on motor for loose or shorted terminals or worn insulation. Install correct circuit breaker; reduce number of machines running on that circuit (circuit overload)
Work piece slows when cutting or makes a squealing noise on start-up.	Belt worn out.	Replace Belt
Vibration when in operation	Not secured to work surface Damaged belt. Worn bearing.	Bolt machine to work bench Replace belt Check/replace bearing.

# PARTS



# PART LIST

PART NO.	DESCRIPTION	SPECIFICATION	QTY
60150-1	Bed		1
60150-2	Handle		2
60150-3	Round Head Screw	M6x16	4
60150-4	Bed Plate		1
60150-5	Plate		1
60150-6	Hinge		1
60150-7	Flat Haed Screw	M5x10	4
60150-8	Button Haed Screw	M3x16	2
60150-9	Label LOGO		1
60150-10	I.D Label		1
60150-11	Nut	M5	5
60150-12	Flat Head screw	M3x10	1
60150-13	Magnet		3
60150-14	Spring Washer	M6	4
60150-15	Cap Screw	M6x25	4
60150-16	Hook		2
60150-17	Screw	M5x10	6
60150-18	Power Switch (ON-OFF)		1
60150-19	Pan screw	M4x15	4
60150-20	Button Haed Screw	M5X12	2
60150-21	Power Switch Plate		1
60150-22	Head Stock		1
60150-23	External Tooth Washer	M5	1
60150-24	Pan screw	M5x10	1
60150-25	Strain relief	M16	4
60150-26	Nylon Nut	M3	2
60150-27	Cord Snap Ring	ACC-4	2
60150-28	Roun Cross Head Screw	M5x20	2
60150-29	Set Screw	1/4"x1/4"	3
60150-30	Handwheel		1
60150-31	Set screw	3/16"x1/4"	3
60150-32	Locking Nut		1
60150-33	Ball Bearing	6004LLB	1

# PART LIST

PART NO.	DESCRIPTION	SPECIFICATION	QTY
60150-37	Spindle Pulley		1
60150-38	Cap Screw	M4x20	2
60150-39A	Heat Sink		1
60150-40	PC Board		1
60150-41	Round Head Screw	M3x15mm	7
60150-42	Tapping Screw	M3x6	1
60150-43	Speed Display		1
60150-44	Control Box		1
60150-45	Hex domed cap nut	M3	1
60150-46	Control Box -UP		1
60150-47	Round Head Screw	M3x10mm	4
60150-48	Power Cable		1
60150-49	Control Box -Under		1
60150-50	Round Head Screw	M5x6	4
60150-51	Cap Screw	M5x10	2
60150-52	cord protector	SB5M-2	1
60150-53	cord protector	SR-6P3	1
60150-54	Face Plate Wrench		1
60150-55	Power short cable -A		1
60150-55-1	Power short cable -B		1
60150-56	Single wire		1
60150-57	Cap screw	M3x20	2
60150-58	Set screw	1/4-20*3/8	7
60150-59	Washer	M4	4
60150-60	Lock Pin		1
60150-61	Cover		1
60150-62	Push Nut	M5	1
60150-63	Nut	M4	2
60150-64	Acrylic plate		1
60150-65	Magent		1
60150-66	Control Box		1
60150-66-1	Control box-UP		1
60150-66-2	Control box-Under		1

# PART LIST

PART NO.	DESCRIPTION	SPECIFICATION	QTY
60150-66-3	Speed Display		1
60150-66-4	Magnet		1
60150-66-5	cord protector	SR-6P3	1
60150-66-6	Few/Rev switch		1
60150-66-7	Switch guard		1
60150-66-8	ON SWITCH		1
60150-66-9	OFF SWITCH		1
60150-66-10	VR Control		1
60150-66-11	VR knob		1
60150-66-12	Foam		1
60150-66-13	remote control line		1
60150-66-14	Tapping Screw	M3*14	8
60150-66-15	Safety Washer	M12	1
60150-66-16	Single wire		1
60150-66-17	Tapping Screw	M3*6	2
60150-66-18	wire 1		1
60150-66-19	wire 2		2
60150-66-20	wire 3		1
60150-66-21	wire 4		1
60150-66-22	Control box Lable		1
60150-66-23	Control box Lable		1
60150-66-24	Switch Fwd / Rev		1
60150-66-25	LED lamp		1
60150-66-26	led lamp holder		1
60150-67	Ball Bearing	6005LLB	2
60150-68	Hex head Screw	M4x8	4
60150-69	Spindle	1-1/4"-8TPI	1
60150-70	key	5*5*25	1
60150-71	Spur Center	MT2	1
60150-72	Face plate	1-1/4"-8TPI-ψ 95	1
60150-73	Socket Head Button Screw	M3x20	2
60150-74	Washer	M3-D8x1T	4
60150-75	Button Haed Screw	M4x15	2

# PART LIST

PART NO.	DESCRIPTION	SPECIFICATION	QTY
60150-76	Single wire		1
60150-77	Sensor shelf		1
60150-78	Tool Rest Carriage		1
60150-79	Tool Rest	14"	1
60150-80	Lock Handle	3/8"	1
60150-81	Tool Rest Eccentric Shaft		1
60150-82	Clamp bolt		1
60150-83	Clamp		1
60150-84	Nylon nut	3/4" *10unc	1
60150-85	C Ring	S-18	1
60150-86	Clamping Shaft		1
60150-87	Locking Handel	5/16"x20MM	1
60150-88	Socket Head Button Screw	#10-32UNF*5/8"	1
60150-89	Key		1
60150-90	Handwheel		1
60150-91	Handel		1
60150-92	Tailstock		1
60150-93	C-Ring	S-10	1
60150-94	Bolt		1
60150-95	Clamp		1
60150-96	Nut	M10*1.5P	1
60150-97	Cap screw	M6x10	1
60150-98	Flat Washer	M6-D13x1.5T	1
60150-99	Lead Screw		1
60150-100	Quill		1
60150-101A	Live center	MT2	1
60150-102	Shaft		1
60150-103	Knob		1
60150-104	Lock pin		1
60150-105	Flat Head Screw	M3x8	2
60150-106	Foot pad	3/8"	4
60150-107	Foot pad Nut	3/8"	4
60150-108	Motor	3/4HP	1

# PART LIST

PART NO.	DESCRIPTION	SPECIFICATION	QTY
60150-109	Motor wire		1
60150-110	Motor Lable		1
60150-111	Hex head Screw	M8x30	1
60150-112	Washer	1/4"	2
60150-113	Cap Screw	1/4"x5/8"	2
60150-114	Nylon Nut	M8	1
60150-115	Motor Pulley		1
60150-116	Motor plate		1
60150-117	Black handle protector		1
60150-118	Washer	5/16"- 3mm	2
60150-119	Locking Handel		1
60150-120	V-Belt	330J	1
60150-121	Wire clamp	ACC-1.5	1
60150-122	Speed Label		1
60150-123	Allen Key	3mm	1
60150-124	Allen Key	2mm	1
60150-125	Hex head Screw	3/8"-16UNCx2"	4
60150-126	Fixed piece		1
60150-127	Nylon Nut	M4	4
60150-128	Allen Key	4mm	1
60150-129	Nut	1/4"	1
60150-130	Cover plate		1
60150-132	Button plug	NB1419	1
60150-133	Spring Washer	M4	4
60150-134	Copper block		1
60150-135	Washer	M5	2
60150-136	Wave Washer	BWW6302	1
60150-137	Label		1
60150-138	Label		1