

FOR BEST RESULTS USE ONLY
RELS TOOL BITS.
MAINTENANCE SCHEDULE
204 Model RELS & Van Norman Lathes

Daily:

- Check the oil level. Adjust as necessary with 30 SAE motor oil.
- Add 3-5 drops of oil to the Vertical Shaft Assembly at “E” and “F” in figure 3 below.
- All adapters should be kept clean and free of nicks or burs. WD-40 works well as a cleaning medium as it both cleans and prevents rust.
- Keep the arbor free of any foreign material on every setup.
- Keep the surfaces in the slot where the tool bit holder mounts free of chips and burs. Also keep the bottom of the tool bit holder free of burs.
- All exposed machine surfaces of the lathe should be brushed clean and wiped with WD-40. **DO NOT BLOW THE MACHINE WITH COMPRESSED AIR.**

Monthly:

- Check all screws and fasteners
- Grease Timkin Bearing at “A” in figure 1a below with a good bearing grease.

Annually:

- Change the lubricant in the housing using 30 SAE motor oil.
- Fill to hole “C” from hole “D” in figure 2 below.
- Check oil in the Zero Max Speed Control Box. Box should be $\frac{3}{4}$ full. Add with 40 SAE grade oil at “B” in figure 1 below.
- Check the belts for wear and replace if necessary.

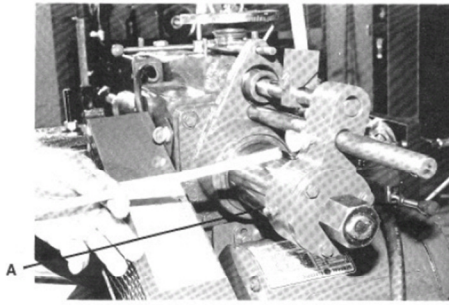


FIGURE 1A

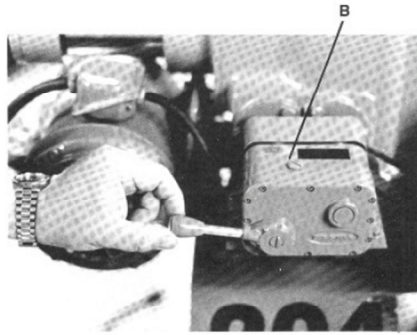


FIGURE 1

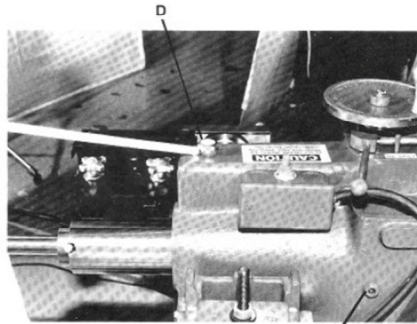


FIGURE 2

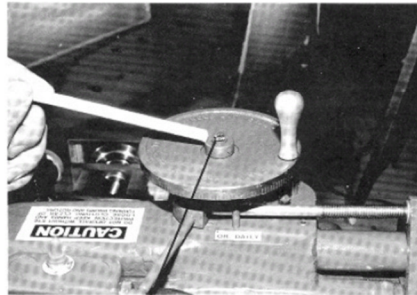


FIGURE 3

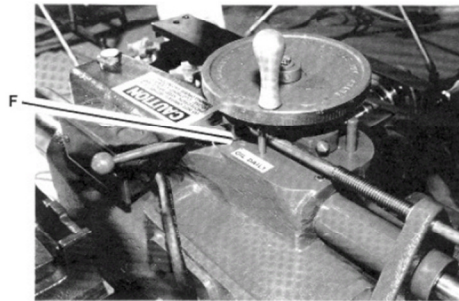


FIGURE 4