WOODFAST

WOOD LATHE WL1220A

Instruction Manual

IMPORTANT

For your safety, read instructions carefully before assembling or using this product. Save this manual for future reference.



HEALTH AND SAFETY GUIDELINES

Always follow the instructions provided with the manual. Always wear safety glasses when using woodworking equipment. Always disconnect the power before adjusting any equipment. Failure to observe proper safety procedures and guidelines can result in serious injury.

WARNING: Do not allow familiarity (gained from frequent use of your machine and accessories) to become commonplace. Always remember that a careless fraction of a second is sufficient to inflict severe injury.



Always wear safety glasses when using woodworking equipment.



Always read the instructions provided before using woodworking equipment.

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1. GENERAL INFORMATION

1.1 FOREWORD

Some information and illustrations in this manual may difer from the machine in your possession, since all the configurations inherent in the machine complete with all the optionals are described and illustrated. Therefore, refer only to that information strictly connected with the machine configuration you have purchased.

With this manual we would like to provide the necessary information for maintenance and proper use of the machine. The distribution network is at your service for any technical problem, spare parts or any new requirement you may have for the development of your activity.

This manual must be read and understood before operating the machine. This will provde a better working knowledge of the machine, for increased safety and to obtain the best results.

To facilitate its reading, the manual has been divided into sections pointing out the most important operations. For a quick research of the topics, it is recommended to consult the index. To better stress the importance of some basic passages, they have been marked by some preceding symbols:



Indicates imminent risks which may cause serious injury to the operator or other persons. Be careful and scrupulously follow the instructions.

A statement advising of the need to take care lest serious consequences result in harm to material items such as the asset or the product.

1.2 MACHINE IDENTIFICATION

There is a identification plate fixed to the machine, containing the manufacturer's data, year of construction, serial number and technical specifications.

1.3 CUSTOMER SERVICE RECOMMENDATIONS

Apply the machine to skilled and authorized technical staff to carry out any operation dealing with parts disassembly. Keep to the instructions contained in this manual for the correct use of the machine.



2. SAFETY PRECAUTIONS

2.1 SAFETY REGULATIONS



ING Read carefully the operation and maintenance manual before starting, using, servicing and carrying out any other operation on the machine.

The manufacturer disclaims all responsibilities for damages to persons or things, which might be caused by any failure to comply with the safety regulations.

- The machine operator shall have all necessary prerequisites in oder to operate a complex machiery.
- It is prohibited to use the machine when under the influence of alcohol, drugs or medication.
- All the operators must be suitably trained for use, adjustment and operation of the machine.

- The operators must carefully read the manual paying particular attention to the warning and safety notes. Furthermore, they must be informed on the dangers associated with use of the machine and the precautions to be taken, and must be instructed to periodically inspect the guards and safety devices.

- Before carrying out adjustment, repair or cleaning work, disconnect the machine from the electric power by setting the main switch to stop.

- After an initial bedding-in period or many hours of operation, the driving belts may slacken; this causes an increase in the tool stopping time (the stopping time must be less than 10 seconds). Immediately tighten them.

- The working area around the machine must be kept always clean and clear, in order to have an immediate and easy access to the switchboard.

- Never insert materials which are different from those which are prescribed for the machine utilization. The material to be machined must not contain any metal parts.

- Never machine pieces which may be too small or too wide ithrespect to the machine capacity.

- Do not work wood which has evident defects (cracks, knots, metal parts, etc.)
- Never place hands among the moving parts and/or materials.
- Keep hands clear from the tool; feed the piece with the aid of a pusher.
- Keep the tools tidy and far away from those not authorized persons.
- Never employ cracked nor uckled, neither not correctlyreground tools.
- Never use the tools beyond the speed limit recommended bythe producers.

- Carefully clean the rest surfaces of tools and make surethat they find perfectly horizontally positioned, and with no dents at all.

- Always wear gauntlets when handling the tools.

- Mount the tools in the right machining direction.
- Never start the machine before having correctly installed all the protections.

- Connect the dust suction hoods to an adequate suction system; suction must always be activated when the machine is switched on.

- Never open doors or protections when the machine or the system is operating.

- Many unpleasant experiences have shown that anybody may wear objects which could cause serious accidents.

Therefore, before starting working, take any bracelet, watch or ring off.

- Button the working garment sleeve well around the wrists.

- Take any garment off which, by hanging out, may get tangled in the MOVING UNITS.

- Always wear strong working footwear, as prescribed by the accident-prevention regulations of all countries.

- Use protection glasses. Use appropriate hearing protection systems (headsets, earplugs, etc.) and dust protection masks.

- Never let unauthorized people repair, service or operate the machine.

- The manufacturer is not responsible for any damage deriving from arbitrary modifications made to the machine.

- Any transport, assembly and dismantling is to be made only by trained staff, who shall have specific skill for the specified operation.

- The operator must never leave the machine unattended during operation.

- During any working cycle break, switch the machine off.

- In case of long working cycle breaks, disconnect the general power supply.

2.2 RESIDUAL RISKS

Despite observance of all the safety regulations, and use according to the rules described in this manual, residual risks may still be present, among which the most recurring are:

- contact with tool
- contact with moving parts (belts, pulleys, etc..)
- recoil of the piece or part of it
- accidents due to wood splinters or fragments
- tool insert ejection
- electrocution from contact with live parts
- danger due to incorrect tool installation
- inverse tool rotation due to incorrect electrical connection
- danger due to dust inhalation in case of working without vacuum cleaner.

Bear in mind that the use of any machine tool carries risks. Use the appropriate care and concentration for any type of machining (also the most simple).

The highest safety is in your hands.

2.3 SAFETY AND INFORMATION SIGNALS

This signals may be applied on the machine; in some cases they indicate possible danger conditions, in others they serve as indication.

Always take the utmost care.

SAFETY SIGNALS:



Risk of eye injury. Wear eye protection.



Danger of electric shock. Do not access the area when the machine is powered.



Carefully read and understand the manual before using the machine.

INFORMATION SIGNALS:

Indicate the technical characteristics, direction of rotation and inclination, block and release, etc. Carefully following the directions to simply the use and adjustment of the machine. The signals are graphically described and do not require further explanation.

3. SPECIFICATIONS

3.1 MAIN COMPONENTS



- 1. Tailstock Locking Lever
- 2. Tailstock Hand Wheel
- 3. Tailstock Assembly
- 4. Tailstock Locking Handle
- 5. Live Center
- 6. Spindle Hand Wheel
- 7. Headstock

- 8. Face Plate
- 9. Spur Center
- 10. Tool Rest Base
- 11. Tool Rest 12. Lathe Bed
- 12. Laure Deu
- 13. Tool Rest Locking Level 14. Electronic Controls

3.2 TECHNICAL SPECIFICATION

Volts. Hertz	2301//50H7
Amps	
Motor Power	
Swing over Bed	
Distance between Centers	
Spindle Speeds	
Spindle Taper	MT30X3.5
Tailstock Ram Travel	
Number of Indexing Positions	

3.3 ELECTRICAL CONNECTION

- Electrical installation should be carried out by competent, qualified personnel.

- The mains connection should be made using the terminal box.

- Replacement of the power supply cable should only be done by a qualified electrician.



To avoid electrocution or fire, any maintenance or repair to electrical system should be done only by qualified electricians using genuine replacement parts.



3.4 NOISE LEVEL

	No load	Load
Sound Pressure Level	< 80dB(A)	< 90dB(A)
Sound Power Level	< 90dB(A)	< 100dB(A)

The noise levels measured are emission levels and not necessarily the safe working level. Although there is a correlation between the emission levels and the exposure levels, this cannot be used reliably to determine whether or not further precautions are required. The factors which affect the actual level of operator exposure include the duration of exposure, the ambient characteristics and other sources of emission, for example, the number of machines and other adjacent machining. The permitted exposure values may also vary from country to country. Nevertheless, this information allows the user of the machine to better evaluate the dangers and risks.

Other factors which reduce exposure to noise are:

- correct tool choice
- tool and machine maintenance
- use of hearing protection systems (e.g. headsets, earplugs,...)

WARNING Please use the hearing protection systems if the above mentioned noise levels exceed 95dB(A).

4. INSTALLATION

WARNING The machine must not be plugged in and the power switch must be in the OFF position untill installation is complete.

4.1 INSTALL TOOL REST AND BASE ON LATHE BED

- Remove the tailstock assembly by releasing the locking handle and sliding the assembly off the end of the lathe bed.

- Slide the tool rest base onto the lathe bed and reinstall the tailstock assembly.

- Loosen locking handle and insert tool rest into tool rest base, adjust height up or down and tighten locking handle.



Fig.4.1

4.2 SPINDLE LOCK

Indexing is a useful feature of the M320 lathe, allowing accurate pattern work on projects such as straight fluting, grooving, drilling, lay out and more.



The indexing system must only be WARNING used when the lathe is stationary and the power is turned off.



Please note: The indexing system must not be used as a method of holding the spindle while removing VARNING accessores such as face plates, chuck ets. Damage caused to the machine by doing so is not covered by the warranty.





4.3 ATTACHING SPUR CENTER ON THE HEADSTOCK

- Insert spur center, with a No.2 Morse Taper shank, into the headstock spindle.





4.4 KNOCKOUT BAR

- The knockout bar is used to remove the spur center from the headstock spindle. Insert knockout bar into hole at opposite side from spur center.





4.5 ATTACHING LIVE CENTER ON THE TAILSTOCK

- Insert the live center, with a No.2 Morse Taper shank into the tailstock spindle.

- To remove live center from the tailstock spindle, loosen locking handle and rotate the hand wheel counterclockwise to retract spindle into the body of the tailstock. The live center will be pushed out of the spindle.





4.6 INSTALL THE FACEPLATE TO THE HEADSTOCK

- Thread the faceplate clockwhise onto the headstock spindle. Next, tighten faceplate with supplied wrench.



4.7 INSTALL TOOL HOLDER ON THE LATHE BED

- Located the tool holder from the carton, and install it onto the lathe bed with two pan head screws.



4.8 SECURE LATHE TO A SOLID WORK SURFACE

- The lathe must be attached to a solid work surface or stand. Four mounting holes are easily accessible at the base of the lathe.





5. ADJUSTMENTS AND OPERATIONS

5.1 ADJUSTING THE TOOL REST

- The tool rest base can be easily moved along the lathe bed. Loosen locking lever counter clockwise, slide tool rest base to new position, and tighten locking lever clockwise.

- NOTE: Position the tool rest as close to the work piece as possible. It should be 1/8" above the centerline of the workpiece.

- To adjust clamping action of the tool rest base, remove base and adjust nut clockwise to tighten and counterclockwise to loosen.

5.2 ADJUSTING TAILSTOCK

- Loosen locking lever to move the tailstock along the lathe bed to desired position. Tighten lever.

- To adjust clamping action of the tailstock, remove it from lathe bed and adjust nut clockwise to tighten and counterclockwise to loosen.

- To adjust tailstock spindle in or out, loosen locking handle and turn handwheel. When the tailstock spindle is in a desired position, tighten locking handle.





Fig.5.2

5.3 CHANGING SPINDLE SPEEDS

- The lathe features a three step motor and spindle pulleys to provide variable spindle speeds. Open access cover to change spindle speeds.

- With access cover open, loosen locking handle. Raise lever to release tension on motor pulley and tighten locking handle. Check speed and belt position chart in the front of the headstock to determine spindle speed required. Adjust the belt to proper tension with the raise lever and tighten the locking handle.

- Turn the speed control dial clockwise, the spindle speed will be increased. Turn counter colckwise, the speed will be decrased.

- Turn off the lathe, place the directional switch to FWD, the spindel is turn in clockwise. Switch to REW, the spindle will turn in counter clockwise.



Fig.5.3

6. MAINTENANCE



Before cleaning or carrying out maintenance work, disconnect the machine from the power source (wall socket). Never use water or other liquids to clean the machine. Use a brush. Regular maintenance of the machine will prevent unnecessary problem.

- Keep the lathe bed casting clean and lubricated.
- Keep the outside of the machine clean to ensure accurate operation of all moving parts and prevent excessive wear.
- Keep the ventilation slots of the motor clean to prevent it from overheating.
- Remove all saw dust and chips from the lathe after each use.

7. TROUBLE SHOOTING



For your own safety, always turn off and uppug the machine before carrying out any troubleshooting.

Symptom	Possible Cause	Solution
Motor will not	Machine not plugged in	Plug the machine in
start	Low voltage	
	Loose connection	
Motor	Motor overloaded	Reduce load on motor
overheats	Air flow restricted on motor	Clean out motor to obtain normal air flow
Excessive	Bad motor	Have motor checked
motor noise	Pulley set screw loose	Tighten set screw
Motor will not	Circuit overloaded with lights or other tools	Decrease the load on the circuit
develop full	Circuit too long or undersized wires	Reduce the length of the wire or increase the wire
power or stalls	Voltage too low	size
	Circuit breakers do not have sufficient capacity	Have the voltage checked by an electrician
	Drive belt tension too high	Have a licensed electrician install proper size
	Use of extension cord	breaker
		Adjust belt tension
		Use heavier gauge extension cord or no extension
		cord
Machine bogs	Excessive deoth of cut	Decrease depth of cut
down during	Turning tools are dull	Sharpen turning tools
cutting		



Do not make adjustments while the lathe is running,Ensure the switch is off, power is disconnected and all moving parts have stopped before servicing. Failure to comply may result in serious injury.



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washar 6 34 Datain | washer WSH6GB93B 4 35 Headstoch | holder JL93010017-001S 1 36 Hinge shaft | ss pan head screw M6X12GB818B 2 37 Wave wash | ntersunk head screw M4X10GB819B 4 38 Bearing | nder head hex socket bolt M5X12GB70B 1 1 39 Retaining rin | -
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