GENERAL 25-200 Wood Lathe Variable Speed Instruction Manual

Contents

GENERAL

GENERAL 25-200 Wood Lathe Variable Speed

Product Information

Model	#25-200
Product Name	Variable Speed Maxi Lathe VS+
Features	• Quick lock control levers easily position tool rest. • Large 12″ inboard bowl turning capacity. • Stable cast-iron frame, head & tailstock to reduce chatter and vibration for smoother turning. • Maximum distance of 17 5/16″ between centers. • Quick release belt tension lever for faster, easier speed changes. • **Three variable speed ranges:** 300 to 900, 600 to 1800 & 1200 to 3600 rpm. • Digital spindle speed display. • 12″ tool rest with sturdy 1″ diameter support post. • Forward/reverse switch.
Specifications	• **Spindle Speed (Variable)**: 300 to 3600 RPM • **Swing Over Bed**: 12″ (304 mm) • **Swing Over Tool Rest:** 9 1/4″ (236 mm) • **Swing Over Side Bed**: 19 1/4″ (490 mm) • **Swing Over Side Tool Rest**: 16 5/8″ (424 mm) • **Distance Between Centers:** 17 5/16″ (440 mm) • **Spindle Thread:** 1″ (25.4 mm) – 8 TPI • **Tailstock Through Hole**: 3/8″ (10 mm) • **Morse Taper:** MT #2 • **Self Ejecting Travel**: 2 1/8″ (55 mm) • **Tool Rest**: 12″ (305 mm) • **Face Plate**: 3 1/8″ (80 mm) • **Motor**: M1 3/4 HP, 110 V, 8 A, 2500 RPM • **Weight**: 146 lbs (66.5 kg)

Product Usage Instructions

1. Ensure that you are in a well-lit, clean, and debris-free working area.
2. Do not operate the wood lathe when tired, distracted, or under the influence of drugs or alcohol.
3. Keep children and visitors at a safe distance from the wood lathe and do not allow them to operate it.
4. Childproof and tamper-proof your shop and all machinery to prevent unauthorized or unsupervised use.
5. Give your work your undivided attention to avoid any distractions that can lead to serious injury.
6. Work in a well-ventilated area and use a dust collector, as fine particulate dust can be hazardous to health. Wear appropriate eye, ear, and respiratory protection devices.
7. Avoid wearing loose clothing, gloves, jewelry, or any objects that can get caught in the wood lathe. Use

protective hair covering and non-slip footwear.

8. Remove any adjusting wrenches, tools, drinks, or clutter from the machine before operating.
9. Keep your hands away from the spindle, spinning workpiece, and all moving parts. Use a brush to clear away chips and dust, not your hands.
10. Inspect the stock for defects such as checks, splits, cracks, knots, or foreign objects before use.
11. Select the appropriate turning speed for the size and type of workpiece being turned. Start with the lowest speed when working on a new workpiece.
12. Ensure that the workpiece is securely installed between centers before turning on the wood lathe. Tighten down and secure all locking levers and moveable or removable parts.

GENERAL® INTERNATIONAL

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THANK YOU for choosing this Variable Speed Maxi Lathe VS+ model 25-200
by General® International. This unit has been carefully tested and inspected before shipment and if properly used and maintained, will provide you with years of reliable service. To ensure optimum performance and trouble-free operation, and to get the most from your investment, please take the time to read this manual before assembling, installing and operating the unit.
The manual's purpose is to familiarize you with the safe operation, basic function, and fea-tures of this unit as well as the set-up, maintenance and identification of its parts and compo-nents. This manual is not intended as a substitute for formal woodworking instruction, nor to offer the user instruction in the craft of woodworking. If you are not sure about the safety of performing a certain operation or procedure, do not proceed until you can confirm, from knowledgeable and qualified sources, that it is safe to do so.
Once you've read through these instructions, keep this manual handy for future reference.

GENERAL® INTERNATIONAL WARRANTY

All component parts of General® International products are carefully tested and inspected during all stages of production, and each product is thoroughly inspected upon completion of assembly. Because of our commit-ment to quality and customer satisfaction, General® International agrees to repair or replace, within a period of 24 months from date of purchase, any genuine part or parts which, upon examination, prove to be defective in workmanship or material. In order to obtain this warranty, all defective parts must be returned freight pre-paid to General® International Mfg. Co., Ltd. Repairs attempted without our written authorization will void this warranty.

Disclaimer: The information and specifications in this manual pertain to the unit as it was supplied from the factory at the time of printing. Because we are committed to making con-stant improvements, General® International reserves the right to make changes to components, parts or features of this unit as deemed necessary, without prior notice and without obligation to install any such changes on previously delivered units. Reasonable care is taken at the factory to ensure that the specifications and information in this manual corresponds with that of the unit with which it was supplied. However, special orders and "after factory" modifications may render some or all information in this manual inapplicable to your machine. Further, as several generations of this model of wood lathe and several versions of this manual may be in circulation, if you own an earlier or later version of this unit, this manual may not depict your tool exactly. If you have any doubts or questions contact your retailer or our support line with the model number of your unit for clarification.

RULES FOR SAFE OPERATION

To help ensure safe operation, please take a moment to learn the machine's applications and limitations, as well as potential hazards. General® International disclaims any real or implied warranty and holds itself harmless for any injury that may result from improper use of its equipment.

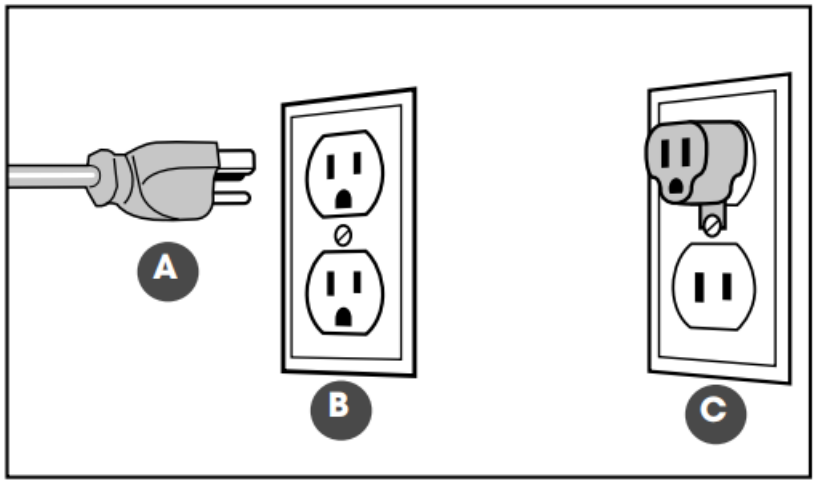
1. Do not operate the wood lathe when tired, distracted, or under the effects of drugs, alcohol or any medication that impairs reflexes or alertness.
2. The working area should be well lit, clean and free of debris.
3. Keep children and visitors at a safe distance when the wood lathe is in operation; do not permit them to operate the wood lathe.
4. Childproof and tamper proof your shop and all machinery with locks, master electrical switches and switch keys, to prevent unauthorized or unsupervised use.
5. Stay alert! Give your work your undivided atten- tion. Even a momentary distraction can lead to seri- ous injury.
6. Fine particulate dust is a carcinogen that can be hazardous to health. Work in a well-ventilated area and whenever possible use a dust collector and wear eye, ear and respiratory protection devices.
7. Do not wear loose clothing, gloves, bracelets, neck- laces or other jewelry while the wood lathe is in operation. Wear protective hair covering to contain long hair and wear non-slip footwear.
8. Be sure that adjusting wren ches, tools, drinks and other clutter are removed from the machine before operating.
9. Keep hands well away from the spindle, the spin ning workpiece, and all moving parts. Use a brush, not hands, to clear away chips and dust.
10. Do not use stock containing defects such as che- cks, splits, cracks, knots or foreign objects. Before starting, inspect stock and remove all foreign ob- jects such as dirt, nails, staples or any object that could damage a tool or become dislodged and fly free and cause injury.
11. Select appropriate turning speed for the size and type of workpiece being turned and use lowest speed when starting a new workpiece.
12. Before turning on the wood lathe, make sure the 12. Before turning on the wood lathe, make sure the able parts are tightened down and secured.
13. Adjust the cutting tool parallel and as close as pos- sible to the workpiece and, before starting the lathe, turn the workpiece by hand, at least one full rotation to make sure that it does not come in contact with the cutting tool.
14. Maintain turning tools with care. Keep turning tools sharp and clean for best and safest performance.
15. Avoid working from awkward or off balance posi- tions. Do not overreach and keep both feet on floor.
16. Keep guards in place and in working order. If a guard must be removed for maintenance or clea- ning be sure it is properly re-attached before using the tool again.
17. Use of parts and accessories NOT recommended by GENERAL® INTERNATIONAL may result in equip- ment malfunction or risk of injury.
18. Never stand on machinery. Serious injury could result if the tool is tipped over.
19. Always disconnect the tool from the power source before servicing, changing accessories, perfor- ming any maintenance or cleaning, or if the machine will be left unattended.
20. Make sure that switch is in the “OFF” position before plugging in the power cord.
21. Make sure the tool is properly grounded. If equip- ped with a 3-prong plug it should be used with a three-pole receptacle. Never remove the third prong.
22. Do not use this wood lathe for any purpose other than its intended use. If used for other purposes, GENERAL® INTERNATIONAL disclaims any real or implied warranty and holds itself harmless for any injury, which may result from that use.

ELECTRICAL REQUIREMENTS

BEFORE CONNECTING THE MACHINE TO THE POWER SOURCE, VERIFY THAT THE VOLTAGE OF YOUR

POWER SUPPLY CORRE-SPONDS WITH THE VOLTAGE SPECIFIED ON THE MOTOR I.D. NAMEPLATE. A POWER SOURCE WITH GREATER VOLTAGE THAN NEEDED CAN RESULT IN SERIOUS INJURY TO THE USER AS WELL AS DAMAGE TO THE MACHINE. IF IN DOUBT, CONTACT A QUALIFIED ELECTRICIAN BEFORE CONNECTING TO THE POWER SOURCE.
THIS TOOL IS FOR INDOOR USE ONLY. DO NOT EXPOSE TO RAIN OR USE IN WET OR DAMP LOCATIONS.

GROUNDING INSTRUCTIONS



- In the event of an electrical malfunction or short circuit, grounding reduces the risk of electric shock. The motor of this machine is wired for 110V single phase operation and is equipped with a 3-conductor cord and a 3-prong grounding plug A to fit a grounded type receptacle B.
- Do not remove the 3rd prong (grounding pin) to make it fit into an old 2-hole wall socket or extension cord. If an adaptor plug is used C, it must be attached to the metal screw of the receptacle.

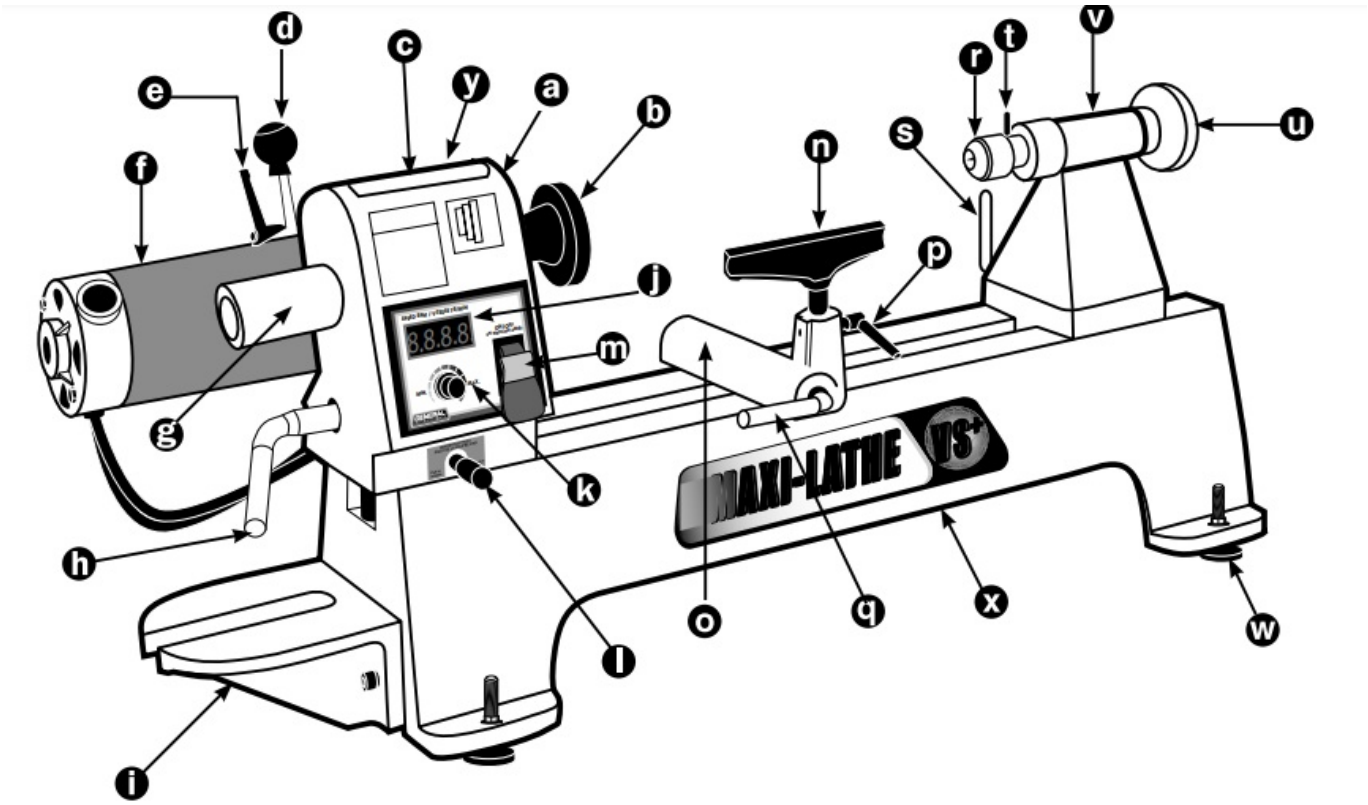
Note: The use of an adaptor plug is illegal in some areas. Check your local codes. If you have any doubts or if the supplied plug does not correspond to your electrical outlet, consult a qualified electrician before proceeding.

CIRCUIT CAPACITY
Make sure that the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.
If the circuit breaker trips or the fuse blows regularly, your machine may be operating on a circuit that is close to its amperage draw capacity. However, if an unusual amperage draw does not exist and a power failure still occurs, contact a qualified technician or our service department.

EXTENSION CORDS
If you find it necessary to use an extension cord with your machine, use only 3-wire extension cords that have 3-prong grounding plug and a matching 3-pole receptacle that accepts the tool’s plug. Repair or replace a dam-aged extension cord or plug immediately.
Make sure the cord rating is suitable for the amperage listed on the motor I.D. plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.
The accompanying chart shows the correct size extension cord to be used based on cord length and motor I.D. plate amp rating. If in doubt, use the next heavier gauge. The smaller the number, the heavier the gauge.

TABLE – MINIMUM GAUGE FOR CORD				
EXTENSION CORD LENGTH				
AMPERES	**50 feet**	**100 feet**	**200 feet**	**300 feet**
< 5	**18**	**16**	**16**	**14**
6 to 10	**18**	**16**	**14**	**12**
10 to 12	**16**	**16**	**14**	**12**
12 to 16	**14**	**12**	***NR**	***NR**
*NR = Not Recommended				

IDENTIFICATION OF MAIN PARTS AND COMPONENTS



- A- HEADSTOCK
- B FACE PLATE
- C BELT GUARD
- D BELT TENSION RELEASE LEVER
- E BELT TENSION LOCK LEVER
- F MOTOR
- G FLYWHEEL
- H HEADSTOCK LOCKING LEVER
- I OUTBOARD BED EXTENSION
- J SPINDLE SPEED READOUT
- K SPINDLE SPEED CONTROLLER
- L HEADSTOCK PIVOT PIN

- M ON/OFF SWITCH (KEY SWITCH)
- N TOOL REST
- O TOOL REST CARRIAGE
- P TOOL REST LOCKING LEVER
- Q TOOL REST CARRIAGE LEVER
- R LIVE CENTER
- S LIVE CENTER
- T TAILSTOCK LOCKING LEVER
- U TAILSTOCK QUILL LOCKING LEVER
- V QUILL MOVEMENT HANDWHEEL
- W TAILSTOCK
- X LEVELING FOOT
- Y LATHE BED FORWARD/REVERSE SWITCH (NOT SHOWN)

UNPACKING & SET UP

UNPACKING

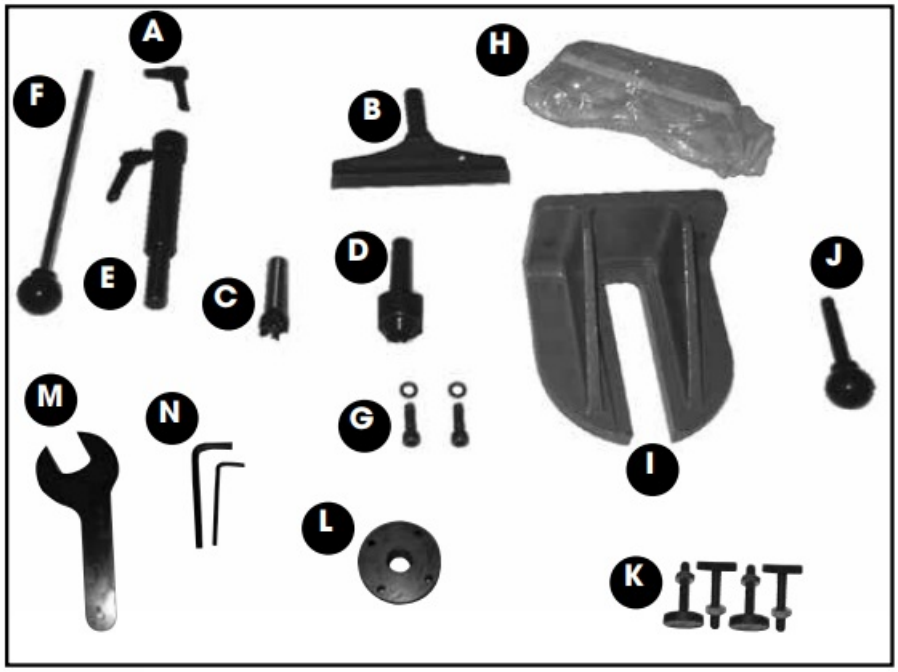
This model 25-200 is heavy – 146 lbs (66.5 kg). Do not over-exert. The help of an assistant will be needed for the following step.
Carefully unpack and remove the wood lathe and its components from the box and check for damaged or miss-ing items as per the list of contents below.

NOTE: Please report any damaged or missing items to your General International distributor immediately.

LIST OF CONTENTS

Once the parts have been removed from the packaging, you should have the following items

- A- TOOL REST LOCKING LEVER
- B- TOOL REST
- C- HEADSTOCK SPUR CENTER
- D- TAILSTOCK LIVE CENTER
- E- TOOL REST EXTENSION POST
- F- KNOCK OUT BAR
- G- OUTBOARD EXTENSION HARDWARE
- H- SAFETY GLASSES
- I- OUTBOARD BED EXTENSION
- J- BELT TENSION LEVER
- K- LEVELING FEET (with nuts)
- L- FACE PLATE
- M- FACE PLATE WRENCH
- N- ALLEN KEYS (3 MM AND 6 MM)
- O- LATHE WITH HEADSTOCK, TAILSTOCK AND TOOL REST CARRIAGE (NOT SHOWN)



CLEAN UP
Be sure to work in a well ventilated area for the clean-up process.

- The unpainted cast-iron surface of the lathe bed is covered with a protective coating that helps prevent rust from forming during shipping and storage. Remove this protective coating by rubbing with a rag dipped in kerosene, mineral spirits or paint thinner. (Handle and dispose of potentially flammable solvent soaked rags according to manufacturers' safety recommendations.)
- A putty knife held flat to avoid scratching the surface, may also be used to scrape off the coating followed by clean-up with solvent. Avoid rubbing the lathes painted surfaces as many solvent based products will remove paint.
- To prevent rust, apply a light coating of paste wax or use regular applications of any after-market surface protectant or rust inhibitor.

INSTALLATION & ASSEMBLY
For your convenience this lathe is shipped from the factory partially assembled and requires only minimal assembly and set-up before being put into service.

Before starting the assembly, make sure that the switch is in the "OFF" position and that the power cord is unplugged. Do not plug in or turn on the lathe until you have completed the assembly and installation steps described in this section of the manual.

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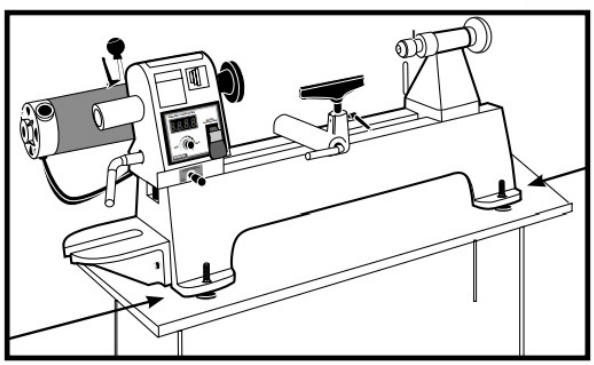
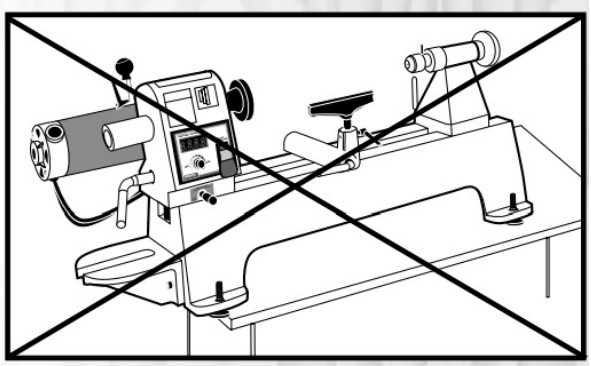
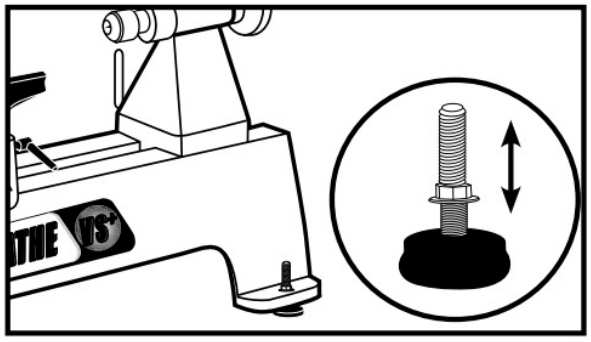
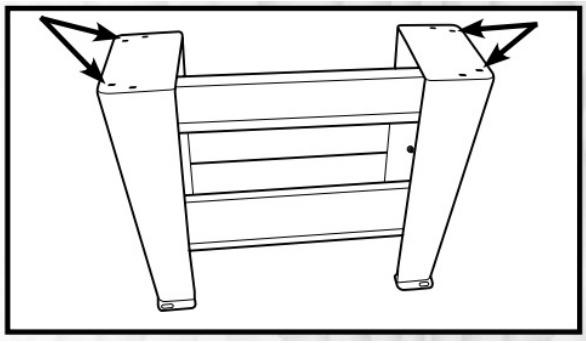




The unit should be installed on a flat, sturdy and stable surface able to support the weight of the machine and the workpiece with ease.

- Never install the machine over the edge of a table or workbench.

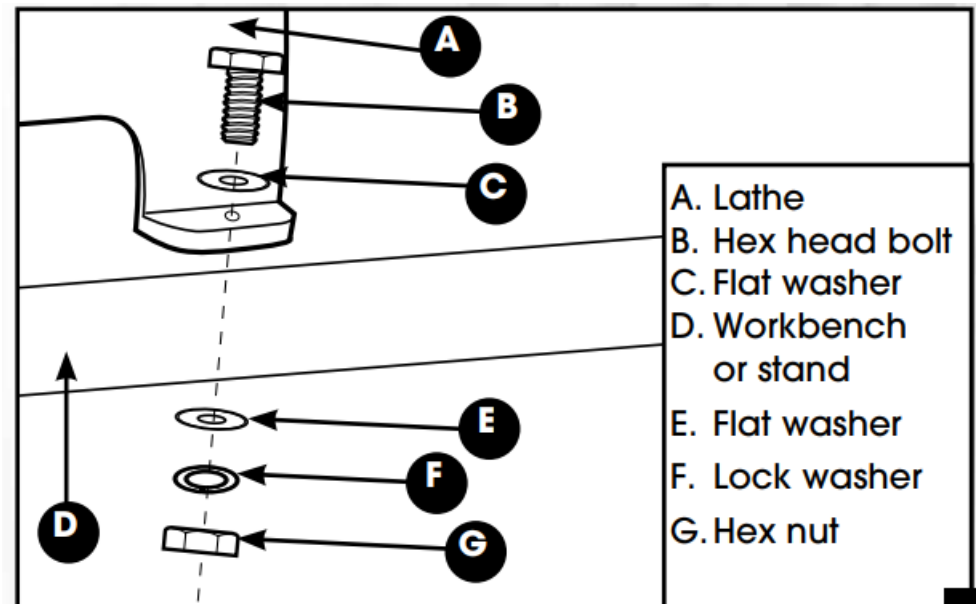




- Install the leveling feet and set the lathe on your workbench. Adjust the leveling feet to ensure that all four feet sit firmly on the bench. Make sure that the machine does not rock.
- If you prefer an optional steel stand (item 25-195N) is available from your local General International dealer. The stand is equipped with mounting holes allowing the lathe, after removing the level-ing feet, to be bolted directly to the stand.

For your safety it is essential that the machine does not rock or tip during operation. Upon start-up or during operation,

If a permanent shop placement is practical, consider removing the leveling feet on the base and drilling matching through-holes in the mounting surface of your workbench or stand to bolt the lathe in place (hardware not included) on your workbench. if you notice any rocking, tipping or chattering of the base turn the machine off immediately and re-adjust the leveling feet as needed to stabilize the lathe on the bench.



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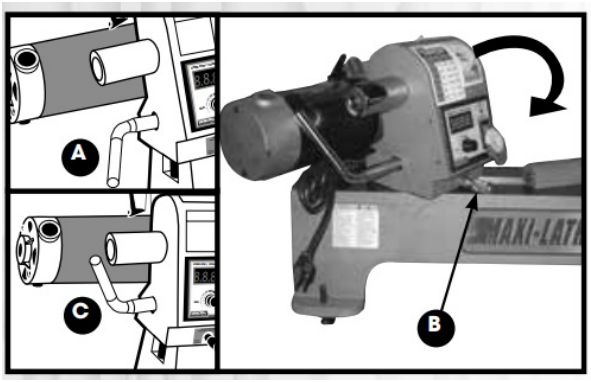
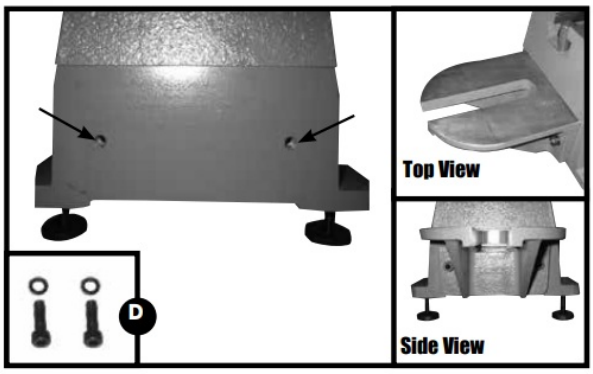
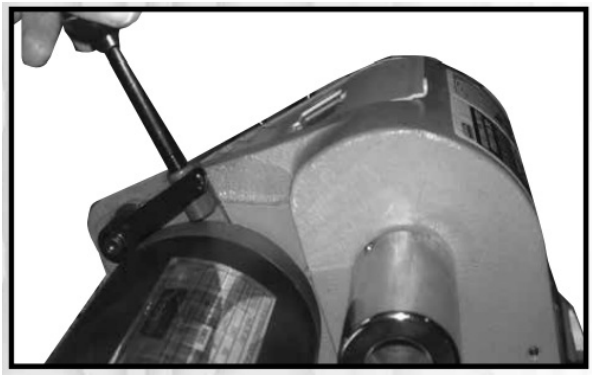
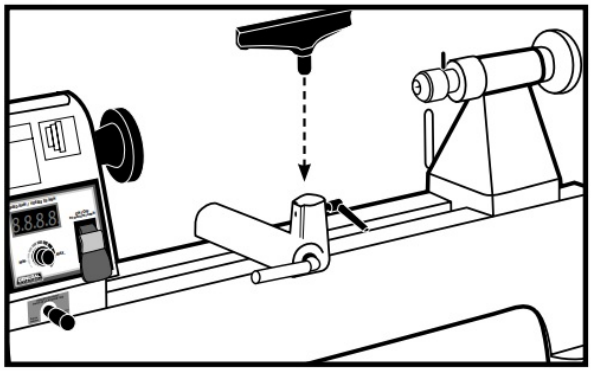




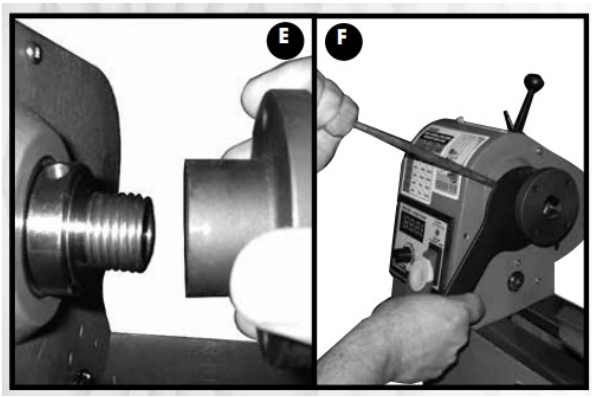
Release the headstock locking lever A and pull the headstock pivot pin B outwards and pivot the headstock 180º. Lock the headstock in place by pulling the headstock locking lever forward C.

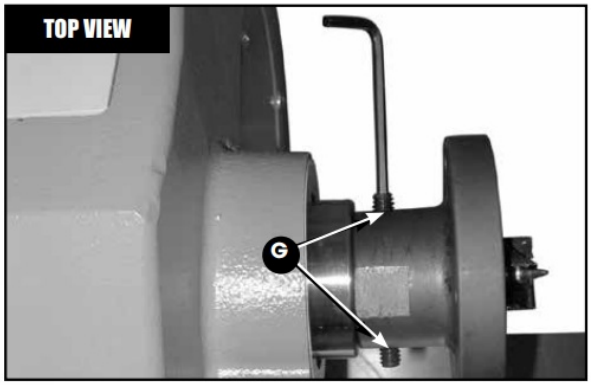
- Use the 2 mounting bolts and lock washers D to attach the outboard bed extension to the bed as shown.





- Install the belt tension release lever as shown.
- Install the tool rest on the tool rest carriage.





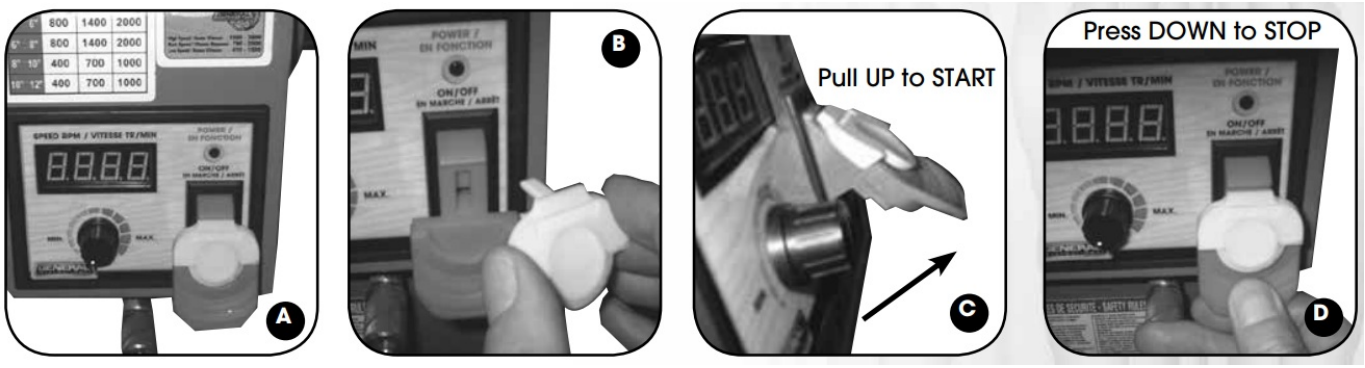
- Thread the face plate onto the headstock spin-dle E and tighten using the supplied face plate wrench (Insert the knock-out bar in the spindle hole F to keep the spindle from turning while tight-ening the face plate).
- Then lock the face plate by tightening the two set screws G using a 3 mm Allen key.

BASIC ADJUSTMENTS & CONTROLS

ON/OFF POWER SWITCH

The wood lathe is equipped with a rocker type ON/OFF switch located on the headstock A, that is equipped with a lock-out key.

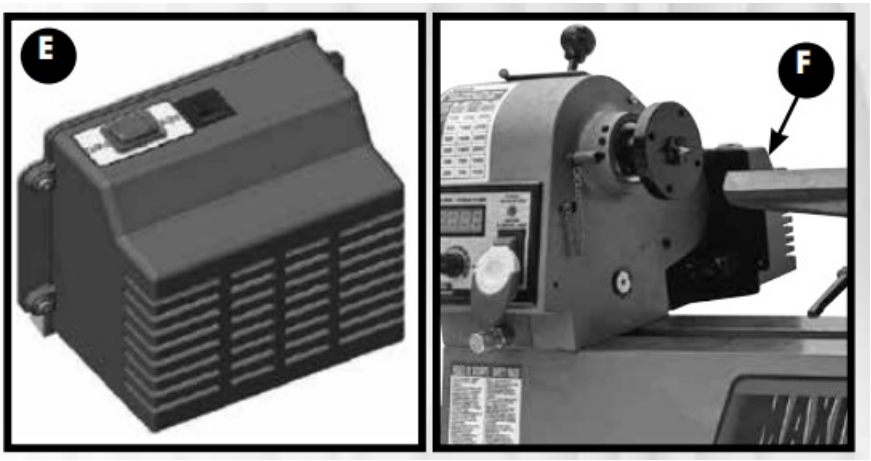
- To prevent unwanted or unauthorized start-up or usage remove the lock-out key and store it in a safe place B.
- To start the lathe, insert the lock-out key and pull up the switch C. To stop the lathe, push down on the power switch D.



FORWARD / REVERSE SWITCH

ALWAYS BE SURE TO STOP THE LATHE SPINDLE COMPLETELY BEFORE CHANGING DIRECTION. WHEN MOUNTING A FACE PLATE, ALWAYS MAKE SURE THE SET SCREWS IN THE FACE PLATE ARE TIGHTENED SECURELY AFTER THE FACE PLATE IS INSTALLED. FAILURE TO DO SO MAY RESULT IN THE FACE PLATE UNSCREWING FROM THE SPINDLE.

- The Forward/Reverse switch E is located on the rear of the headstock F.
- **Forward:** The spindle rotates toward to the operator from the top of the workpiece.
- **Reverse:** The spindle rotates backward to the operator from the top of the workpiece.



CHANGING SPINDLE SPEED

This model 25-200 MAXI-LATHE VS + is equipped with an electronic variable speed controller allowing the user to change the speed of the spindle (within the 3 different spindle speed ranges: 300-900, 600-1800 & 1200-3600 rpm) by simply turning the speed control dial. The digital spindle speed readout will indicate the operating spindle speed.

Note: Turning speeds vary depending on the size and diameter of the workpiece as well as which stage you are at in the overall turning process. When turning a smaller diameter workpiece, a higher spindle speed is

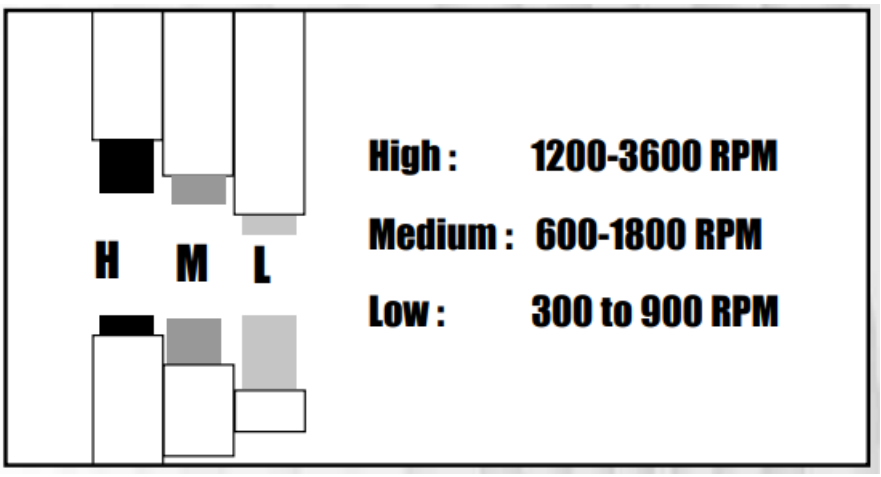
recommended. Proper spindle speed selection comes with practice and experience and when in doubt always start at a slower speed increasing when you are sure that it is safe to do so.

SPEED RECOMMENDATIONS

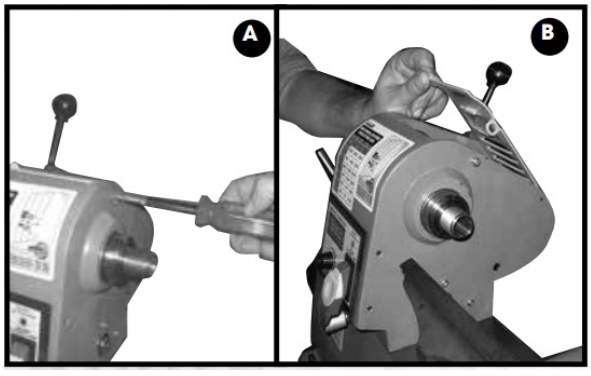
DIAMETER OF WORK	ROUGHING RPM	GENERAL CUTTING RPM	FINISHING RPM
UNDER 2”	1500	2650	3600
2 TO 4”	800	1400	2000
4 TO 6”	800	1400	2000
6 TO 8”	800	1400	2000
8 TO 10”	300	700	1000
10 TO 12”	300	700	1000

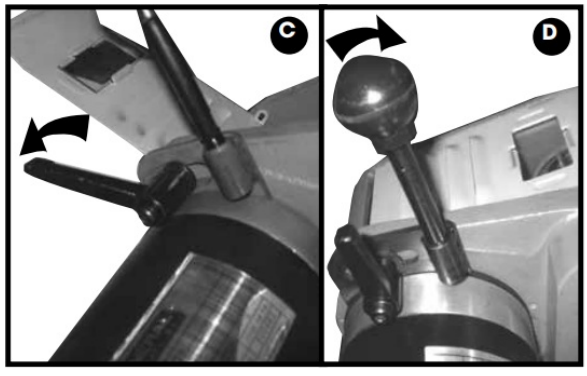
Use the chart as a basic guideline for selecting the appropriate spindle speed.

SPEED RANGES

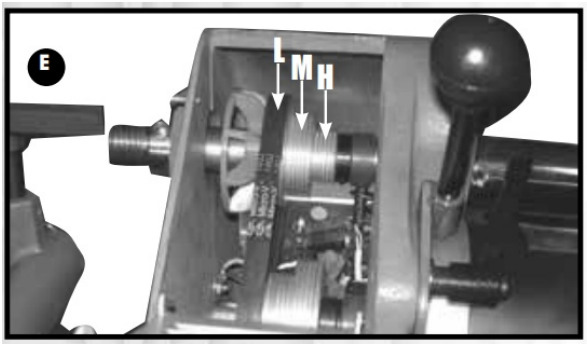


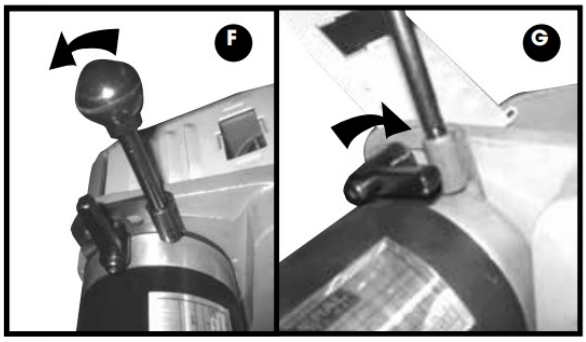
- Changing between the 3 speed ranges requires moving the drive belt from one set of drive pulleys to another. The speed range will vary.
- To reposition the belt and change spindle speed ranges



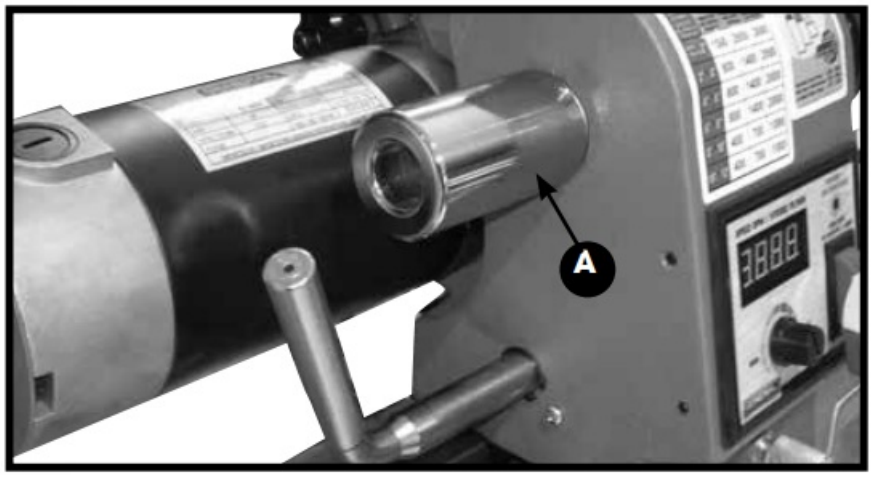


1. Turn off and unplug the lathe from the power source.
2. To access the belt and pulleys, loosen the belt guard locking screw A and open the belt guard located on the headstock B.
3. Release the belt tension locking lever C.
4. Release the tension on the belt by pulling the belt tension release lever backward D.

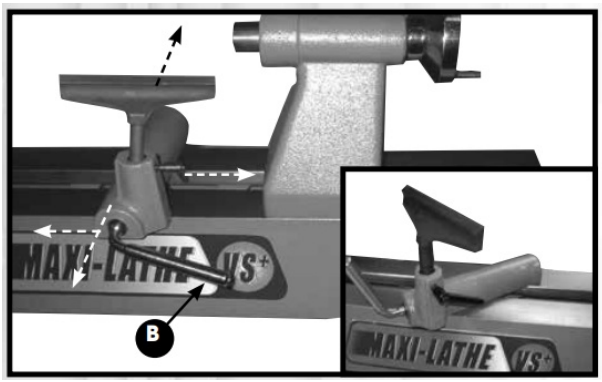


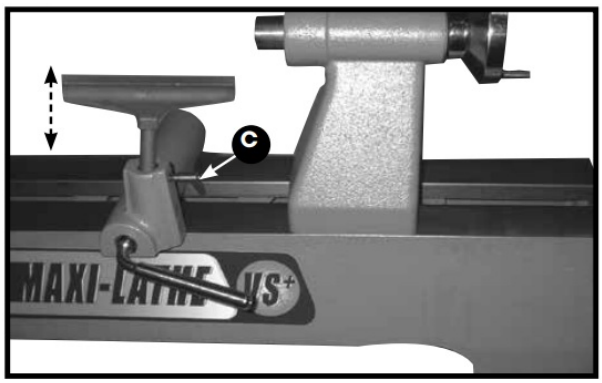


5. Set the belt by hand to the required pulley posi- tion (High/Medium/Low) E.
6. Push the belt tension release lever forward to re-tension the belt F and lock the belt tension lever G.
7. To verify the belt positioning and ensure the belt will run smooth on the pulleys; rotate the fly wheel A by hand to turn the spindle while observing the belt movement. If the belt moves smoothly re-install the belt guard – if the belt wobbles between the pulleys repeat steps 3-6 as needed.



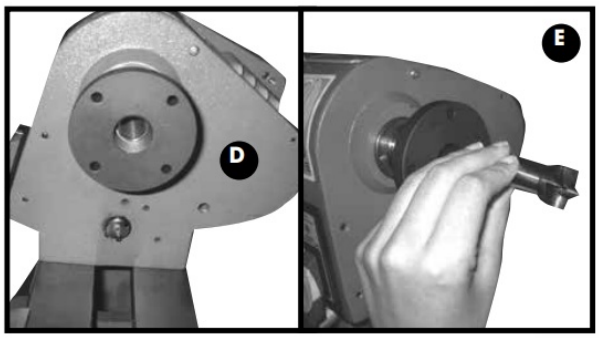
TOOL REST CARRIAGE & TOOL REST ADJUSTMENTS





1. The tool rest carriage can be moved along the bed slide ways as needed. Loosen the tool rest carriage lever B and move the carriage to the desired location. Retighten the lever securely after adjustment.
2. The tool rest should be adjusted so that its top is 1/8” above the center of the workpiece. Loosen the tool rest locking lever C and adjust the height and position of the tool rest as needed. Retighten the lever securely after adjustment.

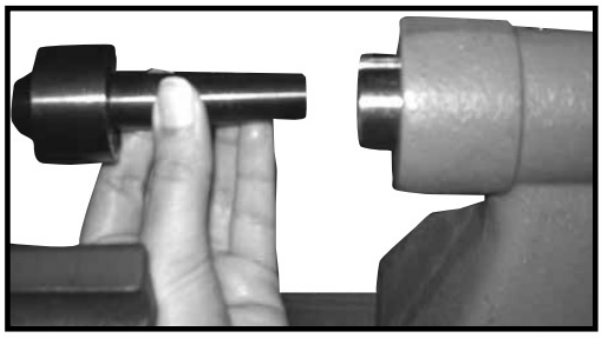
MOUNTING & REMOVING HEADSTOCK SPUR CENTER

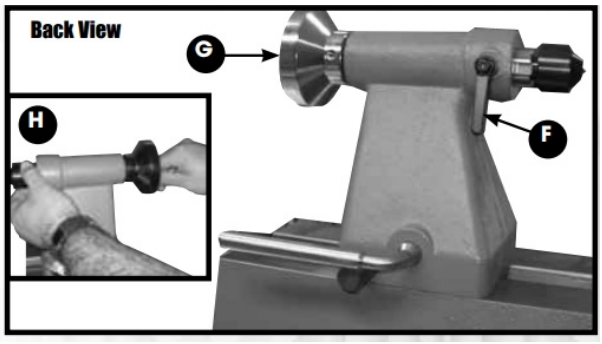


1. The headstock spindle has an MT#2 taper hole into which the spur center fits D. Make sure the shank of the spur center and the spindle hole are clean and free of debris, then fit the spur center firmly in the spindle hole by hand E.
2. To remove the headstock spur center, knock it out from the opposite end of the spindle using the supplied knock-out-bar.

Note: When knocking out the spur center, always hold it by hand to prevent it from falling.

MOUNTING & REMOVING TAILSTOCK LIVE CENTER



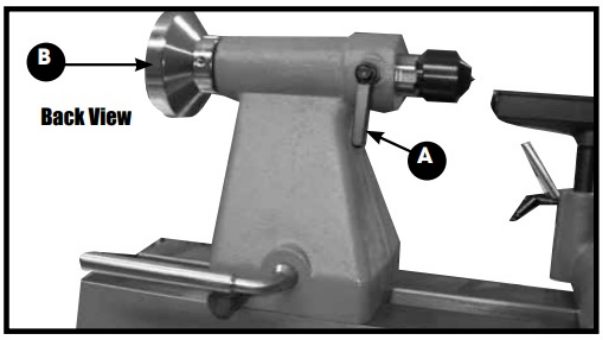


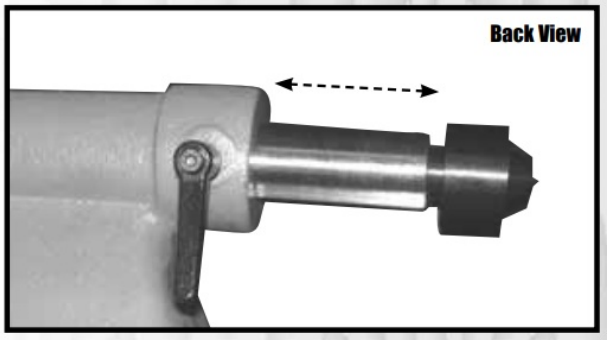
1. The tailstock has an MT#2 taper hole into which the live center fits. Make sure the shank of the live center and the tailstock hole are clean and free of debris and fit the live center firmly in the spindle hole by hand.
2. To remove the live center from the tailstock quill, loosen the tailstock quill locking lever F and move the quill out by turning the quill movement handwheel G until the quill end is nearly inside the tailstock and the live center can be removed by hand.

Note: When removing the live center, always hold it by hand to prevent it from falling H.

MOVE TAILSTOCK QUILL IN/OUT

The tailstock quill can be moved in and out of the tailstock casting by turning the tailstock quill movement handwheel.



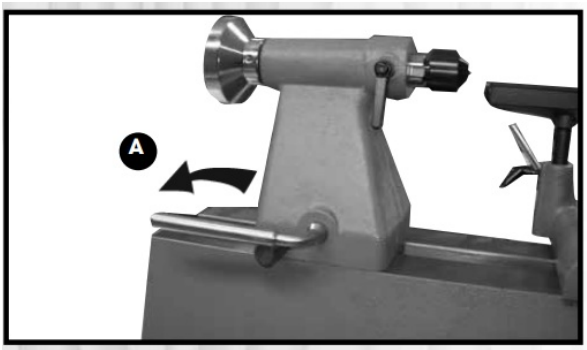


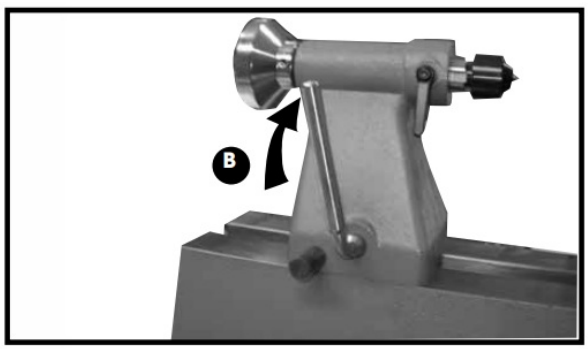
1. To move the tailstock quill, loosen the quill lock- ing lever A.
2. Turn the the quill movement handwheel B to move the quill as needed.
3. Retighten the quill locking lever to secure the quill in its new position.

TAILSTOCK MOVEMENT

The tailstock is used to support the other end of the workpiece to be turned and can be moved along the bed slideways to suit the length of the workpiece. To move the tailstock on the bed:

1.





Loosen the tailstock locking lever A.

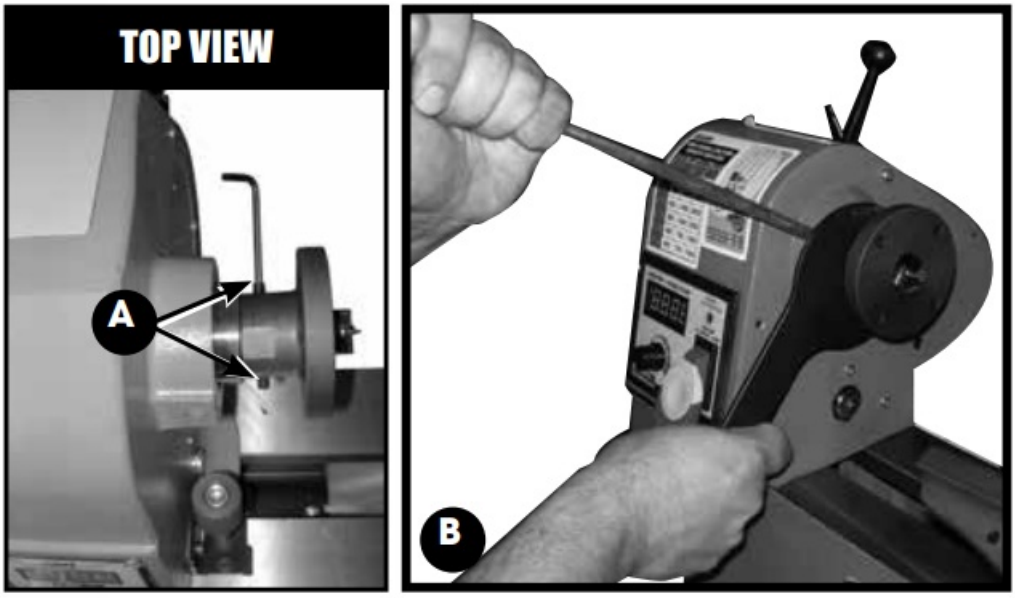
2. Move the tailstock by hand to the desired loca- tion on the bed.
3. Retighten the tailstock locking lever B to secure the tailstock in its new position.

MOUNTING A WORKPIECE TO THE FACEPLATE

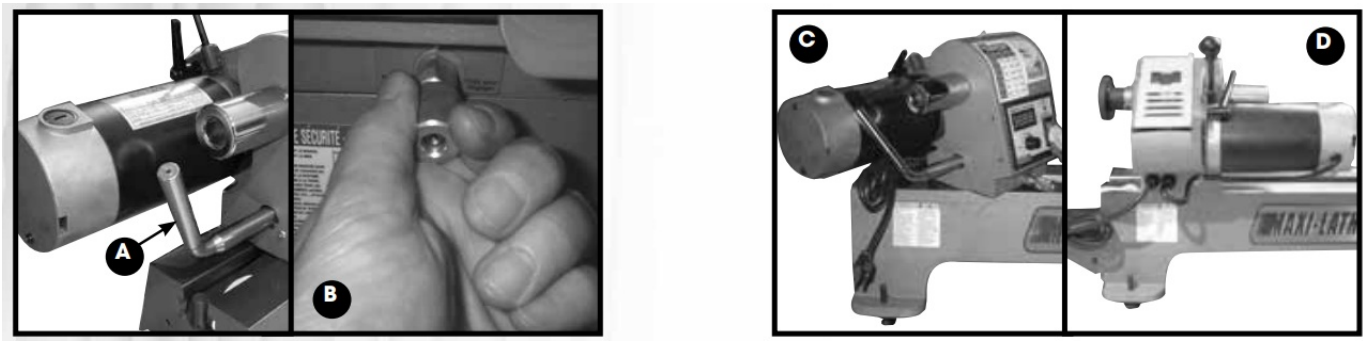
For turning applications where the workpiece cannot be secured between the headstock and tailstock centers (such as bowl turning) the faceplate must be used to secure the workpiece to the headstock spindle.

REMOVE THE FACE PLATE

1. Unlock the face plate by loosening and removing the two set screws A using a 3 mm Allen key.
2. Loosen the face plate by inserting the supplied knock out bar in the spindle hole to keep the spindle from turning while loosening the face plate using the supplied face plate wrench, as shown in B, then unscrew and remove the face plate.
3. With the face plate removed from the lathe, mount the workpiece onto the faceplate with wood screws (not inzcluded) through the mounting holes on the face plate. Make sure the screws are not so long that they will enter the area of the workpiece where the material is to be removed.
4. Re-install the face plate on the headstock.



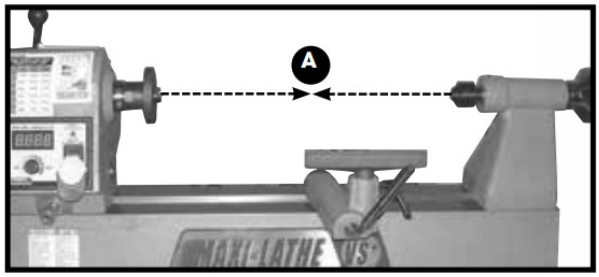
PIVOTING THE HEADSTOCK (FOR OUTBOARD TURNING)
For outboard bowl turning on larger diameter work pieces the headstock can be pivoted 180° To pivot the headstock

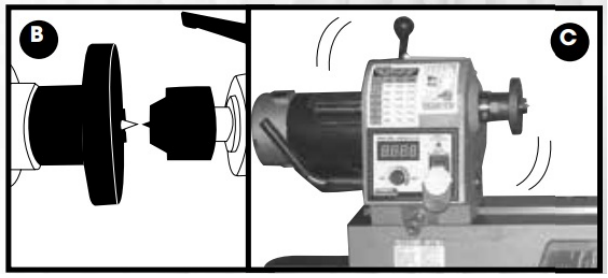


1. Loosen the headstock locking lever A.
2. Unscrew the knurled end of the indexing pin (turn counter clockwise) and pull out on the headstock pivot pin to release the headstock B.
3. Rotate the headstock 180° to outboard position. C and D.
4. Release the headstock pivot pin and Retighten it (turn clockwise) on its shaft.
5. Adjust the positioning of the headstock on the bed and tighten the headstock locking lever to secure the headstock in place.

CHECKING ALIGNMENT BETWEEN CENTERS
There is a small amount of play built into the headstock on the bed to allow the headstock to pivot freely. Whenever the headstock is pivoted back from the outboard position, the alignment between the headstock and tailstock centers should be double checked and adjusted as needed.

To check the alignment between the headstock and tailstock centers





1. Pivot the headstock to its normal spindle turning position and lock it in place.
2. Install a spur center in the headstock and a live center in the tailstock.
3. Release the tailstock locking lever and advance the tailstock on the bed A until the points of the 2 centers just barely touch each other.
4. Using the tailstock locking lever, secure the tail stock on the bed with the points still touching.
5. Look down at the two centers from above to verify that the points are in alignment. If the points line up B, proceed with normal turning opera- tions.
6. If the points are not lined up release the head- stock locking lever and manually adjust the headstock position using the play in the head- stock to line up the center points C.
7. With the points lined up, hold the headstock in place and tighten the headstock locking lever.
8. With the points lined up, proceed with normal turning operations.

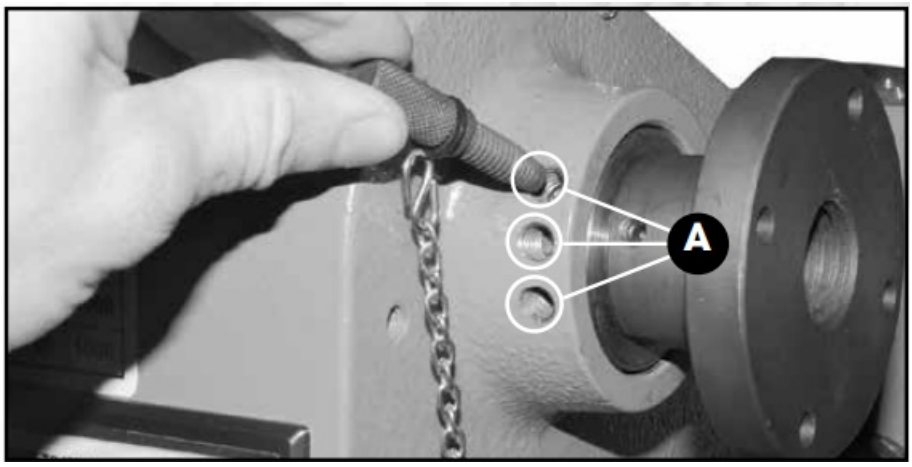
INDEXING

For advanced turners, the indexing features on this lathe allows the user to lock the spindle in place at 36 evenly spaced 10° intervals (360°/36 positions = 10°) while the workpiece is installed between the centers. This is primarily used for reeding or fluting (cutting decorative grooves vertically up the length of the spindle) usually with the help of a shop made jig and a router.

NEVER TURN ON THE LATHE WHEN THE HEADSTOCK SPINDLE IS LOCKED IN PLACE. ALWAYS, TURN OFF AND UNPLUG THE LATHE FROM THE POWER SOURCE, BEFORE INSERTING THE INDEXING PIN TO LOCK THE SPINDLE.
TURNING ON THE LATHE AFTER THE INDEXING PIN (OR ANY OTHER OBJECT) HAS BEEN INSERTED INTO THE HEADSTOCK INDEXING HOLE, THEREBY PREVENTING THE HEADSTOCK SPINDLE FROM TURNING, CAN LEAD TO SERIOUS INJURY, DAMAGE TO THE WORKPIECE, OR DAMAGE TO THE LATHE AND THE MOTOR.

To lock the spindle, turn the spindle slowly by hand until one of the 36 indexing holes is aligned with the first hole in the headstock and then screw the indexing pin into it.

Note: The 3 holes A allow more flexibility when locking the spindle. If the user wants to keep the workpiece in its exact position and it is not possible to lock the spindle with the first hole because the spindle hole and the headstock hole are not aligned, screw the indexing pin into one of the two other holes.



Complete the desired cut, groove or other operation on the spindle and then remove the indexing pin. If further grooves are required, turn the spindle by hand to set the workpiece to the required position and then screw the indexing pin into the required hole in the headstock.

Note: There are 36 evenly spaced holes in the headstock spindle allowing for indexing at 10° increments (360°/36 positions = 10°), allowing for a wide variety of symmetrical decorative grooves or patterned cuts.
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PERIODIC MAINTENANCE

- Keep the unit clean and free of dust by wiping with a cloth or vacuuming off any woodchips or dust after each use.
- All bearings are sealed and permanently lubricated and no further lubrication is required.
- Regular applications of any after-market surface protectant or rust inhibitor will help prevent rust and keep the tool rest, head, and tailstock sliding smooth on the bedway.
- Always turn off and unplug the lathe when you have completed turning and to avoid unauthorized use, remove the switch key and store it in a safe place.
- Periodically inspect the power cord and plug for damage. Replace the power cord and the plug at the first signs of visible damage.

RECOMMENDED OPTIONAL ACCESSORIES

- A large range of optional aftermarket accessories can be used with this lathe. Your local dealer may be able to offer suggestions based on what is readily available in your area.
- Key issues to keep in mind when shopping for aftermarket accessories are

- Headstock and tailstock feature a MT#2 taper – to avoid damaging the lathe use only headstock and tailstock centers with a matching taper.
- Headstock spindle threads are 1” diameter x 8 threads per inch (T.P.I.) – to avoid stripping or dam-aging the threads, use only threaded headstock attachments (such as face plates and jaw chucks) that have matching threads.
- We also offer a large variety of optional accessories to help you increase productivity, accuracy and safety when using your lathe. Here’s a small sampling of accessories available from you local General International dealer.
- For more information about our products, please visit our website at **www.general.ca0**

Steel support stand for maxi-lathes – #25-195N
Free-up valuable bench space in your shop and mount your lathe to dedicated stand. Easy to assemble. This sturdy steel stand is designed specifically to fit General International models 25-100, 25-114, 25-114QC & 25-200 Maxi Lathes.

#25-105 | 4” – 4 JAW SCROLL CHUCK 1” – 8
Designed specifically for use on lathes with 1” dia. x 8 TPI headstock threads.

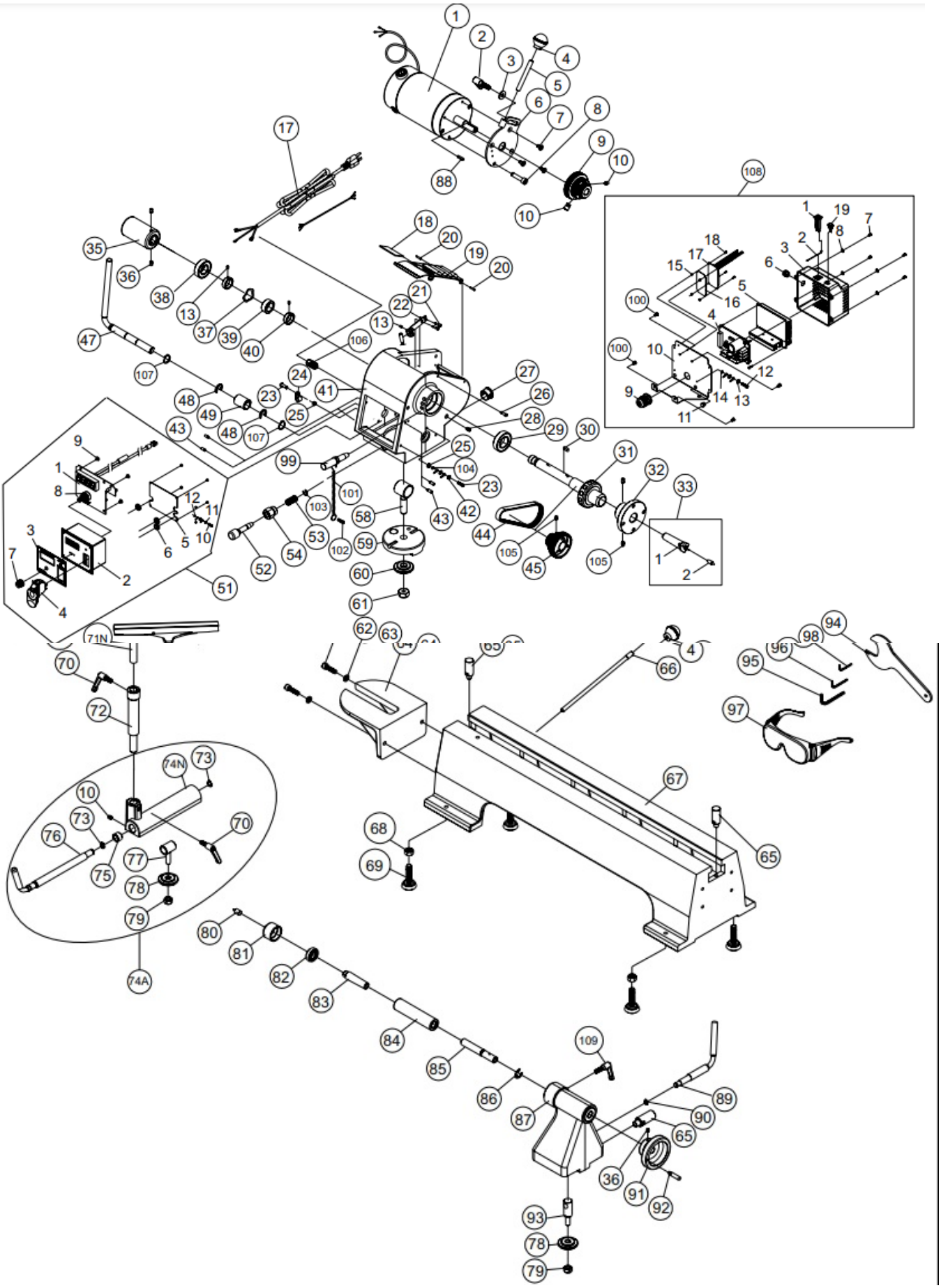
32″ BED EXTENSION (FOR 49 5⁄16″ BETWEEN CENTERS) – #25-205

STEEL SUPPORT STAND FOR MAXI-LATHE BED EXTENSIONS – #25-196

For models

- 25-100,
- 25-114,
- 25-114QC and 25-200.

Portable Dust Collector – #10-050M1
Designed for flexibility and mobility. Featuring an adjustable multi-po-sition support arm and a wide, rotating dust hood this unit is ideal for use on wood lathes.



PARTS LIST 25-200

IMPORTANT: When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired

	PART N0.	REF. N0.	DESCRIPTION	SPECIFICATIONS	QTY	
	25200-001	910092-000	MOTOR	DC90V/0.75HP	1	
	25200-002	921457-000	LOCK LEVER	5/16”-18UNC-3/4”L	1	
	25200-003	006002-049	FLAT WASHER	8.5 X 16 X 2t	1	
	25200-004	250372-615	KNOB		2	
	25200-005	380571-901	HANDLE		1	
	25200-006	171960-902	MOTOR PLATE		1	
	25200-007	000403-107	FLAT HEAD SCREW	M6 X 1.0P X 16	3	
	25200-008	000104-111	CAP SCREW	M8 X 1.25P X 35	1	
	25200-009	090246-000	MOTOR PULLEY		1	
	25200-010	000203-102	SET SCREW	M6 X 1.0P X 8	4	
	25200-013	000201-101	SET SCREW	M4 X 0.7P X 6	3	
	25200-017	WN02-06	POWER CORD		1	
	25200-018	250589-000	WINDOW		1	
	25200-019	171959-000	HEADSTOCK COVER		1	
	25200-020	011001-105	SPRING PIN	3 X 10	2	
	25200-021	000101-101	CAP SCREW	M4 X 0.7P X 8	2	
	25200-022	171961-901	SENSOR BRACKET		1	
	25200-023	003303-204	ROUND HEAD SCREW	3/16”-24NC X 3/4”	2	
	25200-024	021102-000	RELIEF	ACC-2.5	4	
	25200-025	009003-200	NUT	3/16” X -24NC	4	
	25200-026	003303-207	ROUND HEAD SCREW	3/16”-24NC X 5/8”	1	
	25200-027	021805-000	STRAIN RELIEF	NB-1216	1	
	25200-028	000205-101	SET SCREW	M10 X 1.5P X 12	1	
	25200-029	030408-000	BEARING	6005-2NK	1	
	25200-030	012003-007	KEY	5 X 5 X 20	1	
	25200-031	WN02-53	SPINDLE		1	
	25200-032	050966-902	FACE PLATE		1	
	25200-033	921458-000	SPUR CENTER ASS’Y		1	
	25200-033-1	380407-901	SPUR CENTER		1	

	25200-033-2	380443-906	CENTER POINT FOR SPUR CE NTER		1	
	25200-035	240056-907	SPINDLE FLYWHEEL		1	
	25200-036	003201-101	SET SCREW	1/4”-20NC X 1/4”	3	
	25200-038	030407-000	BEARING	6004-2NK	1	
	25200-039	660114-000	MAGNETIC RING		1	
	25200-040	380562-901	STOP RING		2	
	25200-041	050719-000	HEADSTOCK		1	
	25200-042	006502-200	SPROCKET WASHER	5.3 X 10 X 0.6t(BW-5)	1	
	25200-043	001901-103	SET SCREW	M5 X 0.8P X 15L	4	
	25200-044	014320-000	BELT	140J-5R	1	
	25200-045	090167-000	SPINDLE PULLEY		1	
	25200-047	380552-907	HANDLE		1	
	25200-048	010209-000	E-RING	ETW-15	3	
	25200-049	130190-000	ECCENTRIC RING		1	
	25200-051	WN02-31	CONTROL BOX WITH PANEL		1	
	25200-051-1	490468-000	DISPLAY BOARD	110V,61HZ	1	
	25200-051-2	250679-615	CONTROL BOX		1	
16						

PARTS LIST 25-200

	PART N0.	**REF. N0.**	**DESCRIPTION**	**SPECIFICATION**	**QTY**	
	25200-051-3	572469-000	CONTROL BOX LABEL	GENERAL	1	
	25200-051-4	937338-000	SAFETY SWITCH		1	
	25200-051-5	172302-000	CONTROL BOX COVER		1	
	25200-051-6	021501-000	RELIEF	10 X 14 X 3.5	3	
	25200-051-7	240057-000	VR KNOB		1	
	25200-051-8	490464-000	VR	B50K	1	
	25200-051-9	001101-205	TAP SCREW	M3 X 1.06P X 6	7	

	25200-051-10	003303-203	ROUND HEAD SCREW	M5 X 0.8P X 10	1	
	25200-051-11	006502-200	SPROCKET WASHER	5.3 X 10(BW-5)	2	
	25200-051-12	006001-131	FLAT WASHER	5.3 X 10 X 2t	1	
	25200-052	380554-905	HEADSTOCK PIVOT PIN		1	
	25200-053	280141-000	SPRING		1	
	25200-054	360732-905	LOCK NUT		1	
	25200-058	380514-901	ADJUSTMENT SCREW		1	
	25200-059	050622-000	HEADSTOCK PIVOT BASE		1	
	25200-060	130196-903	SLIDE RING		1	
	25200-061	009101-200	HEX NUT	3/4”-10UNC	1	
	25200-062	003104-111	CAP SCREW	5/16”-18NC X 1-1/2”	2	
	25200-063	006305-100	LOCK WASHER	8.2 X 15.4	2	
	25200-064	050722-000	OUTBOARD EXTENSION BED		1	
	25200-065	290072-902	STOPPER		3	
	25200-066	380559-905	KNOCKOUT BAR		1	
	25200-067	050718-000	BED		1	
	25200-068	009006-200	HEX NUT	3/8”-16NC	4	
	25200-069	230081-000	LEVELING FOOT		4	
	25200-071N	070034-904	TOOL REST	12”	1	
	25200-072	380553-902	TOOL REST EXT.BAR		1	
	25200-074A		TOOL REST ASSEMBLY		1	

	25200-74A-10	000203-102	SET SCREW	M6 X 1.0P X 8	4	
	25200-74A-70	921455-000	LOCK LEVER	5/16”-18UNC-15L	1	
	25200-74A-73	010003-000	S-RING	STW-12	2	
	25200-74A-74N	051085-049	TOOL REST CARRIAGE		1	
	25200-74A-75	160058-000	BUSHING		1	
	25200-74A-76	380561-907	ECCENTRIC ROD		1	
	25200-74A-77	380411-902	ADJUSTMENT SCREW		1	
	25200-74A-78	160053-901	SLIDE RING		2	
	25200-74A-79	008308-200	LOCK NUT	M10 X 1.5P	1	
	25200-080	380415-901	CENTER POINT FOR LIVE CENTER		1	
	25200-081	380413-901	LIVE CENTER		1	
	25200-082	030001-000	BEARING	6002Z	1	
	25200-083	380414-901	LIVE CENTER SHAFT		1	
	25200-084	360361-000	TAILSTOCK SPINDLE		1	
	25200-085	360369-901	TAILSTOCK SCREW		1	
	25200-086	010208-000	E-RING	ETW-12	1	
	25200-087	050720-000	TAILSTOCK		1	
	25200-088	012002-007	KEY	4 X 4 X 20	1	
	25200-089	380558-907	ECCENTRIC ROD		1	
	25200-090	010001-000	S-RING	STW-10	1	
	25200-091	240053-906	TAILSTOCK HANDWHEEL		1	

PARTS LIST – 25-200

PART N0. REF. N0. DESCRIPTION SPECIFICATIONS QTY

25200-092	380444-906	HANDLE		1
25200-093	380408-905	ADJUSTMENT SCREW		1
25200-094	172318-904	FACE PLATE WRENCH	#38	1
25200-095	040006-000	ALLEN WRENCH	6 MM	1
25200-096	040003-000	ALLEN WRENCH	3 MM	1
25200-097	042602-000	SAFETY GOGGLES		1
25200-098	040002-000	ALLEN WRENCH	2.5 MM	1
25200-099	380764-902	INDEX PIN		1
25200-100	000303-202	ROUND HEAD SCREW	M5 X 0.8P X 8	4
25200-101	380765-906	CHAIN		1
25200-102	003303-207	ROUND HEAD SCREW	3/16”-24NC X 5/8”	1
25200-103	010203-000	E-RING	ETW-6	1
25200-104	006001-131	FLAT WASHER	5.3 X 10 X 2t	1
25200-105	000203-102	SET SCREW	M6 X 1.0P X 8	4
25200-106	021316-000	STRAIN RELIEF	MG16A-10B-ST	1
25200-107	010030-000	S-RING	STW-19	2
25200-108	WN02-58	PWM CONTROLER		1
25200-108-1	490490-000	THERMO RELAY	12AMP	1
25200-108-2	471002-005	CONNECT WIRE	SJT X 16AWG X 1C	1
25200-108-3	250716-615	PWM CONTROLER BOX*		1
25200-108-4	490465-000	PWM PC BOARD*	PWM(AC120V,60HZ/DC 90V,8A),800 ~2000	1
25200-108-5	310169-000	HEAT SINK		1
25200-108-6	020001-000	RELIEF	SB6R-3	1
25200-108-7	000302-202	ROUND HEAD SCREW	M4 X 0.7P X 8	4
25200-108-8	006002-001	FLAT WASHER	4.3 X 10 X 1.0t	4
25200-108-9	021306-000	STRAIN RELIEF	PGA16-14B	1
25200-108-10	172468-902	PWM CONTROLER BRACKET		1
25200-108-11	042502-000	COVER D9.5		1

25200-108-12	003303-203	ROUND HEAD SCREW M5 X 0.8P X 10	1
25200-108-13	006502-200	GEAR WASHER 5.3 X 10(BW-5)	2
25200-108-14	006001-131	SPROCKET WASHER 5.3 X 10 X 2t	1
25200-108-15	250748-621	BUSHING	4
25200-108-16	540277-000	HEAT SINK	1
25200-108-17	490693-000	FWD/REV PC BOARD	1
25200-108-18	000302-102	ROUND HEAD SCREW M4 X 0.7P X 8	4
25200-108-19	490694-000	FWD/REV SWITCH 10A125A 6(2)A250V	1
25200-109	921456-000	LOCK LEVER 5/16”-18UNC-20L	1
25200-110	004402-101	SET SCREW 1/4”-20NC X 1/4”	1

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	GENERAL 25-200 Wood Lathe Variable Speed [pdf] Instruction Manual 25-200, 25-200 Wood Lathe Variable Speed, Wood Lathe Variable Speed, Lathe Variable Speed, Variable Speed

References

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