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Operating Manual

Variable Speed Mini Lathe

○ L1835C- (VP)



Keep Read And Understand The Operation Manual And Safety Information Before Operated!

This Machine is Suitable To Use Only From 12°C~35°C(53.6°F~95°F)

PRINTED IN CHINA

V1.01.02

MATTERS NEEDING ATTENTION

The information contained in this handbook is intended as a guide to the operation of these machines and does not form part of any contract . The data it contains has been obtained from the machine manufacturer and from other sources. We strive to ensure the accuracy of this information and try to verify each item and each data, but we cannot guarantee the full accuracy of the information, which means that the equipment supply may differ in detail from the description of the instructions. Furthermore, development of the machine may mean that the equipment supplied may differ in detail from the descriptions herein. The responsibility therefore lies with the user to satisfy himself that the equipment or process described is suitable for the purpose intended.

QUALITY ASSURANCE









We will make every effort to ensure the quality of our products, and we promise to consumers that we will guarantee our products for one year, except for machine damage caused by improper operation of customers, and accidents resulting therefrom, or abnormal wear and damage caused by lack of maintenance.


In order to fulfill the warranty commitment, the product or part with quality problems, please return to us for verification, postage prepaid. Goods sent back should be accompanied by a note of the date of purchase and a written explanation of the quality of the product. After our inspection and confirmation, we will repair or replace their products, or refund the payment; If we fail to provide repair or replacement in a timely manner, we shall bear the costs arising from the repair or replacement of the products; If the damage is not due to the quality of the product, but due to the user's improper operation or other reasons, the cost shall be borne by the customer .

Our company reserves the right to make changes to this specification and product specifications. We will make continuous efforts to improve the quality of our products.

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SAFETY WARNING

Symbol	Symbol Description
	Warning - To reduce the risk of injury, user must read instructions manual carefully.
	This symbol, placed before a safety comment, indicates a kind of precaution, warning, or danger. Ignoring this warning may lead to an accident. To reduce the risk of injury, fire, or electrocution, please always follow the recommendation shown below.
	Danger! Risk of personal injury or environmental damage! Risk of electric shock! Risk of personal injury by electric shock!
	Alternating current
	Beware of clamping
	Warning- Be sure to wear ear protectors when using this product.
	Warning- Be sure to wear eye protectors when using this product.
	Do not put your hands into safety guard when machine is working
	No entry automatic machinery in operation Authorized personnel only
	Do not fill oil during operation
	Do not turn during repair
	No fatigue operation
	The operation is no phone calls

	<p>Disposal information:</p> <p>This product is subject to the provision of European Directive 2012/19/EC. The symbol showing a wheeled bin crossed through indicates that the product requires separate refuse collection in the European Union. This applies to the product and all accessories marked with this symbol. Products marked as such may not be discarded with normal domestic waste, but must be taken to a collection point for recycling electrical and electronic devices</p>
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WARNING: Read all safety warnings, instructions, illustrations and specifications provided with this machine. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

1. The machine tool should be used by experienced personnel. If you are not familiar with the operation process of the lathe, do not use the machine tool at will. Use the instructions before operating.
2. Before starting the machine tool, the safety cover should be in the correct position.
3. Before starting the machine tool, please check whether the tool rest wrench and chuck key are removed.
4. Prevent the machine from starting accidentally. Turn off the motor power before clamping the workpiece or tool.
5. Don't force cut. Cutting according to the set cutting speed, cutting depth and feed speed.
6. Use the right tools. Use the correct tool or workpiece for machining.
7. Keep the tool sharp and clean to ensure normal and safe operation.
Lubricate and replace accessories regularly.
8. Before adjusting or repairing the machine, be sure to disconnect the power supply.
9. Please check the safety performance of the machine before starting it.
Check the performance of all moving parts. All parts must be installed correctly. Damaged parts must be repaired promptly.
10. When the machine is running, the operator shall not leave.

11. Keep the working place clean, dirty working environment is easy to lead to accidents.
12. Do not use the machine in dangerous environment.
Do not work in damp places. Ensure that electrical components are protected from moisture. Keep good lighting.
13. Children are prohibited from entering the work site, and non-operating personnel should keep a safe distance from the work area.
14. To keep children out of the work area. The door should be locked when leaving the workshop.
15. Dress appropriately. Don't wear loose clothing, gloves, ties, rings, bracelets, jewelry, etc. To be on the safe side, For the sake of safety , wearing non-slip shoes. If you have long hair, please wear a work hat.
16. Wear protective glasses when operating.
17. Pay attention to where you stand and keep your balance at all times.
18. Do not place your hands near the moving parts of the machine.
19. Do not perform any setting operations while the machine is running.
20. Read and understand all warning signs posted on the machine.
21. This manual is intended only to familiarize customers with the operation of the machine and is not a training manual.
22. Please obey these warnings or serious injury may result.
23. The machine will produce some harmful chemicals in the work of dust, sawing, grinding and drilling produced by grinding. To reduce the harm of these chemicals, please work in a well-ventilated place and wear safety devices. Such as particulate filter masks

SPECIFICATIONS:

Type number	L1835C- (VP)	
Capacities:		
Specifications	Metric	Imperial
Swing over Bed	180mm	ϕ 7"
Swing over Cross Slide	110mm	ϕ 4-1/3"
Distance Between Centers	350mm	13-3/4"
Width of Bed	90mm	3-1/2"
Headstock:		
Hole Through Spindle	20mm	ϕ 4/5"
Taper in Spindle Nose	MT3	MT3
Number of Spindle Speeds	1-Variable	1-Variable
Range of Spindle Speeds	0-2500 RPM	0-2500 RPM
Chuck Type	K11-100	K11-100
Feeding and Threading:		
Number of Metric Threads	9	9
Range of Metric Threads	0.5-2.5mm	0.5-2.5mm (optional)
Number of Imperial Threads	18	18
Range of Imperial Threads	12-52 T.P.I (optional)	12-52 T.P.I
Range of Longitudinal Feed	0.1-0.20mm	0.004"~0.008" (2Step)
Compound and Carriage:		
Tool Post Type	4-Way	4-Way
Maximum tool size	10×10mm	2/5"×2/5"
Maximum Compound Slide Travel	50mm	2"
Maximum Cross Slide Travel	60mm	2-3/8"
Maximum Carriage Travel	295mm	11-3/5"
Tailstock:		
Tailstock Spindle Travel	50mm	2"
Taper in Tailstock Spindle	MT2	MT2
Miscellaneous:		
Power	550W,220~240V,1PH,50HZ	3/4HP,110V,1PH,60HZ
Dimension:		
Overall dimensions (L×W×H)	750×310×290mm	29-1/2"×12-1/5"×11-2/5"
Plywood Case size (L×W×H)	830 X370X450mm	32-2/5"×14-3/5"×17-7/10"
Net Weight	42.9kg	94.6lbs
Gross Weight	57.5kg	126.8lbs

The specifications in this manual are given as general information and are not binding. We reserve the right to effect, at any time and without prior notice, changes or alterations to parts, fitting and accessory equipment deemed necessary for any reason whatsoever.

- **Standard accessories (metric model)**

- | | |
|--------------------|---|
| 1. Oil Pan | 1 |
| 2. Rear Chip Plate | 1 |
| 3. Three Jaw Chuck | 1 |
| 4. Specification | 1 |
| 5. Tool Box | 1 |



Fig. 1

- **Accessories in the tool box (Fig. 1)**

- | | |
|---|--|
| 3 | Hand Wheel Lever |
| 1 | Dead Center MT2 |
| 1 | Oil Gun |
| 1 | Chuck key for the 3-jaw chuck |
| 3 | Outside Jaws for the 3-jaw Chuck |
| 6 | Hex Wrenches Sets 2/2.5/3/4/5/6mm |
| 3 | Double End Head Wrenches (8-10/12-14/13-16) |
| 9 | Change Gear (30T,35T,40T,40T,45T,50T,50T,60T,60T) |
| 1 | Philips Screwdriver |
| 1 | LED lamp |
| 7 | Turning tool |
| 4 | Rubber feet |
| 4 | Screw M6X25 |
| 1 | Timing belts 3M-432 |

- **Special accessories (Accessories that require additional payment)**

Four jaw chuck and back plate (connecting plate)

Live Center

Steady rest Follow rest

Drill chuck and connecting rod