

# **STARTRITE MTC**

## **OPERATING INSTRUCTIONS AND PARTS LIST**

### **HEALTH and SAFETY**

**MACHINES CAN BE DANGEROUS IF IMPROPERLY USED.**

- 1. Operators should be instructed in the safe use of this machine.**
- 2. Operators and supervisors should be conversant with the contents of this handbook.**

**GRADUATE 6 in.  
WOODTURNING LATHE**

**HANDBOOK  
44**

THE **600** GROUP

**GRADUATE 6 in.  
WOODTURNING LATHE**

**HANDBOOK**

**44**

# Union

## GRADUATE 6in. WOODTURNING LATHE

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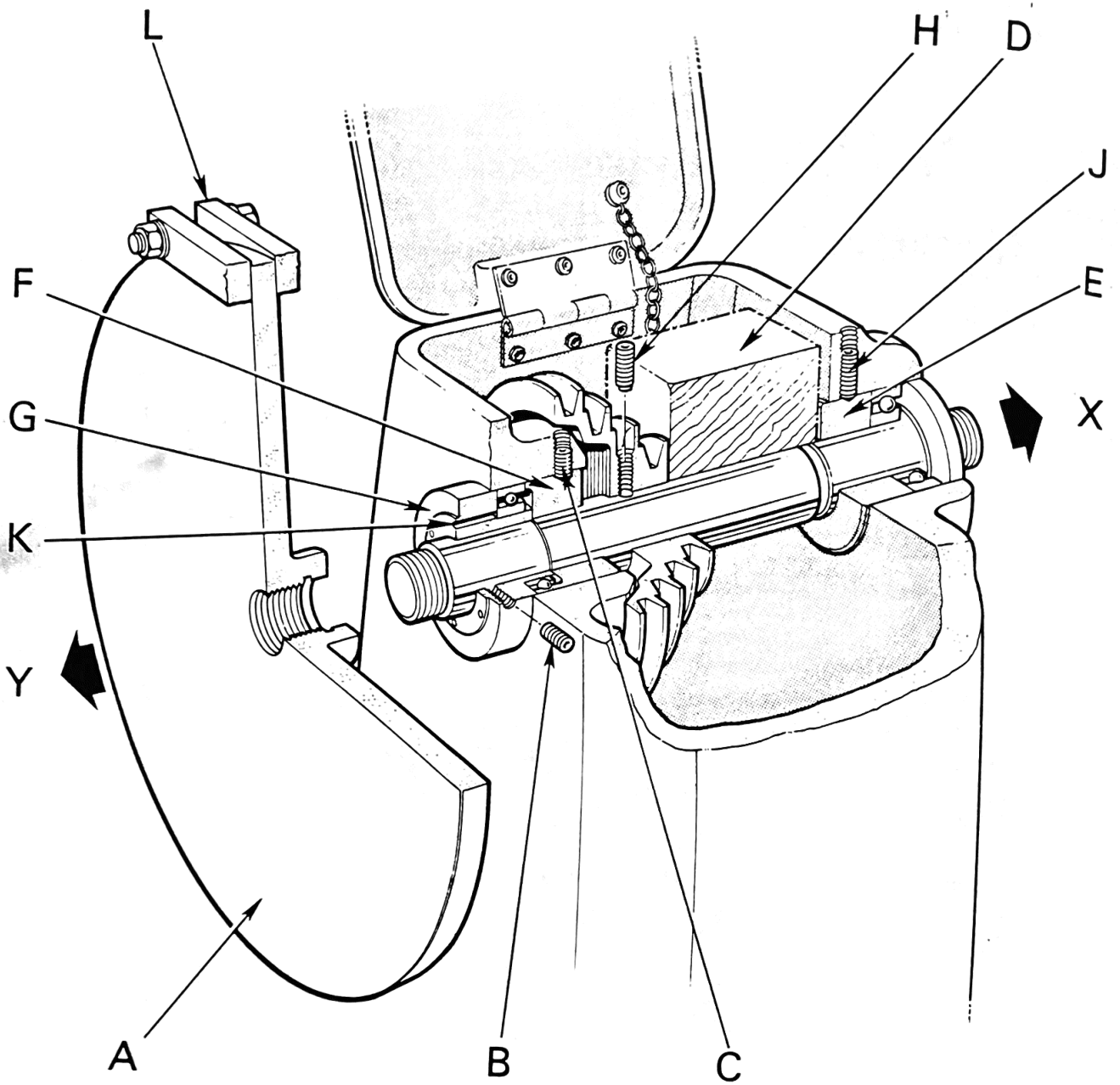
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#### INSTRUCTIONS FOR ORDERING SPARE PARTS

When ordering spare parts always quote the Machine No. which is stamped on the tailstock end of the bed.

Spares can be obtained through your usual machinery dealer, or direct from the manufacturers.



**SAFETY NOTE — SWITCH OFF ELECTRICAL SUPPLY TO MACHINE BEFORE CARRYING OUT MAINTENANCE.**

## LUBRICATION

Lubricate main spindle bearings each day by turning grease caps. Ensure the caps are kept well filled. **Do not overgrease.**  
Oil tailstock screw daily and lightly smear the spindle with oil.  
Oil motor platform turnbuckle screws and pivot points occasionally.  
Clean and oil the bed ways and outer rest arm top face frequently.  
Recommended Lubricants: "Shell" Alvania Grease 3, "Shell" Tellus 33 Oil, or equivalent.

## MAINTENANCE

### 1. To Replace Old Type Spindle with New

Remove faceplate (A). File off any burrs which may be on the end of the spindle. Release set screws (B) and (C). Place a wood block (D) in the position shown and withdraw spindle in direction of arrow 'X'. The pulley will slide off the spindle when it abuts against the wood block. If any difficulty is experienced the spindle should be given a sharp knock.

Re-assemble new spindle, passing it through the front bearing and spacer (E), through the pulley and rear spacer (F) and through the bearing sleeve (G) until the shoulder of the spindle is up against the bearing sleeve. Tighten screw (B) and line up head pulley with motor pulley and tighten screws (C).

### 2. To Replace Bearings

Remove faceplate (A), release set screws (B) and (C) and withdraw spindle and front bearing in direction of arrow 'X' (same method as instruction (1)).  
Remove sleeve complete with rear bearing in direction of arrow 'Y', if bearings are tight in housings release set screws (H) and (J) and lightly tap spacers (F) and (E) until the bearings are ejected.  
To remove rear bearing from its sleeve use pins through the ejector holes (K) then fit new bearing.  
Re-assemble front spacer (E) and clamp set screw (J) in dimple. Re-assemble rear spacer (F). Do not as yet clamp set screw (H). Re-assemble spindle complete with new front bearing.  
Re-assemble rear bearing and sleeve up to shoulder on spindle and clamp set screw (B). Adjust rear spacer (F) to remove side play then clamp set screw (H). Care should be taken with this final adjustment to prevent overloading of bearings. Line up head pulley with motor pulley and clamp set screw (C).

### 3. To Remove End Play

Release set screw (H) and adjust spacer (F) slightly in direction of arrow 'Y' then re-clamp screw (H). Care should be taken to prevent overloading of bearings.

### 4. To Replace Vee Belt

Remove faceplate (A) and release set screws (B) and (C).  
Slacken tension on vee belts.  
Withdraw spindle in direction of arrow 'X' sufficiently to allow vee belt to be replaced. Replace spindle, line up head pulley with motor pulley and clamp set screws (B) and (C).  
Tension vee belts.  
Replace faceplate (A).

### 5. To Remove Faceplates which have become locked on Spindle

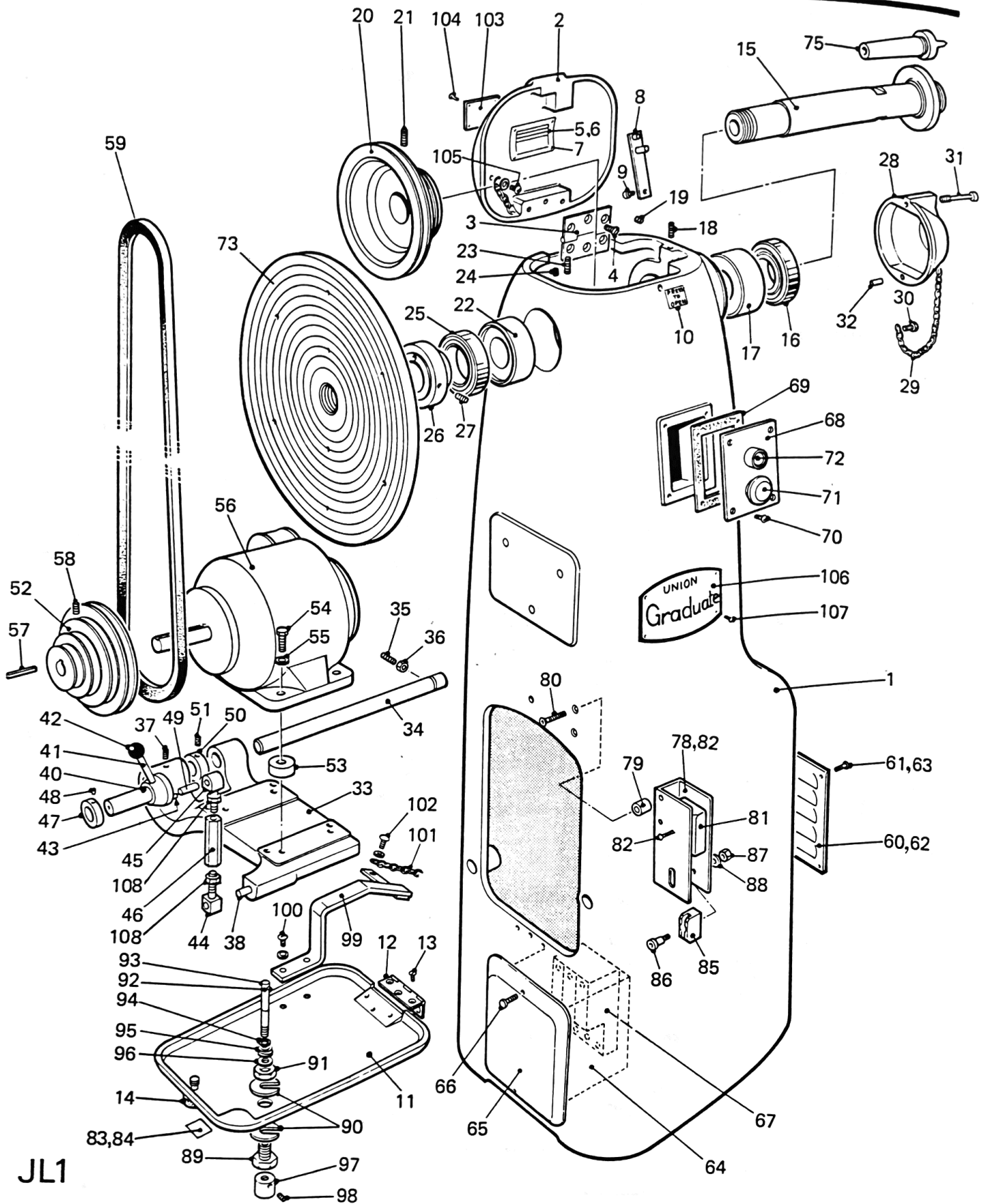
Take two pieces of steel bar (L)  $\frac{3}{4}$ " x  $\frac{1}{2}$ " section  $7\frac{1}{4}$ " long and drill two  $13/32$ " dia holes in each at  $5.9/16$ " centres. Clamp these blocks onto the faceplate by means of two  $3/8$ " dia nuts and bolts. With the spanner on the flats of the spindle, and locating against the main body casting, strike the steel clamps with a hammer, on the appropriate end to release the faceplate.

**NOTE:** Faceplates, driver plates and chucks should be removed from the spindle at regular intervals to reduce risk of jamming.

Before attaching face plates, the spindle nose should be cleaned and well-lubricated to prevent seizing.  
**DO NOT RESTART MACHINE WITH CLAMPS IN PLACE.**

# Motor Leg and Drive Assembly

# Union



JL1

# Motor Leg and Drive Assembly

MACHINE SUPPLIED WITH POSITIVE ACTION LIMIT SWITCH

ITEM NO.	PART NO.	DESCRIPTION	QTY:
1	JL-308	MOTOR LEG	1
2	JL-312A	COVER	1
3	JL-66	HINGE	1
4	3/16" BSW x 3/8"	SOCKET COUNTERSUNK HEADED SCREW	6
5	104	SPEED PLATE 50HZ	1
6	169	SPEED PLATE 60HZ	1
7	3/32" dia	RIVET	4
8	SG-170/ JL-335/JL-400	LATCH ASSEMBLY	1
9	3/16" BSW x 3/8"	SOCKET HEAD CAP SCREW	1
10	SP 300	"PRESS TO OPEN" TRANSFER	1
11	JL-329A	DOOR	1
12	JL-66	HINGE	1
13	3/16" BSW x 3/8"	SOCKET COUNTERSUNK HEADED SCREW	6
14	JL-401	STUD	1
15	JL-323	MAIN SPINDLE	1
16	LJ-40	BALL BEARING (METRIC)	1
17	JL-326	SPACER BUSH	1
18	3/8" BSW x 3/4"	SOCKET SET SCREW DOG POINT	1
19	1/8" GAS	BRASS GREASE CUP NO.1	1
20	JL-324	HEAD PULLEY	1
21	3/8" BSW x 3/4"	SOCKET SET SCREW (1/2 DOG POINT WITH NYLON PATCH)	1
22	JL-326	SPACER BUSH	1
23	3/4" BSW x 1/2"	SOCKET SET SCREW (CUP POINT)	1
24	1/8" GAS	BRASS GREASE CUP NO.1	1
25	XXLJ-50	BALL BEARING (METRIC)	1
26	JL-327	BEARING BUSH	1
27	5/16" BSW x 5/8"	SOCKET SET SCREW (DOG POINT)	1
28	JL-341	SPINDLE NOSE COVER	1
29	CHAIN 13" LONG	CHROME PLATED CHAIN	1
30	3/16" BSW x 1/2"	ROUND HEAD SET SCREW	2
31	JL-348	FIXING SCREW	1
32	1/4" dia x 3/4"	STRAIGHT PIN	1
33	JL-287C	MOTOR PLATFORM (D80 3ph & 1ph)	1
34	JL-318	PLATFORM SPINDLE	1
35	3/8" BSW x 3/4"	SOCKET SET SCREW (1/2 DOG POINT)	1
36	3/8" BSW	HEX LOCKNUT	1

# Motor Leg and Drive Assembly

ITEM NO.	PART NO.	DESCRIPTION	QTY.
37	5/16" BSW x 3/8"	SOCKET HEAD SET SCREW (1/2 DOG POINT) WITH NYLON PATCH	1
38	JL-319	STUD	1
39	2BA x 1/4"	SOCKET HEAD SET SCREW (CUP POINT)	1
40	JL-320A	ECCENTRIC SHAFT	1
41	JL-376	HANDLE	1
42	BB4	BAKELITE BALL	1
43	3/16" dia x 1/2"	STRAIGHT PIN	1
44	JL-321	TURNBUCKLE STUD (RH)	1
45	JL-321B	TURNBUCKLE STUD (LH)	1
46	JL-322	TURNBUCKLE	1
47	JL-328	COLLAR	1
48	2BA x 1/4"	SOCKET HEAD SET SCREW (CUP POINT)	1
49	JL-387	PIN	1
50	JL-408	FIXING COLLAR	1
51	5/16" BSW x 3/8"	SOCKET SET SCREW (CUP POINT) WITH NYLON PATCH	1
52	JL-73E	MOTOR PULLEY (D80)	1
53	JL-457	SPACER	4
54	5/16" BSW x 1 1/2"	HEXAGON HEADED SET SCREW	4
55	5/16"	STANDARD WASHER	4
56	D80	1/4 HP, 1500 RPM MOTOR (3ph) OR	1
	D80	1 HP, 1500 RPM MOTOR (3ph) OR	1
	D80	1 HP, 1500 RPM MOTOR (1ph) OR	1
	56 FRAME	1/4 HP, 1500 RPM MOTOR (1ph)	1
57	6 x 5 x 40	RECTANGULAR KEY	1
58	1/4" BSW x 5/8"	SOCKET SET SCREW (CUP PT) WITH NYLON PATCH	1
59	A66	PREMIUM VEE BELT	1
60	JL-145	LOUVRED COVER (1 HP MOTORS ONLY)	1
61	1/4" BSW x 1/2"	ROUND HEAD SET SCREW	1
62	JL-145	LOUVRED COVER (1 HP MOTOR ONLY)	1
63	1/4" BSW x 1/2"	ROUND HEAD SET SCREW	1
64	G20-216	PROTECTIVE BOX	1
65	G20-215A	STARTER MOUNTING PLATE	1
66	3/16" BSW x 1/2"	RAISED C'SUNK HEADED SET SCREW CHROME PLATED	2
67	CT10	STARTER & OVERLOAD (STATE SUPPLY VOLTAGE ETC WHEN ORDERING)	1
68	935	PUSHBUTTON PLATE	1
69	MHI-6-206	GASKET (PUSHBUTTON PLATE)	1
70	3/16" BSW x 1/2"	ROUND HEAD SET SCREW	4

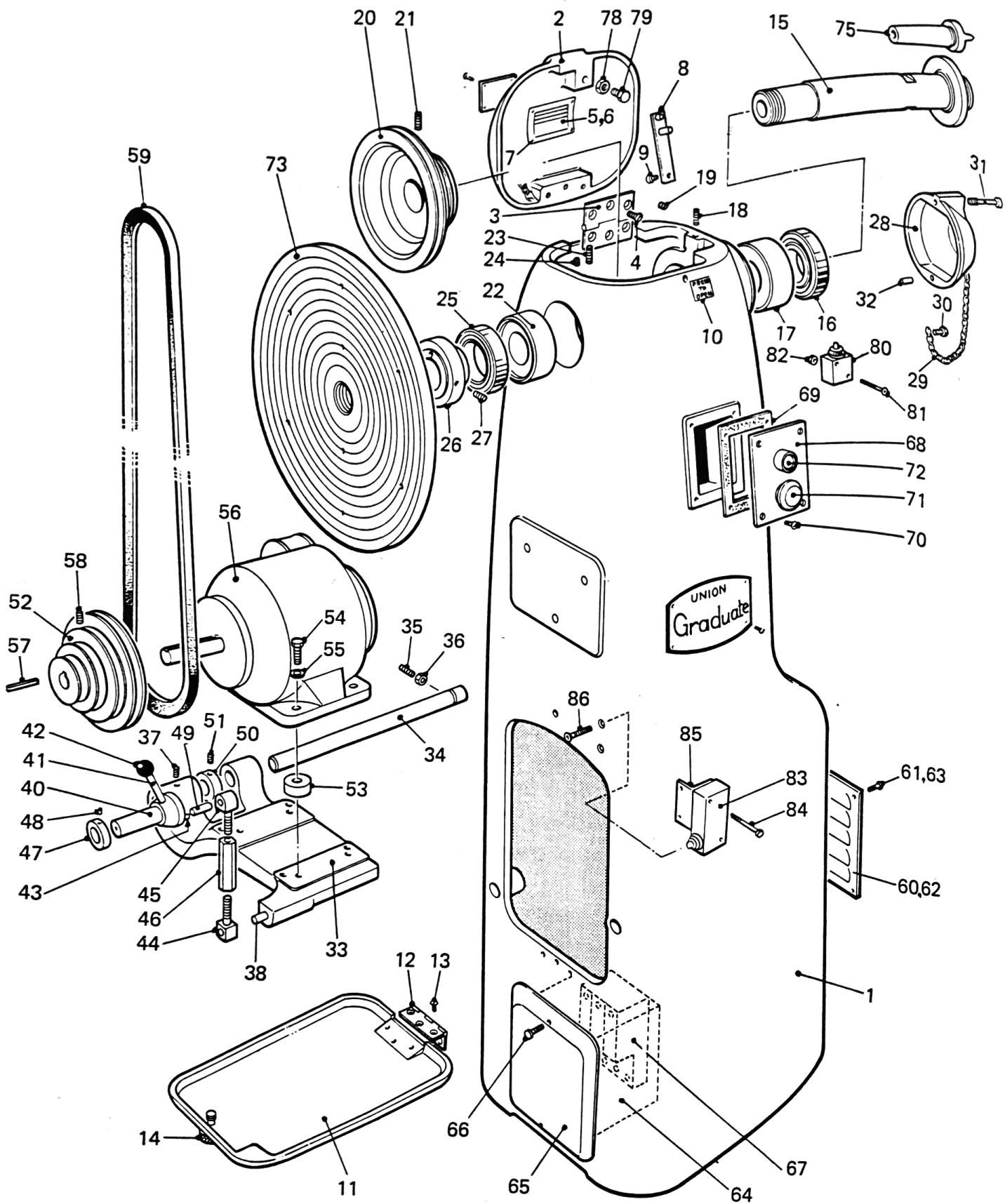


# Motor Leg and Drive Assembly

ITEM NO.	PART NO.	DESCRIPTION	QTY.
71	P-r/k (red)	MUSHROOM HEADED STOP PUSHBUTTON & CONTACT BLOCK	1
72	D-12/k (green)	START PUSHBUTTON & CONTACT BLOCK	1
73	JL-138	OUTSIDE FACEPLATE 14" DIA (see accessory list for additional faceplates)	1
74	JL-367	DRIVER PLATE 8" DIA NOT ILLUSTRATED	1
75	L5-10-193	FORK CENTRE	1
76	L5-585	CONE CENTRE NOT ILLUSTRATED	1
77	L5-875	CUP CENTRE NOT ILLUSTRATED	1
78	JL-466	MOUNTING BRACKET	1
79	JL-464	SPACER	2
80	3/16" BSW x 1 1/4"	SOCKET COUNTERSUNK HEAD SCREW	2
81	KB5-EQR	LIMIT SWITCH	1
82	2BA x 7/8"	SOCKET COUNTERSUNK HEAD SCREW	2
83	3S3B191-3EC	OFF LEGEND	1
84	3S3B191-3EB	ON LEGEND	1
85	D901H016.1	CAM	1
86	M5 x Ø 6 x 12mm	SOCKET HEAD SHOULDER SCREW	1
87	M5	HEX NUT	1
88	M5	WASHER	1
89	JL-465	BUSH	1
90	M12	WASHER (LARGE HEAVY FORM C)	2
91	36052001	LOCKNUT	1
92	JL-463	KEY (INTERLOCK SWITCH)	1
93	Ø 4 x 22 (MBK)	SPIRAL PIN	1
94	DIN 1400-8	EXTERNAL CIRCLIP	1
95	TYPE D (M8)	SPRING WASHER	1
96	M8	STANDARD WASHER	1
97	D901H018.1	KNOB	1
98	M5 x 6	SOCKET SET SCREW (CUP POINT)	1
99	468	ANCHOR STRIP	1
100	3/16" BSW x 1/2"	SOCKET BUTTON HEAD SCREW	2
101	16 SWG x 1/2" pitch	CHAIN (CHROME PLATED)	1
102	3/16" BSW x 1/2"	SOCKET BUTTON HEAD SCREW	1
103	1020	INSTRUCTION PLATE	1
104	No.4 UNF x 1/4"	POZI-PAN TAPTITE SCREW	4
105	3/16" BSW x 1/2"	SOCKET BUTTON HEAD SCREW	1
106	262	NAME PLATE	1
107	3/32" DIA	RIVET	4
108	5/16" BSF	HEX LOCKNUTS	2

# Motor Leg and Drive Assembly

# Union



# Motor Leg and Drive Assembly

MACHINE SUPPLIED WITH MICRO SWITCHES ON HINGED COVERS

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	JL-308	MOTOR LEG	1
2	JL-312	COVER	1
3	JL-66	HINGE	1
4	3/16" BSW x 3/8"	SOCKET COUNTERSUNK HEADED SCREW	6
5	104	SPEED PLATE 50HZ	1
6	169	SPEED PLATE 60HZ	1
7	3/32" dia	RIVET	4
8	SG-170/ JL-335/JL-400	LATCH ASSEMBLY	1
9	3/16" BSW x 3/8"	SOCKET HEAD CAP SCREW	1
10	SP 300	"PRESS TO OPEN" TRANSFER	1
11	JL-329	DOOR	1
12	JL-66	HINGE	1
13	3/16" BSW x 3/8"	SOCKET COUNTERSUNK HEADED SCREW	6
14	JL-401	STUD	1
15	JL-323	MAIN SPINDLE	1
16	LJ-40	BALL BEARING (METRIC)	1
17	JL-326	SPACER BUSH	1
18	3/8" BSW x 3/4"	SOCKET SET SCREW DOG POINT	1
19	1/8" GAS	BRASS GREASE CUP NO.1	1
20	JL-324	HEAD PULLEY	1
21	3/8" BSW x 3/4"	SOCKET SET SCREW (1/2" DOG POINT WITH NYLON PATCH)	1
22	JL-326	SPACER BUSH	1
23	3/4" BSW x 1/2"	SOCKET SET SCREW (CUP POINT)	1
24	1/8" GAS	BRASS GREASE CUP NO.1	1
25	XXLJ-50	BALL BEARING (METRIC)	1
26	JL-327	BEARING BUSH	1
27	5/16" BSW x 5/8"	SOCKET SET SCREW (DOG POINT)	1
28	JL-341	SPINDLE NOSE COVER	1
29	CHAIN 13" LONG	CHROME PLATED CHAIN	1
30	3/16" BSW x 1/2"	ROUND HEAD SET SCREW	2

# Motor Leg and Drive Assembly

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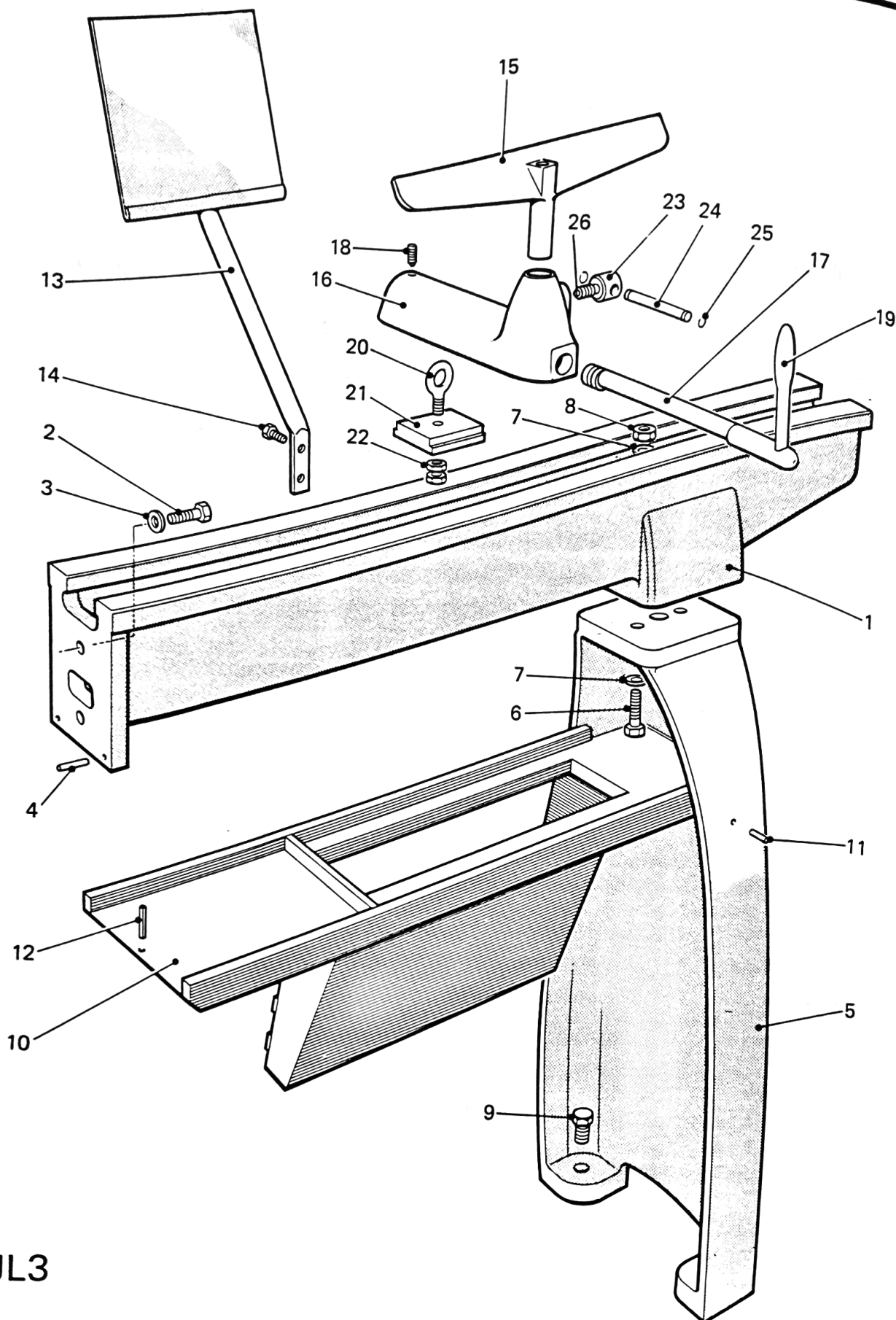
ITEM NO.	PART NO.	DESCRIPTION	QTY.
31	JL-348	FIXING SCREW	1
32	¼" dia x ¾"	STRAIGHT PIN	1
33	JL-287C	MOTOR PLATFORM (D80 3ph & 1ph)	1
34	JL-318	PLATFORM SPINDLE	1
35	3/8" BSW x ¾"	SOCKET SET SCREW (½ DOG POINT)	1
36	3/8" BSW	HEX LOCKNUT	1
37	5/16" BSW x 3/8"	SOCKET HEAD SET SCREW (½ DOG POINT) WITH NYLON PATCH	1
38	JL-319	STUD	1
39	2BA x ¼"	SOCKET HEAD SET SCREW (CUP POINT)	1
40	JL-320A	ECCENTRIC SHAFT	1
41	JL-376	HANDLE	1
42	BB4	BAKELITE BALL	1
43	3/16" dia x ½"	STRAIGHT PIN	1
44	JL-321	TURNBUCKLE STUD (RH)	1
45	JL-321B	TURNBUCKLE STUD (LH)	1
46	JL-322	TURNBUCKLE	1
47	JL-328	COLLAR	1
48	2BA x ¼"	SOCKET HEAD SET SCREW (CUP POINT)	1
49	JL-387	PIN	1
50	JL-408	FIXING COLLAR	1
51	5/16" BSW x 3/8"	SOCKET SET SCREW (CUP POINT) WITH NYLON PATCH	1
52	JL-73E	MOTOR PULLEY (D80)	1
53	JL-457	SPACER	4
54	5/16" BSW x 1½"	HEXAGON HEADED SET SCREW	4
55	5/16"	STANDARD WASHER	4
56	D80	¾ HP, 1500 RPM MOTOR (3ph) OR	1
	D80	1 HP, 1500 RPM MOTOR (3ph) OR	1
	D80	1 HP, 1500 RPM MOTOR (1ph) OR	1
	56 FRAME	¾ HP, 1500 RPM MOTOR (1ph)	1
57	6 x 5 x 40	RECTANGULAR KEY	1
58	¼" BSW x 5/8"	SOCKET SET SCREW (CUP PT) WITH NYLON PATCH	1

# Motor Leg and Drive Assembly

ITEM NO.	PART NO.	DESCRIPTION	QTY.
59	A66	PREMIUM VEE BELT	1
60	JL-145	LOUVRED COVER (1 HP MOTORS ONLY)	1
61	¼" BSW x ½"	ROUND HEAD SET SCREW	1
62	JL-145	LOUVRED COVER (1 HP MOTOR ONLY)	1
63	¼" BSW x ½"	ROUND HEAD SET SCREW	1
64	G20-216	PROTECTIVE BOX	1
65	G20-215A	STARTER MOUNTING PLATE	1
66	3/16" BSW x ½"	RAISED COUNTERSUNK HEADED SET SCREW CHROME PLATED	2
67	CT10	STARTER & OVERLOAD (STATE SUPPLY VOLTAGE ETC WHEN ORDERING)	1
68	935	PUSHBUTTON PLATE	1
69	MHI-6-206	GASKET (PUSHBUTTON PLATE)	1
70	3/16" BSW x ½"	ROUND HEAD SET SCREW	4
71	P-r/k (red)	MUSHROOM HEADED STOP PUSHBUTTON & CONTACT BLOCK	1
72	D-12/k (green)	START PUSHBUTTON & CONTACT BLOCK	1
73	JL-138	OUTSIDE FACEPLATE 14" DIA (see accessory list for additional faceplates)	1
74	JL-367	DRIVER PLATE 8" DIA NOT ILLUSTRATED	1
75	L5-10-193	FORK CENTRE	1
76	L5-585	CONE CENTRE NOT ILLUSTRATED	1
77	L5-875	CUP CENTRE NOT ILLUSTRATED	1
78	5/16" BSW	HEX NUT	1
79	5/16" BSW x ½"	HEX HEADED SET SCREW	1
80	3BR	MICRO SWITCH	1
81	4BA x 1½"	SOCKET COUNTERSUNK SET SCREW	2
82	4BA	STANDARD NUT	2
83	M3BRM	MICRO SWITCH	1
84	4BA x 1¼"	CHEESE HEAD SET SCREW	2
85	JL-345	BRACKET	1
86	¼" BSW x 3/8"	HEX HEADED SET SCREW	1

# Bed and Rest Assembly

# Union



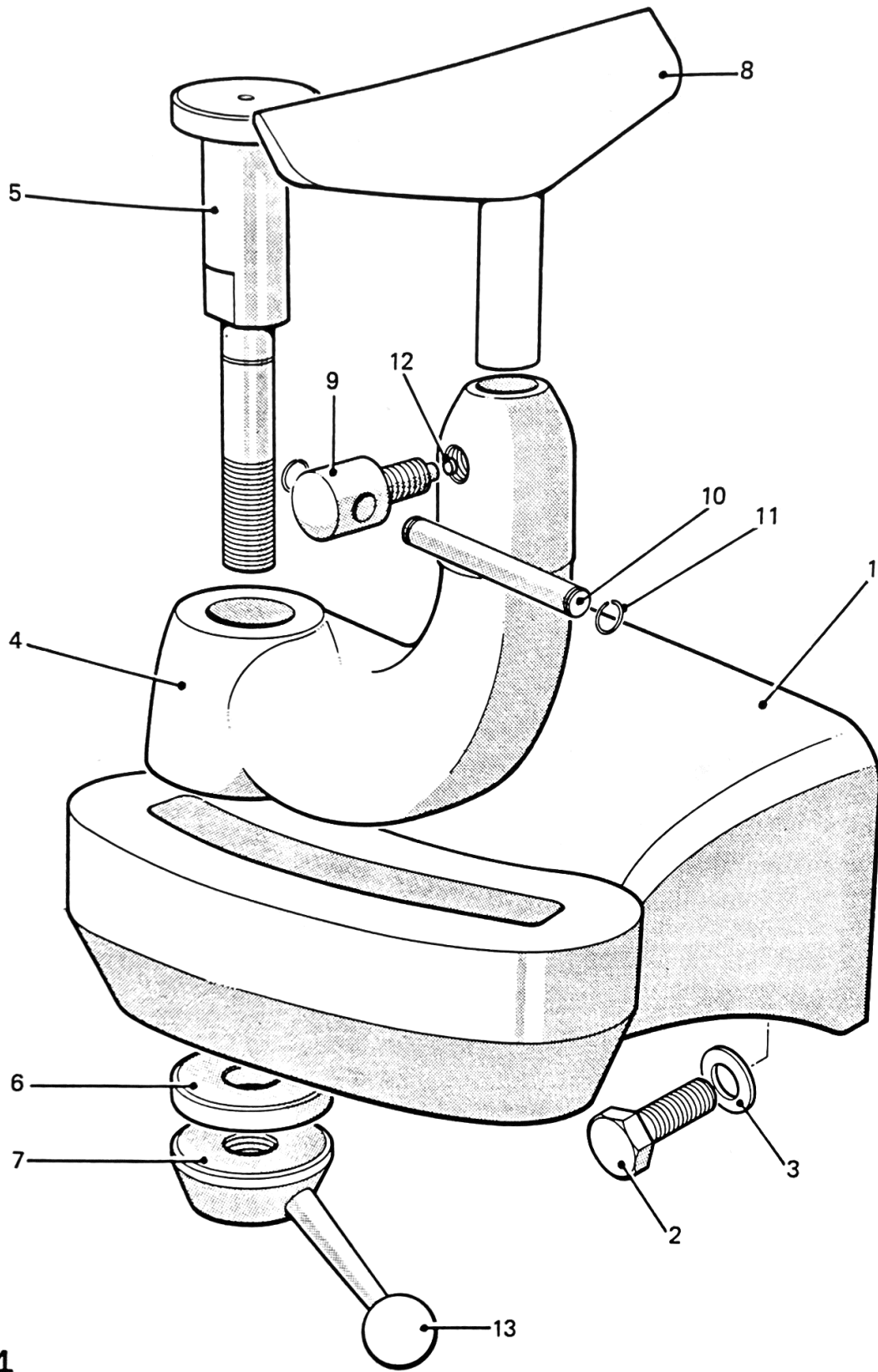
JL3

# Bed and Rest Assembly

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	JL-6G	BED TO ADMIT 30 IN. CENTRES	1
	JL-6H	BED TO ADMIT 42 IN. CENTRES	1
	JL-6J	BED TO ADMIT 54 IN. CENTRES	1
2	½" x 1½" FH	SCREW HEX HEAD	2
3	½" FW	WASHER	2
4	¼" x 1½" PR	PIN	2
5	JL-331	LEG	1
6	½" x 1½" FH	SCREW HEX HEAD	2
7	½" FW	WASHER	4
8	½" FN	NUT	2
9	L5-1-42	SCREW JACKING	2
10	JL-343	TOOL TRAY 30 IN.	1
	JL-343A	TOOL TRAY 42 IN. CENTRES	1
	JL-343B	TOOL TRAY 54 IN. CENTRES	1
11	¼" x 1" PR	PIN	2
12	¼" x 1¼" PR	PIN	1
13	JL-273A	DRAWING HOLDER	1
14	5/16" x ¾" FH	SCREW HEX HEAD	2
15	JL-314	TEE - LONG (14 IN.)	1
	JL-313	TEE - SHORT	1
16	JL-334	HANDREST BASE	1
17	JL-46	SHAFT ECCENTRIC	1
18	3/8" x ¾" FO	SCREW GRUB DOG POINT	1
19	JL-300	LEVER LOCKING	1
20	L2A-62	EYE BOLT	1
21	L2A-48	PLATE, HOLDING PLATE	1
22	½" FL	LOCKNUT	2
23	JL-392A	NIPPING STUD	1
24	JL-393	LEVER	1
25	JL-391	CLIP LEVER RETAINING	2
26	JL-382	DIE PIECE	1

# Outside Rest & Swivel Arm Assembly

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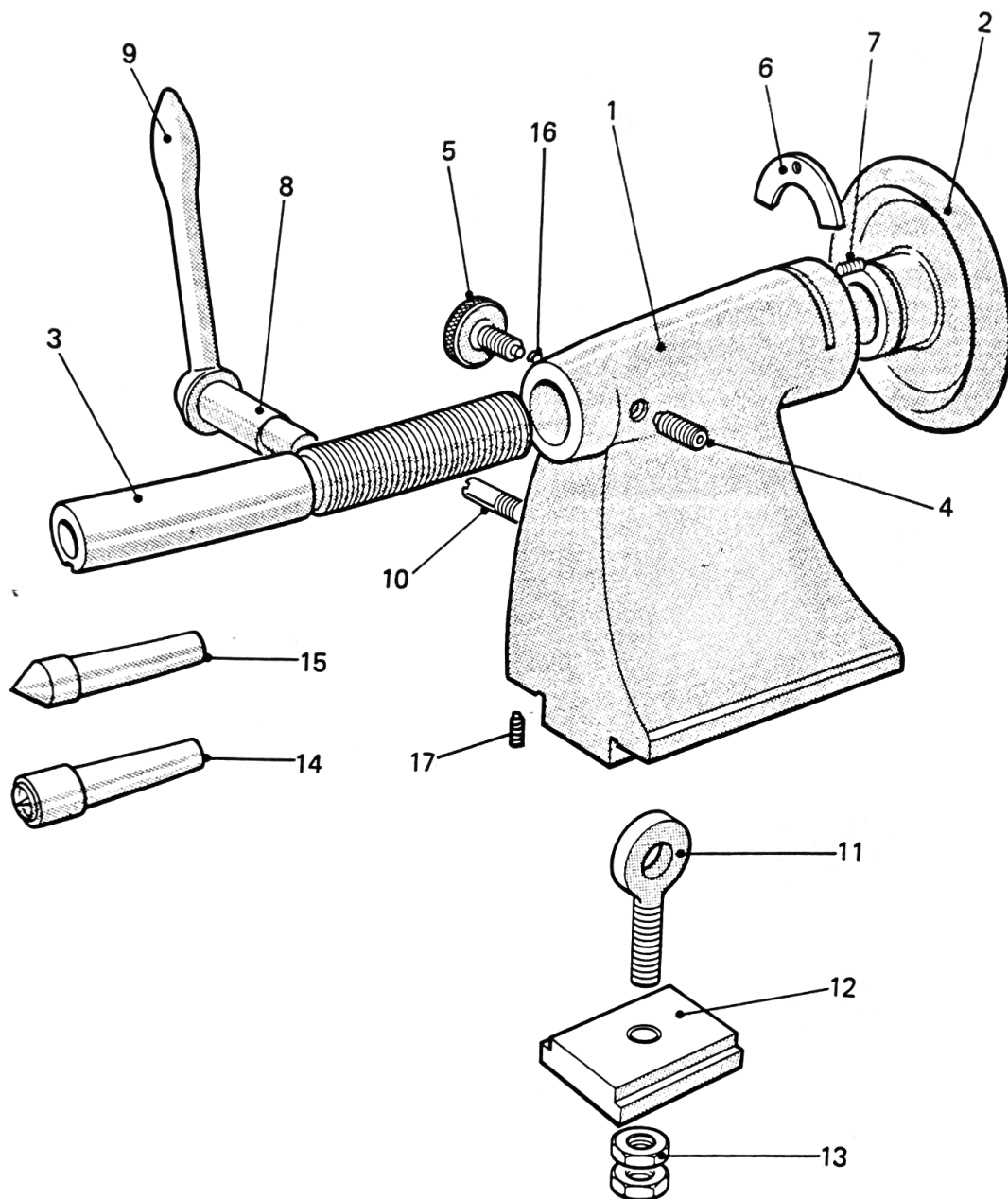
JL4



# Outside Rest & Swivel Arm Assembly

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ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	JL-309A	OUTSIDE REST ARM	1
2	½" x 1½" FH	SCREW HEX HEAD	3
3	½" FW	WASHER	3
4	JL-311A	SWIVEL ARM	1
5	JL-315A	LOCKING STUD	1
6	JL-316	PLATE	1
7	JL-28	LEVER LOCKING	1
8	JL-313	TEE REST (SHORT 7½ IN.)	1
9	JL-392	NIPPING STUD	1
10	JL-393	LEVER	1
11	JL-391	CLIP, LEVER RETAINING	2
12	JL-382	DIE PIECE	1
13	BBI	BAKELITE BALL	1



JL5

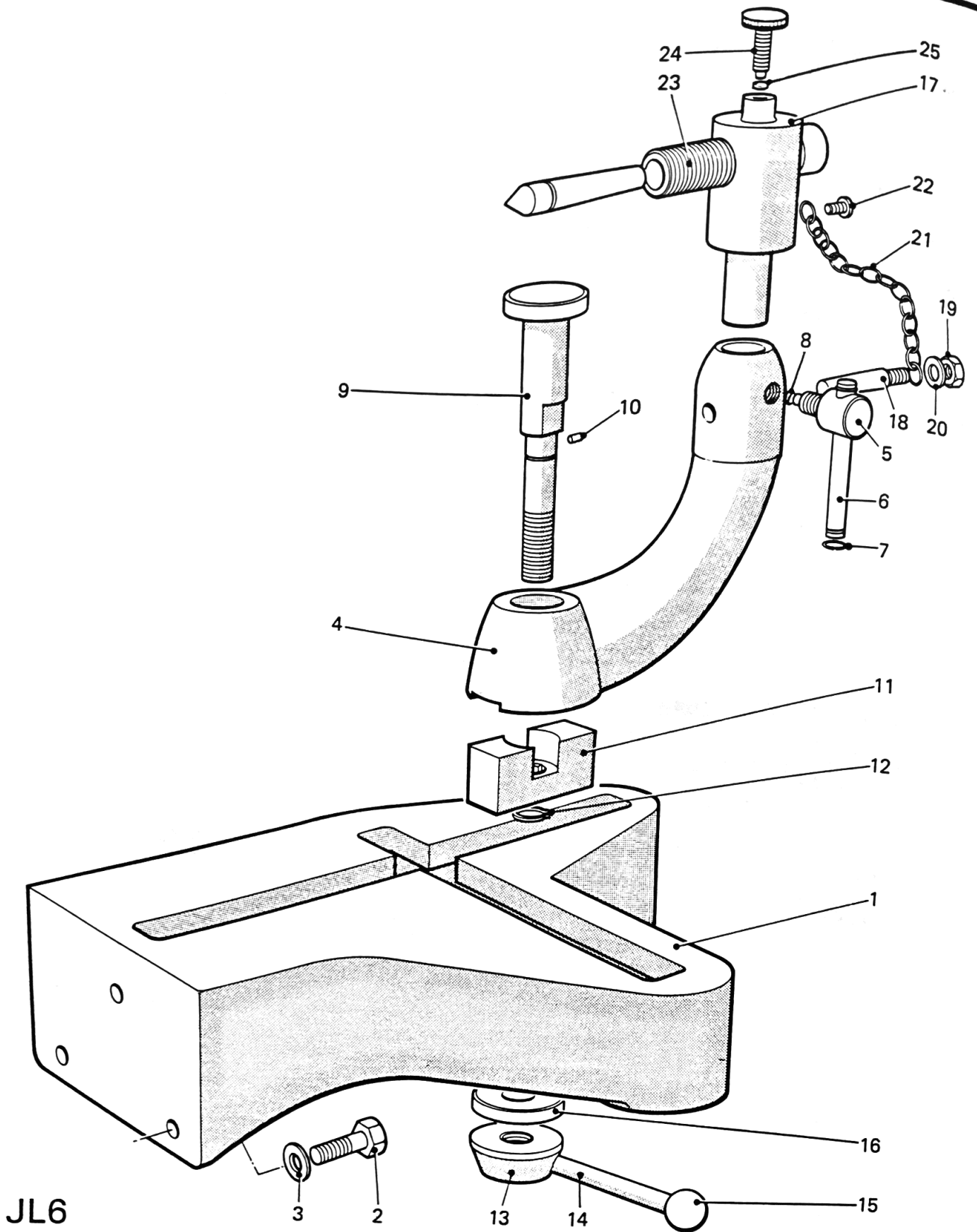
ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	JL-333	TAILSTOCK BODY	1
2	JL-135A	HANDWHEEL	1
3	JL-133A	SPINDLE	1
4	3/8" BSW x 3/4" FO	SOCKET SET SCREW DOG POINT	1
5	JL-298	LOCKING SCREW	1
6	L2A 58	COLLAR	1
7	3/16" BSW x 3/4" FO	SOCKET SET SCREW CUP POINT	1
8	L2A-60	ECCENTRIC STUD	1
9	JL-300	LOCKING LEVER	1
10	L6-7-41	PIN STOP	1
11	L2A-66	EYE BOLT	1
12	L2A-48	HOLDING DOWN PLATE	1
13	1/2" FL	LOCKNUT	2
14	L5-875	CENTRE CUP	1
15	L5-585	CENTRE CONE	1
16	JL-299	DIE PIECE	1
17	3/8" BSW x 1/2"	SOCKET SET SCREW DOG POINT	1

**PARTS REQUIRED FOR LEVER OPERATED TAILSTOCK (NOT ILLUSTRATED)**

JL-420	TAILSTOCK BODY	1
L16-7-41	STOP PIN	1
JL-169	QUILL	1
JL-85	LEVER	1
JL-118	HANDLE	1
JL-48	LINK	1
JL-83	SWIVEL STUD	2
JL-170	FULCRUM PIN	1
JL-298	NIPPING SCREW	1
JL-299	DIE PIECE	1
L2A-60	ECCENTRIC STUD	1
3/8" BSW x 3/4"	SOCKET SET SCREW CUP POINT	1
L2A-66	EYE BOLT	1
L2A-48	HOLDING DOWN PLATE	1
1/2" BSW	HEX NUT	2
JL-300	LOCKING LEVER	1

# Short Bed & Swivel Arm Assembly

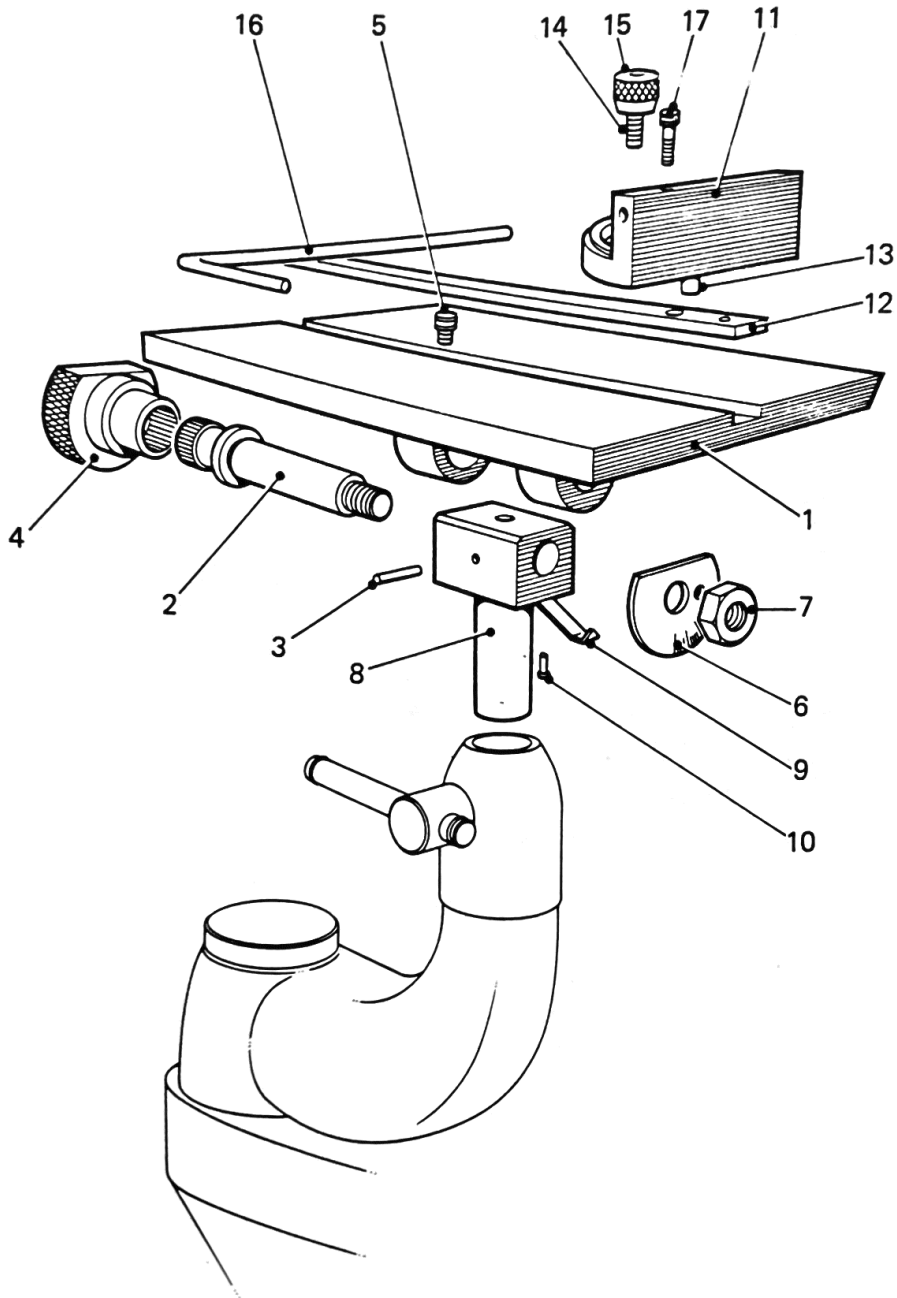
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JL6

# Short Bed & Swivel Arm Assembly

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	JL-423A	SHORT BED	1
2	½" x 1½" BSW	SCREW HEX HEAD	3
3	½" WN	WASHER	3
4	JL-311B	SWIVEL ARM	1
5	JL-392	NIPPING STUD	1
6	JL-393	LEVER	1
7	1000-43	CIRCLIP PLAIN WIRE	2
8	JL-382	DIE PIECE	1
9	JL-315B	LOCKING STUD	1
10	3/16" x 3/8"	PIN GROOVED	1
11	JL-425	BLOCK, TENON	1
12	1400 x ¾"	CIRCLIP EXTERNAL	1
13	JL-28	PILLAR LOCKING BOSS	1
14	L16-10-95	LEVER	1
15	BBI	BALL 1 IN. DIA.	1
16	JL-316	PLATE	1
17	JL-427	CENTRE BLOCK	1
18	JL-430	DOWEL REMOVABLE	1
19	3/8" UNC	HEX NUT	1
20	3/8" WN	WASHER	1
21	4"	CHAIN, BRASS	1
22	2BA x ½"	SCREW ROUND HEAD	2
23	JL-428	SPINDLE	1
24	JL-298	LOCKING SCREW	1
25	JL-299	DIE PIECE	1

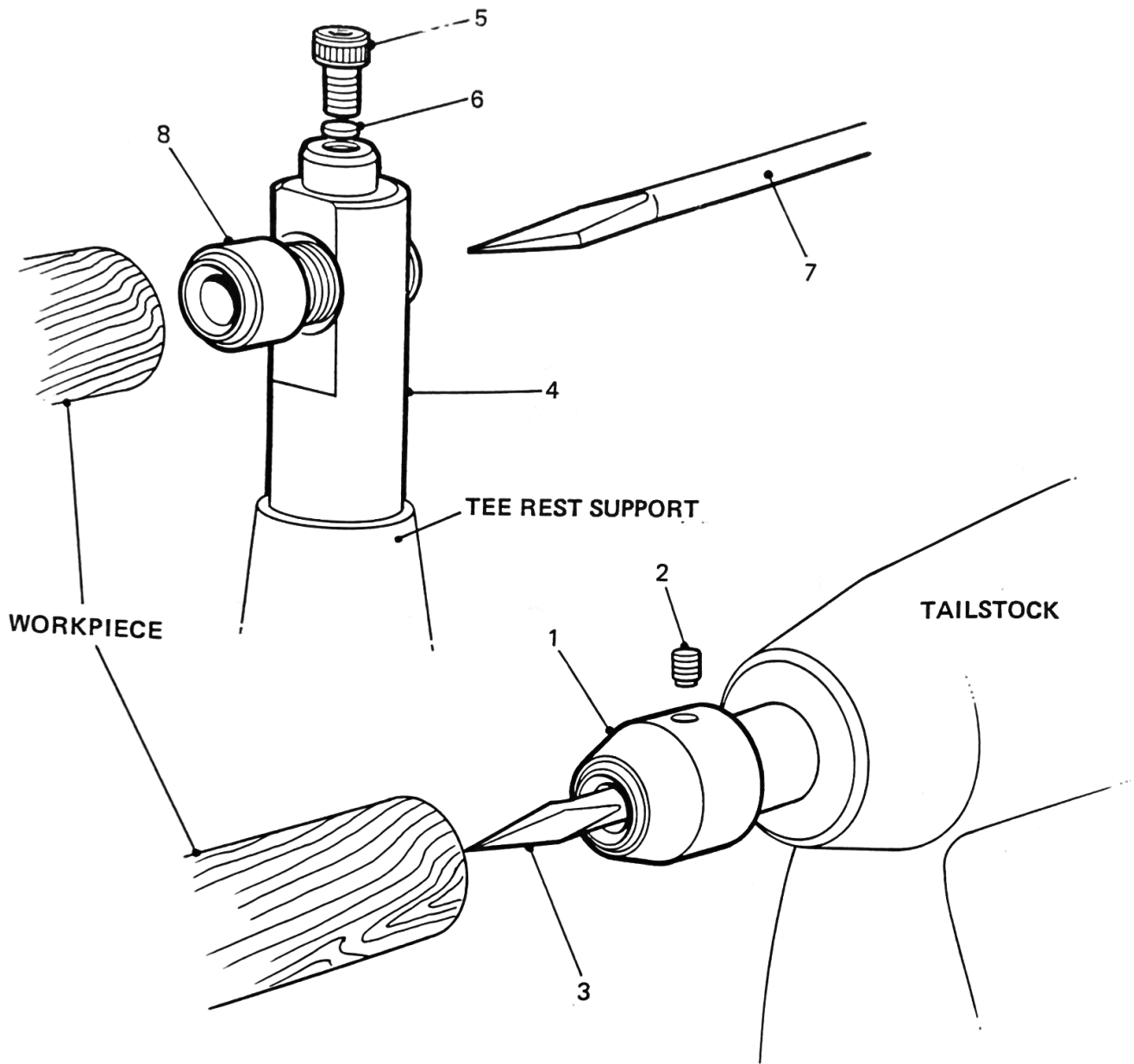


JL7

# Sanding Table Assembly

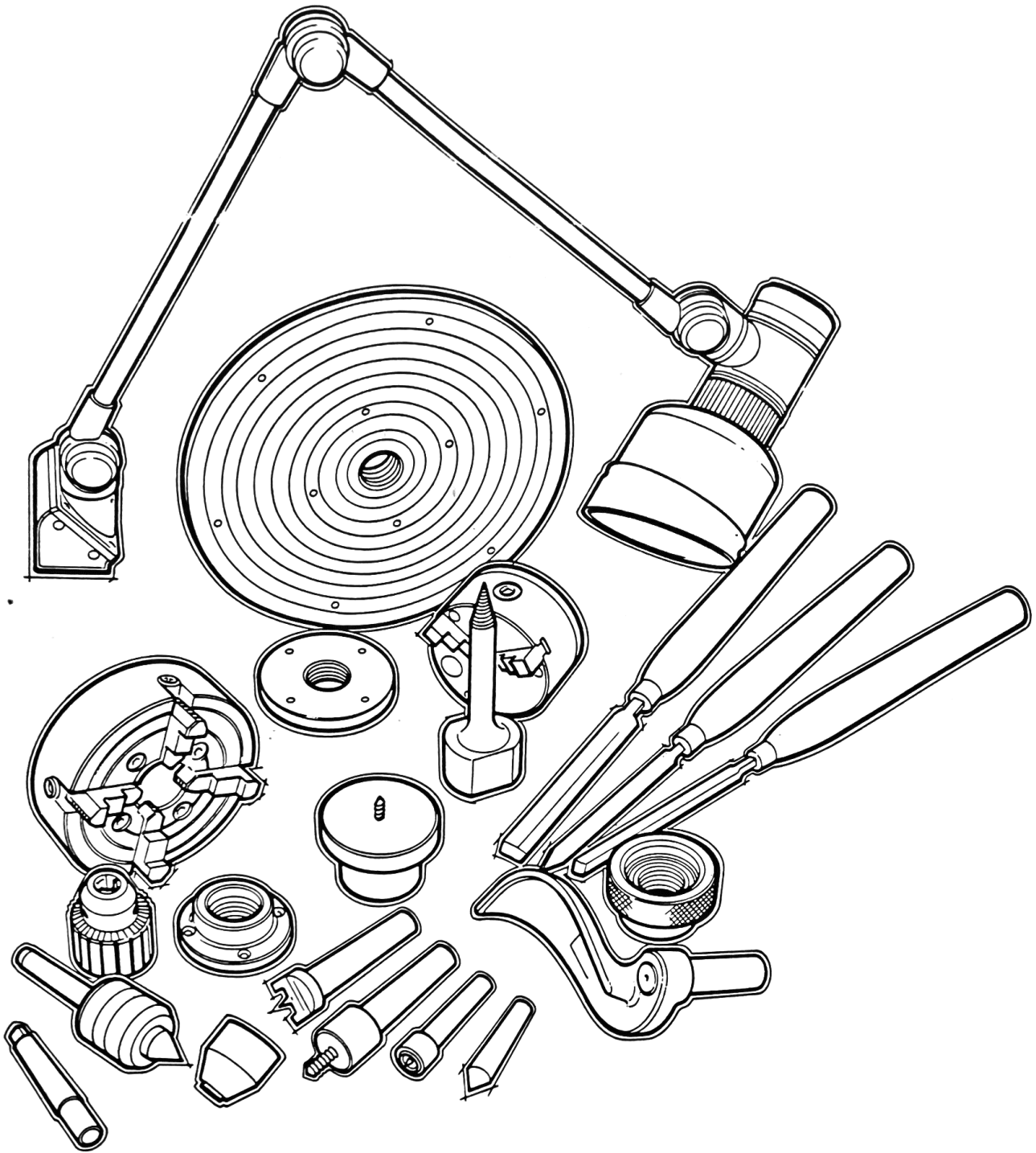
union

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	JL-189	SANDING TABLE	1
2	JL-105	SWIVEL STUD	1
3	3/16" PT x 1.3/8"	TAPER PIN	1
4	JL-106	INDEXING NUT	1
5	JL-107	STOP	1
6	JL-111	INDEXING WASHER	1
7	1/2" FN	NUT	1
8	JL-191A	ADJUSTABLE COLUMN	1
9	JL-112	INDEX POINTER	1
10	3/32" DIA.	RIVET	2
11	JL-192	MITRE GAUGE	1
12	JL-193	TENON PIECE	1
13	JL-205	PIVOT PIN	1
14	JL-204	NIPPING STUD	1
15	JL-203	NIPPING NUT	1
16	JL-207	LENGTH GAUGE	1
17	2BA FY 3/4"	SOCKET HEAD CAP SCREW	1





ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	JL-368	CENTRE ADAPTOR 5/16" DIA.	1
	JL-368A	CENTRE ADAPTOR 7/16" DIA.	1
2	1/4" BSW x 5/16"	SOCKET SET SCREW CUP POINT	1
3	JL-212	BORING TOOL 5/16" DIA.	1
	JL-213	BORING TOOL 7/16" DIA.	1
4	JL-214	ADAPTOR FOR PILOT BUSHES	1
5	5/16" BSW x 1 1/4"	SOCKET CAP SCREW	1
6	L5-1-15	DIE PIECE	1
7	JL-213	BORING TOOL 7/16" DIA.	1
8	JL-215	PILOT BUSH 7/16" DIA.	1



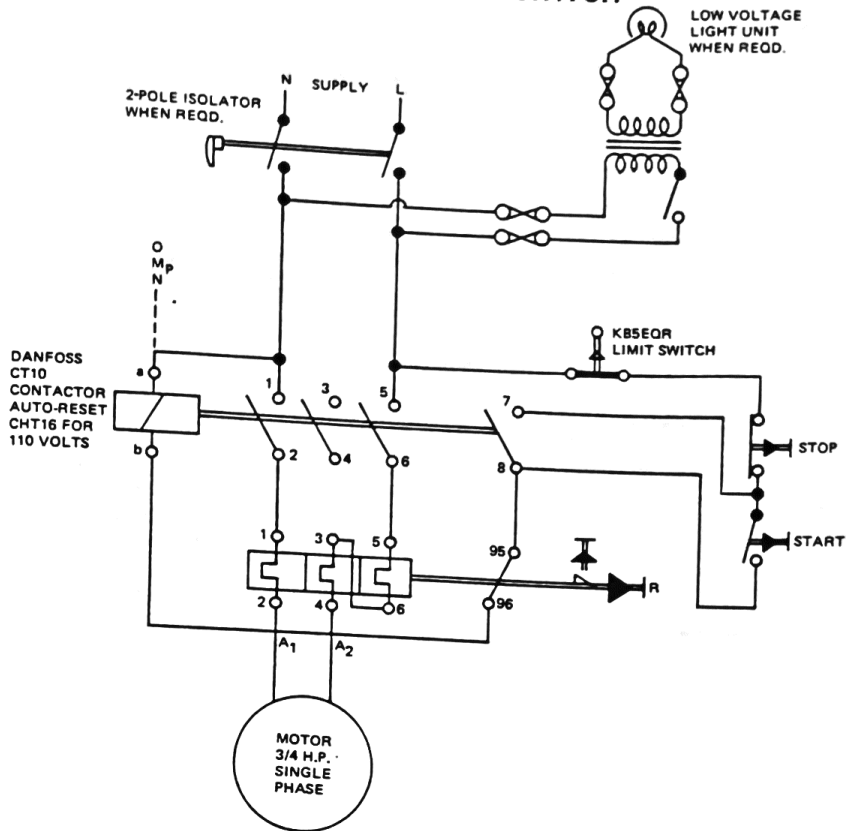
# Additional Equipment

ITEM NO.	PART NO.	DESCRIPTION	QTY.
	JL-349	KNOCK OUT BAR	1
	3/8" WHIT	OPEN SINGLE ENDED SPANNER	1
		FOOT OPERATED STOP SWITCH	1
	JL-177	12" DIA SANDING DISC (RH) INNER	1
	JL-177A	12" DIA SANDING DISC (LH) OUTER	1
	JL-365	3" DIA FACE PLATE (RH) INNER	1
	JL-365A	3" DIA FACE PLATE (LH) OUTER	1
	JL-366	4" DIA FACE PLATE (RH) INNER	1
	JL-366A	4" DIA FACE PLATE (LH) OUTER	1
	JL-364	6" DIA FACE PLATE (RH) INNER	1
	JL-160A	6" DIA FACE PLATE (LH) OUTER	1
	JL-367A	8" DIA FACE PLATE (LH) OUTER	1
	JL-159B	12" DIA FACE PLATE (RH) INNER	1
	JL-159	12" DIA FACE PLATE (LH) OUTER	1
	JL-167	BELL CHUCK (2" CAPACITY) RH INNER	1
	3/8" BSW x 1 1/2"	SOCKET SET SCREW (CLIP POINT)	8
	JL-355	EGG CUP TURNING CHUCK	1
	JL-247	CLAMPING RING	1
	3/16" x 1/2"	STRAIGHT PIN	1
	WR 19	WRENCH	1
	JL-149	SCREW CHUCK 3/4" DIA RH INNER	1
	No.16 x 1 1/2"	WOOD SCREW RH	1
	JL-149A	SCREW CHUCK 3/4" DIA LH OUTER	1
	JL-17A	WOOD SCREW LH	1
	1/4" BSW x 3/4"	SOCKET SET SCREW CUP POINT	1
	1540-91601	6" - 4 JAW CHUCK TYPE 54	1
	JL-275	BACK PLATE	1
	1580-01005	4" - 3 JAW CHUCK TYPE 58	1
	JL-148	BACK PLATE	1
	5/16" BSW x 1"	HEX HEAD SET SCREW	3
	No.34	1/2" DRILL CHUCK	1
	No.2	MORSE TAPER ARBOR	1
	No.2 MT	REVOLVING CENTRE	1
	L5-10-194	SCREWED CENTRE	1

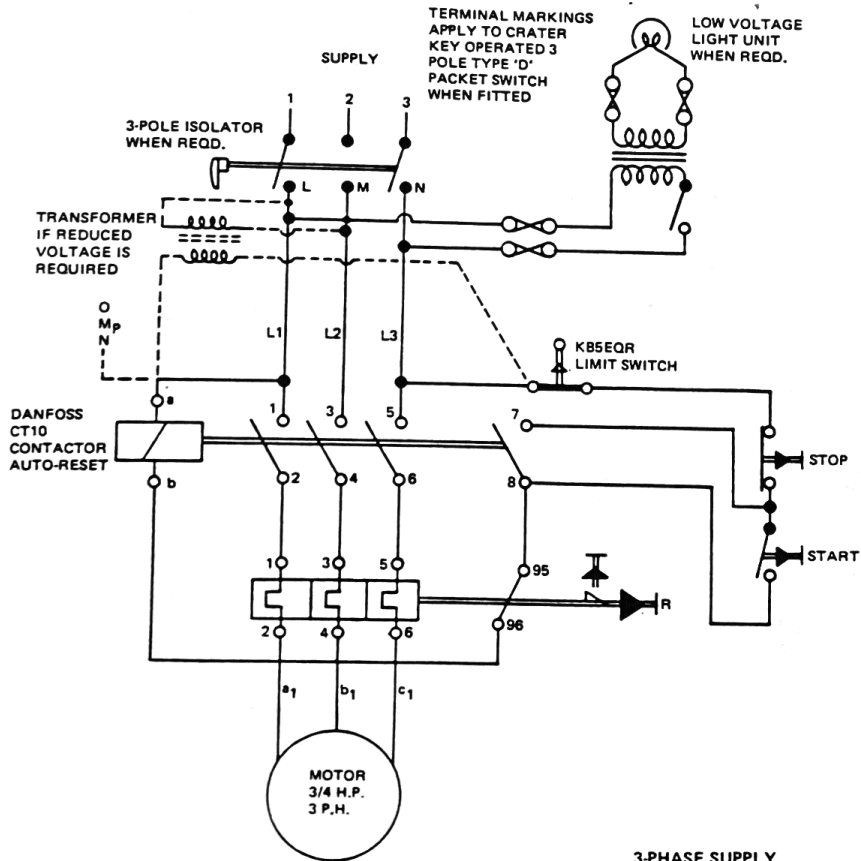
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ITEM NO.	PART NO.	DESCRIPTION	QTY.
	JL-174	SPINDLE EXTENSION	1
	JL-344A	REST – BOWL TURNING	1
	JL-386	SHAFT – BOWL TURNING REST	1
	3/16" x 1 1/2"	TAPER PIN	1
	No.5506	STANDARD WOOD TURNING TOOLS	1 set
	No.2007	'LONG & STRONG' WOOD TURNING TOOLS	1 set
	JL-394	REAR CHIP GUARD 30" CENTRE MACHINE	1
	JL-394A	REAR CHIP GUARD 42" CENTRE MACHINE	1
	JL-394B	REAR CHIP GUARD 54" CENTRE MACHINE	1
	JL-395	MAIN BRACKET	2
	JL-396	OUTER BRACKET	1
	JL-397	TOP STAY	1
	JL-398	END STAY	1
	1/4" BSW x 1/2"	SOCKET HEAD CAP SCREW	7
	1/4" BSW x 5/8"	HEX HEAD SET SCREW	5
	1/4"	STANDARD WASHER	12
	2BA x 1/2"	SOCKET HEAD CAP SCREW	1
	2BA x 1/2"	SOCKET COUNTERSUNK HEAD SET SCREW	2
	1/4" BSW x 5/8"	SOCKET COUNTERSUNK HEAD SET SCREW	2
	TI-LL-ST	LOVO-LITE ARM (400 x 400)	1
	T22/12	TRANSFORMER 200/250V PRIMARY 12V SECONDARY	1
	T22/25	TRANSFORMER 200/250V PRIMARY 25V SECONDARY	1
	T22/50	TRANSFORMER 200/250V PRIMARY 50V SECONDARY	1
	T34/12	TRANSFORMER 346/440V PRIMARY 12V SECONDARY	1
	T34/25	TRANSFORMER 346/440V PRIMARY 25V SECONDARY	1
	T34/50	TRANSFORMER 346/440V PRIMARY 50V SECONDARY	1
	JL-352A	BRACKET	1

## MACHINE SUPPLIED WITH POSITIVE ACTION LIMIT SWITCH



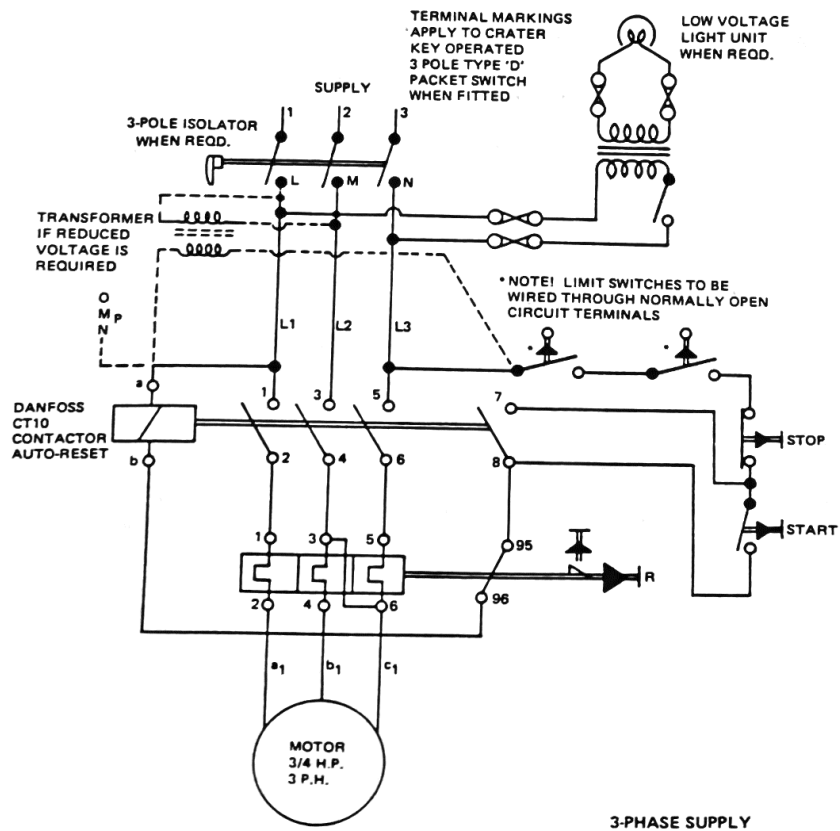
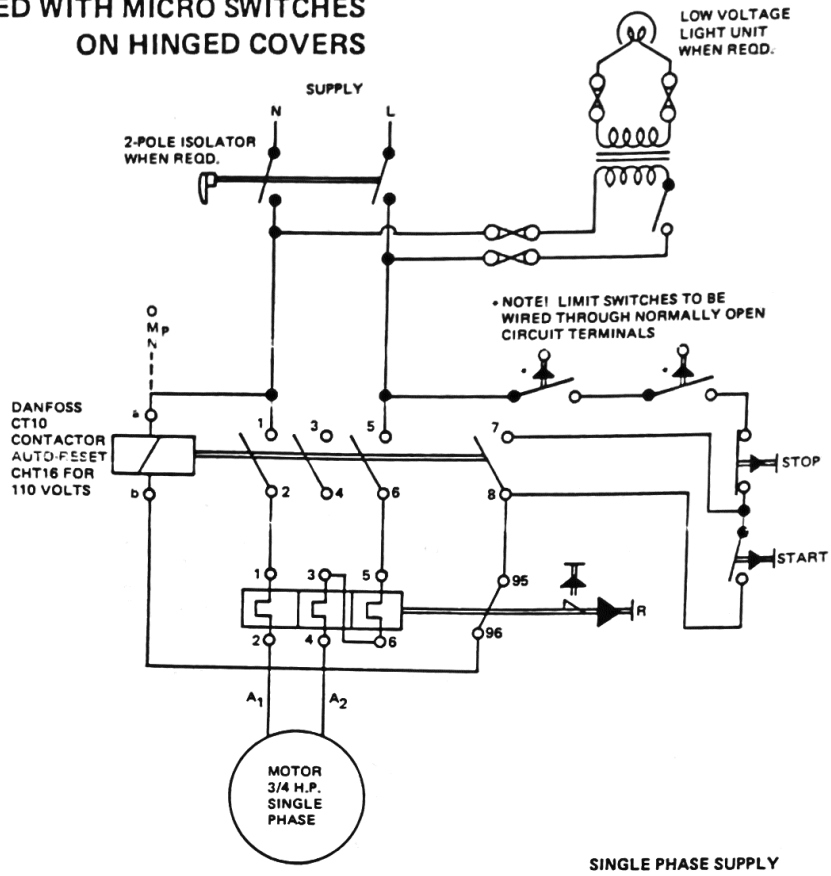
SINGLE PHASE SUPPLY



3-PHASE SUPPLY

# Wiring Diagram

## MACHINE SUPPLIED WITH MICRO SWITCHES ON HINGED COVERS



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