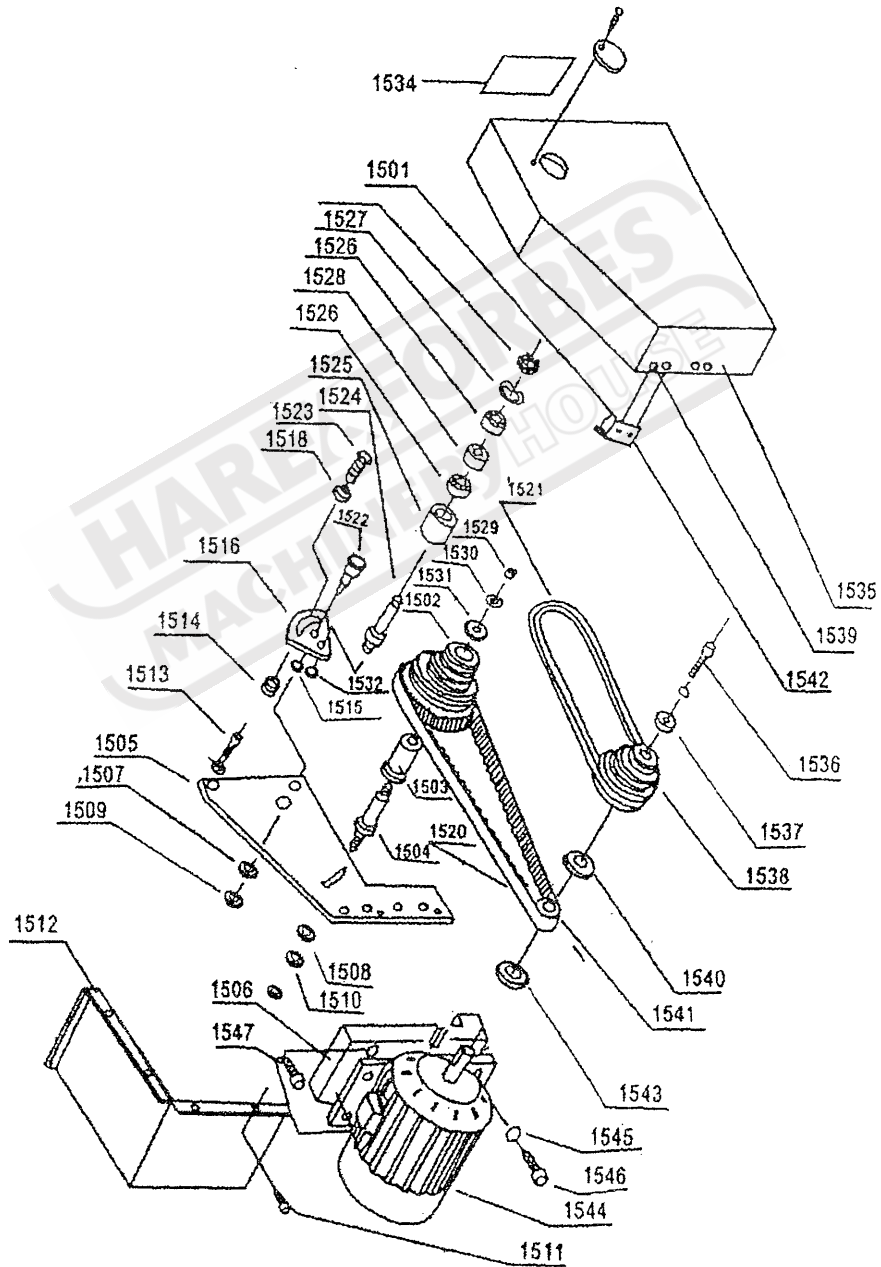


Form 3 Bearings

No	Name	Type	Specification	Qty	Position
5	Single row taper bearing	2007107	35 × 62 × 17	2	Head stock
7	Single row thrust bearing	8101	12 × 26 × 9	1	Saddle
20	Single row thrust bearing	8101	12 × 26 × 9	1	Tail stock
23	Single row centripetal force bearing	101	12 × 28 × 8	2	Jam wheel
25	Single row centripetal force bearing	101	12 × 28 × 8	1	Change gear

Fig.3 Motor And Belt Wheels



Form4 Motor & pulley transmission

No.	Excused standard no.	Name	Qty	Notes
1501	GB96-52-67	Nut	3	M5
1502	15023	Synchromesh mid pulley	1	
1503	15021	Bearing	1	
1504	15020	Shaft	1	
1505	15022	Cover	1	
1506	GB96-76	Washer	1	12
1507	GB97-76	Washer	1	10
1508	GB52-76	Nut	1	M12
1509	GB52-76	Nut	1	M10
1510	GB54-76	Nut	1	M12
1511	GB818-76	Screw	4	M5×8
1512	15027	Cover	1	
1513	GB30-76	Threaded bolt	3	M10×20
1514	15025	Washer	1	
1515	15016	Washer	1	
1516	15026	Fan shaped support	1	
1517	15030	Support	1	
1518	GB97-76	Washer	1	8
1519	GB818-76	Screw	2	M5×12
1520		Serrated belt	1	M1.5×Z124
1521		Triangle belt	1	Otype762
1522	15015	Shaft	1	
1523	GB30-76	Bolt	1	M8×25
1524	15014	Shaft	1	
1525	15012	Jam wheel	1	
1526	101	Single row centripetal force bearing	2	12×28×8
1527	GB894-76	Spaver	1	12
1528	15013	Quill	1	
1529	R71-1	Oil seal	1	6
1530	GB894-76	Spacer	1	12
1531	15031	Washer	1	
1532	GB894-76	Spacer	1	12
1533	GB893-76	Spacer	1	28
1534	15029	Plate	1	
1535	15028	Cover	1	
1536	GB70-76	Screw	1	
1537	15017	Spacer	1	
1538	15018	Pulley	1	
1539	GB818-76	Screw	5	M5×8
1540	15024-1	Spacer	1	
1541	15024	Pulley	1	
1542		Hinge	1	75
1543	15024-2	Spacer	1	
1544	JZ7134	Motor	1	400/370W 500/550W
1545	GB97-76	Washer	4	8
1546	GB30-76	Bolt	4	M8×25

Fig.4-1 Bed Assembly(CJ9528)

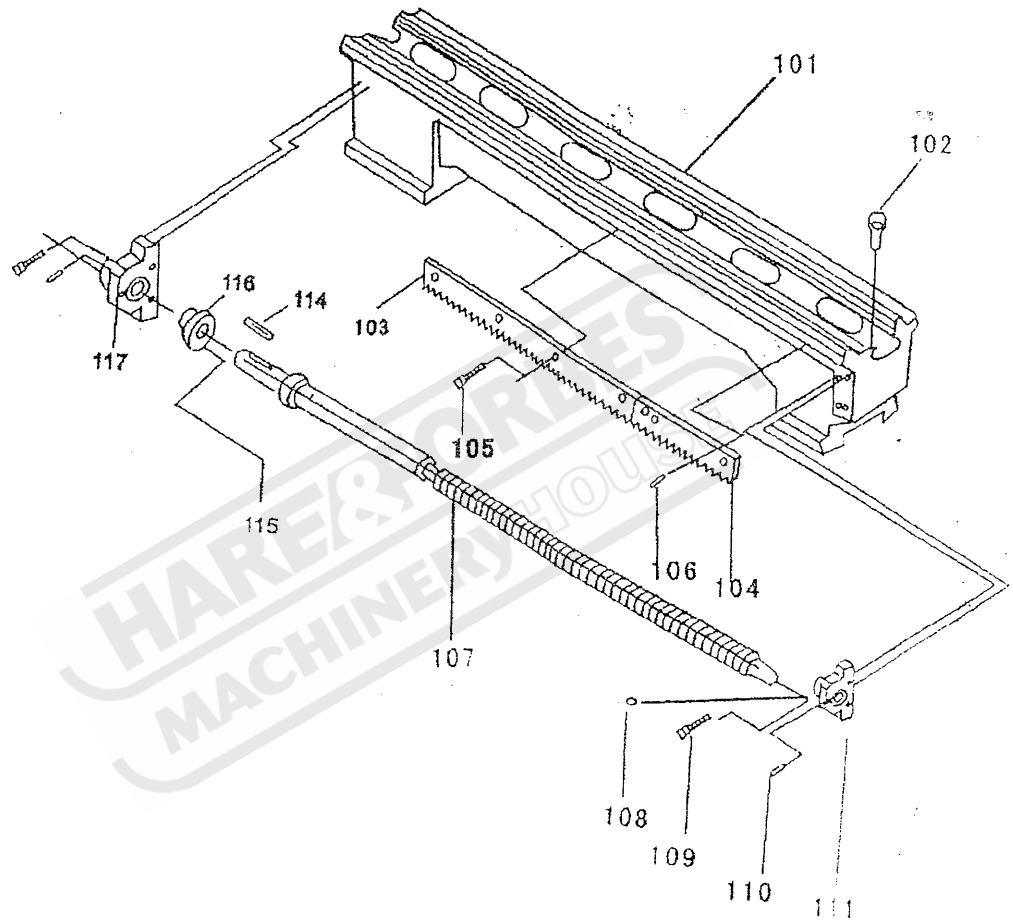
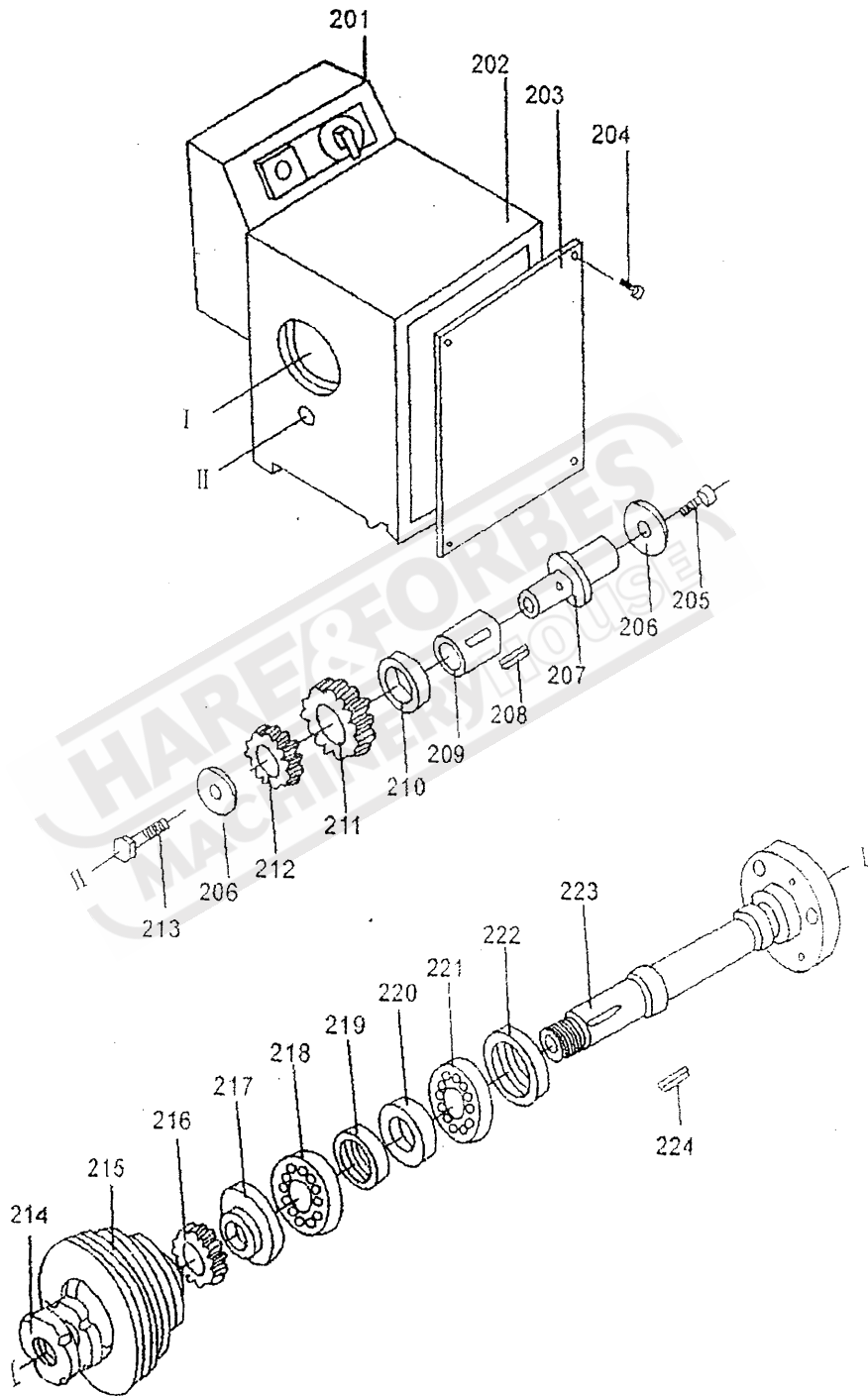


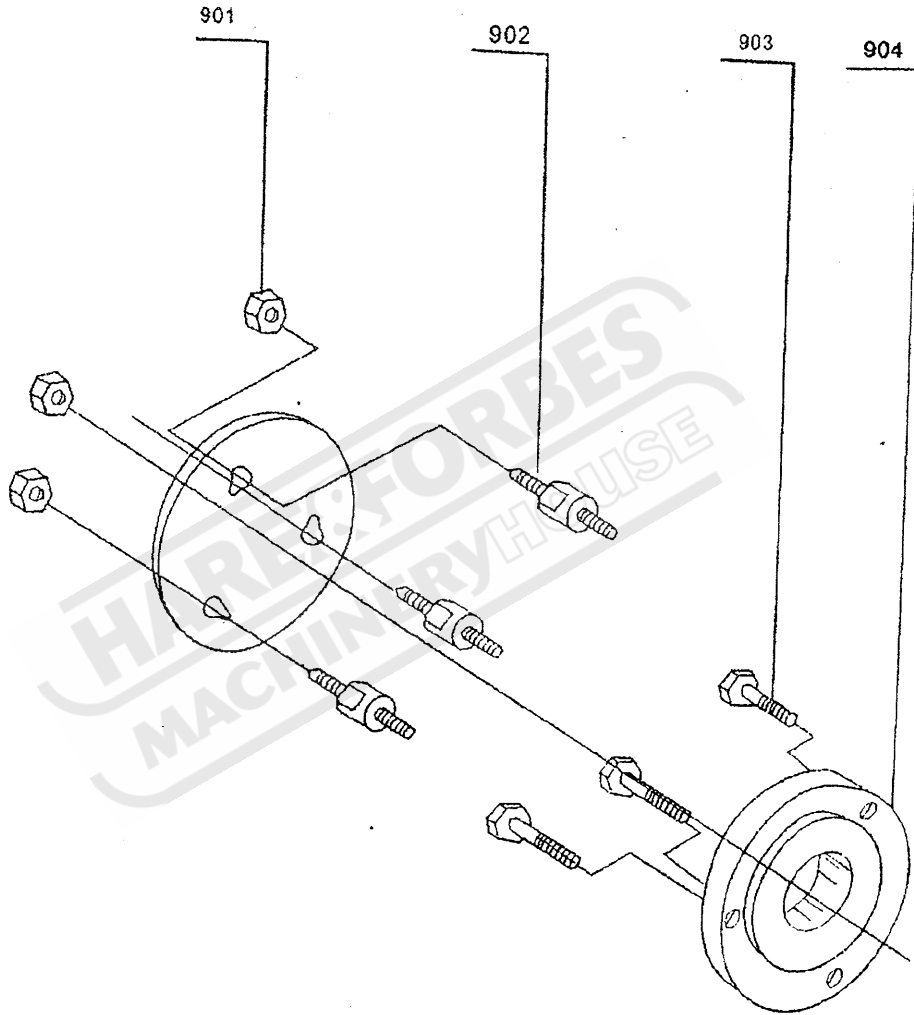
Fig.5-3 Head Stock(CJ9528)



Form7 Head stock (Fig5-3)

No.	Excused standard no.	Name	Qty	Notes
201	15032	Electric box	1	
202	02011	Head stock body	1	
203	02016	Face cover	1	
204	GB818-86	Screw	4	M3×6
205	GB70-85	Threaded bolt	1	M6×12
206	GB96-85	Washer	2	6
207	02027	Shaft	1	
208	GB1096-86	Key	1	4×20
209	02028	Quill	1	
210	08019	Loop	1	
211	08018A	Gear	1	Z52
212	08016	Gear	1	Z40
213	GB5783-86	Bolt	1	M6×16
214	GB812-88	Nut	1	M27×1.5
215	02020	Pulley	2	
216	02021	Gear	1	Z52
217	02025	Loop	1	
218	GB297-64	Bearing	1	2007107
219	02013	Oil seal	1	
220	02013	Oil seal	1	
221	GB297-64	Bearing	1	2007107
222	02013	Oil seal	1	
223	02012	Spindle	1	
224	GB1096-86	Key	1	4×50

Fig.5-4 3-jaw Chuck Base(CJ9528)



Form8 3-jaw chuck base(Fig5-4)

No.	Excused standard no.	Name	Qty	Notes
901	GB55-76	Nut	3	M10
902	09012	Bolt	3	
903	GB21-76	Bolt	3	M8×25
904	09011	3-jaw chuck base	1	

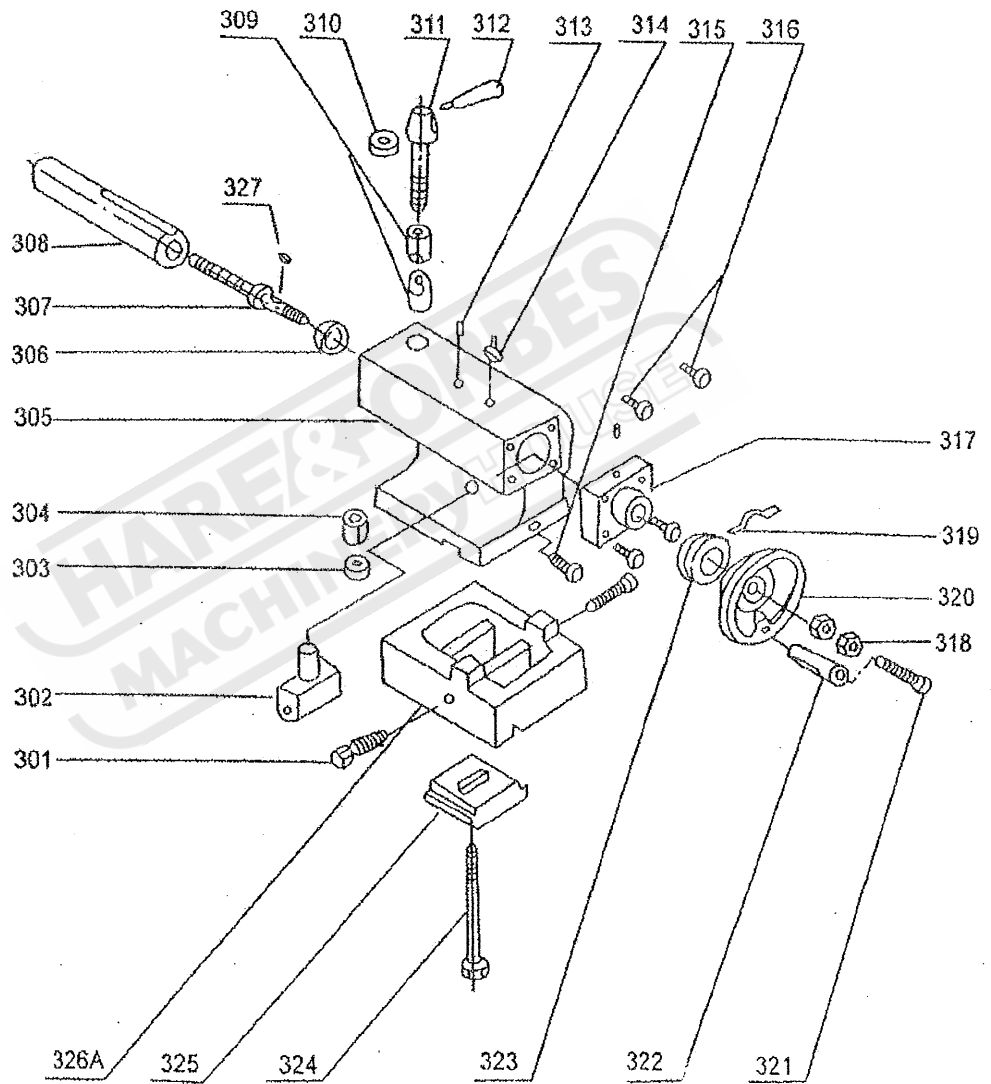
6、TAIL STOCK

See Fig 6-1

Tail stock is consisted of its base,sleeve,screw post,etc.It can be moved along the guiding rails, you can screw 304 Nut to fasten it at any position on the guiding rails. Then turn 320 Hand wheel to get the tail stock sleeve moving forward and backward to finish boring, tapping, reaming, cutting, etc. The manufacturing accuracy of the tail stock has reached the allowable error range. The zero central position line is carved in front of the 305 tail stock body and 326 tail stock base.If you need moving the tail stock axis to left and right side when cutting, adopt the following measures.

- 6.1 Loosen 304 Nut,you can move the tail stock.
- 6.2 Loosen 315 Nut
- 6.3 Adjust 301 screw slightly to move tail stock for the right process requirement.
- 6.4 Fasten 315 screw and 304 Nut to start operation.

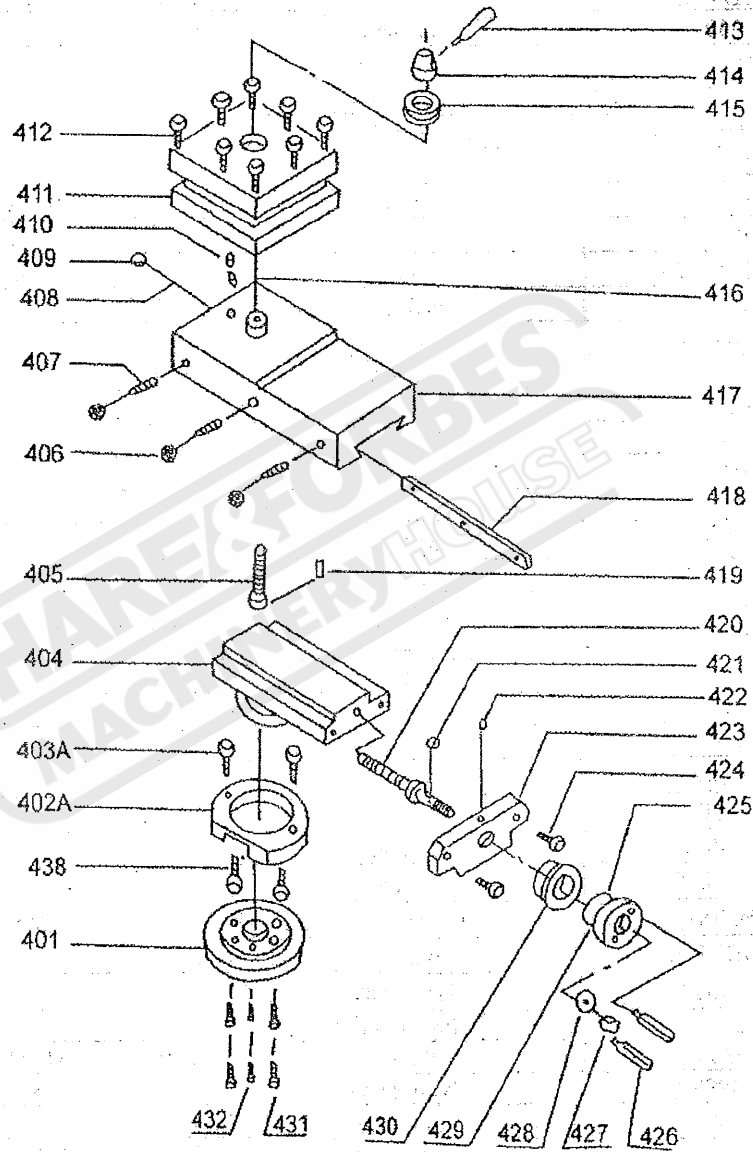
Fig.6-1 Tail Stock(CJ9528)



Form 9 Tail stock prats(Fig6-1)

No.	Excused standard no.	Name	Qty	Notes
301	GB70-76	Screw	2	M8×30
302	03013	Nut	1	
303	GB97-76	Washer	1	B12
304	GB55-76	Nut	1	M12
305	03011	Tail stock base	1	
306	8101	Single row thrust bearing	1	12×26×9
307	03016	Screw post	1	
308	03015	Sleeve	1	
309	03020	Jam Quill	1pair	
310	GB97-76	Washer	1	B8
311	03021	Screw Post	1	
312	03022	Handle	1	6
313	R71-1	Oil cup	2	
314	03019	T-shaped key	1	M6×16
315	GB75-76	Screw	1	M5×16
316	GB70-76	Screw	4	
317	03017	End cover	1	4×30
318	GB879-76	Nut	1	
319	04022	Pinch cock	1	
320	03018	Hand wheel	1	
321	06027A	T hreded bolt	1	
322	06027	Quill	1	
323	04021	Ring	1	
324	GB30-76	Threaded bolt	1	M12×100
325	03014	Gland	1	
326	03012	Gas	1	
326A	HD210-03012	Base	1	
327	GB1079-86	Key	1	4×12

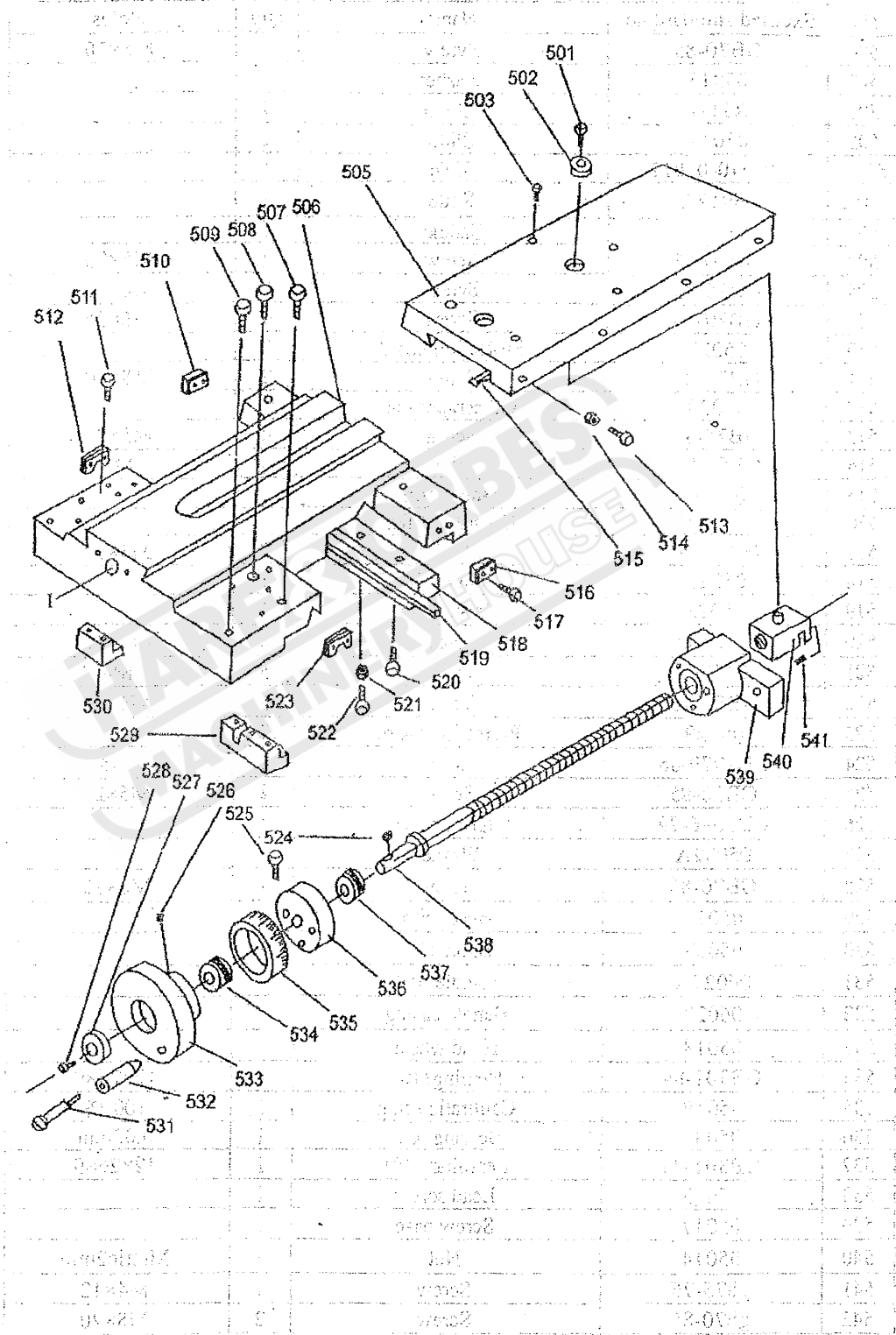
Fig.7-2 Tool Post(CJ9528)



From 10 Tool rest(Fig7-1,7-2,7-3)

No.	Excused standard no.	Name	Qty	Notes
401	04025	Turn plate base	1	
402	04024	Gland	1	
402A	04024A	Gland	1	
403	GB30-76	Threaded bolt	2	M8×20
403A	GB41-85	Nut	2	M6
404	04011	Turn plate	1	
404A	HD210-04011	Turn plate	1	
405	04015	Threaded bolt	1	
405A	HD210-04015	Threaded bolt	1	
406	GB54-76	Nut	3	M4
407	GB75-76	Screw	3	M4×20
408	GB75-76	Screw	1	M4×12
409	GB54-76	Nut	1	M4
410	04014	Locating pin	1	
411	04013	Follow rest	1	
411A	HD210-04013	Follow rest	1	
412	GB85-76	Screw	8	
413	03022	Handle	1	
414	04017	Handle base	1	
415	04016	Washer	1	
416	Q81-1	Spring	1	
417	04012	Slide	1	
418	04026	Filling iron	1	
419	GB879-76	Cylinder pin	1	
420	04018	Screw post	1	3×10
421	GB879-76	Key	1	
422	R71-1	Oil cup	2	3×10
423	04020	Support	1	
424	GB70-76	Screw	2	
425	04022	Spring slice	1	
426	04023B	Handle	2	
427	GB5781-76	Nut	2	M8
428	GB97-76	Washer	1	
429	04023	Hand wheel	1	
430	04021	Calibration ring	1	
431	GB65-76	Screw	4	M6×16
432	GB897-76	Cylinder pin	2	4×16
433	04024	Position bolt	1	
434	GB37	T-shaped bolt	2	M6×22
435	GB41-85	Nut	2	M6
436	04025	Shaft	1	
437	GB876-84	Rivet	2	2×4
438	GB37	T-shaped bolt	2	M6×22

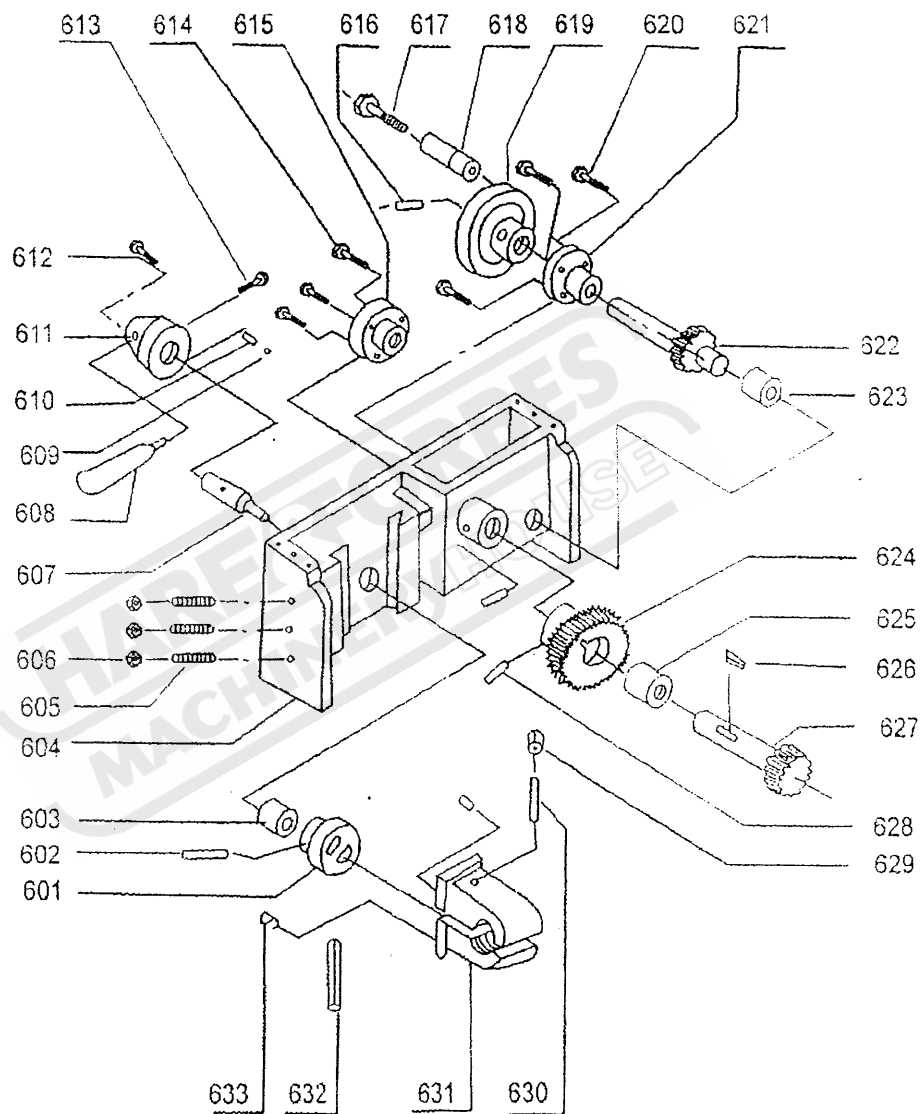
Fig.8-1 Saddle(CJ9528)



From 11 Saddle(Fig8-1)

No.	Excused standard no.	Name	Qty	Notes
501	GB70-85	Screw	1	M5×10
502	05015	Washer	1	
503	R71-1	Oil vup	9	
505	05012	Slide	1	
501A	HG210-05012	Slide	1	
505B	05012A	Slide	1	
506	05011	Saddle	1	
507	GB70-85	Screw	4	M5×20
508	GB70-85	Screw	1	M8×20
509	GB70-85	Screw	4	M6×35
510	05027	Protection board	2	
511	GB70-86	Screw	2	M8×30
512	05030	Oil scraper felt	2	
513	GB75-76	Screw	4	M5×25
514	GB52-76	Nut	4	M5
515	05026	Brake iron	1	
516	05027	Oil scraper felt	1	
517	GB67-76	Screw	8	M3×12
518	05021	Brake clip	1	
519	05022	Brake iron	1	
520	GB70-85	Screw	4	M5×16
521	GB70-76	Nut	5	M4
522	GB54-76	Screw	5	M4×16
523	05029	Protection board	2	
524	GB1079-86	Key	1	4×8
525	GB70-85	Screw	3	M5×22
526	GB1096-79	Spring slice	1	
527	05032A	Washer	1	
528	GB70-85	Screw	1	M6×10
529	05024	Brake clip	1	
530	05023	Brake clip	1	
531	06027A	Handle bolt	1	
532	06027	Handle casing	1	
533	05018	Hand wheel	1	
534	GB301-84	Bearing 8101	1	12×26×9
535	05019	Calibration ring	1	100 格
536	05031	Bearing base	1	0.02mm
537	GB301-84	Bearing 8101	1	12×26×9
538	05013	Lead screw	1	
539	05017	Screw base	1	
540	05014	Nut	1	Metric2mm
541	gb75-76	Screw	2	M4×12
542	gb70-85	Screw	2	M8×20

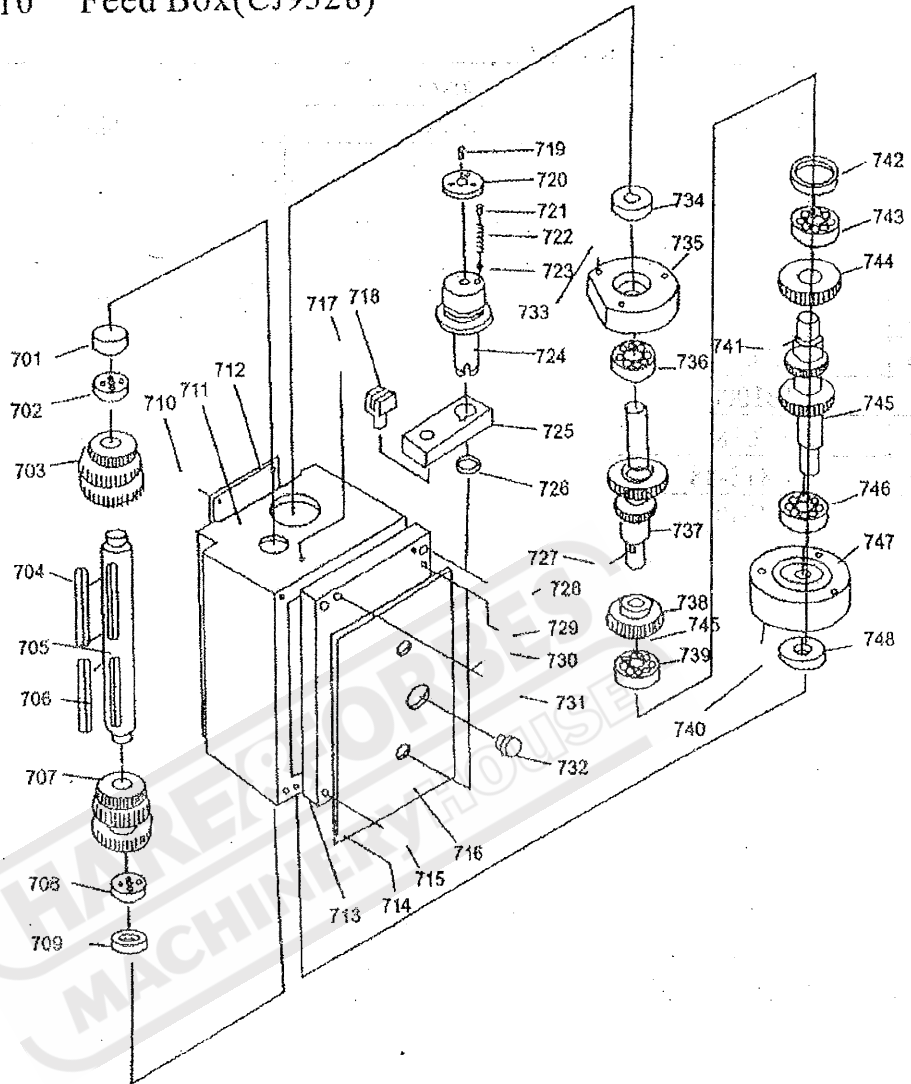
Fig.9-1 Apron



Form 12 Apron(Fig9-1)

No.	Excused standard no.	Name	Qty	Notes
601	06020	Notched joint	1	
602	GB117-76	Circular cone pin	1	
603	06012	Shaft,quill	1	
604	06011	Apron base	1	
605	GB75-76	Screw	3	
606	GB54-76	Nut	3	
607	06021	Rotation shaft	1	
608	03022	Handle	1	
609	GB308-77	Steel ball	1	
610	Q81-76	Spring	1	
611	06026	Fixed handle	1	
612	GB73-76	Screw	1	
613	GB73-76	Screw	1	
614	GB70-76	Screw	3	
615	06024	Quill	1	
616	GB117-76	Circular cone pin	1	
617	06027A	Bolt	1	
618	06027	Handle casing	1	
619	03018	Hand wheel	1	
620	GB70-76	Screw	3	
621	06025	Quill	1	
622	06013	Gear shaft	1	
623	06012	Quill	1	
624	06016	Gear	1	
625	06015	Quill	1	
626	GB1096-79	Key	1	
627	06014	Gear shaft	1	
628	GB71-76	Screw	2	
629	GB54-76	Nut	1	
630	GB73-76	Screw	1	
631	06017	Half nut	1组	
632	06019	Adjustable	1	
633	GB119-76	Cylinder pin	2	

Fig.10 Feed Box(CJ9528)

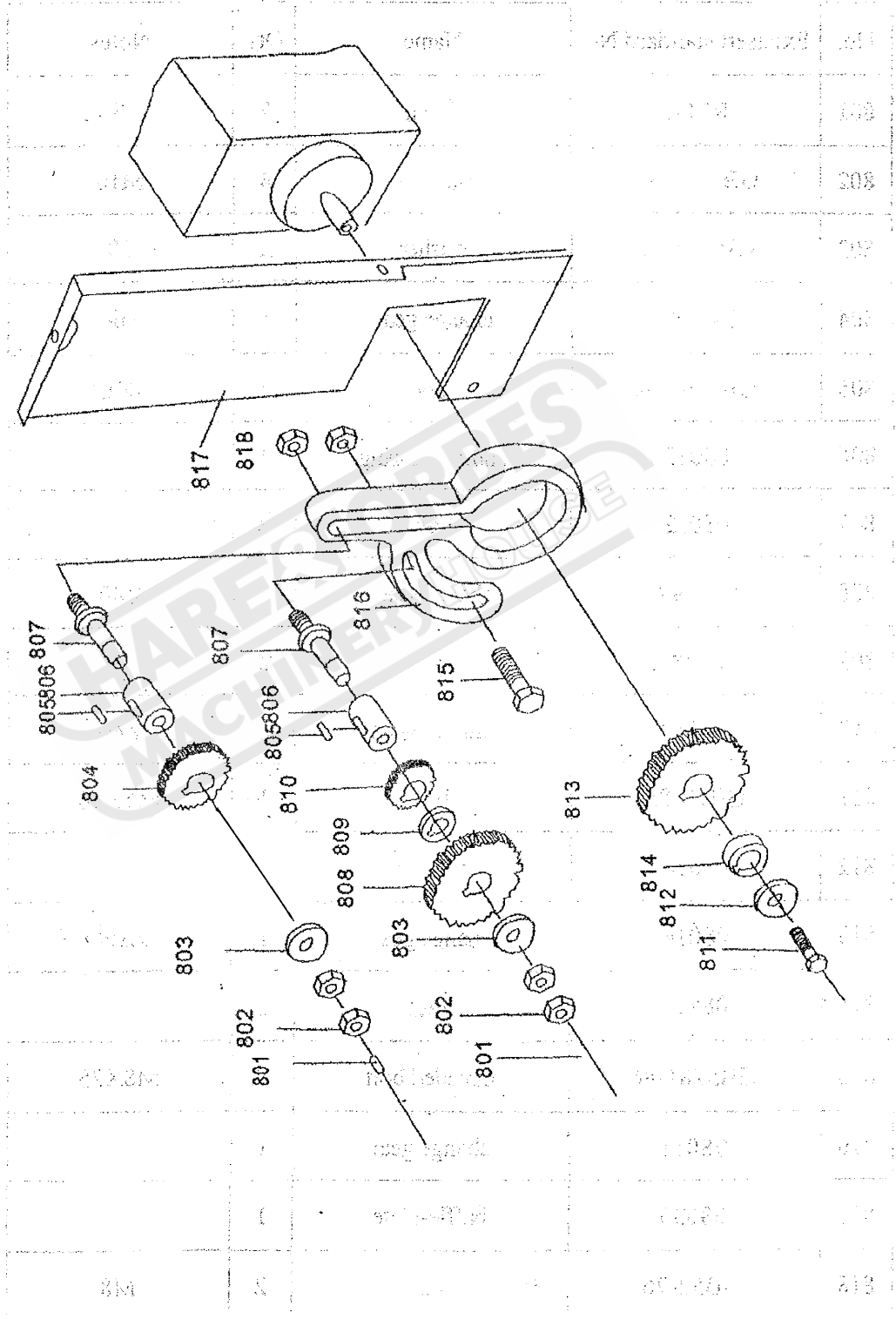


Form 14 Feed box(Fig10)

No.	Excused standard no.	Name	Qty	Specification
701	07023	cover	1	
702	GB276-86	Bearing	1	1000802
703	07026	Gear	1	
704	GB1096-86	Key	1	4×55
705	07024	Shaft	1	
706	GB1096-86	Key	1	4×55
707	07025	Gear	1	
708	GB276-86	Bearing	1	1000802

709	07023	Cover	1	
710	GB68-86	Screw	4	M5×8
711	07011	Feed box	1	
712	07027	Back cover	1	
713	07012	Face plate	1	
714	GB818-88	Screw	4	M3×6
715	GB70-85	Screw	4	M5×18
716	07029	Plate	1	
717	JB1000	Oil plug	1	M10×1
718	07018	Shift fork	2	
719	GB818-88	Screw	2	M3×6
720	07030	Plate	2	
721	GB73-85	Spring	4	M6×8
722	GB2089	Steel ball	4	0.7×5×19
723	GB308-85	Steel ball	4	
724	07017	Handle	2	
725	02016	Con nection block	2	
726	GB894.2-86	Spacer	2	
727	GB1096-86	Key	3	4×8
728	GB70-85	Threaded bolt	2	M8×90
729	GB118-89	Circular cone pin	2	
730	JB1000	Oil plug	1	M10×1
731	GB70-85	Screw	2	M6×90
732	GB1160.1-79	Oil window	1	
733	GB70-85	Screw	3	M5×20
734	HG4-691	Oil seal	1	15×30×10
735	070156	Cover	1	
736	GB276-89	Bearing	1	202
737	07022	Gear shaft	1	
738	07020	Gear	1	
739	GB276-89	Bearing	1	202
740	GB70-85	Screw	1	M5×25
741	GB1096-86	Key	1	4×8
742	07021	Spacer	1	
743	GB076-89	Bearing	1	202
744	07020	Gear	1	
745	07019	Gear shaft	1	
746	GB276-89	Bearing	1	103
747	07014	Cover	1	
748	HG4-691	Oil seal	1	

Fig.11-2 Change Gear(CJ9528)



(081210) (mm) (gsm) 11 g15

Form 16 CHANGE GEAR WHEEL BOX (Fig11-2)

No.	Excused standard No.	Name	Qty	Notes
801	R71-1	oil cup	2	6
802	GB6172-86	thin nut	4	M10
803	GB97.1-86	washer	2	10
804	08018A	change gear	1	Z60
805	GB1096-86	key	2	4X12
806	08013	sliding bearing	2	
807	08012	bolt	2	
808	08019A	change gear	1	Z100
809	08038A	spare	2	
810	08017	change gear	1	Z30
811	GB70-85	bolt	1	M5X16
812	01020	washer	1	
813	08014	change gear	1	Z96
814	08019	quill	1	
815	GB5781-86	threaded bolt	1	M8X25
816	08011	change gear	1	
817	08035	baffle-plate	1	
818	GB52-76	nut	2	M8

Fig.12 Follow Rest

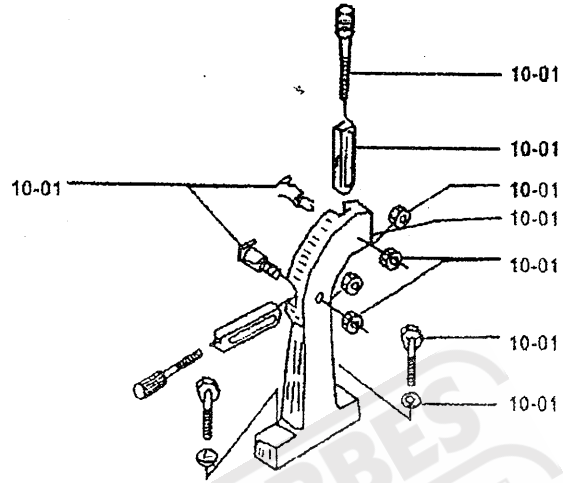
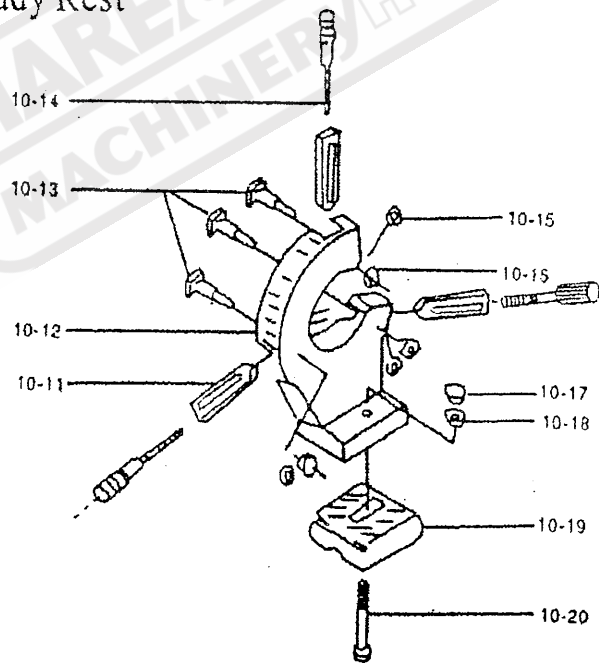


Fig.13 Steady Rest



Form 17 FOLLOW REST (Fig. 12)

No.	Excused standard No.	Name	Qty	Notes
1001	11014	screw	2	take to use
1002	11012	adjustable threaded bolt	2	take to use
1003	12012	support	2	
1004	GB97-76	washer	2	10
1005	12011	follow rest base	1	
1006	GB52-76	nut	2	M10
1007	GB30-76	threaded bolt	2	M8X30
1008	GB97-76	washer	2	8

Form 18 STEADY REST (Fig. 13)

No.	Excused standard No.	Name	Qty	Notes
1011	11013	support	3	
1012	11011	steady rest base	1	
1013	11014	screw	3	
1014	11012	adjustable	3	
1015	GB97-76	washer	3	10
1016	GB6170-86	nut	3	M10
1017	GB41-86	nut	1	M12
1018	GB97-76	washer	1	12
1019	03014	clip	1	
1020	GB8-76	threaded bolt	1	M12×70

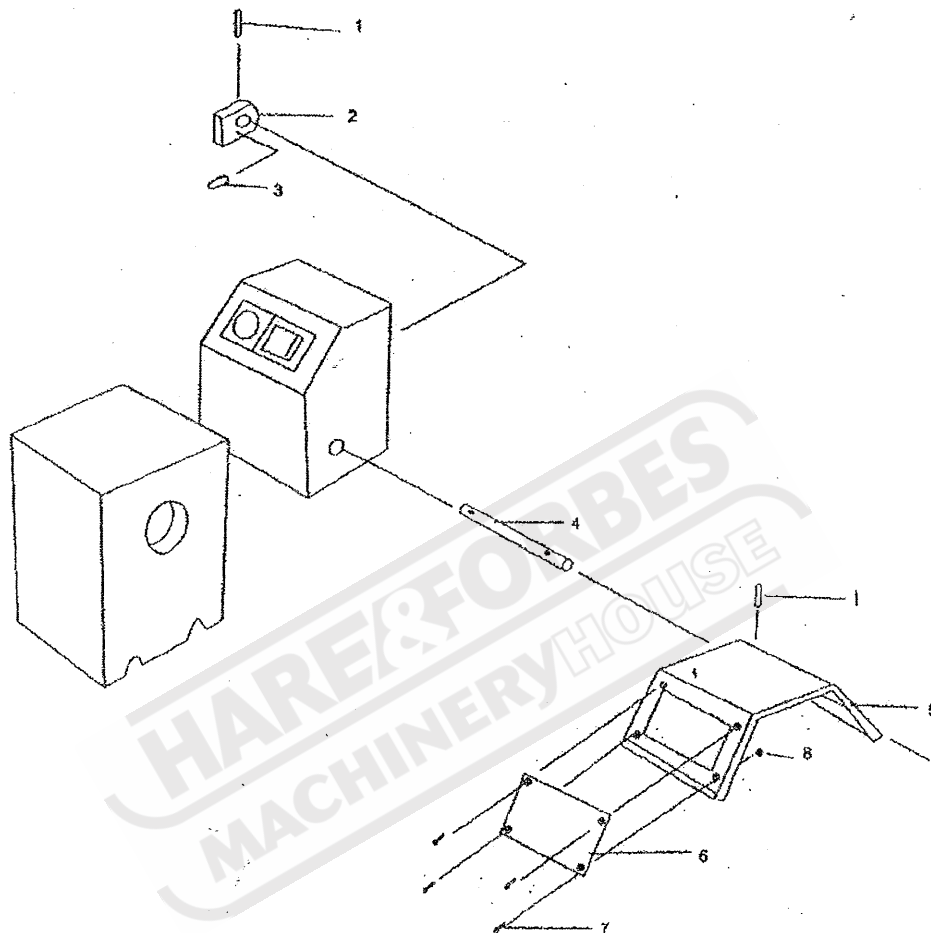
11. PROTECTION OF THE LATHE

In order to ensure the security, and avoid unexpected hurt, we supply many kinds of safety devices for customers to order properly.

11.1 Chuck protection

There are two kinds of chuck protection devices. See Fig

Fig.14-2 Chuck Cover(With cutting power device)



Form 20 Chuck cover (With cutting power device) (Fig. 14-2)

No.	Excused standard No.	Name	Qty	Notes
1	GB79-86	Elastic pin	2	4x20
2	02029	Switch block	1	
3	GB79-86	Elastic pin	1	4x10
4	02031A/2	Shaft	1	
5	02031A	Chuck cover	1	
6	02031A/3	Glass	1	
7	GB818-86	Screw	4	M3X6
8	GB6170-86	Nut	4	M3