

JET

BD-10VS

OPERATING MANUAL LATHE

Original:
GB
Operating Instructions
Parts List



JPW (Tool) AG
Tämperlistrasse 5
CH-8117 Fällanden
Switzerland
Phone +41 44 806 47 48
Fax +41 44 806 47 58
www.jettools.com



CE-Conformity Declaration
CE-Konformitätserklärung
Déclaration de Conformité CE

Product / Produkt / Produit:

Metal Lathe
Die Metall - Dreher
Tour de métal

BD-10VS

Brand / Marke / Marque:

JET

Manufacturer / Hersteller / Fabricant:

JPW (Tool) AG, Tämperlistrasse 5, CH-8117 Fällanden
Schweiz / Suisse / Switzerland

We hereby declare that this product complies with the regulations
Wir erklären hiermit, dass dieses Produkt der folgenden Richtlinie entspricht
Par la présente, nous déclarons que ce produit correspond aux directives suivantes

2006/42/EC

Machinery Directive

Maschinenrichtlinie

Directive Machines

2006/95/EC

electromagnetic compatibility

elektromagnetische Verträglichkeit

compatibilité électromagnétique

Directive Basse Tension designed
in consideration of the standards
und entsprechend folgender zusätzlicher Normen entwickelt wurde
et été développé dans le respect des normes complémentaires suivantes

EN ISO 12100:201 0; EN 60204-1 :2006+A 1 :2009+AC:2010

EN 61000-6-2:2005; EN 61000-6-4:2007+A1:2011

Responsible for the Documentation / Dokumentations-Verantwortung / Responsabilité de Documentation:

Hansjörg Meier

Head Product-Mgmt. / Leiter Produkt-Mgmt. / Resp. Gestion des Produits

JPW (Tool) AG



2016-10-10 Alain Schmid, General Manager
JPW (Tool) AG, Tämperlistrasse 5, CH-8117 Fällanden
Schweiz / Suisse / Switzerland

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1 Safety

Glossary of symbols

	gives additional indications
	calls on you to act
	Enumerations

This part of the operating manual

- explains the meaning and use of the warning references contained in the operating manual,
- explains how to use the lathe properly,
- highlights the dangers that might arise for you or others if these instructions are not obeyed,
- tells you how to avoid dangers.

In addition to this operating manual please observe

- applicable laws and regulations,
- legal regulations for accident prevention,
- the prohibition, warning and mandatory signs as well as the warning notes on the lathe.

European standards must be observed during installation, operation, maintenance and repair of the lathe.

If European standards are not applied in the national legislation of the country of destination, the specific applicable regulations of each country must be observed.




Where necessary, the required measures must be taken to comply with the specific regulation of each country before the lathe is first used.

ALWAYS KEEP THIS DOCUMENT CLOSE TO THE LATHE FOR FUTURE REFERENCE.

1.1 Safety warnings (warning notes)

1.1.1 Classification of hazards

We classify the safety warnings into various levels. The table below gives an overview of the classification of symbols (pictograms) and warnings for the specific danger and its (possible) consequences.

Pictogram	Alarm expression	Definition/Consequences
	DANGER!	Imminent danger that will cause serious injury or death to personnel.
	WARNING!	Risk: A danger that might cause serious injury or death to personnel.
	CAUTION!	Danger or unsafe procedure that might cause injury to personnel or damage to property.
	ATTENTION!	Situation that could cause damage to the machine and product and other types of damage. No risk of injury to personnel.
	INFORMATION	Application tips and other important or useful information and notes. No dangerous or harmful consequences for personnel or objects.

In the case of specific dangers, we replace the pictogram



1.1.2 Other pictograms



Warning of automatic start-up!



Activation forbidden!



Pull the mains plug!



Use protective goggles!



Use ear protection!



Use protective gloves!



Use protective boots!



Wear a safety suit!



Protect the environment!



Contact address

1.2 Proper use



WARNING!

Improper use of the lathe

- will endanger personnel,
- will endanger the machine and other material property of the operator,
- may affect proper operation of the machine.

The machine is designed and manufactured to be used in environments where there is no potential danger of explosion.

The lathe is designed and manufactured for straight turning and facing round or regularly formed three-, six- or twelve-square workpieces in cold metal, castings and plastics or similar materials that do not constitute a health hazard or do not create dust, such as wood, Teflon®, etc. The lathe must only be installed and operated in a dry and well-ventilated place. The workpieces may only be clamped in the lathe chuck using the special check-key provided.

If the lathe is used in any way other than as described above, modified without the authorisation of company or operated with different process data, then it is being used improperly.

We do not take liability for damage caused by improper use.

We would like to stress that any modifications to the construction, or technical or technological modifications that have not been authorised by company will also render the guarantee null and void.

It is also part of proper use that

- the maximum values for the lathe are complied with,
- the operating manual is observed,
- inspection and maintenance instructions are observed.

 Technical data'

In order to achieve cutting performance, it is essential to choose the right turning tool, feed, tool pressure, cutting speed and coolant.



WARNING!

Very serious injury due to improper use.

It is forbidden to make any modifications or alterations to the operating values of the machine. These could endanger personnel and cause damage to the machine.

1.3 Possible dangers caused by the machine

The lathe has undergone a safety inspection (analysis of danger with assessment of risks). It has been designed and built on the basis of this analysis using the latest technological advances.

Nonetheless, there remains a residual risk, since the machine operates with

- high revolutions,
- rotating parts,
- electrical voltage and currents.

We have used construction resources and safety techniques to minimise the health risk to personnel resulting from these hazards.

If the lathe is used and maintained by personnel who are not duly qualified, there may be a risk resulting from incorrect operation or unsuitable maintenance.



INFORMATION

All personnel involved in assembly, commissioning, operation and maintenance must

- be duly qualified,
- follow this operating manual.

Disconnect the machine whenever cleaning or maintenance work is being carried out.



WARNING!

THE LATHE MAY ONLY BE USED WITH THE SAFETY DEVICES ACTIVATED.

Disconnect the lathe whenever you detect a failure in the safety devices or when they are not fitted!

All additional installations carried out by the operator must incorporate the prescribed safety devices.

As the machine operator, this will be your responsibility!

👉 **“Safety devices“ on page 11**

1.4 Qualification of personnel

1.4.1 Target group

This manual is addressed to

- operators,
- users,
- maintenance staff.



The warning notes therefore refer to both operation and maintenance of the machine.

Determine clearly and unequivocally who will be responsible for the different activities on the machine (use, maintenance and repair).



Vague or unclear assignment of responsibilities constitutes a safety hazard!

Always disconnect the machine plug from the mains. This will prevent it being used by unauthorised personnel.



INFORMATION

All personnel involved in assembly, commissioning, operation and maintenance must

- be duly qualified,
- follow this operating manual.

In the event of improper use

- there may be a risk to personnel,
- there may be a risk to the machine and other material property,
- correct functioning of the lathe may be affected.

1.4.2 Authorised personnel



WARNING!

Incorrect use and maintenance of the machine constitutes a danger for personnel, objects and the environment.

Only authorised personnel may operate the machine!

The only personnel authorised to use this machine and perform maintenance on it are trained and instructed technical staff working for the operator and manufacturer.

1.4.3 Obligations of the operator

The operator must instruct staff at least once a year on

- all safety standards that apply to the machine,
- operation,
- accredited technical guidelines.

The operator must also

- check staff's understanding,
- document training/instruction,
- require staff to confirm participation in training/instruction by means of a signature,
- check whether the staff are aware of safety and of dangers in the workplace and whether they observe the operating manual.

1.4.4 Obligations of the user

The user must

- have read and understood the operating manual,
- be familiar with all safety devices and regulations,
- be able to manipulate the machine.

1.4.5 Additional qualification requirements

For work on electrical components or equipment there are additional requirements:

- This work must only be carried out by a qualified electrician or person working under the instructions and supervision of a qualified electrician.

Before carrying out work on electric components or operating units the following measures must be taken, in the order given.

- Disconnect all poles
- Ensure that the machine cannot be turned on again
- Check that there is no voltage

1.5 User positions

The user must stand in front of the machine.

1.6 Safety devices

Use the lathe only with properly functioning safety devices.

Stop the lathe immediately if there is a failure in the safety device or if it is not functioning for any reason.

It is your responsibility!

If a safety device has been activated or has failed, the lathe must only be used when

- the cause of the failure has been removed,
- it has been verified that there is no resulting danger for personnel or objects.



WARNING!

If you bypass, remove or override a safety device in any other way, you are endangering yourself and other personnel working with the machine. The possible consequences are

- damage as a result of components or parts of components flying off at high speed,
- contact with rotating parts,
- fatal electrocution.

The lathe includes the following safety devices:

- Self-latching, lockable EMERGENCY STOP button
- Screwed-down protective cover on the headstock
- Special key for the lathe chuck

1.6.1 EMERGENCY STOP button



1.6.2 Protective cover



The headstock of the lathe is fitted with a screwed-down protective cover.



WARNING!

Remove the protective cover only after the mains plug of the lathe has been pulled.



Protective cover



1.6.3 Lathe chuck key

The lathe is equipped with a special key for chucks. Once the lathe chuck key has been released, it is pushed out of the lathe chuck by a spring.



Lathe chuck key



CAUTION!

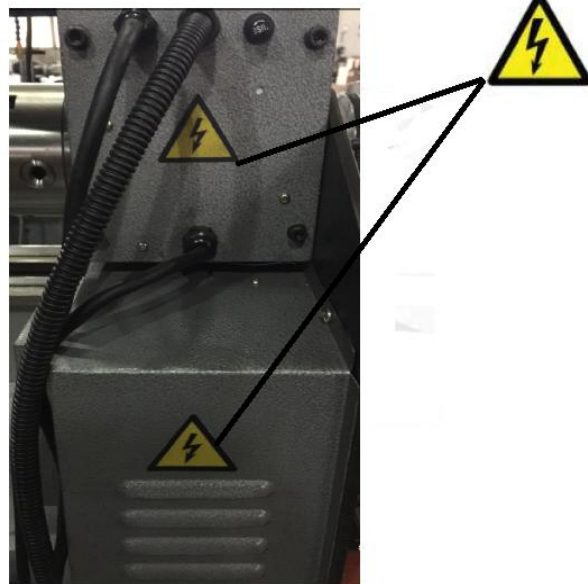
Only operate the lathe using this key.

1.6.4 Prohibition, warning and mandatory labels



INFORMATION

All warning labels must be legible. Check them regularly.



1.7 Safety check

Check the lathe at least once per shift. Inform the person responsible immediately of any damage, defect or change in operating function.

Check all safety devices

- at the beginning of each shift (with the machine stopped)
- once a week (with the machine in operation)
- after every maintenance and repair operation

Check that prohibition, warning and information labels and the markings on the lathe

- can be identified (if not, clean them)
- are complete



INFORMATION

Use the following table for organising the checks.

General check		
Equipment	Check	OK
Protective cover, chaw juck cover	Fitted, firmly bolted and not damaged	
Labels, markings	Installed and legible	
Date:	Checked by (signature):	

Run test		
Equipment	Check	OK
EMERGENCY STOP button	When the EMERGENCY STOP button is activated, the lathe should be switched off.	
Lathe chuck key	Once the chuck key has been released, it should be automatically pressed out of the lathe chuck.	
Date:	Checked by (signature):	

1.8 Individual protection gear



For certain work individual protection gear is required.

Protect your face and eyes: During all work, and specifically work during which your face and eyes are exposed to hazards, a safety helmet with a face guard should be worn.



Use protective gloves when lifting or handling pieces with sharp edges.



Wear safety shoes when fitting, dismantling or transporting heavy components.



Use ear protection if the noise level (immission) in the workplace exceeds 80 dB(A).

Before starting work, make sure that the prescribed individual protection gear is available in the workplace.



CAUTION!

Dirty or contaminated body protection gear can cause disease.

Clean it after every use and once a week.

1.9 Safety during operation

In the description of work with and on the machine we highlight the dangers specific to that work.



WARNING!

Before activating the lathe, double check that this will not endanger other people and cause damage to equipment.

Avoid unsafe working practises:

- Make sure your work does not endanger anyone.
- Clamp the workpiece tightly before activating the lathe.
- For clamping workpieces, only use the special chuck key supplied.
- Mind the maximum chuck opening.
- Use protective goggles.
- Do not remove turning chips by hand. To remove turning chips, use a chip hook and/or handbrush.
- Clamp the turning tool at the correct height and with the least possible overhang.
- Turn off the lathe before measuring the workpiece.
- The instructions in this manual must be observed during assembly, handling, maintenance and repair.
- Do not work on the lathe if your concentration is reduced, for example, because you are taking medication.
- Observe the rules for preventing accidents issued by your association for the prevention of occupational accidents and safety in the workplace or other inspection authorities.
- Inform the inspector of any danger or failure.
- Stay at the lathe until all rotating parts have come to a halt.
- Use prescribed protection gear. Make sure to wear a well-fitting work suit and, where necessary, a hairnet.

1.10 Safety during maintenance

Inform operating staff in good time of any repair and maintenance work.

Report all safety-relevant changes or performance details of the lathe. Document all changes, have the operating manual changed accordingly and train the machine operators.

1.10.1 Disconnecting the lathe and making it safe



Pull the mains plug before beginning any maintenance or repair work. All machine components and hazardous voltages and movements must have been disconnected.

Place a warning sign on the machine.



WARNING!

Before reconnecting the machine, make sure that the change-over switch on the lathe is in the "0" position.

Change-over switch



ON / OFF switch

1.10.2 Using lifting equipment



WARNING!

Use of unstable lifting and suspension gear that might break under load can cause very serious injuries or even death.

Check that the lifting and load suspension gear is of sufficient load capacity and in perfect condition.

Observe the rules for preventing accidents issued by your association for the prevention of occupational accidents and safety in the workplace or other inspection authorities.

Hold the loads properly.

Never walk under suspended loads!

1.10.3 Mechanical maintenance work

Remove all protection and safety devices before beginning maintenance work and re-install them once the work has been completed. These include:

- Covers
- Safety indications and warning signs
- Earth (ground) connection

If you remove protection or safety devices, refit them immediately after completing the work.

Check that they are working properly!

1.11 Accident report

Inform your superiors and Top-Tech company immediately in the event of accidents, possible sources of danger and any actions which almost led to an accident (near misses).

These near misses can have many possible causes.

The sooner they are notified, the faster the causes can be eliminated.



INFORMATION

In the description of execution of work with and on the machine we highlight the dangers specific to that work.

1.12 Electrical system

Have the machine and/or the electric equipment checked regularly, and at least every six months. Eliminate immediately all defects such as loose connections, defective wires etc.

A second person must be present during work on live components, to disconnect the power in the event of an emergency. Disconnect the lathe immediately if there are any anomalies in the power supply!

2 Technical Data

The following information gives the dimensions and weight and is the manufacturer's authorised machine data.

Power connection	BD-10VS
Total connection rate	1100 W ~ 50Hz
Degree of protection	IP 54

Machine data	
Height of centres [mm]	125
Max. turning diameter [mm]	250
Distance between centres [mm]	500
Spindle speed [rpm]	50- 2500
Spindle taper	MK4
Spindle hole [mm]	26
Bed width [mm]	135
Travel of top slide [mm]	75
Travel of cross slide [mm]	100
Tailstock taper	MK2
Tailstock sleeve travel [mm]	60
Longitudinal feed [mm/rev]	0.1 - 0.2-0.4
Pitch - Metric	0.2 - 4.0
Pitch - In inches	8 - 56

Dimensions	
Height [mm]	480
Length [mm]	1,100
Depth [mm]	540
Total weight [kg]	140

Work area	
Height [mm]	2,000
Length [mm]	2,200
Depth [mm]	1,900

Environmental conditions	
Temperature	5 - 35 °C
Humidity	25 - 80 %

Operating material	
Feed gear	Mobilgear 627 or equivalent oil
Bright steel parts and lubricating nipples	Non-corrosive lubricating oil
Change gears	Chain oil (spray box)

2.1 Emissions

The level of noise emitted by the lathe is less than 70 dB(A).



INFORMATION

If the lathe is installed in an area where various machines are in operation, the acoustic influence (immission) on the operator of the lathe may exceed the legally permitted peak value in the workplace.



We recommend the use of soundproofing and ear protection.

3 Assembly



INFORMATION

The lathe comes pre-assembled.

3.1 Extent of supply

When the machine is delivered, check immediately that the lathe has not been damaged during shipping and that all components are included. Also check that no fastening screws have come loose.

Compare the parts supplied with the information on the packaging list.

3.2 Transport



WARNING!

Machine parts falling off forklift trucks or other transport vehicles could cause very serious or even fatal injuries. Follow the instructions and information on the transport case:

- Centres of gravity
- Suspension points
- Weights
- Means of transport to be used
- Prescribed shipping position



WARNING!

Use of unstable lifting and load-suspension gear that might break under load can cause very serious injuries or even death.

Check that the lifting and load suspension gear has sufficient load capacity and that it is in perfect condition. Observe the rules for preventing accidents.

Hold the loads properly.

Never walk under suspended loads!

3.3 Storage

ATTENTION!

Improper storage may cause important parts to be damaged or destroyed.

Store packed or unpacked parts only under the intended environmental conditions.

3.4 Installation and assembly

3.4.1 Requirements of the installation site

Organise the work area around the lathe in accordance with local safety regulations.

Operation, maintenance and repair in the work area must not be hindered.



INFORMATION

The mains plug of the lathe must be freely accessible.

3.4.2 Load suspension point

- Fasten the load suspension gear around the lathe bed.
- Make sure that you distribute the loads evenly so that the lathe cannot turn over while lifting.
- Make sure that no add-on pieces or varnished parts are damaged due to the load suspension.

3.4.3 Installation



WARNING!

Danger of crushing and overturning. The lathe must be installed by at least 2 people.

- Check the horizontal orientation of the base of the lathe with a spirit level.
- Check that the foundation has sufficient floor-load capacity and rigidity.



ATTENTION!

Insufficient rigidity of the foundation leads to the superposition of vibrations between the machine and the foundation (natural frequency of components). Insufficient rigidity of the entire lathe assembly also rapidly causes the lathe to reach critical speeds, with unpleasant vibrations, leading to bad turning results.

- Position the lathe on the intended foundation.
- Secure the lathe to the foundation or substructure of the machine using the (4) through holes.
- If necessary, use anti-vibration elements (model S1) for your machine substructure.



INFORMATION

The installation site must be designed in accordance with ergonomic workplace requirements.

The installation drawings described below may differ from the real dimensions (cast parts). The tolerances are in the range of the general tolerances according to DIN 7168 g.

3.5 First use



WARNING!

Personnel and equipment may be endangered if the lathe is first used by inexperienced personnel.

We do not take liability for damage caused by incorrect commissioning.

3.5.1 Cleaning and greasing

- Remove the anticorrosive agent applied to the machine for transport and storage purposes. We recommend the use of stove distillate.
- Do not use any solvents, thinners or other cleaning agents which could corrode the varnish on the machine. Follow the specifications and indications of the manufacturer of the cleaning agent.
- Lubricate all bright machine parts with non-corrosive lubricating oil.
- Grease the machine using the lubrication chart.

3.5.2 Visual inspection

Check the oil level in the inspection glass of the feed gear.

3.5.3 Run test

- Check smooth running of all spindles.



INFORMATION

For manufacturing engineering reasons and for reasons of precision of fit, there may be occasional slight stiffness in the spindles. This will disappear after a short time in use.

- Check the state of the lathe chuck and the turning jaws.

3.5.4 Power connection

Connect the following cables:

- Connect the electric supply cable.
- Check the fuse protection of your power supply against the technical data for the total connection value of the lathe.



ATTENTION!

Please pay attention that all three phases (L1, L2, L3) are connected correctly.

Most engine failure result from incorrect connection, for instance the neutral conductor (N) is being connected to a phase.

This might lead to the following results:

- The engine does get quickly very hot.
- The engine noise increases, i.e. becomes louder.
- The engine has no power.

When the phases are connected wrongly, the guarantee is being null and void.



ATTENTION!

Lathes with frequency converter must not be operated with a CEE plug. Connect the machine permanently to a connection box (see EN 50178 / VDE 5.2.11.1)

3.5.5 Functional test

→ Clamp a workpiece into the lathe chuck of the machine or close the jaws of the lathe chuck fully before turning on the machine.



WARNING!

- **Mind the maximum chuck opening.**
- **Do not stand in front of the lathe chuck when turning on the machine for the first time.**

3.6.1 Mounting instruction chuck flange

Putting on of jaw chuck onto the chuck flange

Clean the flange and spindle nose, put the flange onto the spindle nose screws.

Measure the inner hole of the jaw chuck and turn this value of the chuck flange to a diameter as a H7 fit. Turn once easily over the flat surface of the chuck flange.

Put the jaw chuck onto the flange.

Consider: The jaw chuck must let itself manually and put on with the aid of a rubber-faced hammer (distribute uniformly easy strokes over the front panel).

Clamp clamping bolts alternatingly and uniformly.

The screws may perform no compulsion onto the drilling wall since the chuck body bends itself else or the jaws are locked in position.

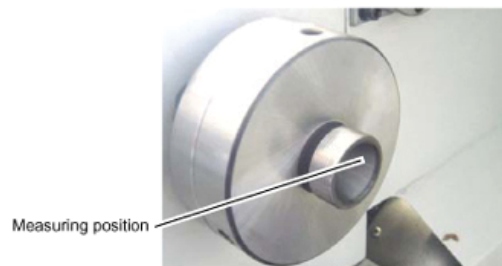
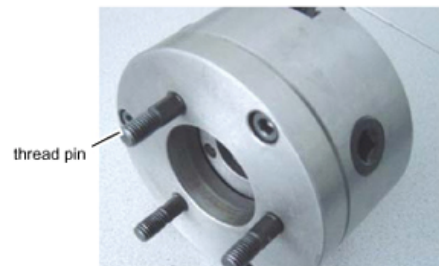
Furthermore, radial runouts can occur.

Refinishing on the jaw chuck is inadmissible!

3.6.2 Mounting instruction of collet chuck holder

Proceed as follows.

- Mark out the position of the jaw chuck at the spindle flange before dismantling with an e.g. felt-tipped pen.
- Dismantle the jaw chuck.
- Clean all faces of the spindle nose and of the collet chuck holder extremely thoroughly.
- Dismantle the thread pins of the jaw chuck and screw in the thread pins into the collet chuck holder.
- Measure the run out of the spindle nose. Mark out the greatest positive rash of the dial gauge at the spindle nose with an e.g. felt-tipped pen.
- Attach the collet chuck holder to the spindle flange, tighten the nuts easily. Pull in the nuts stepwise ones and uniformly alternating at least three times in succession (you receive the run out possible for best only this way).
- Measure the run out of the collet chuck holder at the conical surface.
- Position the collet chuck holder by turning each 120° at the spindle flange to the highest run out precision is achieved and assemble after this the collet chuck holder on the highest circularity accuracy position.
- Mark out the position of the highest circularity accuracy of spindle flange with collet chuck holder.



4 Design and function

The machine is a universal lathe. It has been designed and manufactured for straight turning and facing round or regularly formed three-, six- or twelve-square workpieces in metal, plastics or similar materials.

The hollow work spindle enables you to clamp longer workpieces with a diameter of up to 25 mm.

The speed is regulated by repositioning a V-belt on pulleys.

The existing leadscrew enables longitudinal feed and thread-cutting. It is also possible to use the machine for drilling jobs with the help of an (optional) drill chuck clamped in the tailstock.

4.1 Construction features

- Spindle-bearing arrangement with precision ball bearings
- Powerful, maintenance-free motor
- Hardened spindle nose
- High concentricity precision of the work spindle < 0.009 mm
- Oil-bathed rounded gearwheels on feed gear
- Self-latching, lockable EMERGENCY STOP button with undervoltage circuit breaker
- Left- and right-hand motor rotation controlled by a switch
- Induction-hardened, precision-ground prismatic bed made of gray cast iron (HRC 42 - 52)
- Cross and straight turning slide with dovetail slideway and adjusting gibs
- Leadscrew for thread-cutting or feed for straight turning with change gear set
- Adjustable tailstock for taper turning

4.2 Lathe bed

The lathe bed integrates the headstock and the driving unit, for attaching the apron and lead-screw and for guiding the lathe saddle and tailstock.

4.3 Headstock

The headstock houses the feed gear and the reducing gear with pulleys. The work spindle transmits the torque during the turning process. The work spindle also receives the workpieces and clamping tools.

The work spindle is driven an electromotor, via pulleys. The replacement of the change gears for other feeds is carried out on the headstock.



Headstock

4.4 Feed gear

The feed gear is used to select the feeds for straight turning as well as for thread-cutting. In order to achieve certain thread pitches, it is necessary to replace the change gears.

The torque of the work spindle is transmitted to the feed gear and thus to the leadscrew.

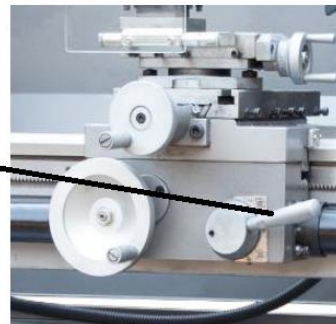


Feed gear

4.5 Apron

The apron houses the leadscrew nut with an engaging lever for activating the automatic feed as well as the handwheel for manual feed. The straight turning and cross slide are located on the apron with bed guidance.

Engaging lever



Apron

4.6 Tailstock

The tailstock is used for centring and drilling, supporting long shafts, turning between centres as well as turning long, thin tapers.



Tailstock

5 Operation

5.1 Safety

Use the lathe only under the following conditions:

- The lathe is in proper working order.
- The lathe is used as prescribed.
- The operating manual is followed.
- All safety devices are installed and activated.



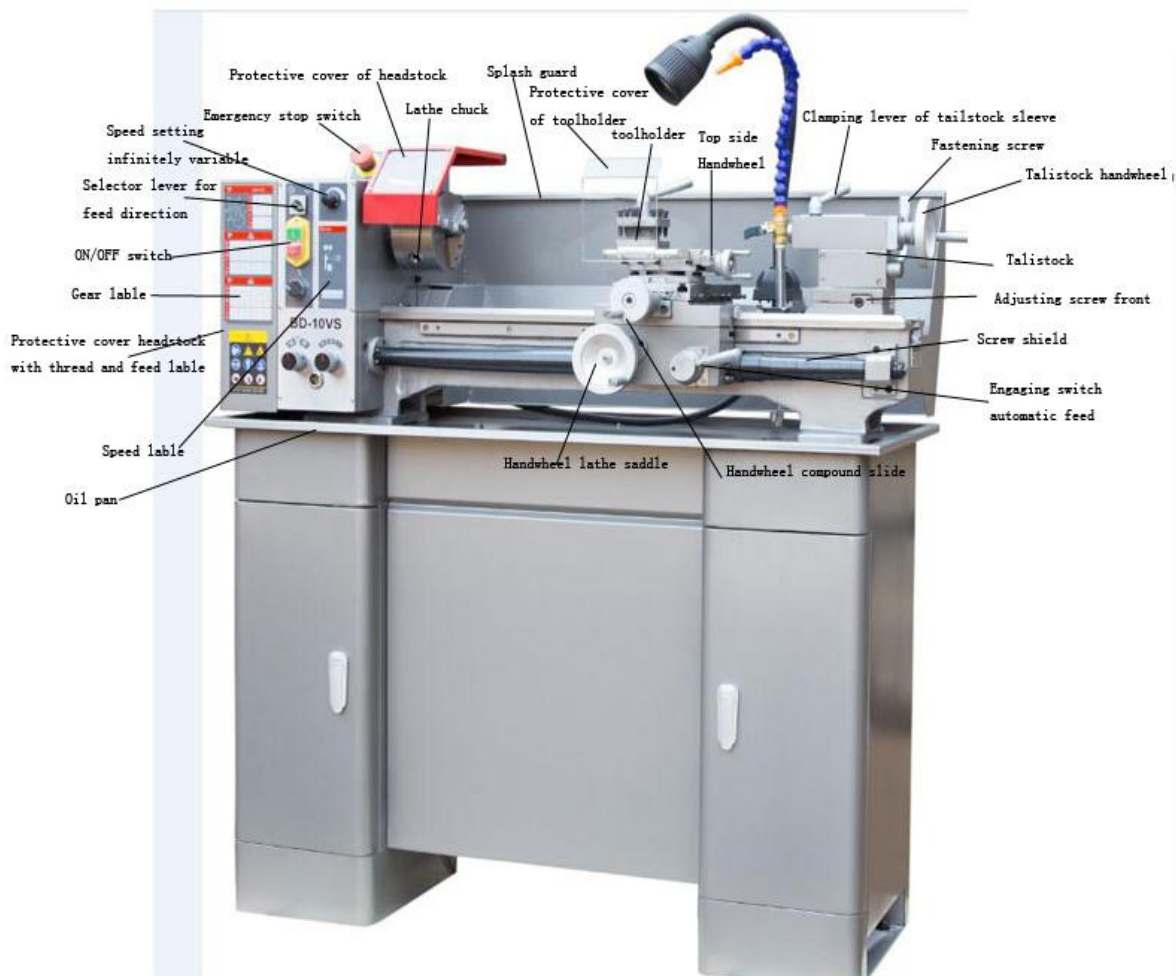
All anomalies should be eliminated immediately. Stop the machine immediately in the event of any abnormality in operation and make sure it cannot be started up accidentally or without authorisation.

Notify the person responsible immediately of any modification.

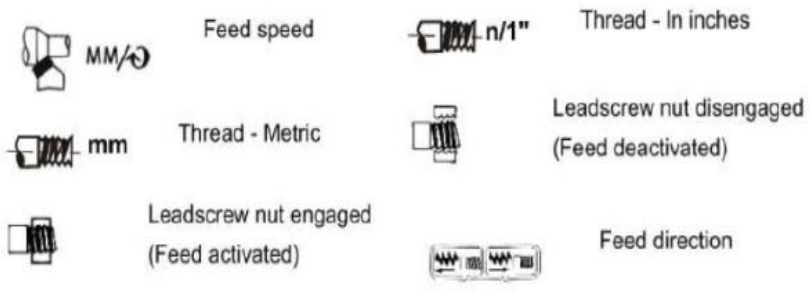
☞ "Safety during operation" on page 14

5.2 Control and indicating elements

5.2.1



5.3 Control elements

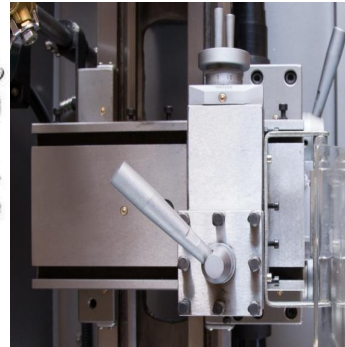


5.4 Toolholder

Clamp the turning tool into the toolholder.

The tool must be clamped firmly and with the least possible overhang in order to absorb well and reliably the cutting force generated during the chip formation.

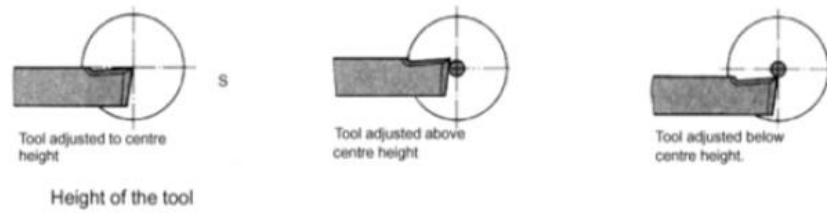
Adjust the height of the tool. Use the tailstock with lathe centre to adjust the tool to the required height. If necessary, use steel spacer shims under the tool to get the required height.



Toolholder

5.4.1 Tool height

For the facing process, the cutting edge of the tool must be exactly aligned with the height of the lathe centre to obtain a shoulder-free face. The facing process is a turning operation in which the turning tool feeds perpendicular to the axis of rotation of the workpiece in order to produce a flat surface. The different methods are transversal facing, transversal slicing and longitudinal facing.



5.4.2 Tool angle



ATTENTION!

The tool must be clamped with its axis perpendicular to the axis of the workpiece. If it is clamped at an angle, the tool may be sucked into the workpiece.



Tool clamped perpendicular to the axis of the workpiece

Tool clamped at an angle with respect to the feed direction

Graphic: Angle of the tool

5.5 Lathe chuck

The workpieces must be clamped firmly and securely onto the lathe before they are machined. The clamp should be tight enough to ensure that the workpiece is moved correctly, but not so tight that it is damaged or deformed.

- Clamp the workpiece into the lathe chuck with the aid of the chuck key provided.



Lathe chuck



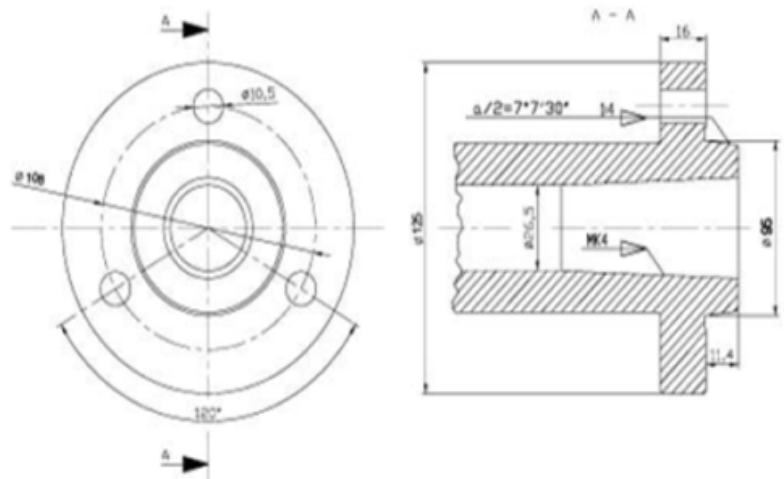
WARNING!

Do not clamp any workpieces that exceed the permitted chucking capacity of the lathe chuck. The clamping force of the chuck is too low if its capacity is exceeded. Also, the jaws might work loose.

5.5.1 Head spindle seat

The head spindle seat is designed as a short-taper seat. For the installation of a quantum four jaw chuck a chuck flange is necessary.

☞ "Optional machine accessories" on page 25



Head spindle seat



ATTENTION!

When disassembling the machine a workpiece holder might fall on the engine bed and might damage the guide rail. Put a wooden board or another appropriate part on the engine bed in order to prevent damages.

- Unscrew the 3 nuts on the flange for the lathe chuck to remove the workpiece holder (in this case, the three-jaw chuck).
- Take the workpiece holder off.
- If necessary, loosen the workpiece holder by hitting it gently with a plastic-tipped hammer or a rubber mallet.

5.6 Adjusting the speed

Adjust the speed by changing the position of the V-belt on the pulleys.

With the "Vario" equipment variant, the speed can be regulated within the corresponding speed ranges with the aid of a frequency converter. The speed can then be adjusted using the potentiometer on the control panel of the lathe.



WARNING!

Unplug the shockproof plug of the lathe before opening the protective cover.



5.6.1 Protective cover of the headstock

In order to change the speed or feed, you must first remove the protective cover.

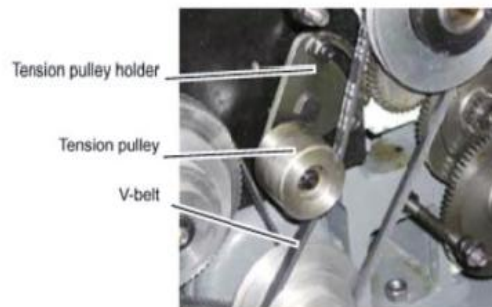
- Unplug the shockproof plug from the mains.
- Unscrew the two fastening screws.
- Remove the protective cover.



Protective cover of the headstock

5.6.2 Changing the speed range

- Loosen the nut on the tension pulley holder and release the tension of the V-belt.
- Lift the V-belt into the corresponding position.



Tension pulley

- Depending on the speed selected, the V-belt will have to be lifted directly onto the motor pulley or onto the pulley of the primary transmission.
- Handle the V-belt with care. It must not be damaged or overstretched.
- Tighten the tension pulley and fasten the nut again.

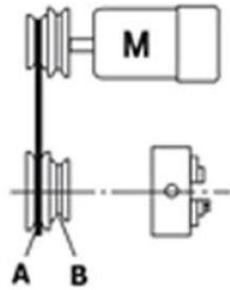
- The correct tension of the synchronous belt has been reached when you can still bend it approximately 3 mm with your index finger.



ATTENTION!

Make sure the tension pulley is in contact with the outside of the V-belt at all times!
Make sure the tension of the V-belt is correct. Excessive or insufficient tension can cause damage.

5.6.3 Speed table

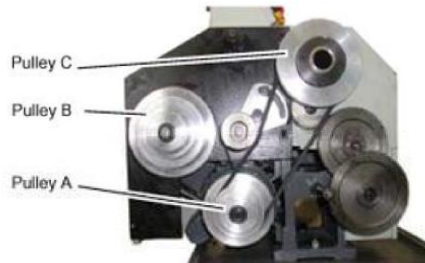


spindle speed \curvearrowright /min

A	B
50-1250	100-2500

Example

With the belt running from Pulley A to Pulley C on the Diameter-3 pulley, you will obtain a speed of 2,000 rpm.



INFORMATION

In the V-belt position AC3, the physical limits of the drive are being achieved at 2500 min⁻¹ by mechanical frictional resistance. It is impossible to have an effective controlling variable of 225% in the V-belt position AC 3. The full range of controlling variables from 15% to 225% are only available for the V-belt position AC 1.

This setting is intended to prevent the workpiece from getting loose by too high centrifugal force of the clamping jaws on the drill chuck.

5.7 Adjusting the feed

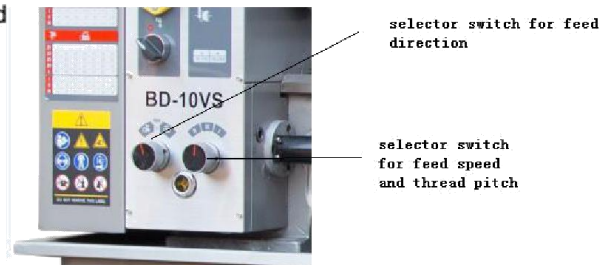
5.7.1 Selector switch

Use the selector switches to select the feed direction and feed speed.



ATTENTION!

Wait until the machine has come to a complete halt before making any change to the selector switches.



Selector switches



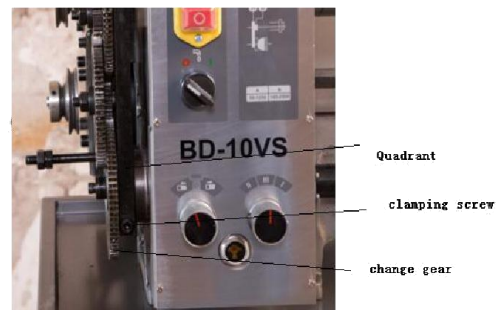
INFORMATION

Use the table on the lathe for selecting the feed speed or the thread pitch. Change the change gears if the required thread pitch cannot be obtained with the installed gear set.

5.7.2 Changing the change gears

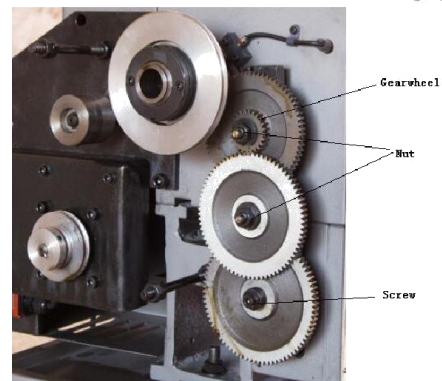
The change gears for the feed are mounted on a quadrant.

- Unplug the shockproof plug from the mains.
- Loosen the locking screw on the quadrant.



Side view of the change gears

- Swing the quadrant to the right.
- Unscrew the bolt from the leadscrew or the nuts from the quadrant bolts in order to remove the change gears from the front.
- Install the gear couples using the feed or change gear table and screw the gearwheels onto the quadrant again.

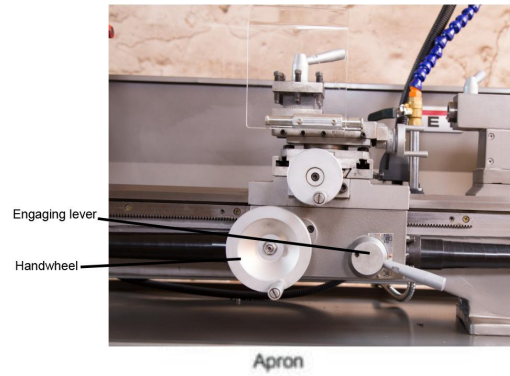


Front view of the change gears

- Swing the quadrant to the left until the gearwheels have engaged again.
- Readjust gear flank clearance by inserting a normal sheet of paper as an adjusting or distance aid between the gearwheels.
- Immobilise the quadrant with the locking screw.
- Attach the protective cover of the headstock and reconnect the machine to the power supply.

5.7.3 Engaging lever

- The automatic longitudinal feed and the feed for thread-cutting are activated and deactivated using the engaging lever. The feed is transmitted via the leadscrew nut.
- Push the engaging lever downwards. The leadscrew nut is engaged and the automatic longitudinal feed is activated.

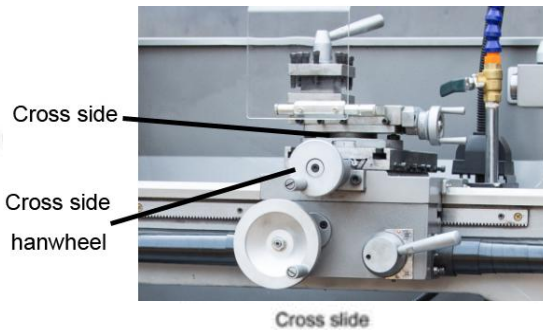


- Move the handwheel slightly to lock the engaging lever in place.

5.8 Lathe saddle with cross and top slide

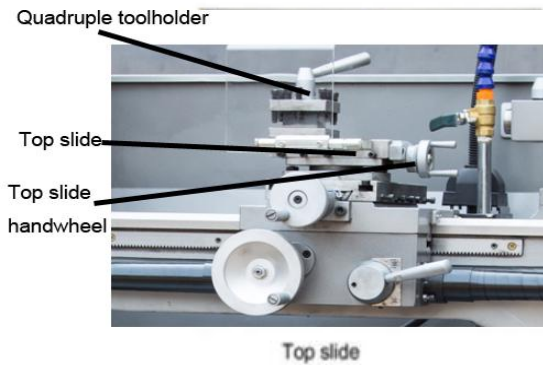
The handwheel is used to manually traverse the lathe saddle.

The cross slide can be advanced and returned by turning the cross slide handwheel.



The top slide (tool slide) supports the quadruple toolholder.

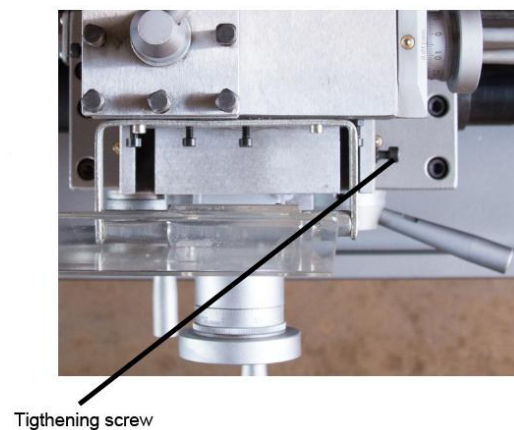
Use the top slide handwheel to move the corresponding slide.



5.8.1 Immobilising the lathe saddle

The cutting force produced during facing, recessing or slicing process may displace the lathe saddle.

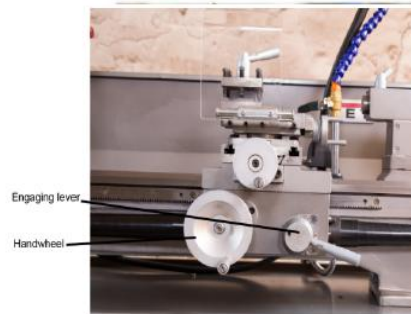
- Secure the lathe saddle using the tightening screw.



5.8.2 Turning tapers with the top slide

It is possible to turn short tapers with the top slide.

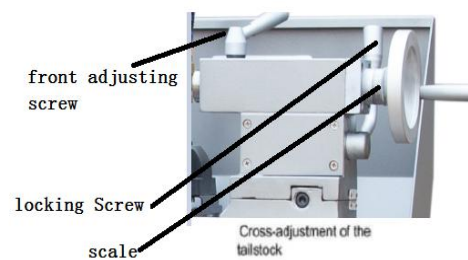
- Loosen the two nuts on the left and the right of the top slide.
- Swivel the top slide.
- Clamp the top slide again.



5.8.3 Cross-adjustment of the tailstock

The cross-adjustment of the tailstock is used for turning long, thin bodies.

- Loosen the locking nut of the tailstock.
- Unscrew the locking screw approximately half a turn.



- By alternately loosening and tightening the two (front and rear) adjusting screws, the tailstock is moved out of the central position. The desired cross-adjustment can be read off the scale.
- First retighten the locking screw and then the two (front and rear) adjusting screws.
- Retighten the locking screw of the tailstock.



ATTENTION!

Check clamping of the tailstock and the sleeve, respectively, for turning jobs between centres!

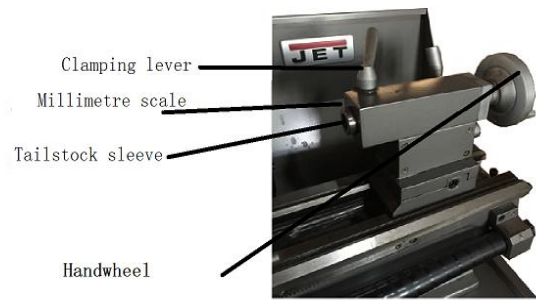
Fit the securing screw at the end of the lathe in order to prevent the tailstock from falling off the lathe bed.



5.9 Tailstock sleeve

The tailstock sleeve is used to hold the tools (bits, lathe centres, etc.).

- Clamp the required tool in the tailstock sleeve.
- Use the millimetre scale on the sleeve to readjust and/or adjust the tool.
- Clamp the sleeve with clamping lever.



Tailstock

- Use the handwheel to move the sleeve forward and back.

The sleeve of the tailstock can be used to introduce a drill chuck for holding bits and counter-sinks.

5.10 Clamping a workpiece into the lathe chuck

When the workpiece is being clamped unprofessionally, there is a risk of injury as the workpiece may fly off or the jaws may break. The following examples do not show all possible situations of danger.

The workpieces are to be clamped safely and tightly on the lathe before starting the operation. The clamping force is to be dimensioned in a way to make sure that the workpiece is securely driven and that there are no dangers or deformations on the workpiece.

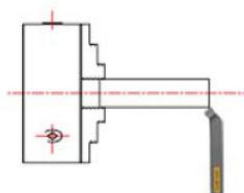


WARNING!

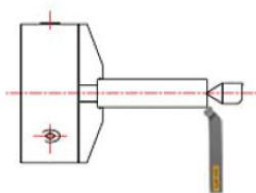
Do not clamp any workpieces that exceed the permitted chucking capacity of the lathe chuck. The clamping force of the chuck is too low if its capacity is exceeded. Also, the jaws may come loose.

incorrect

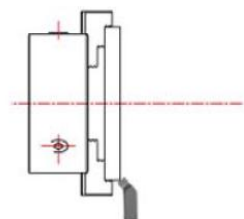
correct



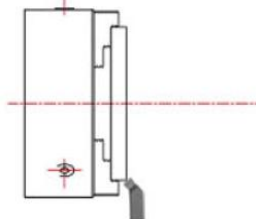
Clamping length too long, overhang too long.



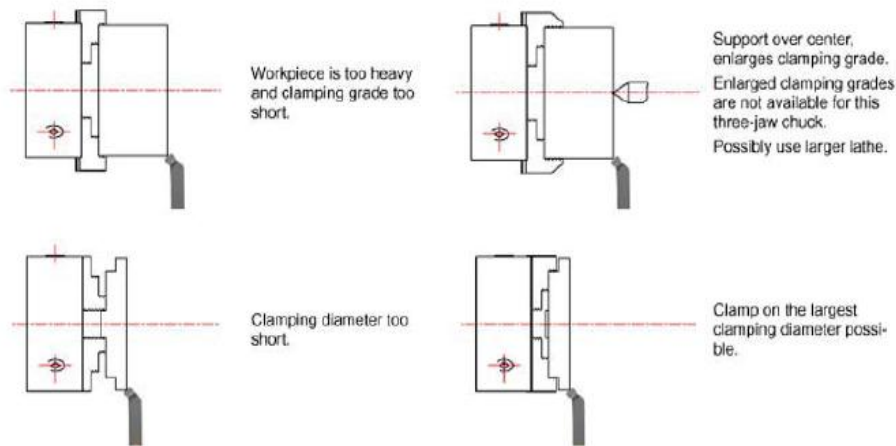
Additional support over center.



Clamping diameter too large.



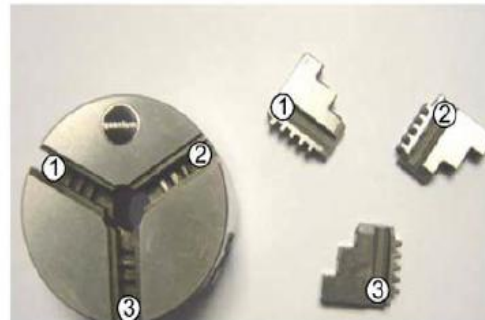
Use larger lathe.



5.10.1 Replacing the clamping jaws on the lathe chuck

The clamping jaws and the three-jaw chuck are equipped with numbers. Insert the clamping jaws at the correct position and in the right order into the three-jaw chuck.

After the replacement, bring the jaws completely together in order to control if they are inserted correctly.



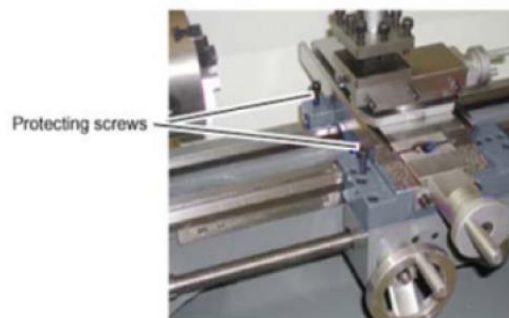
Three-jaw chuck / clamping jaws

5.11 General working notes

5.11.1 Fitting a follow rest

The lathe is prepared for fitting a follow rest.

- Remove the two protecting screws in the lathe saddle.
- Attach the follow rest with the help of thread screws.



Lathe saddle

5.11.2 Coolant

Friction during the cutting process causes high temperatures at the cutting edge of the tool.

The tool should therefore be cooled during the cutting process. Cooling the tool with a suitable cooling lubricant ensures better working results and a longer edge life of the cutting tool.

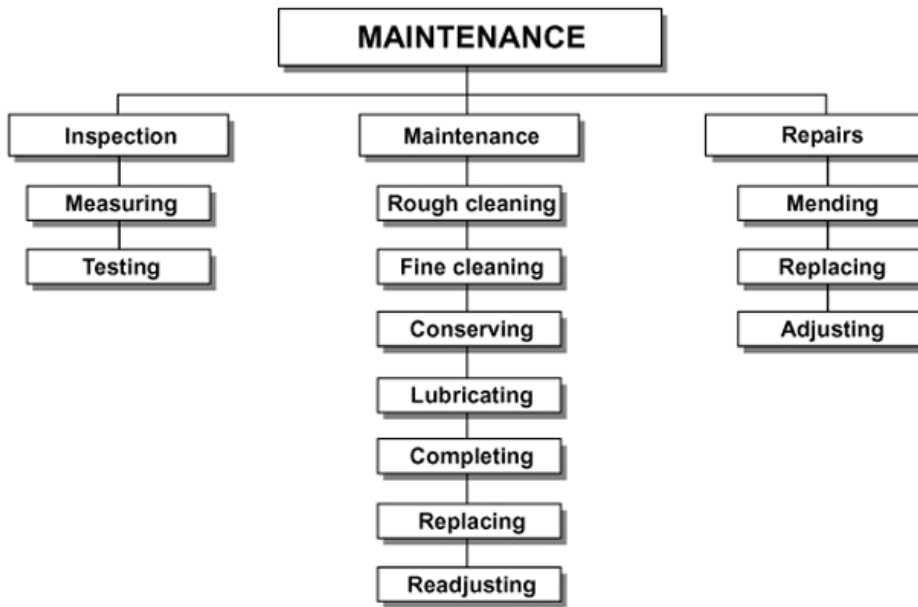
6 Maintenance

In this chapter you will find important information about

- Inspection
- Maintenance
- Repair

of the lathe.

The diagram below shows which of these headings each task falls under.



Illustr.6-1: Maintenance - Definition according to DIN 31051



ATTENTION!

Properly-performed regular maintenance is an essential prerequisite for

- safe operation
- fault-free operation
- long service life of the lathe and
- the quality of the products you manufacture.

Installations and equipment from other manufacturers must also be in optimum condition.



ENVIRONMENTAL PROTECTION

During work on the bit-holder head, make sure that

- collector vessels are used, with sufficient capacity for the amount of liquid to be collected.
- liquids and oils are not spilt on the ground.

Clean up any spilt liquid or oils immediately using proper oil-absorption methods and dispose of them in accordance with current legal requirements on the environment.

Cleaning up spillages

Do not re-introduce liquids spilt outside the system during repair or as a result of leakage from the reserve tank: collect them in a collecting vessel to be disposed of.

Disposal

Never dump oil or other pollutant substances in water inlets, rivers or channels.

Used oils must be delivered to a collection centre. Consult your superior if you do not know where the collection centre is.

6.1 Safety



WARNING!

The consequences of incorrect maintenance and repair work may include:

- Very serious injury to personnel working on the lathe
- Damage to the lathe

Only qualified personnel should carry out maintenance and repair work on the lathe.

6.1.1 Preparation



WARNING!

Only carry out work on the lathe if it has been unplugged from the mains power supply.



Attach a warning label.

6.1.2 Restarting

Before restarting run a safety check.





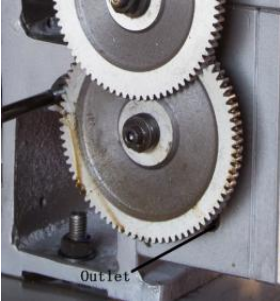

WARNING!

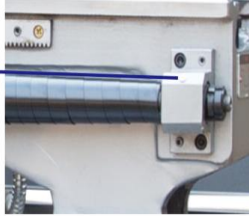
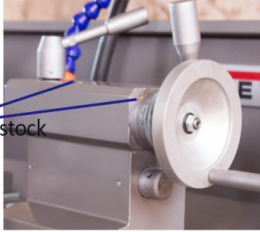
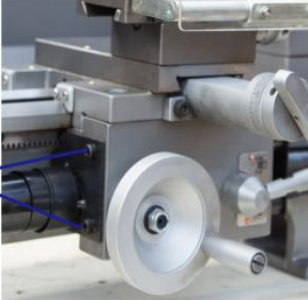
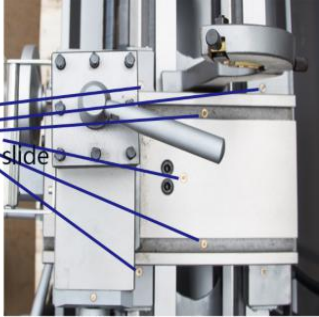
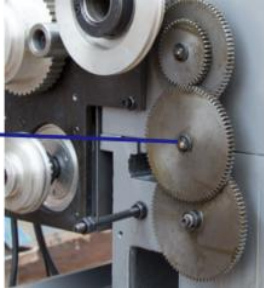
Before connecting the machine you must check that there is no danger for personnel and the lathe is undamaged.

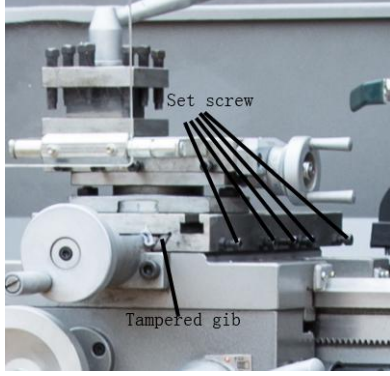
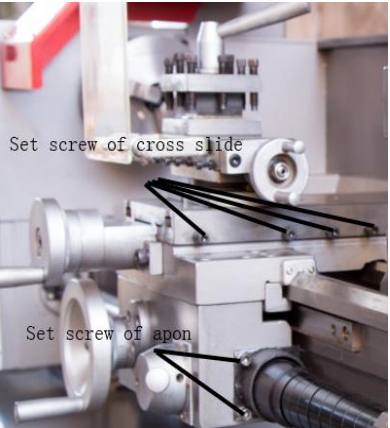
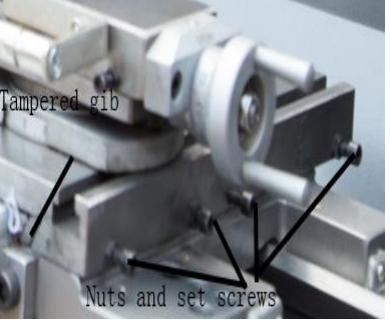
6.2 Inspection and maintenance

The type and extent of wear depends to a large extent on individual usage and service conditions. For this reason, all the intervals are only valid for the authorised conditions.

Interval	Where?	What?	How?
Start of work after every maintenance and repair operation	Lathe		Safety check
Start of work after every maintenance and repair operation	Lathe	Lubricate	<ul style="list-style-type: none"> → Lubrication all slideways. → Lubrication the change gears and lead screw slightly with Lithium-based grease
as required	slide Top	Readjust	<p>Excessive clearance in the top slide can be reduced by readjusting the tapered gib</p> <ul style="list-style-type: none"> → Loose the counternut → Turn the set screw slightly clockwise and secure the set screws again using the counternut <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <p>i INFORMATION</p> <p>A 90° turn of the set screws corresponds to a travel of 0.2 mm. Make any readjustment of the set screws in small steps.</p> <div style="text-align: center; margin-top: 10px;">  </div> </div>

Interval	where?	what?	How?
Start of work after every maintenance and repair operation		<p>Visual inspection</p> <p>Oil change</p> <p>Inspection glass</p>	<p>→Check the oil level in the gear's inspection glass. It must reach at least the center of the inspection glass.</p> <p>→If necessary, fill up to the reference mark with Mobilgear 627 or equivalent oil</p> 
First after 200 hours in service, then after every year	Feed repair	Oil change	<p>→Use an adequate adequate collector vessel with</p> <p>→Sufficient capacity for the oil change</p> <p>→Unscrew the bolt the outlet</p> <p>→Unscrew the bolt of the charging hole</p> <p>→Close the outlet when no more oil is running off</p> <p>→Refill with Mobilgear 627 or an equivalent oil up to the reference mark in the center of the inspection glass using a suitable funnel in the filling hole</p>  

Interval	Where?	What?	How?
Every month	lathe BD-10YS	Lubricate	<p>Lubrication all lubricating nipples with machinery oil</p> <p>Lubricating nipple on lead screw </p> <p>Lubricating nipple on tailstock </p> <p>Lubricating nipples on lathe saddle handel </p> <p>Lubricating nipples on lathe saddle and cross slide </p> <p>Lubricating nipple on change gear primary transmission </p>

Interval	Where?	What?	How?
as required	Slideways	Readjust	<p>→ Loosen the counternuts</p> <p>→ Turn the set screw slightly clockwise and secure the set screws again using the counternut</p> <p>i INFORMATION</p> <p>A 90 turn of the set screw corresponds to a travel of approximately 0.2mm. Make any readjustment of the set screw in short steps. The tapered gib for guiding the lead screw nut has been factory-set and does not normally need to be readjusted.</p>   



INFORMATION

The spindle bearings are permanently greased. Greasing during the maintenance intervals is not necessary. Further greasing of the spindle bearings is only necessary in case of de- and remounting of the spindle bearing

6.3 Repair

For any repair work, get assistance from an employee of Top-Tech company technical service or send us the lathe.

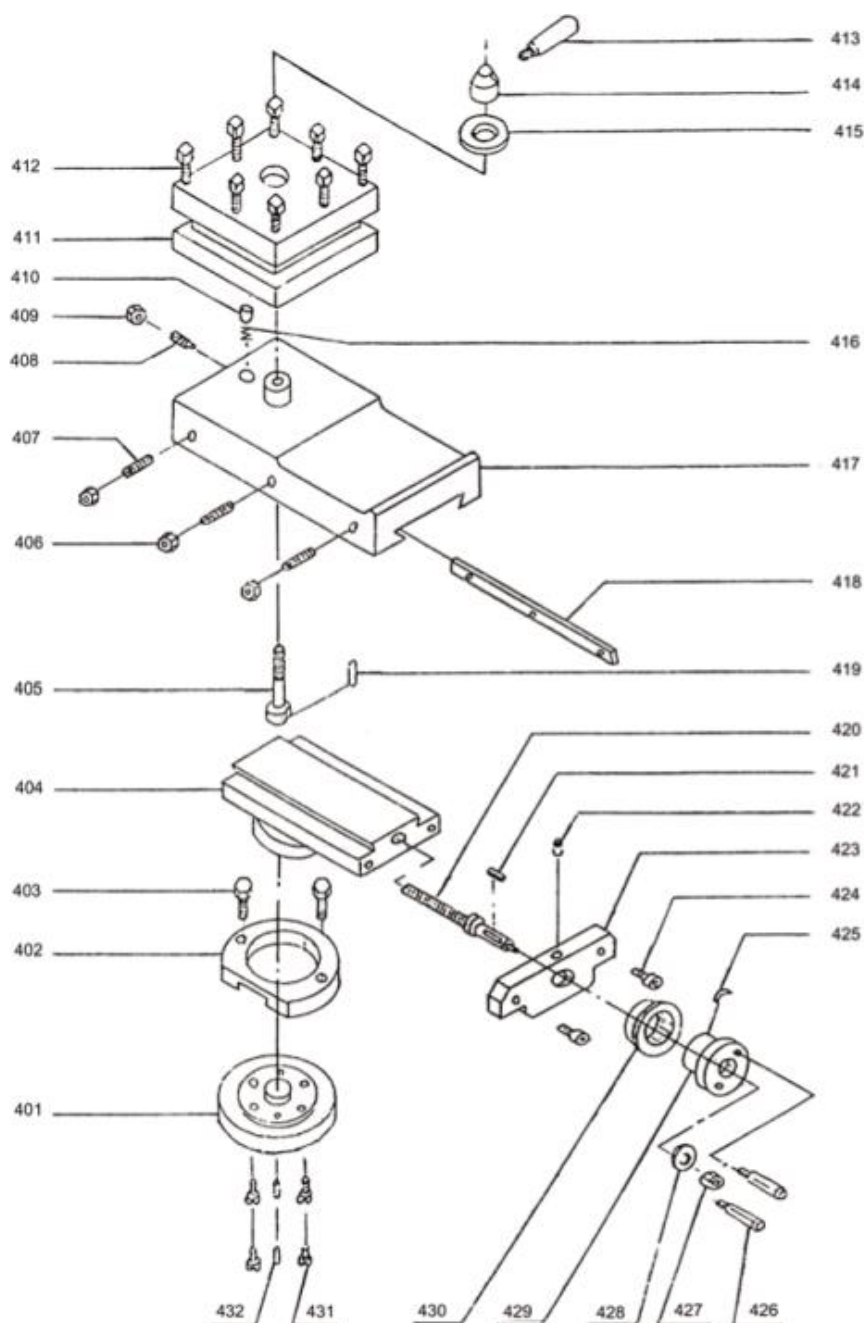
If the repairs are carried out by qualified technical staff, they must follow the indications given in this manual.

Top-Tech company does not take responsibility nor does it guarantee against damage and operating anomalies resulting from failure to observe this operating manual.

For repairs, only use

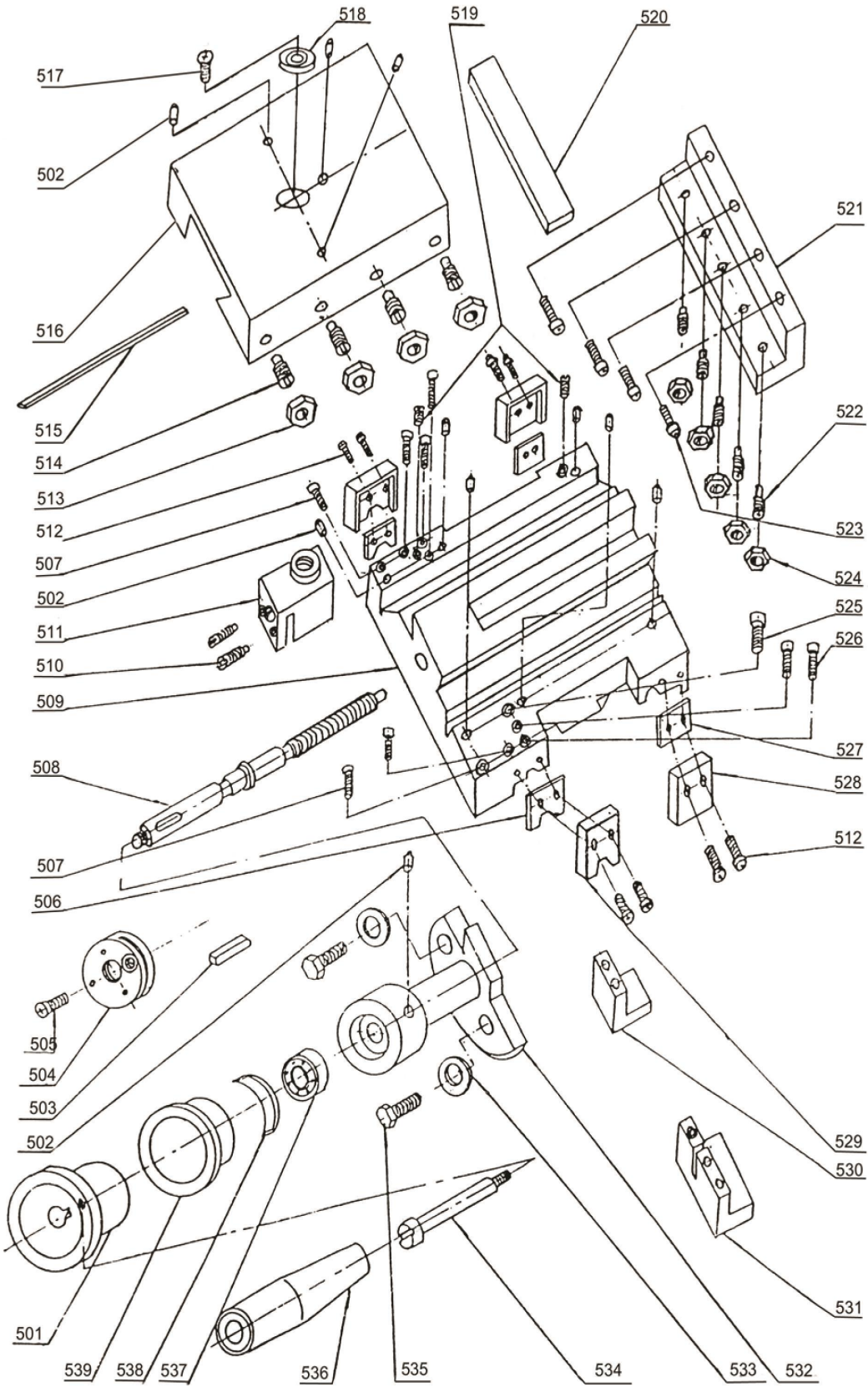
- faultless and suitable tools
- original spare parts or parts from series expressly authorised by Top-Tech company .

6.4 Exploded view of top slide



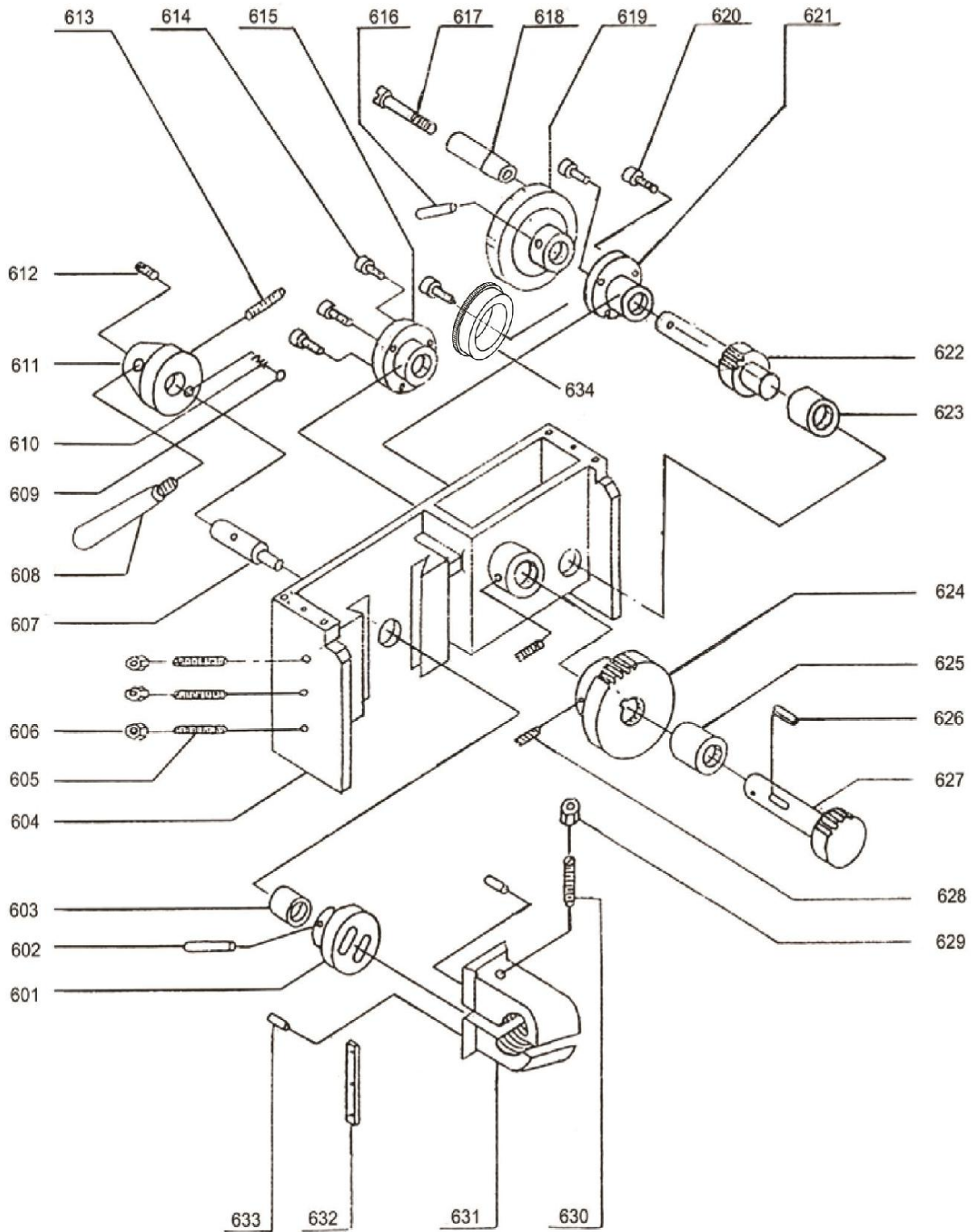
6.4.1 Spare parts list of TOP SLIDE					
Partslst Index No.	JPW Part No.	Description	Size	Q'ty	Supplier's Part No.
401	BD10TP-401	GRADUATED DIAL		1	401
402	BD10TP-402	INTERMEDIATE FLANGE		1	402
403	BD10TP-403	HEXAGON SOCKET SCREW M8×20	M8×20	2	403
404	BD10TP-404	SLIDE GUIDE WAY		1	404
405	BD10TP-405	STRAINING SCREW		1	405
406	BD10TP-406	NUT M4		3	406
407	BD10TP-407	HEXAGON SOCKET SCREW M4×40	M4×40	3	407
408	BD10TP-408	HEXAGON SOCKET SCREW M4×12	M4×12	1	408
409	BD10TP-409	NUT M4	DIN439	1	409
410	BD10TP-410	POSITIONING PIN		1	410
411	BD10TP-411	LATHE TOOL HOLDER		1	411
412	BD10TP-412	SQUARE-HEAD BOLT M8×25		8	412
413	BD10TP-413	HANDLE		1	413
414	BD10TP-414	CLAMPING PIECE		1	414
415	BD10TP-415	WASHER		1	415
416	BD10TP-416	COMPRESSION SPRING	0.8X4X15	1	416
417	BD10TP-417	TOP SLIDE		1	417
418	BD10TP-418	GUIDE BEAD		1	418
419	BD10TP-419	PARALLEL PIN 3×10	DIN6325	1	419
420	BD10TP-420	TOP SLIDE SPINDLE		1	420
421	BD10TP-421	FLAT KEY	3 x 12 mm	1	421
422	BD10TP-422	BALL OILER	6	1	422
423	BD10TP-423	BEARING PEDESTAL		1	423
424	BD10TP-424	HEXAGON SOCKET SCREW M4×16	M4×16	2	424
425	BD10TP-425	SINOUS SPRING		1	425
426	BD10TP-426	HANDLE		2	426
427	BD10TP-427	NUT M8	DIN439	1	427
428	BD10TP-428	WASHER Ø8	DIN6340	1	428
429	BD10TP-429	HANDWHEEL		1	429
430	BD10TP-430	GRADUATED COLLAR		1	430
431	BD10TP-431	HEXAGON SOCKET SCREW M6×16	M6×16	4	431
432	BD10TP-432	PARALLEL PIN 4×16	DIN6325	2	432
	BD10TP-433	SCALE OF TOP SLIDE			433

6.5 Exploded view of CROSS SLIDE



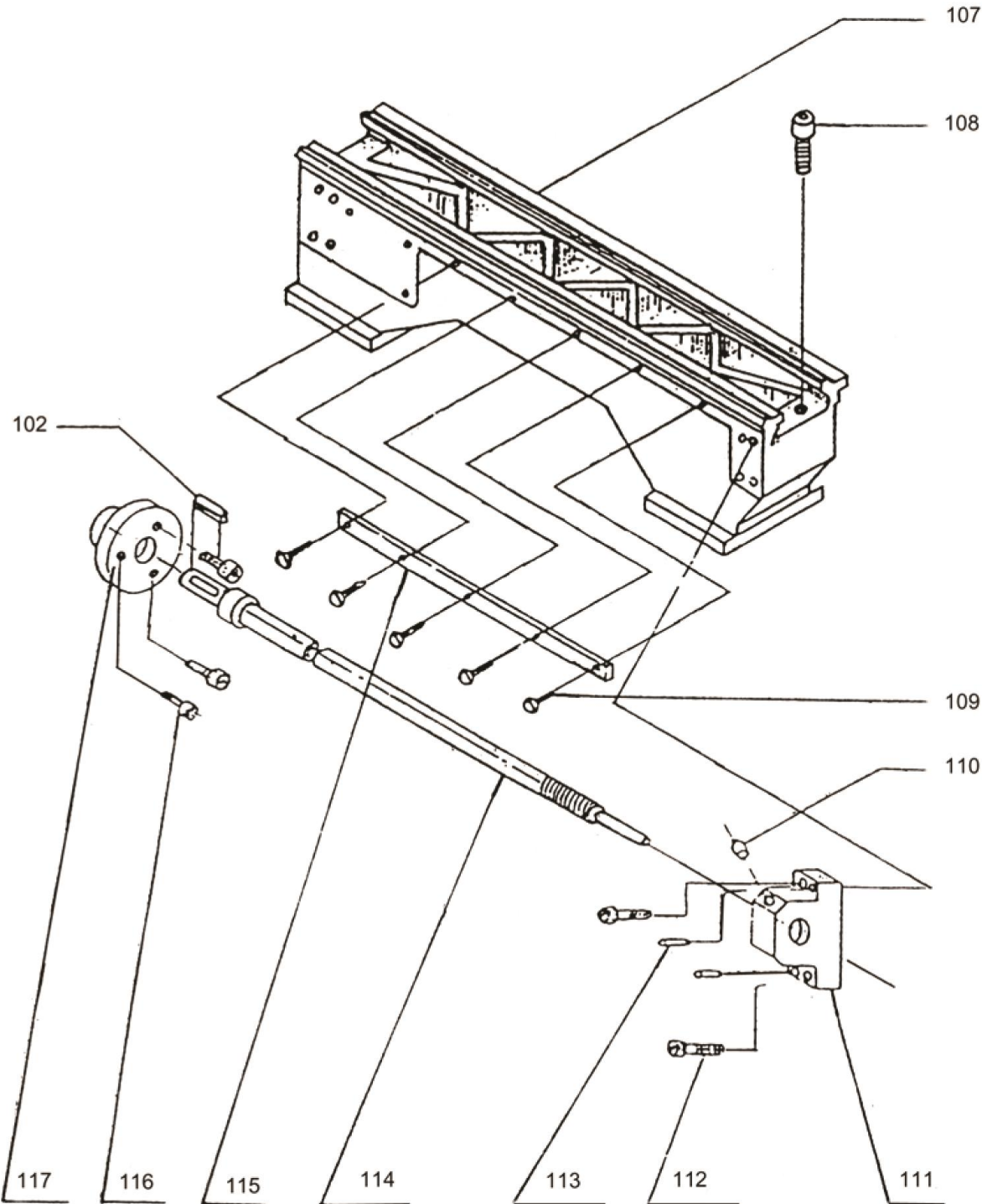
6.5.1 Spare parts list of CROSS SLIDE					
Partslst Index No.	JPW Part No.	Description	Size	Q'ty	Supplier's Part No.
501	BD10CS-501	HANDWHEEL		1	501
502	BD10CS-502	BALL OILER	6	10	502
503	BD10CS-503	FLAT KEY	4 x 12 mm	1	503
504	BD10CS-504	ROUND NUT		1	504
505	BD10CS-505	SCREW M3×6	DIN 912	1	505
506	BD10CS-506	SCRAPER		2	506
507	BD10CS-507	HEXAGON SOCKET SCREW M6×35	M6×35	4	507
508	BD10CS-508	CROSS SLIDE SPINDLE		1	508
509	BD10CS-509	LATHE SADDLE		1	509
510	BD10CS-510	HEXAGON SOCKET SCREW M3×12	M3×12	2	510
511	BD10CS-511	SPINDLE NUT OF CROSS SLIDE		1	511
512	BD10CS-512	SCREW M3×12	DIN 912	8	512
513	BD10CS-513	NUT M5	DIN439	4	513
514	BD10CS-514	HEXAGON SOCKET SCREW M5×25	M5×25	4	514
515	BD10CS-515	GUIDE BEAD		1	515
516	BD10CS-516	CROSS SLIDE		1	516
517	BD10CS-517	HEXAGON SOCKET SCREW M5×10	M5×10	1	517
518	BD10CS-518	WASHER		1	518
519	BD10CS-519	HEXAGON SOCKET SCREW M8×10	M8×10	2	519
520	BD10CS-520	GUIDE BEAD		1	520
521	BD10CS-521	GUIDE RAIL		1	521
522	BD10CS-522	HEXAGON SOCKET SCREW M4×16	M4×16	5	522
523	BD10CS-523	HEXAGON SOCKET SCREW M5×16	M5×16	4	523
524	BD10CS-524	NUT M4	DIN439	5	524
525	BD10CS-525	SCREW M8×20	M8×20	1	525
526	BD10CS-526	SCREW M5X20	M5X20	4	526
527	BD10CS-527	SCRAPER		2	527
528	BD10CS-528	METAL REINFORCEMENT		2	528
529	BD10CS-529	METAL REINFORCEMENT		2	529
530	BD10CS-530	FRONT SAFETY BLOCK		1	530
531	BD10CS-531	SAFETY BLOCK		1	531
532	BD10CS-532	GUIDE BEARING		1	532
533	BD10CS-533	WASHER 8	DIN6340	2	533
534	BD10CS-534	HAND SCREW		1	534
535	BD10CS-535	SCREW M6×20	M6×20	2	535
536	BD10CS-536	HANDLE		1	536
537	BD10CS-537	ROLLING BEARING 51101	DIN620	1	537
538	BD10CS-538	SINOUS SPRING		1	538
539	BD10CS-539	GRADUATED COLLAR		1	539

6.6 Exploded view of Apron



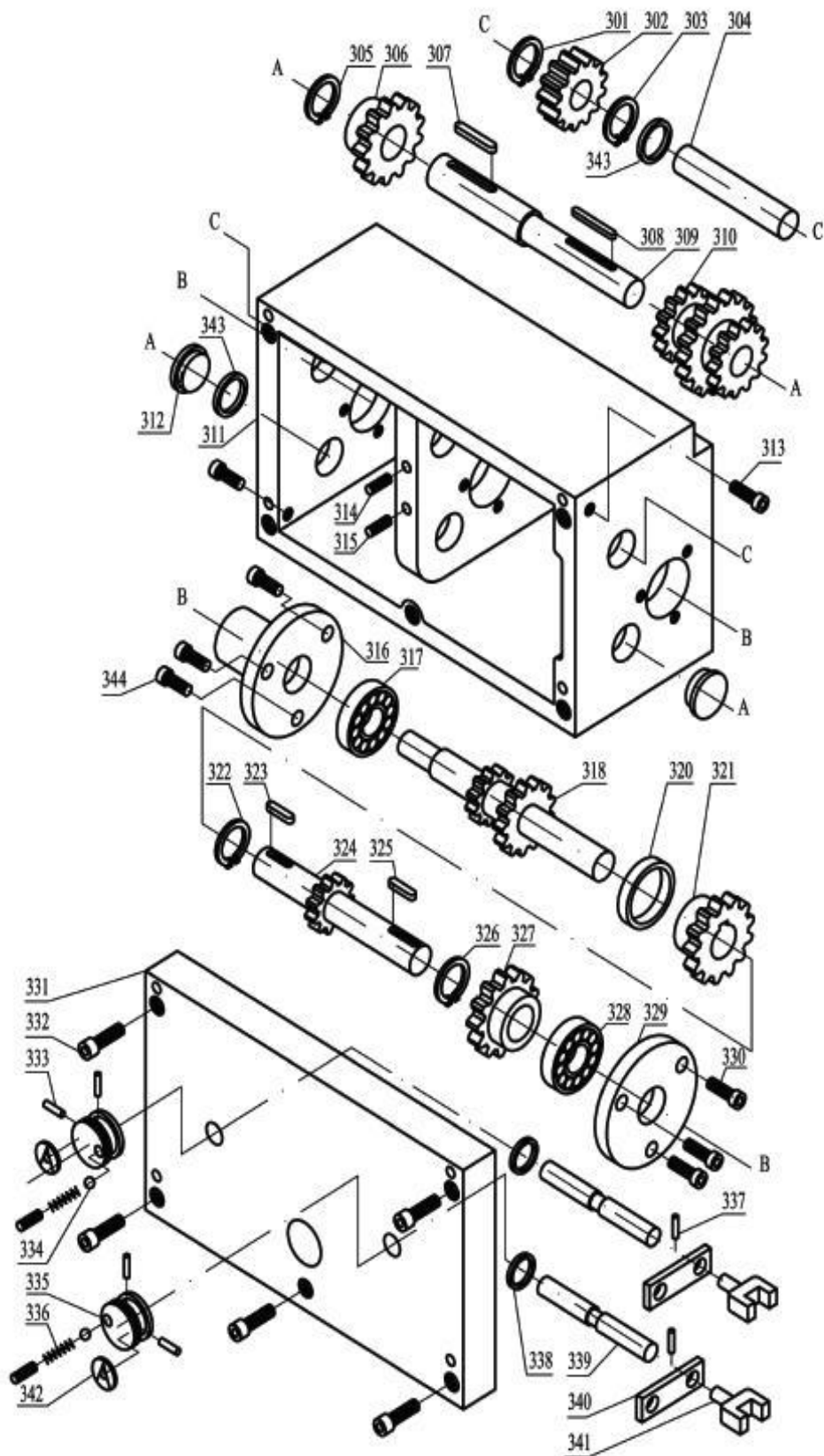
6.6.1 Spare parts list of APPRON					
Partslist Index No.	JPW Part No.	Description	Size	Q'ty	Supplier's Part No.
601	BD10AP-601	ECCENTER		1	601
602	BD10AP-602	TAPER PIN 3×20	DIN7978	1	602
603	BD10AP-603	BUSH		1	603
604	BD10AP-604	HOUSING		1	604
605	BD10AP-605	HEXAGON SOCKET SCREW M5×30	M5×30	3	605
606	BD10AP-606	NUT M5	DIN439	3	606
607	BD10AP-607	SHAFT		1	607
608	BD10AP-608	HANDLE		1	608
609	BD10AP-609	STEEL BALL 5		1	609
610	BD10AP-610	COMPRESSION SPRING 0.8×5×25		1	610
611	BD10AP-611	ENGAGING HUB		1	611
612	BD10AP-612	HEXAGON SOCKET SCREW M6×10	M6×10	1	612
613	BD10AP-613	HEXAGON SOCKET SCREW M4×8	M4×8	3	613
614	BD10AP-614	HEXAGON SOCKET SCREW M4×8	M4×8	3	614
615	BD10AP-615	FLANGE PEDESTAL		1	615
616	BD10AP-616	TAPER PIN 3×30	DIN7978	1	616
617	BD10AP-617	HANDLE BAR		1	617
618	BD10AP-618	HANDLE		1	618
619	BD10AP-619	HANDWHEEL		1	619
620	BD10AP-620	HEXAGON SOCKET SCREW M4×8	M4×8	3	620
621	BD10AP-621	FLANGE PEDESTAL		1	621
622	BD10AP-622	PINION SHAFT		1	622
623	BD10AP-623	BUSH		1	623
624	BD10AP-624	GEARWHEEL		1	624
625	BD10AP-625	BUSH		1	625
626	BD10AP-626	FLAT KEY	5 x 10 mm	1	626
627	BD10AP-627	PINION SHAFT		1	627
628	BD10AP-628	SCREW M4×8	DIN 912	2	628
629	BD10AP-629	NUT M5	DIN439	1	629
630	BD10AP-630	HEXAGON SOCKET SCREW M5×25	M5×25	1	630
631	BD10AP-631	LEADSCREW NUT (SET)		1	631
632	BD10AP-632	GUIDE BEAD		1	632
633	BD10AP-633	PINION PIN 5×20		2	633
634	BD10AP-634	GRADUATED COLLAR		1	634

6.7 Exploded view of LATHE BED



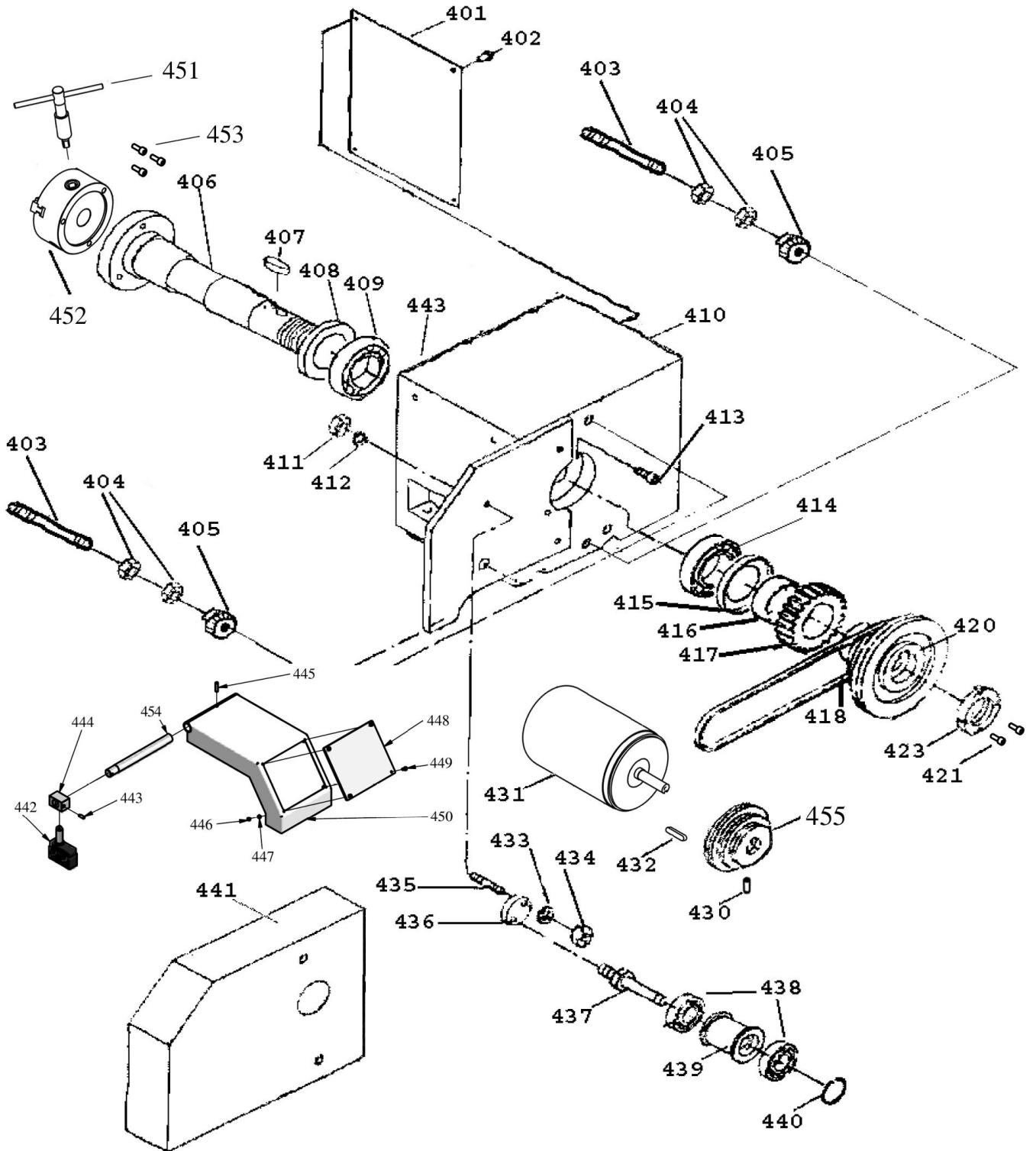
6.7.1 Spare parts list of LATHE BED					
Partslist Index No.	JPW Part No.	Description	Size	Q'ty	Supplier's Part No.
102	BD10LB-102	FLAT KEY	4 x 12 mm	1	102
107	BD10LB-107	LATHE BED		1	107
108	BD10LB-108	HEXAGON SOCKET SCREW M8×12	M8×12	1	108
109	BD10LB-109	HEXAGON SOCKET SCREW M5×12	M5×12	5	109
110	BD10LB-110	BALL OILER	6	1	110
111	BD10LB-111	RIGHT BEARING PEDESTAL		1	111
112	BD10LB-112	HEXAGON SOCKET SCREW M6×16	M6×16	4	112
113	BD10LB-113	FLAT KEYTAPER PIN 6×22	DIN6885	2	113
114	BD10LB-114	LEADSCREW		1	114
115	BD10LB-115	RACK		1	115
116	BD10LB-116	HEXAGON SOCKET SCREW M4×16	M4×16	3	116
117	BD10LB-117	ADJUSTING FLANGE		1	117

6.8 Exploded view of feed gear



6.8.1 Spare parts list of FEED GEAR					
Partslst Index No.	JPW Part No.	Description	Size	Q'ty	Supplier's Part No.
301	BD10FG-301	LOCK WASHER	Φ12	1	301
302	BD10FG-302	GEARWHEEL		1	302
303	BD10FG-303	LOCK WASHER	Φ12	1	303
304	BD10FG-304	SHAFT C		1	304
305	BD10FG-305	CIRCLIP FOR SHAFT Φ16		1	305
306	BD10FG-306	GEARWHEEL		1	306
307	BD10FG-307	FEATHER KEY	4×30	1	307
308	BD10FG-308	FEATHER KEY	4×60	1	308
309	BD10FG-309	SHAFT A		1	309
310	BD10FG-310	GEARWHEEL COMBINATION		1	310
311	BD10FG-311	GEAR WHEEL BOX		1	311
312	BD10FG-312	PLUG		2	312
313	BD10FG-313	SET SCREW ZG3/8	ZG 3/8	2	313
314	BD10FG-314	HEXAGON SOCKET SCREW	M 6×10	1	314
315	BD10FG-315	HEXAGON SOCKET SCREW	M 6×10	1	315
316	BD10FG-316	FLANGE		1	316
317	BD10FG-317	BEARING	180202	1	317
318	BD10FG-318	GEARWHEEL		1	318
319	BD10FG-319	SHAFT	1215	1	319
320	BD10FG-320	SHAFT RING		1	320
321	BD10FG-321	GEARWHEEL		1	321
322	BD10FG-322	CIRCLIP	Φ15	1	322
323	BD10FG-323	FEATHER KEY	4×14	1	323
324	BD10FG-324	LONG-FACE PINION		1	324
325	BD10FG-325	FEATHER KEY	4×10	1	325
326	BD10FG-326	LOCK WASHER	Φ15	1	326
327	BD10FG-327	GEARWHEEL		1	327
328	BD10FG-328	BEARING	180202	1	328
329	BD10FG-329	FLANGE COVER OF LEADSCREW		1	329
330	BD10FG-330	HEXAGON SOCKET SCREW	M 6×12	3	330
331	BD10FG-331	FRONT PLATE		1	331
332	BD10FG-332	HEXAGON SOCKET SCREW M6X20	M6X20	5	332
333	BD10FG-333	SPRING PIN ISO8752	A5×30	2	333
334	BD10FG-334	STEEL BALL	Φ5	2	334
335	BD10FG-335	SELECTOR SWITCH		2	335
336	BD10FG-336	SPRING	0, 8×45×11	2	336
337	BD10FG-337	PIN	Φ5×20	2	337
338	BD10FG-338	O-RING	1800710	2	338
339	BD10FG-339	SHAFT		2	339
340	BD10FG-340	PLATE		2	340
341	BD10FG-341	GEAR FORK		2	341
342	BD10FG-342	SELECTOR SWITCH MARKING		2	342
343	BD10FG-343	RUBBER SEALING RING 14.0X2.65		2	343
344	BD10FG-344	HEX SOCKET HEAD SCREW M5X12	M5X12	3	344
345	BD10FG-345	HEXAGON SOCKET SCREW		1	345
346	BD10FG-346	HEXAGON SOCKET SCREW		1	346

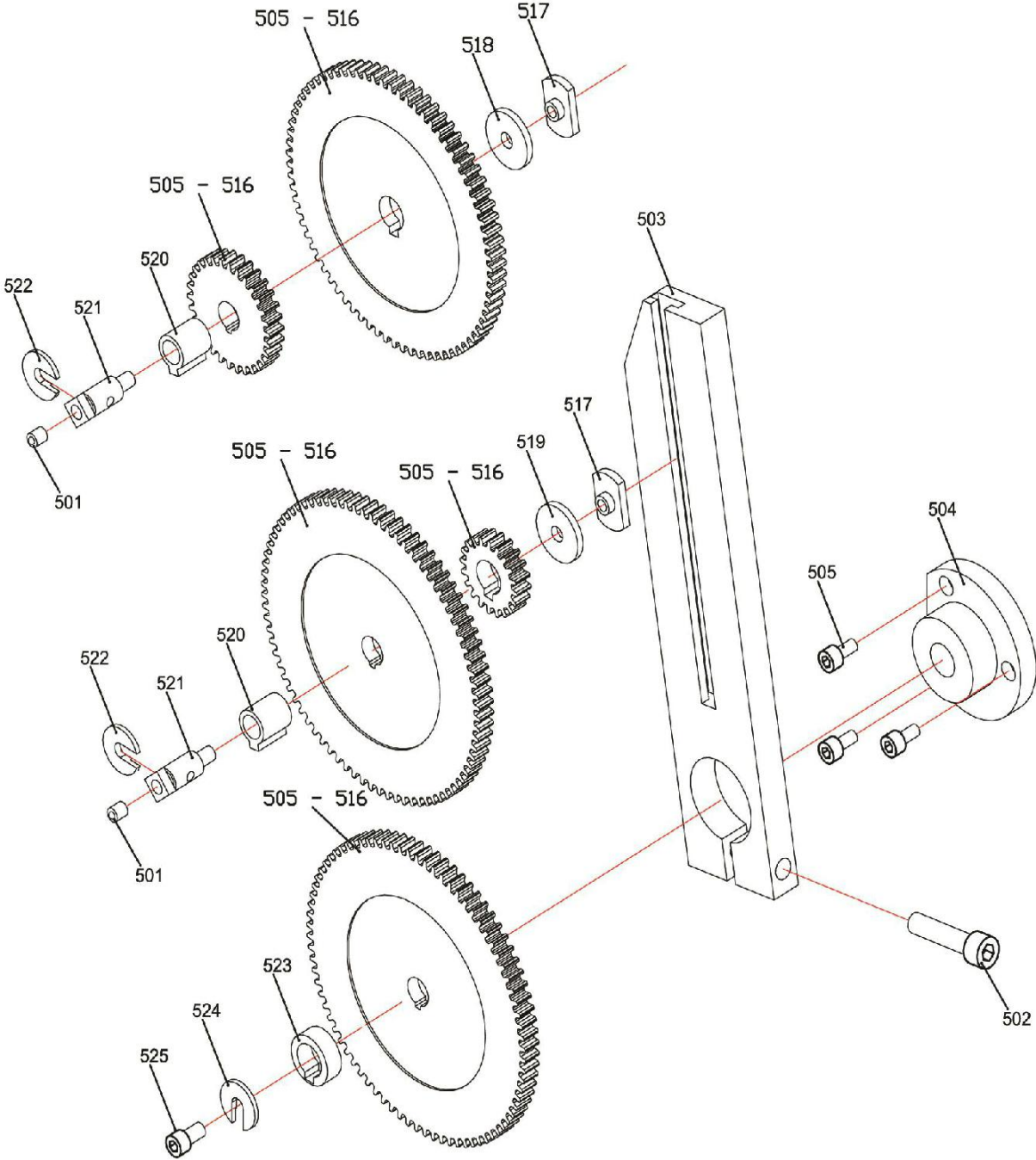
6.9 Exploded view of HANDSTOCK



6.9.1 Spare parts list of HEANSTOCK

Partslist Index No.	JPW Part No.	Description	Size	Q'ty	Supplier's Part No.
401	BD10HD-401	CHARACTERISTICS PLATE		1	401
402	BD10HD-402	FASTENING SCREW	M 4×10	6	402
403	BD10HD-403	PROTECTIVE COVER OF THREADED ROD		2	403
404	BD10HD-404	NUT	M 10	4	404
405	BD10HD-405	KNURL NUT		2	405
406	BD10HD-406	WORK SPINDLE		1	406
407	BD10HD-407	FEATHER KEY	8×45	1	407
408	BD10HD-408	RING		1	408
409	BD10HD-409	BEARING	32009	1	409
410	BD10HD-410	HEADSTOCK		1	410
411	BD10HD-411	NUT	M 10	1	411
412	BD10HD-412	WASHER	10	1	412
413	BD10HD-413	HEXAGON SOCKET SCREW	M8×25	1	413
414	BD10HD-414	BEARING	32009	1	414
415	BD10HD-415	RING		1	415
416	BD10HD-416	BUSH		1	416
417	BD10HD-417	GEARWHEEL		1	417
418	BD10HD-418	SHORT V-BELT	7M-730	1	418
420	BD10HD-420	PULLEY COMBINATION WORK SPINDLE		1	420
421	BD10HD-421	ALLEN SCREWS	M5×12	2	421
423	BD10HD-423	SHAFT NUT (GROOVE NUT)		1	423
430	BD10HD-430	THREADED PIN	ISO 4028-M6X10	1	430
431	BD10HD-431	MOTOR	110ZYT59T1	1	431
432	BD10HD-432	FLAT KEY	4 x 30 mm	1	432
433	BD10HD-433	WASHER		1	433
434	BD10HD-434	HEXAGONAL NUT M8	DIN439	1	434
435	BD10HD-435	ALLEN SCREWS		1	435
436	BD10HD-436	ECCENTRIC OF TENSION PULLEY		1	436
437	BD10HD-437	SHAFT OF TENSION PULLEY		1	437
438	BD10HD-438	BEARING 6001RZ	6001RZ	2	438
439	BD10HD-439	TENSION PULLEY		1	439
440	BD10HD-440	CIRCLIP		1	440
441	BD10HD-441	HANGING WHEEL BOX COVER		1	441
442	BD10HD-442	MICRO SWITCH		1	442
443	BD10HD-443	HEXAGONAL CYLINDRICAL SIDE SCREW	M5×12	1	443
444	BD10HD-444	SHAFT SLEEVE		1	444
445	BD10HD-445	CYLINDRICAL PIN	3×20	1	445
446	BD10HD-446	NUT	M4	4	446
447	BD10HD-447	FLAT WASHER	Φ4	4	447
448	BD10HD-448	PROTECTIVE GLASSES		1	448
449	BD10HD-449	SOCKET HEAD CAP SCREW	M4×10	4	449
450	BD10HD-450	CHUCK SHIELD		1	450
451	BD10HD-451	KEY FOR 3 - JAW CHUCK	10mm	1	451
452	BD10HD-452	THREE JAW CHUCK	K11-125	1	452
453	BD10HD-453	HEXAGON SOCKET SCREW	M8X35	3	453
454	BD10HD-454	CHUCK SHIELD SHAFT		1	454
455	BD10HD-455	MOTOR PULLEY		1	455

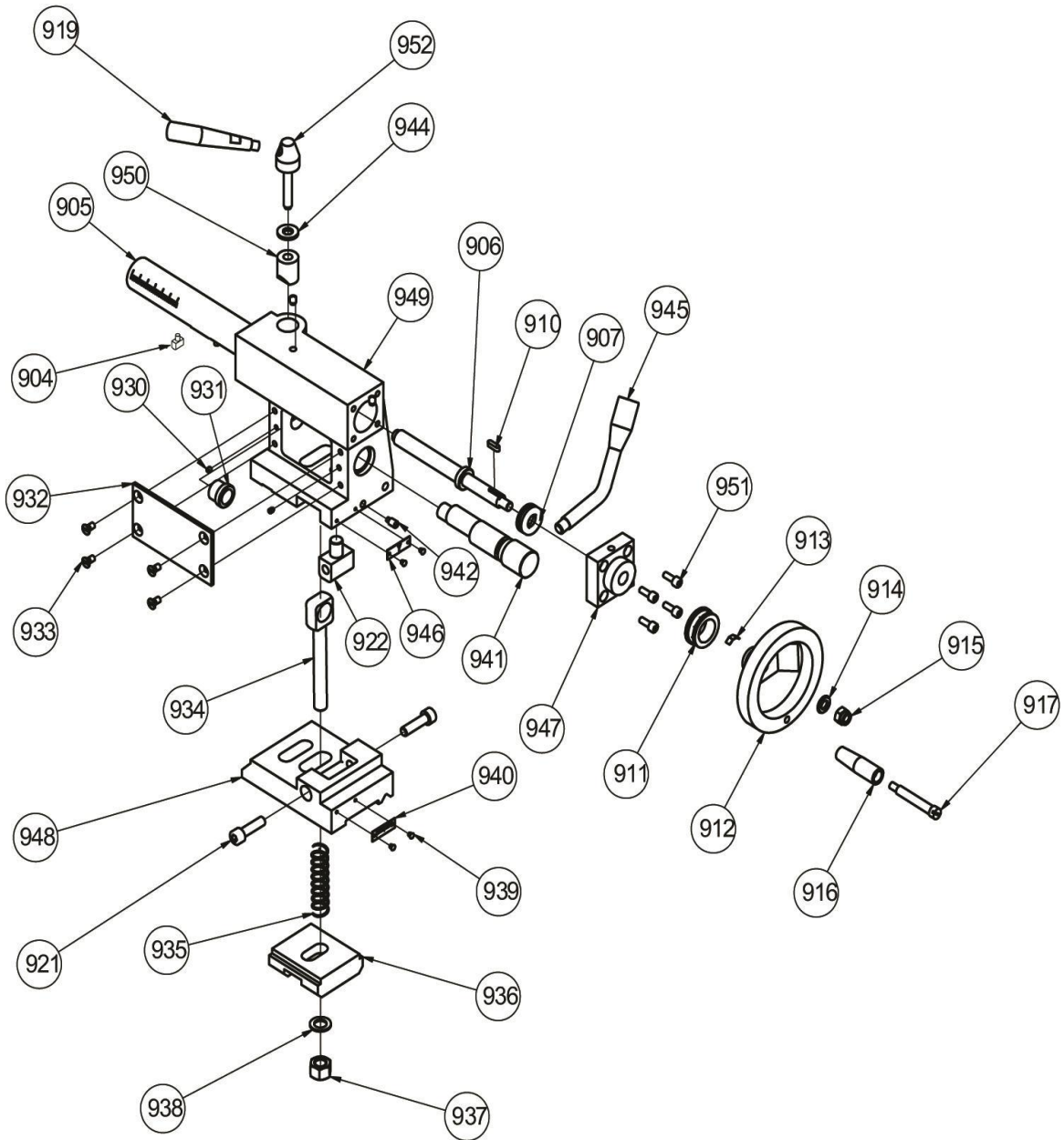
6.10 Exploded view of change gear



6.10.1 Spare parts list of CHANGE GEAR

Partslist Index No.	JPW Part No.	Description	Size	Q'ty	Supplier's Part No.
501	BD10CG-47	OIL NIPPLE		2	501
502	BD10CG-48	HEXAGONAL SOCKET HEAD SCREW DIN 912	M 8×35	1	502
503	BD10CG-4-503	CHANGE GEAR RAIL		1	503
504	BD10CG-4-504	BEARING PEDESTAL		1	504
505	BD10CG-49	HEXAGONAL SOCKET HEAD SCREW DIN 912	M5×10	3	505
506	BD10CG-4-506	GEAR	Z85, Module 1,5	1	506
507	BD10CG-4-507	GEAR	Z80, Module 1,5	1	507
508	BD10CG-4-508	GEAR	Z75, Module 1,5	1	508
509	BD10CG-4-509	GEAR	Z70, Module 1,5	1	509
510	BD10CG-4-510	GEAR	Z65, Module 1,5	1	510
511	BD10CG-4-511	GEAR	Z60, Module 1,5	2	511
512	BD10CG-4-512	GEAR	Z50, Module 1,5	1	512
513	BD10CG-4-513	GEAR	Z45, Module 1,5	1	513
514	BD10CG-4-514	GEAR	Z30, Module 1,5	1	514
515	BD10CG-4-515	GEAR	Z25, Module 1,5	1	515
516	BD10CG-4-516	GEAR	Z20, Module 1,5	1	516
517	BD10CG-4-517	T-NUT	M5	2	517
518	BD10CG-4-518	SPACER	1,5mm	1	518
519	BD10CG-4-519	SPACER	3mm	1	519
520	BD10CG-4-520	BUSHING		2	520
521	BD10CG-4-521	AXLE SHAFT		2	521
522	BD10CG-4-522	C-WASHER		2	522
523	BD10CG-4-523	COLLAR SPREADER		1	523
524	BD10CG-4-524	C-WASHER		1	524
525	BD10CG-50	HEXAGONAL SOCKET HEAD SCREW DIN 912	M6×10	1	525

6.11 Exploded view of tailstock



6.11.1 Spare parts list of TAILSTOCK

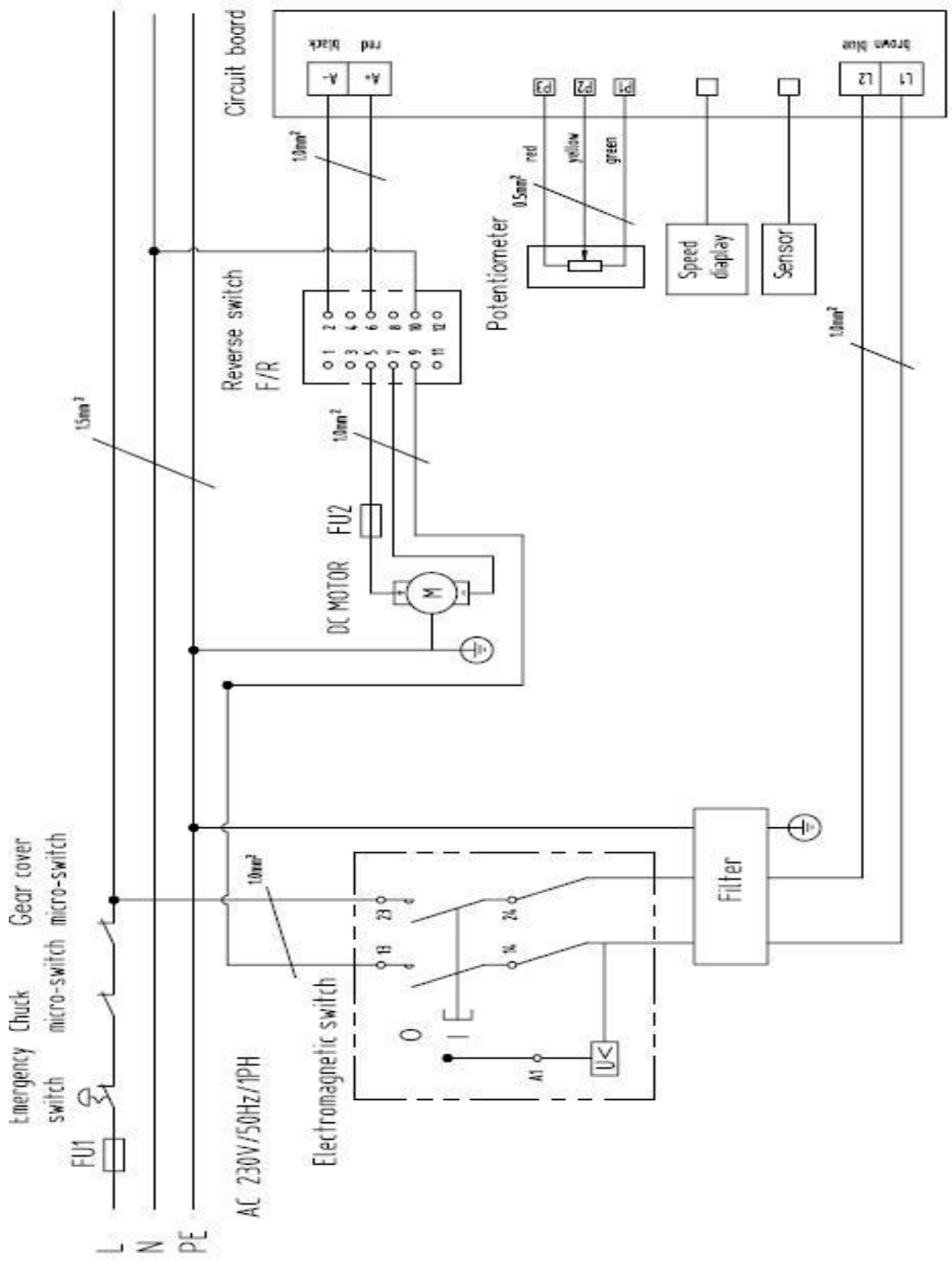
Partslist Index No.	JPW Part No.	Description	Size	Q'ty	Supplier's Part No.
904	BD10TS-904	PIECE OF CENTERING OF SPINDLE SLEEVE		1	904
905	BD10TS-905	SPINDLE SLEEVE		1	905
906	BD10TS-906	SPINDLE		1	906
907	BD10TS-907	AXIALLY GROOVED BALL BEARING	51101	1	907
910	BD10TS-910	FLAT KEY	4 x 14 mm	1	910
911	BD10TS-911	SCALES RING		1	911
912	BD10TS-912	HAND WHEEL		1	912
913	BD10TS-913	SPRING PLATE		1	913
914	BD10TS-914	WASHER	ISO 7090 - 8	1	914
915	BD10TS-915	HEXAGON NUT	DIN 6924 -M8	1	915
916	BD10TS-916	CASE FOR HANDLE		1	916
917	BD10TS-917	FIXING BOLT FOR CASE		1	917
919	BD10TS-919	CLAMPING LEVER		1	919
921	BD10TS-921	SOCKET HEAD SCREW	GB 70-85 - M8 x 30	2	921
922	BD10TS-922	PIECE OF CENTERING OF SPINDLE SLEEVE		1	922
930	BD10TS-930	THREADED PIN	ISO 4028 - M4 x 5	1	930
931	BD10TS-931	GUIDE BUSH		1	931
932	BD10TS-932	COVER		1	932
933	BD10TS-933	COUNTERSUNK SCREW	ISO 2009 - M5 x 10	4	933
934	BD10TS-934	TIGHTENING SCREW		1	934
935	BD10TS-935	SPRING	1.2 x 13.2 x 40 mm	1	935
936	BD10TS-936	CLAMPING PLATE		1	936
937	BD10TS-937	HEXAGON NUT	ISO 4035 -M12	1	937
938	BD10TS-938	WASHER		1	938
939	BD10TS-939	RIVET		4	939
940	BD10TS-940	SCALE		1	940
941	BD10TS-941	ECCENTRIC CAM		1	941
942	BD10TS-942	THREADED PIN	ISO 4028 -M6 x 12	1	942
944	BD10TS-944	WASHER		1	944
945	BD10TS-945	CLAMPING LEVER		1	945
946	BD10TS-946	SCALE		1	946
947	BD10TS-947	SADDLE		1	947
948	BD10TS-948	BASE PLATE TAILSTOCK		1	948
949	BD10TS-949	TAILSTOCK UPPER SECTION		1	949
950	BD10TS-950	CLAMPING PART COLLAR		1	950
951	BD10TS-951	SOCKET HEAD SCREW	GB 70-85 -M5 x 14	4	951
952	BD10TS-952	HEAD CLAMPING LEVER		1	952

6. 11. 1 Spare parts list of TAILSTOCK

Partslist Index No.	JPW Part No.	Description	Size	Q'ty	Supplier's Part No.
904	BD10TS-904	PIECE OF CENTERING OF SPINDLE SLEEVE		1	904
905	BD10TS-905	SPINDLE SLEEVE		1	905
906	BD10TS-906	SPINDLE		1	906
907	BD10TS-907	AXIALLY GROOVED BALL BEARING	51101	1	907
910	BD10TS-910	FLAT KEY	4 x 14 mm	1	910
911	BD10TS-911	SCALES RING		1	911
912	BD10TS-912	HAND WHEEL		1	912
913	BD10TS-913	SPRING PLATE		1	913
914	BD10TS-914	WASHER	ISO 7090 - 8	1	914
915	BD10TS-915	HEXAGON NUT	DIN 6924 -M8	1	915
916	BD10TS-916	CASE FOR HANDLE		1	916
917	BD10TS-917	FIXING BOLT FOR CASE		1	917
919	BD10TS-919	CLAMPING LEVER		1	919
921	BD10TS-921	SOCKET HEAD SCREW	GB 70-85 - M8 x 30	2	921
922	BD10TS-922	PIECE OF CENTERING OF SPINDLE SLEEVE		1	922
930	BD10TS-930	THREADED PIN	ISO 4028 - M4 x 5	1	930
931	BD10TS-931	GUIDE BUSH		1	931
932	BD10TS-932	COVER		1	932
933	BD10TS-933	COUNTERSUNK SCREW	ISO 2009 - M5 x 10	4	933
934	BD10TS-934	TIGHTENING SCREW		1	934
935	BD10TS-935	SPRING	1.2 x 13.2 x 40 mm	1	935
936	BD10TS-936	CLAMPING PLATE		1	936
937	BD10TS-937	HEXAGON NUT	ISO 4035 -M12	1	937
938	BD10TS-938	WASHER		1	938
939	BD10TS-939	RIVET		4	939
940	BD10TS-940	SCALE		1	940
941	BD10TS-941	ECCENTRIC CAM		1	941
942	BD10TS-942	THREADED PIN	ISO 4028 -M6 x 12	1	942
944	BD10TS-944	WASHER		1	944
945	BD10TS-945	CLAMPING LEVER		1	945
946	BD10TS-946	SCALE		1	946
947	BD10TS-947	SADDLE		1	947
948	BD10TS-948	BASE PLATE TAILSTOCK		1	948
949	BD10TS-949	TAILSTOCK UPPER SECTION		1	949
950	BD10TS-950	CLAMPING PART COLLAR		1	950
951	BD10TS-951	SOCKET HEAD SCREW	GB 70-85 -M5 x 14	4	951
952	BD10TS-952	HEAD CLAMPING LEVER		1	952

6.12

Wiring Diagram BD-10VS



Spare parts list BD-10VS (230V)

Designation	Model	Quantity	Note
Electromagnetic switch	KJD17GF	1	
Reverse Switch F/R	ZH-A	1	
Filter	NF211B10/02	1	
Emergency stop	ZB2-BE102C 240V 3A	1	
Circuit board	JYMC-220A-I 230VAC 12ADC	1	
Potentiometer	WX14-12 4K7	1	
Speed display and sensor	JD011 5V	1	
DC Motor	ZYT110/59T1	1	
FU1, FU2	10A	2	
Gear Guard Switch	QKS8	1	
Chunk Guard Switch	LXW5-11Q1	1	

7 Anomalies

7.1 Anomalies in the lathe

Problem	Cause / possible effects	Solution
Machine does not switch-on	<ul style="list-style-type: none"> • Precedence of switch-on not considered. • Release of the FI protected switch. 	<ul style="list-style-type: none"> • Power connection
Surface of workpiece too rough	<ul style="list-style-type: none"> • Tool blunt • Tool springs • Feed too high • Radius at the tool tip too little 	<ul style="list-style-type: none"> • Resharpen tool • Clamp tool with less overhang • Reduce feed • Increase radius
Workpiece is becoming coned	<ul style="list-style-type: none"> • Centres are not aligned (tailstock has offset) • Top slide not aligned well (cutting with the top slide) 	<ul style="list-style-type: none"> • Adjust tailstock to the centre • Align top slide well
Lathe is chattering	<ul style="list-style-type: none"> • Feed too high • Main bearings have clearance 	<ul style="list-style-type: none"> • Reduce feed • Have the main bearing readjusted
Centre runs hot	<ul style="list-style-type: none"> • Workpiece has expanded 	<ul style="list-style-type: none"> • Loosen tailstock tip
Tool has a short edge life	<ul style="list-style-type: none"> • Cutting speed too high • Crossfeed too high • Insufficient cooling 	<ul style="list-style-type: none"> • Reduce cutting speed • Lower crossfeed/smooth finish (allowance not over 0.5 mm) • More coolant
Flank wear too high	<ul style="list-style-type: none"> • Clearance angle too small (tool "pushes") • Tool tip not adjusted to centre height 	<ul style="list-style-type: none"> • Increase clearance angle • Correct height adjustment of the tool
Cutting edge breaks off	<ul style="list-style-type: none"> • Wedge angle too small (heat build-up) • Grinding crack due to wrong cooling • Excessive clearance in the spindle bearing arrangement (vibrations) 	<ul style="list-style-type: none"> • Increase wedge angle • Cool uniformly • Have the clearance in the spindle bearing arrangement readjusted
Cut thread is wrong	<ul style="list-style-type: none"> • Tool is clamped incorrectly or has been started grinding the wrong way • Wrong pitch • Wrong diameter 	<ul style="list-style-type: none"> • Adjust tool to the centre - Grind angle correctly • Adjust the right pitch • In a previous step, turn the workpiece to the correct diameter

8 Appendix

8.1 Copyright

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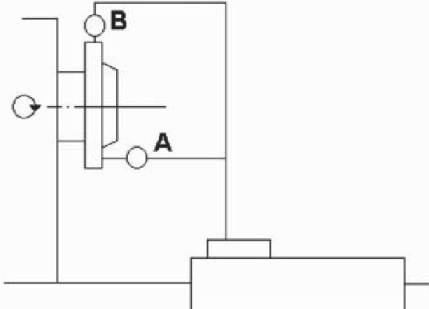
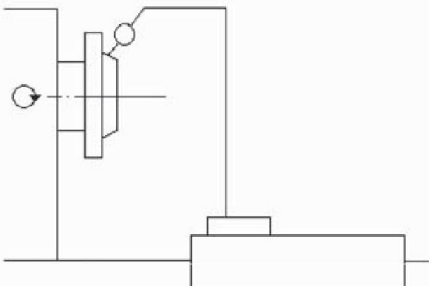
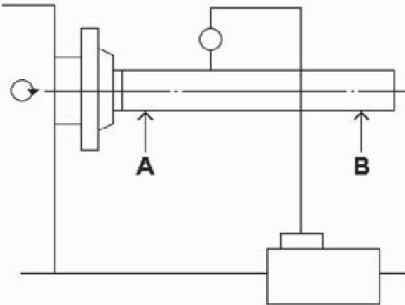
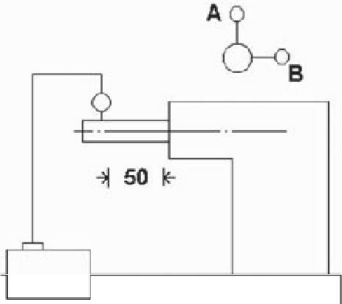
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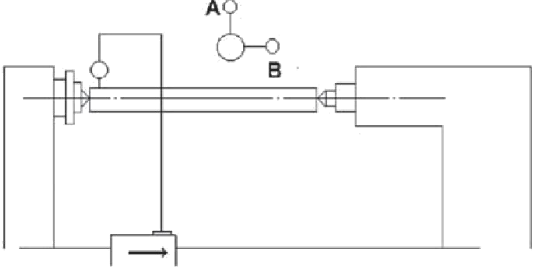
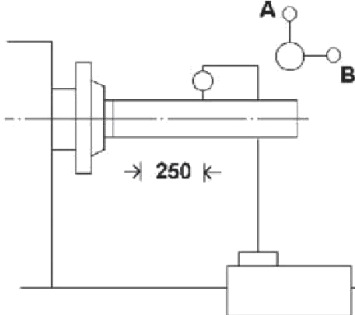
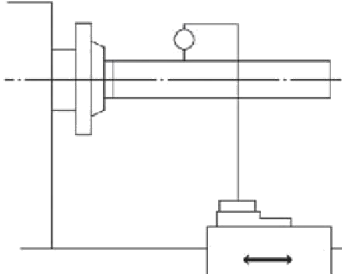
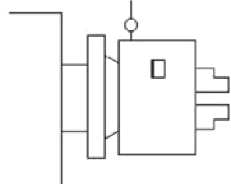
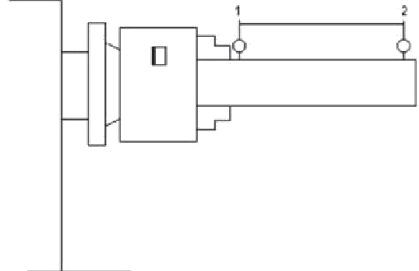
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8.2 Terminology/Glossary

Term	Explanation
Headstock	Housing for the feed gear and the synchronous belt pulleys
Leadscrew nut	Split nut which engages in the leadscrew
Lathe chuck	Clamping tool for holding the workpiece
Drill chuck	Device for holding the bit
Lathe saddle	Slide on the slideway of the machine bed which feeds parallel to the tool axis
Cross slide	Slide on the lathe saddle which moves transversely to the tool axis
Top slide	Swivelling slide on the cross slide
Taper mandrel	Taper of the bit, the drill chuck or the centre
Tool	Cutting tool, bit, etc.
Workpiece	Piece to be turned or machined
Tailstock	Movable turning aid
Rest	Follow or steady support for turning long workpieces
Lathe dog	Device or clamping aid for driving pieces to be turned between centres

9 Acceptance test report

N°	Test object	Drawing	Allowed deviation [mm]	Measured deviation [mm]
1	Periodical axial slip of spindle and run out of spindle		A: 0,009 B: 0,01	A: B:
2	Run out of spindle nose centring taper		0,009	
3	Run out of internal taper of spindle		A: 0,015 B: 0,03	A: B:
4	Parallelism of receiving taper in tailstock A = vertical plane B = horizontal plane		A: 0,025/50 B: 0,015/50	A: B:

N°	Test object	Drawing	Allowed deviation [mm]	Measured deviation [mm]
5	Headstock and tailstock centres for same height above reference plane Receiving taper in spindle (MT 3) Receiving taper in tailstock (MT 2)		A: 0,03	A:
6	Parallelism of spindle axis A = vertical plane B = horizontal plane		A: 0,03/250 B: 0,03/250	A: B:
7	Parallelism of spindle axis with longitudinal movement of upper slide		0,04/75	
8	Run out of jaw chuck		0,04	
9	Run out of jaw chuck Test pin A : $\varnothing 20\text{mm}$ B : $\varnothing 30\text{mm}$		A) 1: 0,04 2: 0,08/100 B) 1: 0,04 2: 0,08/100	A) 1: 2: B) 1: 2:

10.0 Packing list

BD-10VS standar accessories part

Part NO.	Name	Specification	Quantity
1	oil gun		1
2	hexagon wrench	2.5/3/4/5/6	5
3	double end spanner	8-10/12-14/17-19	3
4	chuck spanner		1
5	steady center	MT2	1
6	follow center	MT4	1
7	reverse chuck 3 jaws	Φ125mm	3
8	painting can		2
9	handle		2
10	change gears	30/45/50/60/60/65/85T	7
14	T allen key	6mm	1
15	gross screwdriver	3"	1
16	straight screwdriver	3"	1
17	quadruple tool holder spanner	8mm	1
18	fuse	10A	2
21	gates belt	7M-710	1

