



OPERATOR'S HANDBOOK

WM-240



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NOTE

The information contained in this handbook is intended as a guide to the operation of these machines and does not form part of any contract. The data it contains has been obtained from the machine manufacturer and from other sources. Whilst every effort has been made to ensure the accuracy of these transcriptions it would be impracticable to verify each and every item. Furthermore, development of the machine may mean that the equipment supplied may differ in detail from the descriptions herein. The responsibility therefore lies with the user to satisfy himself that the equipment or process described is suitable for the purpose intended.

A. LIMITED WARRANTY

Warren Machine Tools Ltd. Makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follow: 1 YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE. This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and tear, repair or alterations outside our facilities, or to a lack of maintenance.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, the product or part must be returned to us for examination, postage prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product, or refund the purchases price if we cannot readily and quickly provide a repair or replacement, if you are willing to accept a refund. We will return repaired product or replacement at WARCO'S expense, but if it is determined there in no defect, or that the defect resulted from causes not within the scope of WARCO'S warranty, then the user must bear the cost of storing and returning the product.

The manufacturers reserve the right to change specifications at any time as they continually strive to achieve better quality equipment.

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WARNING!

Read and understand the entire instruction manual before attempting set-up or operation of this machine!

1. **This machine is designed and intended for use by properly trained and experienced personnel only.** If you are not familiar with the proper safe use of lathes, do not use this machine until proper training and knowledge has been obtained.
2. **Keep guards in place.** Safety guards must be kept in place and in working order.
3. **Remove adjusting keys and wrenches.** Before turning on machine, check to see that any adjusting wrenches are removed from the tool.
4. **Reduce the risk of unintentional starting.** Make sure switch is in the OFF position before plugging in the tool.
5. **Do not force tool.** Always use a tool at the rate for which it was designed.
6. **Use the right tool.** Do not force a tool or attachment to do a job for which it was not designed.
7. **Maintain tools with care.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubrication and changing accessories.
8. **Always disconnect the machine from the power source before adjusting or servicing.**
9. **Check for damaged parts.** Check for alignment of moving parts, breakage of parts, mounting, and any other condition that may affect the tools operation. A guard or any part that is damaged should be repaired or replaced.
10. **Turn power off. Never leave a machine unattended.** Do not leave a machine until it comes to a complete stop.
11. **Keep work area clean,** Cluttered areas and bench invite accidents.
12. **Do not use in a dangerous environment.** Do not use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
13. **Keep children and visitors away.** All visitors should be kept a safe distance from the work area.
14. **Make the workshop child proof.** Use padlocks, master switches, and remove starter keys.
15. **Wear proper apparel.** Loose clothing, gloves, neckties, rings, bracelets, or other jewelry may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair. Do not wear any type of glove.
16. **Always use safety glasses.** Every day glasses only have impact resistant lenses; they are not safety glasses.
17. **Do not overreach.** Keep proper footing and balance at all times.
18. **Don not put hands near the cutter while the machine is operating.**
19. **Do not perform any set-up work while machine is operating.**
20. **Read and understand all warnings posted on the machine.**
21. **This manual is intended to familiarize you with the technical aspects of this lathe.** It is not, nor was it intended to be a training manual.
22. **Failure to comply with all of these warnings may result in serious injury.**
23. **Some dust created** by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are lead from lead based paint; crystalline silica from bricks and cement and other masonry products.
24. **Your risk from those exposures** varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter our microscopic particles.

SPECIFICATIONS:

	WM240
Capacities:	
Swing Over Bed	210/240mm
Swing Over Cross Slide	120mm
Distance Between Centers	400mm
Width of Bed	135mm
Headstock:	
Hole Through Spindle	21mm
Taper in Spindle Nose	MT3
Number of Spindle Speeds	Variable
Range of Spindle Speeds	30~2350RPM
Feeding and Threading:	
Number of Metric Threads	12
Range of Metric Threads	0.4~3mm
Number of Imperial Threads	8
Range of Imperial Threads	10~44 T.P.I.
Range of Longitudinal Feed	0.1~0.20mm
Compound and Carriage:	
Tool Post Type	4-Way
Maximum Compound Slide Travel	75mm
Maximum Cross Slide Travel	85mm
Maximum Carriage Travel	300mm
Tailstock:	
Tailstock Spindle Travel	75mm
Taper in Tailstock Spindle	MT2
Miscellaneous:	
Main Motor	1.1KW, 240V/ 1Ph/50Hz
Dimension:	
Length	940mm
Width	550mm
Height	550mm
Weight	110KGS

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⚠ WARNING!

**Read and understand the entire contents of this Manual before attempting set-up or operation!
Failure to comply may cause serious injury!**

CONTENTS OF SHIPPING CONTAINER

- 1 WM240 Lathe
- 1 Steady Rest
- 1 Follow Rest
- 1 Face Plate
- 1 Operator's Manual
- 1 Toolbox

TOOLBOX CONTENTS (Fig. 1)

- 1 Dead Center MT3
- 1 Dead Center MT2
- 3 External Jaw
- 1 Oil Gun
- 1 Spanner for Spindle Adjustment
- 1 Cross Screwdriver
- 1 Flat Screwdriver
- 1 Safety Key for 3-Jaw Chuck
- 1 Key for 4-Jaw Chuck
- 1 Tool Post Square Wrench
- 1 "T" Wrench for Change Gear
- 5 Hex Socket Wrench
- 3 Double End Head Wrench
- 10 Change Gears



Fig. 1

UNCRATING AND CLEAN-UP

1. Finish removing the wooden crate from around the lathe
2. Check all the accessories of the machine tool according to the packing list.
3. Unbolt the lathe from the shipping crate bottom.
4. Choose a location for the lathe that is dry, has good lighting and has enough room to be able to service the lathe on all four sides.
5. With adequate lifting equipment, slowly raise the lathe off the shipping crate bottom. **Do not lift by spindle.** Make sure lathe is balanced before moving to sturdy bench or stand.
6. To avoid twisting the bed, the lathe's location must be absolutely flat and level. Bolt the lathe to the stand (if used). If using a bench, through bolt for best performance.
7. Clean all rust protected surfaces using a mild commercial solvent, kerosene or diesel fuel. Do not use paint thinner, gasoline or lacquer thinner. These will damage painted surfaces. Cover all cleaned surfaces with a light film of 20W machine oil.
8. Remove the end gear cover. Clean all components of the end gear assembly and coat all gears with a heavy, non-slinging grease.

FOUNDATION DRAWING

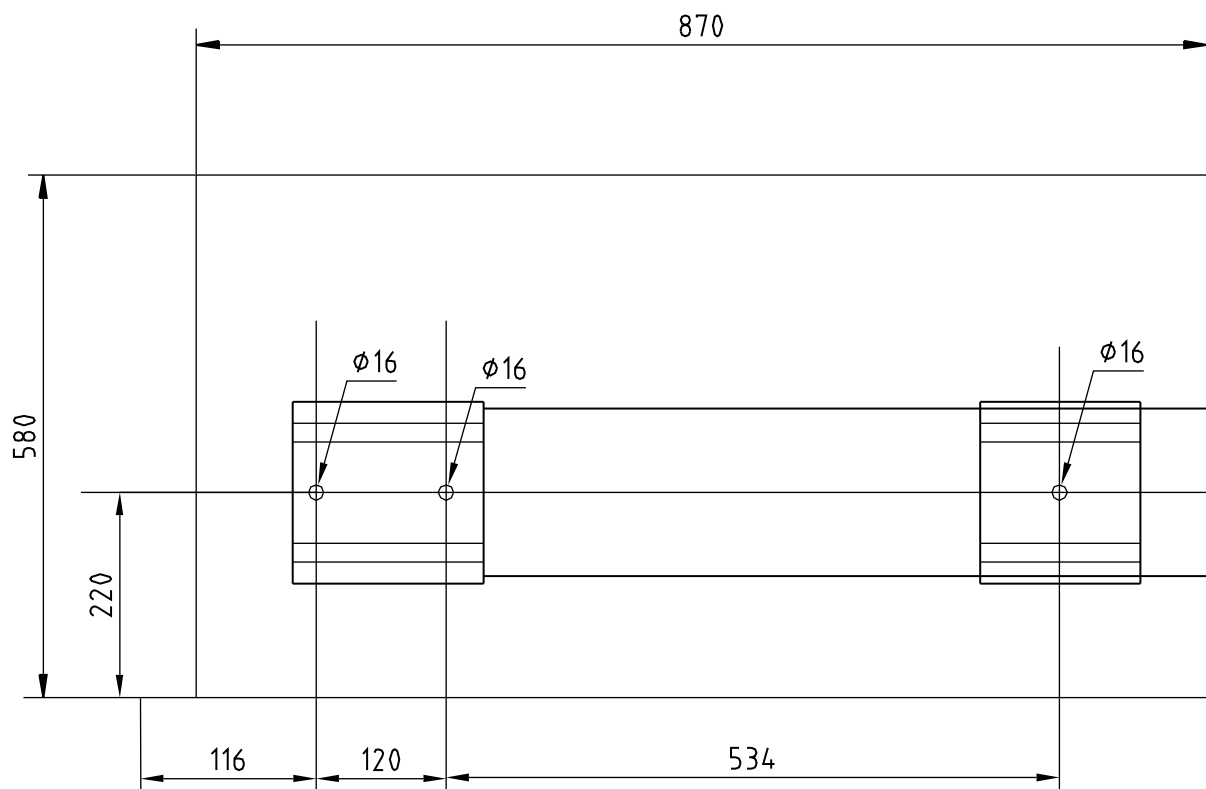


Fig. 2

GENERAL DESCRIPTION

Lathe Bed (Fig. 3)

The lathe bed is made of high-grade iron. By combining high cheeks with strong cross ribs, a bed of low vibration and rigidity is produced. It integrates the headstock and drive unit, for attaching the carriage and leadscrew. The two precision-ground V – sideways, re-enforced by heat hardening and grinding, are the accurate guide for the carriage and tailstock. The main motor is mounted to the rear of the left side of the bed.

Headstock (Fig. 4)

The headstock is cast from high grade, low vibration cast iron. It is bolted to the bed with four screws. The headstock houses the main spindle with two precision taper roller bearings and the drive unit.

The main spindle transmits the torque during the turning process. It also holds the workpieces and clamping devices. (e.g. 3-jaw chuck).

Carriage (Fig. 5)

The carriage is made from high quality cast iron. The slide parts are smoothly ground. They fit the V on the bed without play. The lower sliding parts can be easily and simply adjusted. The cross slide is mounted on the carriage and moves on a dove tailed slide. Play in the cross slide may be adjusted with the gibs.

Move the cross slide with its conveniently positioned handwheel. There is a graduated collar on the handwheel.

A four way tool post is fitted on the top slide and allows four tools to be clamped. Loosen the center clamp handle to rotate any of the four tools into position.

Apron (Fig. 6)

The apron is mounted on the bed. It houses the half nut with an engaging lever for activating the automatic feed. The half nut gibs can be adjusted from the outside.

A rack, mounted on the bed, and a pinion operated by handwheel on the carriage allow for quick travel of the apron.

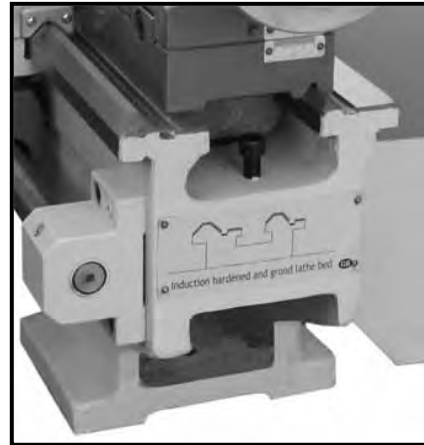


Fig. 3



Fig. 4

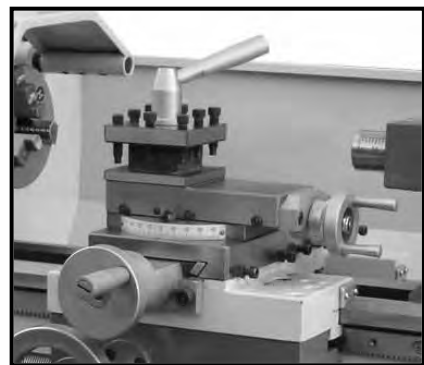


Fig. 5

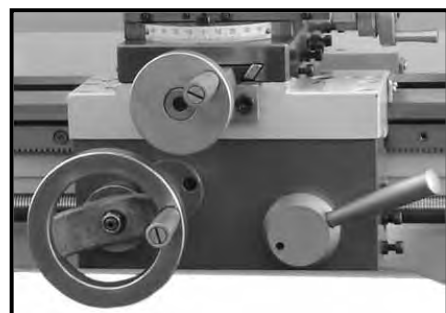


Fig. 6

Leadscrew

The leadscrew (A, Fig.7) is mounted on the front of the machine bed. It is connected to the quadrant at the left and is supported by bearing on both ends.

Tailstock (Fig. 8)

The tailstock slides on a V way and can be clamped at any location. The tailstock has a heavy-duty spindle with a Morse taper No. 2 socket and a graduated scale. The spindle can be clamped at any location with a clamping lever. The spindle is moved with a handwheel at the end of the tailstock.

NOTE:

Fit the securing screw (B, Fig. 8) at the end of the lathe in order to prevent the tailstock from falling off the lathe bed.

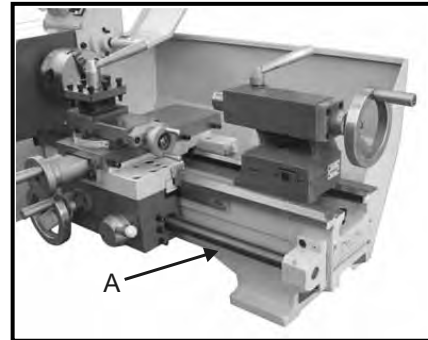


Fig. 7

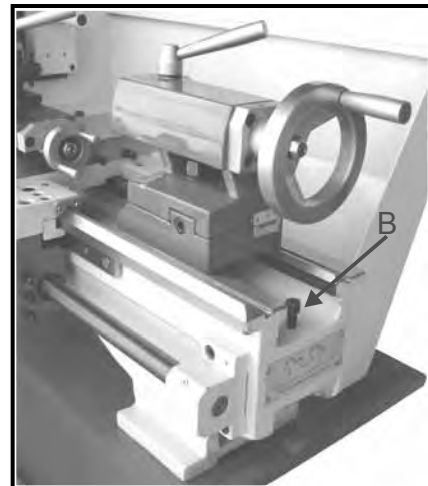


Fig. 8

CONTROLS

1. Emergency Button ON/OFF Switch (C, Fig. 9)

The machine is switched on and off with ON/OFF button. Depress to stop all machine functions. To restart, lift the cover and press ON button.

2. Change-over Switch (D, Fig. 9)

After the machine is switched on, turn the switch to “F” position for counter-clockwise spindle rotation (forward). Turn the switch to “R” position for clockwise spindle rotation (reverse). “0” position is OFF and the spindle remains idle.

3. Variable Speed Control Switch (E, Fig. 9)

Turn the switch clockwise to increase the spindle speed. Turn the switch counter-clockwise to decrease the spindle speed. The possible speed range is dependent from the position of the drive belt.



Fig. 9

4. Compound Rest Lock

Turn two hex nuts (A, Fig. 10) clockwise to lock and counter-clockwise to unlock.

5. Compound Slide Lock

Turn set screw (B, Fig. 11) clockwise, and tighten to lock. Turn counter-clockwise to loosen.

6. Cross Slide Lock

Turn hex socket cap screw (C, Fig. 11) clockwise and tighten to lock. Turn counter-clockwise and loosen to unlock.

7. Carriage Lock

Turn hex socket cap screw (D, Fig. 12) clockwise and tighten to lock. Turn counter-clockwise and loosen to unlock.

Caution: carriage lock screw must be unlocked before engaging automatic feeds or damage to lathe may occur.

9. Longitudinal Traverse Handwheel (E, Fig. 13)

Rotate hand wheel clockwise to move the apron assembly toward the tailstock (right). Rotate the hand wheel counter-clockwise to move the apron assembly toward the headstock (left).

10. Cross Traverse Lever (F, Fig. 13)

Clockwise rotation moves the cross slide toward the rear of the machine.

11. Half Nut Engage Lever (G, Fig. 13)

Move the lever down to engage. Move the lever up to disengage.

12. Compound Rest Traverse Lever (H, Fig. 13)

Rotate clockwise or counter-clockwise to move or position.

13. Tool Post Clamping Lever (I, Fig. 13)

Rotate counter-clockwise to loosen and clockwise to tighten. Rotate the tool post when the lever is unlocked.

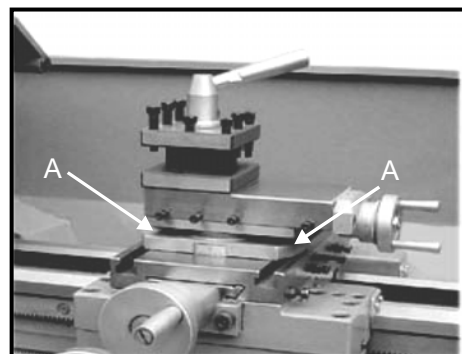


Fig. 10

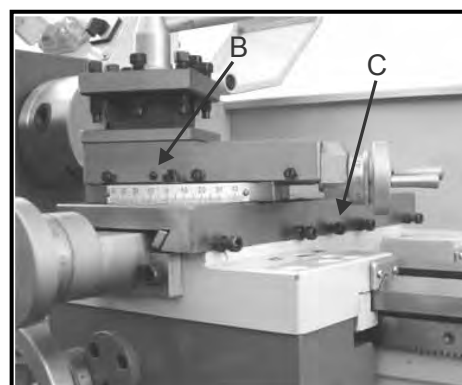


Fig. 11

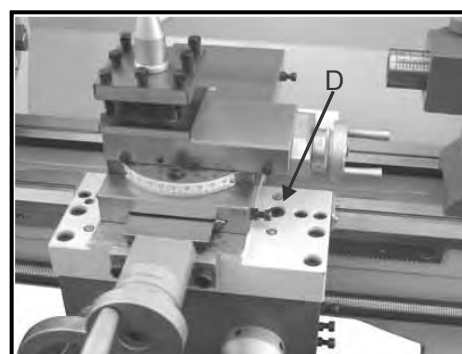


Fig. 12

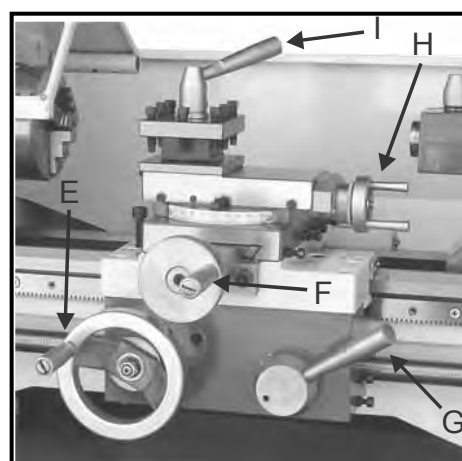


Fig. 13

14. Tailstock Clamping Screw (A, Fig. 14)

Turn hex nut clockwise to lock and counter-clockwise to unlock.

15. Tailstock Quill Clamping Lever (B, Fig. 14)

Rotate the lever clockwise to lock the spindle and counter-clockwise to unlock.

16. Tailstock Quill Traverse Handwheel (C, Fig. 14)

Rotate clockwise to advance the quill. Rotate counter-clockwise to retract the quill

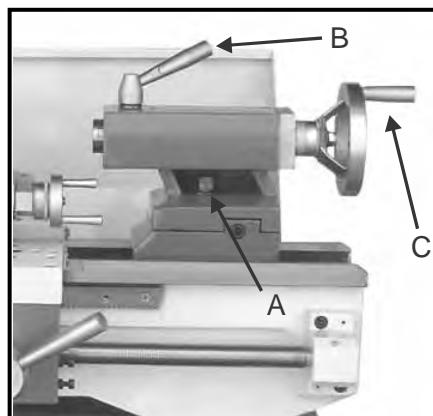


Fig. 14

17. Tailstock Off-set Adjustment

Three sets screws (D, Fig. 15) located on the tailstock base are used to off-set the tailstock for cutting tapers. Loosen lock screw on tailstock end. Loosen one side set screw while tightening the other until the amount of off-set is indicated on scale. Tighten lock screw.



Fig. 15

OPERATION

Replacement of Chuck

The head spindle holding fixture is cylindrical. Loose three set screws and nuts (A, Fig.16) on the lathe chuck flange to remove the chuck. Position the new chuck and fix it using the same set screws and nuts.

Tool Set-Up

Clamp the turning tool into the toolholder.

The tool must be clamped firmly. When turning, the tool has a tendency to bend under the cutting force generated during the chip formation. For best results, tool overhang should be kept to a minimum of 3/8" or less.

The cutting angle is correct when the cutting edge is in line with the center axis of the work piece. The correct height of the tool can be achieved by comparing the tool point with the point of the center mounted in the tailstock. If necessary, use steel spacer shims under the tool to get the required height. (Fig. 17)

Change Speed

1. Unscrew the two fastening screws (B, Fig.18) and remove the protective cover.
2. Adjust the V-belt into the corresponding position.
3. Outside position is low speed, inside position is high speed.

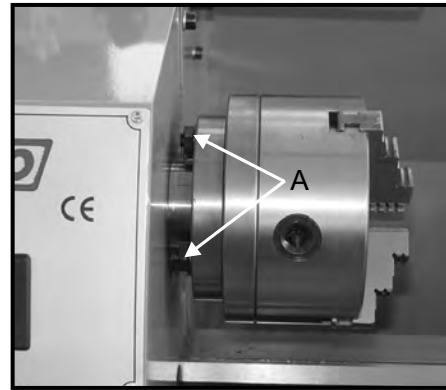


Fig. 16



Fig. 17



Fig. 18

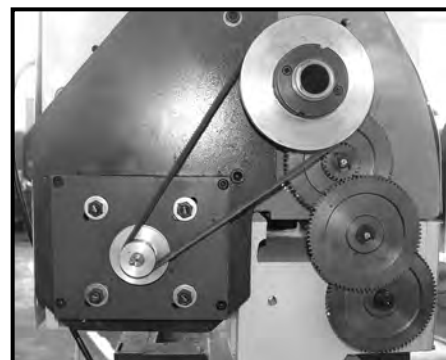


Fig. 19

Manual Turning

Apron travel, cross travel, and top slide handwheel can be operated for longitudinal or cross feeding. (Fig.20)

Longitudinal Turning with Auto-Feed

Use the table (A, Fig.21) on the lathe for selecting the feed speed or the thread pitch. Adjust the change gear if the required feed or thread pitch cannot be obtained with the installed gear set.

Change Gears Replacement

1. Disconnect the machine from the power source.
2. Unscrew the two fastening screws and remove the protective cover.
3. Loosen the locking screw (B, Fig.22) on the quadrant.
4. Swing the quadrant (C, Fig.22) to the right.
5. Unscrew the hex socket cap screw (D, Fig.22) from the leadscrew or the nuts (E, Fig.22) from the quadrant bolts in order to remove the change gears from the front.
6. Install the gear couples according to the thread and feed table (Fig.23) and screw the gearwheels onto the quadrant again.
7. Swing the quadrant to the left until the gearwheels have engaged again.
8. Readjust gear backlash by inserting a normal sheet of paper as an adjusting or distance aid between the gearwheels.
9. Immobilize the quadrant with the locking screw.
10. Install the protective cover of the headstock and reconnect the machine to the power supply.

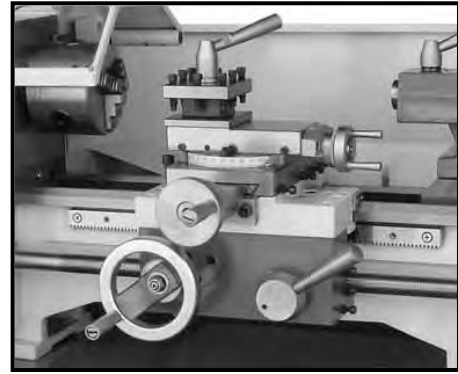


Fig. 20

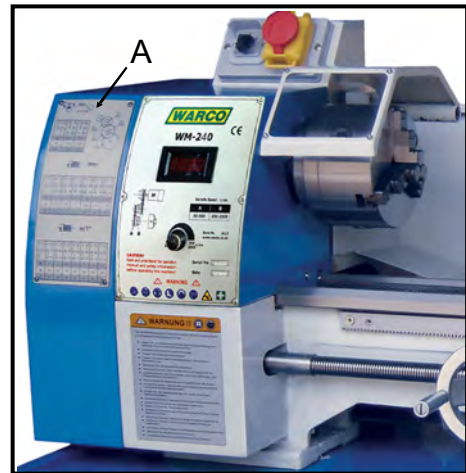


Fig. 21

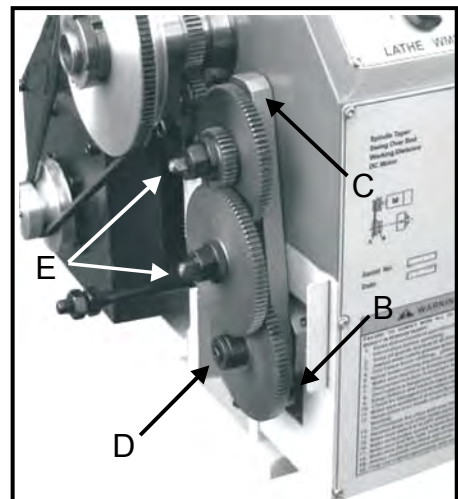
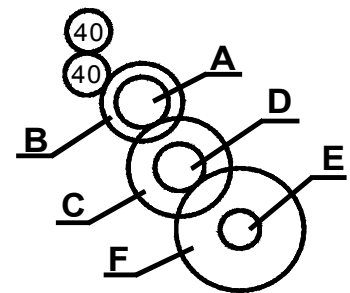


Fig. 22

THREAD AND FEEDING TABLE FOR LATHE

METRIC

					
mm					
		0.1		0.2	
A	B	33	80	30	70
C	D	90	25	90	42
E	F	H	90	H	80
mm					
		0.4	0.5	0.6	0.7
A	B	H 70	H 75	H 75	H 75
C	D	30 75	30 60	42 80	42 60
E	F	80 H	80 H	70 H	80 H
		1.25	1.5	1.75	2
A	B	H 52	H 70	H 75	H 70
C	D	75 80	60 40	70 80	80 75
E	F	60 H	80 H	40 H	H 40
n / 1"					
		10	11	14	19
A	B	H 70	H 80	H 70	H 70
C	D	80 42	60 40	60 33	60 40
E	F	60 H	52 H	80 H	90 H
		20	22	40	44
A	B	H 70	H 70	H 75	H 75
C	D	60 42	60 80	33 52	30 52
E	F	90 H	52 H	80 H	80 H

INCH

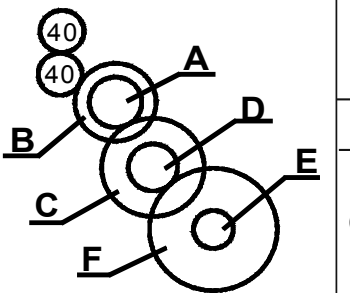
					
in					
		0.004		0.008	
A	B	30	80	42	75
C	D	90	25	90	40
E	F	H	90	H	90
n / 1"					
n		8	9	10	11
A	B	H 90	H 90	H 90	90 40
C	D	75 40	80 40	60 40	75 60
E	F	50 H	60 H	50 H	H 66
n		12	13	14	16
A	B	H 70	H 80	H 80	H 75
C	D	30 80	60 40	60 40	60 40
E	F	H 40	65 H	70 H	80 H
n		18	20	24	28
A	B	H 80	H 80	H 75	H 65
C	D	60 40	42 40	30 60	60 80
E	F	90 H	70 H	H 80	70 H
n		32	40	48	56
A	B	H 90	H 75	H 75	H 75
C	D	30 40	42 80	30 60	30 70
E	F	80 H	70 H	80 H	80 H

Fig. 23

Straight Turning (Fig. 24)

In the straight turning operation, the tool feeds parallel to the axis of rotation of the workpiece. The feed can be either manual by turning the handwheel on the lathe saddle or the top slide, or by activating the automatic feed. The crossfeed for the depth of cut is achieved using the cross slide.

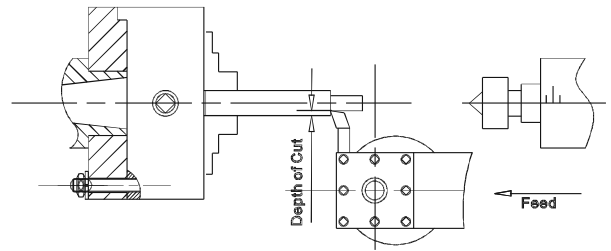


Fig. 24

Facing and Recesses (Fig. 25)

In the facing operation, the tool feeds perpendicular to the axis of rotation of the workpiece. The feed is made manually with the cross slide handwheel. The crossfeed for cut depth is made with the top slide or lathe saddle.

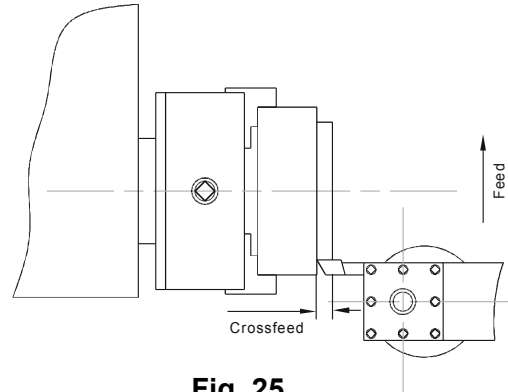


Fig. 25

Turning Between Centers (Fig. 26)

For turning between centers, it is necessary to remove the chuck from the spindle. Fit the M.T.3 center into the spindle nose and the M.T. 2 center into the tailstock. Mount the workpiece fitted with the driver dog between the centers. The driver is driven by a catch or face plate.

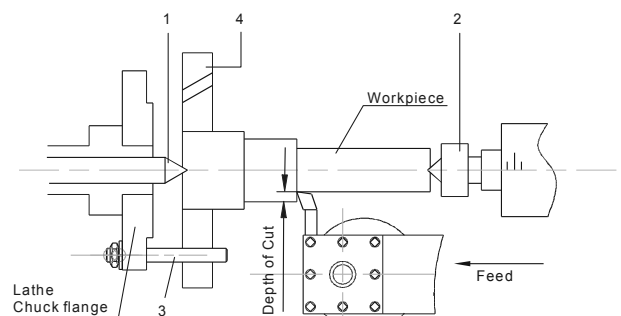
Note: Always use a small amount of grease on the tailstock center to prevent center tip form overheating.

Taper Turning Using Tailstock Off-Set

Work to a side angle of 5 can be turned by off-setting the tailstock. The angle depends on the length of the workpiece.

To off-set the tailstock, loosen locking screw (A, Fig.27) Unscrew the set screw (B, Fig.27) on right end of the tailstock. Loosen the front adjusting screw (C, Fig.24) and take up the same amount by tightening the rear adjusting screw (D, Fig.27) until the desired taper has been reached. The desired cross-adjustment can be read off the scale. (E, Fig.27). First retighten the set screw (B, Fig.27) and then the two (front and rear) adjusting screw to lock the tailstock in position. Retighten the locking screw (A, Fig.27) of the tailstock. The workpiece must be held between to centers and driven by a face plate and driver dog.

After taper turning, the tailstock should be returned to its original position according to the zero position on the scale of tailstock. (E, Fig.27)



- 1.Fixed Centre 60°
- 2.Living Centre 60°
- 3.Dog Drive Pin
- 4.Dog Plate

Fig. 6

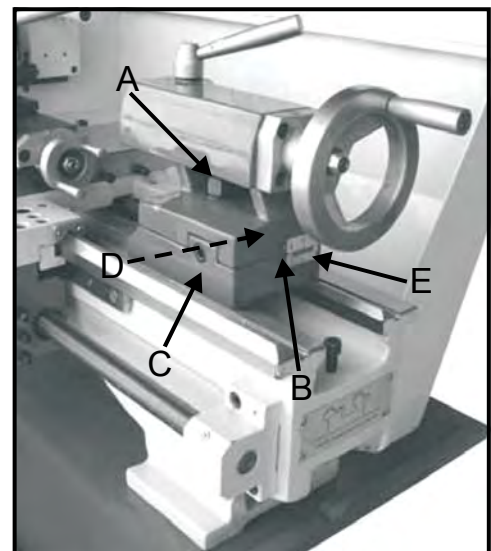


Fig. 27

Thread Cutting

Set the machine up to the desired thread pitch (according to the threading chart, Fig.23). Start the machine and engage the half nut. When the tool reaches the part, it will cut the initial threading pass. When the tool reaches the end of the cut, stop the machine by turning the motor off and at the same time back the tool out of the part so that it clears the thread. Do not disengage the half nut lever. Reverse the motor direction to allow the cutting tool to traverse back to the starting point. Repeat these steps until you have obtained the desired results.

NOTES

Example: Male Thread

- The workpiece diameter must have been turned to the diameter of the desired thread.
- The workpiece requires a chamfer at the beginning of the thread and an undercut at the thread runout.
- The speed must be as low as possible.
- The change gears must have been installed according to the required pitch.
- The thread cutting tool must be exactly the same shape as the thread, must be absolutely rectangular and clamped so that it coincides exactly with the turning center.
- The thread is produced in various cutting steps so that the cutting tool has to be turned out of the thread completely (with the cross slide) at the end of each cutting step.
- The tool is withdrawn with the leadscrew nut engaged by inverting the change-over switch.
- Stop the machine and feed the thread cutting tool in low cut depths using the cross slide.
- Before each passage, place the top slide approximately 0.2 to 0.3mm to the left and right alternately in order to cut the thread free. This way, the thread cutting tool cuts only on one thread flank with each passage. Keep cutting the thread free until you have almost reached the full depth of thread.

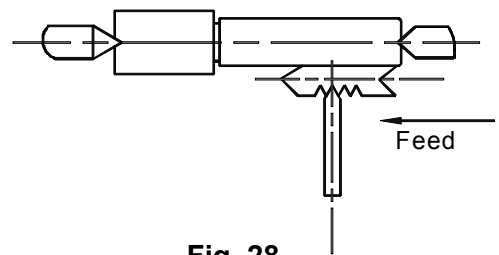


Fig. 28

Lathe Accessories

Three Jaw Universal Lathe Chuck

Using this universal chuck, round, triangular, square, hexagonal octagonal, and twelve-cornered stock may be clamped. (Fig.29)

Note: new lathes have very tight fitting jaws. This is necessary to ensure accurate clamping and long service life. With repeated opening and closing, the jaw adjust automatically and their operation becomes progressively smoother.

Note:

For the original 3-jaw chuck that mounted on the lathe, the factory has mounted the chuck in the best way to guarantee the holding accuracy with two “0” mark (A, Fig.29) showed on the chuck and chuck flange.

There are two types of jaws: Internal and external jaws. Please note that the number of jaws fit with the number inside the chuck's groove. Do not mix them together. When you are going to mount them, please mount them in ascending order 1-2-3, when you are going to take them out, be sure to take them out in descending order 3-2-1, one by one. After you finished this procedure, rotate the jaws to the smallest diameter and check that the three jaws are well fitted.

Four Jaw Independent Lathe Chuck

This special chuck has four independently adjustable chuck jaws. These permit the holding of asymmetrical pieces and enable the accurate set-up of cylindrical pieces. (Fig.30)

Drill Chuck (Optional)

Use the drill chuck to hold centering drills and twist drills in the tailstock. (B, Fig.31)

Morse Taper Arbor (Optional)

An arbor is necessary for mounting the drill chuck in the tailstock. It has a No. 2 Morse taper. (C, Fig.31)

Live Center (Optional)

The live center is mounted in ball bearings. Its use is highly recommended for turning at speeds in excess of 600 RPM. (Fig.32)

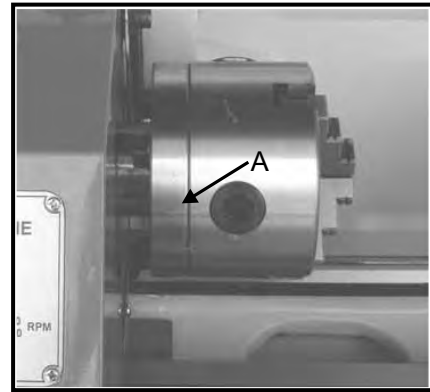


Fig. 29

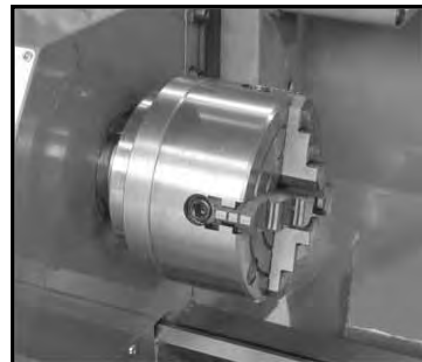


Fig. 30

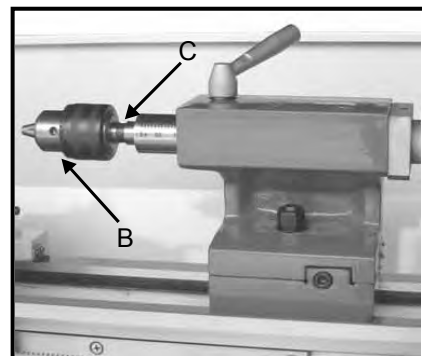


Fig. 31

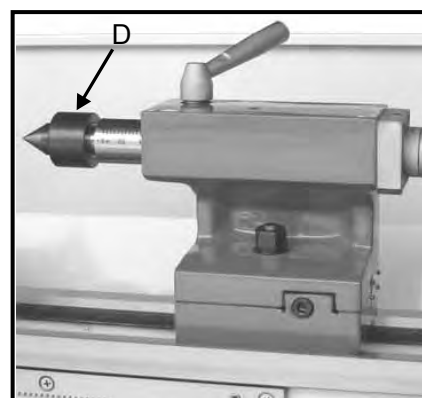


Fig. 32

Steady Rest

The steady rest serves as a support for shafts on the free tailstock end. For many operations the tailstock can not be used as it obstructs the turning tool or drilling tool, and therefore, must be removed from the machine. The steady rest, which function as an end support, ensures chatter-free operation. The steady rest is mounted on the bedways and is secured from below with a locking plate. The sliding fingers require continuous lubrication at the contact points to prevent premature wear. (Fig.33)

Setting the Steady Rest

1. Loosen three hex nuts. (A, Fig.33)
2. Loosen knurled screw (B, Fig.33) and open the sliding fingers. (C, Fig.33) until the steady rest can be moved with its finger around the workpiece. Secure the steady rest in position.
3. Tighten knurled screws so that fingers are snug but not tight against the workpiece. Tighten three nuts (A, Fig.33). Lubricate the sliding points with machine oil.
4. When, after prolonged operation, the jaw show wear, the tips of the fingers may be filed or remilled.

Follow Rest

The follow rest is mounted on the saddle and follow the movement of the turning tool. Only two sliding fingers are required. The place of the third finger is taken by the turning tool. The follow rest is used for turning operations on long, slender workpieces. It prevents flexing of the workpiece under pressure from the turning tool. (Fig.34)

Set the fingers snug to the workpiece but not overly tight. Lubricate the fingers during operation to prevent premature wear.

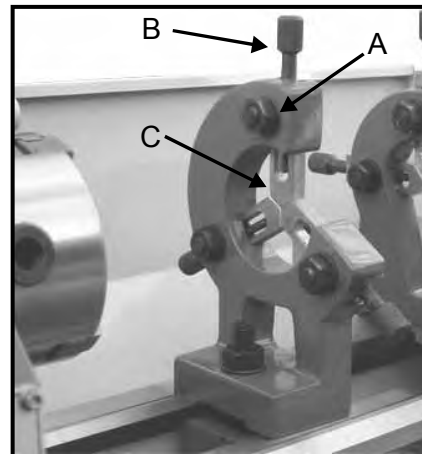


Fig. 33



Fig. 34

ADJUSTMENT

After a period time, wear in some of the moving components may need to be adjust

Main Spindle Bearings

The main spindle bearings are adjusted at the factory. If end play becomes evident after considerable use, the bearings may be adjusted.

Fasten the slotted nut (A, Fig.35) on the back of the spindle, loosen the outer slotted nut (B, Fig.35). Adjust the slotted nut (A, Fig.35) until all end play is taken up. The spindle should still revolve freely. Fasten the slotted nut (A, Fig.35) again and tighten the outer slotted nut (B, Fig.35).

Caution: excessive tightening or preloading will damage the bearings.

Adjustment of Cross Slide

The cross slide is fitted with a gib strip(C, Fig.36) and can be adjusted with screws (D, Fig.36) fitted with lock nuts. (E, Fig.36) Loosen the lock nuts and tighten the set screws until slide moves freely without play. Tighten lock nuts to retain adjustment.

Adjustment of Top Slide

The top slide is fitted with a gib strip(F, Fig.37) and can be adjusted with screws (G, Fig. 37) fitted with lock nuts. (H, Fig. 37) Loosen the lock nuts and tighten the set screws until slide moves freely without play. Tighten lock nuts to retain adjustment.

Adjustment of Half Nut Guide

The half nuts engagement can be adjusted with screws (I, Fig.38) fitted with lock nuts (J, Fig.38). Loosen the nuts on the right side of the apron and adjust the control screws until both half nuts move freely without play. Tighten the nut.

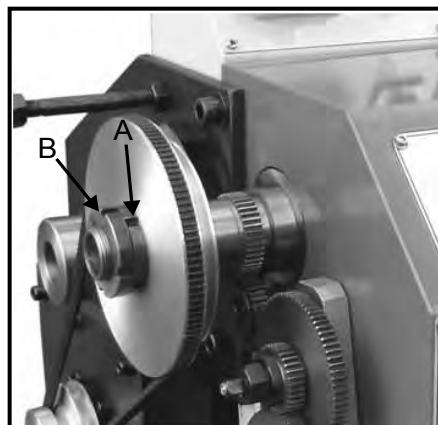


Fig. 35

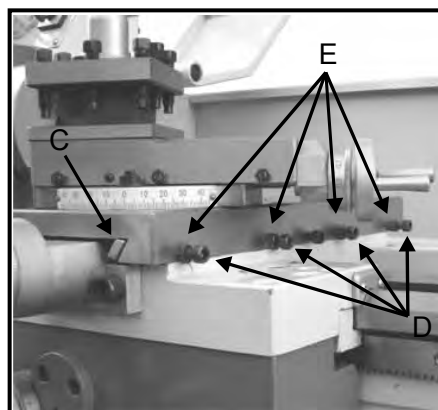


Fig. 36

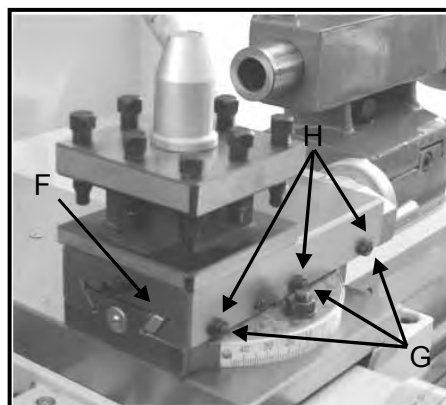


Fig. 37

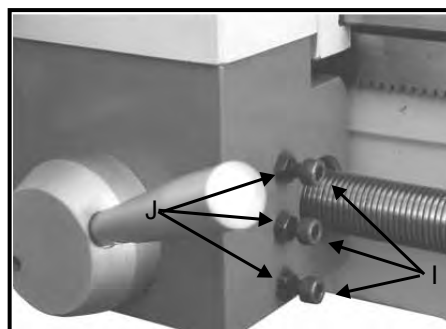


Fig. 38

LUBRICATION



CAUTION

**Lathe must be serviced at all lubrication points and all reservoirs filled to operating level before the lathe is placed into service!
Failure to comply may cause serious damage!**

NOTES:

Lubricate all slideways lightly before every use. Lubricate the change gears and the leadscrew slightly with a lithium-based grease.

1. Change Gear

Lubricate two oil ports (A, Fig. 39) on the gear shafts with 20W machine oil once daily.

2. Carriage

Lubricate Four oil ports (B, Fig. 40) with 20W machine oil once daily.

3. Cross Slide

Lubricate three oil ports (C, Fig. 40) with 20W machine oil once daily.

4. Compound Slide

Lubricate two oil ports (D, Fig. 40) with 20W machine oil once daily.

5. Leadscrew

Lubricate the left oil port (E Fig. 41) and right oil port (F, Fig. 42) with 20W machine oil once daily..

6. Tailstock

Lubricate two oil ports (G, Fig. 42) with 20W machine oil once daily.

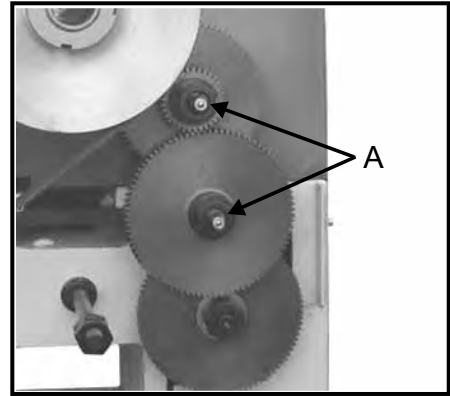


Fig. 39

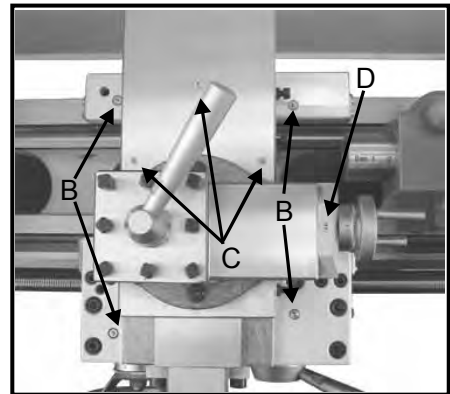


Fig. 40

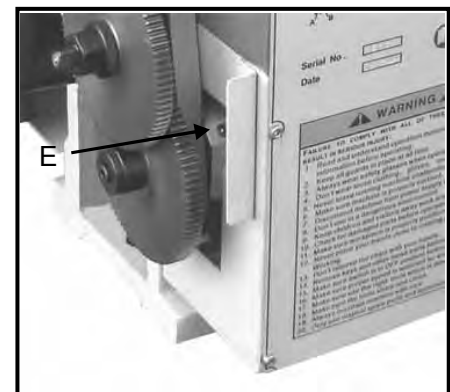


Fig. 41

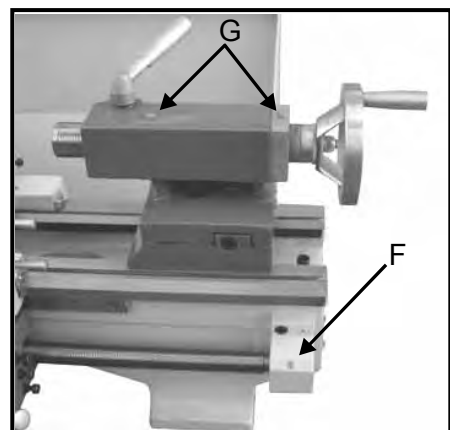


Fig. 42

ELECTRICAL CONNECTIONS

⚠ WARNING!

Connection of the lathe and all other electrical work may only be carried out by an authorized electrician!

Failure to comply may cause serious injury and damage to the machinery and property!

The WARCO WM240 Lathe is rated at 1.1KW, 1PH, 240V only. Confirm power available at the lathe's location is the same rating as the lathe. Using the wiring diagram (Fig.43) for connecting the lathe to the mains supply, The fuse is 8A.

Make sure the lathe is properly grounded.

The following is wiring diagram of the lathe: (Fig.43)

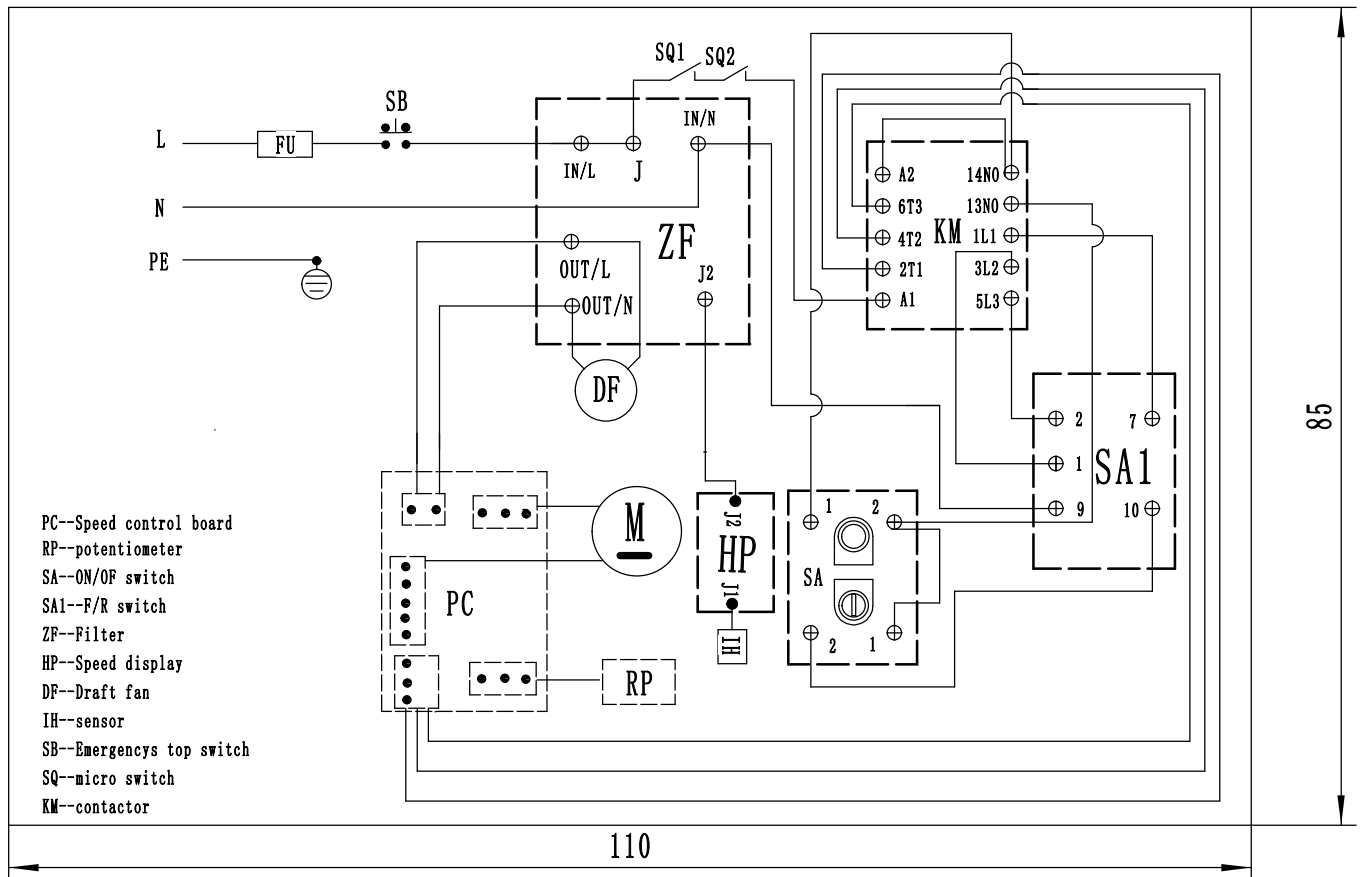


Fig. 43

MAINTENANCE

Keep the maintenance of the machine tool during the operation to guarantee the accuracy and service life of the machine tool.

1. In order to retain the machine's precision and functionality, it is essential to treat it with care, keep it clean and grease and lubricate it regularly. Only through good care, you can be sure that the working quality of the machine will remain constant.

NOTES:

Disconnect the machine plug from the mains supply whenever you carry out cleaning, maintenance or repair work!

Oil, grease and cleaning agents are pollutants and must not be disposed of through the drains or in normal refuse. Dispose of those agents in accordance with current legal requirements on the environment. Cleaning rags impregnated with oil, grease and cleaning agents are easily inflammable. Collect cleaning rags or cleaning wool in a suitable closed vessel and dispose of them in an environmentally sound way – do not put them with normal refuse!

2. Lubrication all slideways lightly before every use. The change gears and the leadscrew must also be lightly lubricated with lithium base grease.
3. During the operation, the chips which falls onto the sliding surface should be cleaned timely, and the inspection should be often made to prevent chips falling into the position between the machine tool saddle and lathe bed guide way. Asphalt felt should be cleaned at certain time.

NOTES:

Do not remove the chips with your bare hands. There is a risk of cuts due to sharp-edged chips. Never use flammable solvents or cleaning agents or agents that generate noxious fumes! Protect electrical components such as motors, switches, switch boxes, etc., against humidity when cleaning.

4. After the operation every day, eliminate all the chips and clean different part of the machine tool and apply machine tool oil to prevent rusting.
5. In order to maintain the machining accuracy, take care of the center, the surface of the machine tool for the chuck and the guide way and avoid mechanical damage and the wear due to improper guide.
6. If the damage is found, the maintenance should be done immediately.

NOTES:

Repair work may only be carried out by qualified personnel with the corresponding mechanical and electrical knowledge.

TROUBLESHOOTING

Problem	Possible Reason	Elimination
Surface of workpiece too rough	Tool blunt Tool springs Feed too high Radius at the tool tip too small	Resharpen tool Clamp tool with less overhang Reduce feed Increase radius
Workpiece becomes coned	Centers are not aligned (tailstock has offset) Top slide not aligned well (cutting with the top slide)	Adjust tailstock to the center Align top slide well
Lathe is chattering	Feed too high Slack in main bearing	Reduce feed Adjust the main bearing
Center runs hot	Workpiece has expanded	Loosen tailstock center
Tool has a short edge life	Cutting speed too high Crossfeed too high Insufficient cooling	Reduce cutting speed Lower crossfeed(finishing allowance should not exceed 0.5mm) More coolant
Flank wear too high	Clearance angle too small Tool tip not adjusted to center high	Increase clearance angle Correct height adjustment of the tool
Cutting edge breaks off	Wedge angle too small (heat build-up) Grinding crack due to wrong cooling Excessive slack in the spindle bearing Arrangement (vibrations)	Increase wedge angle Cool uniformly Adjust the slack in the spindle bearing arrangement
Cut thread is wrong	Tool is clamped incorrectly or has been started grinding the wrong way Wrong pitch Wrong diameter	Adjust too to the center Grind angle correctly Adjust the right pitch Turn the workpiece to the correct diameter
Spindle does not activate	Emergency stop switch activated	Unlock emergency stop switch



WM240

PARTS LIST for

Warren Machine Tools Ltd

Warco House, Fisher Lane, Chiddingfold, Surrey GU84TD

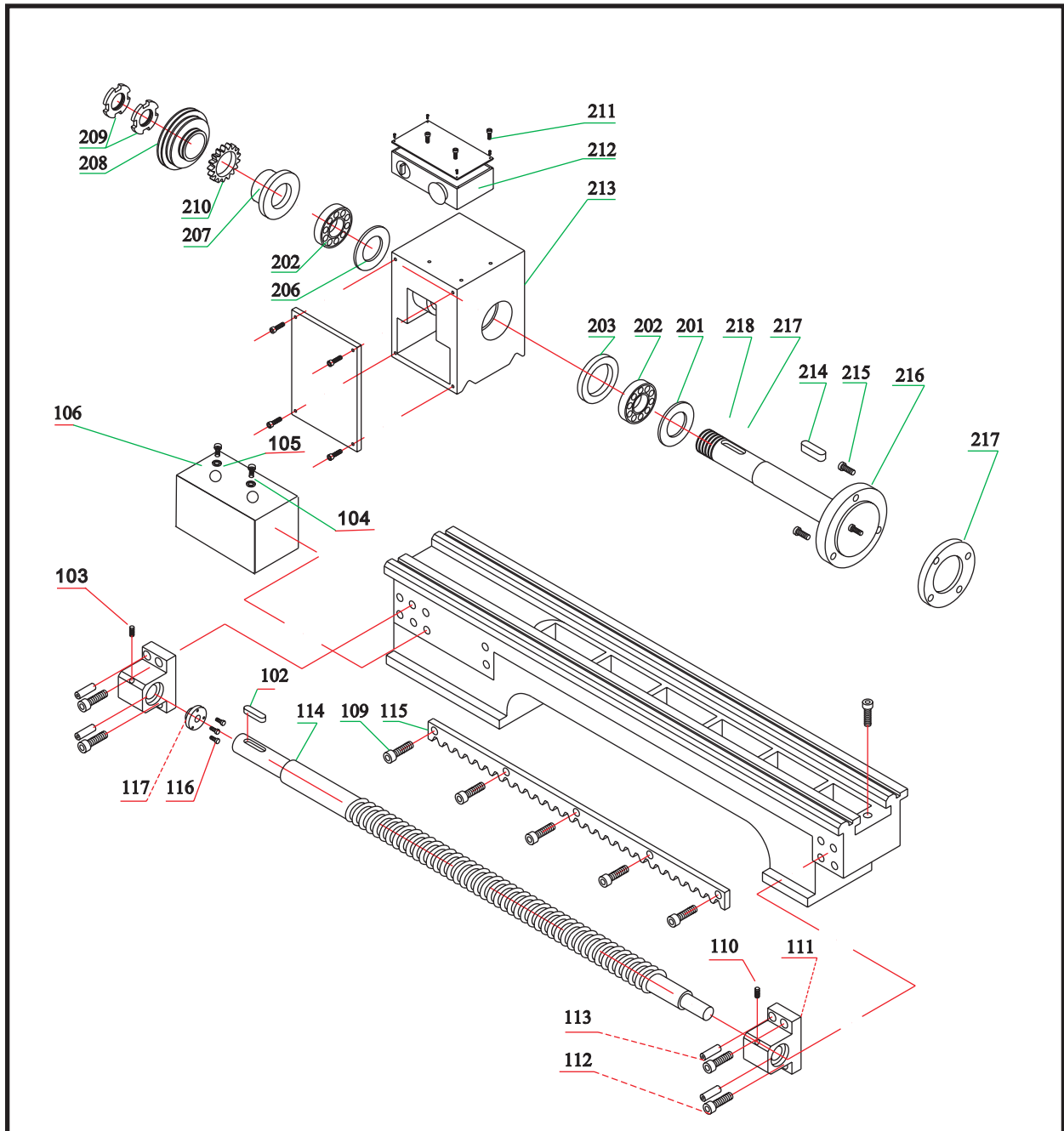
Tel: 01428 682929

Fax: 01428 685870

E-mail: warco@warco.co.uk

Web: www.warco.co.uk

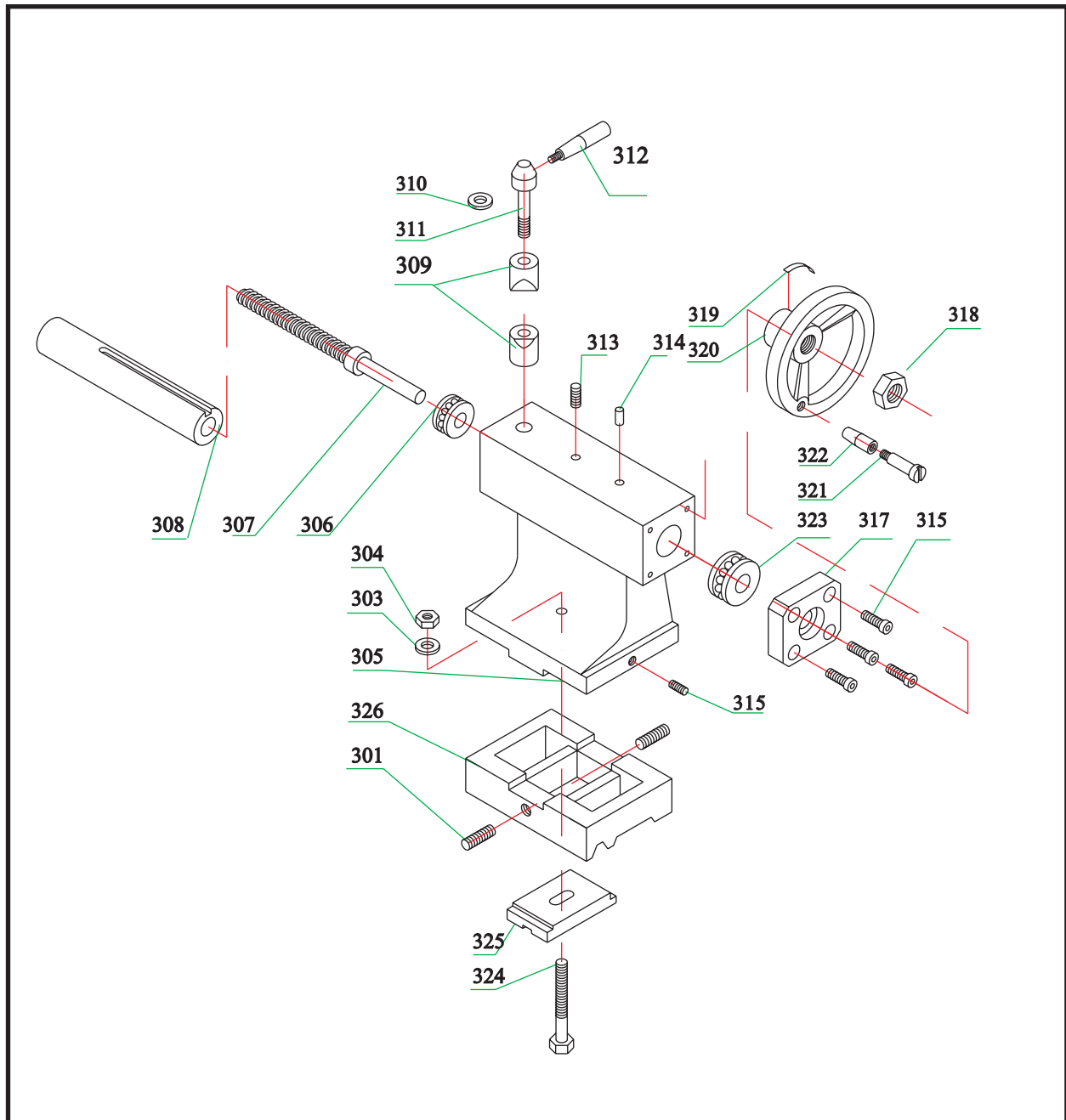
WM240 LATHE - Headstock, Bed Assembly



Parts No.	Description	Specification	Qty
101	Bearing Housing		1
102	Key		1
103	Oil Cup		1
104	Screw	M8x16	2
105	Washer	M8	2
106	Cover		1
107	Lathe Bed		1
108	Screw	M8x12	1
109	Screw	M5x12	5
110	Oil Cup		2
111	Bearing Housing		1
112	Screw	M6x16	4
113	Pin	6x22	4
114	Leadscrew		1
115	Rack		1
116	Screw	M4x16	3
117	Adjusting Flange		1

Parts No.	Description	Specification	Qty
201	Sealing Ring		1
202	Bearing	8x0.8	2
203	Sealing Ring		1
204	Screw	M3x6	4
205	Label		1
206	Sealing Ring		1
207	Spacer Ring		1
208	Pulley		1
209	Nut	M27x1.5	2
210	Gear		2
211	Screw	M3x6	4
212	Electric Box		1
213	Headstock		1
214	Key	4X40	2
215	Screw	M6x16	2
216	Spindle		2
217	Backplate		1

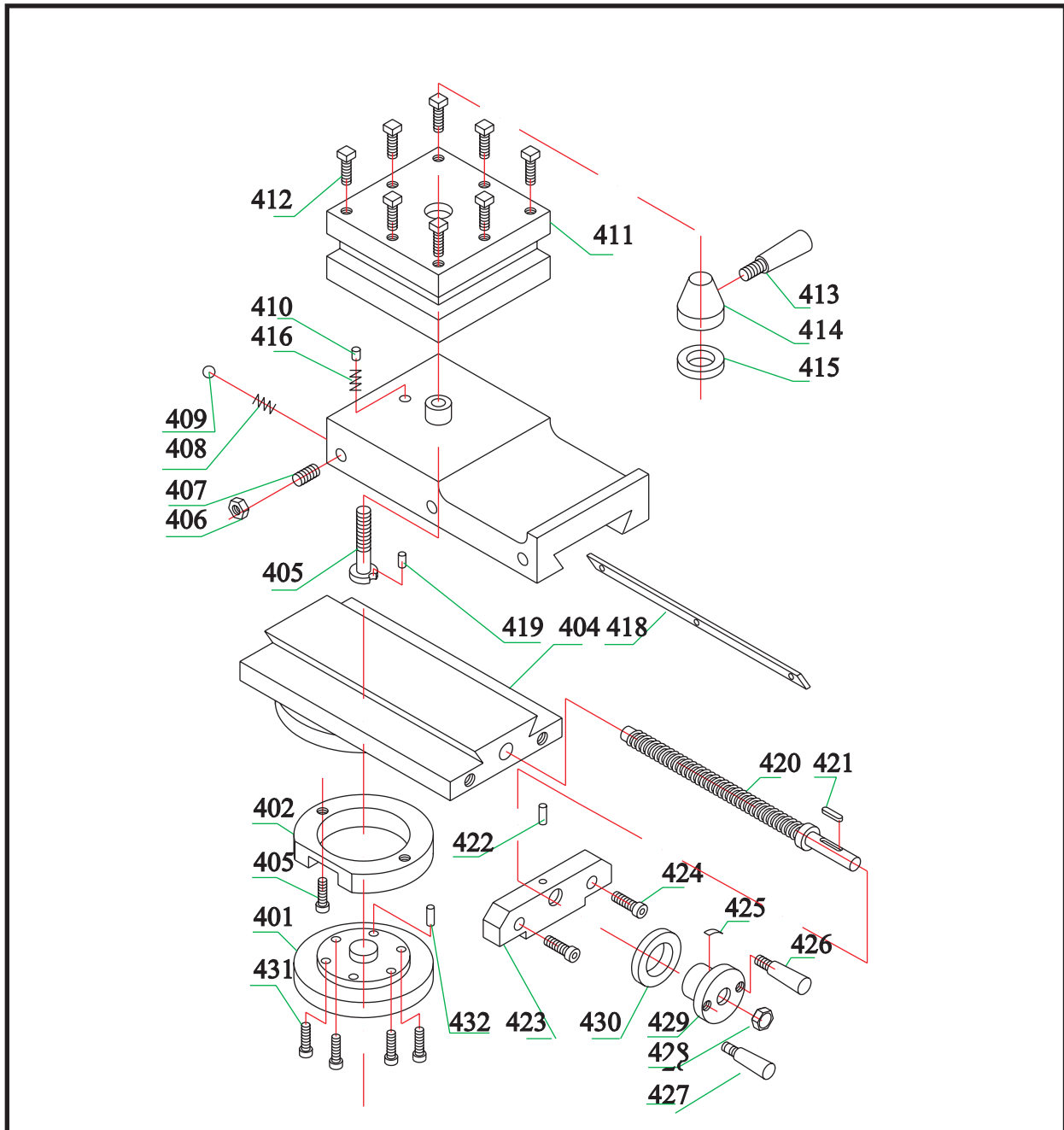
WM240 LATHE - Tailstock Assembly



Parts No.	Description	Specification	Qty
301	Pin	M8x30	2
302	Nut		1
303	Washer	M12	1
304	Nut	M12	1
305	Tailstock		1
306	Bearing	12x26x9	1
307	Leadscrew		1
308	Quill		1
309	Locking Bush		1
310	Washer		1
311	Locking Base		1
312	Handle		1
313	Oil Cup		2

Parts No.	Description	Specification	Qty
314	Pin		1
315	Screw	M6x16	1
316	Screw	M5x16	1
317	Support		1
318	Nut	4x30	1
319	Spring Piece		1
320	Handlewheel		1
321	Screw		1
322	Sleeve		1
323	Dial Scale		1
324	Bolt	M12x100	1
325	Clamping Plate		1
326	Base		1

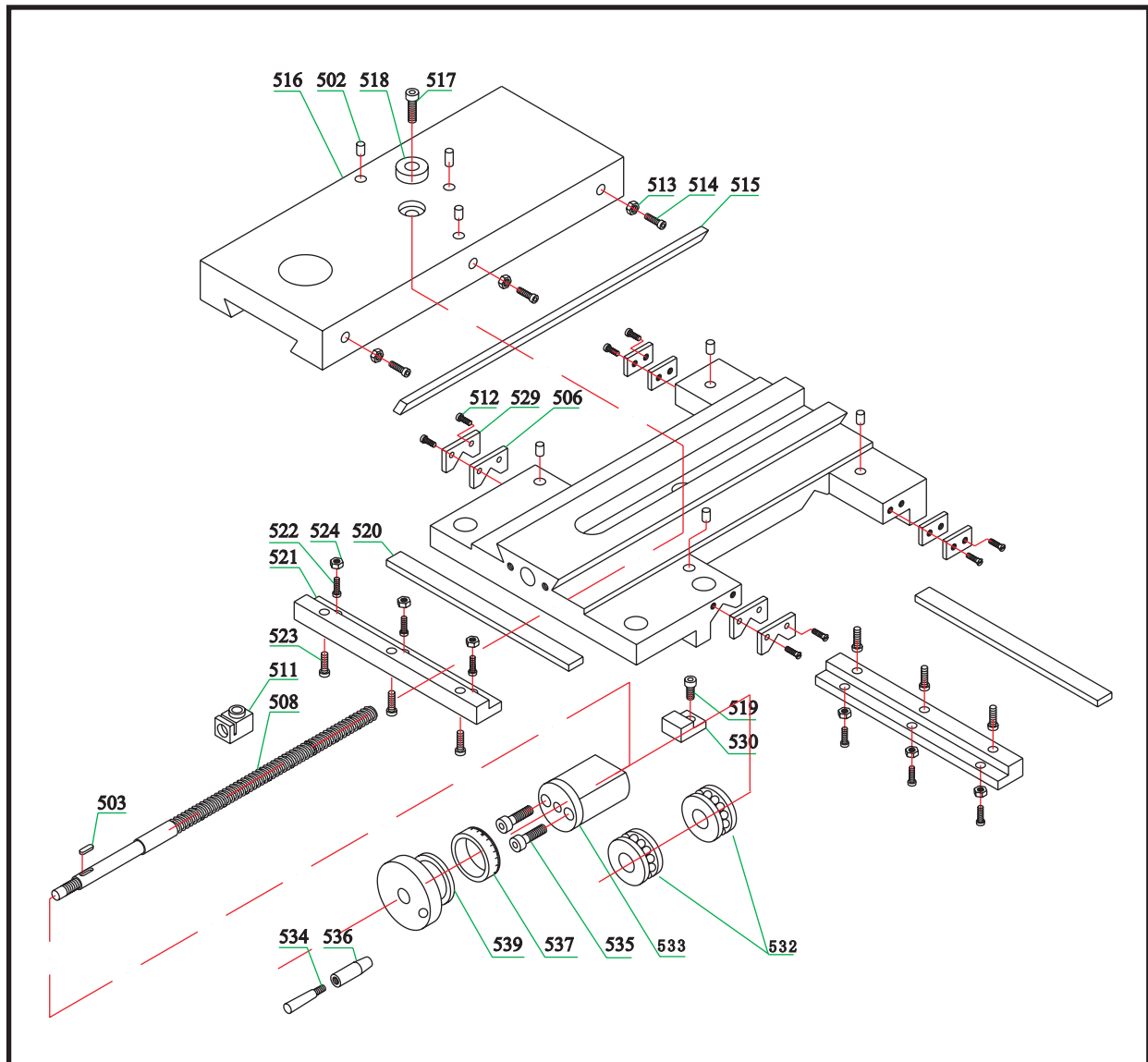
WM240 LATHE - Top Slide Assembly



Parts No.	Description	Specification	Qty
401	Graduated Dial		1
402	Clamping Ring		1
403	Screw	M8x20	2
404	Base		1
405	Bolt		1
406	Nut		3
407	Screw	M4x40	3
408	Screw	M4x12	1
409	Nut	M4	9
410	Pin		3
411	Tool Post		1
412	Screw	M8x25	8
413	Handle		1
414	Base		1
415	Washer		1
416	Spring		1

Parts No.	Description	Specification	Qty
417	Top Slide		1
418	Gib		1
419	Pin	3x10	1
420	Leadscrew		1
421	Pin	3x10	1
422	Oil Cup		2
423	Support		1
424	Screw	M5x16	2
425	Spring Piece		1
426	Handle		2
427	Handle		2
428	Nut	M8	1
429	Handlewheel		1
430	Dial Scale		1
431	Screw	M6x16	4
432	Pin	4x16	2

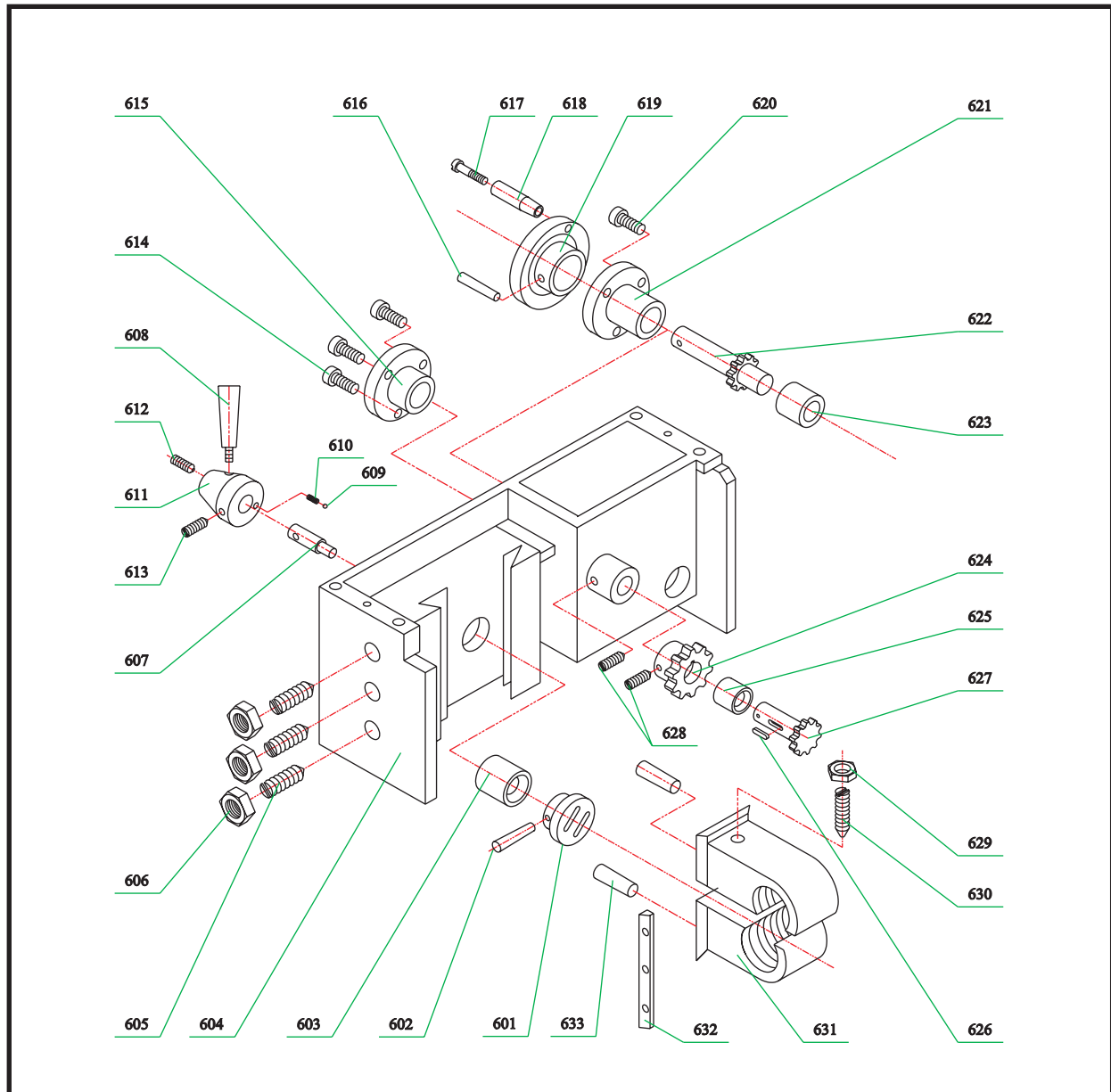
WM240 LATHE - Cross Slide, Carriage Assembly



Parts No.	Description	Specification	Qty
501	Handwheel		1
502	Oil Cup		10
503	Key	4x12	1
504	Nut		1
505	Screw	M3x6	1
506	Wiper		2
507	Screw	M6x35	4
508	Leadscrew		1
509	Carriage		1
510	Screw	M3x12	2
511	Nut		1
512	Screw	M3x12	8
513	Nut	M5	4
514	Screw	M5x25	4
515	Gib		1
516	Cross Slide		1
517	Oil Cup		1
518	Bush		1
519	Screw	M8x35	2
520	Gib		1

Parts No.	Description	Specification	Qty
521	Clamping Plate		1
522	Screw	M4x16	5
523	Screw	M5x16	4
524	Nut	M4	5
525	Screw	M8x20	1
526	Screw		4
527	Wiper		2
528	Metal Piece		2
529	Metal Piece		2
530	Clamping Plate		1
531	Locking Plate		1
532	Bearing	12x26x9	2
533	Support		1
534	Handel		1
535	Screw	M6X20	2
536	Sleeve		1
537	Dial Scale		1
538	Spring Piece		1
539	Handlewheel		1

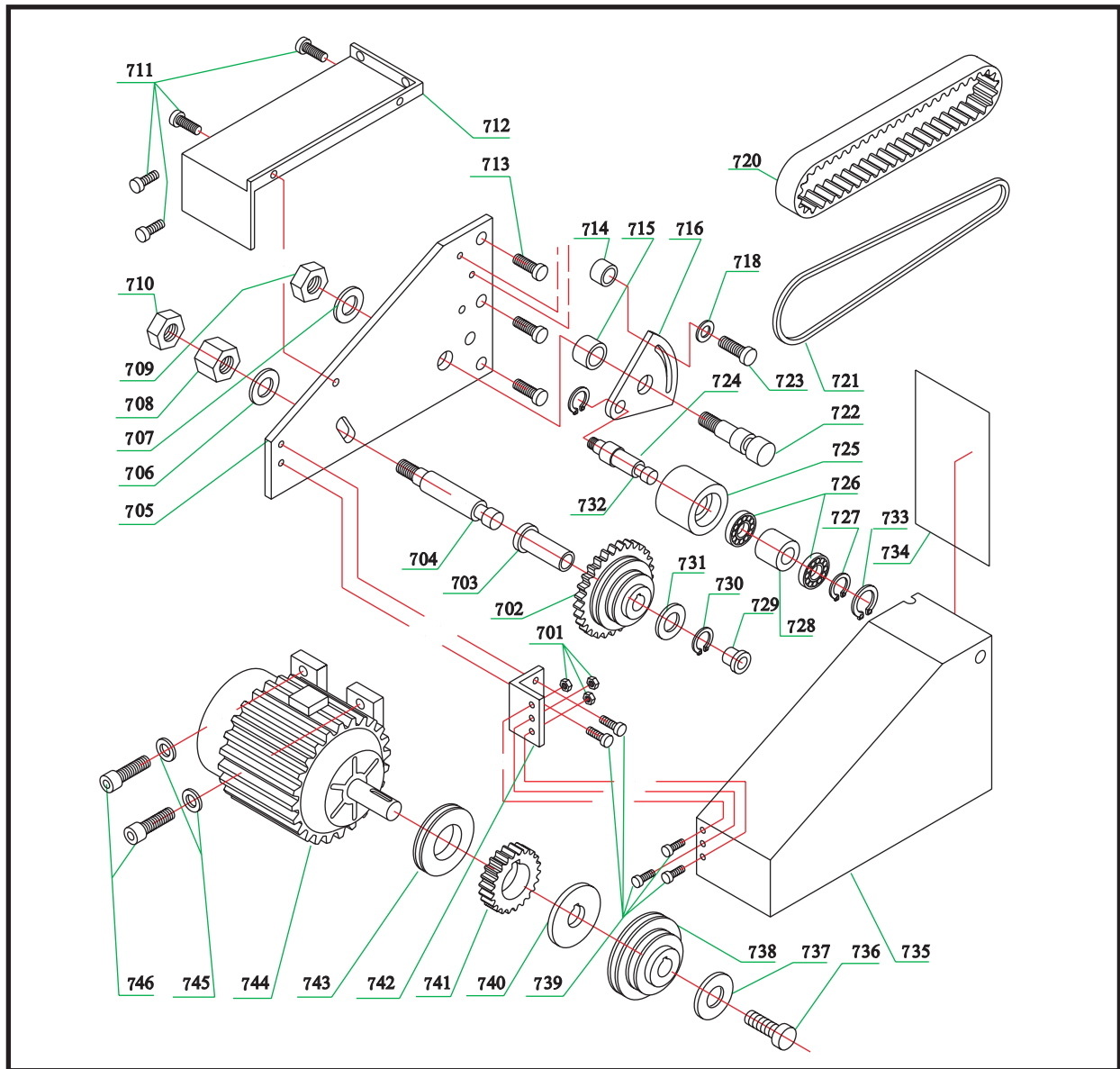
WM240 LATHE - Apron Assembly



Parts No	Description	Specification	Qty
601	Base		1
602	Pin	3x20	1
603	Bush		1
604	Housing		1
605	Screw	M5x30	3
606	Nut	M5	3
607	Shaft		1
608	Handle		2
609	Ball		1
610	Spring	0.8x5x25	1
611	Base		1
612	Screw	M6x10	1
613	Screw	M4X8	3
614	Screw	M4X8	3
615	Flange		1
616	Pin	3x30	1
617	Screw		1

Parts No.	Description	Specification	Qty
618	Sleeve		1
619	Handlewheel		1
620	Screw	M4x8	3
621	Flange		1
622	Gear Shaft		1
623	Bush		1
624	Gear		1
625	Buah		1
626	Key	5x10	1
627	Pinion Shaft		1
628	Screw	M4X8	2
629	Nut	M5	1
630	Screw	M5x25	1
631	Half Nut		1
632	Gib		1
633	Pin	5x20	2

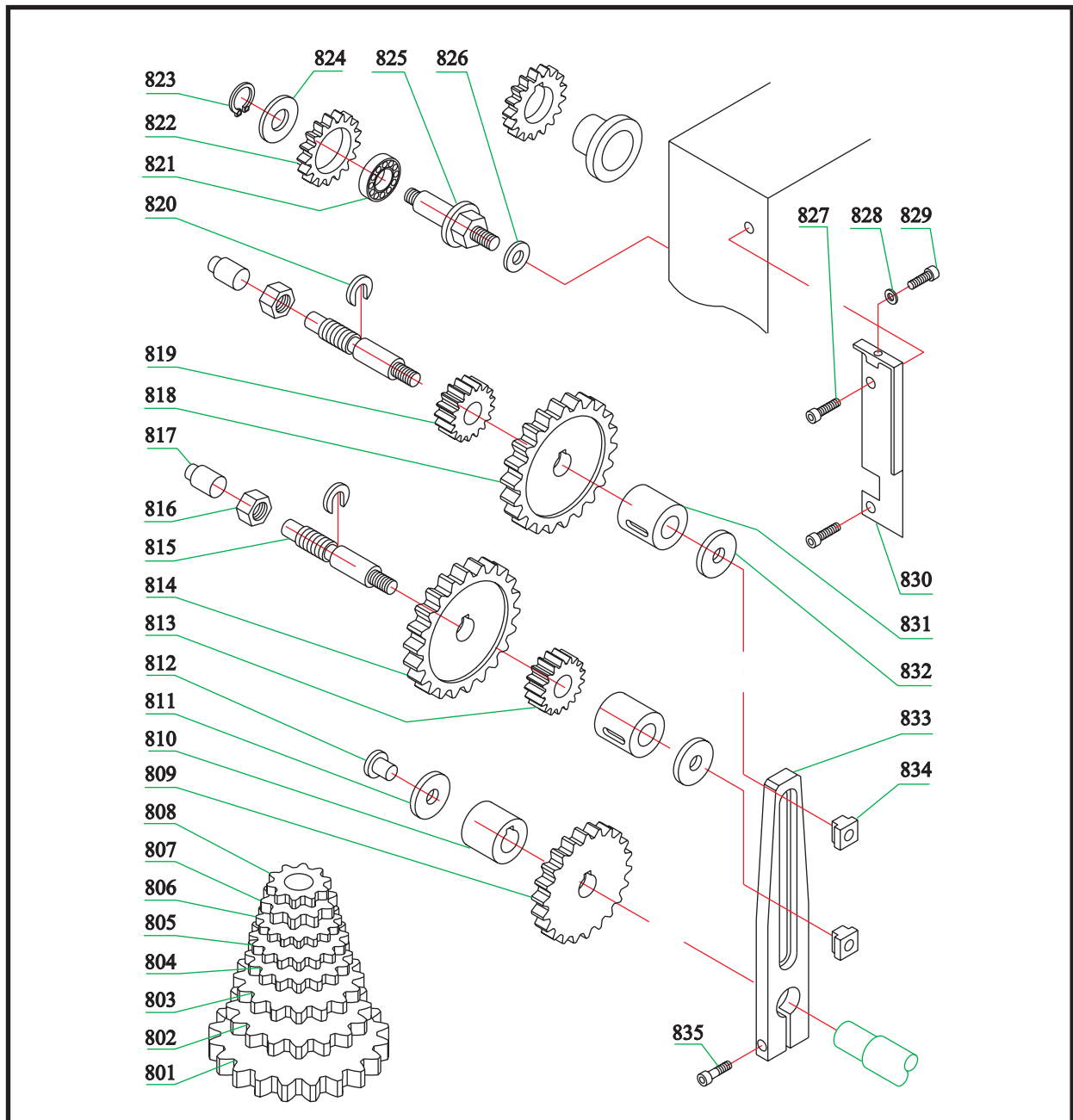
WM240 LATHE - Pulley, Motor Assembly



Parts No.	Description	Specification	Qty
701	Nut	M5	3
702	Teeth Pulley		1
703	Bearing		1
704	Shaft		1
705	Carriage Plate		1
706	Washer	12	1
707	Washer	10	1
708	Nut	M12	1
709	Nut	N10	1
710	Nut	M12	1
711	Screw	M5x8	4
712	Motor Cover		1
713	Screw	M10x20	3
714	Washer		1
715	Washer		1
716	Holding Fixture		1
718	Washer	8	1
720	Screw	M5X12	1
721	V-Belt	A730	1
722	Shaft		1
723	Screw	M8x25	1
724	Bolt		1

Parts No.	Description	Specification	Qty
725	Tension Pulley		1
726	Bearing		2
727	Spring Ring	12	1
728	Bush		1
729	Oil Cup		1
730	Spring Ring	12	1
731	Washer		1
732	Spring Ring	12	1
733	Spring Ring	28	1
734	Label		1
735	Cover		1
736	Screw	M5x35	1
737	Spring Ring		1
738	Pulley		1
739	Screw		5
740	Spring Ring		1
741	Teeth Pulley		1
742	Hingle		1
743	Spring Ring		1
744	Motor		1
745	Washer	8	4
746	Screw	M8x25	4

WM240 LATHE - Change Gears Assembly



Parts No.	Description	Specification	Qty
801	Change Gear	90T	2
802	Change Gear	80T	2
803	Change Gear	70T	1
804	Change Gear	52T	1
805	Change Gear	50T	1
806	Change Gear	42T	1
807	Change Gear	40T	1
808	Change Gear	33T	1
809	Change Gear	60T	1
810	Bush		1
811	Washer		1
812	Screw	M5x8	1
813	Change Gear	25T	1
814	Change Gear	75T	1
815	Bolt		2
816	Nut	M12	2
817	Oil Cup		2
818	Change Gear	80T	1

Parts No.	Description	Specification	Qty
819	Change Gear	33T	1
820	Washer		2
821	Bearing	12x28x2	1
822	Gear	40T	1
823	Spring Ring	12	1
824	Washer		1
825	Bolt		1
826	Washer	10	1
827	Screw	M5x8	1
828	Washer	6	1
829	Screw	M6x10	1
830	Cover		1
831	Bearing		2
832	Washer		3
833	Frame		1
834	T-Nut		2
835	Screw	M6x35	1
836	Change Gear	66T	1
837	Change Gear	33T	1



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