



METAL LATHE – STANDARD OPERATING PROCEDURE

DO NOT use this machine without completing appropriate induction / training.



Approved safety glasses must be worn at all times with this equipment.



Hearing protection must be worn at all times when using this equipment.



Appropriate protective footwear with substantial uppers must be worn in work areas.



Close fitting protective clothing or a suitable workshop apron is advisable.



Gloves must not be worn when using this equipment.



Contain or restrain long and loose hair, and remove exposed rings or jewellery.

PRE-OPERATIONAL SAFETY CHECKS

1. Locate and ensure you are familiar with all machine operations including the E- Stop.
2. Ensure all moving parts are functional and clear from obstruction or interference.
3. Check the workspace and surrounding area is clean and ensure there are no slip/trip hazards present.
4. Only one person may operate this machine at any one time.
5. Ensure all safety guards and switches are operational and in place.

POTENTIAL HAZARDS

- Rotating parts – Entanglement
- Ejected material and particles
- Eye injuries
- Hot metal – Burns
- Noise
- Sharp edges and burs

OPERATIONAL SAFETY PROCEDURES

1. Move the carriage saddle and tailstock along the bed to allow room and clearance to the lathe chuck.
2. Lift chuck safety guard and place round stock securely in the 3 jaw chuck, tightening with the chuck key.
3. Turn lathe chuck and workpiece slowly by hand to ensure clearance and correct fitment in the chuck.

4. Place chuck key in the safety switch hole located on top of the lathe headstock and close the chuck safety guard.
Note: machine will not start without the above step.
5. Select correct spindle speed using motor speed switch and the speed gear select handles. Refer to speed/feed chart on wall for your material.
6. Securely mount required cutting tool into the tool post and center the height using tailstock live center as a reference.
7. If machining long stock support live end with tailstock and live center after drilling end center hole.
8. Start machine by selecting 'ON button' and selecting the 'control rod' **down**. This will turn the chuck in the fwd cutting direction.
9. Keep all body parts well clear (at least 150mm) of the rotating chuck and the tool post.
10. Use cutting fluid as required to prevent workpiece from heating.
11. Using the carriage/saddle handwheel, cross-slide and compound handwheels to make cuts of the workpiece.
12. **Take caution to not drive tool post into the chuck!**
13. To stop the chuck: lift control rod to mid position. Use foot break afterwards if you want to slow it down faster.
14. Ensure the lathe chuck has come to a complete stop before you:
 - make adjustments to settings or speed.
 - take measurements of the workpiece.
 - Clear away swarf and debris.

POST OPERATION

1. Switch off the power to the machine when work is completed.
2. Never leave chuck key in the chuck.
3. Clean up all debris using a brush and dispose of appropriately.
4. Put away all accessories and tooling.
5. Wipe down the lathe bed with a clean rag and a small amount of 'slide oil' from the blue oil tin.
6. Dispose of any waste material in the appropriate bins provided.

