CT041
12” x 37” BELT DRIVE LATHE
User Manual

! WARNING

1 **Read and understand the entire instruction manual before operating machine.**

2 **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.**

3 **This machine is designed and intended for use by trained and experienced personnel only. If you are not familiar with the proper safe use of lathe, do not use this machine until proper training and knowledge has been obtained.**

4 Always wear approved safety glassed /face shields while using this machine.

5 Make certain the machine is properly grounded.

6 Before operating the machine, remove tie, rings, ,watches, other jewelry, and roll up sleeves above the elbows. Remove all loose clothing and confine long hair. Do not wear gloves.

7 Keep the floor around the machine clean and free of scrap material, oil and grease.

8 Keep machine guards in place at all times when the machine is in use. If removed for maintenance purpose, use extreme caution and replace the guards immediately

9 Do not over reach. Maintain a balanced stance at all times so that you do not fall or lean against blades or other moving parts.

10 Make all machine adjustments or maintenance with the machine unplugged from the power source.

11 Replace warning labels if they become obscured or removed.

12 Use the right tool. Don't force a tool or attachment to do a job which it was no designed for.

13 Make certain the motor switch is in the OFF position before connecting the machine to the power supply.

14 Give your work undivided attention. Looking around, carrying on a conversation, and " horse-play" are careless acts that can result in serious injury.

15 Keep visitors a safe distance from the work area.

16 Use recommended accessories; improper accessories may be hazardous.

17 Make a habit of checking to see that keys and adjusting wrenches are removed before turning on the machine

18 Never attempt any operation or adjustment if the procedure is not understood.

19 Keep fingers away from revolving parts and cutting tools while in operation.

20 Never force the cutting action.

21 Do no t attempt to adjust or remove tools during operation.

22 Always keep cutters sharp.

23 Always use identical replacement parts when servicing.

24 Failure to comply with all of these warnings may cause serious injury.

SPECIFICATIONS:	**CT041 12"×37"**	
Capacities:		
Swing Over Bed	300 mm	12"
Swing Over Cross Slide	173 mm	6 3/4"
Swing Through Gap	480 mm	18 7/8"
Length of Gap	210 mm	8"
Distance Between Centers	940 mm	37"
Headstock:		
Hole Through Spindle	36mm	1 3/8"
Taper in Spindle Nose	M.T.5	
Spindle Taper Adapter	M.T.3	
Number of Spindle Speeds	12	
Range of Spindle Speeds	50-1200r.p.m.	
Gearbox:		
Number of Metric Threads	24	
Range of Metric Threads	0.25~7.5mm	
Number of Inch Threads	50	
Range of Inch Threads	4~112T.P.I.	
Lead Screw Pitch	8T.P.I.	
Lead Screw Diameter	22mm	7/8"
Feed Rod Diameter	19mm	3/4"
Compound and Carriage:		
Toolpost Type	4-Way	
Maximum Tool Size	16x16mm	5/8"x5/8"
Maximum Compound Slide Travel	89mm	3 1/2"
Maximum Cross Slide Travel	50mm	6"
Maximum Carriage Travel	850mm	33 1/2"
Tailstock:		
Tailstock Spindle Travel	92mm	3 5/8"
Diameter of Tailstock spindle	32mm	1 1/4"
Taper in Tailstock Spindle	M.T.3	
Miscellaneous:		
Length of Bed	1473mm	58"
Width of Bed	182mm	7 1/8"
Main Motor	1.5HP, 1Ph, 220V	
Dimension:		
Length	1630mm	64"
Width	686mm	27"
Height	1245mm	49"
Weight (approx.)	410kgs	902lbs.

TABLE OF CONTENTS

WARNING

Read and understand the entire contents of this Manual before attempting set-up or operation!

Failure to comply may cause serious injure!

CONTENTS OF SHIPPING CONTAINER

1 Lathe
1 Steady Rest (mounted on lathe)
1 Follow Rest (mounted on lathe)
1 6" Three Jaw Chuck (mounted on lathe)
1 8" Four Jaw Chuck
1 10" Face Plate
1 Full Length Splash Guard
1 Chip Tray
2 Cabinet Stand
1 Tool Box

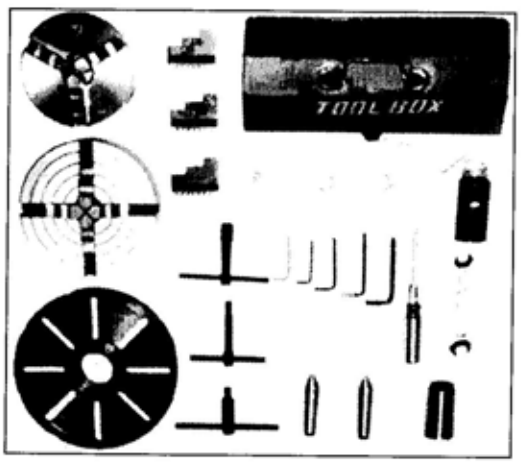


Fig. 1

Tool Box Contents (refer to Fig. 1):

1 No. 1 Flat Blade Screwdriver
1 Open End Wrench (17-19mm)
1 Hex Socket Wrench (3,4,5,6,8mm)
1 Oil Gun
2 No.3 Morse Taper Dead Center
1 No.5 to No.3 Spindle Sleeve
3 Change Gears (30T, 32T, 46T)
3 Outside Jaws for Three Jaw Chuck
1 Chuck Key
1 Key for Cam Locks
1 Tool Post Wrench

Uncrating and Clean-up

1. Finish removing the wooden crate from around the lathe.

2. Unbolt the lathe from the shipping crate bottom.

3. Choose a location for the lathe that is dray, has good lighting and has enough room to be able to service the lathe on all four sides.

4. 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.

5. 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.

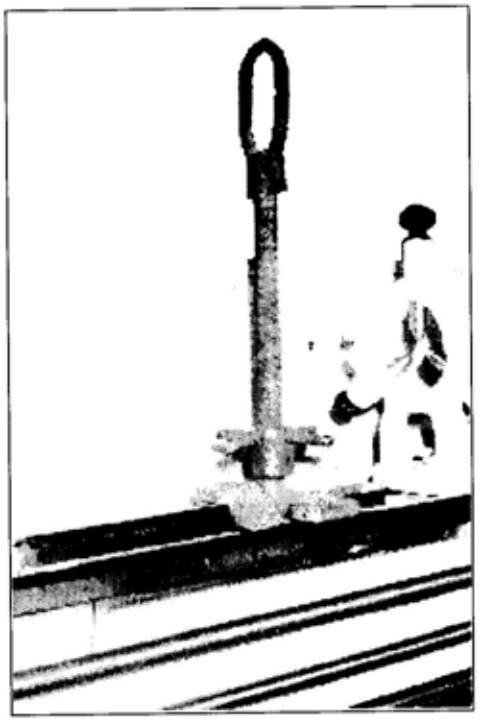


Fig. 2

6. 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.

7. Remove the end gear cover. Clean all components of the end gear assembly and coatall gears with a heavy, non-slinging grease.

8. Using a engineer's precision level on the bedways, check to make sure lathe is level side to side and front to back. Loosen mounting bolts, shim and tighten mounting bolts if necessary. The lathe must be level to be accurate.

Foundation Drawing

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!

1. **Headstock** – Oil must be up to indicator mark in both oil sight glasses (A, Fig. 3). Top off with Shell Turbo T-68 or equivalent. Drain oil completely by removing oil windows and refill (B, Fig. 4) after the first three months of operation. Then, change oil in the headstock annually. Grease three fittings (B, Fig. 3) with #2 tube grease daily. Oil the oil ports(C, Fig. 4) on pulley shaft with 20W machine oil once daily. Remove the set screw on the pulley shaft (D, Fig.4) and oil with a couple of drops of 20W machine oil once daily.

2. **Center Back Gear Shaft** – Remove the set screw on the shaft (E, Fig. 4) and oil with a couple of drops of 20W machine oil. Oil once weekly.

3. **Quick Change Gearbox** – Remove both oil cap beside the electric control panel (C, Fig. 3). Oil each hole with Shell Turbo T-68 or equivalent daily. Replace oil cap.

4. **Apron** – Remove oil cap(A , Fig.5) on right side of apron to fill the apron. Lubricate one oil port (B, Fig. 5) on the apron top and one oil port(C, Fig. 5) on the apron hand wheel once daily with 20W machine oil.

5. **Cross Slide** – Lubricate one oil port (D, Fig.5) with 20W machine oil once daily.

6. **Compound Rest** – Lubricate one oil port (E, Fig.5) with 20W machine oil once daily.

7. **Carriage** – Lubricate two oil ports (F, Fig. 6) with 20W machine oil once daily.

8. **Leadscrew & Feed Rod** – Lubricate two ball oilers on leadscrew feed rod bracket (located at the right end

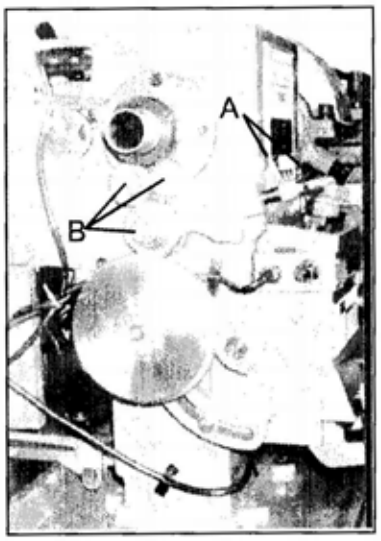


Fig. 3

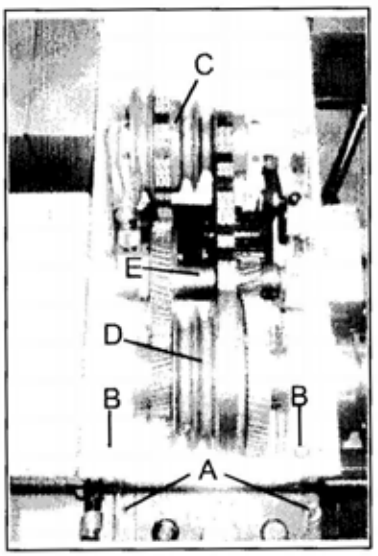


Fig. 4

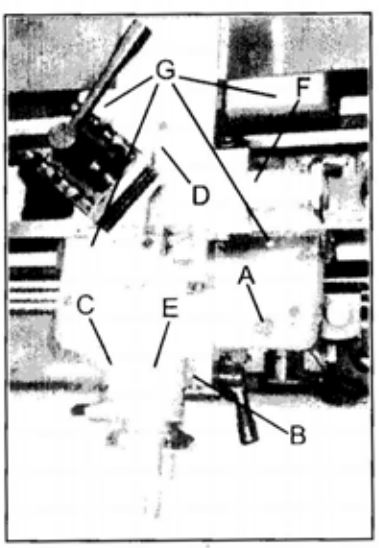


Fig. 5

of the lead screw and feed rod - A, Fig.6) with 20W machine oil once daily.

7. **Tailstock** – Lubricate three oil ports (B, Fig. 6) with 20W machine oil once daily.

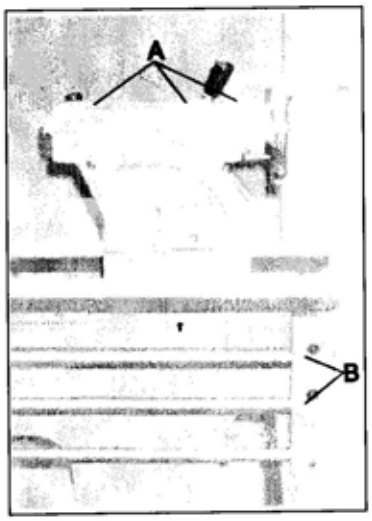


Fig. 6

Electrical Connections

WARNING
All electrical connections must be completed by a qualified electrician!
Failure to comply may cause serious injury and or damage to the machinery and property!

The CT041 belt drive lathe is rated at 2HP, 1PH, 220V only. Confirm power available at the lathe's location is the same rating as the lathe.

The following is wiring diagram of the lathe. (Fig. 7)

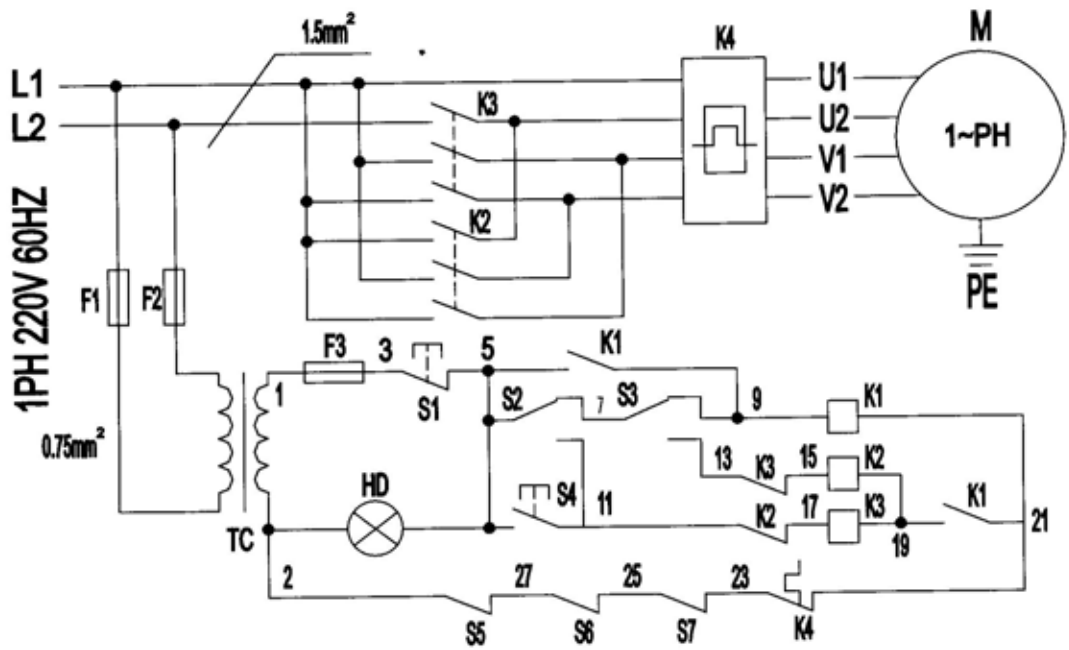


Fig. 7

General Description

Lathe Bed

The lathe bed (A, Fig. 8) is made of high grade cast iron. By combining high cheeks with strong cross ribs, a bed with low vibration and high rigidity is realized. Two precision ground vee slideways, reinforced by heat hardening and grinding are an accurate guide for the carriage and headstock. The main drive motor is mounted to the rear of the bed.

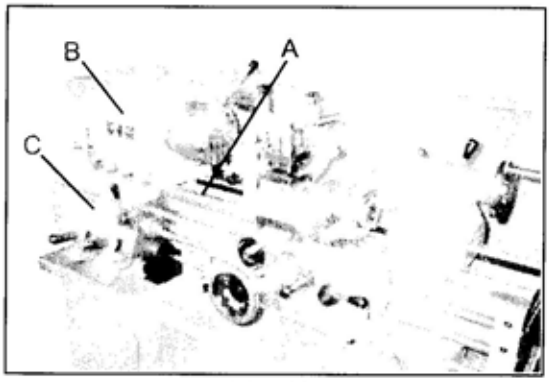


Fig. 8

Headstock

The headstock (B, Fig. 8) is cast from high grade, low vibration cast iron. It is bolted to the bed by four screws with two adjusting screws for alignment. In the head, the spindle is mounted on two precision taper roller bearings. The hollow spindle has Morse Taper#5 with a 1-3/8" bore.

Gear Box

The gear box (C, Fig. 8) is made from high quality cast Iron and is mounted to the left side of the machine bed. The motor will drive the gearbox through a range of Twelve speeds.

Carriage

The carriage (A, Fig. 9) is made from high quality cast iron. The Sliding parts are smooth ground. The cross-slide is mounted on the carriage and moves on a dove-tailed slide which can be adjusted for play by means of the gibs.

The top slide (compound – C, Fig. 9), which is mounted on the cross slide(B, Fig. 9), can be rotated through 360°. The top slide and the cross slide travel in a dovetail slide and have adjustable gibs. A four-way tool post is fitted on the top slide.

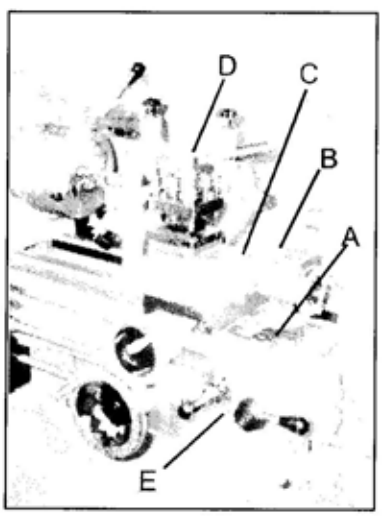


Fig. 9

Four Way Tool Post

The four-way tool (D, Fig. 9) post is mounted on the top slide and allows a maximum of four tools to be mounted simultaneously. Remember to use a minimum of two clamping screws when installing a cutting tool.

Apron

The apron (E, Fig. 9) is mounted to the carriage. In the apron a half nut is fitted. The half nut gibs can be adjusted from the outside. The half nut is engaged by use of a lever. Quick travel of the apron is accomplished by means of a bed-mounted rack and pinch, operated by a hand wheel on the front of the apron.

Tailstock

The tailstock (A, Fig. 10) slides on a v-way and can be locked at any location by a clamping lever. The tailstock has a heavy-duty spindle with a Morse Taper #3.

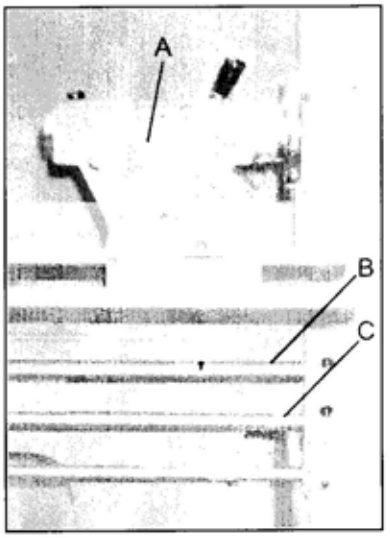


Fig. 10

Leadscrew and Feed Rod

The leadscrew (B, Fig. 10) and feed rod (C, Fig. 10) are mounted on the front of the machine bed. They are connected to the gearbox at the left for automatic feed and lead and are supported by bushings on both ends.

Steady Rest

The steady rest (A, Fig.11) serves as a support for shafts on the free tailstock end. The steady rest is mounted on the bedway and secured from below with a bolt, nut and locking plate. The sliding fingers require continuous lubrication at the contact points with the workpiece to prevent premature wear.

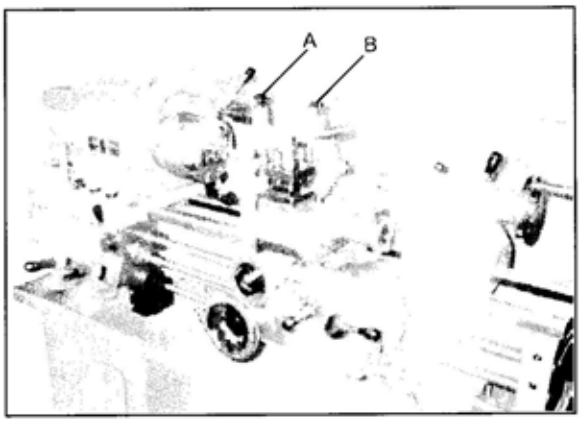


Fig. 11

To set the steady rest:

1. Loosen three hex socket cap screws.
2. Loosen knurled screw and open sliding fingers until the steady rest can be moved with its fingers around the workpiece. Secure the steady rest in position.
3. Set the fingers snugly to the workpiece and secure by tightening three hex socket cap screws. Fingers should be snug but not overly tight. Lubricate sliding points with lead based grease.
4. After prolonged use, the fingers will show wear. Remill or file the tips of the fingers.

Follow Rest

The traveling follow rest (B, Fig. 11) is mounted on the saddle and follows the movement of the turning tool. Only two fingers are required as the turning tool takes the place of the third. The follow rest is used for tuning operations on long, slender workpieces. It prevents flexing of the workpiece from the pressure of the cutting tool.

The sliding fingers are set similar to the steady rest, free of play, but not binding. Always lubricate adequately with lead based grease during operation.

Controls

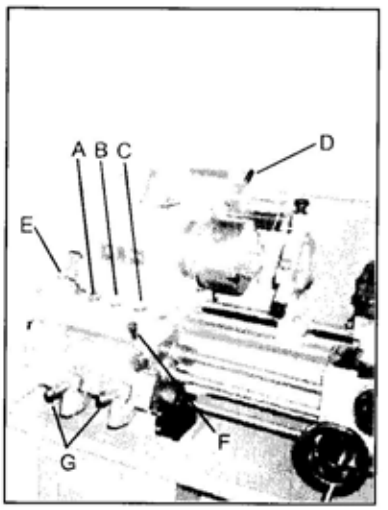


Fig. 12

1. **Control Panel** – located on top of gearbox.

A. **Power Indicator Light** (A, Fig.12) – lit whenever lathe has power. Turns off when emergency stop button is depressed.

B. **Emergency Stop Switch** (B, Fig.12) – depress to stop all machine functions. (Caution: lathe will still have power). Twist to re-set.

C. **Jog Switch** (C, Fig.12) – depress and release to advance spindle momentarily.

2. **Belt Tensioning Handle** (D, Fig.12) – located on the headstock behind the chuck. Pull forward to release tension on the drive belt. Push toward the rear to tension the rates.

3. **Feed Direction Selector** (E, Fig.12) – located on the front lower left corner of the headstock. Arrows beside the handle indicate saddle travel direction when the chuck is rotating in the forward direction or counter-clockwise as viewed from the front of the chuck.

4. **Feed Rod / Leadscrew Selector** (F, Fig.12) – located on front of lathe above feed rate selectors. Move lever to left to activate feed rod. Mover lever to the right to activate leadscrew

5. **Feed Rate Selectors** (G, Fig.12) – two levers located at the bottom of the headstock. Use to set desired feed or lead rates.

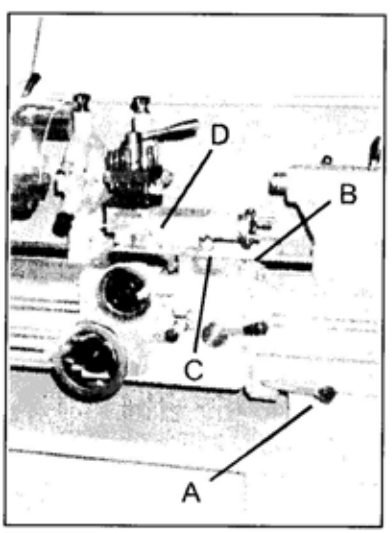


Fig. 13

6. **Forward/Reverse Lever** (A, Fig.13) – located on the right side bottom of the apron. Pull lever up for clockwise spindle rotation (reverse). Push lever down for counter-clockwise spindle rotation (forward). Neutral position is a center detent and the spindle remains idle.

7. **Carriage Lock** (B, Fig.13) – hex socket cap screw located on top rear of carriage body. Turn clockwise and tighten to lock. Turn counter-carriage. Caution: carriage lock screw must be unlocked before engaging automatic feeds or damaged to lathe may occur.

8. **Compound Rest Lock** (C, Fig.13) – set crew located on side of compound rest. Turn clockwise to lock and counter-clockwise to unlock.

9. **Cross Slide Lock** (D, Fig. 13) – set screw located on side of cross slide body. Turn

clockwise and tighten to lock. Turn counter-clockwise and loosen to unlock. **Caution**: cross slide lock screw must be unlock before engaging automatic feeds or damage to the lathe may occur.

10. **Longitudinal Traverse Hand Wheel** (A. Fig. 14) – located on the apron assembly. Rotate hand wheel clockwise to move the apron assembly toward the tailstock (right). Rotate the wheel counter-clockwise to move the apron assembly toward the headstock (left).

11. **Feed Selector** (B, Fig. 14) - located in the center front of the apron assembly. Push lever to the left and up activates the crossfeed function. Pull lever to the right and down activates the longitudinal function.

12. **Half Nut Engage Lever (Thread Cutting)** – (C, Fig. 14) located on front of the apron. Move the lever down to engage. Move the lever up to disengage.

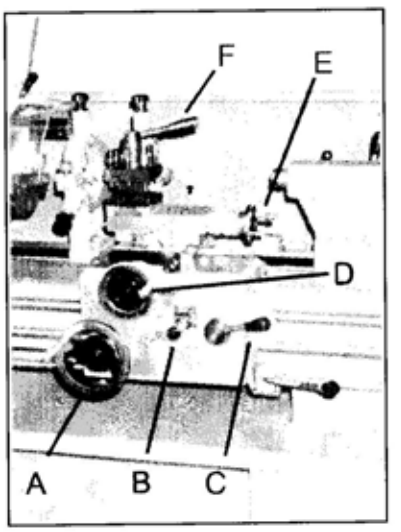


Fig. 14

13. **Cross Traverse Handwheel** (D , Fig. 14) – located above the apron assembly. Clockwise rotation moves the cross slide toward the rear of the machine.

14. **Compound Rest Traverse Handwheel** (E, Fig. 14) – Located on the end of the compound slide. Rotate clockwise to move or position.

15. **Tool Post Clamping Lever** (F, Fig. 14) – located on top of the tool post. Rotate counter-clockwise to loosen and clockwise to tighten.

16. **Tailstock Quill Clamping Lever** (A, Fig. 15) – located on the tailstock. Lift up to lock the spindle. Push down to unlock.

17. **Tailstock Clamping Lever** (B, Fig. 15) – located on the tailstock. Lift up lever to lock. Push down lever to unlock.

18. **Tailstock Quill Traverse Handwheel** (C, Fig.15) – located on the tailstock. Rotate clockwise to advance the quill. Rotate counter-clockwise to retract the quill.

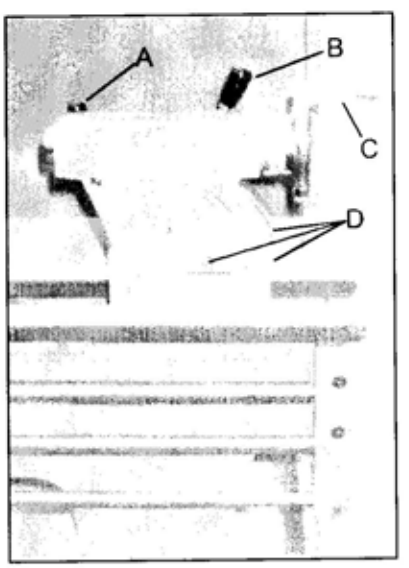


Fig. 15

19. **Tailstock Off-Set Adjustment** (D, Fig. 15) – three set screws located on the tailstock base are used to off-set the tailstock for cutting tapers. Loosen lock screw on tailstock end. Adjust side screws until amount of offset is indicated on scale. Tighten lock screw.

20. **High Low Speed Selector** (A, Fig. 16) – located on the left side of the headstock inside the end gear cover. Push toward the rear of the machine for the high-speed range and pull toward the front for the low speed change.

21. **Lock Pin for the Back Gear** (B, Fig. 16) – located inside the headstock cover. Pull the pin out and turn 90 clockwise to engage the back gear. Pull the pin out, turn 90 counter-clockwise, and rotate the chuck until the pin seats to disengagethe back gear.

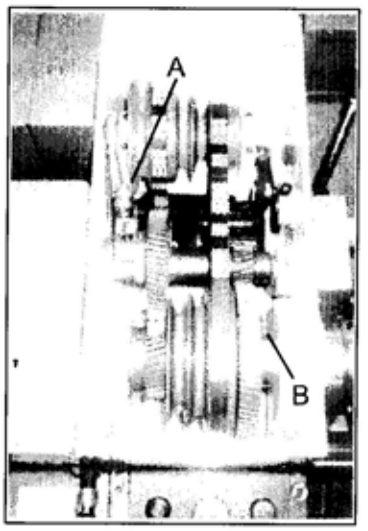


Fig. 16

Break-In Procedure

During manufacture and testing, the lathe has been operated in the low R.P.M. range for three hours.

To allow time for the gears and bearings to bread-in and run smoothly, do not run the lathe above 550 R.P.M. for the first six hours of operation and use.

Operation

Speed Selection

To change speeds, disconnect the lathe from the power source and move the belts to the desired location according to the speed selection chart on the front of the headstock.

Feed and Thread Selection

1. Reference the feed and thread tables (A, Fig.17) found on the gearbox and change gear cover.
2. Mover levers (B, Fig. 17) to the appropriate detent position.

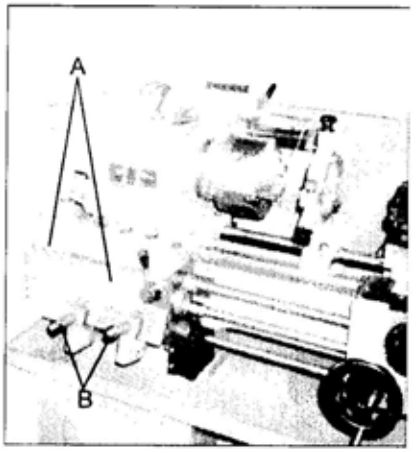


Fig. 17

Change Gear Replacement

Note: the 40T x 127T x 40T gears are installed in the end gear compartment when delivered from the factory. This combination will cover most inch feeds and threads under normal circumstance. The 30, 32 and 46 tooth gears found in the toolbox are used as indicated on feed and thread tables.

1. **Disconnect the machine from the power source.**
2. Move the end cover on the left end of the headstock
3. Loosen nuts (A & B, Fig. 18)
4. Move quadrant (C, Fig. 18) out of the way and hold in place temporarily by tightening nut. (B, Fig. 18)
5. Remover hex socket cap screws (D and/or E, Fig. 18), depending on which gear is to be changed.
6. Install new gear(s) and tighten in place with a hex socket cap screw.
7. Loosen nut (B, Fig. 18), move quadrant back so teeth mesh on gears, and tighten nuts (A & B, Fig. 18). **Caution: Make sure there is a backlash of .002~.003" between gears. Setting the gear too tight will cause excessive noise and wear.**
8. Close the cover and connect the machine to the power source.

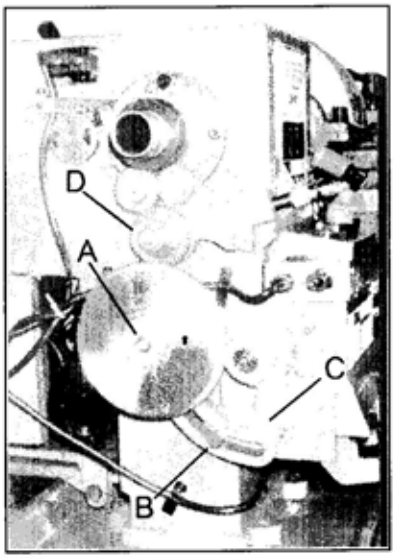


Fig. 18

Automatic Feed Operations and Feed Changes

1. Move the forward/reverse selector (A, Fig. 19) up or down depending on desired direction.
2. Set the carriage feed/thread selector (B, Fig. 19) to the left position to start the feed rod rotating.

Powered Carriage Travel

Push lever (C, Fig. 19) to the right and down to engage cross feed. Pull lever to the left and up to engage longitudinal feed.

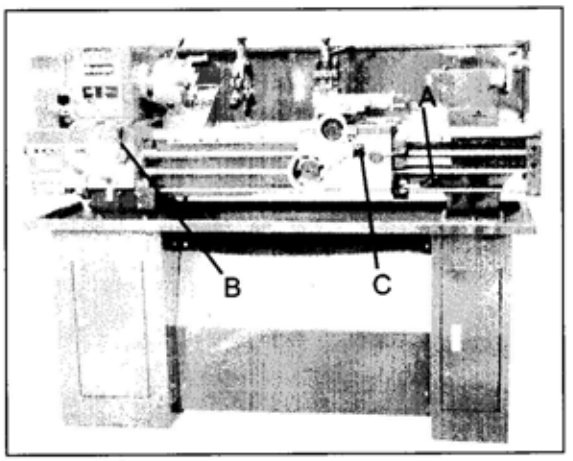


Fig. 19

The compound rest (A, Fig. 20) is located on top of the carriage and can be rotated 360°. There is a calibrated dial (B, Fig. 20) below the rest to assist in placement of the compound to the desired angle.

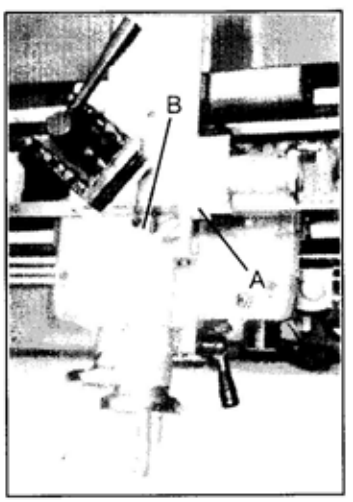


Fig. 20

Thread Cutting

1. Set feed rate selectors (A, Fig. 21) in proper position for the correct feed rate of the thread pitch to be cut.
2. Move carriage feed/thread selector (B, Fig. 21) lever to the right (lead screw will start to rotate).
3. Engage the half nut lever (C, Fig. 21).
4. To cut inch threads, refer to the chart below. The half nut lever and the threading dial are used to thread in the conventional manner. The thread dial chart specifies at which point a thread can be entered using the thread dial.

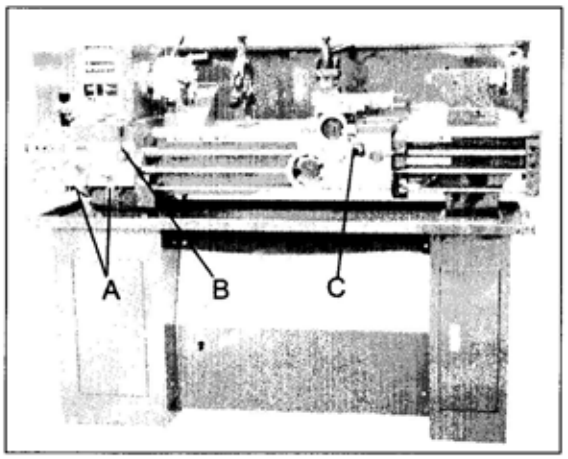
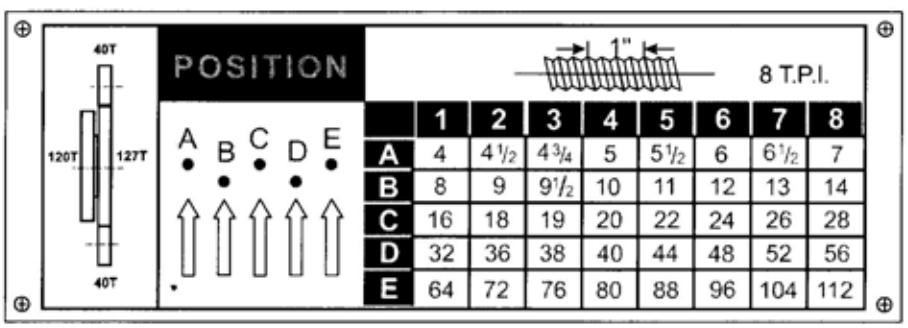


Fig. 21

5. To cut metric threads, the half nuts must be left continually engaged once the start point has been selected and the half nut is initially engaged (thread dial cannot be used).



	1	2	3	4	5	6	7	8
A	4	4 1/2	4 3/4	5	5 1/2	6	6 1/2	7
B	8	9	9 1/2	10	11	12	13	14
C	16	18	19	20	22	24	26	28
D	32	36	38	40	44	48	52	56
E	64	72	76	80	88	96	104	112

METRIC THREAD TABLE

mm	127/120/40			127/120/32		127/120/30	
	1	4	6	1	6	1	4
A	6	4.8	4	7.5	5	4.5	
B	3	2.4	2	3.75	2.5	2.25	1.8
C	1.5	1.2	1		1.25		0.9
D	0.75	0.6	0.5				0.45
E		0.3	0.25				

INCH THREAD TABLE

T.P.I.		A	B	C	D	E
127/120/32/48	1	5 3/4	11 1/2	23	46	92
127/120/32/30	1	3 3/4	7 1/2	15	30	60

FEEDING TABLE mm/inch

40/127/40		1	2	3	4	5	6	7	8
	D	.42 .0165	.37 .0146	.35 .0138	.33 .0131	.30 .0120	.28 .0110	.26 .0101	.24 .0094
	E	.210 .0082	.185 .0073	.175 .0069	.165 .0065	.150 .0060	.140 .0055	.130 .0050	.120 .0047

INDICATOR TABLE

T.P.I.	SCALE	T.P.I.	SCALE
4	1--4	23	1
4 1/2		24	1--8
4 3/4		26	1 or 3
5	1	28	1--4
5 1/2		32	1--4
6	1 or 3	36	1--4
6 1/2		38	1 or 3
7	1	40	1--8
8	1--8	44	1--4
9	1	46	1 or 3
9 1/2		48	1--8
10	1 or 3	52	1--4
11	1	56	1--8
11 1/2		64	1--8
12	1--4	72	1--8
13	1	76	1--4
14	1 or 3	80	1--8
16	1--8	88	1--8
18	1 or 3	92	1--4
19	1	96	1--8
20	1--4	104	1--8
22	1 or 3	112	1--8

LEAD SCREW PITCH 8T.P.I.

Adjustments

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

Saddle

1. Loosen three hex nuts (A, Fig. 22) found in the bottom rear of the cross slide and back off one full turn each.
2. Turn each of the four set screws with a hex wrench until a slight resistance is felt. Do not over tighten these screws.
3. Move the carriage with the hand wheel and determine if the drag is to your preference. Readjust the setscrews as necessary to achieve the desired drag.
4. Hold the socket screw firmly with a hex wrench and tighten the hex nut to lock the setscrew in place.

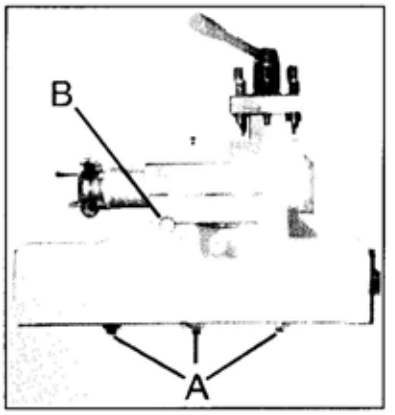


Fig. 22

5. Move the carriage again and adjust again if necessary. Note: over adjustment will cause excessive premature wear of the gibs.

Cross Slide

If the cross slide is too loose, follow procedure below to tighten:

1. Loosen the rear gib screw (B, Fig. 18) approximately one turn.
2. Tighten the front gib screw a quarter turn. Turn the cross slide handwheel to see if the cross slide is still loose. If it is still loose, tighten the front screw a bit more and try again.
3. When the cross slide is properly adjusted, tighten the rear gib screw. Do not over tighten. This will cause premature wear on the gib and mating parts.

Compound Rest

Follow the same procedure as the cross slide adjustment to adjust the compound rest.

Tailstock

If the handle will not lock the tailstock, follow the procedure below:

1. Lower handle (A, Fig.23) to the unlocked position.

2. Slide tailstock to an area that will allow you to reach under the tailstock.

3. Tighten tailstock clamping nut !/4 turn. Re-test for proper locking. Repeat as necessary.

Fig. 23

Tailstock Off-Set

Follow the procedure below to offset the tailstock to cut shallow tapers:

1. Lock tailstock in position by raising locking handle (A, Fig. 24)
2. Loosen setscrew (B, Fig. 24) on right end of tailstock
3. Alternately loosen and tighten front and rear setscrews (C, Fig. 24) until desired offset is indicated on scale.
4. Tighten setscrew (B, Fig. 24) on right end of tailstock to lock setting.

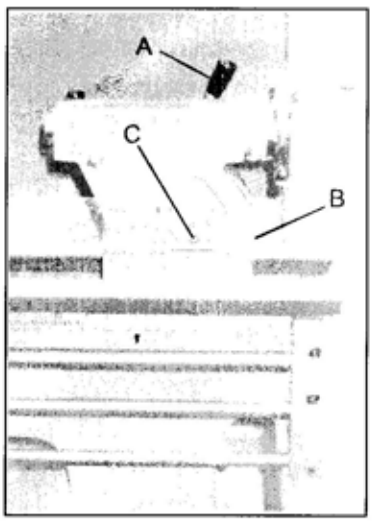


Fig. 24

Crossfeed Backlash

1. Remove the screw (A, Fig. 25) holding the nut in place.
2. Rotate the cross slide handwheel until the feed nut

   Reach the end of its travel.
3. Turn the socket head cap screw in the nut until backlash is acceptable. Adjust in small increments and test after each adjustment.
4. After the adjustment has been made, return the cross slide Nut to the center position and install the retaining screws.

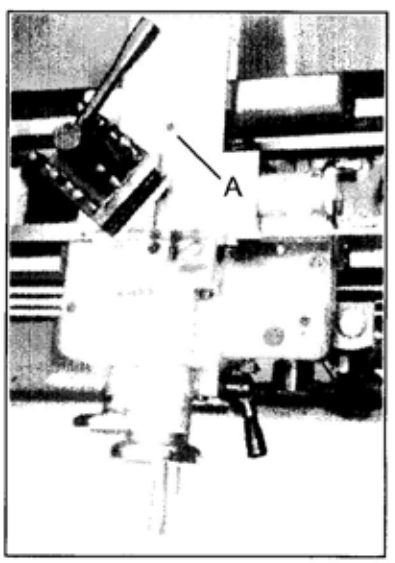


Fig. 25

Headstock Alignment

The headstock has been aligned at the factory and should not Require adjustment. However, if adjustment is deemed necessary, follow the procedure below to align the headstock.

1. Using an engineer's precision level on the bedways, make sure the lathe is level side to side and front to back. If the lathe is not level, correct to a level condition before proceeding. Re-test alignment if any leveling adjustments were made.
2. From steel bar stock of approximately 50mm in diameter, cut a piece approximately 200mm long.
3. Place 50mm of bar stock into chuck and tighten chuck. Do not use the tailstock or center to support the other end.
4. Set and cut along 200mm of the bar stock,
5. Using a micrometer, measure the bar stock next to the chuck and at the end. The measurement should be the same.
6. If the measurements are not the same and adjustment is required, loosen the bolts that hold the headstock to the bed. Do not loosen completely, some drag should remain.

7. Adjust two screws located on the backside of the headstock just above the motor mount bracket and make another cut. Keep adjusting screws after each cut until the bar stock measurements are the same. Tighten all headstock screws and jam nuts on adjusting screws

Removing Gap Section

1. Locate two nuts (A, Fig. 26) in the center of the gap section.
2. Using an open end wrench, tighten the two nuts. This will cause the taper pins to release. Remove the taper pins.
3. Remove the four hex socket cap screws (B, Fig. 26) with a hex key wrench.
4. Gap section can now be removed.

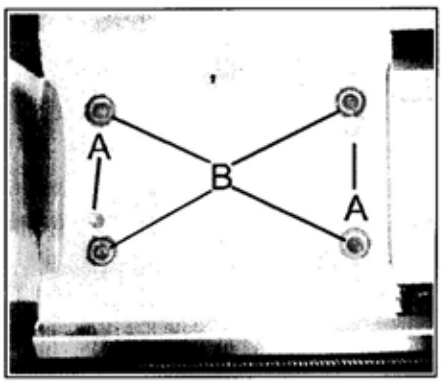
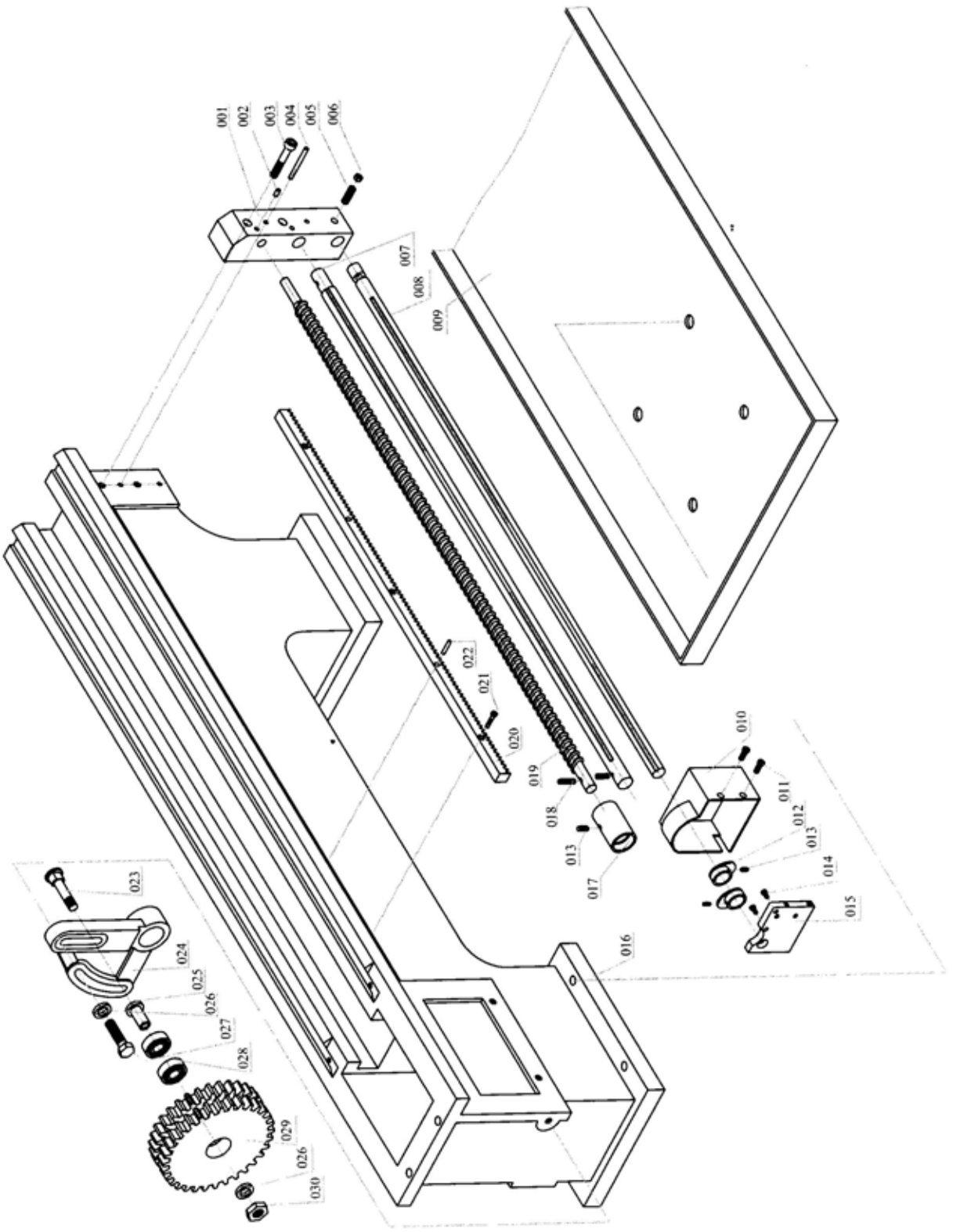


Fig. 26

Installing Removable Gap Section

1. Clean the bottom and the ends of the gap section thoroughly.
2. Set gap section in place and align.
3. Remove nuts from the taper pins.
4. Slide taper pins in their respective holes and seat using a mallet. Install nuts on the taper pins finger tight.
5. Install four socket head cap screws and tighten securely.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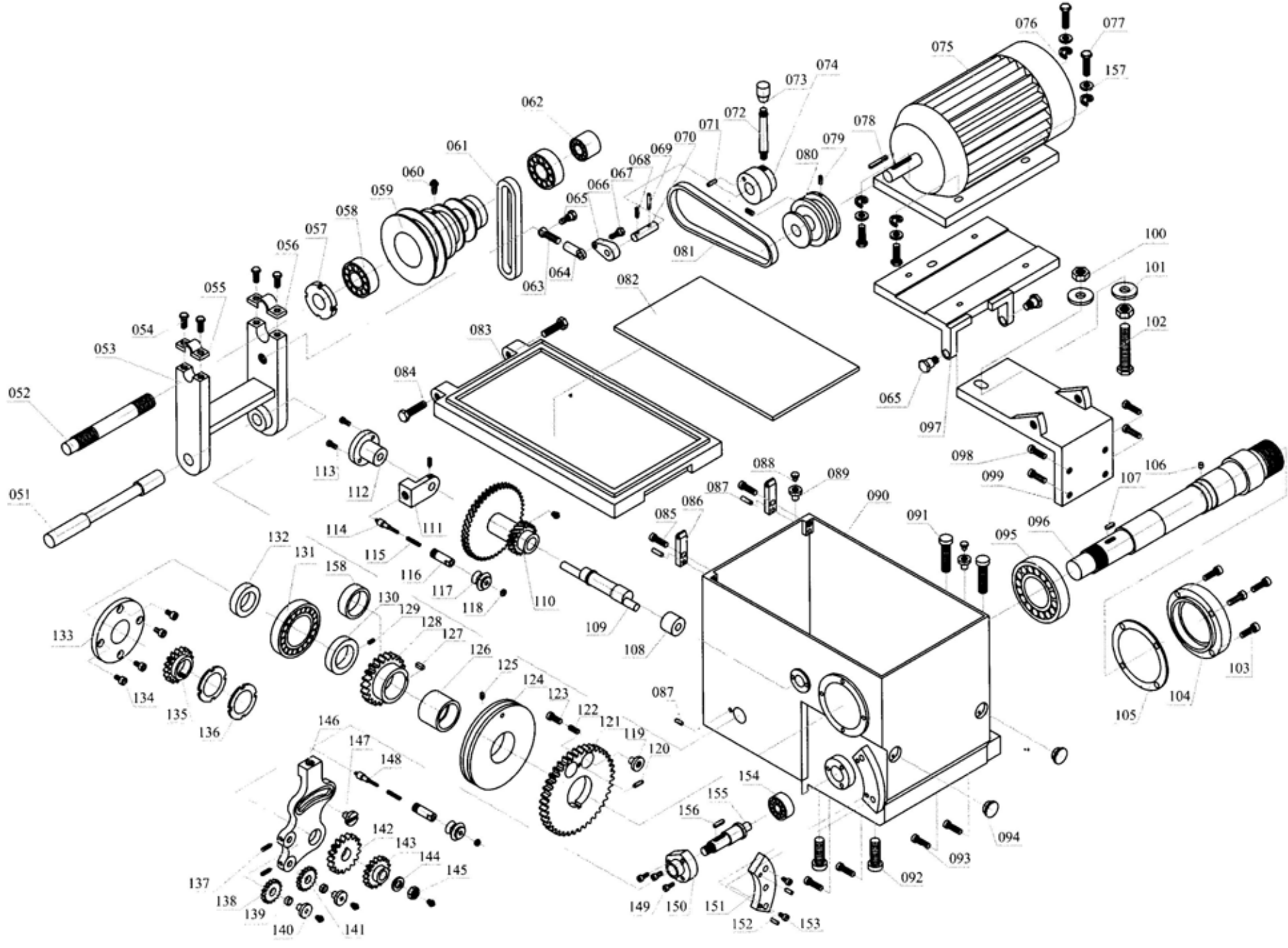
Parts List For CT041 Belt Drive Lathe

BED ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
001	CM1224C-01-011	Fixing block		1
002	GB1155	Oiler	6	2
003	GB70	Socket head cap screw	M8X50	2
004	GB879	Pin	5X50	2
005	GB77	Socket head cap screw	M8X20	1
006	GB41	Nut	M8	1
007	CM1224C-01-009	Feed rod		1
008	CM1224C-01-013	Switch lever		1
009	CM1224C-01-012	Chip pan		1
010	CM1224C-01-015	Switch cover		1
011	GB65	Round head screw	M6X12	2
012	CM1224C-01-014	Eccentric bracket		2
013	GB77	Flat set screw	M6X6	3
014	GB70	Socket head cap screw	M6X12	2
015	CM1224C-01-016	Switch board		1
016	CM1224C-01-010	Bed		1
017	CM1224C-01-005	Sleeve of lead screw		1
018	GB879	Spring pin	5X30	2
019	CM1224C-01-006	Lead Screw		1
020	CM1224C-01-007	Rack		1
021	GB70	Socket head cap screw	M6X20	3
022	GB879	Spring pin	5X30	2
023	CM1224C-01-002	Change gear shaft		1
024	CM1224C-01-001	Bracket		1
025	CM1224C-01-003	Bearing sleeve		1
026	GB95	Washer	10	2
027	GB5780	Bolt	M10X40	1
028	GB278	Bearing	60103	2
029	CM1224C-01-004	Change gear (big)		1
030	GB41	Nut	M10	1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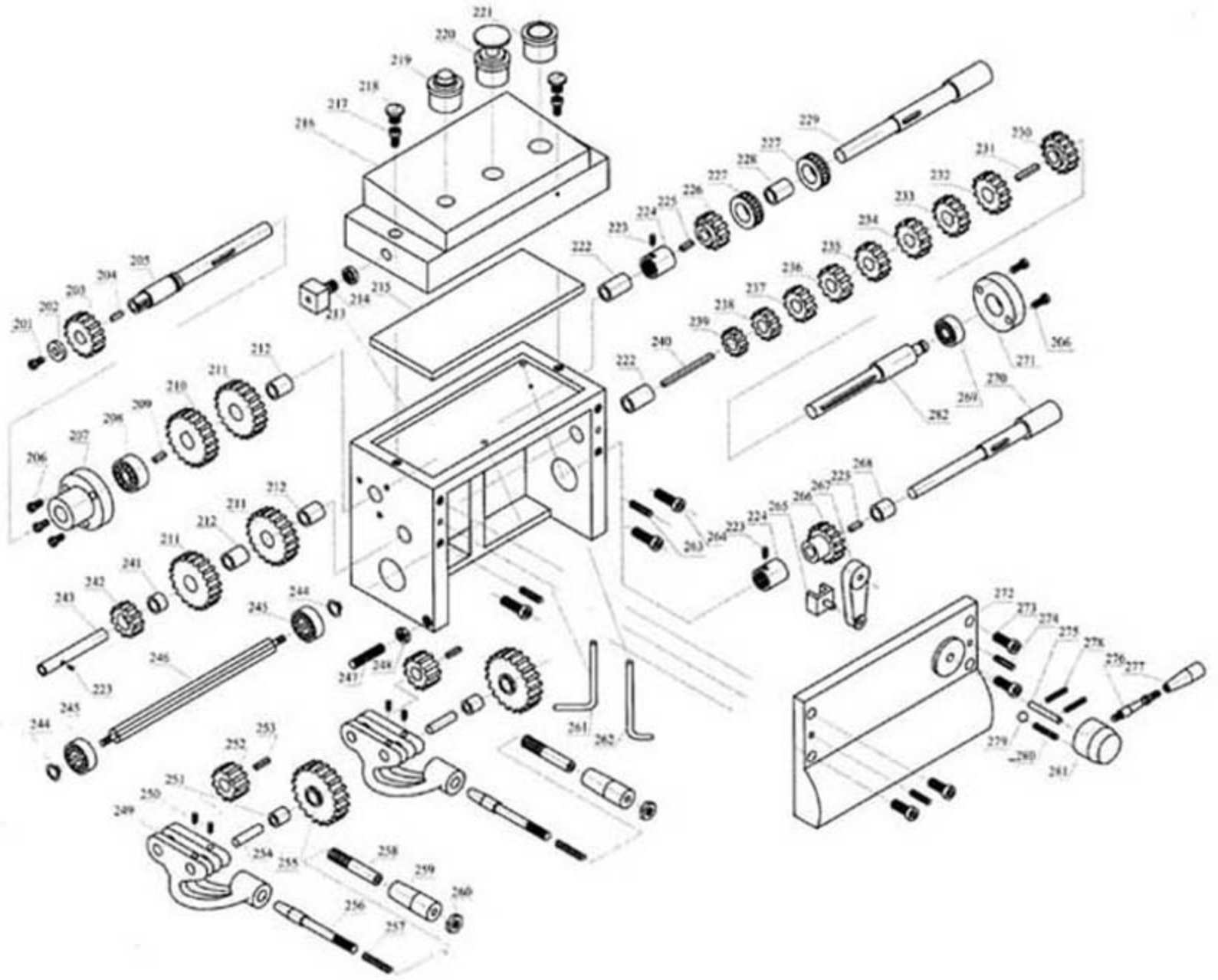
HEADSTOCK

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
051	CM1224C-02-002	V-pulley supporting shaft		1
052	CM1224C-02-015	V-pulley shaft		1
053	CM1224C-02-001	Bracket		1
054	GB70	Screw	M5X12	4
055	CM1224C-02-013	Small cover of bracket		1
056	CM1224C-02-013	Big cover of bracket		1
057	GB812	Nut	M25X1.5	1
058	GB278	Bearing	60105	2
059	CM1224C-02-014	V-pulley		1
060	GB1152	Oiler	M6X1	5
061	GB1171	V-belt	B-838	1
062	CM1224C-02-012	Locking nut		1
063	CM1224C-02-011	Bolt		1
064	CM1224C-02-010	Adjustable nut		1
065	CM1224C-02-009	Bolt		3
066	CM1224C-02-008	Transmission bracket		1
067	CM1224C-02-042	Hexagon bolt		1
068	GB78	Screw	M8X12	2
069	GB879	Pin	5X40	1
070	CM1224C-02-007	Axle		1
071	GB879	Pin	5X14	1
072	CM1224C-06-015	Clamping Lever		1
073	GB4141.14	Knob	BM10X50	1
074	CM1224C-02-50	Lever seat		1
075		Motor		1
076	GB93	Spring washer	8	4
077	GB5780	Bolt	M8X25	4
078	GB1096	Key	6X32	1
079	GB77	Screw	M8X16	2
080	CM1224C-02-004	Pulley		1
081	GB1171	V-belt	B-813	1
082	CM1224C-02-048	Washer of cover		1
083	CM1224C-02-046	Cover		1
084	GB27	Bolt	M8X35	2
085	GB70	Screw	M8X20	2
086	CM1224C-02-049	Hinge		2
087	GB879	Pin	5X25	3
088	CM1224C-02-052B	Plug		2
089	CM1224C-02-053A	Plug		2
090	CM1224C-02-003	Headstock		1
091	GB70	Screw	M10X35	2

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
092	GB70	Screw	M10X30	2
093	GB70	Screw	M8X30	4
094	GB1160	Oiler	16	2
095	GB297	C7211 Bearing		1
096	CM1224C-02-041	Main spindle		1
097	CM1224C-02-005	Motor seat		1
098	GB70	Screw	M8X30	4
099	CM1224C-02-006	Motor base plate		1
100	GB6172	Nut	M12	2
101	GB96	Washer	12	2
102	GB5780	Bolt	M12X75 M12X80	1
103	GB70	Screw	M8X20	4
104	CM1224C-02-040	Main spindle front cover		1
105	CM1224C-02-053	Paper washer		1
106	GB1096	Key	8X14	1
107	GB1096	Key	6X16	1
108	CM1224C-02-016	Back gear sleeve		1
109	CM1224C-02-019	Back gear shaft		1
110	CM1224C-02-017	Back gear		1
111	CM1224C-02-018	Back gear change seat		1
112	CM1224C-02-047	Back gear cover		1
113	GB70	Screw	M6X10	2
114	CM1224C02-051-2	Locating shaft (small)		2
115	CM1224C02-051-4	Compressing spring		2
116	CM1224C02-051-1	Positioning lever grip		2
117	CM1224C02-051-3	Positioning lever		2
118	GB923	Nut	M6	1
119	GB807	Figured flat nut	M8	1
120	GB879	Pin	3X16	1
121	CM1224C-02-039	Helical gear		1
122	CM1224C-02-038	Spring		1
123	CM1224C-02-037	Transmission pin		1
124	CM1224C-02-036	V-pulley		1
125	GB78	Screw	M6X10	1
126	CM1224C-02-035	Bush of V-pulley		1
127	GB1096	Key	8X20	1
128	CM1224C-02-034	Helical gear		1
129	GB77	Screw	M8X10	2
130	CM1224C-02-055	Supporting plate		1
131	GB297	Bearing	C7210	1
132	CM1224C-02-054	Bush		1
133	CM1224C-02-020	Main spindle back cover		1

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
134	GB70	Screw	M8X16	4
135	CM1224C-02-021	Spur gear		1
136	GB812	Nut	M45X1.5	2
137	GB78	Screw	M6X12	2
138	CM1224C-02-043	Spur gear		1
139	CM1224C-02-023	Bush		2
140	CM1224C-02-022	Axle		2
141	CM1224C-02-024	Spur gear		1
142	CM1224C-02-029	Spur gear		1
143	CM1224C-03-009	Gear		1
144	CM1224C-02-027	Washer		1
145	GB170	Nut	M12	1
146	CM1224C-02-030	Tumbler		1
147	CM1224C-02-031	Screw		1
148	CM1224C-02-051	Locating shaft (big)		1
149	GB70	Screw	M6X16	3
150	CM1224C-02-028	Bearing seat		1
151	CM1224C-02-032	Change gear seat		1
152	GB879	Pin	5X20	2
153	GB70	Screw	5X16	2
154	GB276	Bearing	202	1
155	CM1224C-02-026	Axle		1
156	GB1096	Key	5X25	1
157	GB95	Washer	8	4
158	CM1224C-02-033	Bush of helical gear		1



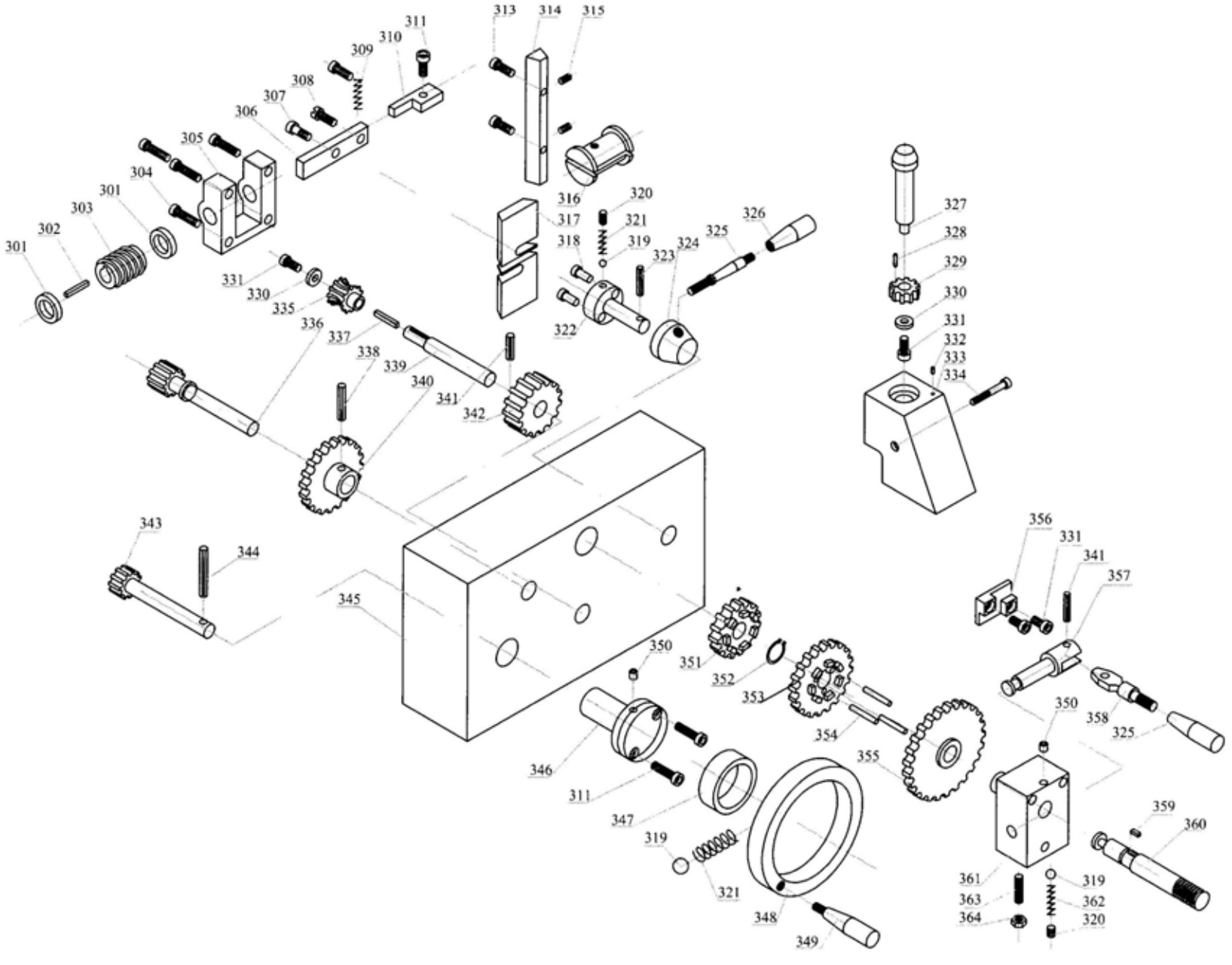
GEARBOX

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
201	GB70	Screw	M6X12	1
202	CM1224C-03-008	Washer		1
203	CM1224C-03-009	Gear		1
204	GB1096	Key	5X14	1
205	CM1224C-03-007	Shaft		1
206	GB70	Screw	M6X10	5
207	CM1224C-03-010	Bearing cover		1
208	GB276	Bearing	60103	1
209	GB1096	Pin	5X16	1
210	CM1224C-03-013	Duplex gear		1
211	CM1224C-03-014	Duplex gear		3
212	CM1224C-03-012	Gear sleeve		3
213	CM1224C-03-033	Gear box		1
214		Pipe connecting	8	1
215	CM1224C-03-037	Carpet		1
216	CM1224C-03-035	Knob seat		1
217	GB70	Screw	M6X8	2
218	CM1224C-03-034	Plug		2
219	D110-110V	Indicator		1
220		Stop switch		1
221	LA19-11A	Knob		1
222	CM1224C-03-011	Axle sleeve		2
223	GB78	Screw	M6X16	3
224	CM1224C-03-049	Nut		2
225	GB1096	Key	6X16	2
226	CM1224C-03-025	Gear		1
227	GB301	Bearing	8104	2
228	CM1224C-03-026	Axle sleeve		1
229	CM1224C-03-027	Axle		1
230	CM1224C-03-028	Gear		1
231	GB1096	Key	6X32	1
232	CM1224C-03-024	Gear		1
233	CM1224C-03-023	Gear		1
234	CM1224C-03-022	Gear		1
235	CM1224C-03-021	Gear		1
236	CM1224C-03-020	Gear		1
237	CM1224C-03-019	Gear		1
238	CM1224C-03-018	Gear		1
239	CM1224C-03-017	Gear		1
240	GB1096	Key	5X74	1
241	CM1224C-03-016	Bushing		1

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
242	CM1224C-03-015	Gear		1
243	CM1224C-03-041	Shaft		1
244	GB894.1	Washer	12	2
245	GB287	Bearing	60201	2
246	CM1224C-03-005	Shaft		1
247	GB73	Screw	M8X35	1
248	GB41	Nut	M8	1
249	CM1224C-03-001	Lever seat		2
250	GB77	Screw	M6X6	4
251	CM1224C-03-004	Bushing		2
252	CM1224C-03-006	Gear		2
253	GB1096	Key	5X14	2
254	CM1224C-03-003	Gear shaft		2
255	CM1224C-03-002	Gear		2
256	CM1224C-03-045	Axle of gripper		2
257	CM1224C-03-046	Spring		2
258	CM1224C-03-047	Sleeve of gripper		2
259	CM1224C-03-044	Lever		2
260	GB923	Nut	M6	2
261	CM1224C-03-042	Oil pipe		1
262	CM1224C-03-043	Oil pipe		1
263	GB879	Pin	5X20	4
264	GB70	Screw	M8X25	3
265	CM1224C-03-036	Fork		1
266	CM1224C-03-032	Gear		1
267	CM1224C-03-038	Connecting rod		1
268	CM1224C-03-031	Bushing		1
269	GB278	Bearing	601201	1
270	CM1224C-03-030	Shaft		1
271	CM1224C-03-050	Front cover		1
272	CM1224C-03-040	Gear box front cover		1
273	GB70	Screw	M6X16	4
274	CM1224C-03-039	Shaft		1
275	GB879	Pin	5X26	1
276	GB4141.14	Lever grip	BM10X50	1
277	CM1224C-04-003	Lever		1
278	GB879	Pin	5X40	1
279	GB308	Steel ball	6	1
280	GB2089	Compressing spring	1X4.5X16-2	1
281	CM1224C-03-048	Knob		1
282	CM1224C-03-029	Shaft		1

GEARBOX

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
201	GB70	Screw	M6X12	1
202	CM1224C-03-008	Washer		1
203	CM1224C-03-009	Gear		1
204	GB1096	Key	5X14	1
205	CM1224C-03-007	Shaft		1
206	GB70	Screw	M6X10	5
207	CM1224C-03-010	Bearing cover		1
208	GB276	Bearing	60103	1
209	GB1096	Pin	5X16	1
210	CM1224C-03-013	Duplex gear		1
211	CM1224C-03-014	Duplex gear		3
212	CM1224C-03-012	Gear sleeve		3
213	CM1224C-03-033	Gear box		1
214		Pipe connecting	8	1
215	CM1224C-03-037	Carpet		1
216	CM1224C-03-035	Knob seat		1
217	GB70	Screw	M6X8	2
218	CM1224C-03-034	Plug		2
219	D110-110V	Indicator		1
220		Stop switch		1
221	LA19-11A	Knob		1
222	CM1224C-03-011	Axle sleeve		2
223	GB78	Screw	M6X16	3
224	CM1224C-03-049	Nut		2
225	GB1096	Key	6X16	2
226	CM1224C-03-025	Gear		1
227	GB301	Bearing	8104	2
228	CM1224C-03-026	Axle sleeve		1
229	CM1224C-03-027	Axle		1
230	CM1224C-03-028	Gear		1
231	GB1096	Key	6X32	1
232	CM1224C-03-024	Gear		1
233	CM1224C-03-023	Gear		1
234	CM1224C-03-022	Gear		1
235	CM1224C-03-021	Gear		1
236	CM1224C-03-020	Gear		1
237	CM1224C-03-019	Gear		1
238	CM1224C-03-018	Gear		1
239	CM1224C-03-017	Gear		1
240	GB1096	Key	5X74	1
241	CM1224C-03-016	Bushing		1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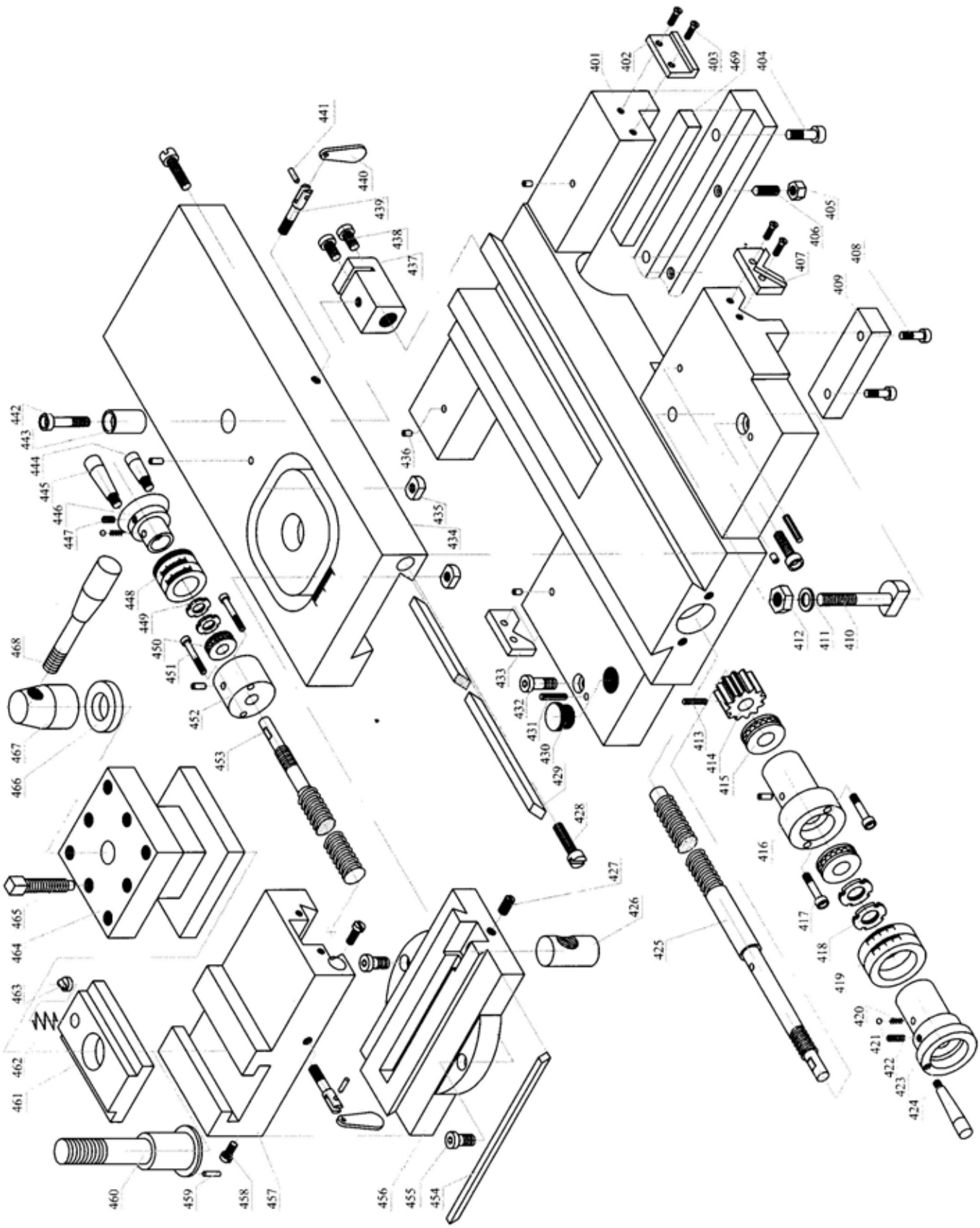
APRON

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
301	CM1224C-04-037	Washer		2
302	GB1096	Key	5X32	1
303	CM1224C-04-022	Worm		1
304	GB70-85	Screw	M6X25	4
305	CM1224C-04-021	Seat frame		1
306	CM1224C-04-035	Safety Piece		1
307	GB30	Screw	M6X8	1
308	GB65	Screw	M4X14	2
309	CM1224C-04-034	Spring		1
310	CM1224C-04-032	Arm		1
311	GB70-85	Screw	M6x16	3
312	GB70-85	Screw	M6X8	2
313	GB70-85	Screw	M5X16	2
314	CM1224C-04-029	Guide plate		1
315	GB78-85	Screw	M6X12	2
316	CM1224C-04-025	Half nut		1
317	CM1224C-04-026	Half nut seat		1
318	CM1224C-04-024	Pin		2
319	GB308	Steel ball	6	3
320	GB77	Screw	M8X8	2
321	CM1224C-06-007	Spring		2
322	CM1224C-04-004	Clutch of half nut		1
323	GB879	Pin	5X40	1
324	CM1224C-04-036	Knob		1
325	GB4141.14	Lever grip	BM12X50	2
326	CM1224C-04-003	Lever		1
327	CM1224C-04-028	Indicator shaft		1
328	GB119	Pin	3X12	1
329	CM1224C-04-030	Indicator gear		1
330	CM1224C-04-031	Washer		2
331	GB70	Screw	M6X12	4
332	GB827	Rivet	2.5X5	1
333	CM1224C-04-027	Thread dial		1
334	GB70	Screw	M6X45	1
335	CM1224C-04-023	Worm		1
336	CM1224C-04-010	Transmission shaft		1
337	GB1096	Key	4X20	1
338	GB879	Pin	5X30	1
339	CM1224C-04-007	Axle		1
340	CM1224C-04-016	Spur gear		2
341	GB879	Pin	5X25	1

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
342	CM1224C-04-006	Transmission gear		1
343	GB879	Pin	5X60	1
344	CM1224C-04-012	Handwheel gear		1
345	CM1224C-04-015	Case of apron		1
346	CM1224C-04-014	Handwheel seat		1
347	CM1224C-04-013	Graduation collar		1
348	CM1224C-04-011	Handwheel		1
349	GB4141.1	Handle	BM8X63	1
350	GB1155	Oiler	6	2
351	CM1224C-04-019	Clutch gear		1
352	GB894.1	Washer	16	1
353	CM1224C-04-009	Clutch gear		1
354	GB119	Pin	6X30	3
355	CM1224C-04-008	Clutch gear		1
356	CM1224C-04-002	Safety stopper		1
357	CM1224C-04-018	Change rod		1
358	CM1224C-04-001	Change lever		1
359	GB1096	Key	4X8	1
360	CM1224C-04-020	Change shaft		1
361	CM1224C-04-017	Change lever seat		1
362	CM1224C-04-038	Spring		1
363	GB75	Screw	M8X35	1
364	GB6170	Nut	M8	1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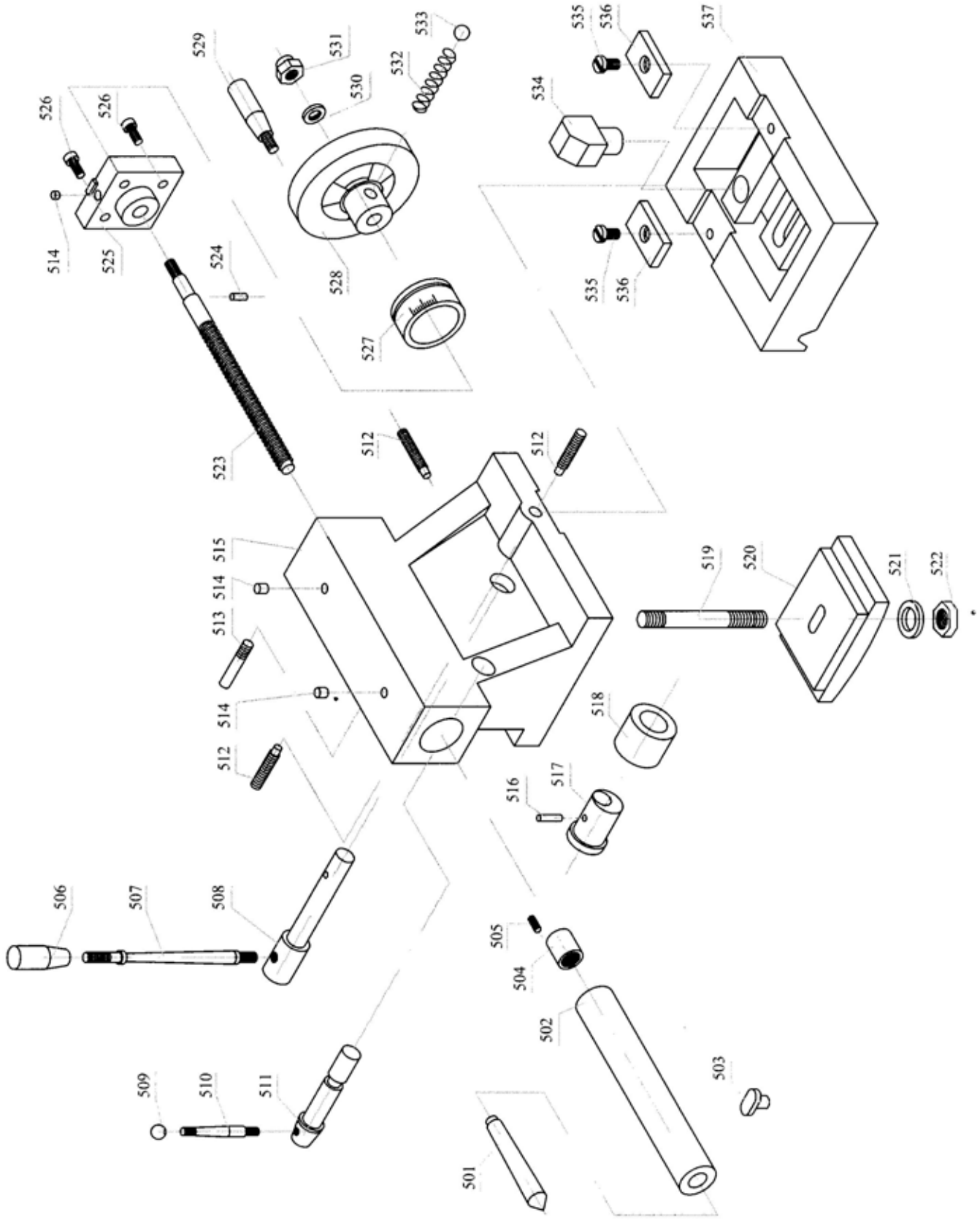
SADDLE, CROSS SLIDE, TOP SLIDE & TOOL POST

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
401	CM1224C-05-003	Saddle		1
402	CM1224C-05-044	Wiper		2
403	GB818	Screw	M5X12	8
404	GB70	Screw	M8X25	3
405	GB41	Nut	M8	3
406	GB78	Screw	M8X22	3
407	CM1224C-05-041	Wiper		1
408	GB70	Screw	M6X16	4
409	CM1224C-05-040	Block slide		2
410	CM1224C-05-032	Fixing bolt		1
411	GB97.1	Washer	10	1
412	GB41	Nut	M10	1
413	GB879	Pin	5X20	1
414	CM1224C-05-039	Gear		1
415	GB301	Bearing	8101	2
416	CM1224C-05-038	Leadscrew seat		1
417	GB70	Screw	M6X45	2
418	GB810	Nut	M12X1.25	2
419	CM1224C-05-037	Graduation collar		1
420	CM1224C-06-007	Compressing spring		2
421	GB308	Steel ball	6	2
422	GB77	Screw	M6X16	1
423	CM1224C-05-023	Handlewheel		1
424	CM1224C-05-024	Lever		1
425	CM1224C-05-004	Leadscrew of saddle		1
426	CM1224C-05-026	Nut		1
427	GB78	Screw	M6X12	1
428	CM1224C-05-034	Adjusting screw		2
429	CM1224C-05-035	Gib		1
430	CM1224C-03-034	Plug		1
431	GB879	Pin	5X35	2
432	GB70	Screw	M8X30	2
433	CM1224C-05-042	Wiper		1
434	CM1224C-05-005	Cross slide		1
435	CM1224C-05-008	Fixing block		2
436	GB1155	Oiler	6	7
437	CM1224C-05-006	Lead screw nut		1
438	GB818	Screw	M4X20	2
439	CM1224C-05-006	Clamping bolt		2
440	CM1224C-05-022B	Clamping lever		2
441	GB879	Pin	2X8	2

SADDLE, CROSS SLIDE, TOP SLIDE & TOOL POST

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
442	GB70	Screw	M6X20	1
443	CM1224C-05-007	Fixing seat		1
444	CM1224C-05-030	Lever		1
445	CM1224C-05-031	Lever		1
446	CM1224C-05-029	Handwheel		1
447	GB77	Screw	M6X6	4
448	CM1224C-05-028	Graduation collar		1
449	GB810	Nut	M10X1	2
450	GB301	Bearing	8100	1
451	GB70	Screw	M4X30	2
452	CM1224C-05-027	Bearing seat		1
453	CM1224C-05-025	Lead screw		1
454	CM1224C-05-029	Gib		1
455	GB70	Screw	M8X18	2
456	CM1224C-05-009	Swivel base		1
457	CM1224C-05-010	Toolpost		1
458	CM1224C-05-020	Adjusting screw		2
459	GB879	Pin	4X10	1
460	CM1224C-05-016	Clamping nut		1
461	CM1224C-05-043	T Key		2
462	CM1224C-05-011	Compressing spring		1
463	CM1224C-05-012	Locating block		1
464	CM1224C-05-014	Tool post		1
465	CM1224C-05-013	Tool post screw		8
466	CM1224C-05-015	Washer		1
467	CM1224C-05-017	Lever		1
468	CM1224C-05-018	Handle		1
469	CM1224C-05-002	Slide gib		1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TAILSTOCK

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
501	JB2889-81	Center	2#	1
502	CM1224C-06-002	Tailstock quill		1
503	CM1224C-06-021	T key		1
504	CM1224C-06-004	Nut of leadscrew		1
505	GB78-85	Screw	M6X10	1
506	GB4141.14-84	Lever grip	M10X50	1
507	CM1224C-06-015	Lever		1
508	CM1224C-06-014	Clamping shaft		1
509	GB4141.11-84	Lever ball	M6X20	1
510	CM1224C-06-008	Lever		1
511	CM1224C-06-009	Eccentric axle		1
512	GB75-85	Screw	M10X40	3
513	CM1224C-06-013	Fixing axle		1
514	GB1155-79	Oiler	6	3
515	CM1224C-06-001	Tailstock		1
516	GB879-86	Spring pin	5X25	1
517	CM1224C-06-011	Sleeve of eccentric axle		1
518	CM1224C-06-010	Sleeve		1
519	CM1224C-06-019	Double bolt		1
520	CM1224C-06-018	Clamping block		1
521	GB97.1-85	Washer	12	1
522	GB6170-86	Nut	M12	1
523	CM1224C-06-003	Lead screw of tailstock		1
524	GB119-86	Pin	5X8	1
525	CM1224C-06-005	Bracket		1
526	GB70-85	Screw	M6X16	4
527	CM1224C-06-006	Graduation collar		1
528	CM1224C-06-016	Handwheel of tailstock		1
529	GB4141.1-84	Handle	BM8X63	1
530	GB97.1-85	Washer	10	1
531	GB923-88	Nut	M10	1
532	CM1224C-06-007	Spring		1
533	GB308-84	Steel ball	6	1
534	CM1224C-06-017	Fixing bracket		1
535	GB68-85	Screw	M6X12	2
536	CM1224C-06-012	Fixing block		1
537	CM1224C-06-020	Base plate		1

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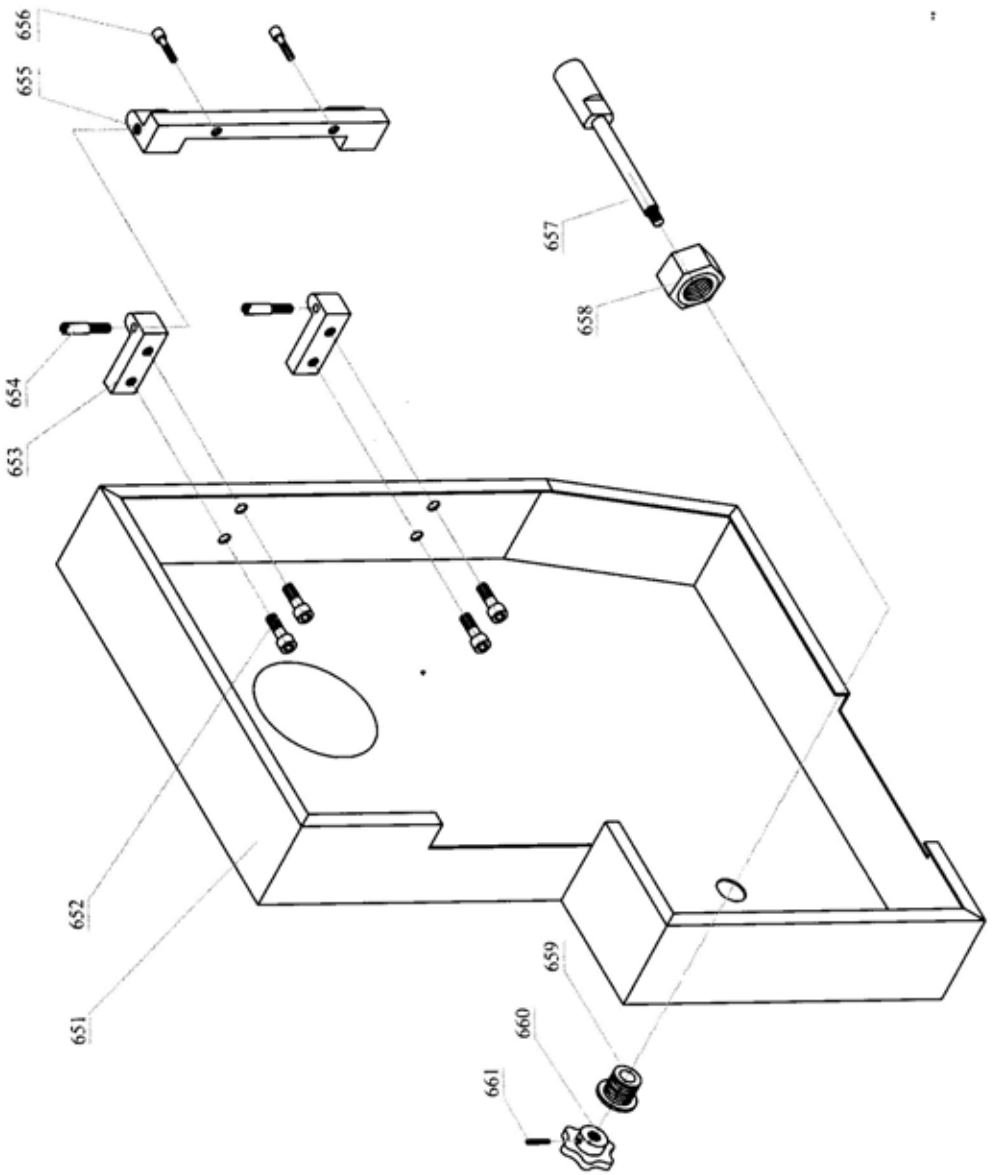
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CONTROL HANDLE & END COVER

INDEX NO.	PART NO.	DESCRIPTION	SIZE	QTY'
601	GB879-86	Spring pin	3X5	1
602	GB1096-79	Key	5X18	1
603	CM1224C-07-005	Axle		1
604	CM1224C-07-002	Lever bracket		1
605	GB70-85	Screw	M6X12	2
606	CM1224C-07-001	Handle		1
607	GB4141.14-84	Lever grip	M10X50	1
608	CM1224C-07-004	Spring	1X6X22	1
609	CM1224C-07-003	Switch cover		1
610	GB119-86	Pin	5X35	1
611	GB308-84	Steel ball	6	1
612	CM1224C-07-006	Spring	1X6X9	1
613	GB77-85	Screw	M8X10	1
614	GB78-85	Screw	M8X12	1
651	CM1224C-08-001	Side cover		1
652	GB70-85	Socket head cap screw	M6X16	1
653	CM1224C-08-003	Side cover seat		1
654	CM1224C-08-002	Locating screw		1
655	CM1224C-08-004	Support of side cover		1
656	GB70-85	Socket head cap screw	M6X12	1
657	CM1224C-08-005	Locking rod		1
658	GB41-86	Nut	M16	1
659	CM1224C-08-006	Sleeve of locking rod		1
660	GB4141.29-84	Knob	M8X32	1
661	GB879-84	Spring pin	3X16	1
701	CJ10-10	Relay switch		2
702	R1	Fuse		1
703	BK-50	Converter		1
704	X5-1015	Support plate		1
705		Knot		1
706	LX5-11N	Travel switch		2
707		Union joint		4
708	GB818-85	Screw		9
709	GB818-85	Screw		5
710	GB818-85	Screw		3
711	CM1224C-09-001	Electrical control box		1
712		Electricalinstalled plate		1
713		Grounding late		1
714		Hinge		2
715		Rivet		8

WARRANTY

CRAFTEX 2 YEAR LIMITED WARRANTY

Craftex warrants every product to be free from defects in materials and agrees to correct such defects where applicable. This warranty covers **two years** for parts and 90 days for labour (unless specified otherwise), to the original purchaser from the date of purchase but does not apply to malfunctions arising directly or indirectly from misuse, abuse, improper installation or assembly, negligence, accidents, repairs or alterations or lack of maintenance.
Proof of purchase is necessary.
All warranty claims are subject to inspection of such products or part thereof and Craftex reserves the right to inspect any returned item before a refund or replacement may be issued.
This warranty shall not apply to consumable products such as blades, bits, belts, cutters, chisels, punches etceteras.
Craftex shall in no event be liable for injuries, accidental or otherwise, death to persons or damage to property or for incidental contingent, special or consequential damages arising from the use of our products.

RETURNS, REPAIRS AND REPLACEMENTS

To return, repair, or replace a Craftex product, you must visit the appropriate Busy Bee Tools showroom or call 1-800-461-BUSY. Craftex is a brand of equipment that is exclusive to Busy Bee Tools.

For replacement parts directly from Busy Bee Tools, for this machine, please call 1-800-461-BUSY (2879), and have your credit card and part number handy.

- All returned merchandise will be subject to a minimum charge of 15% for re-stocking and handling with the following qualifications.
- Returns must be pre-authorized by us in writing.
- We do not accept *collect* shipments.
- Items returned for warranty purposes must be insured and shipped pre-paid to the nearest warehouse
- Returns must be accompanied with a copy of your original invoice as proof of purchase. Returns must be in an un-used condition and shipped in their original packaging a letter explaining your reason for the return. Incurred shipping and handling charges are not refundable.
- Busy Bee will repair or replace the item at our discretion and subject to our inspection.
- Repaired or replaced items will be returned to you pre-paid by our choice of carriers.
- Busy Bee reserves the right to refuse reimbursement or repairs or replacement if a third party without our prior authorization has carried out repairs to the item.
- Repairs made by Busy Bee are warranted for 30 days on parts and labour.
- Any unforeseen repair charges will be reported to you for acceptance prior to making the repairs.
- The Busy Bee Parts & Service Departments are fully equipped to do repairs on all products purchased from us with the exception of some products that require the return to their authorized repair depots. A Busy Bee representative will provide you with the necessary information to have this done.
- For faster service it is advisable to contact the nearest Busy Bee location for parts availability prior to bringing your product in for repair.