



OWNER'S MANUAL



CT089 - 13" x 24" METAL LATHE



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CT089 - 13" x 24" METAL LATHE

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GENERAL SAFETY INSTRUCTIONS

EXTREME CAUTION SHOULD BE USED IN OPERATING ALL POWER TOOLS. KNOW YOUR POWER TOOL, BE FAMILIAR WITH ITS OPERATION. READ THE OWNER'S MANUAL AND PRACTICE SAFE USAGE PROCEDURES AT ALL TIMES.

- ❑ **CONNECT** your machine **ONLY** to the matched and specified power source.
- ❑ **WEAR SAFETY GLASSES, RESPIRATORS, HEARING PROTECTION** and **SAFETY SHOES** when operating heavy machinery. **Always wear safety glasses.**
- ❑ **DO NOT** wear loose clothing or jewellery when operating machinery.
- ❑ **A Safe Environment is important.** Keep the area free of dust, dirt and other debris in the immediate vicinity of the machine.
- ❑ **BE ALERT!** Do Not Use prescription or other drugs that may affect your ability or judgement to safely use this machine.
- ❑ **DISCONNECT** the power source when changing tool bits and or any equipment.
- ❑ **NEVER** leave an operating tool unattended.
- ❑ **ALWAYS** keep blades, knives or bits sharp and properly aligned.
- ❑ **ALWAYS** keep all safety guards in place and ensure their proper function.
- ❑ **ALWAYS** make sure that any tools used for adjustments are removed before operating the machine.
- ❑ **ALWAYS** secure your work with the appropriate clamps or vises.
- ❑ **ALWAYS** keep bystanders safely away while operating machinery.
- ❑ **THINK SAFETY. WORK SAFELY.** Never attempt a procedure if it does not feel safe or comfortable.

CT089 - 13" x 24" METAL LATHE

As part of the growing line of Craftex metalworking equipment, we are proud to offer the CT089 Metal Lathe. The Craftex name guarantees Craft Excellence. By following the instructions and procedures laid out in this owner's manual, you will receive years of excellent service and satisfaction. The CT089 is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

Features and Specifications

Max. Swing Over Bed	320 mm/12.6"
Max. Length of work piece	600 mm/23.62"
Max.Swing Diameter over tool post	210 mm/8.27"
Spindle Bore	1.5"
Spindle Taper	MT #5
Max.Lateral Stroke over tool post	160 mm/6.3"
Max.Longitudinal Stroke over tool post	100 mm/3.94"
Number of Metric Threads	17 (0.5 ~ 4mm/0.002" ~ 0.16")
Number of Inch Threads	20 (9 ~ 40 1/N")
Longitudinal-Feed on spindle tool post	0.135 ~ 1.80mm/r (0.01" ~ 0.07")
Max.Stroke of tail stock sleeve	70 mm/ 2.76"
Tail Stock sleeve taper	MT #3
Spindle Speeds	12 Speeds (60 ~ 1600r/min)
Motor	1 HP, 110v, 60HZ
Net Weight	180 kg/ 400 lbs.
Full Size	131cm x 67.2cm x 44.8cm (51.5" x 26.5" x 17.64")
Outer Packing Size	137 cm x 70 cm x 66cm (51.5" x 27.5" x 26")

Standard Accessories

- Steady Rest
- Follow Rest
- Face Plate
- 3 Jaw Chuck
- 4 Jaw Chuck
- Stand
- Splash Guard

CT089 - 13" x 24" METAL LATHE

Illustrated Features

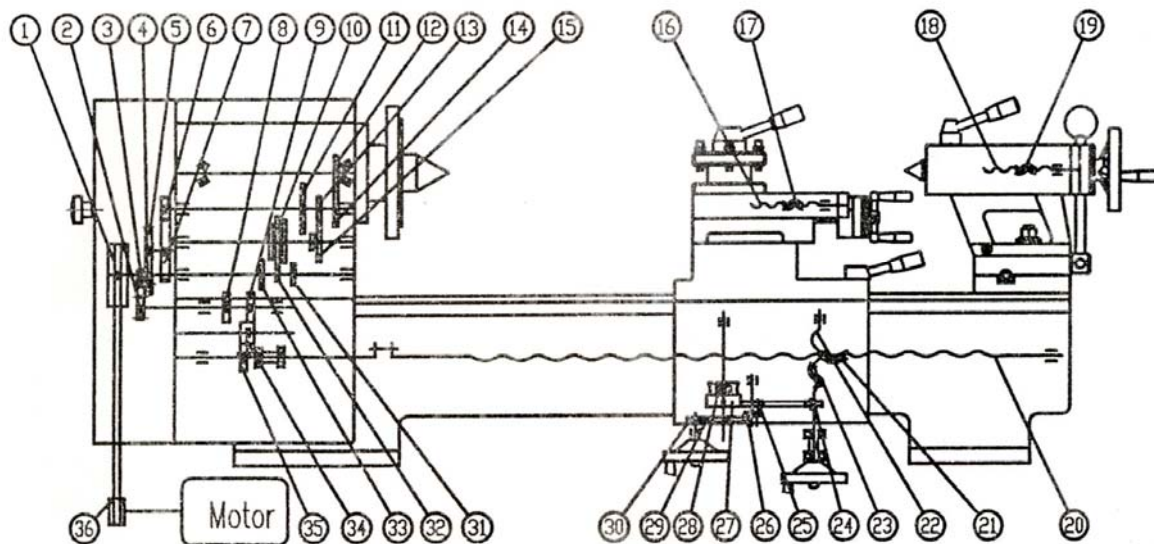


Fig 1. Driving system drawing

- | | |
|---------------------------|----------------------|
| 1) Input Pulley | 21) Longitudinal Nut |
| 2) Gear Change | 22) Cross LeadScrew |
| 3) Gear Change | 23) Cross Nut |
| 4) Gear Change | 24) Gear |
| 5) Gear Change | 25) Gear |
| 6) Gear | 26) Gear |
| 7) Gear | 27) Worm Gear |
| 8) Gear | 28) Worm |
| 9) Gear | 29) Gear |
| 10) Triplicate Gear | 30) Gear |
| 11) Gear | 31) Gear |
| 12) Spindle Gear | 32) Gear |
| 13) Gear | 33) Gear |
| 14) Gear | 34) Gear Slip |
| 15) Duplicate Gear | 35) Slip Gear |
| 16) Tool Post Lead Screw | 36) Motor Pulley |
| 17) Tool Post Nut | |
| 18) Tail Stock Lead Screw | |
| 19) Tail Stock Nut | |
| 20) Longitudinal Screw | |

CT089 - 13" x 24" METAL LATHE

Lifting & Installation

It is recommended that this machine is lifted by the use of a crane or hoisting mechanism as it is very heavy.

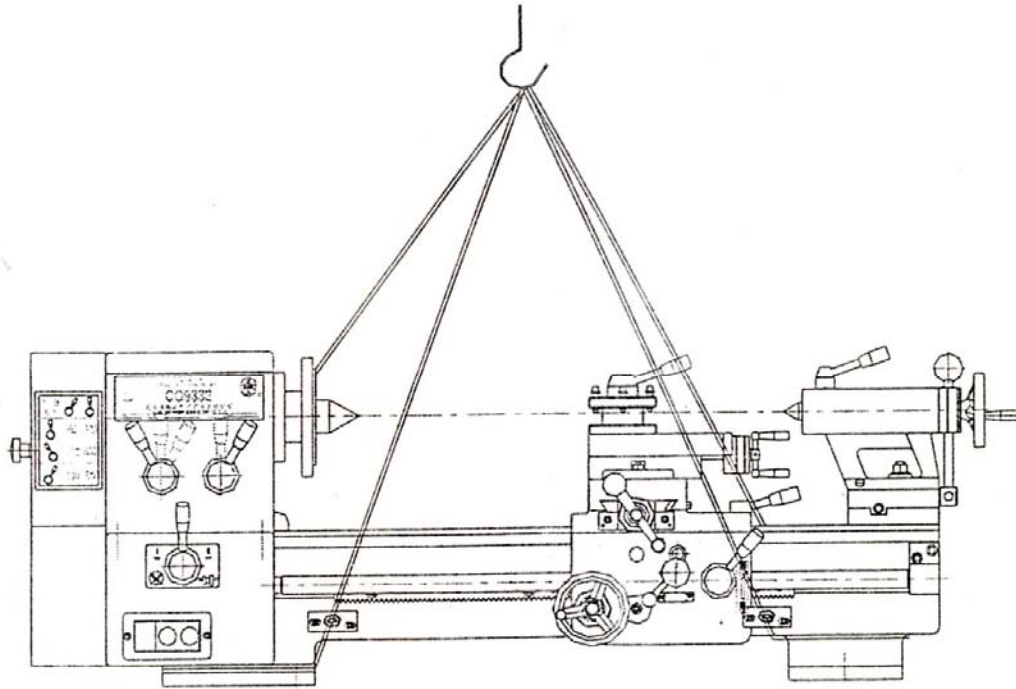


Fig 2.Lifting drawing

CT089 - 13" x 24" METAL LATHE

Lifting & Installation cont...

Please refer to figure 3 when installing this machine. As this lathe is for the most part pre-assembled at the factory, there is not a great deal of assembly for the end user.

Line up the four bolt holes with the stand and carefully place the lathe on the stand.

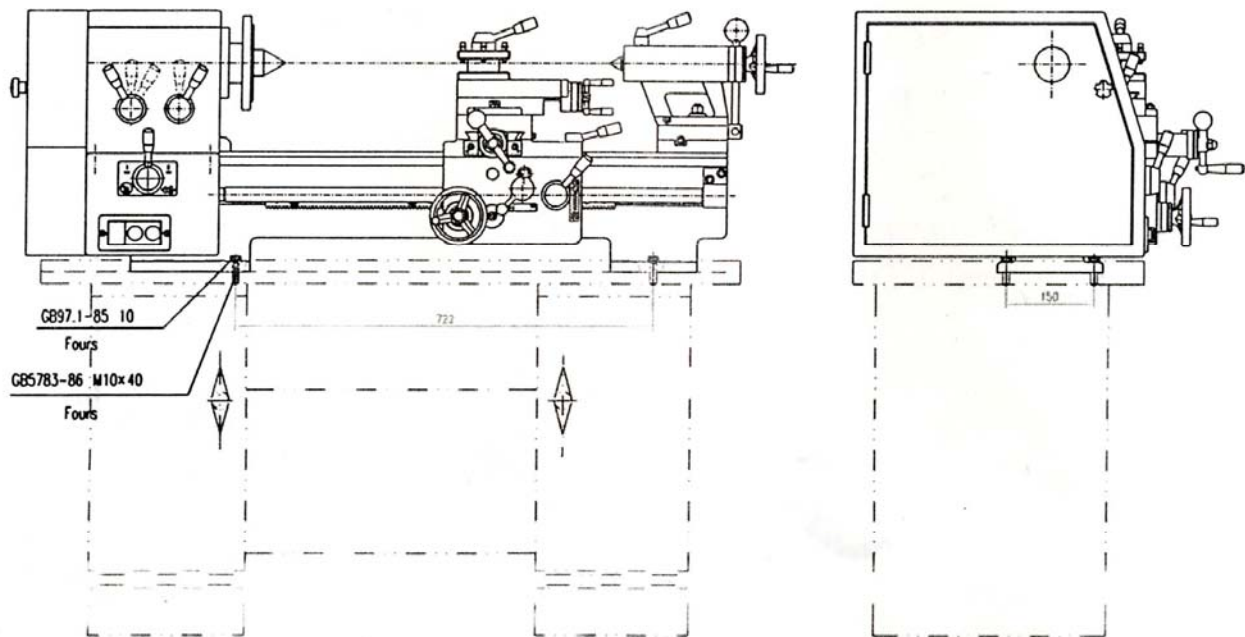


Fig 3. Installation drawing

After installation, be sure to clean the antiseptic coat (used to preserve and protect during shipping) off the guide carriage, tail stock, change gear and pulley with a clean cloth and non-corrosive cleaner.

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Lubrication Positions

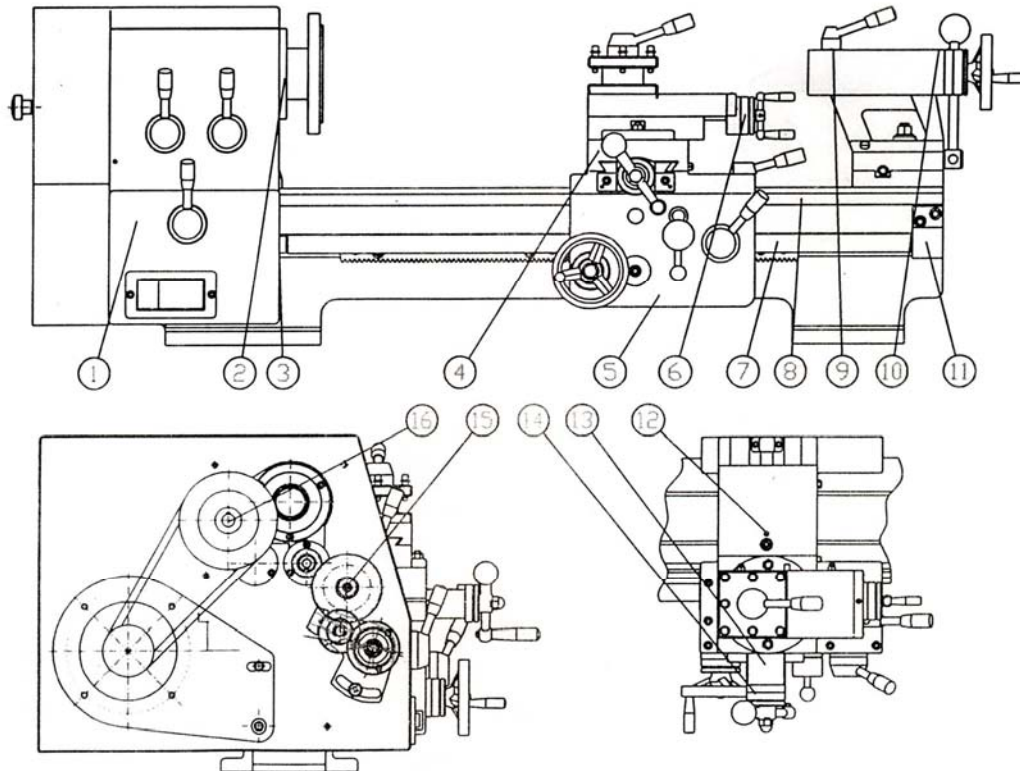


Fig 4. Lubrication positions drawing.

Please refer to the Lubrication chart on the following page in order to properly lubricate and maintain your Lathe. Proper lubrication of any tools, especially Metal Lathes should not be ignored.

CT089 – 13” x 24” METAL LATHE

Lubrication Positions Cont.

Attached List 1: Lubrication Positions Li

Item No.	Lubrication Position	Located part	Lubrication Methods	Lubrication Oil	Lubrication Period
1	Gears, bush bearing	Left trestle	Gun oiling	Machine oil	One year
2	Spindle bearing	Lathe head	Greasing	Grease	1 / year
3	Thrust ball bearing	Left trestle	Greasing	Grease	1 / year
4	Slide way, lead screw, guide surface	Apron parts	gun oiling	Machine oil	2 / days
5	Gears, racks	Apron parts	Greasing	Grease	one month
6	Tool post lead screw, guide surface	Tool carriage	gun oiling	Machine oil	2 /days
7	Longitudinal lead screw	lead screw	gun oiling	Machine oil	2 / days
8	Lathe bed guide	Lathe bed	gun oiling	Machine oil	2 / days
9	Tail stock sleeve	Tailstock	gun oiling	Machine oil	2 / days
10	Tailstock leads crew bush bearing	Tailstock	gun oiling	Machine oil	2 / days
11	Bearing pedestal	Lathe bed	gun oiling	Machine oil	2 / days
12	Cross nut 、 lead screw	Small carriage	gun oiling	Machine oil	2 / days
13	Bearing bush	Small carriage	gun oiling	Machine oil	2 / days
14	Thrust bearing	Lead screw pedestal	Greasing	Grease	6 /s year
15	Change gear shaft	Compound box	gun oiling	Machine oil	2 /s year
16	Bearing	Input pulley	Greasing	Grease	6 /s year

- Notes :
- 1、Recommend to use 3#Ca grease
 - 2、Recommend to use 3#Ca grease 20# machine oil
 - 3、The parts lubricated by grease should be cleaned and the machine oil in feed box be changed and renewed up to the center line of the oil indicator regularly

★ Electrical System

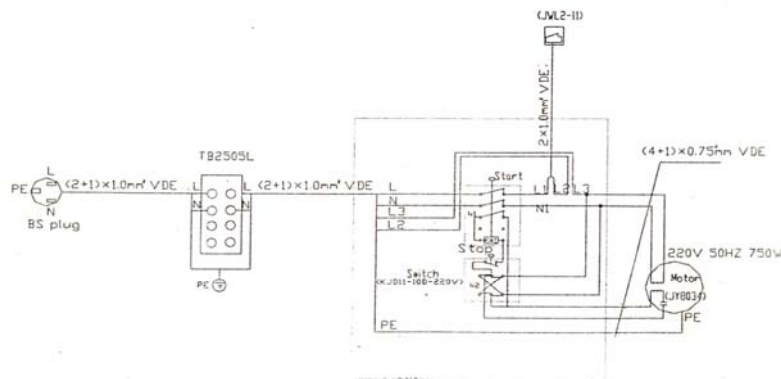


Fig 5. Electrical System Drawing

CT089 - 13" x 24" METAL LATHE

Operating Controls

Refer to the diagram below for the CT089 operation controls.

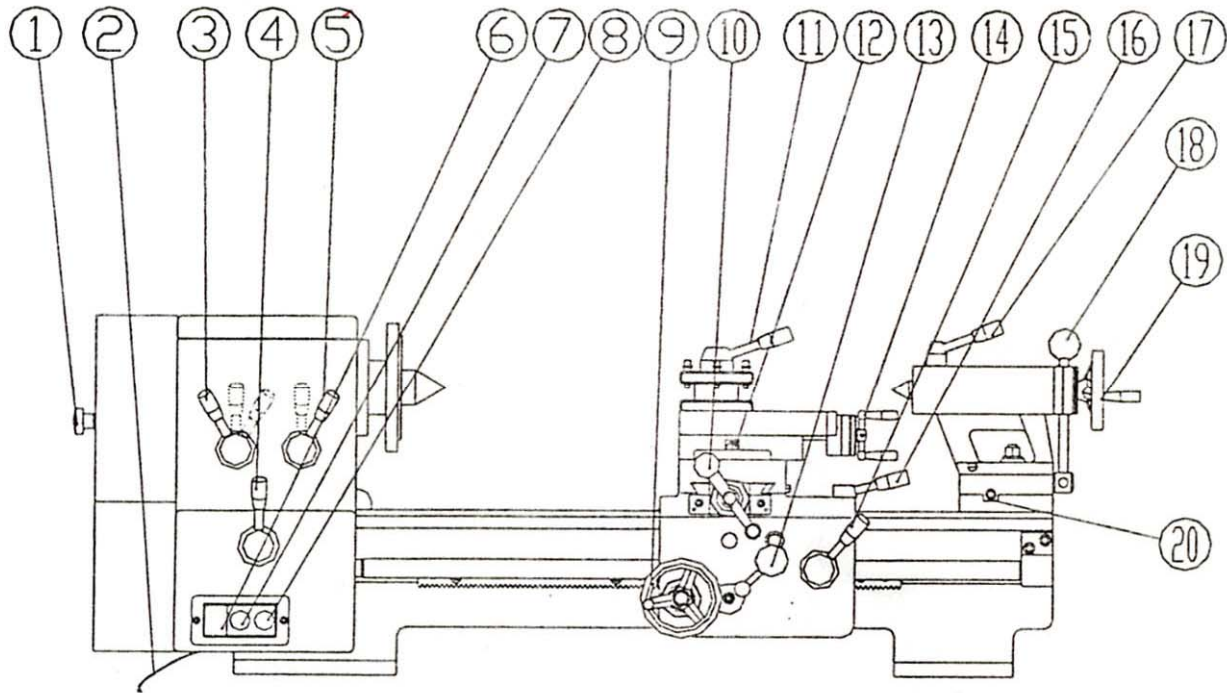


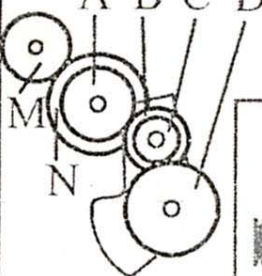




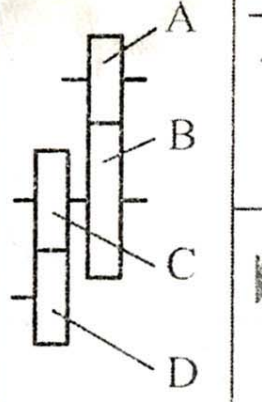





Fig 6. Operation Parts Fig.

1. Transmission Box Cover
2. Power source – plug
3. Shift Knob – Gear change
4. Forward/Reverse Switch for lead screw – Middle position is Neutral
5. Shift Knob – Gear change
6. Forward-Reverse Switch – controls direction of revolution – only to be changed when machine is stopped.
7. Start button
8. Stop button
9. Longitudinal-Feed Handle
10. Small Carriage Cross Feed hand wheel
11. Tool Post feed hand wheel
12. Tool Post Swivel Nut
13. Tool Carriage hand wheel
14. Carriage Auto-Feed Switch
15. Auto Feed for Tool Post – In, Out, Neutral
16. Handle Lock for tailstock center
17. Lever to lock Tailstock
18. Tailstock hand wheel
19. Tailstock hand wheel
20. Offset Screw

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Threading Chart

Please see the following diagram for reference to cutting threads

		M=24 N=60	M=28 N=35	$\frac{A}{B} \times \frac{C}{D}$	 M=24 N=60	 M=28 N=35	 M=24 N=60	 M=28 N=35
		18	9	$\frac{24}{50} \times \frac{25}{48}$	0.135	0.270	0.025	0.050
		20	10	$\frac{32}{28} \times \frac{35}{34}$	0.635	1.270	0.120	0.240
		22	11	$\frac{30}{27} \times \frac{40}{42}$	0.571	1.142	0.108	0.216
		24	12	$\frac{32}{30} \times \frac{36}{40}$	0.518	1.036	0.098	0.196
		26	13	$\frac{30}{34} \times \frac{32}{32}$	0.476	0.952	0.090	0.180
		28	14	$\frac{32}{35} \times \frac{32}{36}$	0.438	0.876	0.083	0.166
		30	15	$\frac{30}{37} \times \frac{34}{50}$	0.406	0.812	0.077	0.154
		32	16	$\frac{35}{32} \times \frac{27}{42}$	0.379	0.758	0.072	0.144
		36	18	$\frac{35}{34} \times \frac{27}{42}$	0.357	0.714	0.068	0.136
		40	20	$\frac{30}{34} \times \frac{28}{42}$	0.317	0.634	0.060	0.120
		0.5	1	$\frac{30}{32} \times \frac{27}{48}$	0.285	0.570	0.054	0.108
		0.6		$\frac{28}{35} \times \frac{25}{48}$	0.225	0.450	0.043	0.086
		0.7		$\frac{24}{36} \times \frac{30}{40}$	0.270	0.540	0.051	0.102
		0.75	1.5	$\frac{28}{36} \times \frac{30}{40}$	0.315	0.630	0.060	0.120
		0.8		$\frac{25}{40} \times \frac{32}{32}$	0.337	0.674	0.064	0.128
		1	2	$\frac{28}{35} \times \frac{32}{42}$	0.360	0.720	0.068	0.136
		1.25	2.5	$\frac{30}{32} \times \frac{32}{36}$	0.450	0.900	0.085	0.170
		1.5	3	$\frac{30}{32} \times \frac{40}{36}$	0.562	1.124	0.106	0.212
		1.75	3.5	$\frac{30}{36} \times \frac{42}{28}$	0.674	1.348	0.128	0.256
		2	4	$\frac{35}{30} \times \frac{40}{32}$	0.787	1.574	0.149	0.298
		2	4	$\frac{35}{30} \times \frac{40}{28}$	0.900	1.800	0.170	0.340

CT089 - 13" x 24" METAL LATHE

Threading

Cutting threads can be performed by the manual use of the change gears and handle 3 & 5 (refer to Operating Controls)

Grounding Instructions

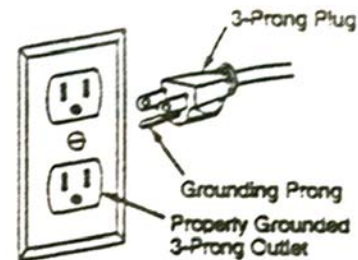
In the event of a malfunction or breakdown, grounding provides the path of least resistance for electrical current and reduces the risk of electrical shock. This tool is equipped with an electrical cord that has an equipment grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching outlet that has been properly installed and grounded in accordance with **ALL** local codes and ordinances.

DO NOT MODIFY THE PLUG PROVIDED. If the provided plug will not fit the electrical outlet, have the proper outlet installed by a qualified licensed electrician.

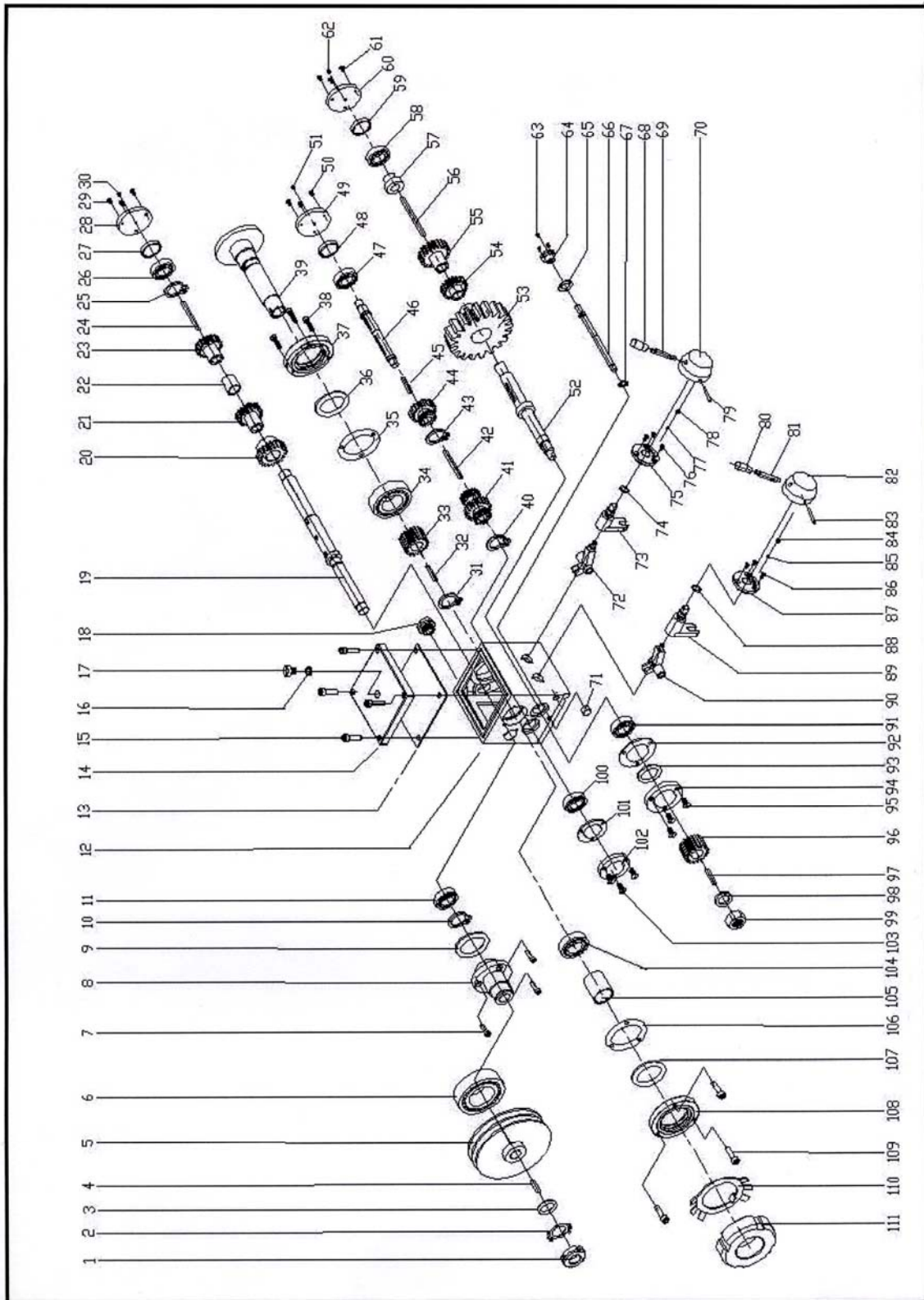
IMPROPER CONNECTION of the equipment grounding conductor can result in risk of electrical shock. The conductor wire with the green insulation (with or without yellow stripes) is the equipment-grounding conductor. If repair or replacement of the electrical cord or plug is required, **DO NOT** connect the equipment grounding conductor to a live terminal.

If in doubt about these instructions consult a qualified, licensed electrician.

USE ONLY A THREE-WIRE EXTENSION CORD with a 3-prong grounding plug and three-hole receptacles that accept the tool's plugs as shown.



Parts Diagram – Lathe Head



Parts Listing – Lathe Head

No.	DESCRIPTION		
	CT089		Lathe head
1		M16×1.5 GB812-88	Spanner nut
2		16 GB858-88	Lock washer for circular nut
3		16 GB97.2-85	Plain washrs
4		5×16 GB1096-79	Plain paralle key
5		CQ9332A-02-016	Spindle pulley
6		60206 GB298-89	Taper roller oearing
7		M5×12 GB70-85	Hexagon socket head screw
8		CQ9332-02-017	Pulley seat
9		16 JB/GQ0324-89	Felt collar
10		16 GB894.1-86	Circlips for shaft-type A
11		203 GB276-89	Single-row ball bearing
12		CQ9332-02-001	Lathe head
13		CQ9332-02-002	Pressurize washer
14		CQ9332-02-003	Transmission cover
15		M8×30 GB70-85	Hexagon socket head screw
16		30×20×2 AT300-04-141	Rubber ring
17		M20×1.5 Q/ZB220-77	Oil port plug
18		M16×1.5 GB1160.2-89	Oil level indicator
19		CQ9332-02-024	Spindle shaft
20		CQ9332-02-019	Gear
21		CQ9332-02-021	Gear
22		CQ9332-02-047	Sleeve spacer
23		CQ9332-02-022	Gear
24		5×70 GB1096-79	Plain paralle key
25		18 GB894.1-86	Circlips for shaft-type A
26		203 GB276-89	Single-row ball bearing
27		CQ9332-02-046	Bearing sleeve
28		CQ9332-02-026	Right sleeve
29		M5×12 GB819-85	Screw
30		M6×8 GB78-85	Screw
31		55 GB894.1-86	External snap ring
32		12×18 GB1567-79	Thin flat key
33		CQ9332-02-007	Gear
34		D2007112 GB297-84	Taper roller oearing
35		CQ9332-02-006	Pressurize washer
36		68 JB/GQ0324-89	Felt collar
37		AT400-04-123	Mainshaft bearing oil seal
38		M5×20 GB70-85	Hexagon socket head screw
39		CQ9332-02-004	Lathe spindle

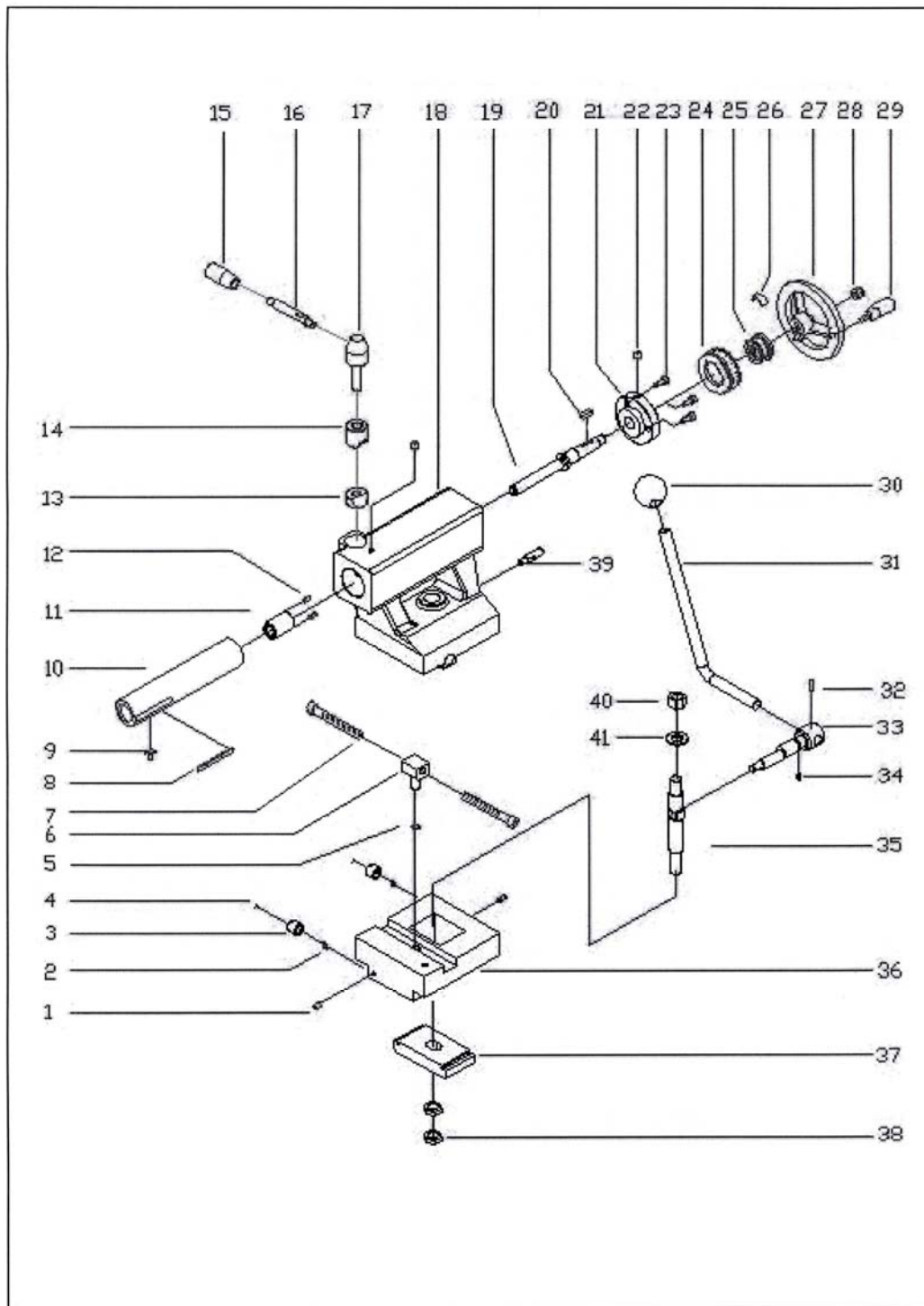
Parts Listing – Lathe Head Cont...

40		20 GB894.1-86	External snap ring
41		CQ9332-02-023	Gear
No.	DESCRIPTION		
	CT089		Lathe head
42		5×60 GB1096-79	Plain paralle key
43		20 GB894.1-86	External snap ring
44		CQ9332-02-025	Gear
45		5×40 GB1096-79	Plain paralle key
46		CQ9332-02-028	Middle shaft
47		203 GB276-89	Single-row ball bearing
48		CQ9332-02-046	Bearing sleeve
49		CQ9332-02-026	Right sleeve
50		M5×12 GB819-85	Screw
51		M6×8 GB78-85	Screw
52		CQ9332-02-011	Output shaft
53		CQ9332-02-010	Gear
54		CQ9332-02-009	Gear
55		CQ9332-02-008	Gear
56		5×60 GB1096-79	Plain paralle key
57		CQ9332-02-030	Sleeve spacer
58		203 GB276-89	Single-row ball bearing
59		CQ9332-02-046	Bearing sleeve
60		CQ9332-02-026	Right sleeve
61		M5×12 GB819-85	Screw
62		M6×8 GB78-85	Screw
63		M5×12 GB819-85	Screw
64		CQ9332-02-039	Sprue
65		CQ9332-02-040	Pressurize washer
66		CQ9332-02-037	Shifting fork shaft
67		12 GB894.1-86	External snap ring
68		BM8×40 GB4141.14-84	Knob
69		BM8×63 GB4141.15-84	Handle lever
70		12×50 GB4141.19-84	Handle seat
71		CQ9332-02-038	Spigots
72		CQ9332-02-033	Right shifting fork
73		CQ9332-02-034	Right shifting fork shaft
74		16×2.4 GB1235-76	O- seal ring
75		AT400-04-127	Localing sleeve
76		M5×12 GB819-85	Screw
77		6.5 GB308-84	Steel ball
78		0.8×5×25 GB2089-80	Spring

Parts Listing – Lathe Head Cont...

79	5x50 GB117-86	Pin
80	BM8x40 GB4141.14-84	Knob
81	BM8x63 GB4141.15-84	Handle lever
82	12x50 GB4141.19-84	Handle seat
No.	DESCRIPTION	
	CT089	Lathe head
83	5x50 GB117-86	Pin
84	0.8x5x25 GB2089-80	Spring
85	6.5 GB308-84	Steel ball
86	M5x12 GB819-85	Screw
87	AT400-04-127	Localing sleeve
88	16x2.4 GB1235-76	O- seal ring
89	CQ9332-02-035	Left shifting fork shaft
90	CQ9332-02-036	Left shifting fork
91	203 GB276-89	Single-row ball bearing
92	CQ9332-02-015	Pressurize washer
93	16 JB/GQ0324-89	Felt collar
94	CQ9332-02-014	Left sleeve
95	M5x12 GB819-85	Screw
96	CQ9332-02-013	Gear
97	4x10 GB1096-79	Plain paralle key
98	10 GB93-87	Spring washer
99	M10 GB6170-86	Hexagon nut
100	203 GB276-89	Single-row ball bearing
101	CQ9332-02-015	Pressurize washer
102	CQ9332-02-048	Sleeve
103	M5x12 GB819-85	Screw
104	2007110 GB297-84	Taper roller bearing
105	CQ9332-02-044	Spring washer
106	CQ9332-02-043	Pressurize washer
107	50 JB/GQ0324-89	Felt collar
108	AT400-04-118	End cap
109	M5x320 GB70-85	Hexagon socket head screw
110	50 GB858-88	Lock washer for circular nut
111	M50 GB812-88	Spanner nut

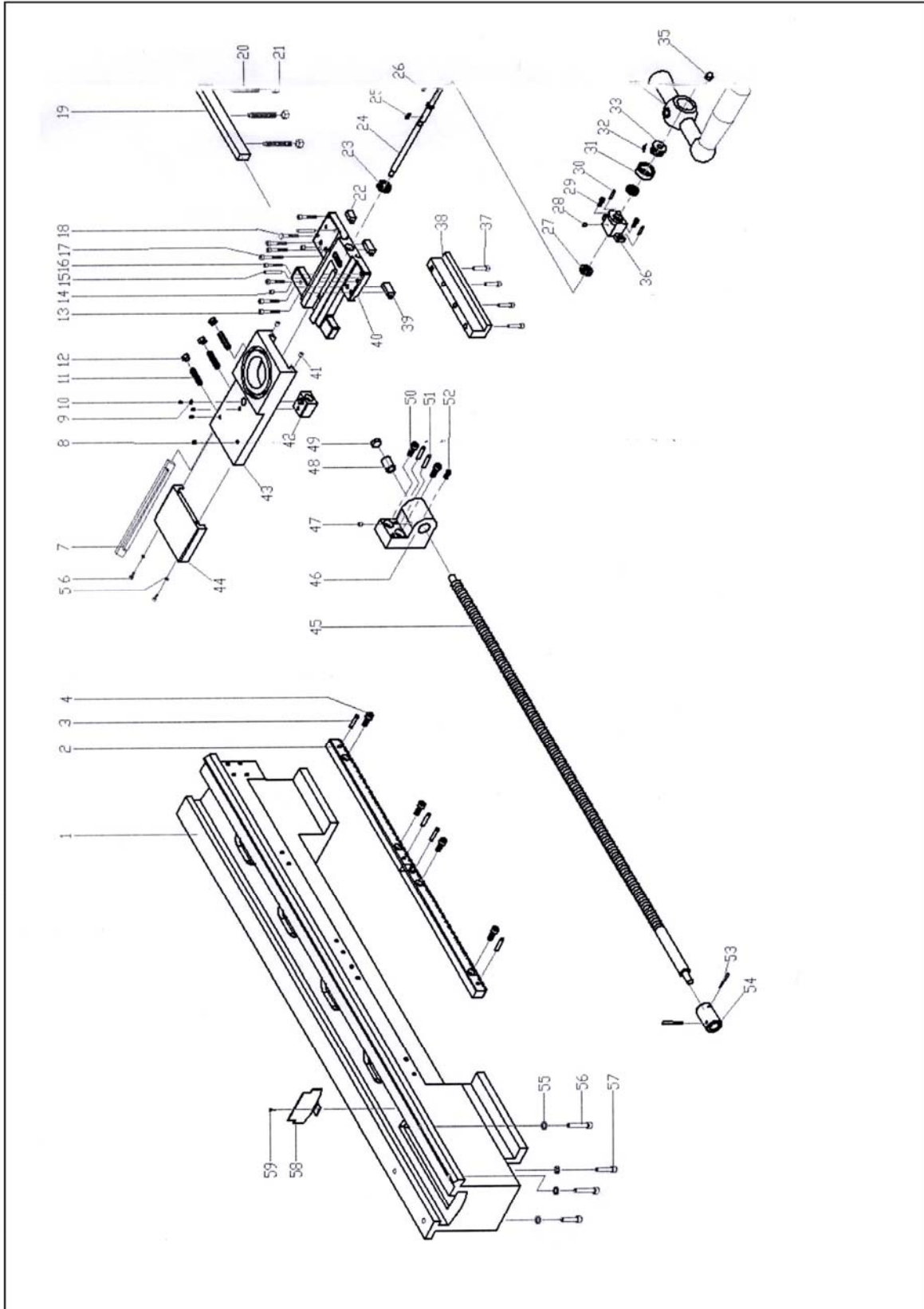
Parts Diagram - Tailstock



Parts Listing - Tailstock

No.	DESCRIPTION	
	CT089	Tailstock
1	M5×8 GB71-85	Set screws with cone point
2	GB2089-80 1.4×7×30	Spring
3	CQ9332-03-008	Oil port plug
4	GB308-77	Steel ball
5	GB894.1-86 12	Circlips for shaft
6	CQ9332-03-009	Tailstock nuts
7	M8×40 GB70-85	Hexagon socket head screw
8	AT400-02-108	Graduated label
9	AT300-02-114	T-key
10	CQ9332-03-003	Tailstock center sleeve
11	AT400-02-120	Tailstock nuts
12	M5×10 GB71-85	Set screws with cone point
13	AT400-02-107	Locking nuts
14	AT400-02-110	Locking sleeve
15	BM8×40GB4141.14-84	Long sleeve knob
16	BM8×40 GB4141.15-84	Handle lever
17	AT280-2-001	Handle seat
18	CQ9332-03-001	Tailstock
19	AT400-02-113	Tailstock screw stem
20	4×28 GB1096-79	Plain parallel key
21	CQ9332-03-011	Sleeve
22	6 GB1155-79	Oil cup
23	M5×12 GB70-85	Hexagon socket head screw
24	AT400-02-114	Dial
25	AT300-03-138	Sleeve
26	AT300-03-139	Spring lamination
27	BM12×125 GB4141.22-84	Hand wheel
28	M10 GB923-88	Domed cap nuts
29	M6×50 GB4141.5-84	Handles with sleeve
30	M10×32 GB4141.11-84	Handle ball
31	CQ9332-03-007	Handle lever
32	5×26 GB117-86	Taper pins
33	CQ9332-03-010	Shaft
34	M5×12 GB75-85	Slotted set screws with long dog point
35	CQ9332-03-006	Pull pole set
36	CQ9332-03-002	Tailstock carriage
37	CQ9332-03-004	Chock
38	M12×1.5 GB6172-86	Hexagon thin nuts
39	CQ9332-03-012	Pin
40	M12 GB6170-86	Hexagon thin nuts
41	12 GB97.2-85	Plain washers

Parts Diagram – Lathe Bed



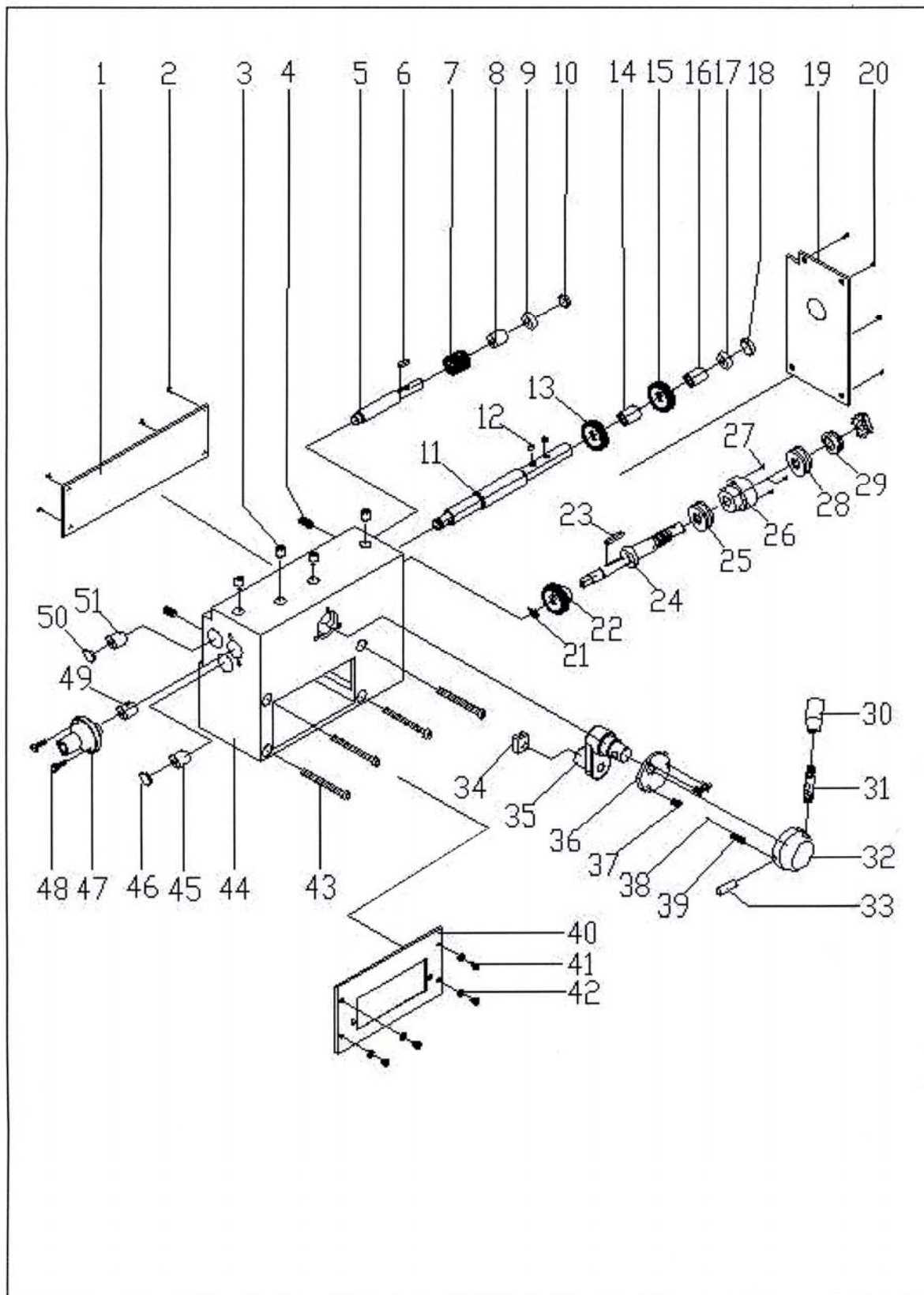
Parts Listing – Lathe Bed

No.	DESCRIPTION		
	CT089		Bed
1		CQ9332-01-001	Bed
2		CQ9332-01-003	Racks
3		6×18 GB117-86	Taper pin
4		M8×16 GB70-85	Hexagon socket cap head screws
5		5 GB97.2-85	Washer
6		M5×10 GB65-85	Screw
7		CQ9332-01-005	Chock
8		6 GB1155-79	Oil cup
9		CQ9332-05-015	Washer
10		M5×12 GB68-85	Screw
11		M6×25 GB75-85	Screw
12		M6 GB6170-86	Hexagon nuts
13		M6×35 GB70-85	Hexagon socket cap head screws
14		8 GB1155-79	Oil cup
15		6×40 GB117-86	Taper pin
16		M6×30 GB70-85	Hexagon socket cap head screws
17		M6×45 GB70-85	Hexagon socket cap head screws
18		M6×40 GB5782-86	Hexagon head bolts
19		CQ9332-01-008	Chock
20		M8×20 GB79-85	Hexagon socket set screws with dog point
21		M8 GB6170-86	Hexagon nuts
22		CQ9332-05-027	Chain up block
23		CQ9332-05-006	Gear
24		CQ9332-05-004	Cross feed screw rod
25		5×16 GB096-79	Plain parralleled key
26		4×18 GB096-79	Plain parralleled key
27		8201 GB301-84	Rolling bearing
28		6 GB1155-79	Oil cup
29		M6×16 GB70-85	Hexagon socket cap head screws
30		5×20 GB117-86	Taper pin
31		CQ9332-05-024	Dial
32		AT300-03-B9	Spring lamination
33		AT300-03-B8	Dial sleeve
34		12×40 GB4141.9-84	Handles with sleeve
35		M10 GB923-88	Nut
36		CQ9332-05-008	Cross feed screw seat
37		M8×40 GB70-85	Hexagon socket cap head screws
38		CQ9332-01-007	Behind board
39		CQ9332-5-005	Forward board
40		CQ9332-05-002	Carriage

Parts Listing – Lathe Bed Cont...

41	6 GB155-79	Oil cup
No.	DESCRIPTION	
	CT089	Bed
42	CQ9332-01-009	Cross nut
43	CQ9332-01-004	Middle carriage
44	CQ9332-00-006	Shield
45	CQ9332-01-002	Longitudinal feed screw
46	CQ9332-01-006	Right pedestal
47	6 GB155-79	Oil cup
48	CQ9332-01-010	Sleeve
49	CQ9332-02-011	Spigots
50	M8x25 GB70-85	Hexagon socket cap head screws
51	5x30 GB117-86	Taper pin
52	M5x8 GB71-85	Slotted set screws with cone point
53	4x25 GB117-86	Taper pin
54	AT520-03-014	Coupling sleeve
55	10 GB93-87	Washer
56	M10x40 GB70-85	Hexagon socket cap head screws
57	M10x35 GB70-85	Hexagon socket cap head screws
58	CQ9332-00-016	Shield
59	M5x10 GB70-85	Hexagon socket cap head screws

Parts Diagram – Lathe Trestle



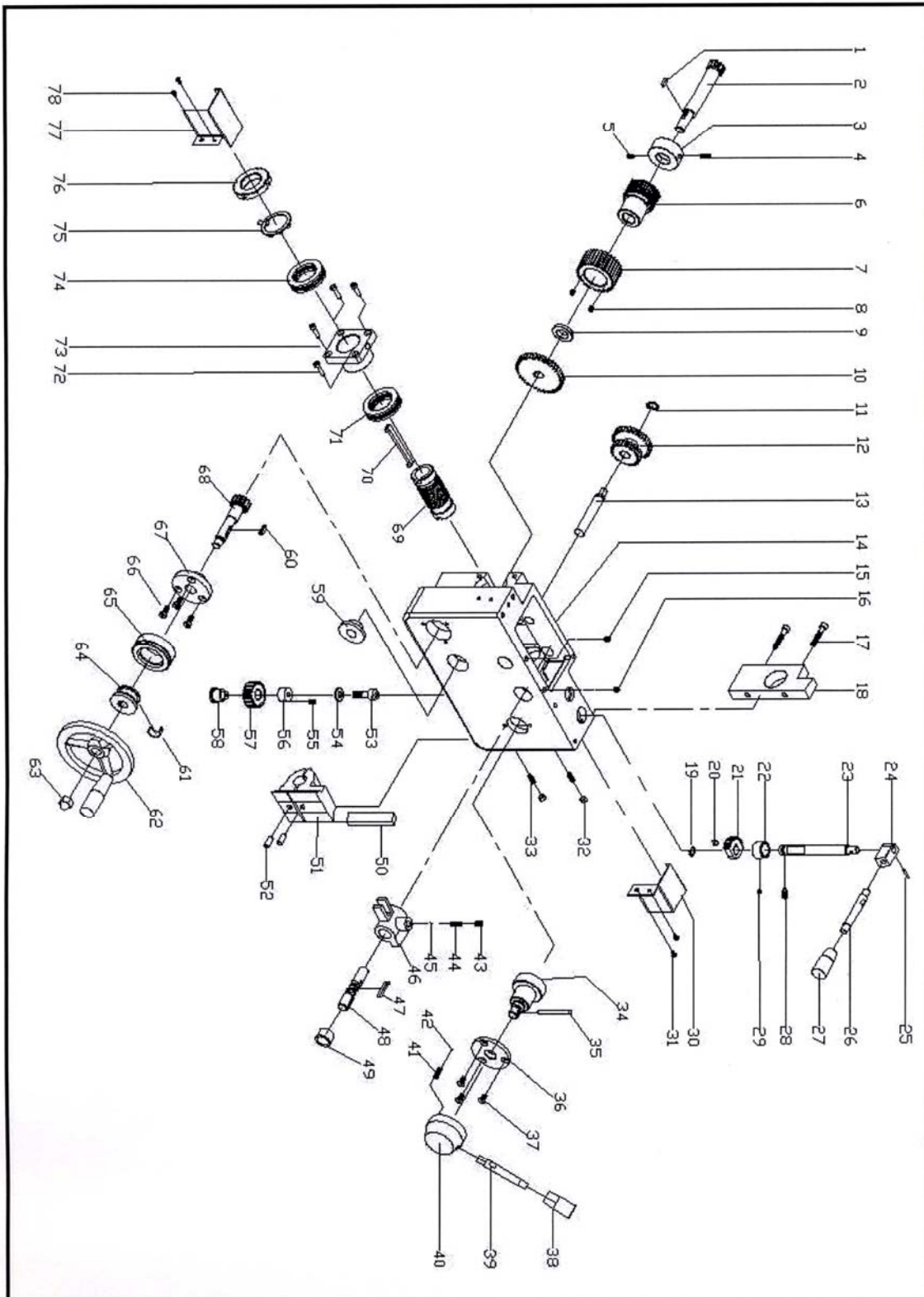
Parts Listing – Lathe Trestle

No.	DESCRIPTION	
	CT089	Left trestle
1	CQ9332-04-002	Transmission cover
2	M5×8 GB68-85	Screws
3	8 GB1155-79	Oil cup
4	M5×6 GB71-85	Set screws with cone point
5	CQ9332-04-004	Shaft
6	5×16 GB1096-79	Plain paralle key
7	CQ9332-04-005	Gear
8	CQ9332-04-007	Sieve spacer
9	CQ9332-04-006	Sieves
10	CQ9332-04-012	Spigots
11	CQ9332-04-010	Shaft
12	5×8 GB1096-79	Plain paralle key
13	CQ9332-04-008	Gear
14	CQ9332-04-009	Sieve spacer
15	CQ9332-04-008	Gear
16	CQ9332-04-007	Sieve spacer
17	CQ9332-04-019	Sieves
18	CQ9332-04-012	Spigots
19	CQ9332-04-015	Transmission cover
20	M4×8 GB65-85	Screws
21	16 GB894.1-86	External snap ring
22	CQ9332-04-014	Gear
23	5×32 GB1096-79	Plain paralle key
24	CQ9332-04-013	Shaft
25	8102 GB301-64	Bearing
26	AT520-03-109	Bearing sleeve
27	M5×16 GB818-85	Screws
28	8102 GB301-64	Bearing
29	M14×1.5 GB812-88	Round nut
30	BM8×40 GB4141.14-84	Knob
31	BM8×40 GB4141.15-84	Handle lever
32	12×50 GB4141.19-84	Handle seat
33	5×50 GB117-86	Taper pin
34	AT520-03-117	Shifting yoke
35	CQ9332-04-003	Shifting fork plate
36	AT300-03-134	Locating plate
37	M5×10 GB68-85	Slotted countersunk-Head screws
38	6.5 GB308-84	Steel ball
39	0.8×5×25 GB2089-84	Spring
40	CQ9332-00-003	Switch board
41	M4×8 GB818-85	Cross recessed pan head screws

Parts Listing – Lathe Trestle Cont...

No.	DESCRIPTION		
	CT089		Left trestle
42		4 GB97.1-85	Washer
43		M8×100 GB70-85	Hexagon socket head screw
44		CQ9332-04-001	Left trestle
45		CQ9332-04-018	Sieves
46		CQ9332-04-012	Spigots
47		CQ9332-04-019	Sieves
48		CQ9332-04-011	Pedestal
49		M5×12 GB70-85	Hexagon socket head screw
50		CQ9332-04-012	Spigots
51		CQ9332-04-006	Sieves

Parts Diagram – Apron Parts



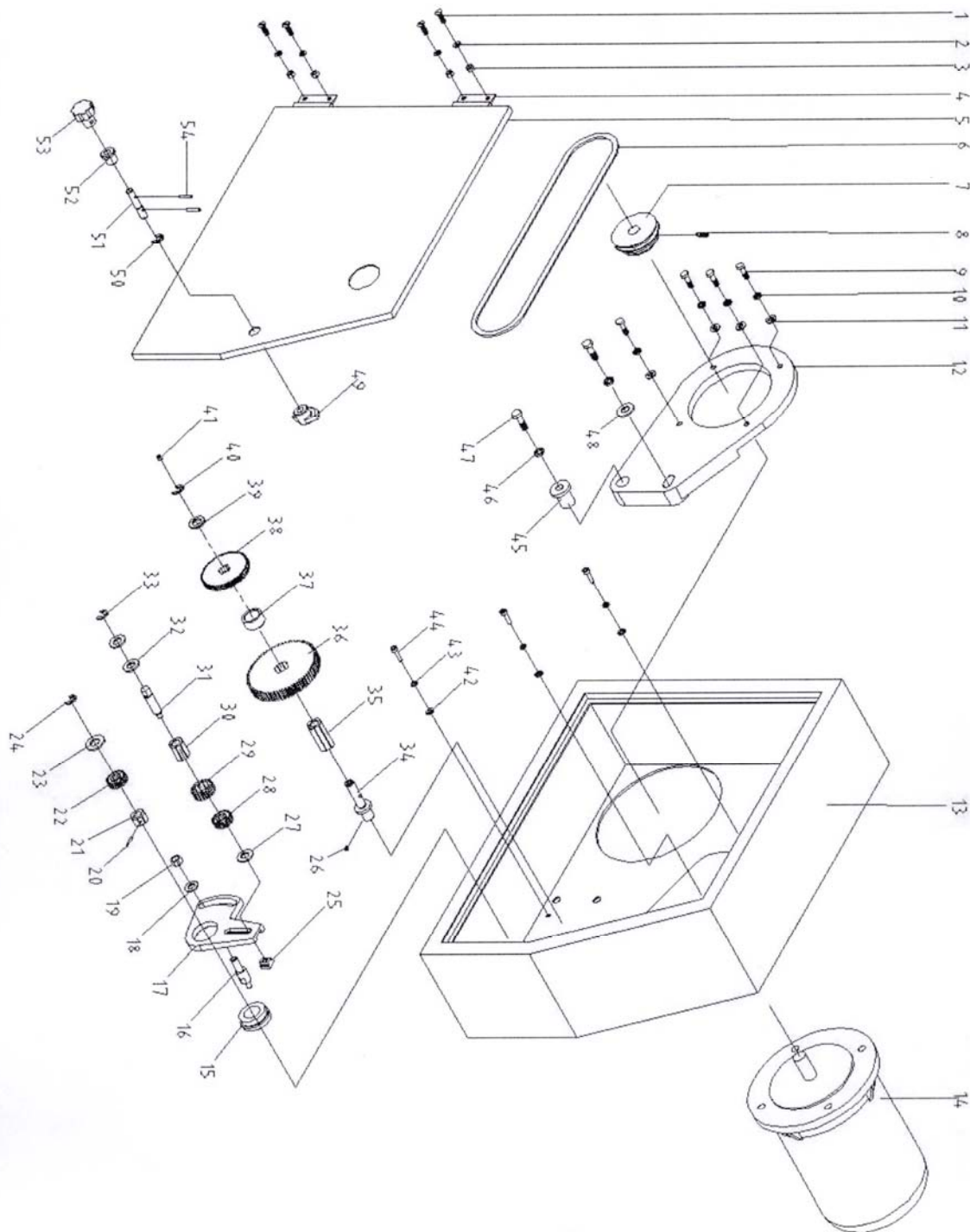
Parts Listing – Apron Parts

No.	DESCRIPTION	
	CT089	Apron parts
1	6x12 GB1096-79	Dlain parallel
2	AT400A-03-203	Gear shaft
3	AT400A-03-206	Sleeve
4	M6x12 GB75-85	Screws
5	M6x12 GB71-85	Set screws with cone point
6	AT400A-03-205	Worm gear
7	CQ9332-05-010	Gear
8	M5x8 GB71-85	Set screws with cone point
9	AT400A-03-207	Spring washer□
10	AT400A-03-241	Big gear
11	20 GB894.1-86	External snap ring
12	CQ9332-05-007	Slippage gear
13	CQ9332-05-009	Slippage shaft
14	CQ9332-05-001	Apron body
15	M5x16 GB71-85	Set screws with cone point
16	M6x20 GB71-85	Set screws with cone point
17	M5x35 GB70-85	Hexagon socket head screw
18	CQ9332-05-025	Apron body right cover
19	12 GB894.1-86	External snap ring
20	4x8 GB1096-79	Dlain parallel
21	CQ9332-05-029	Gear
22	CQ9332-05-014	Sleeve
23	CQ9332-05-013	Axis
24	AT520A-03-213	Square handle seat
25	3x20 GB117-86	Taper pins
26	BM8x50 GB4141.15-84	Handle lever
27	BM8x40 GB4141.14-84	Handle sleeve B-plastic
28	M5x16 GB75-85	Screws
29	M5x8 GB71-85	Set screws with cone point
30	CQ9332-00-106	Right rod baseboard
31	M5x8 GB71-85	Screws
32	M5 GB6170-86	Hexagon nut
33	M5x25 GB75-85	Screws
34	AT400A-03-212	Shaft
35	5x50 GB117-86	Taper pins
36	AT400A-03-221	Sleeve
37	M4x12 GB68-85	Screw
38	BM8x40 GB4141.14-84	Handle sleeve B-plastic
39	BM8x40 GB4141.15-84	Handle lever

Parts Listing – Apron Parts Cont...

40		12x50 GB4141.19-84	Handle seat
41		0.8x5 x25 GB2089-80	Spring
No.	DESCRIPTION		
	CT089		Apron parts
42		6.5 GB308-84	Steel ball
43		M6x8 GB73-85	Flat-point set screw
44		0.6x5 x15 GB2089-80	Spring
45		5 GB308-84	Steel ball
46		AT400A-03-216	Shifting fork
47		5x40 GB1096-79	Drain parallel
48		CQ9332-05-020	Shifting fork shaft
49		CQ9332-05-021	Sleeve
50		AT400-03-127	Chock
51		AT400-03-125	Screw nut
52		6x18 GB119-86	Column pins
53		M6x25 GB70-85	Hexagon socket head screw
54		6 GB93-87	Spring washer
55		M4x8 GB71-85	Set screws with cone point
56		CQ9332-05-015	Sleeve
57		CQ9332-05-017	Middle gear
58		CQ9332-05-016	Shaft
59		AT400-03-132	Bearing sleeve
60		4x28 GB1096-79	Drain parallel
61		AT300-03-139	Spring lamination (Leaf spring)
62		B12x125GB4141.22-84	Hand wheel
63		M10 GB923-88	Domed cap nuts
64		AT300-03-138	Sleeve
65		CQ9332-05-012	Dial
66		M4x12 GB65-85	Screw
67		AT400A-03-227	Flange sleeve
68		CQ9332-05-011	Gear shaft
69		CQ9332-05-022	Worm shaft
70		4x28 JB/GQ0217-89	Get into drain parallel
71		8106 GB301-84	Thrust ball bearing
72		M5x16 GB70-85	Hexagon socket head screw
73		CQ9332-05-023	Worm shaft
74		8106 GB301-84	Thrust ball bearing
75		30 GB858-88	Lock washer
76		M30x1.5 GB812-88	Round nut
77		CQ9332-00-105	Left rod baseboard
78		M5x8 GB71-85	Screws

Parts Diagram – Compound Box



Parts Listing – Compound Box

No	DESCRIPTION	
	CT089	Compound box
1	M4×10 GB65-85	Slotted cheesehead screws
2	4 GB93-87	Spring washers
3	M4 GB6170-86	Hexagon nuts
4		Butt hinge
5	CQ9332-06-002	Door
6	710 GB1171-74	V-belt otype 710
7	CQ9332-00-002A	Motor pulley
8	M6×8 GB75-85	Screws
9	M8×25 GB5782-86	Hexagon head bolts
10	8 GB93-87	Spring washers
11	8 GB97.2-85	Washer
12	CQ9332-00-001	Motor mount plate
13	CQ9332-06-001	Compound box
14	JY8034(7500W)	220V Mount,50HZ
15	CQ9332-04-017	Sleeve
16	AT400-03-146	Stationary shaft
17	AT400-03-144	Change gear plate
18	10 GB97.2-85	Washer
19	M10 GB6170-86	Hexagon nut
20	3×18 GB119-86	Parallel key
21	AT400-03-141	Spline housing
22	CQ9332-00-015	Change gear
23	12 GB97.2-85	Washer
24	9 GB896-86	"E" rings
25	AT400-03-143	T-nut
26	M5×6 GB73-85	Flat-point screw
27	12 GB97.2-85	Washer
28	CQ9332-00-015	Change gear
29	CQ9332-00-015	Change gear
30	AT400-03-145	Spline housing
31	AT400-03-142	Small shaft
32	12 GB97.2-85	Washer
33	9 GB896-86	"E" rings
34	AT400-04-108	Small shaft
35	AT400-04-112	Spline housing
36	AT400A-04-109	Big gear wheel
37	AT400-04-110	Sieves
38	CQ9332-00-015	Change gear
39	12 GB97.2-85	Washer
40	9 GB896-86	"E" rings
41	6 GB1155-79	Oil cup

Parts Listing – Compound Box Cont...

No	DESCRIPTION	
	CT089	Compound box
42	6 GB97.2-85	Washer
43	6 GB93-87	Spring washers
44	M6×16 GB70-85	Hexagon socket head screw
45	CQ9332-00-007	Sieves
46	10 GB93-87	Spring washers
47	M10×45 GB5782-86	Hexagon head bolts
48	10 GB96-85	Washer
49	AT300-05-108	Door-knob
50	6 GB896-86	"E" rings
51	AT300-05-110	Shaft
52	AT300-05-111	Stationary sleeve
53	8×32 GB4141.29-84	Star-grip knob
54	3×18 GB117-86	Taper pins



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.

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 repairs.

