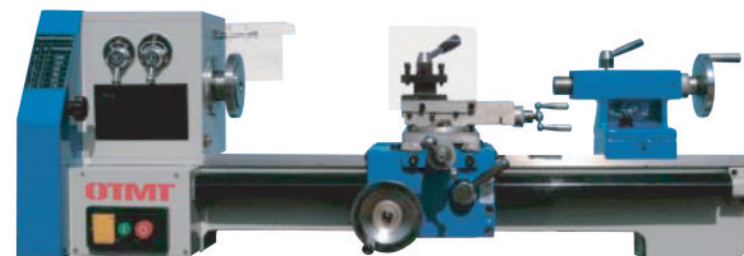


**OTMT**



# OTMT

**Before Operating Your Tools,  
Please Read These Instructions Carefully**



**BELT DRIVE LATHE**

ITEM NO. 87-115-949  
MODEL NO. OT252700

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## GENERAL SAFETY INSTRUCTIONS

EXTREME CAUTION SHOULD BE USED IN OPERATION 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.
- do not change speed while spindle is running .
- 3-jaw chucks or 4-jaw chucks max. speed 2500r/min
- think safely. work safely. never attempt a procedure if it does not feel safe or comfortable.

As part of the growing line of metalworking equipment, we are proud to offer the BL330 Metal Lathe. The 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 BL330 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	330mm
Max. Length of work piece	550mm/750 mm
Max. Swing diameter over tool post	220mm
Spindle Bore	38mm
Spindle Taper	MT.5#
Max Lateral Stroke over tool post	140mm
Metric Thread kinds on processing	17
Max Longitudinal stroke over tool post	100mm
Inch Thread kinds on processing	24
Metric thread pitch on processing	0.5-4 mm
Inch thread pitch on processing	9-40 1/n"
Longitudinal feed on spindle tool post	0.1-1.396mm/r
Max. stroke of tail stock sleeve	70mm
Spindle speeds available	12
Spindle speeds range	60-1650mm/r
Electromotor	As customer's requirement
Net weight	260kgs / 320kgs 280kgs / 350kgs
Full size	123cm*67cm*55cm 145 cm*67cm*62cm
Outer packing size	133cm*77cm*65cm 155cm*77cm*72cm

## Illustrated Features

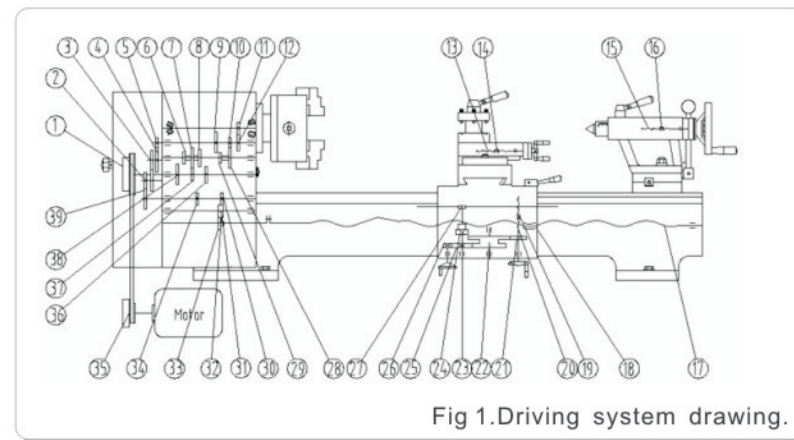


Fig 1. Driving system drawing.

- |                  |                           |                  |
|------------------|---------------------------|------------------|
| 1. Input Pulley  | 14. Tool Post Nut         | 27. Gear         |
| 2. Gear Change   | 15. Tail Stock Lead Screw | 28. Gear         |
| 3. Gear Change   | 16. Tool Post Nut         | 29. Gear         |
| 4. Gear Change   | 17. Longitudinal Screw    | 30. Gear         |
| 5. Gear Change   | 18. Longitudinal Nut      | 31. Gear         |
| 6. Gear          | 19. Cross Nut             | 32. Gear         |
| 7. Gear          | 20. Cross Lead Screw      | 33. Gear         |
| 8. Gear          | 21. Gear                  | 34. Gear         |
| 9. Gear          | 22. Gear                  | 35. Motor Pulley |
| 10. Gear         | 23. Gear                  | 36. Gear         |
| 11. Spindle Gear | 24. Worm Gear             | 37. Gear         |
| 12. Gear         | 25. Worm                  | 38. Gear         |
|                  |                           | 39. Gear         |

## Lifting & Installation

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

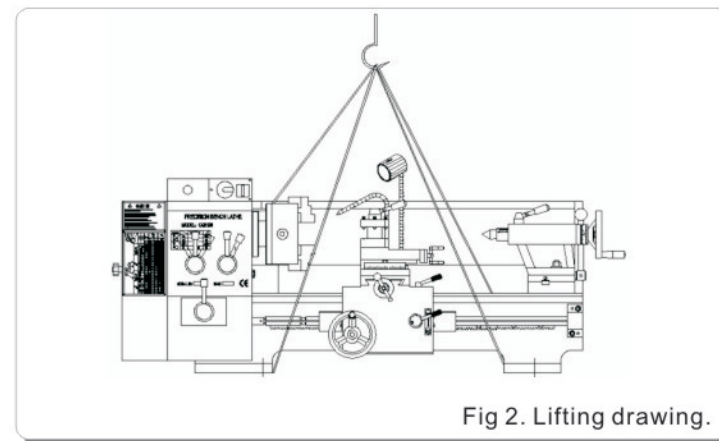


Fig 2. Lifting drawing.



## 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.

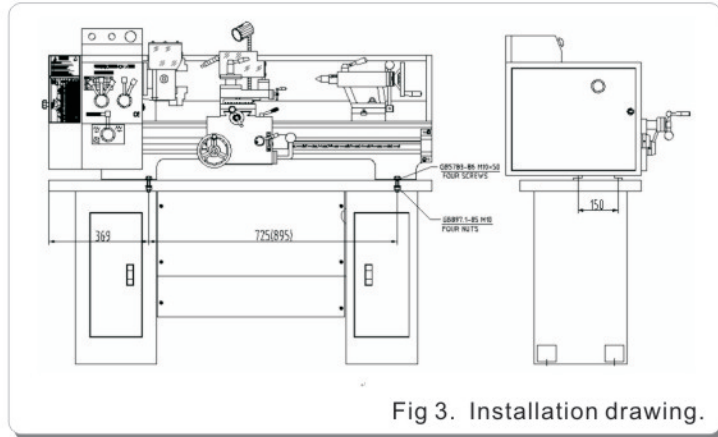


Fig 3. Installation drawing.

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.

## LUBRICATION POSITIONS

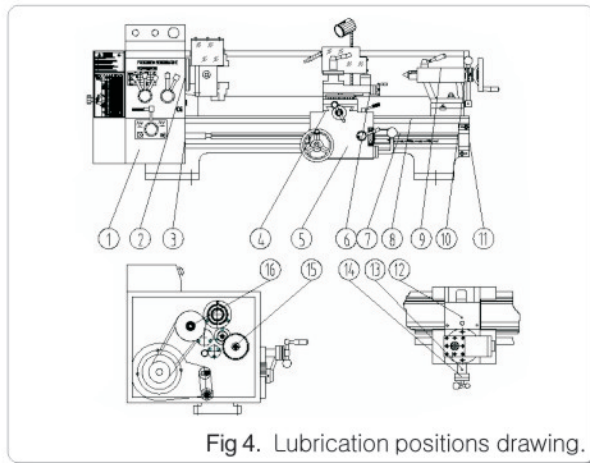


Fig 4. Lubrication positions drawing.

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.

## Lubrication Positions Cont.

### Attached List 1: Lubrication Positions Li

No.	Lubrication Position	Located part	Located part	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 bull 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 lead screw 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 Drawing

### SINGLE PHASE

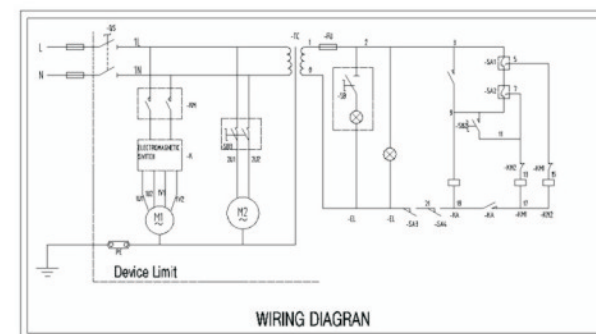
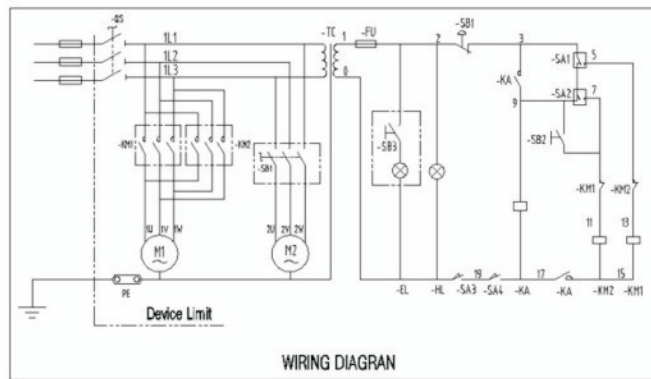
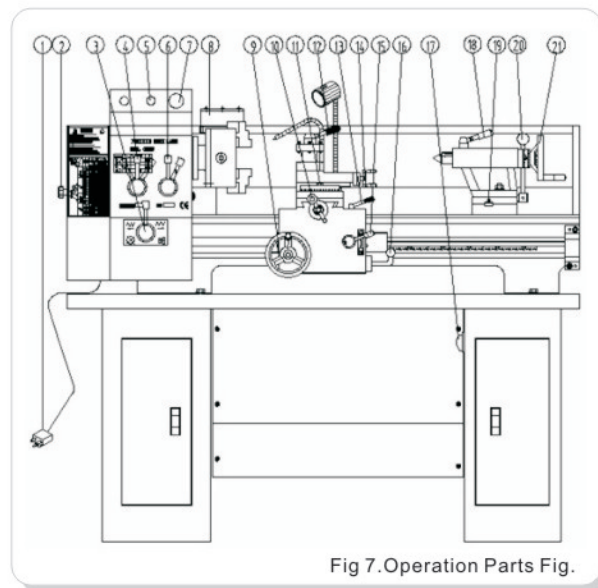


Fig5. Electric System Drawing.





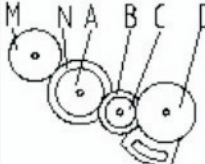







## Operating Controls



- 1.Power source-plug
- 2.Transmission Box Cover
- 3.Forward/Reverse Switch for lead screw-Middle position is Neutral
- 4.Shift Knob-Gear change
- 5.Start button
- 6.Shift Knob-Gear change
- 7.Stop button
- 8.Chuck
- 9.Longitudinal-Feed hand wheel
- 10.Small Carriage Cross Feed hand wheel
- 11.Tool Post Swivel Nut
- 12.Tool Post feed hand wheel
- 13.Auto Feed for Tool Post-Left Right, Neutral
- 14.Tool Carriage hand wheel
- 15.Carriage Auto-Feed Switch
- 16.START Forward/Reverse Switch
- 17.Pump Switch
- 18.Handle Lock for tailstock center
- 19.Offset Screw
- 20.Lever to lock Tailstock
- 21.Tailstock hand wheel

## Threading Chart

Please see the following diagram for reference to cutting threads

				M=24 N=60	M=28 N=35	$\frac{A}{B} \times \frac{C}{D}$				
						$\frac{24}{52} \times \frac{25}{48}$	M=24 N=60	M=28 N=35	M=24 N=60	M=28 N=35
							0.0041	0.0082	0.0009	0.0018
	1/n"		ins	18	9	$\frac{32}{38} \times \frac{35}{34}$	0.0194	0.0388	0.0041	0.0082
				19	9 1/2	$\frac{32}{38} \times \frac{35}{36}$	0.0183	0.0366	0.0038	0.0076
				20	10	$\frac{30}{27} \times \frac{40}{27}$	0.0174	0.0348	0.0037	0.0074
				22	11	$\frac{32}{30} \times \frac{36}{28}$	0.0158	0.0316	0.0034	0.0068
				23	11 1/2	$\frac{27}{24} \times \frac{40}{28}$	0.0151	0.0302	0.0032	0.0064
				24	12	$\frac{30}{32} \times \frac{32}{32}$	0.0145	0.0290	0.0031	0.0062
				26	13	$\frac{32}{32} \times \frac{32}{36}$	0.0134	0.0268	0.0028	0.0056
				28	14	$\frac{30}{27} \times \frac{34}{30}$	0.0124	0.0248	0.0026	0.0052
				30	15	$\frac{35}{32} \times \frac{27}{22}$	0.0116	0.0232	0.0025	0.0050
				32	16	$\frac{35}{32} \times \frac{27}{25}$	0.0109	0.0218	0.0023	0.0046
	mm		mm	0.5	1	$\frac{28}{35} \times \frac{25}{28}$	0.175	0.350	0.037	0.074
				0.6		$\frac{24}{30} \times \frac{30}{40}$	0.209	0.418	0.044	0.088
				0.7		$\frac{28}{30} \times \frac{30}{40}$	0.244	0.488	0.052	0.104
				0.75	1.5	$\frac{25}{40} \times \frac{32}{32}$	0.262	0.524	0.056	0.112
				0.8		$\frac{28}{32} \times \frac{32}{32}$	0.279	0.558	0.059	0.118
				1	2	$\frac{30}{32} \times \frac{32}{36}$	0.349	0.698	0.074	0.148
				1.25	2.5	$\frac{30}{32} \times \frac{40}{36}$	0.437	0.874	0.093	0.186
				1.5	3	$\frac{30}{32} \times \frac{42}{38}$	0.524	1.048	0.111	0.222
				1.75	3.5	$\frac{30}{30} \times \frac{44}{32}$	0.611	1.222	0.129	0.258
				2	4	$\frac{30}{30} \times \frac{40}{38}$	0.698	1.396	0.148	0.296

Threading Cutting threads can be performed by the manual use of the change gears and handle (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

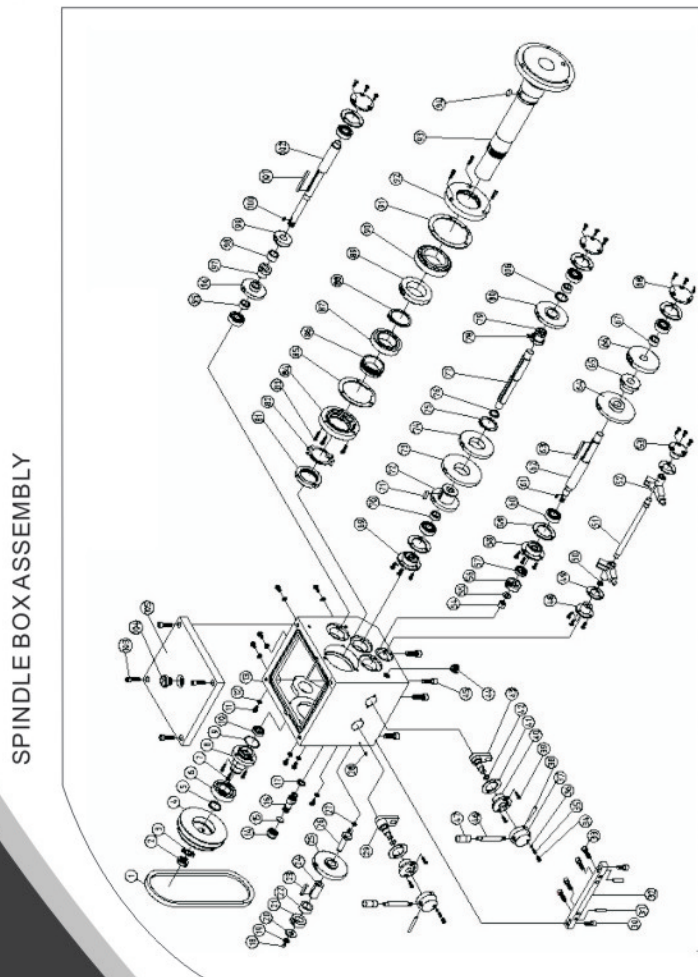
of the equipment grounding conductor can result in risk of electrical shock. The conductor wire with the green insulation (with or without yellow stripes) is the equipment-grounding conductor. If repair or replacement of the electrical cord or cord or plug is required, DO NOT connect the equipment grounding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



## Parts Listing-Lathe Headstock

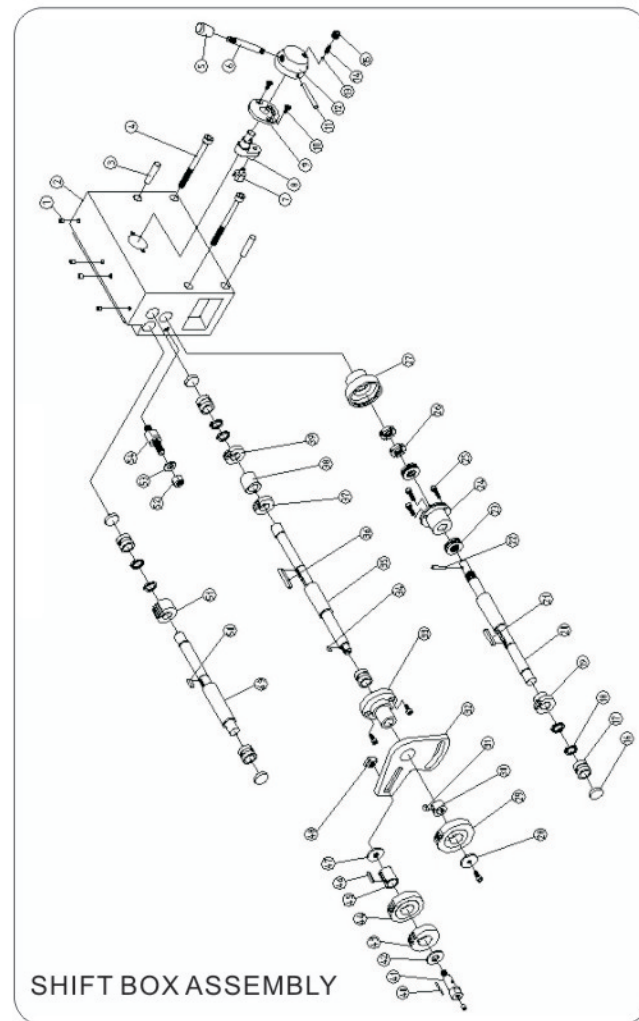
	Part No.	Description
1	V686 GB/T1171-1986	V-belt type 686
2	M16*1.5 GB/T812-1988	Spanner nut
3	16 GB/T858-1988	Lock washer for circular nut
4	BL330-02-031	Spindle pulley
5	30 GB/T894.1-1986	C-Clip
6	6206/P6 GB/T276-1994	Taper roller bearing
7	M5*16 GB/T77-1985	Hexagon socket head screw
8	BL330-02-030	Pulley seat
9	35.5*2.65 GB/T3452.1-1992	O-seal ring
10	FB016030 GB/T13871-1992	Felt cover
11	M6*8 GB/T818-1985	Crossrecessed pan head screws
12	6 GB/T97.1-1985	Plain washers
13	BL330-02-005	Lathe head
14	BL330-02-021	Nut
15	BL330-02-022	Felt cover
16	BL330-02-020	Oil Screw
17	BL330-02-058	Washer
18	6 GB/T7940.4-1995	Oil cup
19	11 GB/T894.1-1986	C-Clip
20	BL330-02-040	Cover
21	BL330-02-039	Change Gear
22	BL330-02-042	Sleeve spacer
23	A5*36 GB/T1096-1994	Plain parallel key
24	BL330-02-041	Sleeve
25	BL330-02-038	Change Gear
26	BL330-02-043	Shaft
27	9*1.8 GB/T3452.1-1992	O-seal ring
28	M5*8 GB/T71-1985	Screw
29	BL330-02-052	Block
30	M8*20 GB/T77-1985	Hexagon socket head screw
31	A6*30 GB/T117-1986	Taper pins
32	BL330-02-019	Adjust block
33	M8*25 GB/T77-1985	Hexagon socket head screw
34	M8*10 GB/T77-1985	Set screws with cone point
35	0.8*5*20 GB/T2089	Spring
36	6 GB/T308-1989	Steel ball
37	BL330-02-004	Handle seat
38	GB/T117-1986	Taper pins
39	M5*16 GB/T819-1985	Screw
40	BL330-02-009	Locating sleeve
41	BL330-02-057	Washer
42	11.2*2.65 GB/T3452.1-1992	O-seal ring
43	BL330-02-055	External snap ring
44	A10 JB/T9741.2	Oil Sight
45	M10*30 GB/T77-1985	Hexagon socket head screw
46	BL330-02-003	Handle lever
47	AM8*40 JB/T7271.3-1994	Knob
48	BL330-02-050	Sleeve
49	BL330-02-018	Washer
50	12 GB/T894.1-1986	C-Clip
51	BL330-02-053	Shifting fork shaft
52	BL330-02-055	Right shifting fork
53	BL330-02-010	Sleeve



## Parts Listing-Lathe Headstock

	Part No.	Description
57	FB016030 GB/T13871-1992	Felt cove
58	BL330-02-034	Sleeve
59	BL330-02-018	Washer
60	6203/P6 GB/T276-1994	Taper roller bearing
61	A4*10 GB/T1096-1994	Plain parallel key
62	BL330-02-044	Output shaft
63	A5*60 GB/T1096-1994	Plain parallel key
64	BL330-02-045	Gear
65	BL330-02-046	Gear
66	BL330-02-048	Gear
67	BL330-02-049	Sleeve spacer
68	BL330-02-023	Sleeve
69	BL330-02-032	Sleeve
70	BL330-02-011	Sleeve spacer
71	A5*22 GB/T1096-1994	Plain parallel key
72	BL330-02-017	Gear
73	BL330-02-016	Gear
74	BL330-02-015	Gear
75	42 GB/T894.1-1986	C-Clip
76	22 GB/T894.1-1986	C-Clip
77	BL330-02-014	Middle shaft
78	6*4*10 GB/T1566-1990	Thin flat key
79	BL330-02-012	Gear
80	BL330-02-013	Gear
81	M50*1.5 GB/T812-1988	Spanner nut
82	50 GB/T858-1988	Lock washer for circular nut
83	M5*20 GB/T77-1985	Hexagon socket head screw
84	BL330-02-036	Sleeve
85	BL330-02-037	Pressurize washer
86	BL330-02-035	Sleeve spacer
87	32010/P6X GB/T276-1994	Taper roller bearing
88	55 GB/T894.1-1986	C-Clip
89	BL330-02-047	Gear
90	32012/P5 GB/T276-1994	Taper roller bearing
91	BL330-02-007	Pressurize washer
92	BL330-02-006	Main shaft bearing oil seal
93	BL330-02-008	Lathe spindle
94	A8*16 GB/T1096-1994	Plain parallel key
95	BL330-02-029	Sleeve spacer
96	BL330-02-028	Gear
97	BL330-02-026	Sleeve spacer
98	BL330-02-027	Gear
99	BL330-02-025	Gear
100	A5*10 GB/T1096-1994	Plain parallel key
101	A5*70 GB/T1096-1994	Plain parallel key
102	BL330-02-024	Single shaft
103	M8*30 GB/T77-1985	Hexagon socket head screw
104	BL330-02-002	Oil port plug
105	BL330-02-001	Transmission cover
106	28 GB/T894.1-1986	C-Clip

## Parts Diagram-Lathe Trestle



## Parts Listing-Lathe Trestle

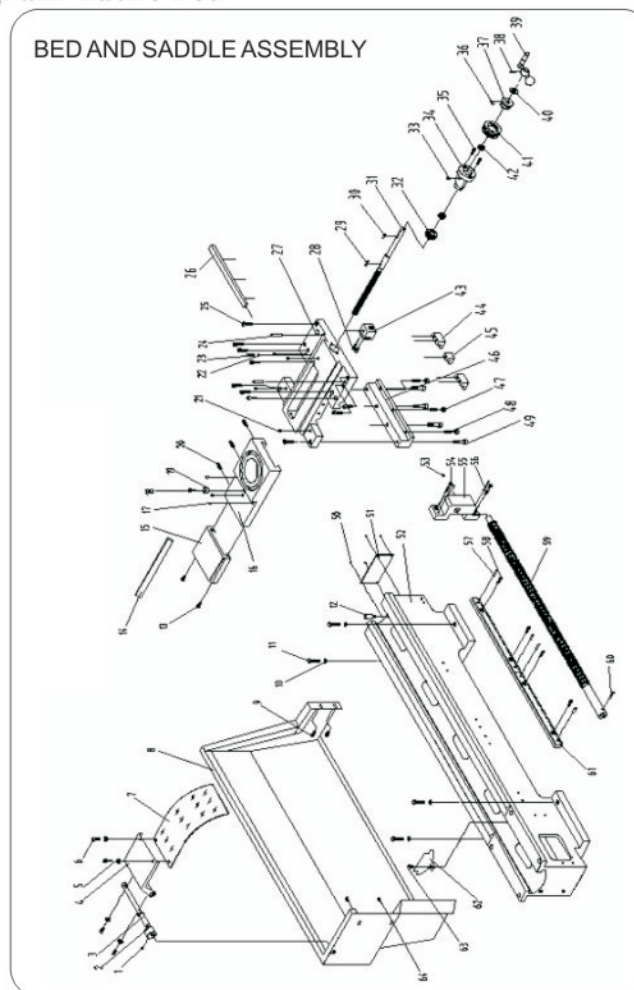
	Part No.	Description
1	6 GB/T7940.4-1995	Oil cup
2	BL330-03-012	Apron body
3	8*40 GB/T118-1986	Taper pins
4	M8*100 GB/T70-1985	Hexagon socket head screw
5	AM8*25JB/T7271.3-1994	Handle sleeve B-plastic
6	BL330-04-019	Handle seat
7	BL330-03-027	Right shifting fork
8	BL330-03-028	Shaft
9	BL330-03-001	Base
10	M5*12 GB/T819-1985	Screw
11	5*50 GB/T117-1986	Taper pins



## Parts Listing-Lathe Headstock

	Part No.	Description
12	BL330-02-004	Handle seat
13	6.5 GB/T308-1989	Steel ball
14	0.8*5*16 GB/T2089-1985	Spring
15	M8*10 GB/T77-1985	Screw
16	BL330-03-014	Cover
17	BL330-03-013	Sleeve
18	16 GB/T894.1-1986	C-Clip
19	BL330-03-024	Gear
20	BL330-03-022	Shaft
21	5*32 GB/T1096-1994	Key
22	4*24 GB/T117-1986	Taper pins
23	51102 GB/T301-1995	Taper roller bearing
24	BL330-03-015	Base
25	M5*12 GB/T70-1985	Hexagon socket head screw
26	M14*1.5 GB/T810-1988	Spanner nut
27	BL330-03-016	Sleeve
28	BL330-03-003	Sleeve
29	BL330-01-011	Gear
30	BL330-03-002	Sleeve spacer
31	5*10 GB/T1096-1994	Key
32	BL330-03-026	Change gear plate
33	BL330-03-008	Sleeve
34	4*10 GB/T1096-1994	Key
35	BL330-03-020	Shaft
36	5*40 GB/T1096-1994	Key
37	BL330-03-009	Gear
38	BL330-03-010	Sleeve spacer
39	BL330-03-011	Gear
40	Φ2.5*24	Shaft
41	BL330-03-004	Shaft
42	BL330-03-005	Sleeve
43	BL330-03-006	Gear
44	BL330-03-010	Gear
45	BL330-03-029	Sleeve
46	5*22 GB/T1096-1994	Key
47	BL330-03-006	Sleeve
48	BL330-03-007	T Nut
49	BL330-03-021	Shaft
50	5*16GB/T1096-1994	Key
51	BL330-03-023	Gear
52	M10 GB/T41-1986	Nut
53	10 GB/T97.1-1985	Plain washers
54	BL330-03-025	Screw

## Parts Diagram-Lathe Bed



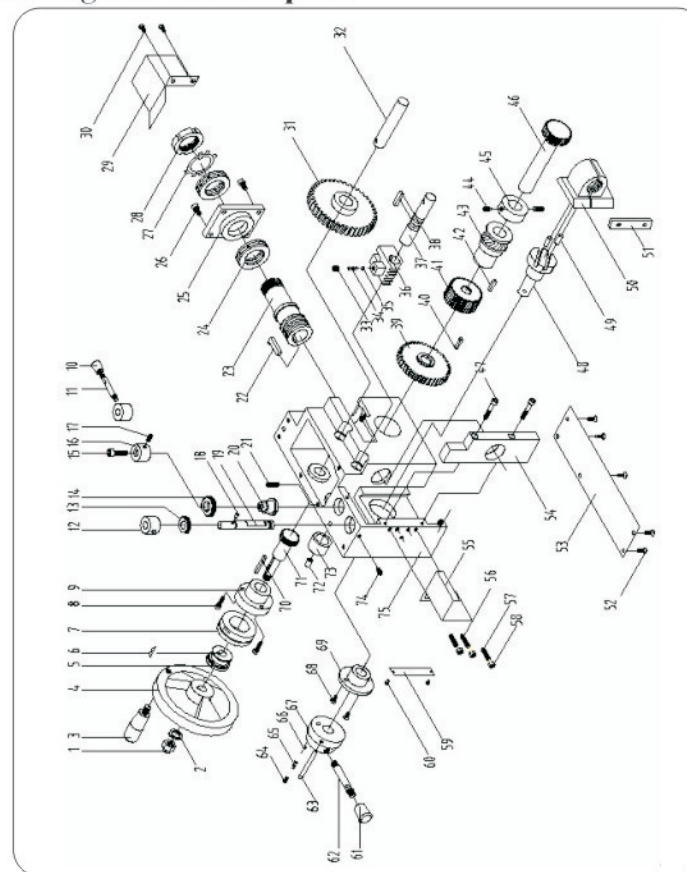
## Parts Listing-Lathe Bed

	Part No.	Description
1	M6*12 GB/T77-1985	Hexagon socket head screw
2	BL330-02T01-002	Cam sleeve
3	BL330-02T01-001	Switch bar
4	BL330-02T01-004	Connecting plate
5	5 GB/T96-1985	Plain washers
6	M5*12 GB/T818-1985	Screw
7	BL330-02T01-003	Shield
8	BL330-01-014	Shield
9	M6*10 GB/T77-1985	Hexagon socket head screw
10	10 GB/T96-1985	Plain washers
11	M10*50 GB	Hexagon head screw
12	BL330-01-018	Pin
13	M8*30 GB/T77-1985	Hexagon socket head screw
14	BL330-05-003	Chock

## Parts Listing-Lathe Bed

	Part No.	Description
15	BL330-05-005	Shield
16	BL330-05-002	Middle carriage
17	6 GB/T7940.4-1995	Oil cup
18	M6*12 GB/T77-1985	Hexagon socket head screw
19	BL330-05-009	Washer
20	M6*20 GB1779-1985	Set screws with cone point
21	6 GB/T7940.4-1995	Oil cup
22	6 GB/T97.1-1985	Plain washers
23	M6*40 GB5782-1986	Hexagon head bolts
24	6*40 GB/T117-1986	Taper pins
25	M6*35 GB/T77-1985	Hexagon socket head screw
26	BL330-05-007	Chock
27	BL330-05-001	Carriage
28	M5*14 GB/T77-1985	Hexagon socket head screw
29	4*16 GB/T1096-1994	Plain parallel key
30	4*16 GB/T1096-1994	Plain parallel key
31	BL330-05-010	Cross feed screw rod
32	BL330-05-013	Gear
33	6 GB/T7940.4-1995	Oil cup
34	BL330-05-014	Cross feed screw seat
35	M6*60 GB/T77-1985	Hexagon socket head screw
36	BL330-04-021	Spring lamination
37	BL330-04-022	Dial sleeve
38	4*25 GB/T117-1986	Taper pins
39	B12*40 GB4141.9-84	Handles with sleeve
40	12 GB/T97.1-1985	Plain washers
41	BL330-05-015	Dial
42	51101 GB/T301-1995	Rolling bearing
43	BL330-05-008	Cross nut
44	BL330-05-011	Chain up block
45	BL330-05-004	Forward board
46	BL330-05-006	Behind board
47	M8 GB/T41-1985	Hexagon nuts
48	M8*30 GB1779-1985	Set screws with cone point
49	M8*45 GB/T77-1985	Hexagon socket head screw
50	2.5*5 GB/T96-1986	Rivet
51	BL330-01-017	Table
52	BL330-01-011	Bed
53	6 GB/T7940.4-1995	Oil cup
54	M8*25 GB/T77-1985	Hexagon socket head screw
55	BL330-01-015	Right pedestal
56	4*24 GB/T117-1986	Taper pins
57	6*35 GB/T117-1986	Taper pins
58	M8*20 GB/T77-1985	Hexagon socket head screw
59	BL330-01-009	Longitudinal feed screw
60	6*35 GB/T117-1986	Taper pins
61	BL330-01-012	Racks
62	BL330-01-019	Shield
63	M6*8 GB/T77-1985	Hexagon socket head screw
64	M6*8 GB/T77-1985	Hexagon socket head screw

## Parts Diagram-Lathe Apron



## Parts Listing-Lathe Apron

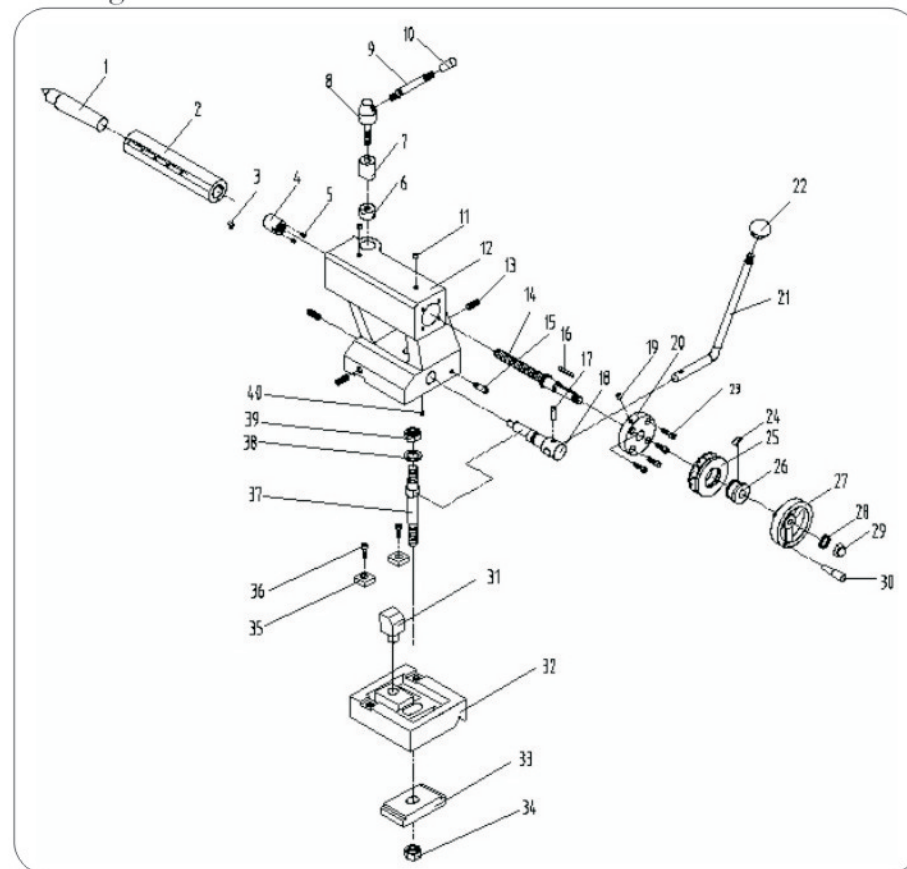
	Part No.	Description
1	M10 GB923-1988	Domed cap nuts
2	M10 GB923-1988	Spring washer
3	JB/T7270.4-1994	Sleeve
4	B12*125 JB/T7273.3-1994	Hand wheel
5	BL330-04-022	Sleeve
6	BL330-04-021	Spring lamination
7	BL330-04-020	Dial
8	M4*20 GB70-85	Hexagon socket head screw
9	BL330-04-023	Flange sleeve
10	AM8*25JB/T7271.3-1994	Handle sleeve B-plastic
11	BL330-04-019	Handle lever
12	BL330-04-006	Sleeve
13	BL330-04-007	Gear
14	BL330-04-005	Middle gear
15	M6*25 GB70-85	Hexagon socket head screw
16	BL330-04-003	Sleeve
17	M5*10 GB/T78-1985	Set screws with cone point
18	4*6 GB/T119-1986	Pin
19	BL330-04-008	Axis
20	BL330-04-004	Shaft



## Parts Listing-lathe Apron

	Part No.	Description
21	M6*20 GB/T78-1985	Screws
22	BL330-04-009	Key
23	BL330-04-025	Worm shaft
24	GB/T301-1995	Thrust ball bearing
25	BL330-04-010	Worm shaft
26	M5*12 GB/T70-1985	Hexagon socket head screw
27	30 GB/T858-1988	Lock washer
28	M30*1.5 GB/T810-1988	Round nut
29	BL330-01-010	Safe shield
30	M5*10 GB/T70-1985	Hexagon socket head screw
31	BL330-04-026	Gear
32	BL330-04-011	Slippage shaft
33	M6*8 GB/T77-1985	Screws
34	0.8*4*12 GB/T2089-1985	Spring
35	φ 5 GB/T308-1989	Steel ball
36	BL330-04-002	Shifting fork
37	BL330-04-032	Shifting fork shaft
38	5*25 GB/T1096-1979	Pin
39	BL330-04-026	Gear
40	6*12 GB/T1096-1994	Pin
41	BL330-04-030	Gear
42	GB/T1096-1994	Pin
43	BL330-04-029	Worm gear
44	M6*10 GB/T79-1985	Screws
45	BL330-04-028	Sleeve
46	BL330-04-027	Gear shaft
47	M5*20 GB/T77-1985	Hexagon socket head screw
48	BL330-04-016	Shaft
49	6*15 GB/T119-1986	Column pins
50	BL330-04-014	Screw nut
51	BL330-04-015	Chock
52	M4*8 GB	Screw
53	BL330-04-013	Cover
54	BL330-04-033	Apron body right cover
55	BL330-01-013	Safe shield
56	M5*25 GB/T78-1985	Screw
57	M5 GB/T41-1985	Hexagon nuts
58	M5*22 GB/T75-1985	Screw
59	BL330-0-0	Table
60	2.5*5 GB/T96-1986	Rivet
61	M8*25 JB/T7271.3-1994	Handle sleeve B-plastic
62	BL330-04-019	Handle lever
63	5*50 GB/T117-1986	Taper pins
64	M8*10 GB/T77-1985	Screw
65	0.8*5*16 GB/T2089-1985	Spring
66	φ 6.5 GB/T308-1989	Steel ball
67	BL330-04-018	Handle seat
68	M4*12 GB/T68-1985	Screw
69	BL330-04-017	Sleeve
70	4*28 GB/T1096-1994	Pin
71	BL330-04-024	Gear shaft
72	GB/T7940.4-1995	Oil cup
73	BL330-04-012	Sleeve
74	M5*10 GB/T78-1985	Screw
75	BL330-04-001	Apron body

## Parts Diagram-tailstock



## Parts Listing-tailstock

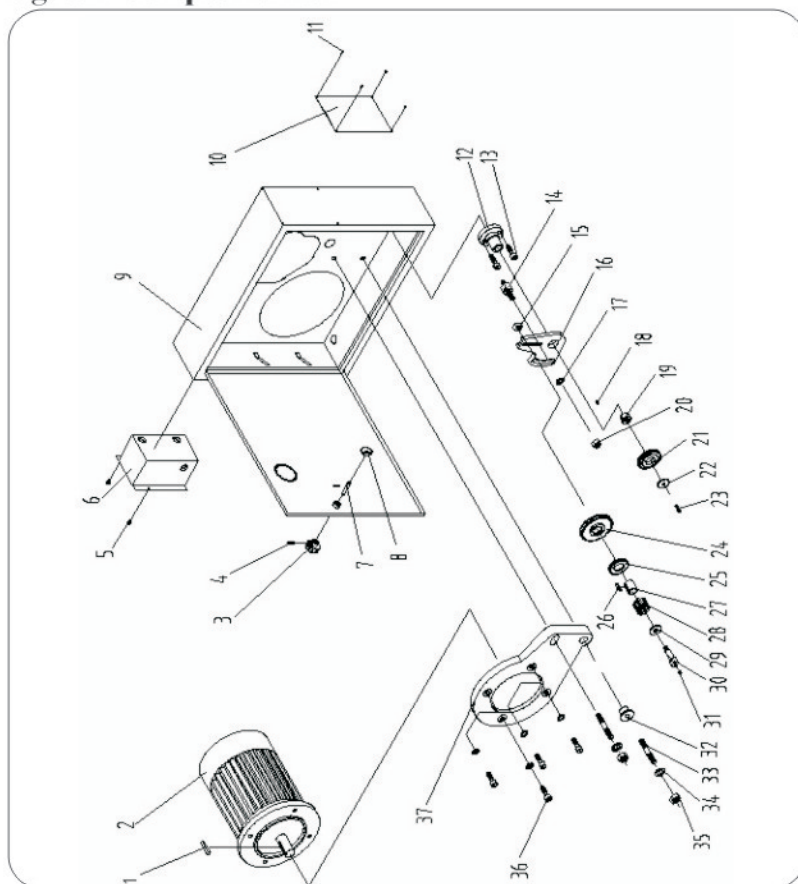
	Part No.	Description
1	Mt3#	Rolling center
2	BL330-06-002	Tailstock center sleeve
3	BL330-06-021	T-Key
4	BL330-06-004	Tailstock Nuts
5	M6*10 GB/T78-1985	Set screws with cone point
6	BL330-06-008	Locking nuts
7	BL330-06-008	Locking Sleeve
8	BL330-06-001	Handle seat
9	BL330-04-019	Handle seat
10	M25*8 JB/T7271.3-1994	Long sleeve knob
11	6 GB/T7940.4-1995	Oil cup
12	BL330-06A-007	Tailstock
13	M10*40 GB/T77-1985	Set screws with cone point
14	BL330-06-003	Tailstock screw stem
15	BL330-06-011	Pin
16	4*28 GB/T1096-1994	Plain parallel key
17	8*25 GB/T117-1986	Taper pins
18	BL330-06-001	Shaft
19	6 GB/T7940.4-1995	Oil cup
20	BL330-06-005	Sleeve



## Parts Listing-tailstock

	Part No.	Description
21	BL330-06A-009	Handle lever
22	M10*32 JB/T7271.1-1994	Handle ball
23	M5*20 GB/T70-1985	Hexagon socket head screw
24	BL330-04-021	Spring lamination
25	BL330-06-006	Dial
26	BL330-04-022	Sleeve
27	B12*250 JB/T7273.3-1994	Hand wheel
28	12 GB/T97.1-1985	Plain washers
29	M10 GB/T923-1976	Domed cap nuts
30	B12*250 JB/T7273.3-1994	Handles with sleeve
31	BL330-06-018	Base
32	BL330-06A-017	Tailstock carriage
33	BL330-06-019	Chock
34	M12 GB/T41-1985	Hexagon thin nuts
35	BL330-06-012	Block
36	M5*16 GB/T70-1985	Hexagon socket head screw
37	BL330-06A-020	Pull pole set
38	12 GB/T97.1-1985	Plain washers
39	M12 GB/T41-1985	Hexagon nuts
40	M6*14 GB1779-1985	Set screws with cone point

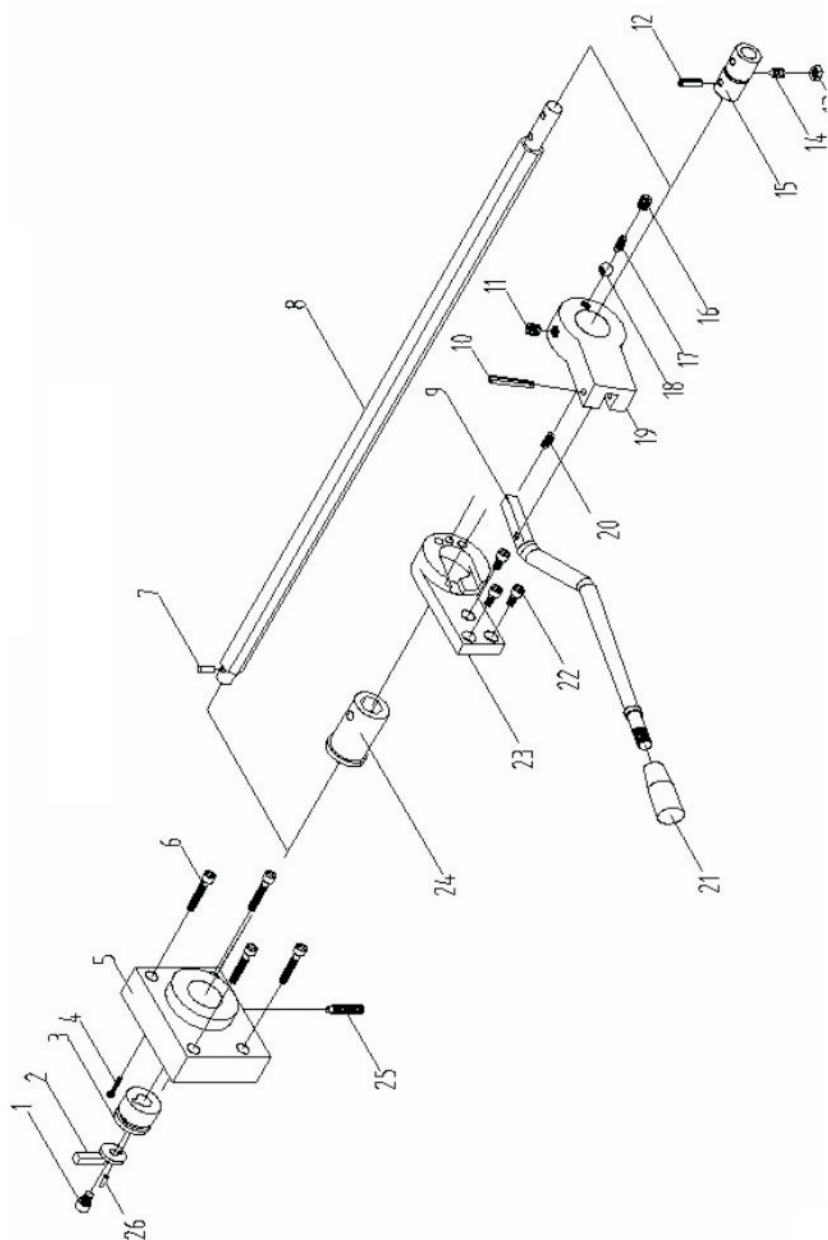
## Parts Diagram-compound Box



## Parts Listing-compound Box

	Part No.	Description
1	A8*30 GB/T1096-1994	Plain parallel key
2	Y90S-4 B5 1.1KW	Motor 1.1kw
3	8*32 JB/T7274.4-1994	Start-grip knob
4	3*14 GB/T879-1986	Taper pins
5	M5*8 GB/T819-1985	Screw
6	BL330-01-019	Safe box
7	BL330-01-005	Shaft
8	BL330-01-003	Door-knob
9	BL330-01-001/002	Compound box
10	BL330-01-032	Thread table
11	2.5*5 GB/T827-1986	Rivet
12	BL330-03-008	Sleeve
13	M5*12 GB/T70-85	Hexagon socket head screw
14	BL330-03-025	Screw
15	BL330-03-007	T-nut
16	BL330-03-026	Change gear plate
17	10 GB/T97.1-1985	Plain washers
18	M10 GB/T41-1985	Hexagon thin nuts
19	BL330-03-002	Sleeve
20	BL330-01-011	Gear
21	BL330-03-003	Sleeve
22	M5*10 GB/T70-1985	Hexagon socket head screw
23	5*10 GB/T1096-1994	Plain parallel key
24	BL330-01-010	Gear
25	BL330-01-006	Gear
26	5*22 GB/T1096-1994	Plain parallel key
27	BL330-03-029	Sleeve
28	Φ 2.5*24	Roller
29	BL330-03-005	Sleeve
30	BL330-03-004	Shaft
31	6 GB/T7940.4-1995	Oil cup
32	BL330-01-007	Sleeve
33	M10*52 GB/T898-1988	Screw
34	10 GB/T97.1-1985	Plain washers
35	M10 GB/T41-1985	Hexagon nuts
36	M8*20 GB/T70-1985	Hexagon socket head screw
37	BL330-013-008	Motor mount plate

## Parts Diagram-lathe Handle



## Parts Listing-lathe Handle

	Part No.	Description
1	M6*12 GB/T70.1-2000	Hexagon socket head screw
2	BL330-08-003A	Block
3	BL330-08-004A	Collar
4	M2.5*16 GB/T818-2000	Screws
5	BL330-08-005A	Box
6	M5*30 GB/T70.1-2000	Hexagon socket head screw
7	A5*12 GB/T117-1986	Taper pins
8	BL330-08-001A	Shaft
9	BL330-08-008A	Handle
10	5*40 GB/T119-1986	Pin
11	M8*16 GB/T78-2000	Screw
12	5*18 GB/T879-1986	Taper pins
13	M6 GB/T41-1985	Hexagon nuts
14	M6*16 GB/T79-2000	Screw
15	BL330-08-009A	Collar
16	M8*10 GB/T77-2000	Screw
17	0.8*5*16 GB/T2089-1985	Spring
18	6.5 GB/T308-1989	Steel ball
19	BL330-08-002A	Handle seat
20	0.8*6*20 GB/T2089-1985	Spring
21	BM10*50 GB/T4141.14-1994	Knob
22	M6*12 GB/T70.1-2000	Hexagon socket head screw
23	BL330-08-007A	Bracket
24	BL330-08-006A	Collar
25	M6*30 GB/T79-2000	Hexagon socket head screw
26	3*10 GB/T879-1986	Taper pins