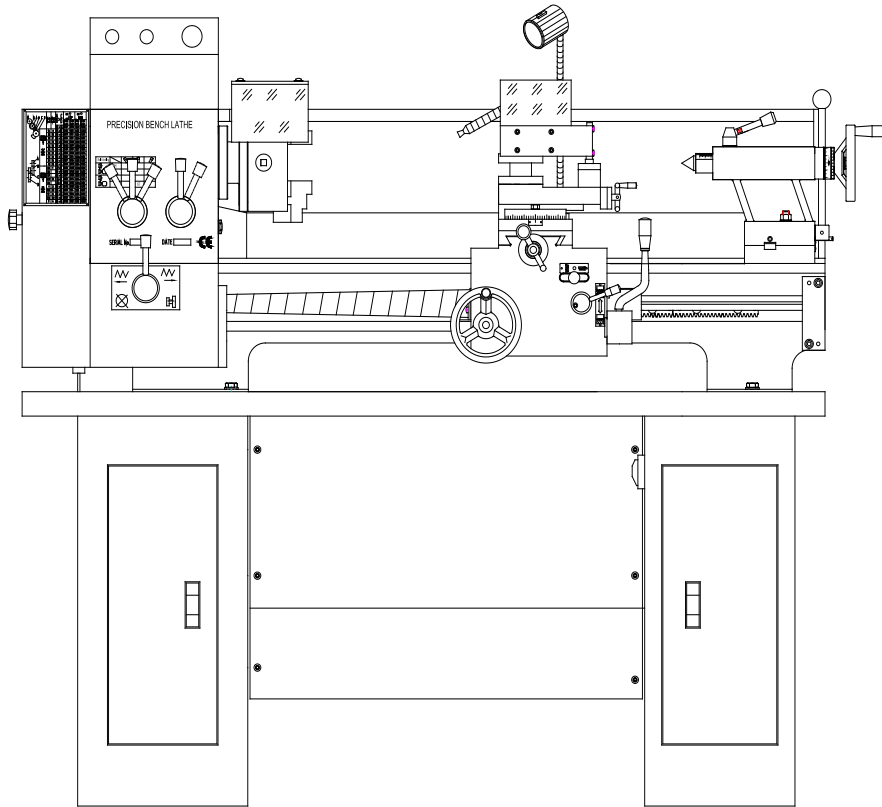


OWNER'S MANUAL



PRECISION METAL LATHE

ASSEMBLY AND OPERATING INFORMATION

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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.
- **THINK SAFELY. WORK SAFELY.** Never attempt a procedure if it does not feel safe or comfortable.

CQ6133 METAL LATHE

As part of the growing line of metalworking equipment, we are proud to offer the CT089 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 CQ6133 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	600mm/800 mm
Max. Swing diameter over tool post	220mm
Spindle Bore	38mm
Spindle Taper	MT.5#
Max Lateral Stroke over tool post	160mm
Max Longitudinal stroke over tool post	100mm
Metric Thread kinds on processing	17
Inch Thread kinds on processing	20
Metric thread pitch on processing	0.5~4 mm
Inch thread pitch on processing	9-40 1/N"
Longitudinal-feed on spindle tool post	0.135~1.80mm/r
Max. stroke of tail stock sleeve	70mm
Tail stock sleeve taper	MT.3#

Spindle speeds available	12
Spindle speeds range	60~1650mm/r
Electromotor	1100w/220v/ 50HZ (or110v/60HZ)
Net weight	330kg
Full size	130cm*74cm*60cm
Outer packing size	133cm*76cm*65cm

Standard Accessories

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

Illustrated Features

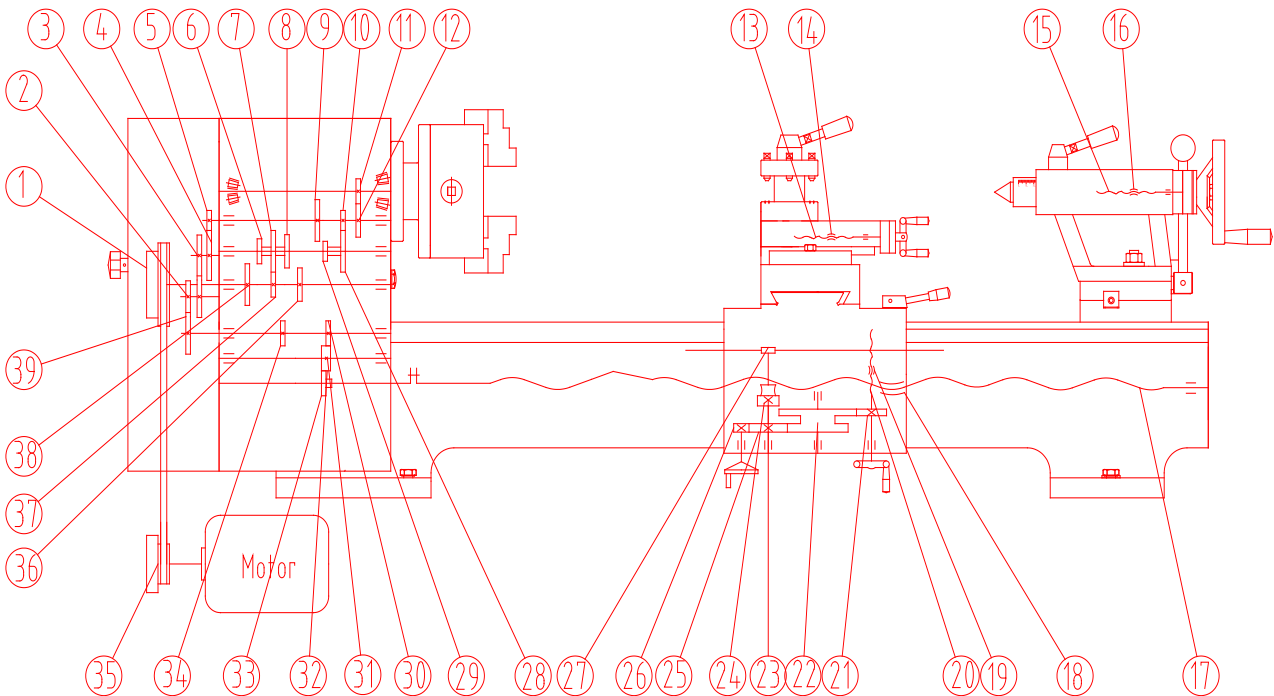


Fig 1. Driving system drawing

- | | | |
|--------------------------|---------------------------|------------------|
| 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 |
| 13. Tool Post Lead Screw | 26. 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.

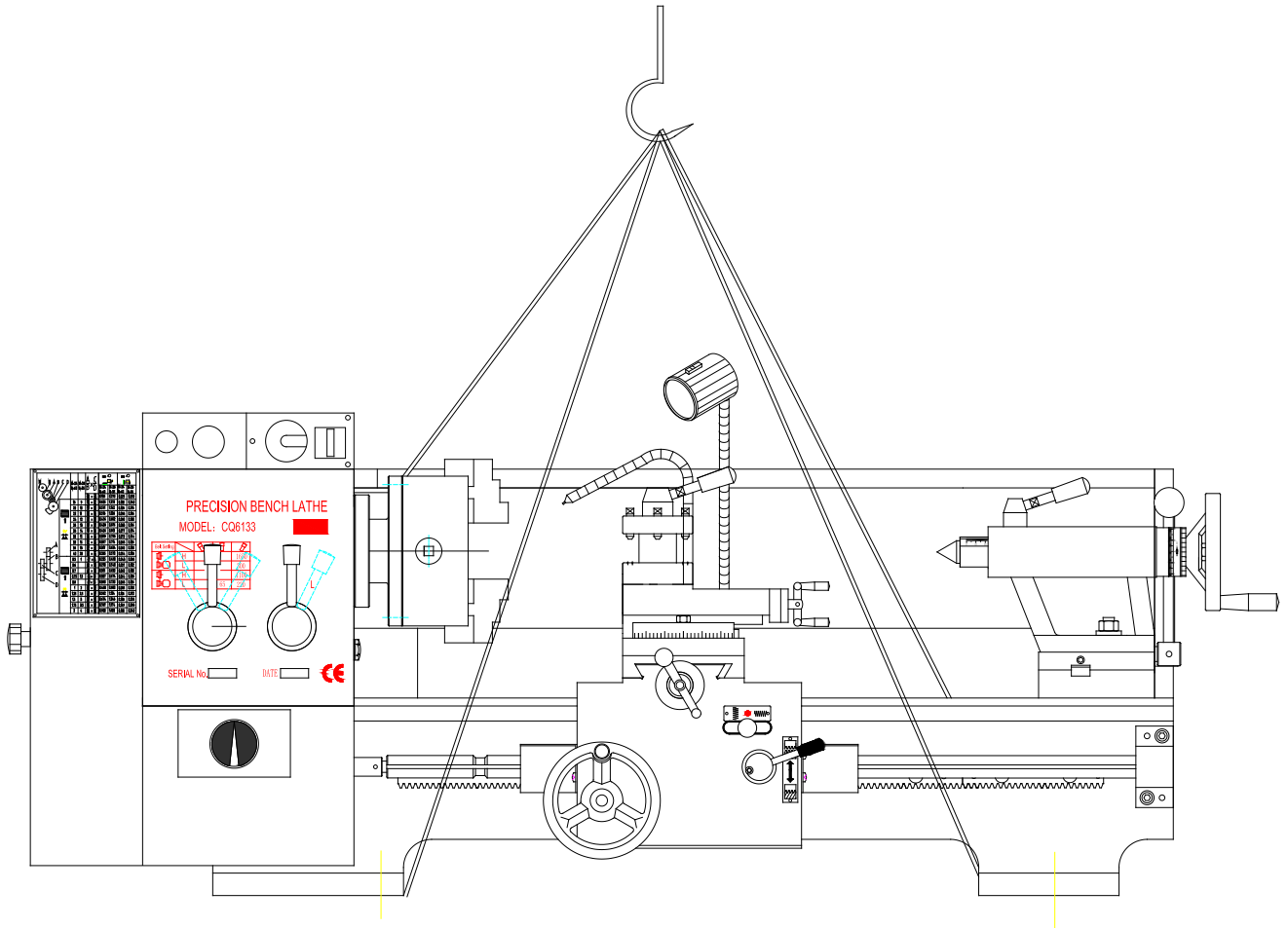


Fig 2. Lifting drawing

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.

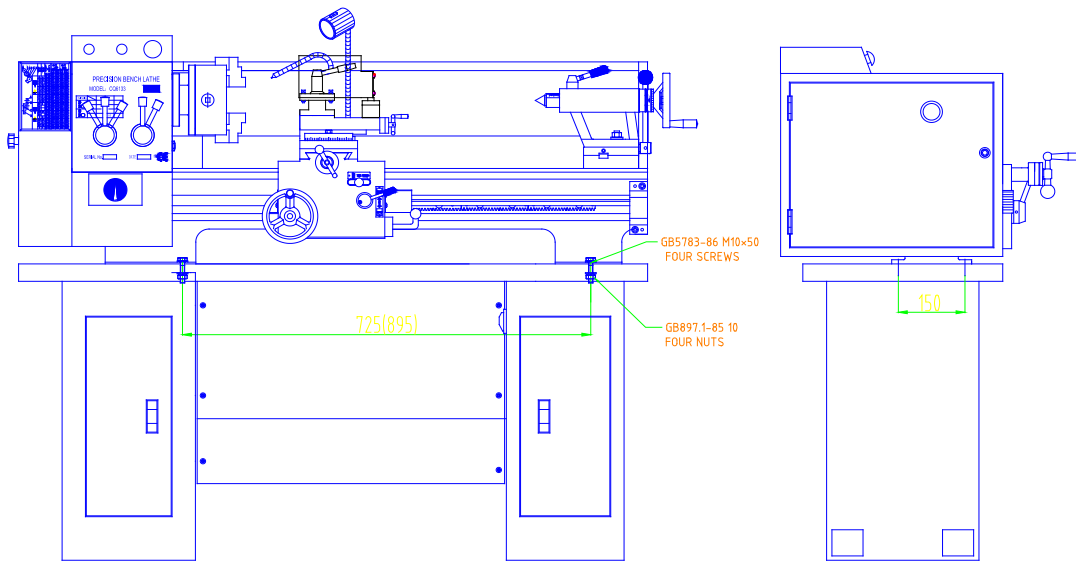


Fig 3. Installation drawing.

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

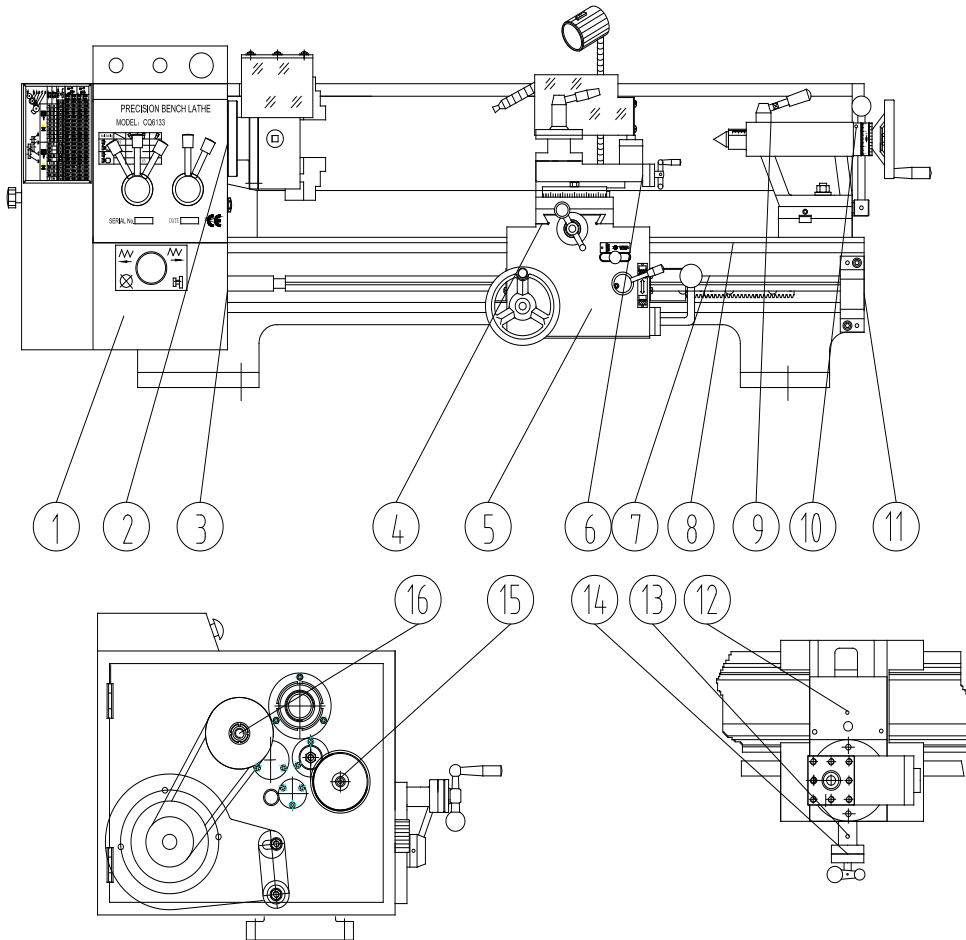


Fig 4. Lubrication positions drawing.

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

Item No.	Lubrication Position	Located part	Located part 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 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

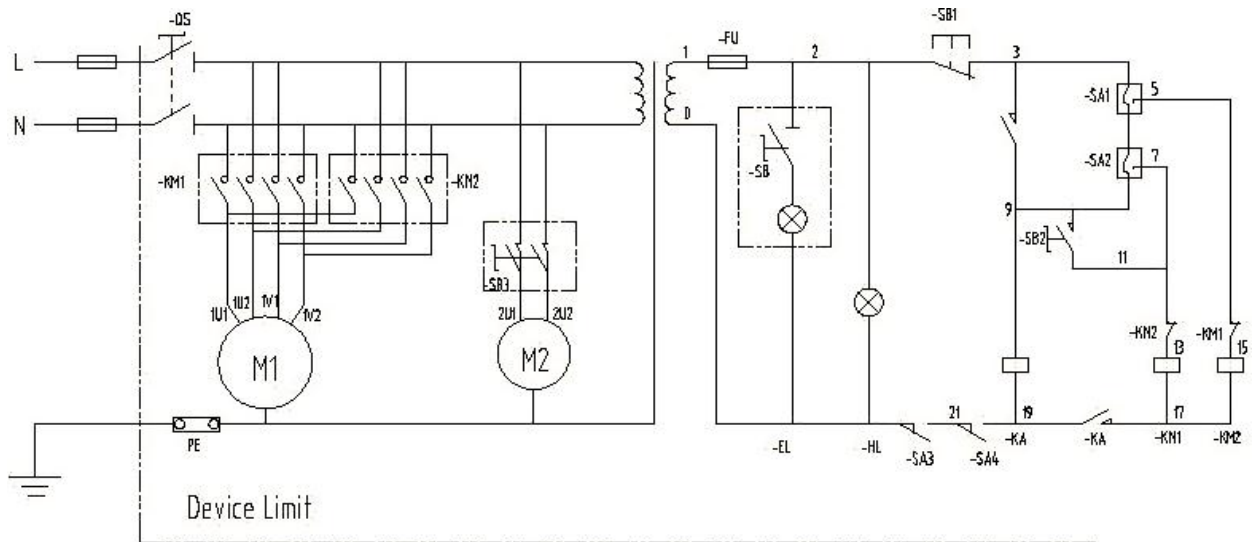


Fig5. Electrical System Drawing

Operating Controls

REFER TO THE DIAGRAM BELOW FOR THE CQ6133 operation controls.

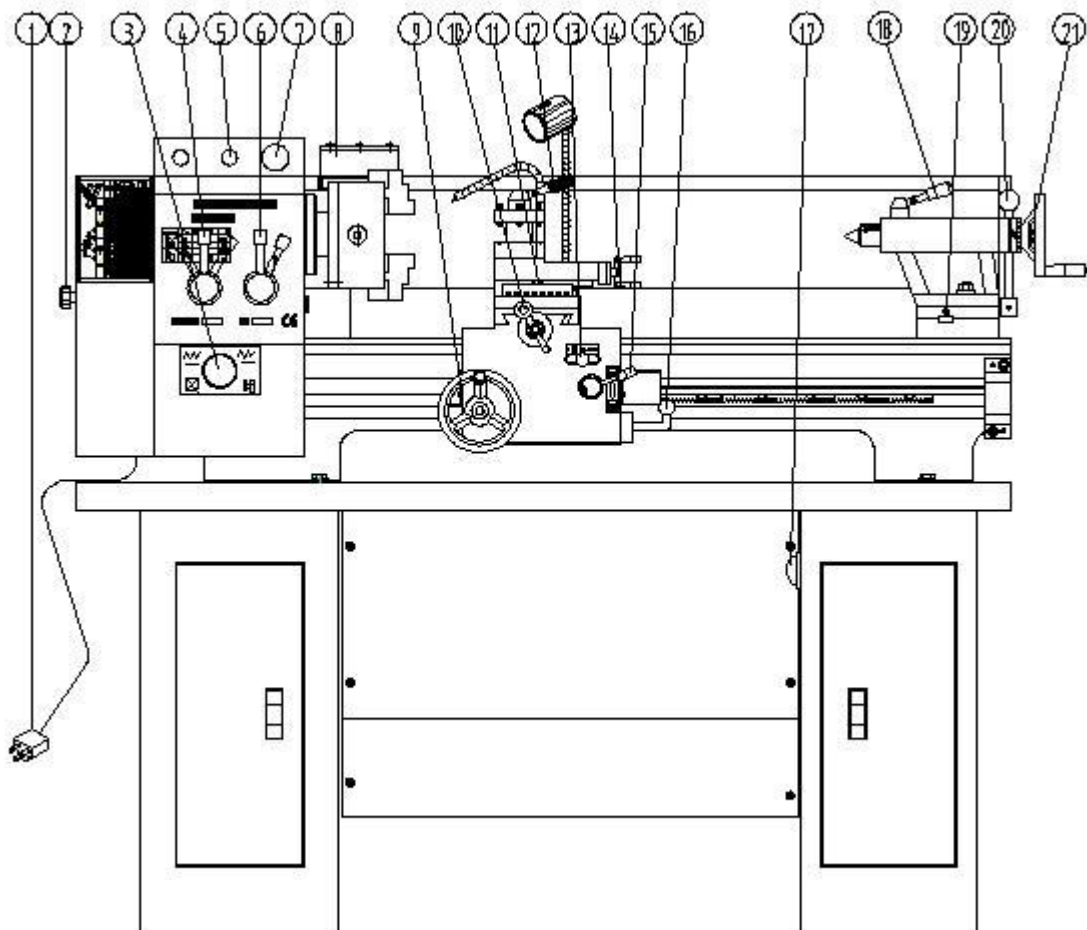
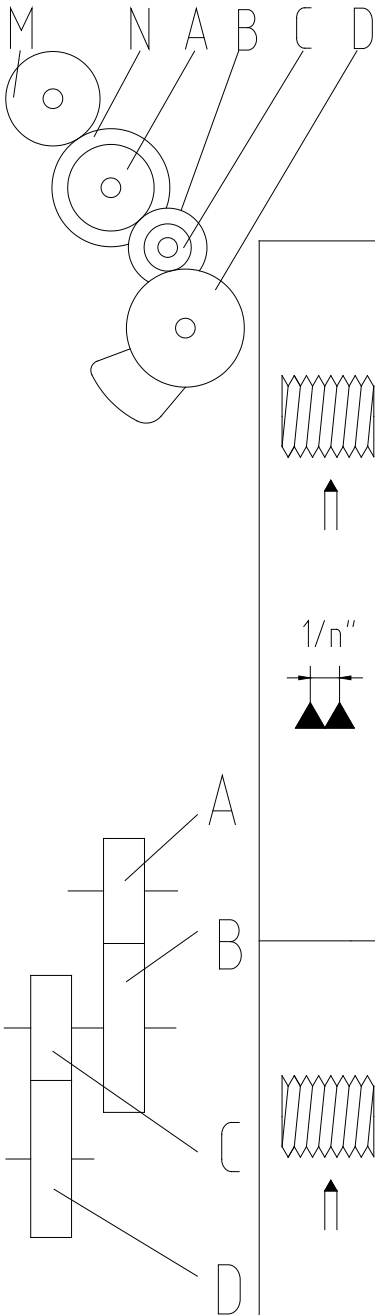




Fig 6. Operation Parts Fig.

- 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) Shift Knob-Gear change
- 6) Stop button
- 7) Chuck
- 8) Longitudinal-Feed hand wheel
- 9) Small Carriage Cross Feed hand wheel
- 10) Tool Post Swivel Nut
- 11) Tool Post feed hand wheel
- 12) Auto Feed for Tool Post-Left, Right, Neutral
- 13) Tool Carriage hand wheel
- 14) Carriage Auto-Feed Switch
- 15) START Forward/Reverse Switch
- 16) Pump Switch
- 17) Handle Lock for tailstock center
- 18) Offset Screw
- 19) Lever to lock Tailstock
- 20) Tailstock hand wheel

Threading Chart

Please see the following diagram for reference to cutting threads

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

Threading

Cutting threads can be performed by the manual use of the change gears and handle 4 & 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.

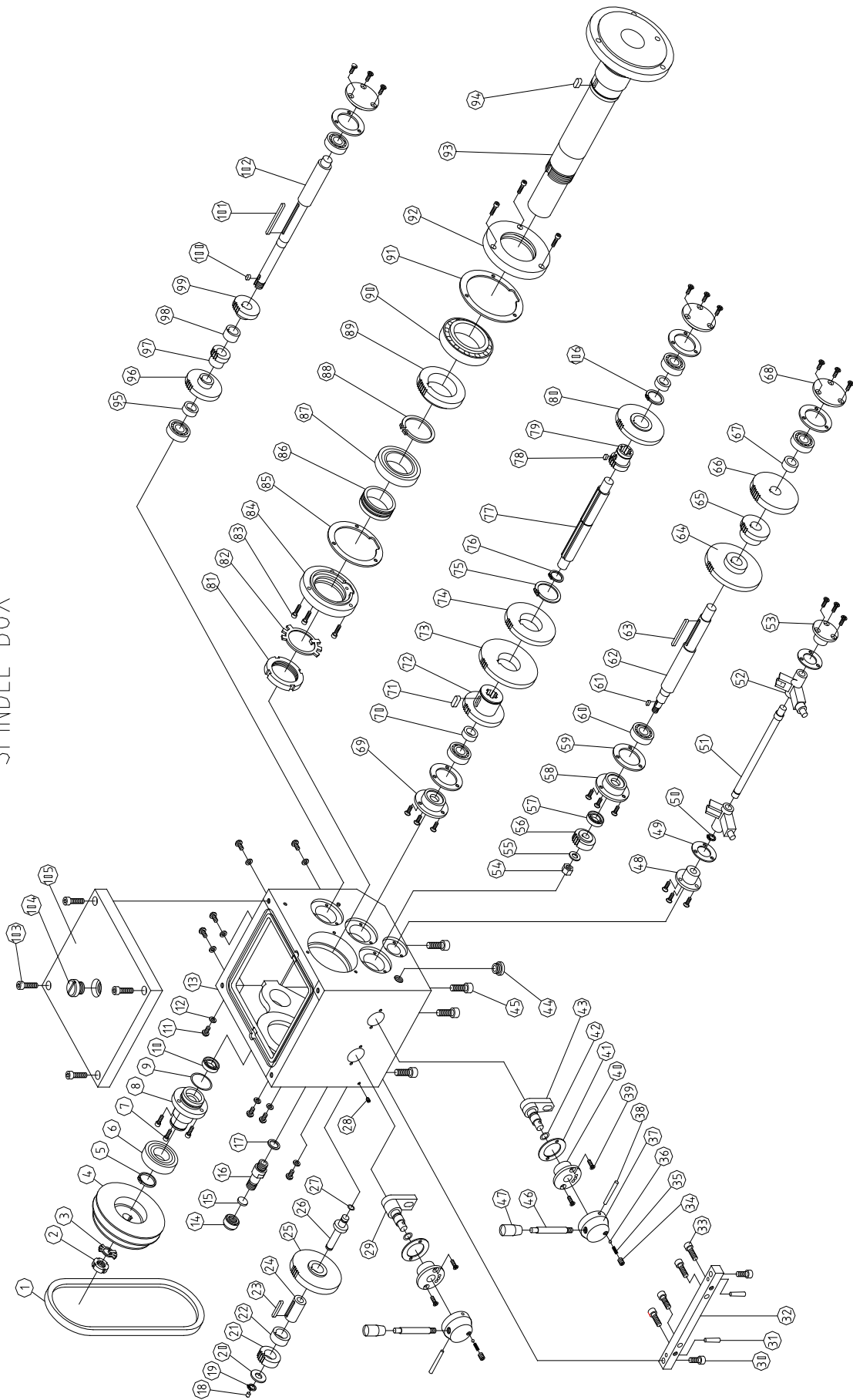
DO NOT MODIFY THE PLUG PROVIDED. If the provided plug will not fit the electrical outlet, have the proper outlet installed by a qualified licensed electrician.

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 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.

SPINDLE BOX



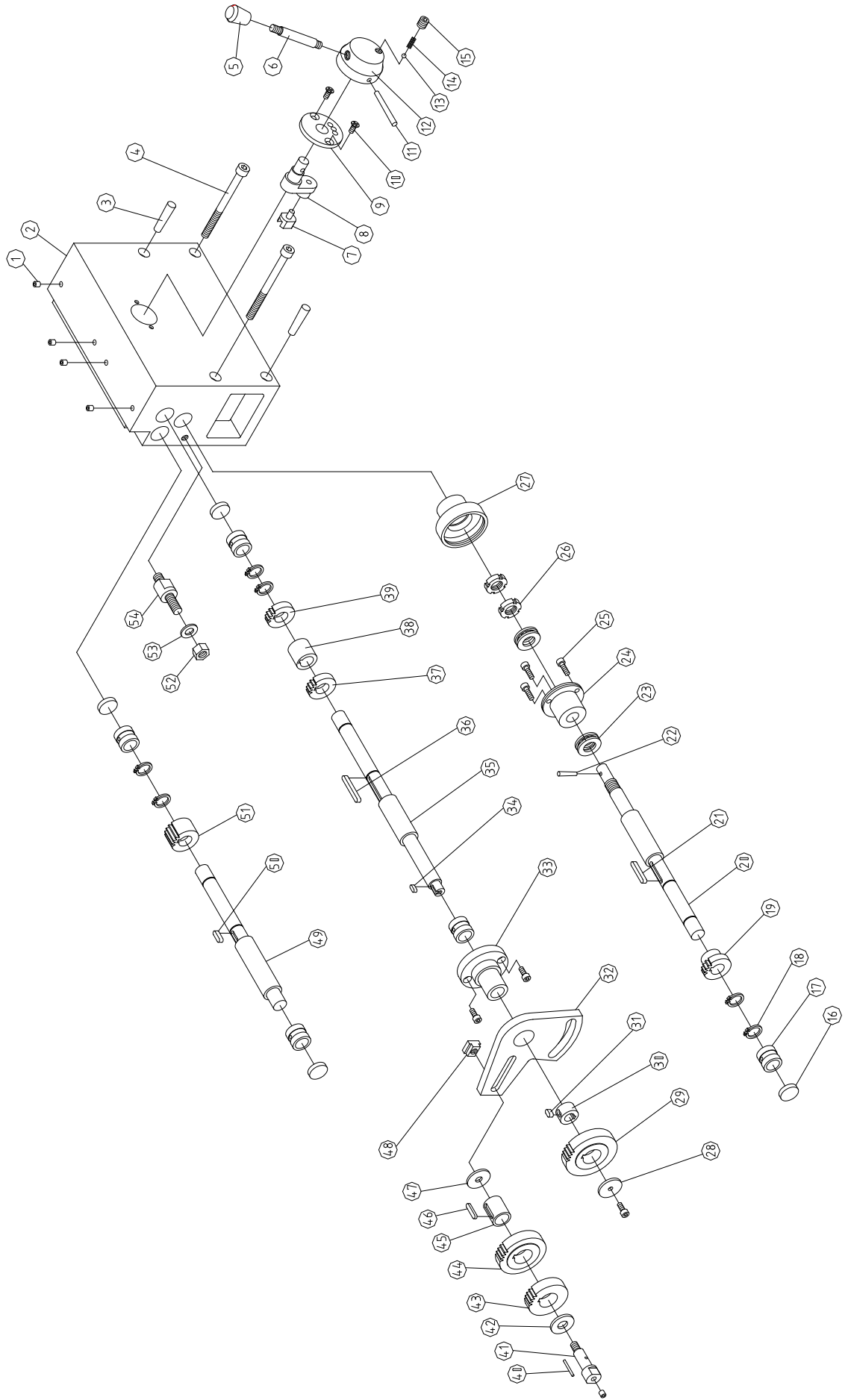
Parts Listing-Lathe Head

No.		SPINDLE BOX	
1	V710 GB/T1171-1986	V-belt type 680	皮带
2	M16*1.5 GB/T812-1988	Spanner nut	圆螺母
3	16 GB/T858-1988	Lock washer for circular nut	止动垫圈
4	CQ6133-02-031	Spindle pulley	皮带轮
5	30 GB/T894.1-1986	Circlips for shaft-type A	轴用挡圈
6	6206/P6 GB/T276-1994	Taper roller bearing	深沟球轴承
7	M5*16 GB/T77-1985	Hexagon socket head screw	内六角螺栓
8	CQ6133-02-030	Pulley seat	皮带轮支承座
9	35.5*2.65 GB/T3452.1-1992	O-seal ring	O 型密封圈
10	FB016030 GB/T13871-1992	Felt collar	骨架橡胶密封圈
11	M6*8 GB/T818-1985	Crossrecessed pan head screws	十字盘头螺钉
12	6 GB/T97.1-1985	Plain washers	平垫圈
13	CQ6133-02-005	Lathe head	主轴箱
14	CQ6133-02-021	Nut	螺母
15	CQ6133-02-022	Felt collar	密封圈
16	CQ6133-02-020	Oil Screw	排油螺栓
17	CQ6133-02-058	Washer	橡胶垫圈
18	6 GB/T7940.4-1995	Oil cup	油杯
19	11 GB/T894.1-1986	Circlips for shaft-type A	轴用挡圈
20	CQ6133-02-040	collar	挡圈
21	CQ6133-02-039	Change Gear	挂轮 C
22	CQ6133-02-042	Sleeve spacer	隔套 D
23	A5*36 GB/T1096-1994	Plain parallel key	平键
24	CQ6133-02-041	Sleeve	衬套 B
25	CQ6133-02-038	Change Gear	挂轮 B
26	CQ6133-02-043	Shaft	芯轴
27	9*1.8 GB/T3452.1-1992	O-seal ring	O 型密封圈
28	M5*8 GB/T71-1985	Screw	开槽锥端紧定螺钉
29	CQ6133-02-052	Block	拨块 A
30	M8*20 GB/T77-1985	Hexagon socket head screw	内六角螺栓
31	A6*30 GB/T117-1986	Taper pins	圆锥销
32	CQ6133-02-019	Adjust block	调整压板
33	M8*25 GB/T77-1985	Hexagon socket head screw	内六角螺栓
34	M8*10 GB/T77-1985	Set screws with cone point	内六角平端紧定螺钉
35	0.8*5*20 GB/T2089	Spring	压缩弹簧
36	6 GB/T308-1989	Steel ball	钢球
37	CQ6133-02-004	Handle seat	手柄座
38	GB/T117-1986	Taper pins	圆锥销
39	M5*16 GB/T819-1985	Screw	十字槽沉头螺钉
40	CQ6133-02-009	Localing sleeve	转向座
41	CQ6133-02-057	Washer	垫圈

42	11.2*2.65 GB/T3452.1-1992	O-seal ring	O 型密封圈
43	CQ6133-02-055	External snap ring	拨块 B
44	A10 JB/T9741.2	Oil Sight	油标
45	M10*30 GB/T77-1985	Hexagon socket head screw	内六角螺栓
46	CQ6133-02-003	Handle lever	手柄杆
47	AM8*40 JB/T7271.3-1994	Knob	手柄套
48	CQ6133-02-050	Sleeve	压盖 E
49	CQ6133-02-018	Washer	垫圈
50	12 GB/T894.1-1986	Circlips for shaft-type A	轴用挡圈
51	CQ6133-02-053	Shifting fork shaft	导向滑杆
52	CQ6133-02-055	Right shifting fork	拨叉 B
53	CQ6133-02-010	Sleeve	压盖 A
54	M10 GB/T41-1986	Nut	螺母
55	10 GB/T97.1-1985	Plain washers	平垫圈
56	CQ6133-02-033	Gear change	挂轮 A
57	FB016030 GB/T13871-1992	Felt collar	骨架橡胶密封圈
58	CQ6133-02-034	Sleeve	压盖 D
59	CQ6133-02-018	Washer	垫圈
60	6203/P6 GB/T276-1994	Taper roller bearing	深沟球轴承
61	A4*10 GB/T1096-1994	Plain parallel key	平键
62	CQ6133-02-044	Output shaft	输出轴
63	A5*60 GB/T1096-1994	Plain parallel key	平键
64	CQ6133-02-045	Gear	齿轮
65	CQ6133-02-046	Gear	齿轮
66	CQ6133-02-048	Gear	齿轮
67	CQ6133-02-049	Sleeve spacer	隔套 E
68	CQ6133-02-023	Sleeve	压盖 B
69	CQ6133-02-032	Sleeve	压盖 C
70	CQ6133-02-011	Sleeve spacer	隔套 A
71	A5*22 GB/T1096-1994	Plain parallel key	平键
72	CQ6133-02-017	Gear	齿轮
73	CQ6133-02-016	Gear	齿轮
74	CQ6133-02-015	Gear	齿轮
75	42 GB/T894.1-1986	Circlips for shaft-type A	轴用挡圈
76	22 GB/T894.1-1986	Circlips for shaft-type A	轴用挡圈
77	CQ6133-02-014	Middle shaft	滑移轴
78	6*4*10 GB/T1566-1990	Thin flat key	薄形平键
79	CQ6133-02-012	Gear	齿轮
80	CQ6133-02-013	Gear	齿轮
81	M50*1.5 GB/T812-1988	Spanner nut	圆螺母
82	50 GB/T858-1988	Lock washer for circular nut	圆螺母用止动垫圈
83	M5*20 GB/T77-1985	Hexagon socket head screw	内六角螺栓
84	CQ6133-02-036	Sleeve	后端盖
85	CQ6133-02-037	Pressurize washer	后端盖垫圈
86	CQ6133-02-035	Sleeve spacer	衬套 A

87	32010/P6X GB/T276-1994	Taper roller bearing	圆锥滚子轴承
88	55 GB/T894.1-1986	Circlips for shaft-type A	轴用挡圈
89	CQ6133-02-047	Gear	齿轮
90	32012/P5 GB/T276-1994	Taper roller bearing	圆锥滚子轴承
91	CQ6133-02-007	Pressurize washer	前端盖垫圈
92	CQ6133-02-006	Mainshaft bearing oil seal	前端盖
93	CQ6133-02-008	Lathe spindle	主轴
94	A8*16 GB/T1096-1994	Plain parallel key	平键
95	CQ6133-02-029	Sleeve spacer	隔套 C
96	CQ6133-02-028	Gear	齿轮
97	CQ6133-02-026	Sleeve spacer	隔套 B
98	CQ6133-02-027	Gear	齿轮
99	CQ6133-02-025	Gear	齿轮
100	A5*10 GB/T1096-1994	Plain parallel key	平键
101	A5*70 GB/T1096-1994	Plain parallel key	平键
102	CQ6133-02-024	Spindle shaft	输入轴
103	M8*30 GB/T77-1985	Hexagon socket head screw	内六角螺栓
104	CQ6133-02-002	Oil port plug	螺钉
105	CQ6133-02-001	Transmission cover	箱盖
106	28 GB/T894.1-1986	Circlips for shaft-type A	轴用挡圈

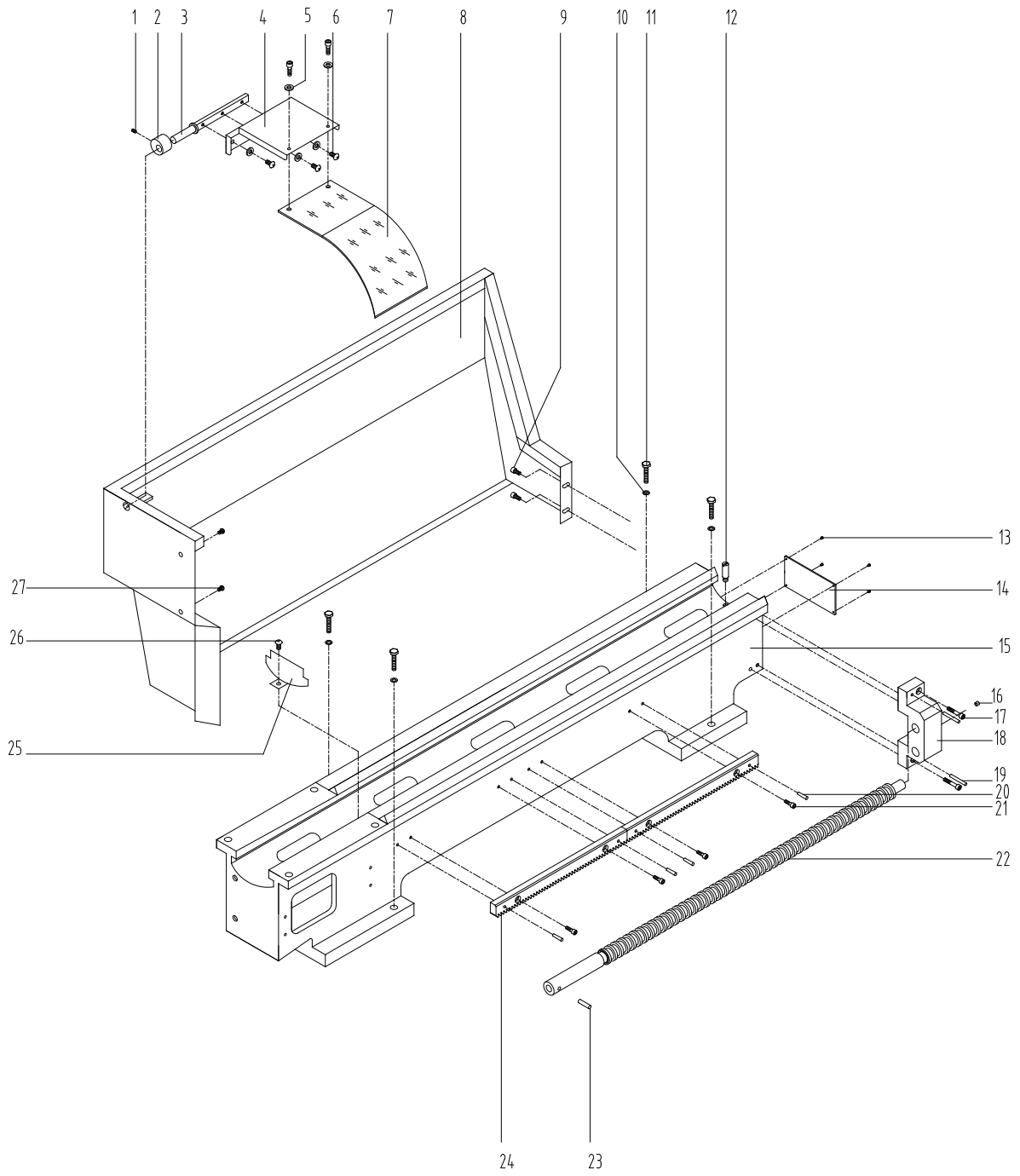
SHIFT BOX



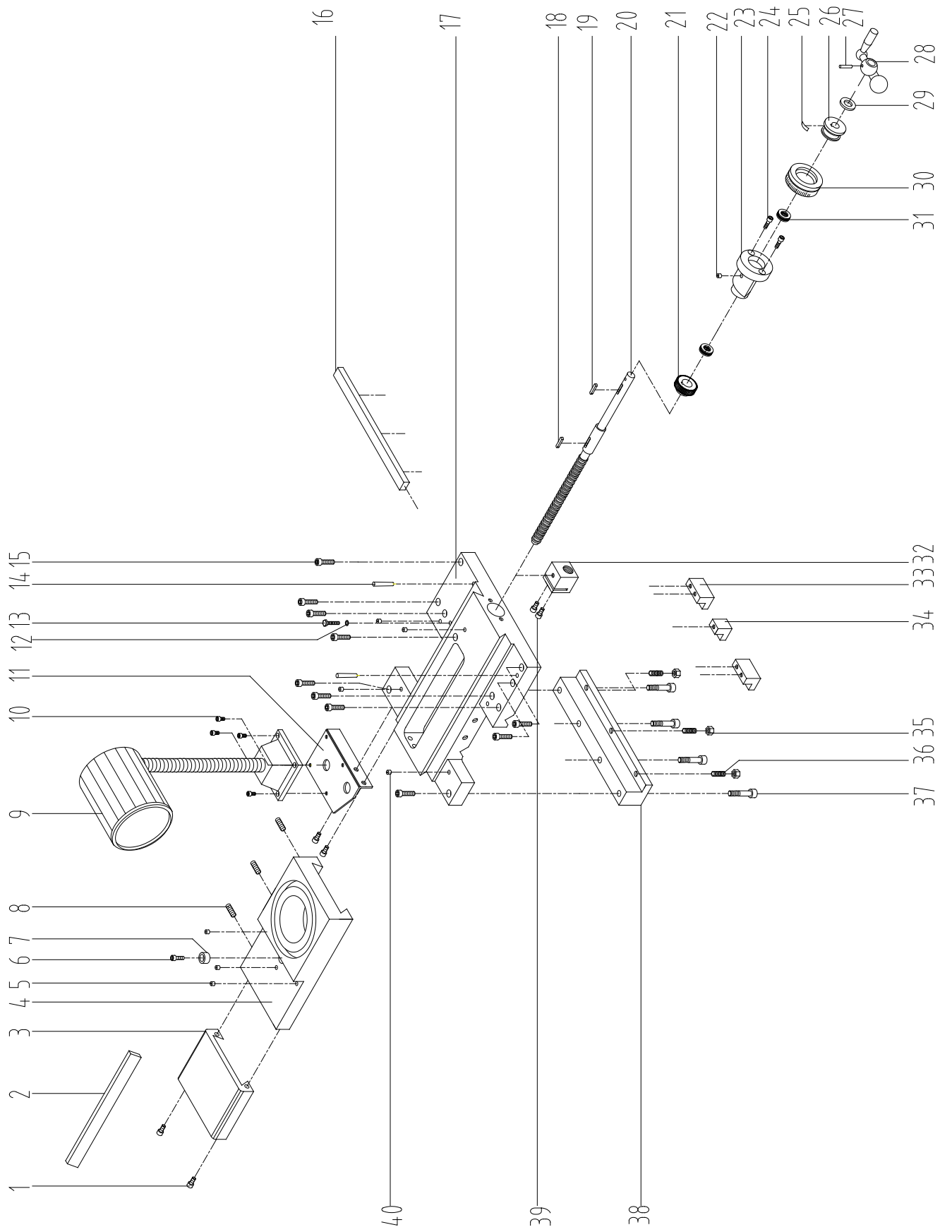
No.			
1	6 GB/T7940.4-1995	Oil cup	油杯
2	CQ6133-03-012	Apron body	箱体
3	8*40 GB/T118-1986	Taper pins	内螺纹锥销
4	M8*100 GB/T70-1985	Hexagon socket head screw	内六角螺钉
5	AM8*25JB/T7271.3-1994	Handle sleeve B-plastic	手柄套
6	CQ6133-04-019	Handle seat	手柄杆
7	CQ6133-03-027	Right shifting fork	拨叉
8	CQ6133-03-028	shaft	拨叉轴
9	CQ6133-03-001	Base	拨叉座
10	M5*12 GB/T819-1985	screw	十字沉头螺钉
11	5*50 GB/T117-1986	Taper pins	圆锥销
12	CQ6133-02-004	Handle seat	手柄座
13	6.5 GB/T308-1989	Steel ball	钢球
14	0.8*5*16 GB/T2089-1985	Spring	弹簧
15	M8*10 GB/T77-1985	screw	内六角平端紧定螺钉
16	CQ6133-03-014	Cover	闷盖
17	CQ6133-03-013	Sleeve	套
18	16 GB/T894.1-1986	Circlips for shaft-type A	轴用弹性档圈
19	CQ6133-03-024	Gear	滑移齿轮
20	CQ6133-03-022	shaft	传动轴
21	5*32 GB/T1096-1994	Key	键
22	4*24 GB/T117-1986	Taper pins	圆锥销
23	51102 GB/T301-1995	Taper roller bearing	推力球轴承
24	CQ6133-03-015	Base	轴承座
25	M5*12 GB/T70-1985	Hexagon socket head screw	内六角螺钉
26	M14*1.5 GB/T810-1988	Spanner nut	圆螺母
27	CQ6133-03-016	Sleeve	护套
28	CQ6133-03-003	Sleeve	挡圈 C
29	CQ6133-附 01-011	Gear	齿轮
30	CQ6133-03-002	Sleeve spacer	轴套
31	5*10 GB/T1096-1994	Key	键
32	CQ6133-03-026	Change gear plate	挂轮架
33	CQ6133-03-008	Sleeve	连接座
34	4*10 GB/T1096-1994	Key	键
35	CQ6133-03-020	shaft	输入轴
36	5*40 GB/T1096-1994	Key	键
37	CQ6133-03-009	Gear	齿轮
38	CQ6133-03-010	Sleeve spacer	隔套
39	CQ6133-03-011	Gear	齿轮
40	Φ2.5*24	shaft	滚针
41	CQ6133-03-004	shaft	滚针轴
42	CQ6133-03-005	Sleeve	挡圈 A
43	CQ6133-附 01-006	Gear	齿轮

44	CQ6133-附 01-010	Gear	齿轮
45	CQ6133-03-029	Sleeve	滚针套
46	5*22 GB/T1096-1994	Key	键
47	CQ6133-03-006	Sleeve	挡圈 B
48	CQ6133-03-007	T Nut	T 型螺母
49	CQ6133-03-021	shaft	中间轴
50	5*16GB/T1096-1994	Key	键
51	CQ6133-03-023	Gear	齿轮
52	M10 GB/T41-1986	Nut	螺母
53	10 GB/T97.1-1985	Plain washers	平垫圈
54	CQ6133-03-025	screw	支承螺钉

Parts Diagram-Lathe Bed



No.		BED	
1	M6*12 GB/T77-1985	Hexagon socket head screw	内六角螺钉
2	CQ6133-02T01-002		偏心套
3	CQ6133-02T01-001		开关杆
4	CQ6133-02T01-004		连接板
5	5 GB/T96-1985	Plain washers	平垫圈
6	M5*12 GB/T818-1985		十字盘头螺钉
7	CQ6133-02T01-003		挡板
8	CQ6133-01-014		挡屑板
9	M6*10 GB/T77-1985	Hexagon socket head screw	内六角螺钉
10	10 GB/T96-1985	Plain washers	平垫圈
11	M10*50 GB	Hexagon head screw	六角螺栓
12	CQ6133-01-018	Pin	挡销
13	2.5*5 GB/T96-1986		铝铆钉
14	CQ6133-01-017	Table	导轨淬火标牌
15	CQ6133-01-011	Bed	床身
16	6 GB/T7940.4-1995	Oil cup	油杯
17	M8*25 GB/T77-1985	Hexagon socket head screw	内六角螺钉
18	CQ6133-01-015	Right pedestal	丝杠座
19	4*24 GB/T117-1986	Taper pins	圆锥销
20	6*35 GB/T117-1986	Taper pins	圆锥销
21	M8*20 GB/T77-1985	Hexagon socket head screw	内六角螺钉
22	CQ6133-01-009	Longitudinal feed screw	纵向丝杠
23	6*35 GB/T117-1986	Taper pins	圆锥销
24	CQ6133-01-012	Racks	齿条
25	CQ6133-01-019	Shield	挡板
26	M6*8 GB/T77-1985	Hexagon socket head screw	内六角螺钉
27	M6*8 GB/T77-1985	Hexagon socket head screw	内六角螺钉

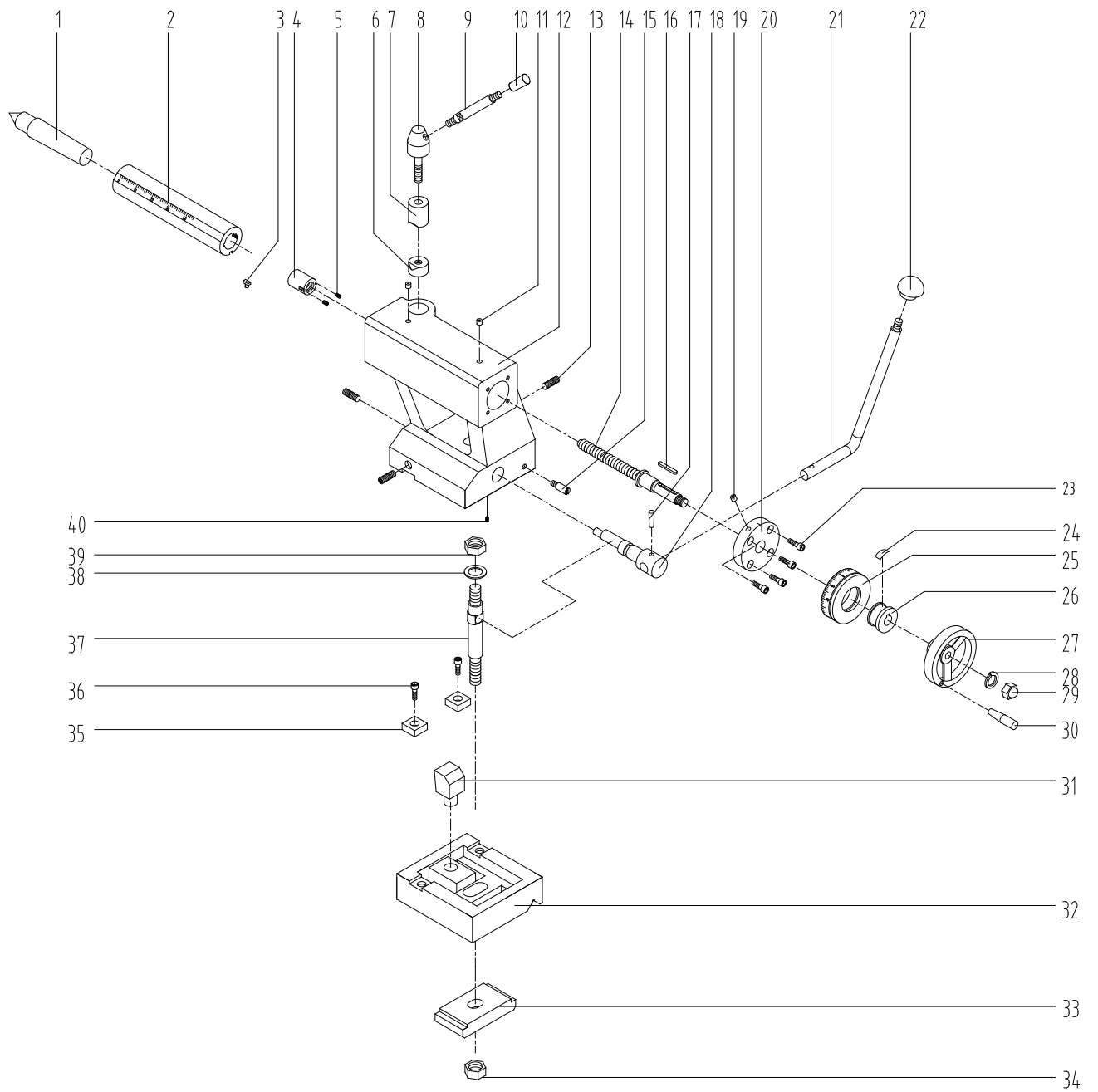


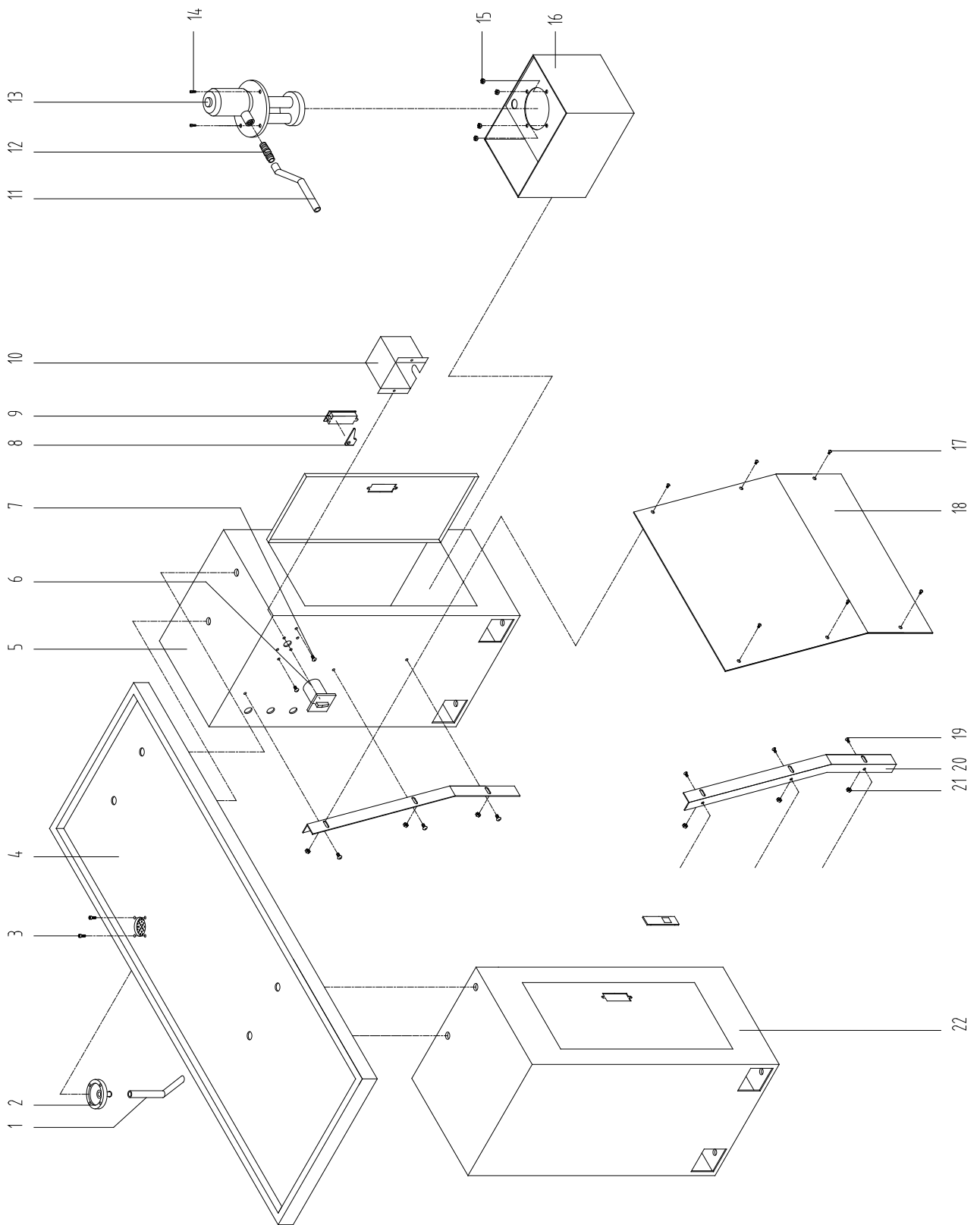
No.			
1	M8*30 GB/T77-1985	Hexagon socket head screw	内六角螺钉
2	CQ6133-05-003	Chock	镶条
3	CQ6133-05-005	Shield	护罩
4	CQ6133-05-002	Middle carriage	上拖板
5	6 GB/T7940.4-1995	Oil cup	油杯
6	M6*12 GB/T77-1985	Hexagon socket head screw	内六角螺钉
7	CQ6133-05-009	Washer	套
8	M6*20 GB1779-1985	Set screws with cone point	内六角锥端紧定螺钉
9	24V 50W	Lamp	工作灯
10	M5*10 GB/T77-1985	Hexagon socket head screw	内六角螺钉
11	CQ6133-07-010	Lamp table	灯座
12	6 GB/T97.1-1985	Plain washers	平垫圈
13	M6*40 GB5782-1986	Hexagon head bolts	六角螺钉
14	6*40 GB/T117-1986	Taper pins	圆锥销
15	M6*35 GB/T77-1985	Hexagon socket head screw	内六角螺钉
16	CQ6133-05-007	Chock	镶块
17	CQ6133-05-001	Carriage	大拖板
18	4*16 GB/T1096-1994	Plain parallel key	平键
19	4*16 GB/T1096-1994	Plain parallel key	平键
20	CQ6133-05-010	Cross feed screw rod	横向丝杠
21	CQ6133-05-013	Gear	齿轮
22	6 GB/T7940.4-1995	Oil cup	油杯
23	CQ6133-05-014	Cross feed screw seat	丝杠座
24	M6*60 GB/T77-1985	Hexagon socket head screw	内六角螺钉
25	51101 GB/T301-1995	Rolling bearing	推力球轴承
26	CQ6133-04-022	Dial sleeve	刻度环芯套
27	4*25 GB/T117-1986	Taper pins	圆锥销
28	B12*40 GB4141.9-84	Handles with sleeve	对重手柄
29	12 GB/T97.1-1985	Plain washers	平垫圈
30	CQ6133-05-015	Dial	刻度环
31	CQ6133-04-021	Spring lamination	簧片
32	CQ6133-05-008	Cross nut	丝杠螺母
33	CQ6133-05-011	Chain up block	压块
34	CQ6133-05-004	Forward board	镶块
35	M8 GB/T41-1985	Hexagon nuts	螺母
36	M8*30 GB1779-1985	Set screws with cone point	内六角锥端紧定螺钉
37	M8*45 GB/T77-1985	Hexagon socket head screw	内六角螺钉
38	CQ6133-05-006	Behind board	压条
39	M5*14 GB/T77-1985	Hexagon socket head screw	内六角螺钉
40	6 GB/T7940.4-1995	Oil cup	油杯

No.			
1	M10 GB923-1988	Domed cap nuts	盖形螺母
2	10 GB/T923-1976	Spring washer	弹性垫圈
3	JB/T7270.4-1994	Sleeve	套
4	B12*125 JB/T7273.3-1994	Hand wheel	手轮
5	CQ6133-04-022	Sleeve	刻度环芯套
6	CQ6133-04-021	Spring lamination	簧片
7	CQ6133-04-020	Dial	刻度环
8	M4*20 GB70-85	Hexagon socket head screw	内六角螺钉
9	CQ6133-04-023	Flange sleeve	手轮座
10	AM8*25JB/T7271.3-1994	Handle sleeve B-plastic	手柄套
11	CQ6133-04-019	Handle lever	手柄杆
12	CQ6133-04-006	Sleeve	保险轴套
13	CQ6133-04-007	Gear	扇形齿轮
14	CQ6133-04-005	Middle gear	过桥齿轮
15	M6*25 GB70-85	Hexagon socket head screw	内六角螺钉
16	CQ6133-04-003	Sleeve	过桥齿轮套
17	M5*10 GB/T78-1985	Set screws with cone point	内六角锥端紧定螺钉
18	4*6 GB/T119-1986	Plain parallel	圆柱销
19	CQ6133-04-008	Axis	保险轴
20	CQ6133-04-004	Shaft	过桥齿轮轴
21	M6*20 GB/T78-1985	Screws	内六角锥端紧定螺钉
22	CQ6133-04-009	Geet in to plain parallel	勾头键
23	CQ6133-04-025	Worm shaft	蜗杆
24	GB/T301-1995	Thrust ball bearing	推力球轴承 51106
25	CQ6133-04-010	Worm shaft	蜗杆轴座
26	M5*12 GB/T70-1985	Hexagon socket head screw	内六角螺钉
27	30 GB/T858-1988	Lock washer	圆螺母用止动垫圈
28	M30*1.5 GB/T810-1988	Round nut	圆螺母 M30*1.5
29	CQ6133-01-010	Safe shield	丝杠护板(左)
30	M5*10 GB/T70-1985	Hexagon socket head screw	内六角螺钉
31	CQ6133-04-026	Gear	齿轮
32	CQ6133-04-011	Slippage shaft	光轴
33	M6*8 GB/T77-1985	Screws	内六角平端紧定螺钉
34	0.8*4*12 GB/T2089-1985	Spring	弹簧
35	∅ 5 GB/T308-1989	Steel ball	钢球
36	CQ6133-04-002	Shifting fork	齿拨叉
37	CQ6133-04-032	Shifting fork shaft	档位轴
38	5*25 GB/T1096-1979	Plain parallel	键 5*25
39	CQ6133-04-026	Gear	齿轮
40	6*12 GB/T1096-1994	Plain parallel	键 6*12
41	CQ6133-04-030	Gear	齿轮
42	GB/T1096-1994	Plain parallel	键 6*12
43	CQ6133-04-029	Worm gear	蜗轮

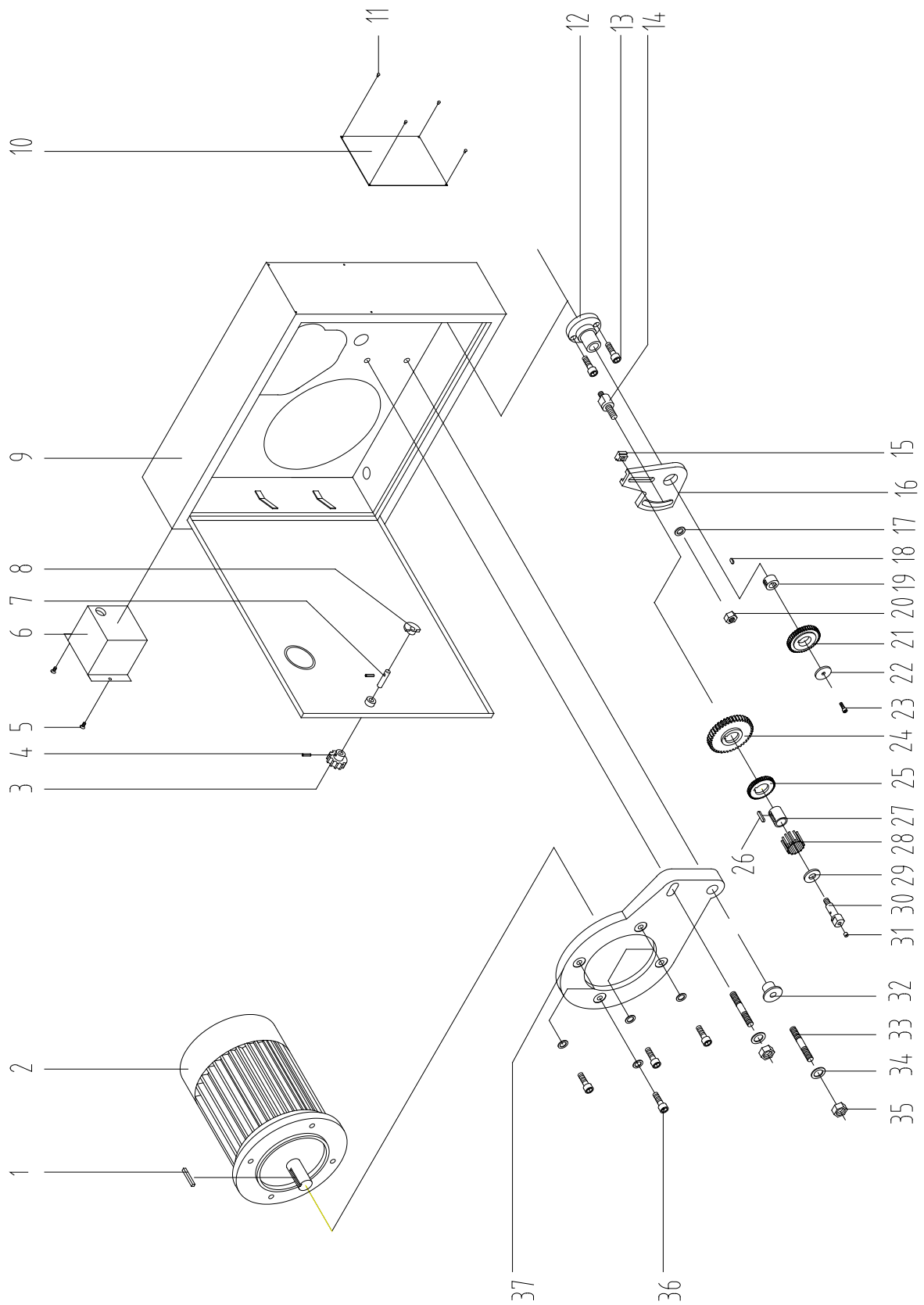
44	M6*10 GB/T79-1985	Screws	内六角柱端紧定螺钉
45	CQ6133-04-028	Sleeve	限位套
46	CQ6133-04-027	Gear shaft	齿轴
47	M5*35 GB/T70-1985	Hexagon socket head screw	内六角螺钉
48	CQ6133-04-016	Shaft	开合轴
49	6*15 GB/T119-1986	Column pins	圆柱销
50	CQ6133-04-014	Screw nut	开合螺母
51	CQ6133-04-015	Chock	镶条
52	M4*8 GB	Screw	十字沉头螺钉
53	CQ6133-04-013	Cover	底盖
54	CQ6133-04-033	Apron body right cover	镶块
55	CQ6133-01-013	Safe shield	丝杠护板(右)
56	M5*25 GB/T78-1985	Screw	内六角锥端紧定螺钉
57	M5 GB/T41-1985	Hexagon nuts	六角螺母
58	M5*22 GB/T75-1985	Screw	圆柱端紧定螺钉
59	CQ6133-0-0	Table	开合螺母标牌
60	2.5*5 GB/T96-1986	Rivet	铝铆钉
61	M8*25 JB/T7271.3-1994	Handle sleeve B-plastic	手柄套
62	CQ6133-04-019	Handle lever	手柄杆
63	5*50 GB/T117-1986	Taper pins	圆锥销
64	M8*10 GB/T77-1985	Screw	内六角平端紧定螺钉
65	0.8*5*16 GB/T2089-1985	Spring	弹簧
66	∅ 6.5 GB/T308-1989	Steel ball	钢球
67	CQ6133-04-018	Handle seat	开合手柄座
68	M4*12 GB/T68-1985	Screw	十字沉头螺钉
69	CQ6133-04-017	Sleeve	开合轴座
70	4*28 GB/T1096-1994	Plain parallel	键
71	CQ6133-04-024	Gear shaft	手轮轴
72	GB/T7940.4-1995	Oil cup	油杯 8
73	CQ6133-04-012	Sleeve	齿轴套
74	M5*10 GB/T78-1985	Screw	内六角锥端紧定螺钉 M5*10
75	CQ6133-04-001	Apron body	箱体

No.		TAILSTOCK	
1	3#	Rooring Center	死顶针
2	CQ6133-06-002	Tailstock center sleeve	尾架套筒
3	CQ6133-06-021	T-Key	T 型键
4	CQ6133-06-004	Tailstock Nuts	丝杠螺母
5	M6*10 GB/T78-1985	Set screws with cone point	内六角紧定螺钉
6	CQ6133-06-008	Locking nuts	锁紧块 A
7	CQ6133-06-008	Locking Sleeve	锁紧块 B
8	CQ6133-06-001	Handle seat	刹紧手柄座
9	CQ6133-04-019	Handle seat	手柄杆
10	M25*8 JB/T7271.3-1994	Long sleeve knob	手柄套
11	6 GB/T7940.4-1995	Oil cup	油杯
12	CQ6133-06A-007	Tailstock	尾架壳体
13	M10*40 GB/T77-1985	Set screws with cone point	内六角紧定螺钉
14	CQ6133-06-003	Tailstock screw stem	尾架丝杠
15	CQ6133-06-011	Pin	挡销
16	4*28 GB/T1096-1994	Plain parallel key	平键
17	8*25 GB/T117-1986	Taper pins	圆锥销
18	CQ6133-06-001	Shaft	偏心轴
19	6 GB/T7940.4-1995	Oil cup	油杯
20	CQ6133-06-005	Sleeve	丝杠座
21	CQ6133-06A-009	Handle lever	刹紧手柄
22	M10*32 JB/T7271.1-1994	Handke ball	手柄球
23	M5*20 GB/T70-1985	Hexagon socket head screw	内六角螺钉
24	CQ6133-04-021	Spring lamination	簧片
25	CQ6133-06-006	Dial	刻度环
26	CQ6133-04-022	Sleeve	刻度环芯套
27	B12*250 JB/7273.3-1994	Hand wheel	手轮
28	12 GB/T97.1-1985	Plain washers	平垫圈
29	M10 GB/T923-1976	Domed cap nuts	盖形螺母
30	B12*250 JB/7273.3-1994	Handles with sleeve	手柄
31	CQ6133-06-018	Base	定位座
32	CA6133-06A-017	Tailstock carriage	尾架底板
33	CA6133-06-019	Chock	压板
34	M12 GB/T41-1985	Hexagon thin nuts	螺母
35	CQW6133-06-012	Block	定位块
36	M5*16 GB/T70-1985	Hexagon socket head screw	内六角螺钉
37	CQ6133-06A-020	Pull pole set	双头螺栓
38	12 GB/T97.1-1985	Plain washers	平垫圈
39	M12 GB/T41-1985	Hexagon nuts	六角螺母
40	M6*14 GB1779-1985	Set screws with cone point	内六角紧定螺钉

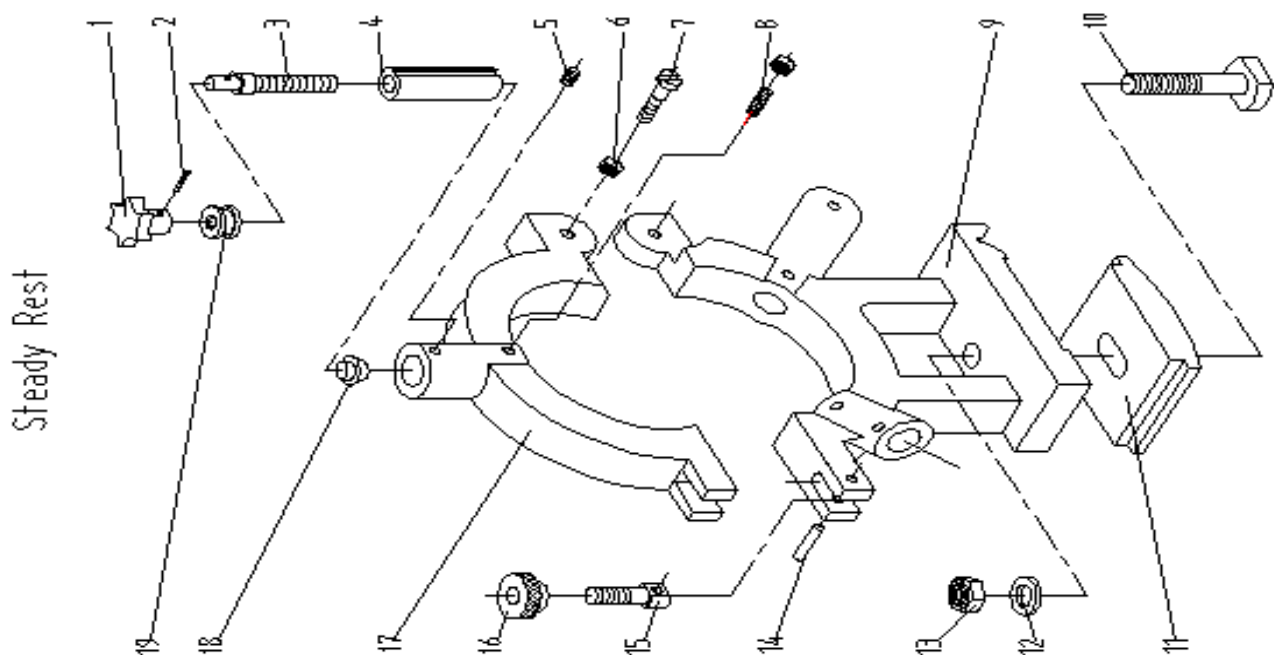




No.		STAND	
1		Water pipe	回水管
2	CQ6133-07-005		集水盘
3	M5*8 GB/T819-1985	Screw	十字盘头螺钉
4	CQ6133-01-016	Oil	油盘
5	CQ6133-07-002	Right stand	右底座
6		Pump switch	水泵转换开关
7	M5*8 GB/T819-1985	Screw	十字盘头螺钉
8			锁舌
9		Door lock	门锁
10	CQ6133-07-006		电器安全罩
11		Water pipe	出水管
12	CQ6133-07-007		水泵接管
13		Pump	水泵
14	M5*20 GB/T819-1985	Screw	十字盘头螺钉
15	M5 GB/T41-1985	Nut	螺母
16	CQ6133-07-008	Water box	水箱
17	M6*15 GB/T819-1985	Screw	十字盘头螺钉
18	CQ6133-07-003		连接板
19	M6*10 GB/T819-1985	Screw	十字盘头螺钉
20	CQ6133-07-004		连接条
21	M6 GB/T41-1985	Hexagon thin nuts	螺母
22	CQ6133-07-001	Left stand	左底座

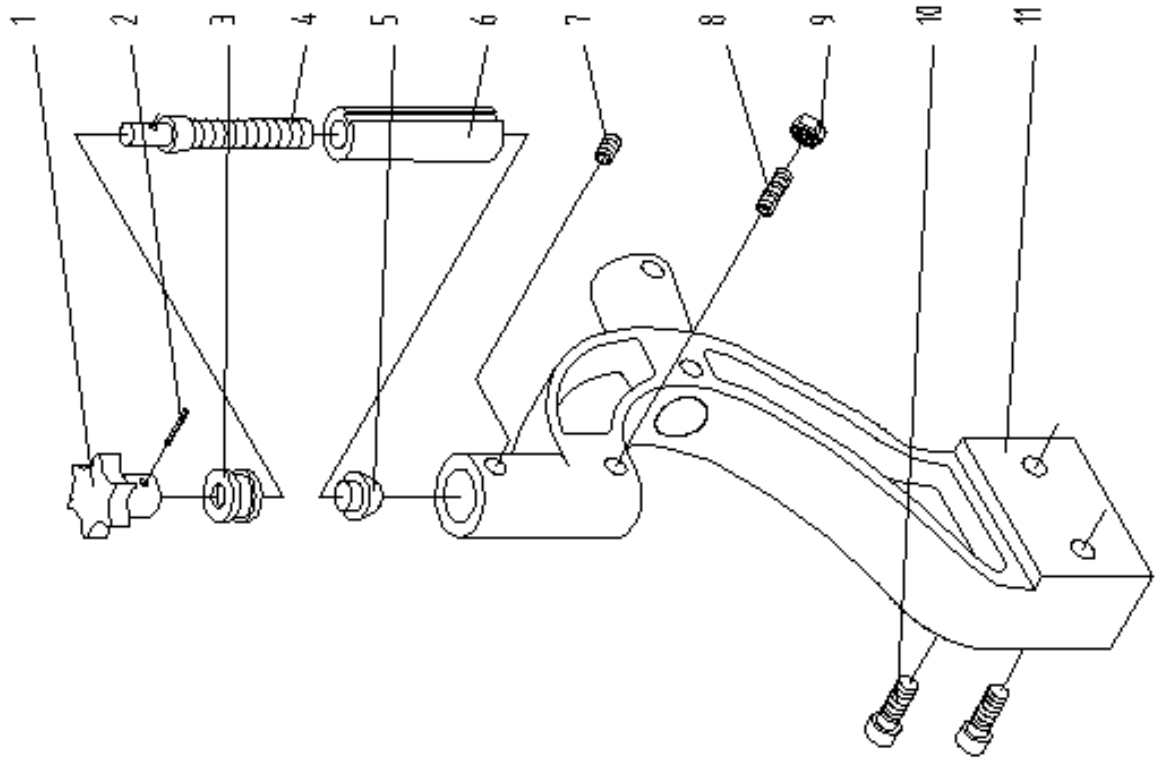


No.			
1	A8*30 GB/T1096-1994	Plain parallel key	平键
2	Y90S-4 B5 1.1KW	220V Mount,50HZ	电动机
3	8*32 JB/T7274.4-1994	Start-grip knob	星形把手
4	3*14 GB/T879-1986	Taper pins	弹性销
5	M5*8 GB/T819-1985	Screw	十字盘头螺钉
6	CQ6133-01-019	Safe box	电器安全罩
7	CQ6133-01-005	Shaft	销轴
8	CQ6133-01-003	Door-knob	锁紧块
9	CQ6133-01-001/002	Compound box	车头护罩
10		Thread table	挂轮表标牌
11	2.5*5 GB/T827-1986	Rivet	铝铆钉
12	CQ6133-03-008	Sleeve	连接座
13	M5*12 GB/T70-85	Hexagon socket head screw	内六角螺钉
14	CQ6133-03-025	Screw	支承螺钉
15	CQ6133-03-007	T-nut	T 型螺母
16	CQ6133-03-026	Change gear plate	挂轮架
17	10 GB/T97.1-1985	Plain washers	平垫圈
18	M10 GB/T41-1985	Hexagon thin nuts	螺母
19	CQ6133-03-002	Sleeve	轴套
20	CQ6133-附 01-011	Gear	齿轮
21	CQ6133-03-003	Sleeve	挡圈 C
22	M5*10 GB/T70-1985	Hexagon socket head screw	内六角螺钉
23	5*10 GB/T1096-1994	Plain parallel key	平键
24	CQ6133-附 01-010	Gear	齿轮
25	CQ6133-附 01-006	Gear	齿轮
26	5*22 GB/T1096-1994	Plain parallel key	平键
27	CQ6133-03-029	Sleeve	滚针套
28	∅ 2.5*24	Roller	滚针
29	CQ6133-03-005	Sleeve	挡圈 A
30	CQ6133-03-004	Shaft	滚针轴
31	6 GB/T7940.4-1995	Oil cup	油杯
32	CQ6133-01-007	Sleeve	转套
33	M10*52 GB/T898-1988	Screw	双头螺栓
34	10 GB/T97.1-1985	Plain washers	平垫圈
35	M10 GB/T41-1985	Hexagon nuts	螺母
36	M8*20 GB/T70-1985	Hexagon socket head screw	内六角螺钉
37	CQ6133-013-008	Motor mount plate	电机托架



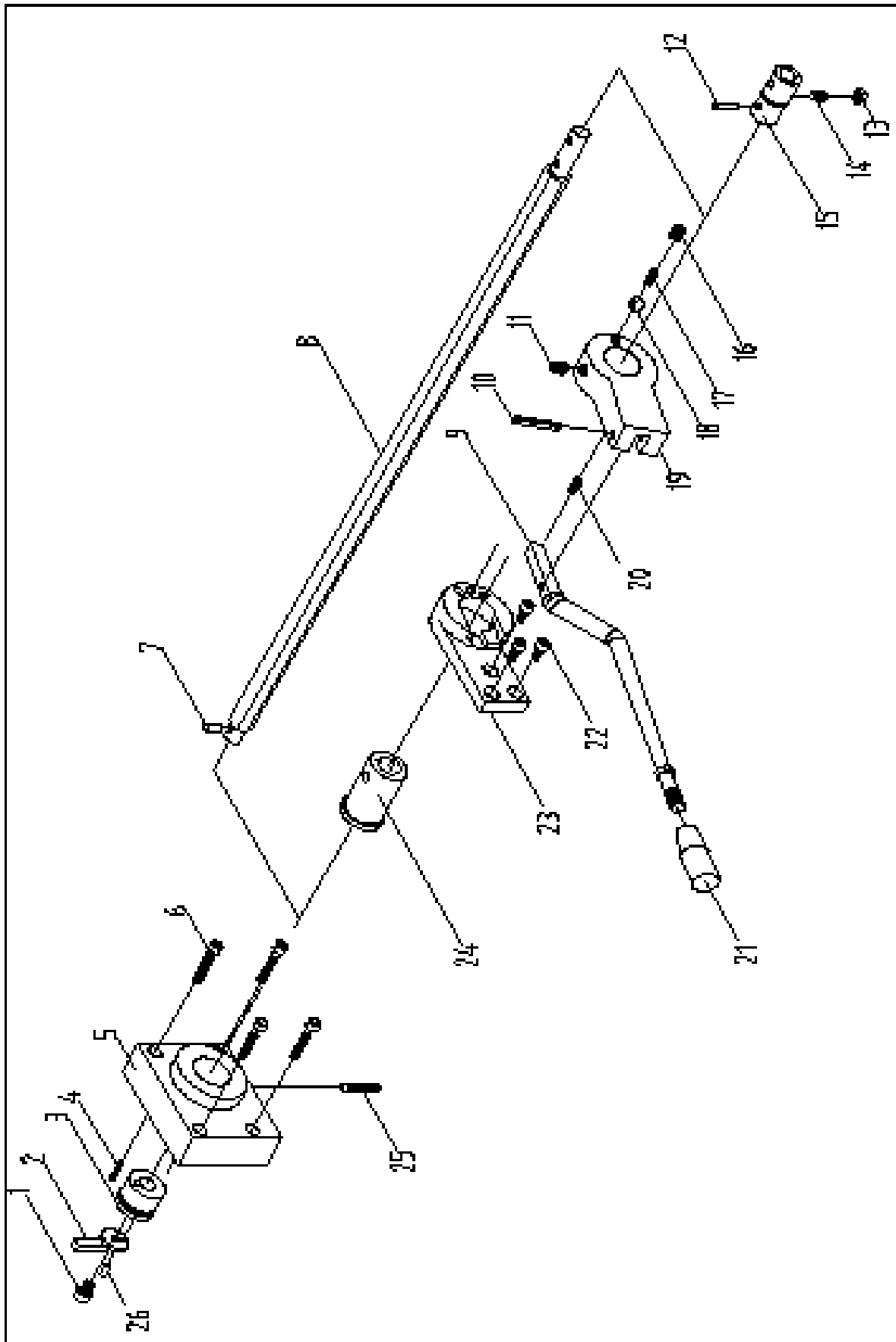
No.	DESCRIPTION		
	CQ6133		
1	8*40 JB/T7274.4-1994	Start-grip knob	星形把手
2	3*18 GB/T879-1986	Taper pins	弹性销
3	CQ6133-01T01-008	Adjusting bolt	调整螺杆
4	CQ6133-01T02-002	Sleeve	芯套
5	M6*8 GB/T77-2000	Screw	平端紧定螺钉
6	M6 GB/T41-2000	Nut	六角螺母
7	CQ6133-01T01-004	Screw	轴位螺钉
8	M6*16 GB/T79-2000	Screw	圆柱端紧定螺钉
9	CQ6133-01T01-001	Stand	底座
10	M12*70 GB/T5780-2000	Screw	六角螺栓
11	CQ6133-06-019	Block	压板
12	12 GB/T96-2000	Washer	平垫圈
13	M12 GB/T41-2000	Nut	六角螺母
14	5*25 GB/T119-2000	Pins	圆柱销
15	CQ6133-01T01-002	shaft	锁紧杆
16	CQ6133-01T01-003	Nut	锁紧螺母
17	CQ6133-01T01-005	Cover	上盖
18	CQ6133-01T01-006	Bracket	衬垫
19	CQ6133-01T01-009	Sleeve	定位套

Follow Rest



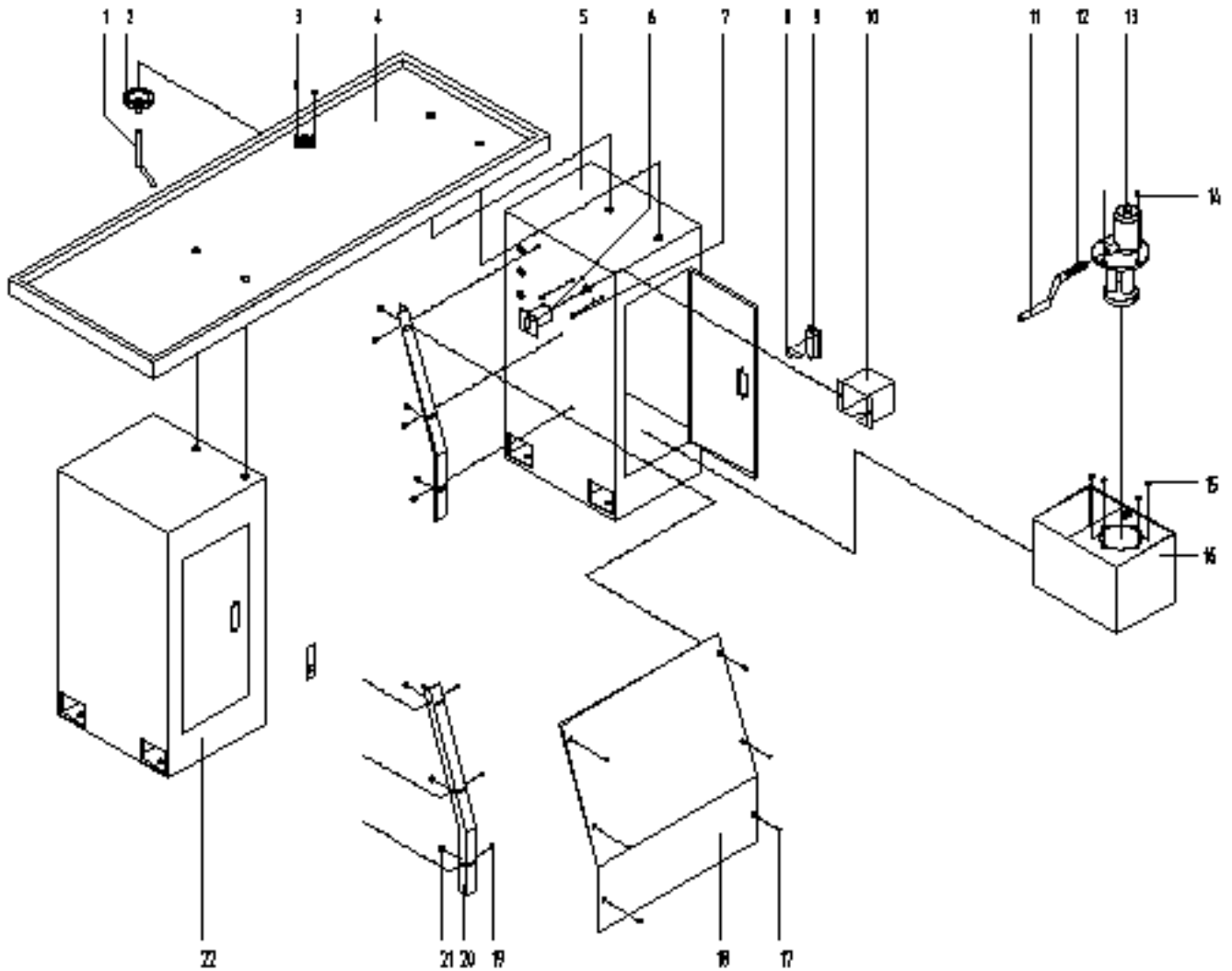
1	8*40 JB/T7274.4-1994	Start-grip knob	星形把手
2	3*18 GB/T879-1986	Taper pins	弹性销
3	CQ6133-01T01-009	Bush	定位套
4	CQ6133-01T02-003	Adjusting bolt	调整螺杆
5	CQ6133-01T01-006	Bracket	衬垫
6	CQ6133-01T02-002	Sleeve	芯套
7	M6*8 GB/T77-2000	Screw	平端紧定螺钉
8	M6*15 GB/T79-2000	Screw	圆柱端紧定螺钉
9	M6 GB/T41-2000	Nut	螺母
10	M8*40 GB/T70-85	Hexagon socket head screw	内六角螺钉
11	CQ6133-01T02-001	Follow rest	跟刀架

Parts Diagram-Lathe Handle



Parts Listing-Lathe Handle

	Parts NO.	Description
1	M6*12 GB/T70.1-2000	Hexagon socket head screw
2	CQ6133-08-003A	Block
3	CQ6133-08-004A	Collar
4	M2.5*16 GB/T818-2000	Crossrecessed pan head screws
5	CQ6133-08-005A	Box
	M5*30 GB/T70.1-2000	Hexagon socket head screw
7	A5*12 GB/T117-1986	Taper pins
8	CQ6133-08-001A	Shaft
9	CQ6133-08-008A	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	CQ6133-08-009A	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	CQ6133-08-002A	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	CQ6133-08-007A	Bracket
24	CQ6133-08-006A	Collar
25	M6*30 GB/T79-2000	Hexagon socket head screw
26	3*10 GB/T879-1986	Taper pins



WARRANTY

Warrants every product to be free from defects in materials and agrees to correct such defects where applicable. This warranty covers two years for part 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 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. 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.

RETEURNS, REPAIRS AND REPLACEMENTS

To return, repair, or replace a 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(2474), 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 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.**