

CENTRAL MACHINERY

®

Lathe Stand

Model 95647

(For Use With Item 43681 - Gap Bed Lathe)



(Lathe Not Included)

Assembly & Operating Instructions

www.harborfreight.com



3491 Mission Oaks Blvd. / Camarillo, CA 93011

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For technical questions and replacement parts, please call 1-800-444-3353.

SPECIFICATIONS

Material	Mild Steel
Frame Metal Thickness	.11" Thick Carbon Steel
Left Cabinet Inside Dimensions	14-1/4" L x 13-1/4" W x 21-31/32" H
Right Cabinet Inside Dimensions	9-1/4" L x 13-1/4" W x 21-31/32" H
Overall Dimensions	66-15/16" L x 22-13/16" W x 27" H
Max Weight Capacity	1,320 lbs.
This Lathe Stand is designed for use ONLY with the 12" x 37" Gap Bed Lathe (SKU 43681)	

SAVE THIS MANUAL

You will need the manual for the safety warnings and cautions, assembly instructions, operating procedures, maintenance procedures, trouble shooting, parts list, and diagram. Keep your invoice with this manual. Write the invoice number on the inside of the front cover. Keep both this manual and your invoice in a safe, dry place for future reference.

READ ALL INSTRUCTIONS BEFORE USING THIS STAND!

NOTICE

The Warnings, Cautions, and Instructions discussed in this instruction manual cannot cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.

SAFETY WARNING & CAUTIONS

READ ALL INSTRUCTIONS BEFORE USING THIS STAND!

1. **KEEP WORK AREA CLEAN.** Cluttered areas invite injuries.
2. **OBSERVE WORK AREA CONDITIONS.** Do not use tools in damp, wet, or poorly lit locations. Don't expose to rain. Keep work area well lit. Do not use electrically powered equipment in the presence of flammable gases or liquids.
3. **KEEP CHILDREN AWAY.** Children must never be allowed in the work area. Do not let them handle machines, tools, or equipment.
4. **STORE IDLE EQUIPMENT.** When not in use, tools must be locked up in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
5. **DO NOT FORCE OR MODIFY THE STAND.** It will do the job better and more safely at the rate for which it was intended. Do not use inappropriate attachments in an attempt to exceed the Stand's capacities.
6. **DESIGNED EXCLUSIVELY FOR USE WITH ITEM 43681--Gap Bed Lathe. STAND IS UNSTABLE WITHOUT LATHE.** Do not use with other machines or loads.
7. **DRESS PROPERLY.** Do not wear loose clothing or jewelry, as they can be caught in moving parts. Non-skid footwear is recommended. Wear restrictive hair covering to contain long hair. Always wear appropriate work clothing.
8. **USE EYE, EAR AND BREATHING PROTECTION.** Always wear ANSI approved impact safety goggles if you are producing metal filings or wood chips. Wear an ANSI approved dust mask or respirator when working around metal, wood, and chemical dusts and mists. Use ANSI approved ear protection when working in a loud or noisy environment.
9. **READ MANUAL.** Read manual for the Stand and for the Lathe (SKU 43681) before assembly and/or use.
10. **DO NOT OVERREACH.** Keep proper footing and balance at all times. Do not reach over or across running machines.
11. **ASSEMBLE AND INSTALL ON A LEVEL, FLAT AND CONCRETE SURFACE CAPABLE OF SUPPORTING STAND, LATHE AND ALL WORKPIECES.** Bolt the Stand to the concrete securely and ensure the Stand is square and stable before installing the Lathe.
12. **DO NOT EXCEED THE MAXIMUM WEIGHT CAPACITY OF 1,320 POUNDS.** Place Lathe on Stand in a careful and controlled fashion; dropping the Lathe on the Stand may briefly create an excess load, resulting in Stand failure and possible damage and/or personal injury.

13. **STAY ALERT.** Watch what you are doing. Do not operate Lathe or assemble or setup this Stand when you are tired.

14. **DO NOT ASSEMBLE WHILE UNDER THE INFLUENCE OF ALCOHOL, DRUGS, OR PRESCRIPTION MEDICINES.**

15. **CHECK FOR DAMAGED PARTS.** Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment and binding of moving parts, any broken parts or mounting fixtures, and any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician. Do not use the tool if any switch does not turn on and off properly.

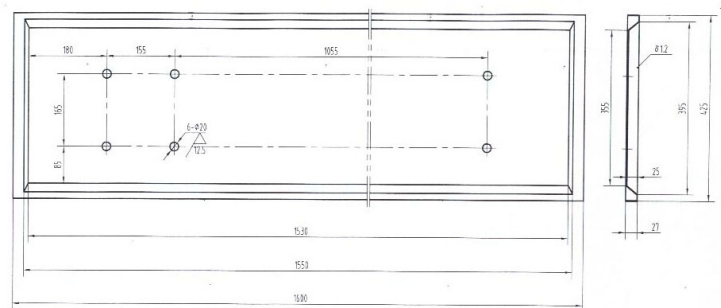
16. **REPLACEMENT PARTS AND ACCESSORIES.** When servicing, use only identical replacement parts intended for use with this tool. Replacement parts are available from Harbor Freight Tools. Use of any other parts will void the warranty.

ASSEMBLY INSTRUCTIONS

PLEASE REFER TO THE ASSEMBLY DIAGRAM AND PARTS LIST ON PAGES 6 AND 7 OF THIS MANUAL AND TO THE MANUAL FOR THE 43681 LATHE

1. Position the Headstock Stand (1) and Tailstock Stand (11) on the shop floor. Place the Headstock Stand (1) on the left, and Tailstock (11) on the right in the position you intend to operate the machine. Be sure the doors face front.
2. Using the included hardware, fasten the Headstock Connecting Strip (2) to the Headstock Stand (1) and the Tailstock Connecting Strip (12) to the Tailstock Stand (11). Then fasten the Connecting Plate (4) to the two stands.
3. Compare the center-to-center distance of the mounting holes in the tops of the stands to the same distance of the mounting holes in the headstock and tailstock of the 43681 Lathe (not included). Adjust the stands so these distances are equal. *See Figure 1*

Figure 1. Overall dimensions of Lathe's oil tray. The mounting holes on the oil tray should align with the mounting holes on Headstock and Tailstock Stands.



4. Check to be sure that the stands are level and stable on the shop floor. If you need to repair the floor, do it now to be sure you have a solid, level surface to mount the machine.

- Once the Stands are positioned properly on a solid level floor, place the Lathe's oil pan on them. Align the mounting holes in the oil pan with the holes in the Stands. If needed, place shims (not included) between the oil/chip tray and the Lathe Stands. Check the level and position of the Stands again to be sure that when the Lathe is positioned on the stands and chip tray it will be level, solid and aligned with the mounting holes in the Stands and tray.

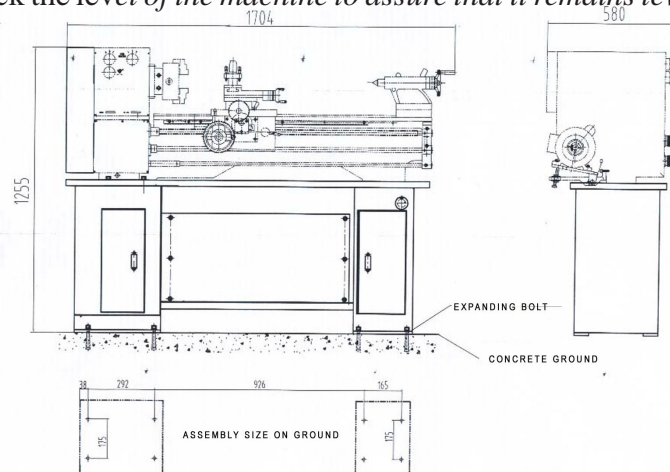
HOISTING AND LEVELING LATHE ONTO STAND

WARNING: DO NOT ATTEMPT TO LIFT THE LATHE BY YOURSELF.

The 43681 Lathe weighs over 800 Lbs., and cannot be lifted safely by one or several strong men. Be sure the Lathe is balanced on the hoist or lift you will use to move it before moving the Lathe.

- Before hoisting, lifting or moving the Lathe, move the tailstock and apron to the far right end of the bedway (away from the headstock) and lock them in place there. This will help to balance the overall mass of the machine near the center.
- Use pads (not included) to protect the machine from damage by the equipment used to hoist it.
- Use a hydraulic lift, fork lift, or hoist to position the Lathe onto the Stand. Read and adhere to all safety warnings and instructions provided by the manufacturer of the lifting device that is being used.
- When the lathe is positioned on the oil tray and Stand, align the mounting holes and drop in the mounting bolts.
- Check the level of the machine. Using a spirit level, check to be sure that the bed of the lathe is level both horizontally and front to back. If there is any out of level, correct it now. Depending on your installation, use angled iron levelers (shims) to adjust the machine into exact level front to back and side to side. Check both ends of the tool before being satisfied. Be sure the machine is level, positioned solidly, and is resistant to vibration.
- Fasten the lathe to the Stand and the Lathe's oil tray by inserting a bolt through a lock washer from the inside of the Stand and upward through the oil tray and lathe. Fasten with a washer and nut. Repeat this for each of the four mounting holes in the headstock, and both mounting holes in the tailstock. Tighten securely. Recheck and readjust level if required.

NOTE: Periodically recheck the level of the machine to assure that it remains level while it is in use.



Stand Parts List

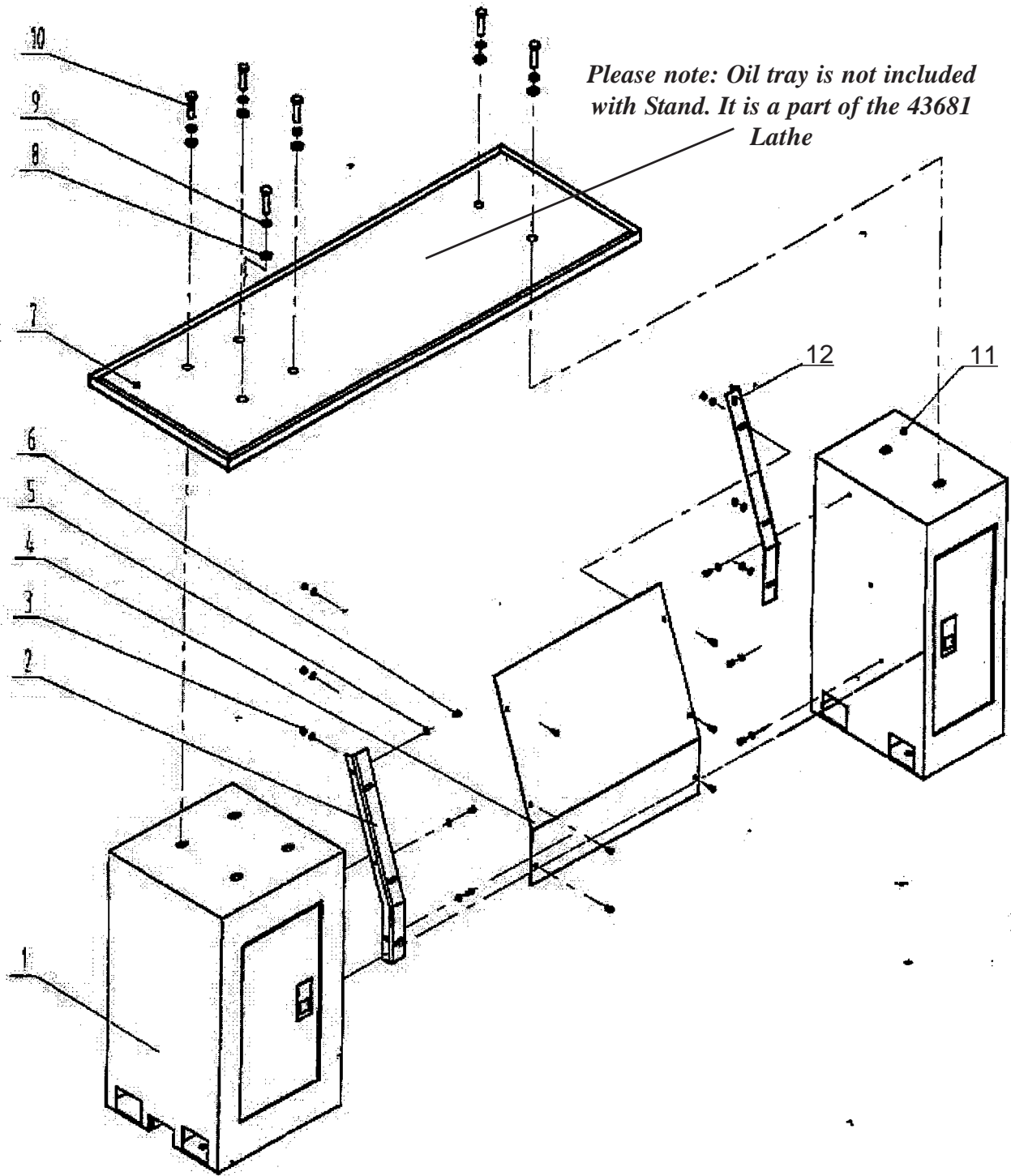
Part No.	Description	Qty.
1	Headstock Stand	1
2	Headstock Connecting Strip	1
3	Nut M6	6
4	Connecting Plate between Stands	1
5	Flat Washer 6	12
6	Bolt M6x10	12
7*	Tray*	1
8	Flat Washer	6
9	Spring Washer	6
10	Bolt M12x50	6
11	Tailstock Stand	1
12	Tailstock Connecting Strip	1

***Please Note: Part 7 (Tray) is not included with the Stand, but with the 43681 Gap Bed Lathe.**

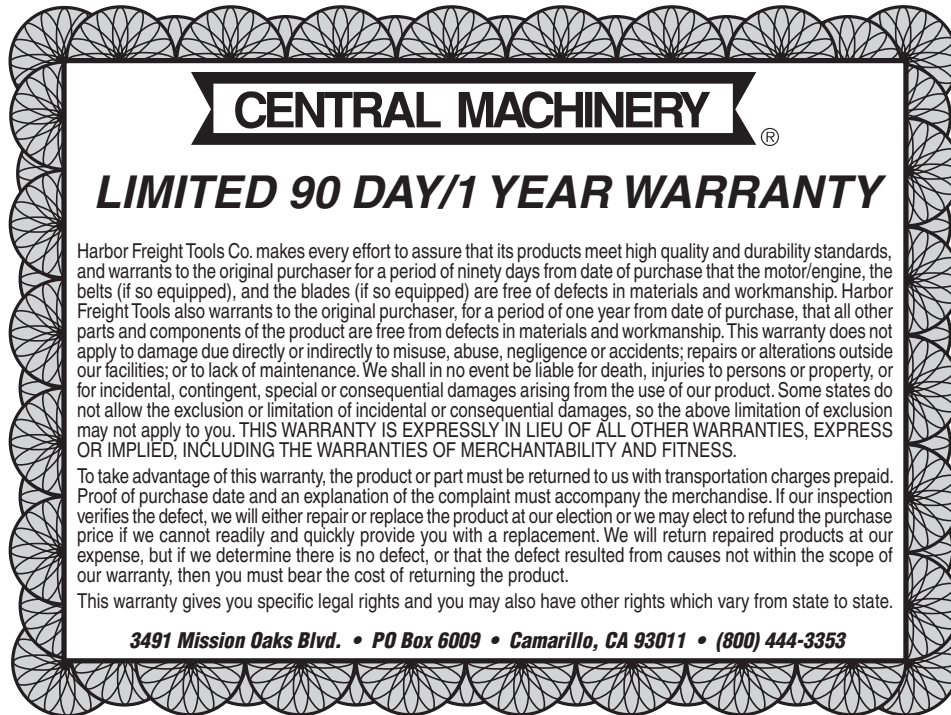
PLEASE READ THE FOLLOWING CAREFULLY

THE MANUFACTURER AND/OR DISTRIBUTOR HAS PROVIDED THE PARTS DIAGRAM IN THIS MANUAL AS A REFERENCE TOOL ONLY: NETHER THE MANUFACTURER NOR DISTRIBUTOR MAKES ANY REPRESENTATION OR WARRANTY OF ANY KIND TO THE BUYER THAT HE OR SHE IS QUALIFIED TO MAKE ANY REPAIRS TO THE PRODUCT OR THAT HE OR SHE IS QUALIFIED TO REPLACE ANY PARTS OF THE PRODUCT: IN FACT THE MANUFACTURER AND/OR DISTRIBUTOR EXPRESSLY STATES THAT ALL REPAIRS AND PARTS REPLACEMENTS SHOULD BE UNDERTAKEN BY CERTIFIED AND LICENSED TECHNICIANS AND NOT BY THE BUYER. THE BUYER ASSUMES ALL RISK AND LIABILITY ARISING OUT OF HIS OR HER REPAIRS TO THE ORIGINAL PRODUCT OR REPLACEMENT PARTS THERETO, OR ARISING OUT OF HIS OR HER INSTALLATION OF REPLACEMENT PARTS THERETO.

Stand Assembly



WARRANTY



CENTRAL MACHINERY®

LIMITED 90 DAY/1 YEAR WARRANTY

Harbor Freight Tools Co. makes every effort to assure that its products meet high quality and durability standards, and warrants to the original purchaser for a period of ninety days from date of purchase that the motor/engine, the belts (if so equipped), and the blades (if so equipped) are free of defects in materials and workmanship. Harbor Freight Tools also warrants to the original purchaser, for a period of one year from date of purchase, that all other parts and components of the product are free from defects in materials and workmanship. This warranty does not apply to damage due directly or indirectly to misuse, abuse, negligence or accidents; repairs or alterations outside our facilities; or to lack of maintenance. We shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our product. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation of exclusion may not apply to you. **THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.**

To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

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