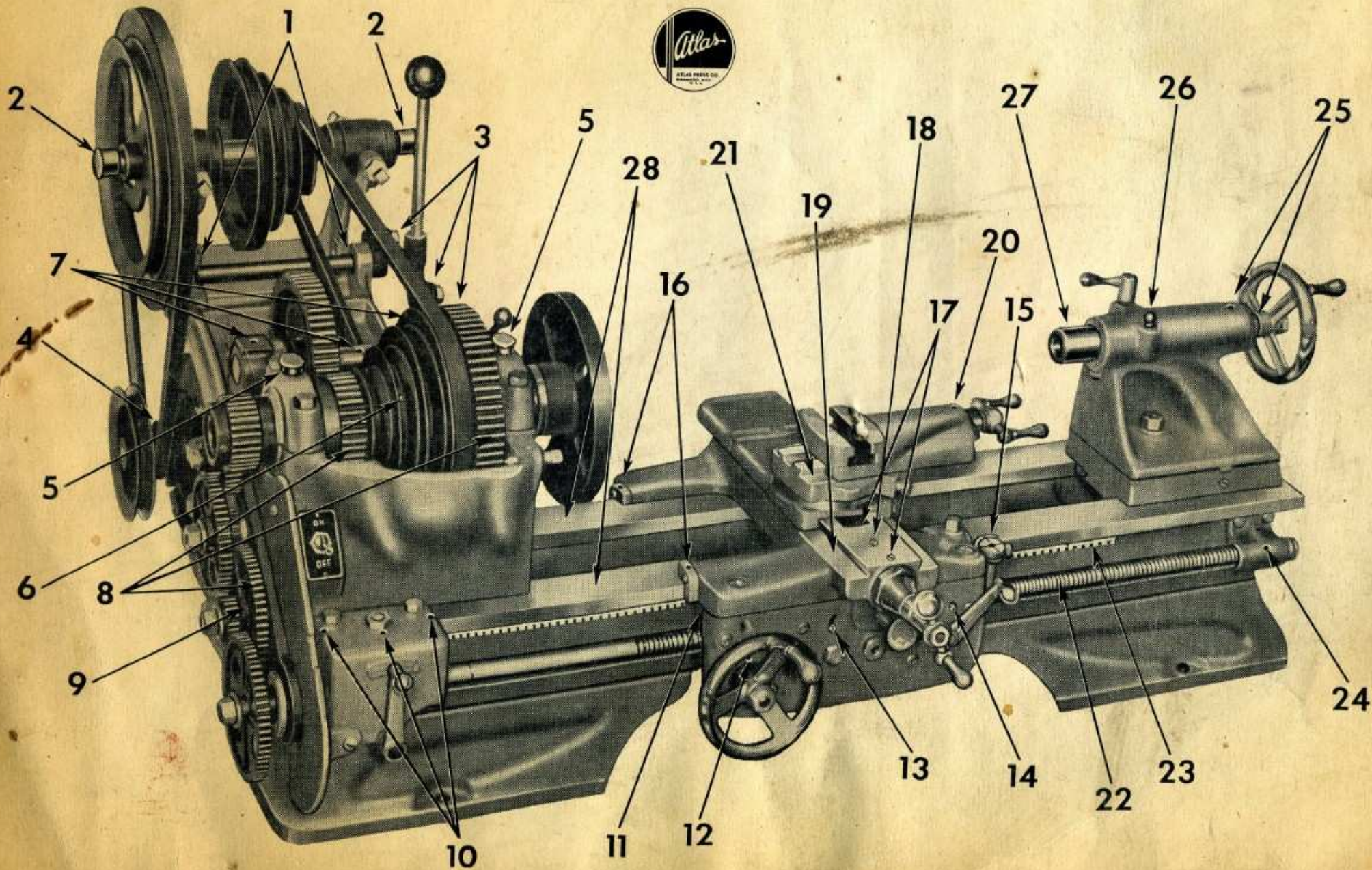


LUBRICATION CHART

PREPARED BY ENGINEERING DEPARTMENT, ATLAS PRESS COMPANY, KALAMAZOO, MICHIGAN, U. S. A.



- 1 Place a few drops of oil on the rockershaft bearings and cams every time the lathe is in use.
- 2 Countershaft Roller Bearings—Fill both grease cups with automotive cup grease every two weeks. Give the grease cup caps a turn or so every time the lathe is used.
- 3 Place a few drops of oil on the rockershaft lever bearings and lever fulcrum bearing every time lathe is used.
- 4 Motor bearings — Sleeve type motors have two oil cups which should be filled once a week with S.A.E. No. 10 Motor Oil or equivalent. Ball bearing motors have two sealed-in type bearings—every six months the small headless screw in these bearings should be removed and a moderate quantity of automotive cup grease forced around the bearing.
- 5 Left and Right Headstock Bearings — Oil with No. 10 motor oil every time lathe is used. Never remove wicking from oil cups.
- 6 Spindle Pulley — Every time the lathe is used in backgear, remove the small screw in the bottom of the second step of the idler pulley and oil freely with No. 10 motor oil or equivalent. Replace screw.
- 7 Back Gear Spindle — Every time the back gears are used, remove the small screw in the center of the back gear spindle and oil freely with No. 10 motor oil or equivalent. Replace screw. Also place a few drops of oil in the oil hole on top of the two back gear spindle bearings.
- 8 Back Gears and Change Gears — A small amount of Keystone No. 122 heavy outer gear lubricant or equivalent applied to the gear teeth will aid in obtaining smoother, more quiet operation. Be sure to remove all oil in the gear teeth before applying this lubricant or it will not adhere.
- 9 Change Gear Bearings — Put a few drops of No. 10 motor oil or equivalent on the change gear bearings each time the lathe is used.
- 10 Lead Screw Stub Bearing and Reversing Gears — Put a few drops of No. 10 motor oil or equivalent in the three oil holes on the top of the reversing gear box every time the lathe is used.
- 11 Carriage Traverse Gear Case — Every time the lathe is in use, put a few drops of No. 10 motor oil in oil hole on top of gear case on back of carriage apron.
- 12 Carriage Hand Wheel Bearing — Put a few drops of No. 10 motor oil or equivalent in ball spring oil hole every time lathe is used.
- 13 Cross Feed Mitre Gear Bearing — Put a few drops of oil in the ball spring oil hole every time lathe is used.
- 14 Half-Nut Lever Bearing — Put a few drops of No. 10 motor oil or equivalent in the ball spring oil hole every time the lathe is used.
- 15 Thread Dial — Once a week put a few drops of No. 10 motor oil or equivalent around the rim of the top of the thread dial.
- 16 Wipers (front and back) — Oil-saturate the felts in the four bed wipers, one at each corner of the carriage saddle, every time the lathe is used.
- 17 Cross Slide Screw — Put a few drops of No. 10 motor oil or equivalent in the oil hole above the front cross slide screw bearing after removing the small screw. Replace the screw. This should be done every time the lathe is used. Clean the cross slide screw regularly with a small stiff brush. Expose threads of cross slide screw by advancing compound rest to extreme rear position — oil threads.
- 18 Cross Feed Gears — Put a few drops of oil in the oil hole above the cross feed screw after removing the small screw. Replace the screw. This should be done every time the lathe is used.
- 19 Cross Slide Ways — Clean regularly and apply a liberal quantity of No. 10 motor oil or equivalent to ways whenever lathe is used.
- 20 Compound Slide Screw — Every time the lathe is used put a few drops of No. 10 motor oil or equivalent in the oil hole on top of the compound rest and above the compound screw bearing.
- 21 Compound Slide Ways — Clean regularly and apply a liberal quantity of No. 10 motor oil or equivalent to the ways whenever the lathe is used.
- 22 Lead Screw — About once a month clean the lead screw threads with kerosene and a small stiff brush and apply a small amount of No. 10 motor oil or equivalent.
- 23 Rack (on bed, under front way) — About once a month apply a small amount of No. 10 motor oil to the rack after cleaning with kerosene and a small stiff brush.
- 24 Lead Screw Bearing (Right End of Lathe) — Put a few drops of No. 10 motor oil or equivalent in the oil hole on top of the bearing every time the lathe is used.
- 25 Whenever using lathe, place a few drops of oil in oil hole on tailstock, also between the tailstock handwheel and screw bearing.
- 26 Tailstock Center Lubricant — Fill the small cup on the tailstock with a mixture of white lead and oil and apply to the tailstock center whenever turning between centers. If white lead is not available, use a liberal amount of cup grease on the center.
- 27 Tailstock Ram — Keep the outside surface of the tailstock ram well oiled.
- 28 Lathe Bed Ways — Keep the bed ways oiled at all times with No. 10 motor oil or equivalent and free from chips. Wipe off the ways before using and cover with fresh oil. Always leave a generous film of oil on the ways when the lathe is not in use. The lathe should be completely covered when not in use. During all grinding operations cover bed ways with canvas or cardboard.

IMPORTANT! KEEP LATHE LEVEL AT ALL TIMES

KEEP ALL LATHE BEARING SURFACES PERFECTLY CLEAN. DIRT IS THE NATURAL ENEMY OF ACCURATE LATHE WORK.