

Woodturning Lathe
Operating Instructions



Producer:

Laguna Tools Inc
744 Refuge Way, Suite 200
Grand Prairie, Texas 75050
USA
Phone: +1 800-234-1976
Website: www.lagunatools.com

Distributor:

IGM nástroje a stroje s.r.o.
Ke Kopanině 560, 252 67, Tuchoměřice
Czech Republic, EU
Phone: +420 220 950 910
E-mail: sales@igmttools.com
Website: www.igmttools.com



EC DECLARATION OF CONFORMITY

We
(Manufacturer)

Laguna Tools Inc.
2072 Alton Parkway, Irvine, California 92606, USA

Declare that the product name: Wood Lathe

Model Name : REVO 12 | 16, REVO 15 | 24, REVO 18 | 36, REVO 24 | 36

Conform with the essential safety requirements of the relevant European Directive:

- Machinery Directive 2006/42/EC
- Electromagnetic Compatibility Directive 2014/30/EU

The person who compile technical file established within the EU:

Name: IGM nástroje a stroje s.r.o.
Address: Ke Kopanine 560, Tuchomerice , CZ-252 67
Tel.: +420 220 950 910
Email: sales@igmtools.com

Mounting and connecting instructions defined in catalogues and technical construction files must be respected by the user.

They are based on the following standards :

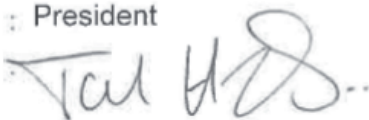
- EN ISO 12100:2010 Safety of Machinery - General principles for design / Risk Assessment and Risk reduction.
- EN 60204-1:2006+AC:2010 Safety of machinery – Electrical equipment of machines, part 1 : General requirements.
- EN 13849-1:2015 Safety of machinery – Safety – related parts of control systems Part 1: General principles for design
- EN 50370 -1:2005 Electromagnetic compatibility (EMC) – Product family standard for machine tools – Part 1: Emission.
- EN 50370 -2:2003 Electromagnetic compatibility (EMC) – Product family standard for machine tools – Part 2: Immunity.
- EN 61000-4-2: 2009 Electrostatic (ESD)
- EN 61000-4-4: 2012 Electrical fast transient/burst requirements (EFT/Burst)
- EN 61000-4-6: 2014 Immunity to conducted disturbances, induced by radio-frequency fields (CS)

Responsible for the documentation: Head Product Management, Laguna Tools Inc.

Name : Torben Helshoj

Responsibility : President

Authorized Signature



Date : Oct. 15, 2021

Place : Laguna Tools Inc.

2072 Alton Parkway, Irvine, California 92606, USA

Telephone: +1 800 234-1976

Fax: +1 949 474-0150



EN - English

Operating instructions (Translation of original)

Dear Woodworker,

Thank you for your purchase and welcome to the **Laguna Tools** group of discerning woodworkers. We understand that you have a choice of where to purchase your machines and appreciate the confidence you have in the Laguna Tools brand. Every machine manufactured by Laguna Tools has been carefully designed and well thought through from a woodworker's perspective. Through hands-on experience, Laguna Tools is constantly working hard to make innovative, precision products. Products that inspire you to create works of art, are a joy to run and work on, and encourage your performance.

Contents

1. Declaration of conformity

1.1 Warranty

2. About this manual

3. Specifications

3.1 Parts of the machine

3.2 Technical data

3.3 Noise emission

4. General safety

4.1 Safety Rules

4.2 Electrical connections

5. Receiving your machine

5.1 Unpacking and transport

5.2 Receiving the lathe

5.3 Locating your machine

6. Assembly and setup

6.1 Assembling the legs to the bed of the lathe

6.2 Cleaning the machine

6.3 Fitting the rotating centre

6.4 Fitting the drive centre into the head stock

6.5 Fitting the face plate

6.6 Lathe controls

6.7 Variable speed adjustment knob

6.8 High / low speed

6.9 Indexing the spindle

7. Maintenance

8. Troubleshooting

1. Declaration of conformity

We declare that this product is in compliance with the Directives and Standards on page 2 of this manual.

1.1 Warranty

IGM Tools & Machinery strives to always deliver high-quality machinery. The warranty is governed by the valid terms and conditions of IGM Tools & Machinery available at www.igmtools.com.

2. About this manual

This manual is intended to thoroughly cover the setup up, maintenance, and proper adjustments of your new purchase. Aside from the proceeding general safety considerations, this manual DOES NOT cover woodworking or metalworking techniques that are possible with this product and the appropriate safety precautions necessary for safe practices.

3. Specifications

Wood turning lathes are typically used to shape wood into cylindrical profiles. Objects made on a wood lathe include such items as furniture

legs, lamp posts, baseball bats, bowls and other ornamental forms. Wood lathe tooling consists of fixtures and securing devices for the work piece, a moveable tool rest, and hand-held cutting tools.

3.1 Parts of the machine

The lathe consists of a number of major parts, which are discussed in this manual. Take the time to read this section and become familiar with the machine.

Identification

There is a plate at the back of the machine listing all the manufacturing data, including the serial number, model, etc.

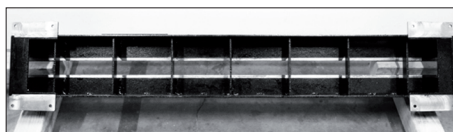
Lathe Bed

The bed is a heavy steel welded construction.



Pic. 1

Underside of lathe bed



Pic. 2

Lathe legs

The Legs are cast iron, and their heavy construction gives the machine a low centre of gravity and ensures that it is very stable. The legs are supplied with adjustable feet to allow the machine to be levelled.

Legs with adjustable feet assembled.



Pic. 3

Head stock

The head stock is cast iron and houses the variable speed control and motor. The spindle can be locked in 14 / 36 and 48 positions.

Headstock removed from the bed



Pic. 4

Headstock attached to bed



Pic. 5

Tail stock

The tail stock is of cast iron construction, and the spindle has a travel of 4 1/2 in. It can accommodate centres and other tools which have a number 2 Morse Taper. The tail stock can be moved to any position on the lathe bed and locked to suit the job at hand.

Tail stock viewed from the back.



Pic. 6

Tail stock viewed from the front



Pic. 7

Tool rest

The tool rest can be moved to any position on the lathe bed and locked to suit the job at hand. The tool rest has a tall profile to allow the bowl turner to turn steep angles. The leading edge is made from 6 mm hardened steel.

Tool rest assembled to the bed



Pic. 8

Tool rest



Pic. 9

Electrical system

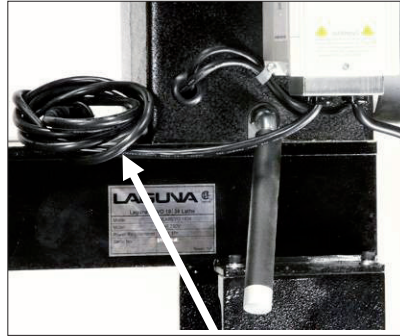
220V: The electrical control system (VFD) is housed at the back of the head stock, The VFD converts single phase 220v to three phase. There is a speed readout at the front of the lathe with controls to fine adjust the rpm of the spindle. A power cord with 220V plug is provided.

VFD with cover open



Pic. 10

Power cord



Pic. 11

Tool storage

A tool storage bracket which can be mounted on either leg.

Tool storage bracket



Pic. 12

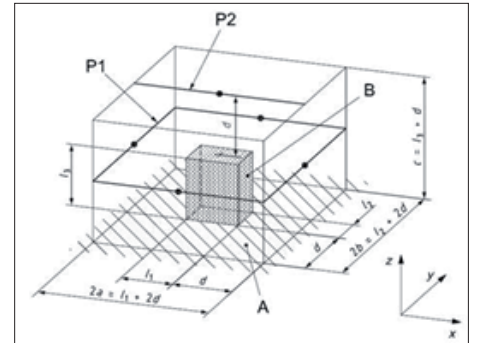
3.2 Technical data

Motor	Induction, 1725RPM, 3 HP 220V
Voltage	220V, 60 Hz, 1 Ph.
	3 phase output
Recommended breaker size	16 A, tripping characteristic C (16/1/C).
Swing over bed	609 mm
Swing over banjo	501 mm
Outboard swing max.	965 mm
Distance between centres	914 mm
Floor to spindle centre	1130 mm
Floor to bed height	826 mm
Dim. W x D x H	1524 x 660 x 1327 mm
Tool rest	305 mm
Speed range high:	135 – 3500 rpm
Speed range low:	50 – 1300 rpm
VFD	DeltaS1 variable frequency drive
Spindle	1.25" x 8 tpi right hand thread
Spindle taper	MT 2
Spindle lock	Spring loaded
Spindle indexing	14 / 36 / 48 with lock
Head stock and tail stock bore	9,5 mm

Tail stock travel	114 mm
Tail stock removal	Self-ejecting
Tail stock taper	MT 2
Faceplate	76 mm
Bed material	Steel
Weight (net/ship)	242 kg / 255 kg

3.3 Noise emissions

Equivalent A-weighted Sound pressure level according to EN ISO 3746: 75.66 dB(A). Uncertainty, K in decibels: 4.0 dB (A) according to EN ISO 4871 The figure quoted is emission levels and are not necessarily safe working levels. Whilst there is a correlation between the emission and exposure levels, this cannot be used reliably to determine whether or not further precautions are required. Factors that influence the actual level of exposure of the workforce include characteristics of the work room, the other sources of noise, etc. i.e. the number of machines and other adjacent processes. Also the permissible exposure level can vary from country to country. This information, however, will enable the user of the machine to make a better evaluation of the hazard and risk.



Pic. 13

4. General safety

"WARNING": For Your Own Safety Read Instruction Manual before Operating Lathe

4.1 Safety Rules

- Wear eye protection.
- Do not wear gloves, a necktie, or loose clothing.
- Tighten all locks before operating.
- Rotate work piece by hand before applying power.
- Rough out work piece before installing on faceplate.
- Do not mount split work piece or one containing a knot.
- Use lowest speed when starting new work piece.

- Keep guards in place and in working order.
- Remove adjusting keys and wrenches. Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
- Keep work area clean. Cluttered areas and benches invite accidents.
- Don't use in a dangerous environment. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.

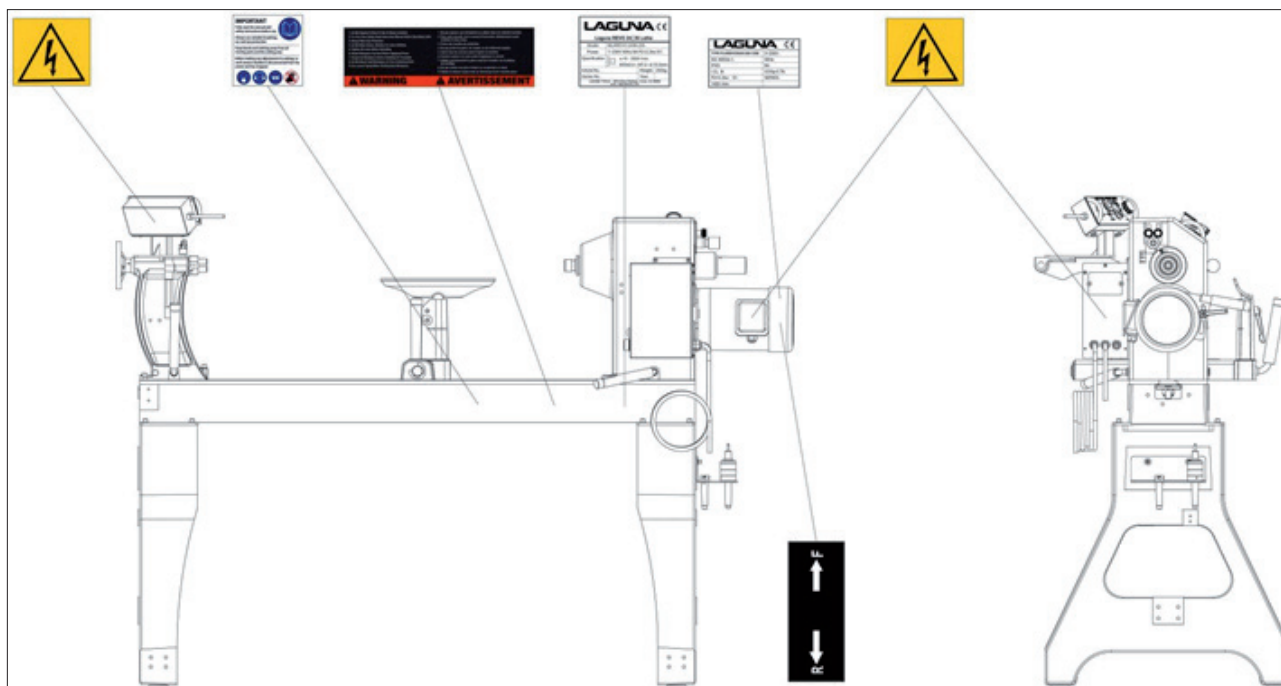
- Keep children away. All visitors should be kept at a safe distance from the work area.
- Make your workshop kid proof with padlocks, master switches, or by removing starter keys.
- Don't force tool. It will do the job better and safer at the rate for which it was designed.
- Use right tool. Don't force tool or attachment to do a job for which it was not designed.
- Use proper extension cord. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.
- Wear proper apparel do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewellery which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- Always use safety glasses. Also use a face or dust mask if cutting operation is dusty.

Everyday eyeglasses only have impact resistant lenses, they are not safety glasses.

- Secure work. Use clamps or a vice to hold the work when practical. It's safer than using your hand and it frees both hands to operate the tool.
- Don't overreach. Keep proper footing and balance at all times.
- Maintain tools with care. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- Disconnect tools before servicing and when changing accessories, such as blades, bits, cutters, and the like.
- Reduce the risk of unintentional starting. Make sure power switch is in the off position before plugging the machine in.
- Use recommended accessories. Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons.

- Never stand on tool serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
- Check damaged parts. Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
- Direction of feed. Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
- Never leave tool running unattended. Turn power off. Don't leave tool until it comes to a complete stop.

Location of warning signs



Pic. 14

Locking the lathe

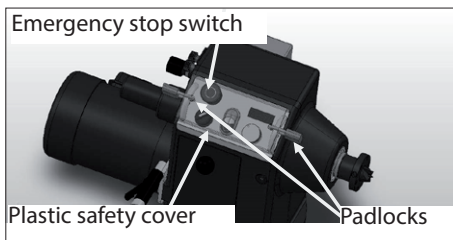
It is strongly recommended that the lathe is never be left unattended in the unlocked condition.

To lock the machine it is recommended that a cover (not supplied) is made to lock the control panel. We have supplied two concepts for locking the panel (see below). The cover can be made from wood or plastic.

First, push down the emergency stop. Then lock the cover together by putting padlocks [not included] on the two handles on the control panel. To safeguard your machine from unauthorized operation and accidental starting by young children, the use of padlocks is strongly recommended.



Pic. 15



Pic. 16

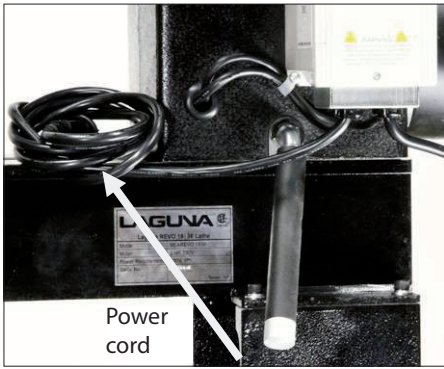
4.2 Electrical connections

Make sure that the power supply meets the machine's requirements (230V). We recommend using a 16 A breaker, tripping characteristic C (16/1/C). **Note.: Perform adjustments with the help of a qualified electrician.**

VFD with cover open



Pic. 17



Pic. 18

5. Receiving your machine

5.1 Unpacking and transport

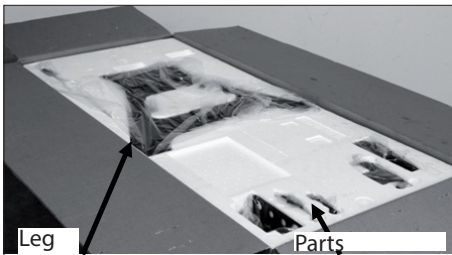
To unpack your machine you will need tin snips, a knife, and a wrench.

1. Using the tin snips, cut the banding that is securing the packing box (If fitted). Extreme caution must be used, because the banding will spring and could cause injury.

Lathe in packaging



Pic. 19



Pic. 20

Top packaging removed



Pic. 21

2. Open the box and remove the parts sent with the lathe including the first leg.

Note: The legs are heavy and caution must be exercised. They are cast iron and if dropped they will break.

3. Remove the top packaging and remove the second leg.

4. Remove the lathe bed. It is recommended that it be lifted with a hoist or forklift using a „sling“ as it is very heavy.

Note: The machine is heavy. Ensure that you have enough people to do the job safely. Do not attempt any procedure that you feel is unsafe, or that you do not have the physical capability of achieving.

5. Lower the bed of the lathe onto 2 stacks of wood. This will allow access to the underside of the bed.



Pic. 22

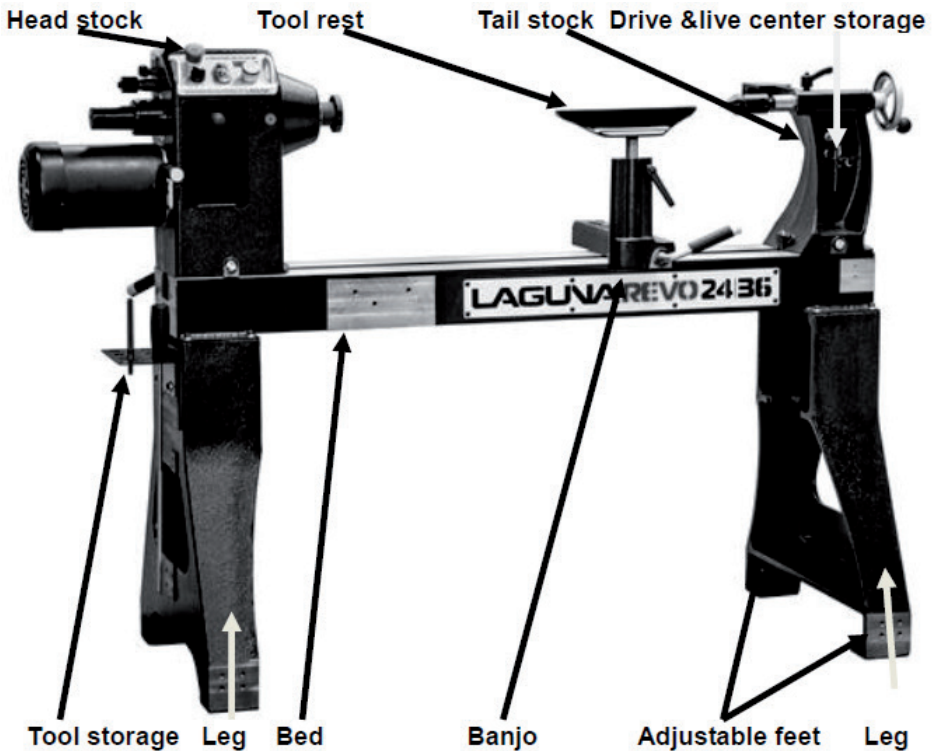
Note: Cast iron and steel parts of the machine are treated with preservative oil against corrosion, before putting the machine into operation it is necessary to degrease all these parts of the machine with technical grade alcohol or technical gasoline.

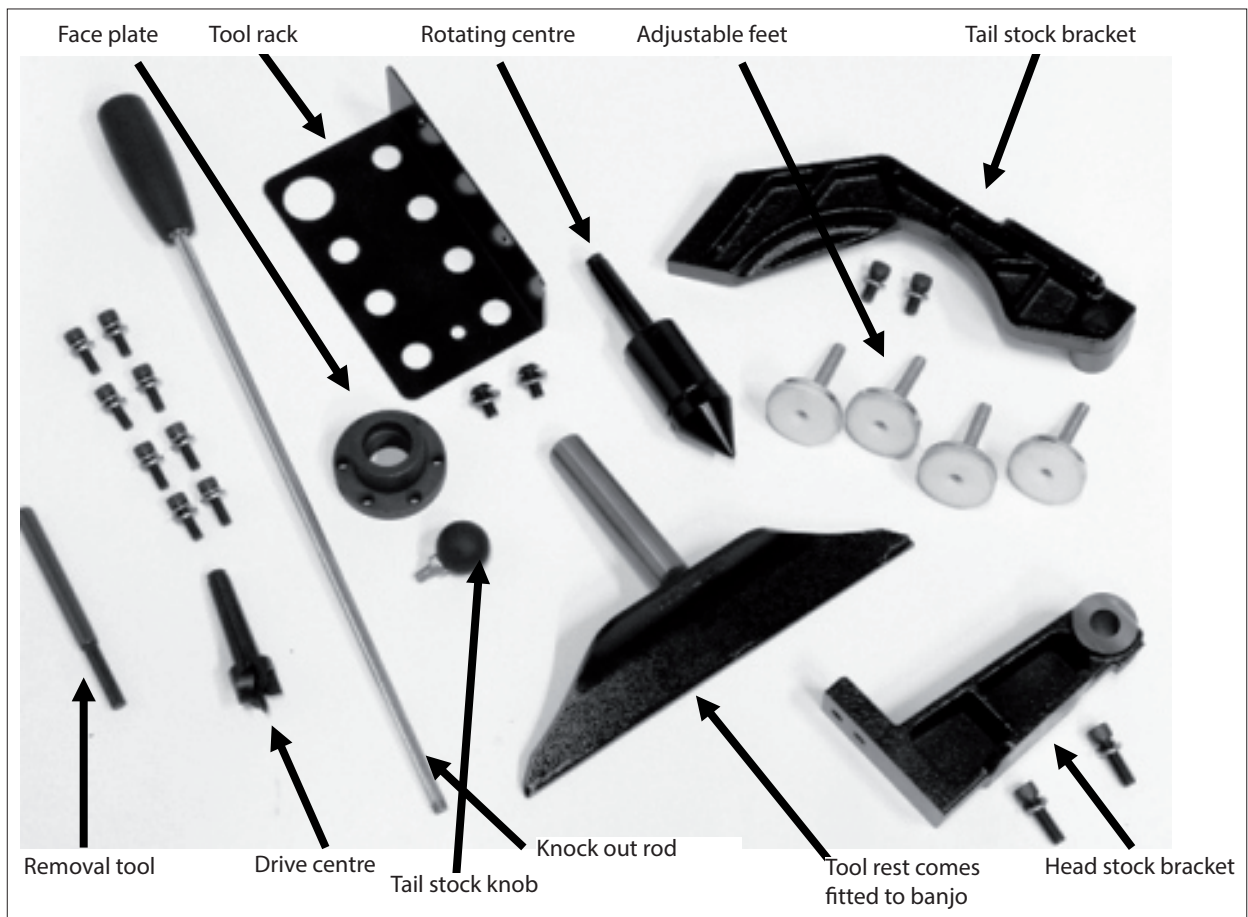
5.2 Receiving the lathe

Before you unpack your new machine you will need to first inspect the packing, invoice and shipping documents supplied by the driver. Insure that there is no visible damage to the packing or the machine. You need to do this prior to the driver leaving. All damage must be noted on the delivery documents and signed by you and the delivery driver. You must then contact the seller (Laguna Tools) as soon as practical. If damage is found after delivery, contact the seller as soon as is practical.

Note: It is probable that you will find sawdust within your machine. This is because the machine has been tested prior to shipment from the factory. It must be noted that additional machine movement can take place between Laguna Tools and the end user and some adjustments may have to be undertaken by the customer. These adjustments are covered in the various sections of this manual.

Parts of the lathe Supplied with:





Pic. 23

Pic. 24

5.3 Locating your machine

Before you remove your machine from the packaging, select the area where you will use your machine. There are no hard and fast rules for its location, but below are a few guidelines:

1. There should be sufficient area at the front of the machine to allow you to work on it comfortably.
2. There should be sufficient area at the back of the machine to allow access for adjustments and maintenance to be conducted.
3. Adequate lighting. The better the lighting the more accurately and safely you will be able to work.
4. Solid floor. You should select a solid flat floor, preferably one made of concrete or something similar.
5. Locate it close to a power source and dust collection.
6. Allow an area for the storage of blanks, finished products and tools.

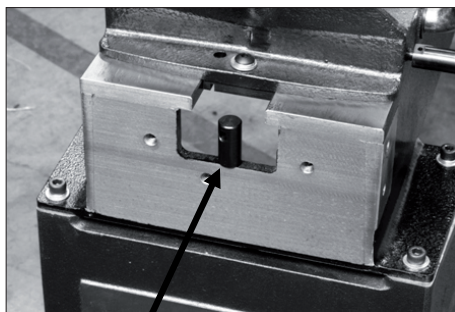
6. Assembly and setup

The machine comes mostly assembled. You will have to assemble the legs, headstock, tail stock, tool storage and the tool rest to the bed of the machine.

Note. It is recommended that the head stock, tool rest and tail stock be removed from the bed of the lathe to ease assembly

6.1 Assembling legs to the bed of the lathe

There is a stop at both ends of the bed. The stop is a safety feature that makes it impossible for the headstock or tail stock to slide off the end of the bed. Remove the stops and loosen the clamps on both the head stock, tool rest and tail stock. Slide them off the bed. This will greatly reduce the weight of the bed and allow easier assembly. **Note:** The headstock and tail stock are very heavy and extreme caution must be exercised when removing them from the bed of the lathe. Take care not to cause damage

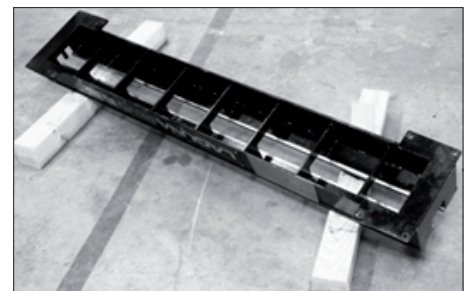


Pic. 25

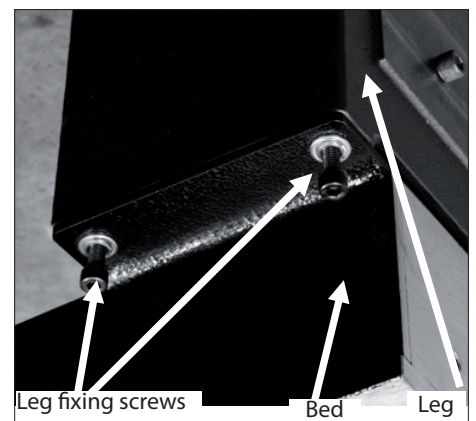


Pic. 26

Bed with headstock and tail stock removed



Pic. 27



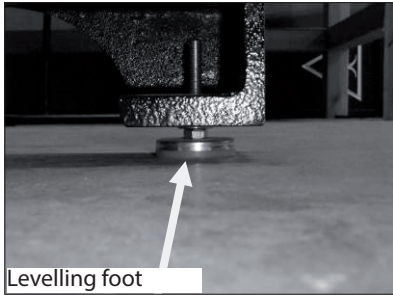
Pic. 28

Lay the bed on timbers in the upside down position. Lift the legs to the vertical position and lower them onto the bed. Secure with the fixing screws provided.

Note: At least two people will be needed to perform the assembly, one to hold the leg in position and one to fit the fixing screws.

Note: If you have any doubt about the

described procedure, seek professional assistance. Fit the 4 levelling feet to the lathe legs with the lock nut on the underside of the leg. Once both legs have been fitted turn the assembly up to the correct position.



Pic. 29



Pic. 30

Assemble the head stock, tool rest and tail stock back onto the bed of the lathe and **fit the stops**. **Note:** If you have any doubt about the described procedure, seek professional assistance. Do not attempt any procedure that you feel is unsafe, or that you do not have the physical capability of achieving.

Assembled lathe



Pic. 31

If you decide to fit the tool rest after fitting the tail stock, follow the below procedure. Fit the tool rest onto the bed of the lathe ensuring that the washer recess fits into the slot in the bed. Fit the banjo onto the bed with the bolt through the washer and assemble the nut onto the thread. Adjust the nut so that the clamp handle locks the banjo with approximately 30 degree of movement.

Tool rest disassembled



Pic. 32



Pic. 33

Washer assembled in position



Pic. 34



Pic. 35

Fitting the stock knob

Screw the tail stock knob onto the tail stock handle.

Tail stock knob



Pic. 36

Tail stock handle



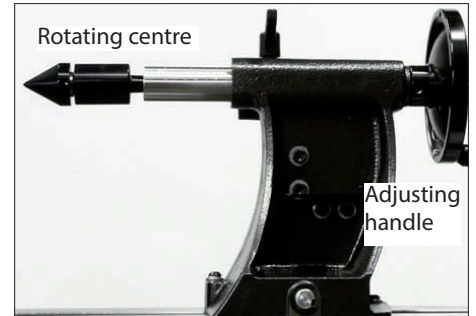
Pic. 37

6.2 Cleaning the machine

Remove the rust protection grease with benzene or a similar solvent. It is important that you remove all the grease and re-lubricate with a Teflon-based lubricant. (Teflon has a lower tendency to attract sawdust and cause clogging).

6.3 Fitting the rotating centre

Ensure that the bore of the tail stock is clean. The rotating centre has a number 2 Morse Taper that fits into the tail stock. Push the centre into the tail stock bore firmly, and ensure that it is securely located. To remove the centre, rotate the adjusting handle until it is as far back as possible and this will eject the centre.



Pic. 38

6.4 Fitting the drive centre into head stock

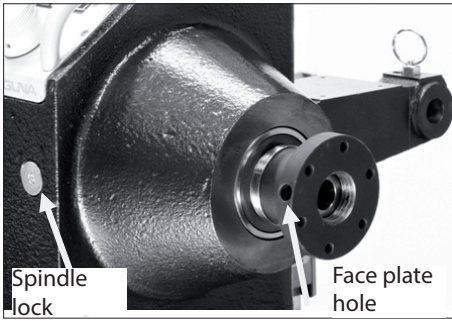
To remove the face plate from the head stock spindle, insert the removal tool into the hole in the face plate large diameter. Lock the spindle with the lathe spindle lock and unlock the face plate by rotating it. Take care not to drop the faceplate onto the bed of the lathe.

Note: The face plate has a left-hand thread.

Removal tool



Pic. 39



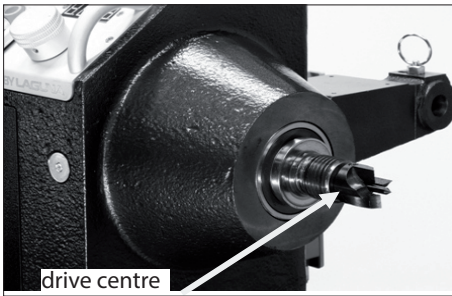
Spindle lock Face plate hole

Pic. 40



spindle lock

Pic. 41



drive centre

Pic. 42



Drive centre removal shaft

Pic. 43

Ensure that the bore of the head stock is clean. The drive centre has a number 2 Morse Taper that fits into the head stock. Push the centre into the head stock bore firmly, and ensure that it is securely located. To remove the centre, push the rod into the back of the head stock, and give it a sharp knock. This will remove the drive centre. **Note:** Never leave the rod in the head stock with the machine running.

6.5 Fitting the face plate

Reverse the removal procedure, described earlier.

6.6 Lathe controls

Emergency stop button

The emergency stop button will lock in the OFF position when fully depressed. To reset it, twist clockwise and it will pop out.

Forward / Reverse switch

The forward / reverse switch selects the direction of the rotation of the spindle. The forward / reverse switch must only be used once the spindle has come to a complete stop.

Start / Stop

The start / stop buttons start the motor and the

rotation of the spindle.

Speed display

The speed display shows the RPM of the spindle.

Variable speed adjustment knob

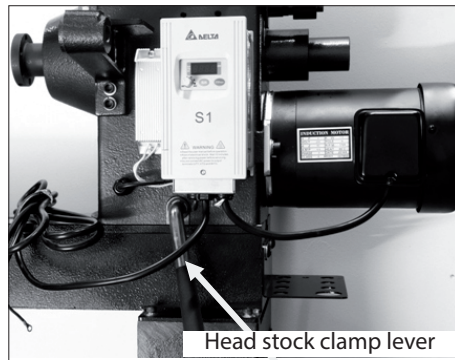
The Variable speed adjustment knob adjusts the spindle speed.



Forward / reverse switch

Variable speed adjustment knob

Pic. 44



Head stock clamp lever

Pic. 45

Head stock clamp lever.

The head stock clamp lever allows the head stock to be released and moved to any position on the lathe bed. It is located at the back of the head stock.

6.7 Variable speed adjustment knob



Increase speed

Decrease speed

Pic. 46

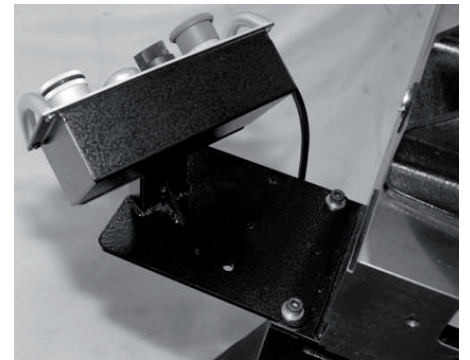
The Variable speed adjustment knob adjusts the spindle speed. Turns clockwise to increase the speed, turns counter-clockwise to decrease the speed.

Fitting the remote controller

The remote controller can be fitted in either of two positions, attached to the tail stock or attached to the tailstock leg.

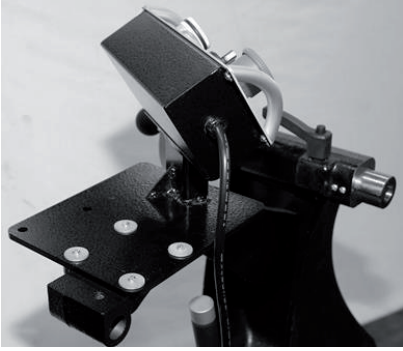
Fitting the remote controller to the tailstock leg.

1. Fit the support plate to the bed by removing the two clamp bolts and with the two clamp screws secure the support plate.
2. Fit the remote controller with the clamping supplied screws.
3. Ensure that the cable is clear of any obstruction.



Fitting the remote controller to the tailstock.

1. Fit the support plate to the tailstock bracket with the clamp screws supplied.
2. Fit the remote controller with the clamping supplied screws.
3. Ensure that the cable is clear of any obstruction.



Note. The headstock can only be controlled by one controller and you must select which controller is used by selecting with the controller selection switch.



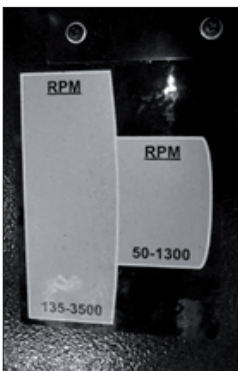
Controller selection switch

6.8 High / low speed

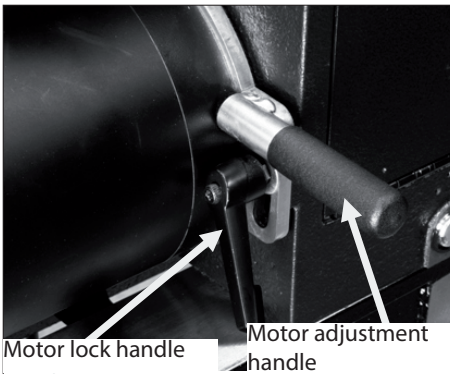
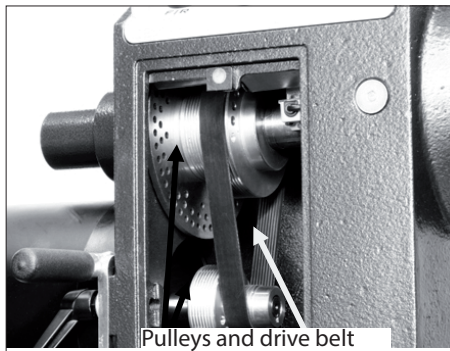
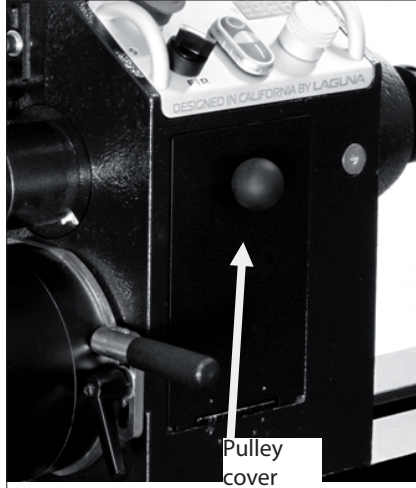
The lathe has two sets of pulleys for high (135 - 3500 rpm) and low (50 - 1300 rpm) speed ranges.

- Adjust between the speed ranges as follows.
1. Disconnect the electric supply to the lathe.
 2. Open the pulley cover.
 3. Loosen the motor lock handle and lift the motor to the highest position with the motor adjustment handle, then lock the motor lock handle.
 4. Move the drive belt to the required set of pulleys.

High / low speed

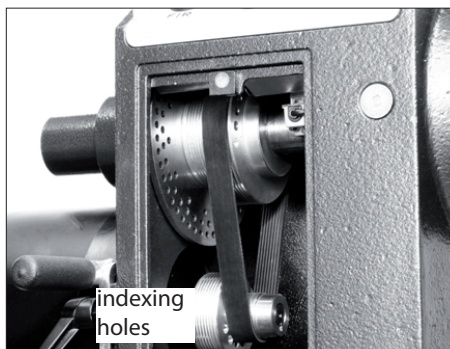


5. Loosen the motor lock handle and with the motor adjustment handle tension the drive belt, then lock the motor lock handle. The belt should be tensioned so that there is approximately 3-6 mm deflection when pressed.

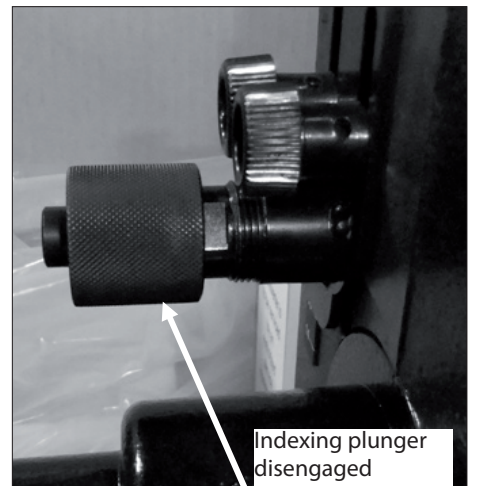
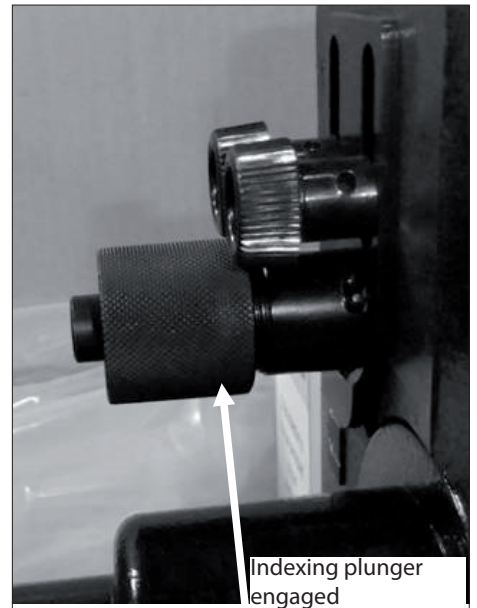
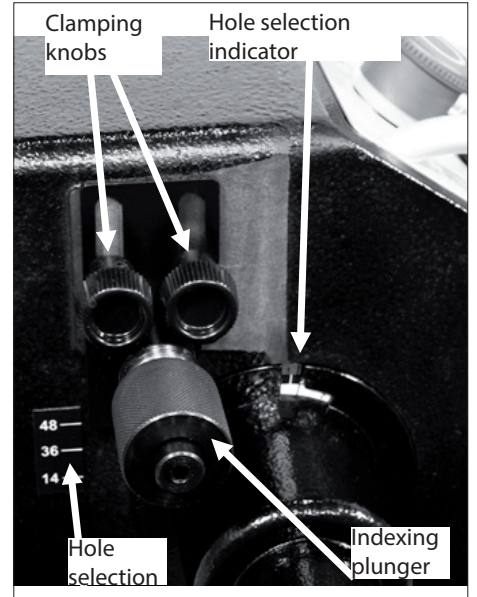


6.9 Indexing the spindle

The spindle has 3 sets of indexing holes 14 / 36 / 48. The selection plunger is located at the end of the head stock. To move between the 3 sets of holes, loosen the clamp knobs and slide the indexing plunger assembly to align with the selected hole set. Clamp in position with the clamp knobs. Try the plunger in a few different holes to check that it inserts and removes smoothly.



The indexing plunger is spring loaded and this is used only to temporarily align the plunger in the selected hole. To fix the plunger in a selected hole, it must be attached to the housing by screwing into the clamped position. There is a hole selection indicator that allows you to view which hole in a selected hole set has been selected.



7. Maintenance
General

Keep your machine clean. At the end of each day, clean the machine. Wood contains moisture, and if sawdust or wood chips are not

removed they will cause rust. In general, we recommend that you only use a Teflon-based lubricant on the lathe. Regular oil attracts dust and dirt. Teflon lubricant tends to dry and has less of a tendency to accumulate dirt and saw dust. Periodically check that all nuts and bolts are tight.

Drive belt

The drive belt should last for many years (depending on the usage) but needs to be inspected regularly for cracks, cuts and general wear. If damage is found, replace the belt.

Bearings

All bearings are sealed for life and do not require any maintenance. If a bearing becomes faulty, replace it.

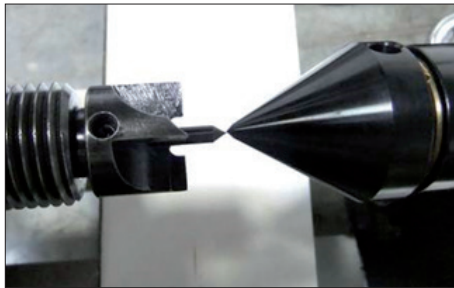
Rust

The lathe is made from steel and cast iron. All non-painted surfaces will rust if not protected. It is recommended that they be protected by applying wax or a Teflon-based lubricant to them.

Centre point alignment and slide clearance adjustment

The centre point alignment and slide clearance are adjusted at the factory and no adjustment should be required. Should movement or wear have taken place, the following adjustment procedure should be conducted. Note: The slide clearance of the headstock and the tail stock must be checked and adjusted should it be needed prior to adjusting the centre point alignment.

Centre points aligned



Slide adjustment

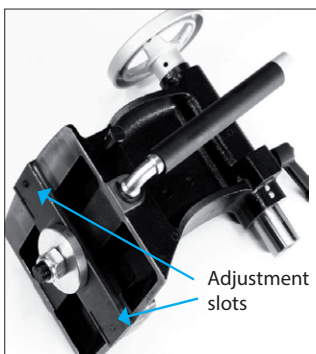
Loosen the clamp handle on the tail stock and check for side movement. If it is excessive, insert an Allen key into the adjusting screw and tighten.

Note: By rotating the adjustment screw, it moves into the adjusting slot which opens and removes the excessive clearance between the tail stock and the bed.

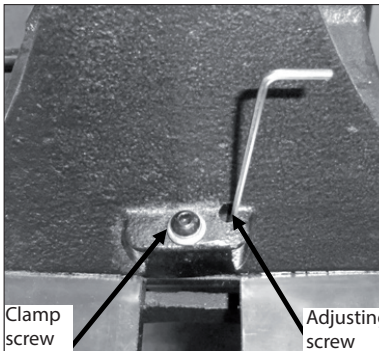
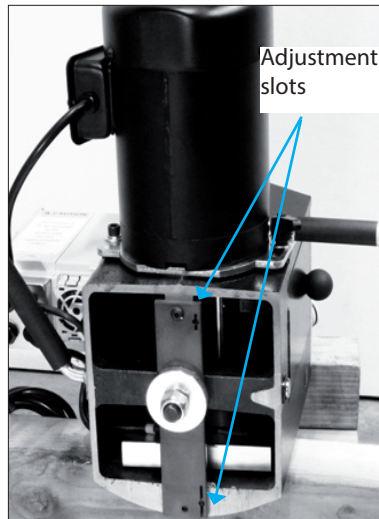
Note: Only make very small adjustments and then recheck the clearance. After adjustment Centre points aligned the tail stock should be slid along the bed to check for any area that it binds in the bed slot. The same procedure as above should be conducted on the head stock should it be required.

Note: It is very unlikely that the headstock will require adjustment as it is not moved as often as the tail stock, so has less tendency's for ware.

View under the tail stock



View under headstock



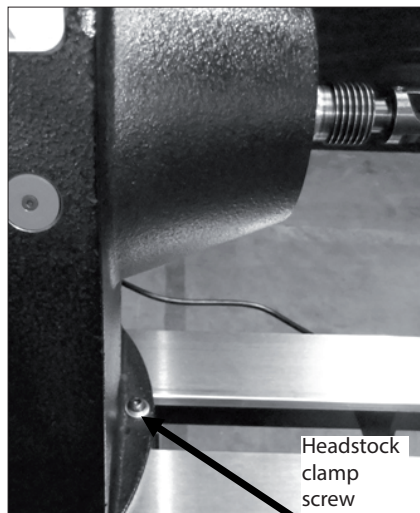
Center point alignment

The tail stock has two clamp screws that are accessible from the top of the tail stock. The clamp screws hold the slide plate to the tail stock casting. There is clearance in the holes that allows the tail stock to be moved in relation to the slide plate. The headstock also has two clamp screws, but one is accessible from under the headstock.

By loosening the clamp screws the headstock and tail stock can be moved and the centre points aligned.

Note: It is recommended that the head stock be adjusted and not the tail stock. If the tail stock is not adjusted parallel to the bed slide, the centre point will not be in alignment when the spindle is extended or retracted.

1. Loosen the clamp screw that is accessible from the top on the head stock.



2. Tap the side of the headstock with a rubber

mallet close to the base in the direction requiring adjustment and retighten the clamp screw.

3. Recheck the centre point alignment and repeat if required.

Note: Never hit any part of the lathe that is cast iron with a metal hammer or similar as it will break the casting.

8. Troubleshooting

Lathe will not start

1. Check that the start switch is in the correct position.
2. Check that the electrical power cord is plugged into the power outlet.
3. Check that the electrical supply is on (reset the breaker).
4. With the power disconnected from the machine, check that the wiring to the plug is correct. Check that the rubber insulation is stripped enough and is not causing a bad connection. Check that all the screws are tight.
5. Emergency stop button engaged. Reset emergency stop button. Twist and it will pop out.

The machine will not stop

This is a very rare occurrence as the machine is designed to be fail-safe. If it should occur and you cannot fix the fault, seek professional assistance. The machine must be disconnected from the power and never run until the fault has been rectified.

1. The stop switch is faulty. Replace the stop switch.

Motor tries to start but will not turn

1. With the power disconnected from the machine, try to turn the spindle by hand. If the spindle will not turn, check the reason for jamming.
2. Capacitor faulty. Replace the capacitor.
3. Motor faulty. Replace the motor.
4. Power line overloaded. Correct overloaded condition.
5. Low voltage. Correct low voltage condition.

Motor overheats

The motor is designed to run hot, but should it overheat it has an internal thermal overload protector that will shut it down until the motor has cooled, and then it will reset automatically. If the motor overheats, wait until it has cooled and restart. If the motor shuts down consistently check for the reason. Typical reasons are dull cutting tools, the motor cooling fan being clogged or faulty, the motor cooling fins are clogged, overfeeding the job, and excessive ambient temperature.

Squeaking noise

1. Check that the motor cooling fan is not contacting the fan cover.
2. Check the bearings.
3. Check the drive belt is tensioned correctly.

Spindle slows down during a cut

1. Dull cutting tools. Replace the tool or have it re-sharpened.
2. Feeding the wood too fast. Slow down the feed rate.
3. Oil or dirt on the drive belt. Clean or replace the drive belt.
4. Drive belt loose. Re-tension drive belt.

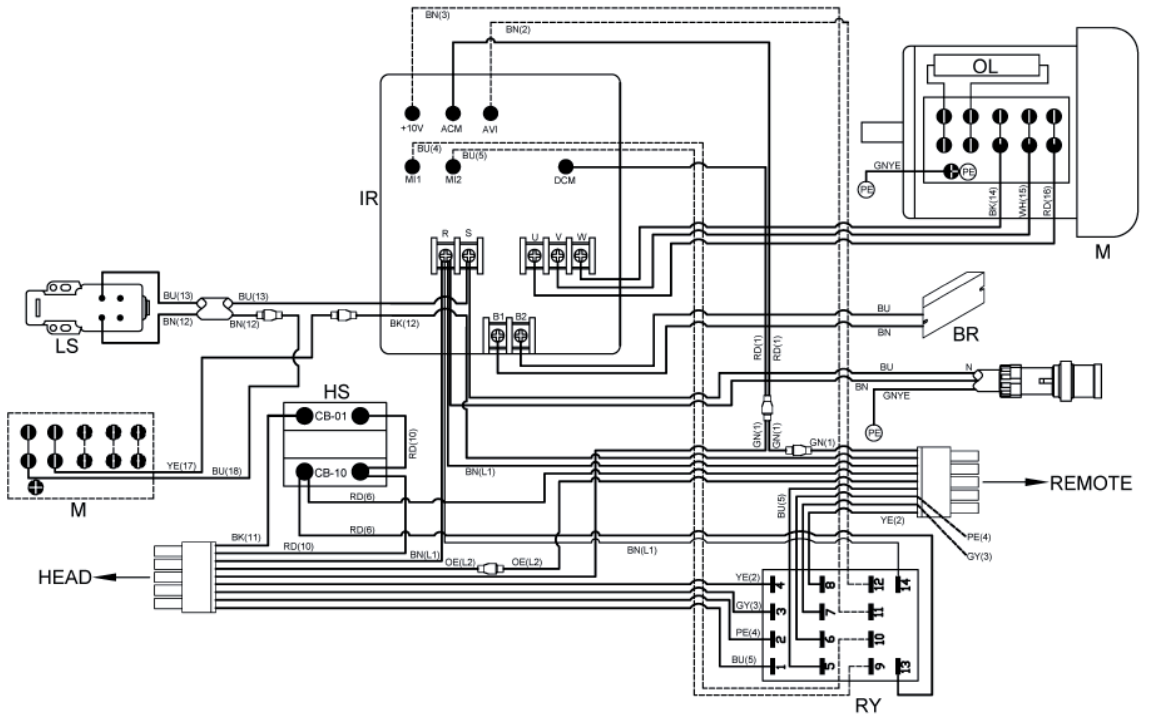
Machine vibrates

1. Machine not level on the floor. Re-level the machine ensuring that it has no movement.
2. Damaged drive belt. Replace the belt.
3. Job is not balanced. Change to slower speed and/ or balance the job.
4. Damaged pulley. Replace the pulley.
5. Worn spindle bearing. Replace the bearing.

Electrical drawing

	colour of strands
BK	black
WH	white
BU	blue
YE	yellow
RD	red
BN	brown
GNYE	green-yellow
GN	green
GY	gray
OE	orange
PE	purple

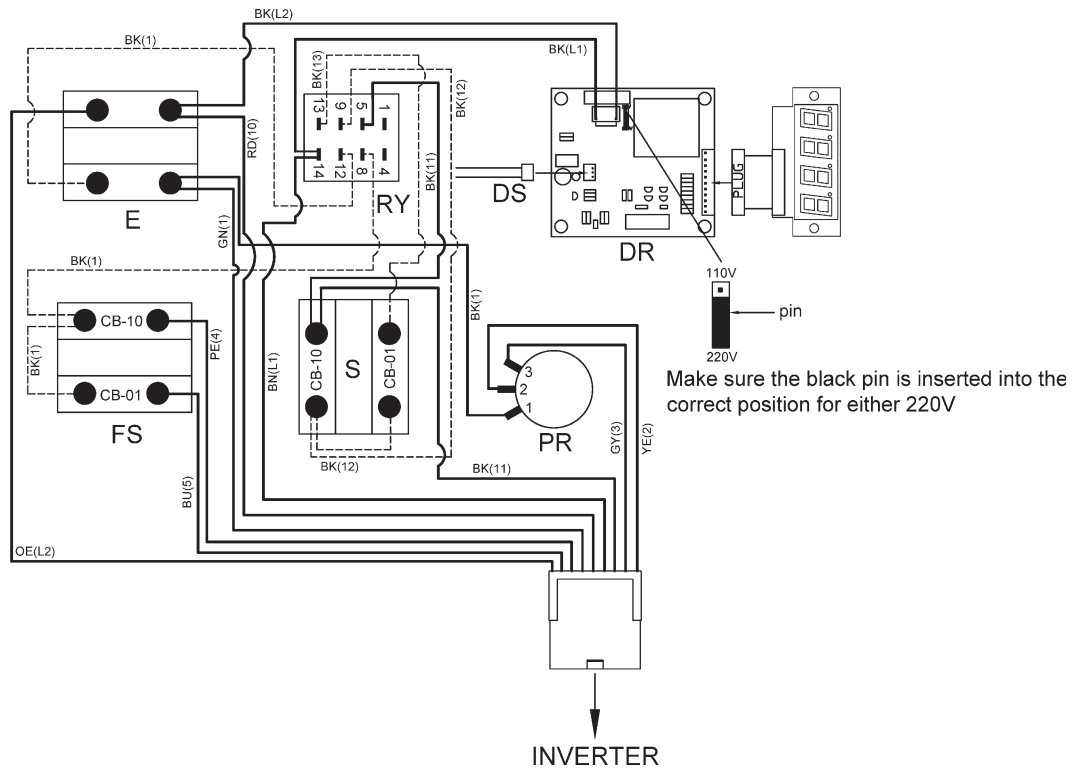
	meaning of symbol
M	motor
LS	limit switch
OL	overload cut-off
HS	HEAD/REMOTE switch
RY	relay
BR	braking resistor
IR	inverter
CS	centrifugal switch



Wiring diagram for control panel on headstock.

	colour of strands
BK	black
BU	blue
YE	yellow
RD	red
BN	brown
PE	purple
GN	green
GY	gray
OE	orange

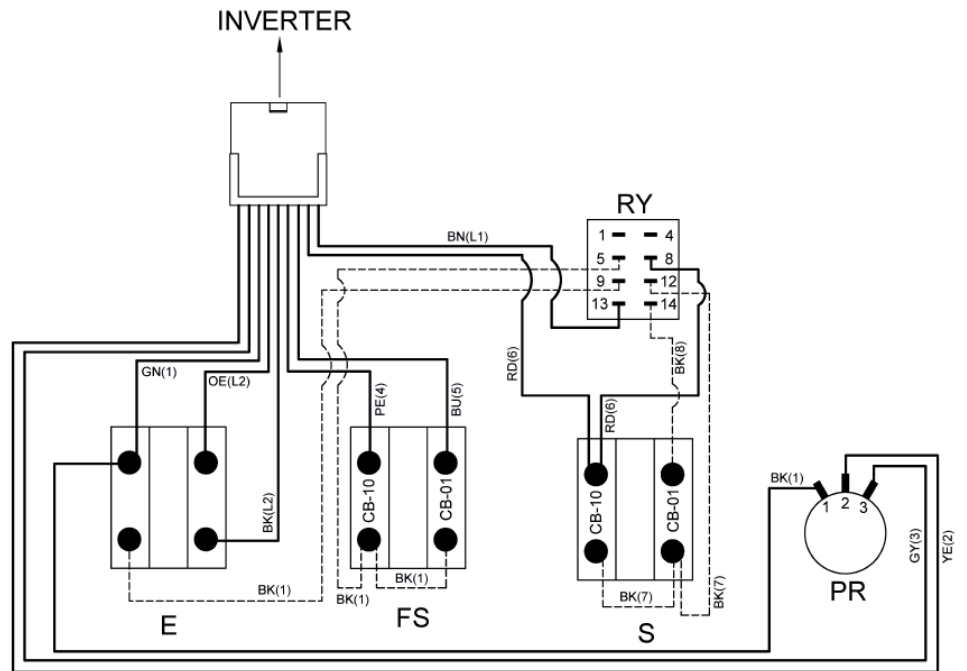
	meaning of symbol
S	switch
E	emergency stop
PR	potentiometer
FS	FWD/REV switch
RY	relay
DS	digital readout sensor
DR	digital readout



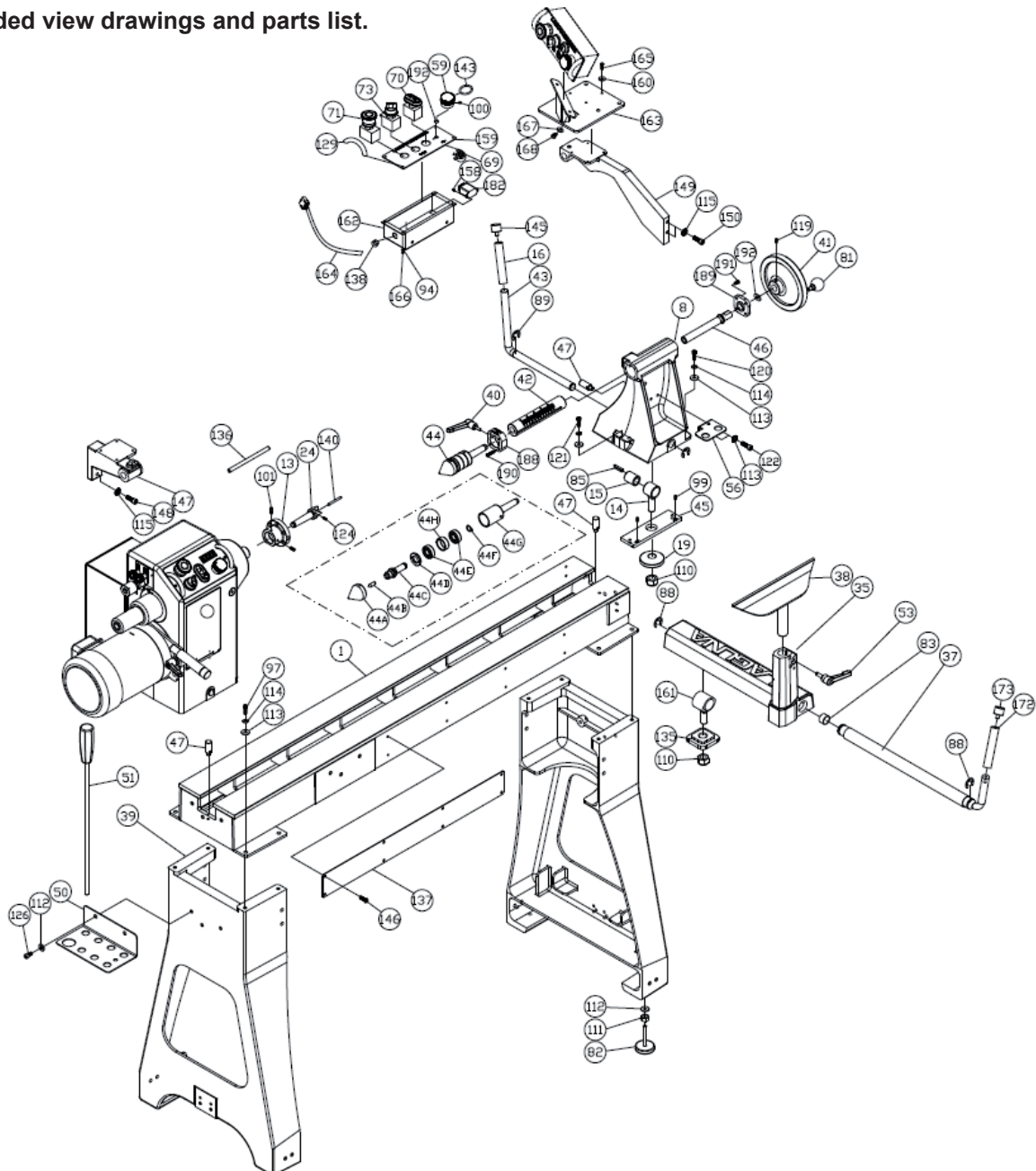
Wiring diagram for remote control.

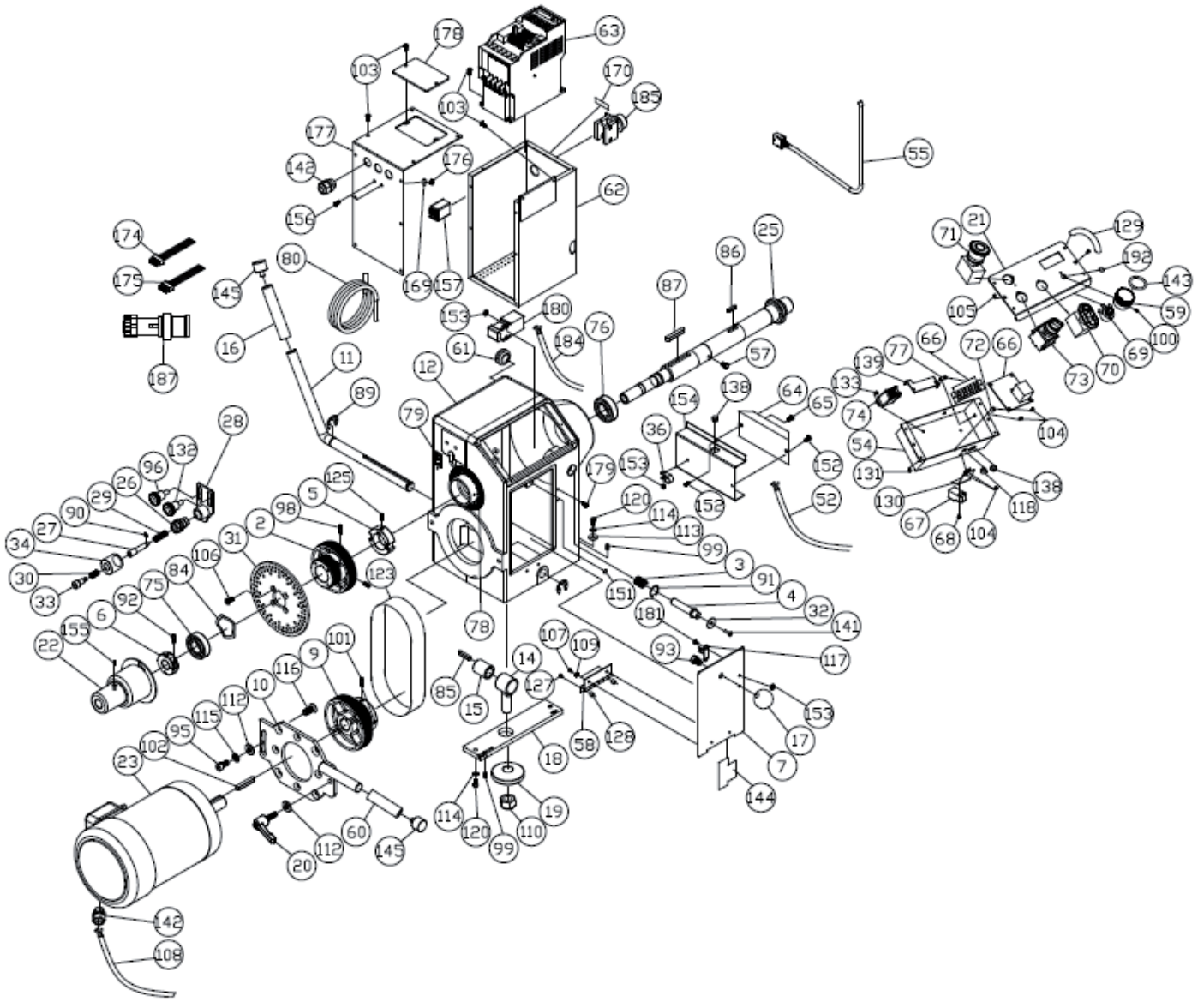
	colour of strands
BK	black
BU	blue
YE	yellow
RD	red
BN	brown
PE	purple
GN	green
GY	gray
OE	orange

	meaning of symbol
S	switch
E	emergency stop
PR	potentiometer
FS	FWD/REV switch
RY	relay



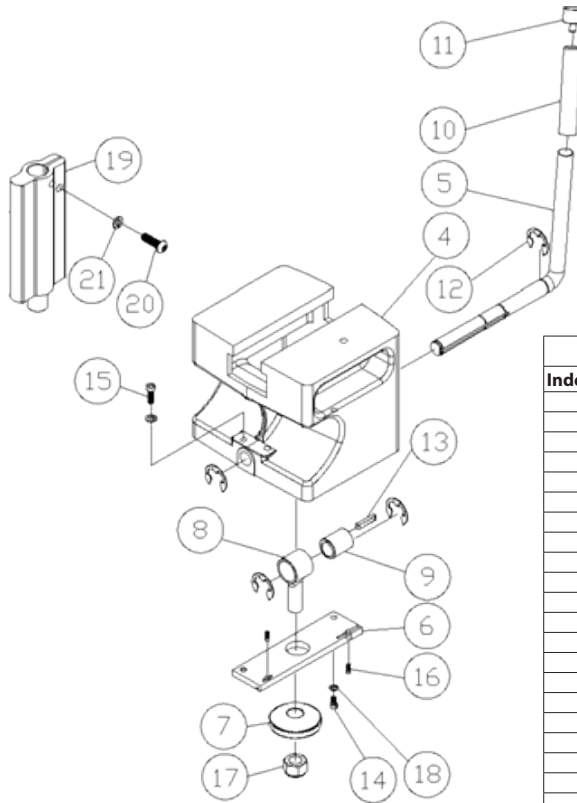
Exploded view drawings and parts list.



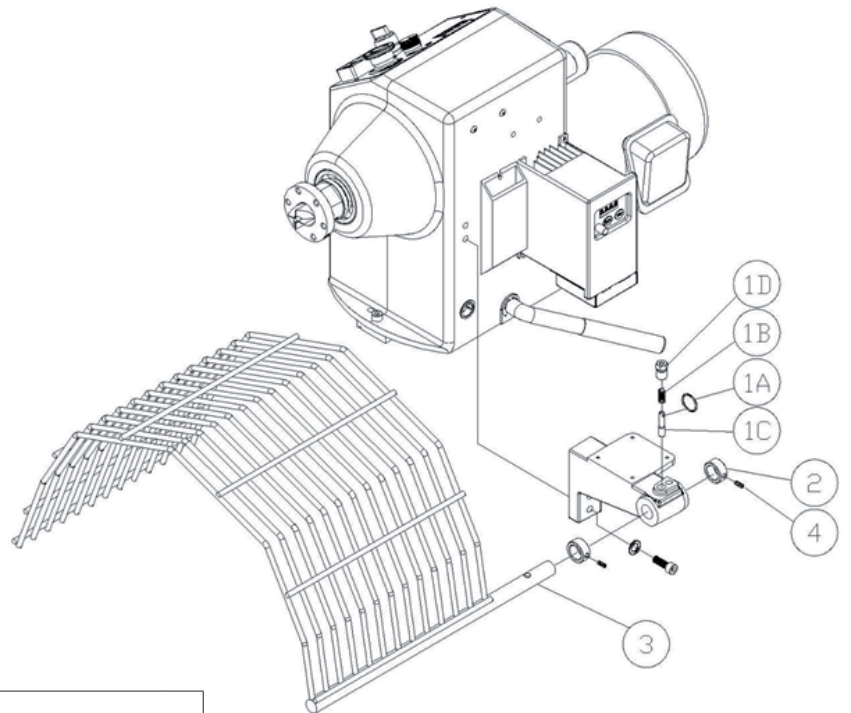
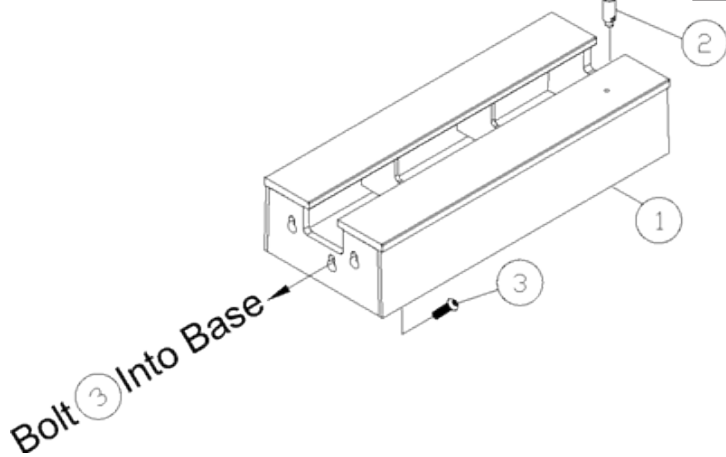


Index	Part Number	Item Description	Specification	Qty
1	PLAREVO1836-101	Bed		1
2	PLAREVO1836-102	Spindle Pulley		1
3	PLAREVO1836-103	Spring		1
4	PLAREVO1836-104	Spindle Lock Plunger		1
5	PLAREVO1836-105	Locking Collar		1
6	PLAREVO1836-106	Bearing Nut		1
7	PLAREVO1836-107-UK	Door		1
9	PLAREVO1836-109	Motor Pulley		1
10	PLAREVO2436-220-110	Motor Plate		1
11	PLAREVO1836-111	Headstock Locking Handle		1
12	PLAREVO-2436-220-112-UK	Headstock		1
13	PLAREVO1836-113-UK	3" Faceplate		1
14	PLAREVO1836-114	Clamp Bolt		2
15	PLAREVO1836-115	Sleeve		2
16	PLAREVO1836-116	Rubber Sleeve		2
17	PLAREVO1836-117	Knob		1
18	PLAREVO1836-118	Headstock Adjusting Plate		1
19	PLAREVO1836-119	Clamp		2
20	PLAREVO1836-120	Lock Handle		1
21	PLAREVO2436-220-121	Control Panel		1
22	PLAREVO1836-122	Handwheel		1
23	PLAREVO-2436-220-123-UK	Motor		1
24	PLAREVO1836-124	Spur Center		1
25	PLAREVO1836-125-UK	Spindle		1
26	PLAREVO1836-126	Index Stud		1
27	PLAREVO1836-127	Index Shaft		1
28	PLAREVO1836-128	Index Bracket		1
29	PLAREVO1836-129	Spring		1
30	PLAREVO1836-130	Spring		1
31	PLAREVO1836-131	Index Plate		1
32	PLAREVO1836-132	Disc, Spindle Lock		1
33	PLAREVO1836-133	Index Bolt		1
34	PLAREVO1836-134	Index Knob		1
35	PLAREVO2436-220-135	Tool Rest Support Base		1
37	PLAREVO2436-220-137	Tool Rest Locking Handle		1
38	PLAREVO1836-138	12" Tool Rest		1
39	PLAREVO2436-220-139	Leg		2
40	PLAREVO1836-140A	Lock Handle		1
41	PLAREVO1836-141	Handwheel		1
42	PLAREVO1836-142A	Quill		1
43	PLAREVO1836-143	Tailstock Locking Handle		1
44	PLAREVO1836-144	Live Center Assembly		1
45	PLAREVO1836-145	Tailstock Adjusting Plate		1
46	PLAREVO1836-146	Lead Screw		1
47	PLAREVO1836-147	Stop Bolt		3
50	PLAREVO1836-150	Tool Caddy		1
51	PLAREVO1836-151	Knockout Rod		1
52	PLAREVO1836-152-UK	Braking Resistor Cord		1
53	PLAREVO1836-153	Lock Handle		1
54	PLAREVO1836-154	Control Box		1
55	PLAREVO2436-220-155	Control Cord		1
56	PLAREVO1836-156	Tailstock Tool Caddy		1
57	PLAREVO1836-157	Hex Cap Screw	M6x6	4
58	PLAREVO1836-158	Door Hinge		1
59	PLAREVO1836-159	Speed Knob		2
60	PLAREVO1836-160	Rubber Sleeve		1
61	PLAREVO1836-161	Rubber Bushing		1
62	PLAREVO-2436-220-162-UK	Control Box		1
63	PLAREVO-2436-220-163-UK	Inverter		1
64	PLAREVO1836-164	Braking Resistor		1
65	PLAREVO1836-165	Screw	M4x12	1
66	PLAREVO1836-166	Digital Readout		1
67	PLAREVO1836-167	Digital Readout Sensor		1
68	PLAREVO1836-168	Screw	M3x20	1
69	PLAREVO1836-169	Control Pot Assembly		2
70	PLAREVO1836-170	ON/ OFF Switch		2
71	PLAREVO1836-171	Emergency Stop		2
72	PLAREVO1836-172	Spacer		2
73	PLAREVO1836-173	Fwd/Rev Switch		2
74	PLAREVO1836-174	Relay		1
75	PLAREVO1836-175	Ball Bearing	6205LLU	1
76	PLAREVO2436-220-176	Ball Bearing	6307LLU	1
77	PLAREVO1836-177	Pillar		2
78	PLAREVO1836-178	Index Label		1
79	PLAREVO1836-179	Index Indicator		1
80	PLAREVO-2436-220-180-UK	Power Cord		1
81	PLAREVO1836-181	Knob		1
82	PLAREVO1836-182	Leveling Foot		4
83	PLAREVO2436-220-183	Bushing		1
84	PLAREVO1836-184	Wave Washer	6205	1
85	PLAREVO1836-185	Key	6x6x30	2
86	PLAREVO1836-186	Key	8x7x25	1
87	PLAREVO1836-187	Key	8x7x60	1
88	PLAREVO2436-220-188	E-Ring	E24	2
89	PLAREVO1836-189	E-Ring	E15	4
90	PLAREVO1836-190	E-Ring	E5	1
91	PLAREVO1836-191	C-Ring	R22	1
92	PLAREVO1836-192	Socket Head Cap Screw	1/4-20UNCx1"	1
93	PLAREVO1836-193	Hex Cap Screw	3/8-16UNCx1/2"	1
94	PLAREVO2436-220-194	Washer, Lock-Int. Tooth	M3	4
95	PLAREVO1836-195	Socket Head Cap Screw	3/8-16UNCx1"	1
96	PLAREVO1836-196	Knob		1
97	PLAREVO1836-197	Socket Head Cap Screw	5/16-18UNCx1"	8
98	PLAREVO1836-198	Set Screw	5/16-18UNCx3/8"	2
99	PLAREVO1836-199	Set Screw	M8x6	4

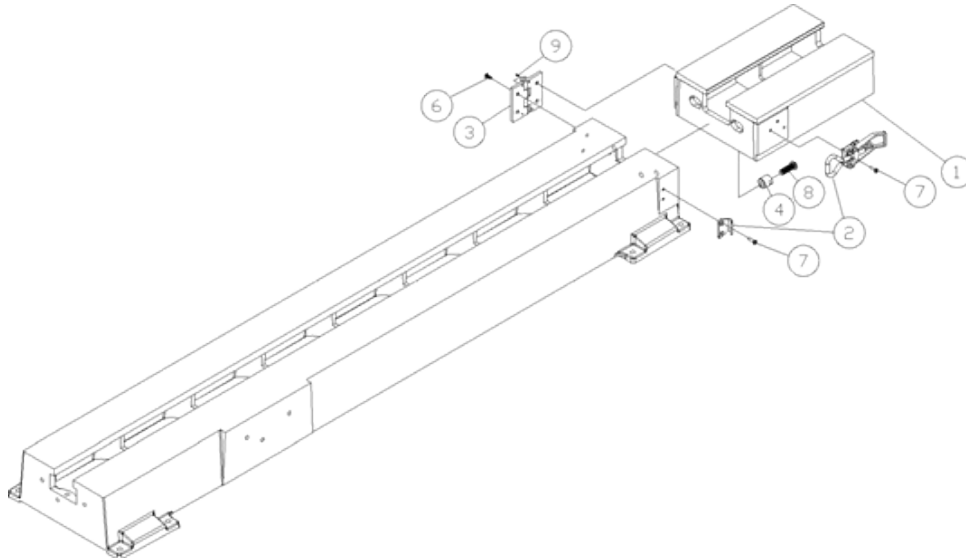
Index	Part Number	Item Description	Specification	Qty
100	PLAREVO1836-1100	Set Screw	M4x4	2
101	PLAREVO1836-1101	Set Screw	1/4-20UNCx1/4	4
102	PLAREVO1836-1102	Key	5x5x50	1
103	PLAREVO1836-1103-1	Screw	M4x8	16
104	PLAREVO1836-1104	Screw	M3x8	6
105	PLAREVO1836-1105	Socket Flat Head Screw	M3x8	2
106	PLAREVO1836-1106	Phillips Flat Head Screw	M6x16	4
107	PLAREVO1836-1107	Screw	M3x4	2
108	PLAREVO1836-1108-UK	Motor Cord		1
109	PLAREVO1836-1109	Flat Washer	D3xD8x1t	2
110	PLAREVO1836-1110	Nylon Insert Lock Nut	M18x2.5	3
111	PLAREVO1836-1111	Hex Nut	3/8-16UNC	4
112	PLAREVO1836-1112	Flat Washer	D10xD23x2t	8
113	PLAREVO1836-1113	Flat Washer	D8xD18x2t	13
114	PLAREVO1836-1114	Lock Washer	5/16"	12
115	PLAREVO1836-1115	Lock Washer	3/8"	5
116	PLAREVO1836-1116	Phillips Flat Head Screw	3/8-16UNCx3/4"	4
117	PLAREVO1836-1158	Safety Interlock Switch Pin		1
118	PLAREVO1836-1118	Strain Relief	2P-4	1
119	PLAREVO1836-1119	Set Screw	1/4-20UNCx3/8	1
120	PLAREVO1836-1120	Socket Head Button Screw	M8x30	3
121	PLAREVO1836-1121	Socket Head Button Screw	M8x45	1
122	PLAREVO1836-1122	Socket Head Cap Screw	5/16-18UNCx1/2"	2
123	PLAREVO2436-220-1123	Poly-V Belt	P18-200	1
124	PLAREVO1836-1124	Set Screw	M6x6	1
125	PLAREVO1836-1125	Set Screw	5/16-18UNCx1/4	1
126	PLAREVO1836-1126	Socket Head Button Screw	3/8-16UNCx5/8"	2
127	PLAREVO1836-1127	Screw	M3x12	2
128	PLAREVO1836-1128	Spacer		2
129	PLAREVO1836-1129	Handle		4
130	PLAREVO1836-1130	Sensor Bracket		1
131	PLAREVO1836-1131	Phillips Flat Head Screw	M3x4	4
132	PLAREVO1836-196	Knob		1
133	PLAREVO1836-1133	Screw	M3x4	1
135	PLAREVO2436-220-1135	Clamp		1
136	PLAREVO1836-1136	Handle, Faceplate		1
137	PLAREVO2436-220-1137	Logo Plate		1
138	PLAREVO1836-1138	Strain Relief	6N-4	2
139	PLAREVO1836-1139	Bracket		1
140	PLAREVO1836-1140	Thimble		1
141	PLAREVO1836-1141	Socket Flat Head Screw	M3x8	1
142	480B5-194	Strain Relief	PG-11	5
143	PLAREVO1836-1143	O-Ring	P29	2
144	PLAREVO1836-1144	Speed Label		1
145	PLAREVO1836-1145	Cap		3
146	PLAREVO1836-1146	Socket Head Button Screw	1/4-20UNCx3/8"	8
147	PLAREVO2436-220-1147	Headstock Bracket		1
148	PLAREVO1836-1148	Socket Head Cap Screw	3/8-16UNCx1-1/4"	2
149	PLAREVO2436-220-1149	Tailstock Bracket		1
150	PLAREVO1836-1150	Socket Head Cap Screw	3/8-16UNCx3/4"	2
151	PLAREVO1836-1151	Magnet		1
152	PLAREVO1836-1152	Screw	M4x6	2
153	PLAREVO1836-1153	Hex Nut	M4x0.7	5
154	PLAREVO1836-1154	Braking Resistor Cover		1
155	PLAREVO1836-1155	Set Screw	M6x12	2
156	PLAREVO1216-197	Screw	#10-32UNFx1/2"	2
157	PLAREVO2436-220-1157	Relay		1
158	PLAREVO2436-220-1158	Socket Head Button Screw	M3x6	1
159	PLAREVO2436-220-1159	Remote Control Panel		1
160	PLAREVO2436-220-1160	Flat Washer	D4xD20x2t	4
161	PLAREVO2436-220-1161	Clamp Bolt		1
162	PLAREVO-2436-220-1162-UK	Remote Control Box		1
163	PLAREVO2436-220-1163	Bracket		2
164	PLAREVO2436-220-1164	Remote Control Cord		1
165	PLAREVO2436-220-1165	Screw	M4x12	4
166	PLAREVO2436-220-1166	Screw	M3x6	4
167	PLAREVO2436-220-1167	Washer, Lock-Int. Tooth	1/4"	2
168	PLAREVO2436-220-1168	Hex Cap Screw	1/4-20UNCx3/8"	2
169	PLAREVO1216-193	Washer, Lock-Int. Tooth	#10	2
170	PLAREVO2436-220-1170	Head/Remote Label		1
171	PLAREVO2436-220-1171	Cable Clamp(NO SHOW)		2
172	PLAREVO2436-220-1172	Rubber Sleeve		1
173	PLAREVO2436-220-1173	Cap		1
174	PLAREVO-2436-220-1174-UK	Connector, Remote		1
175	PLAREVO-2436-220-1175-UK	Connector, Head		1
176	PLAREVO1216-192	Hex Nut	#10-32UNF	2
177	PLAREVO-2436-220-1177-UK	Control Box Cover		1
178	PLAREVO2436-220-1178	Tracking Window		1
179	PLAREVO1216-183	Screw	M4x20	2
180	PLAREVO1836-1160	Safety Interlock Switch	QKS2	1
181	PLAREVO1836-1157	Phillips Flat Head Screw	M4x10	2
182	PLAREVO2436-220-1182	Relay		1
184	PLAREVO2436-220-1184	Safety Interlock Switch Cord		1
185	PLAREVO2436-220-1185	Fwd/Rev Switch(KEY)		1
187	PLAREVO2436-220-1187	Plug		1
188	PLAREVO1836-1167	Adjusting Block		1
189	PLAREVO1836-1168	Adjusting Block		1
190	PLAREVO1836-1169	Socket Head Button Screw	3/16-24UNCx1"	4
191	PLAREVO1836-1170	Socket Head Button Screw	3/16-24UNCx5/8"	4
192	PLAREVO1836-1156	O-Ring	P14	2
193	PLAREVO1836-1174	Wave Washer	M19	1



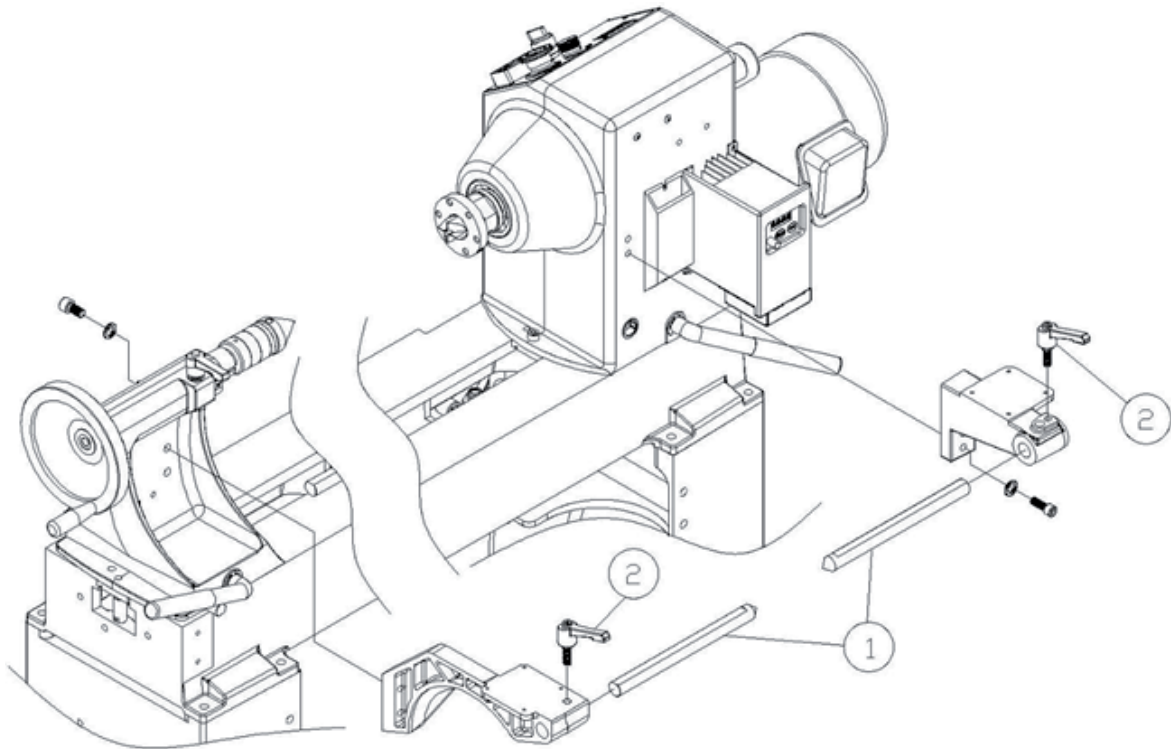
Optional 20" Bed Extension with Riser Block and Tool Rest Extension				
Index	Part Number	Item Description	Specification	Qty
1	PLAREVO1836-301	20" Bed Extension		1
2	PLAREVO1836-147	Stop Bolt		2
3	PLAREVO1836-195	Socket Head Cap Screw	3/8-16UNCx1"	3
4	PLAREVO1836-304	Riser Block		1
5	PLAREVO1836-305	Riser Block Locking Handle		1
6	PLAREVO1836-306	Riser Block Adjusting Plate		1
7	PLAREVO1836-119	Clamp		1
8	PLAREVO1836-114	Clamp Bolt		1
9	PLAREVO1836-115	Sleeve		1
10	PLAREVO1836-116	Rubber Sleeve		1
11	PLAREVO1836-1145	Cap		1
12	MPAREVO1836-189	E-Ring		4
13	PLAREVO1836-185	Key	E15	1
14	PLAREVO1836-194	Socket Head Button Screw	M8x20	1
15	PLAREVO1836-315	Socket Head Button Screw	M8x50	1
16	PLAREVO1836-199	Set Screw	M8x6	2
17	PLAREVO1836-1110	Nylon Insert Lock Nut	M18x2.5	1
18	PLAREVO1836-1114	Lock Washer	5/16"	2
19	PLAREVO1836-319	Tool rest Extension		1
20	PLAREVO1836-320	Socket Head Button Screw	3/8-16UNCx1-1/4"	1
21	PLAREVO1836-1115	Lock Washer	3/8"	1



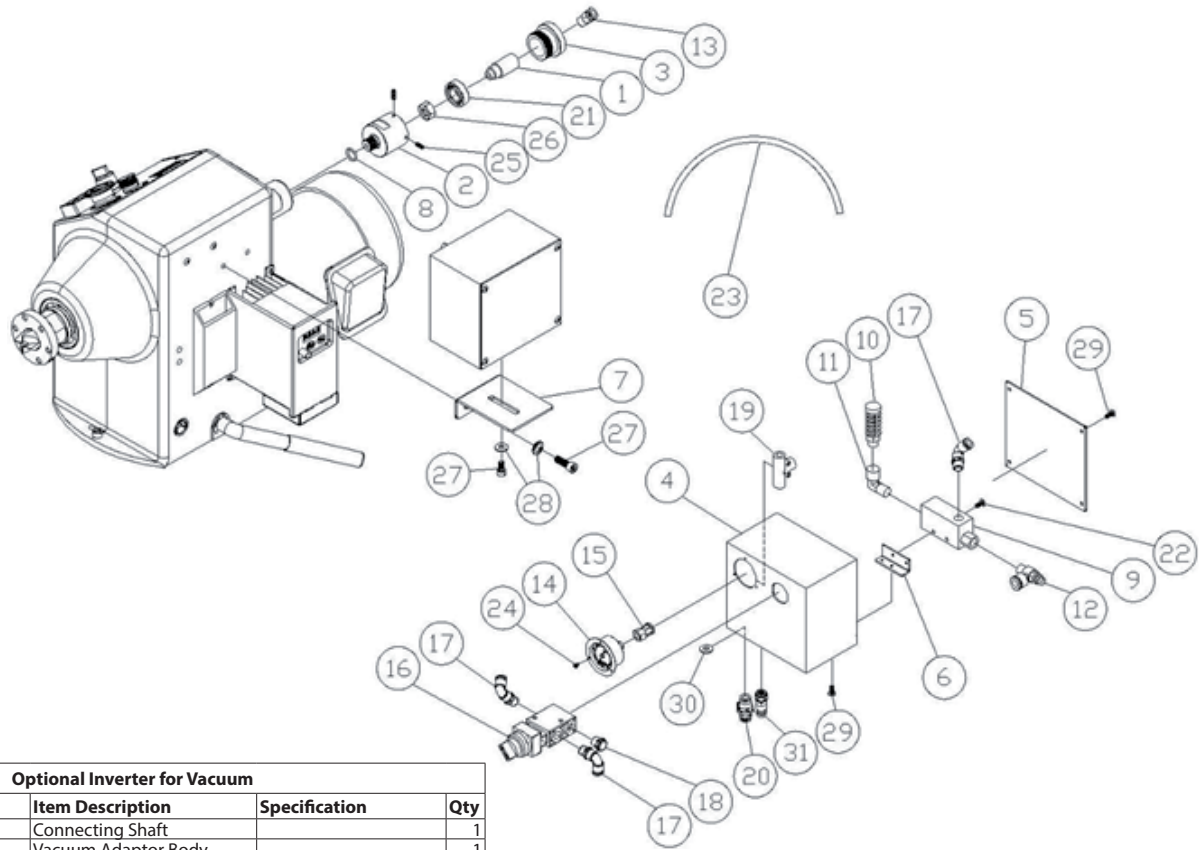
Optional Headstock Guard				
Index	Part Number	Item Description	Specification	Qty
1	PLAREVO1836-201	Plunger		1
2	PLAREVO1836-202	Retaining Collar		2
3	PLAREVO1836-203	Guard		1
4	PLAREVO1836-204	Set Screw	1/4-20UNCx1/4"	2



Optional 12" Swing-Away Extension				
Index	Part Number	Item Description	Specification	Qty
1	PLAREVO1836-401	12" Bed Extension		1
2	PLAREVO1836-402	Draw Latch Assembly		1
3	PLAREVO1836-403	Hinge		1
4	PLAREVO1836-404	Pin		2
5	PLAREVO1836-147	Stop Bolt		1
6	PLAREVO1836-406	Socket Head Cap Screw	M6x12	4
7	PLAREVO1836-407	Phillips Flat Head Screw	M5x12	5
8	PLAREVO1836-320	Socket Head Button Screw	3/8-16UNCx1-1/4"	2
9	PLAREVO1836-409	Set Screw	3/16-24UNCx3/8"	4

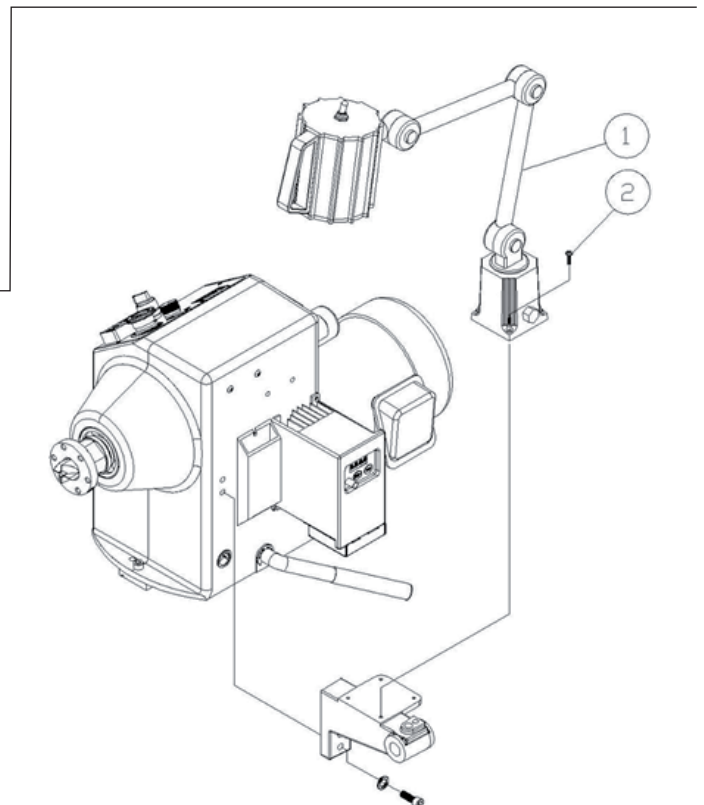


Optional Comparator				
Index	Part Number	Item Description	Specification	Qty
1	PLAREVO1836-501	Center		2
2	PLAREVO1836-502	Lock Handle		2



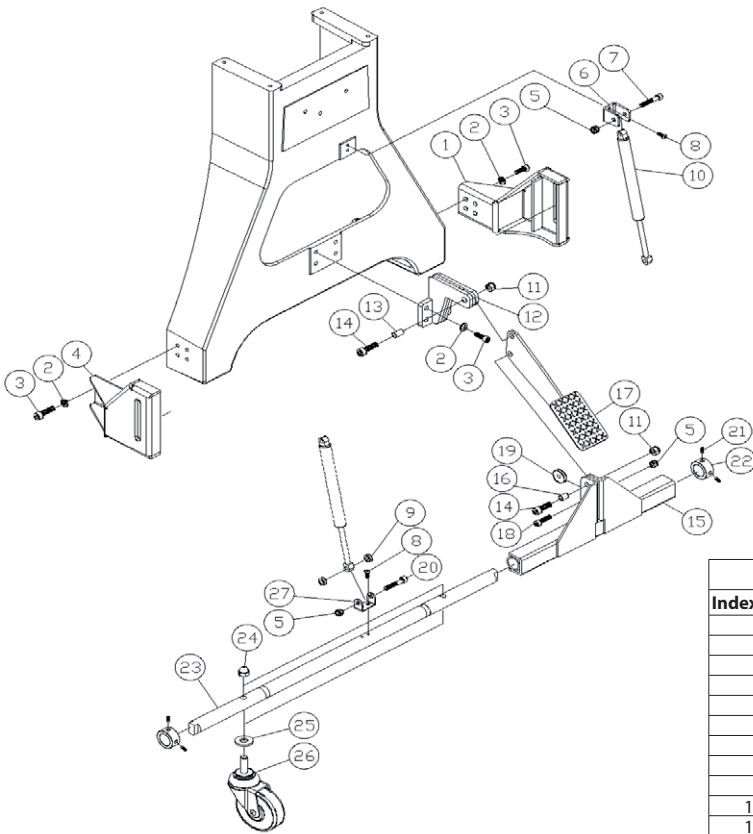
Optional Inverter for Vacuum

Index	Part Number	Item Description	Specification	Qty
1	PLAREVO1836-801	Connecting Shaft		1
2	PLAREVO1836-802	Vacuum Adaptor Body		1
3	PLAREVO1836-803	Cover		1
4	PLAREVO1836-804	Vacuum System Box		1
5	PLAREVO1836-805	Plate		1
6	PLAREVO1836-806	Vacuum Generator Bracket		1
7	PLAREVO1836-807	Vacuum System Bracket		1
8	PLAREVO1836-808	O-Ring	P14	1
9	PLAREVO1836-809	Vacuum Generator		1
10	PLAREVO1836-810	Silencer		1
11	PLAREVO1836-811	L-Type Fitting		1
12	PLAREVO1836-812	Air Flow Regulator		1
13	PLAREVO1836-813	Quick Release Fitting		1
14	PLAREVO1836-814	Pressure Vacuum Gauge		1
15	PLAREVO1836-815	Gauge Fitting		1
16	PLAREVO1836-816	Vacuum Switch		1
17	PLAREVO1836-817	H-Type Fitting		1
18	PLAREVO1836-818	Flat Type Silencer		1
19	PLAREVO1836-819	T-Type Fitting		1
20	PLAREVO1836-820	Straight Fitting-Female		1
21	PLAREVO1836-821	Ball Bearing	6003ZZ	1
22	PLAREVO1836-822	Screw	M4x30	2
23	PLAREVO1836-823	Air Hose		1
24	PLAREVO1836-824	Screw	M2.5x5	3
25	PLAREVO1836-825	Set Screw	M5x5	2
26	PLAREVO1836-826	Hex Nut	M12	1
27	PLAREVO1836-827	Socket Head Cap Screw	5/16-18UNCx1/2"	4
28	PLAREVO1836-1113	Flat Washer	D8xD18x2t	4
29	PLAREVO1836-829	Screw	M4x10	6
30	PLAREVO1836-830	Flat Washer	D1/2"xD26x2.5t	1
31	PLAREVO1836-831	Quick Fitting- Inlet		1

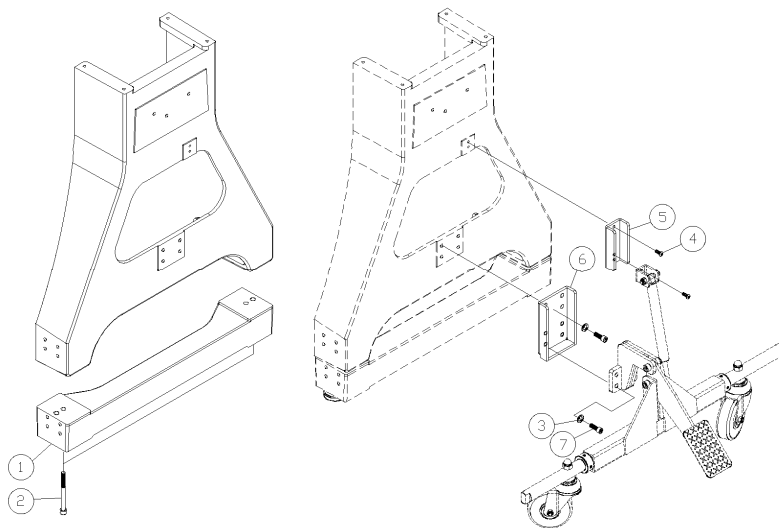


Optional Industrial Flood Light

Index	Part Number	Item Description	Specification	Qty
1	PLAREVO1836-601	Work Light		1
2	PLAREVO1836-602	Screw	M4x15	4



Optional Deluxe Wheel System				
Index	Part Number	Item Description	Specification	Qty
1	PLAREVO1836-901	Support Bracket-Right		2
2	PLAREVO1836-1115	Lock Washer	3/8"	24
3	PLAREVO1836-195	Socket Head Cap Screw	3/8-16UNCx1"	24
4	PLAREVO1836-904	Support Bracket-Left		2
5	PLAREVO1836-905	Nylon Insert Lock Nut	M8x1.25	6
6	PLAREVO1836-906	Support Bracket		2
7	PLAREVO1836-907	Socket Head Cap Screw	M8X45mm	2
8	PLAREVO1836-1146	Socket Head Button Screw	1/4-20UNCx3/8"	8
9	PLAREVO1836-909	Spacer		4
10	PLAREVO1836-910	Cylinder		2
11	PLAREVO1836-911	Nylon Insert Lock Nut	M10x1.5	4
12	PLAREVO1836-912	Support Bracket		2
13	PLAREVO1836-913	Bushing		2
14	PLAREVO1836-914	Socket Head Cap Screw	M10x35mm	4
15	PLAREVO1836-915	Connecting rod		2
16	PLAREVO1836-916	Bushing		2
17	PLAREVO1836-917	Foot Brake		2
18	PLAREVO1836-918	Socket Head Cap Screw	M8X30mm	2
19	PLAREVO1836-919	Bushing		2
20	PLAREVO1836-920	Socket Head Cap Screw	M8X50mm	2
21	PLAREVO1836-199	Set Screw	M8x6	8
22	PLAREVO1836-922	Spacer		4
23	PLAREVO1836-923	Rod		2
24	PLAREVO1836-924	Nut	1/2"-12UNC	4
25	PLAREVO1836-925	Flat Washer	1/2"	4
26	PLAREVO1836-926	Caster	4	1
27	PLAREVO1836-927	Support Bracket		4



Optional 3" Riser Blocks				
Index	Part Number	Item Description	Specification	Qty
1	PLAREVO1836-701	3" Riser Blocks		2
2	PLAREVO1836-702	Socket Head Cap Screw	3/8-16UNCx3-1/2"	4
3	PLAREVO1836-1115	Lock Washer	3/8"	8
4	PLAREVO1836-1146	Socket Head Button Screw	1/4-20UNCx3/8"	4
5	PLAREVO1836-705	Support Bracket		2
6	PLAREVO1836-706	Support Bracket		2
7	PLAREVO1836-707	Socket Head Cap Screw	3/8-16UNCx3/4"	8

INDEX SYSTEM

	1	2	3	4	5	6	7	8	9	10	11	12
14	25.7	51.4	77.1	102.9	128.6	154.3	180	205.7	231.4	257.1	282.9	308.6
36	10	20	30	40	50	60	70	80	90	100	110	120
48	7.5	15	22.5	30	37.5	45	52.5	60	67.5	75	82.5	90

	13	14	15	16	17	18	19	20	21	22	23	24
14	334.3	360										
36	130	140	150	160	170	180	190	200	210	220	230	240
48	97.5	105	112.5	120	127.5	135	142.5	150	157.5	165	172.5	180

	25	26	27	28	29	30	31	32	33	34	35	36
14												
36	250	260	270	280	290	300	310	320	330	340	350	360
48	187.5	195	202.5	210	217.5	225	232.5	240	247.5	255	262.5	270

	37	38	39	40	41	42	43	44	45	46	47	48
14												
36												
48	277.5	285	292.5	300	307.5	315	322.5	330	337.5	345	352.5	360

Circle(°)	Segment	Average
360	14	25.7143
	36	10
	48	7.5



IGM nástroje a stroje s.r.o., Ke kopanině 560,
Tuchoměřice, 252 67, Czech Republic, E.U.
+420 220 950 910, www.igm.cz