

Nardini 1440E Lathe 201 Class.

Safety - recap.

- Wear safety glasses or side covers for normal glasses.
- No long sleeves, loose clothing, neckties or scarves.
- Closed toe shoes.
- No gloves.

Lubrication - recap - Oil every time.

- 8/9 points on the Saddle.
- 2 points on top of Tail stock and 2 on the sides.
- A few drops on the ways.

Power up - recap.

- Main switch on the back to show red in the window.
- Power light on - if not check breakers.
- Pull the emergency switch.
- Motor switch (Low/High). (Plan in conjunction with gearbox).

Removing the draw bar.

- Remove collet if needed.
- Remove pin, pull draw bar out and replace pin.
- Remove collet adapter if needed. Use pipes to knock it out.

Mounting Chuck.

- Make sure you can pick it up and set it down without pinching a finger.
- Remove collet adapter - one chuck will mount with the collet adapter in place.
- Inspect the chuck mating face with lathe - make sure both are clean.
- Place wood support block.
- All locks in position I.
- Line up the mark on 3 jaw chucks.
- Tighten locks across, slight and then firm on second go-around.
- Run slowly and check for gaps on mating face.
- Insert smooth bar and check run out on 3 jaw (option) mandatory (4 jaw).
- Never run faster than 500 RPM.
- **There has to be a hand on the T-handle while it is the chuck. Same thing goes for the handle that gives extra leverage to the drawbar on lathe 2.**
- Has lots of momentum - will keep turning for a while after stop on lathe 1. Lathe 2 has a brake.

Start

- Check the full distance of planned cut for interference.
- Engage gearbox. Move spindle to engage gears.
 - If this is not easy, you are not doing it right.
 - Keep in mind which gear is engaged to spindle.

Power Feed

- Be aware of the safety clutch.
- Set safety stop up.
- The "T" setting - power feed shaft only.
- Select feed for saddle or cross slide.
- Once again - Check for interference for full length of planned cut.
- Less material means smoother finish.
- Test the engage lever before starting and keep your hand on it.
- Start with ample space around to confirm your direction.

Removing Chuck.

- Place wood support block.
- All locks slowly back to position I. When you do the last one, the chuck will sag - be prepared. On lathe 2 you have to whack it with the dead blow hammer.
- Store on cart and install collet draw bar.

Thread Cutting.

- Lathe 1 does TPI and Lathe 2 does metric.
- Use table to select appropriate thread.
- The thread cutting dial does not work for metric.
- Thread cutting only engages on sync marks.
- Engaging is easy if you do it right.
- Forward / Reverse (metric) vs. engage / disengage (TPI).
- Chamfer end and cut relief before cutting threads.
- When you are getting close, cut twice with no adjustment.
- No more than 5 thousands at a time when close.
- Once done flatten threads with file.