



CX803
14" X 43" - 3/4HP WOOD LATHE
User Manual



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GENERAL SAFETY INSTRUCTIONS FOR MACHINES

Extreme caution should be used when operating all power tools. Know your power tool, be familiar with its operation, read through the owner's manual, and practice safe usage procedures at all times.

- ❖ **ALWAYS** read and understand the user manual before operating the machine.
- ❖ **CONNECT** your machine ONLY to the matched and specific power source.
- ❖ **ALWAYS** wear safety glasses respirators, hearing protection and safety shoes, when operating your machine.
- ❖ **DO NOT** wears loose clothing or jewelry when operating your machine. Wear protective hair covering.
- ❖ **A SAFE ENVIRONMENT** is important. Keep the area free of dust, dirt and other debris in the immediate vicinity of your machine.
- ❖ **BE ALERT! DO NOT** use prescription or other drugs that may affect your ability or judgment to safely use your machine.
- ❖ **DISCONNECT** the power source when changing drill bits, hollow chisels, router bits, shaper heads, blades, knives or making other adjustments or repairs.
- ❖ **NEVER** leave a tool unattended while it is in operation.
- ❖ **NEVER** allow unsupervised or untrained personnel to operate the machine
- ❖ **NEVER** reach over the table when the tool is in operation.
- ❖ **ALWAYS** keep blades, knives and bits sharpened and properly aligned.
- ❖ **ALL OPERATIONS MUST BE** performed with the guards in place to ensure safety.
- ❖ **ALWAYS** use push sticks and feather boards to safely feed your work through the machine.
- ❖ **ALWAYS** make sure that any tools used for adjustments are removed before operating the machine.
- ❖ **ALWAYS** keep bystanders safely away while the machine is in operation.
- ❖ **NEVER** attempt to remove jammed cutoff pieces until the blade has come to a full stop.

CX803 – 14" x 43" WOOD LATHE SPECIFIC SAFETY INSTRUCTIONS

Like all power tools and machinery, proper safety and attention must be adhered to. There is danger associated with using any tool or machine so pay careful attention each and every time you use your tool. If you are not familiar with the operations of a lathe, you should obtain the advice and/or instructions from a qualified professional.

- ❖ **Read this operation manual** carefully and understand it before operating the lathe.
- ❖ **Do not over-reach.** Keep proper footing and balance at all times.
- ❖ **Maintain machine** in top condition. Keep machine clean for best and safest performance. Follow instructions for lubrication and changing accessories.
- ❖ **Disconnect the machine** from power source before servicing, changing accessories, and making any adjustments.
- ❖ **To avoid accidental starting,** make sure the switch is in the OFF position before plugging in the power cord.
- ❖ **Never leave the lathe running** and unattended. Turn the power OFF. Do not leave the machine until it comes to a complete stop.
- ❖ **Start and stop the machine yourself.** To avoid accidental injuries make sure not to have anybody help you do this.
- ❖ **Always wear dust mask** operation creates a lot of sawdust and/or chips.
- ❖ **Always operate** the tools in a well-ventilated area and make sure to use a proper dust collection system for optimum dust removal.
- ❖ **Turn OFF then machine** before making any adjustments or servicing.
- ❖ **Do not attempt** to measure the work-piece size while the machine is running.
- ❖ **Make sure** the work-piece is clamped securely between the centers before starting the machine.
- ❖ **Only use** correct size centers.
- ❖ **After adjusting or servicing** the machine, remember to remove all wrenches and other tools from the machine.
- ❖ **Make sure you have read and understood** the instructions given in this manual and you are familiar with your lathe before operating it. If you fail to do so, serious injury could occur.

WARNING!

The safety instructions given above can not be complete because the environment in every shop is different. Always consider safety first as it applies to your individual working conditions.



CX803 – HEAVY DUTY WOOD LATHE

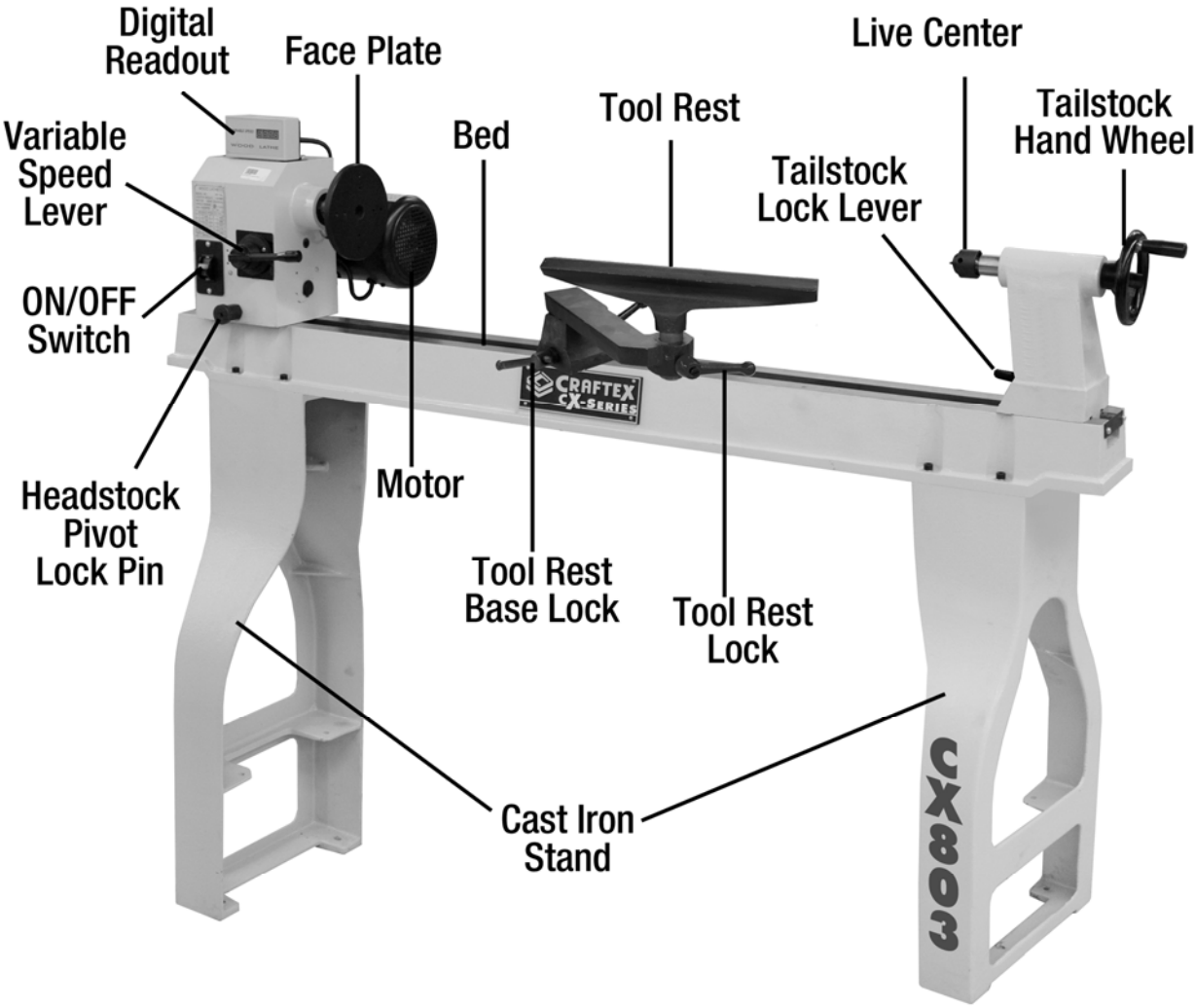
FEATURES

MODEL CX803 – 14" x 43" WOOD LATHE

As part of the growing line of Craftex CX-Series woodworking equipment, we are proud to offer the CX803, a 14" x 43" Wood Lathe. By following the instructions and procedures laid out in this user manual, you will receive years of excellent service and satisfaction. The CX803 is a professional tool and like all power tools, proper care and safety procedures should be adhered to.

- Motor 3/4HP, 120V, Single Phase
- Number of Speeds..... Variable Speed
- Spindle Taper MT2
- Spindle Size..... 1" x 8 TPI
- Swing Over Bed..... 14" (355mm)
- Distance Between Centers 43" (1100mm)
- Spindle Speed Ranges..... Variable, 600 - 2400 RPM
- Tailstock Taper MT2
- Tailstock Spindle Travel 2-1/4" (57mm)
- Faceplate Size..... 6" (152mm)
- Bed Construction..... Precision Ground Cast Iron
- Stand Construction Cast Iron
- Headstock Construction..... Cast Iron
- Tailstock Construction Cast Iron
- Digital RPM Display Yes
- Overall Length 63" (1600mm)
- Approx Weight..... 281 lbs (128 Kg)
- Warranty 3 Years

CX803 – WOOD LATHE PHYSICAL FEATURES



PROPER GROUNDING

Grounding provides a path of least resistance for electric current to reduce the risk of electric shock.

CX803 is for use on a normal 120 volt circuit. Make sure that the machine is connected to an outlet having the same configuration as the plug. If an adaptor plug is used, it must be attached to the metal screw of the receptacle. To prevent electrical hazards, have a qualified electrician ensure that the line is properly wired.

The lathe should be wired with a plug having 3 prongs to fit a 3 prong grounded receptacle as shown in figure-3. Do not remove the grounding prong to fit it into a 2 pronged outlet.

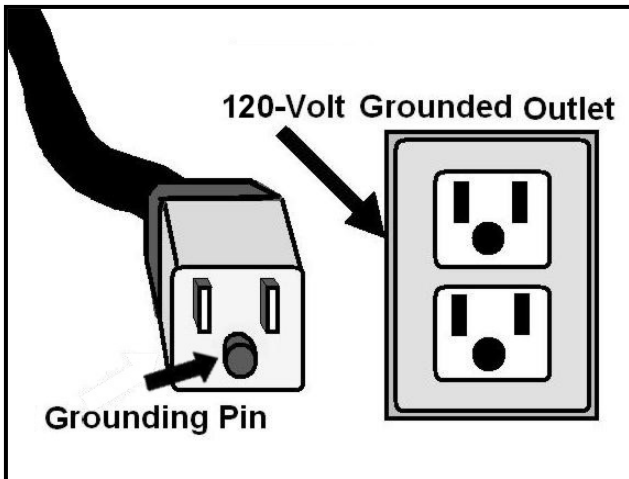


Figure-1 120-Volts outlet for CX803

WARNING

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. Check with a qualified electrician if you are in doubt as to whether the outlet is properly grounded.

It is strongly recommended not to use extension cords with your CX803. Always try to position your machine close to the power source so that you do not need to use extension cords.

In case if you really find it necessary to use an extension cord, make sure the extension cord does not exceed 50-feet in length and the cord is 14-gauge to prevent motor damage.

UNPACKING

The lathe is properly packaged and shipped complete in a crate for safe transportation. When unpacking, carefully inspect the crate to ensure that nothing has been damaged during transit. Open the crate and check that the lathe and the parts are in good condition.

While doing inventory, if you can not find any part, check if the part is already installed on the machine. Some of the parts come pre-assembled.

LIST OF CONTENTS	QTY
A. Lathe	1
B. Tailstock Center	1
C. Headstock Center.....	1
D. Digital Readout.....	1
E. Faceplate	1
F. Stand Legs	2
G. Leveling Feet.....	4
H. Tool Rest.....	1
I. Knockout Bar.....	1
J. Hex Wrenches.....	4
K. Hardware.....	in a Bag

SETUP

Before setting up your machine, you should read and understand the instructions given in this manual.

The unpainted surfaces of this lathe are coated with rust preventive waxy oil and you will want to remove this before you begin assembly. Use a solvent cleaner that will not damage the painted surfaces.

WARNING!

CX803 is a very heavy machine. Do not over-exert yourself. Use a fork truck or other mechanical devices for safe moving.

When moving the machine, position the straps under the lathe bed to lift the lathe safely. Make sure when lifting, the lathe is balance on both sides.

MOUNTING

The CX803 comes with 2 pre drilled holes on each stand legs that allow mounting the feet or securing the lathe to the floor.

Lag shield anchors with lag screws and anchor studs (not included) are the two best methods for mounting an object on the concrete floor.

When mounting the lathe on the floor, make sure the lathe is balanced from all four sides. If the lathe is not balanced, use shims under the legs to balance it.

ASSEMBLY

TO ASSEMBLE YOUR CX803:

Position the stand legs up right, aligned about 41" apart from each other.

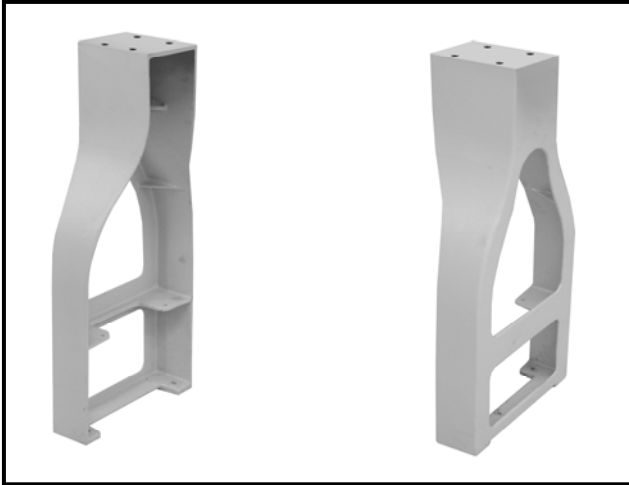


Figure-2 Stand legs positioned to mount the lathe on

Lift the lathe with the help of a fork truck or another mechanical device and place it on the stands.

Align the holes on the lathe bed with the holes on the stand legs and secure the lathe onto the stand using screws and washers provided. See figure-3.

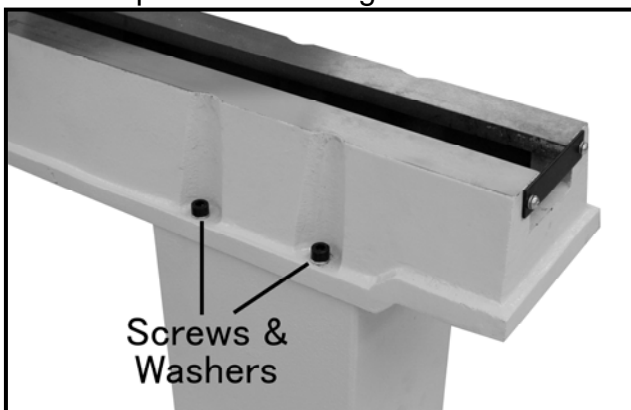


Figure-3 Lathe secured on the stand

Install the tool rest on the lathe bed and secure it by tightening the levers. See figure-4.

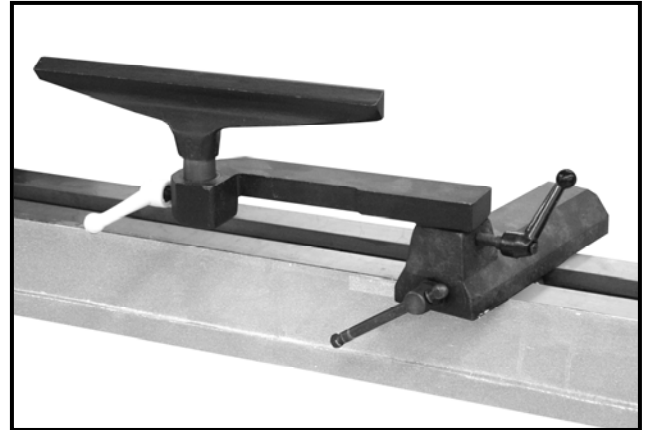


Figure-4 Installing the tool rest

Attach the digital readout to the top of the headstock and securing it using the pre-installed screws and washers shown in figure-5.

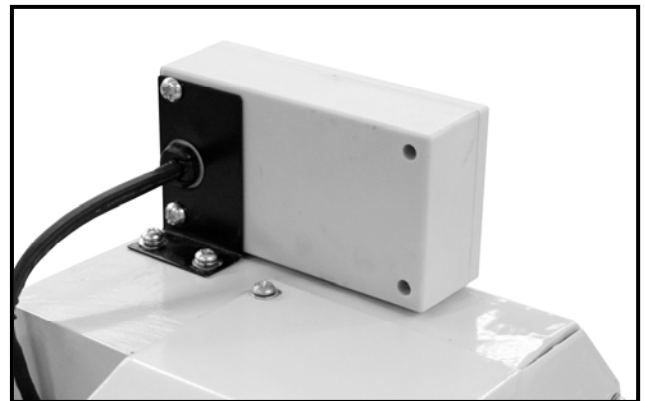


Figure-5 Installing the digital readout

TEST RUN

Once you have assembled your lathe completely, it is then time for a test run to make sure that the machine works properly and is ready for operation.

TO TEST RUN THE CX803:

1. Make sure you have read and understand the safety instructions in this manual.
2. Remove all the tools used for assembling the machine and make sure all the guards are in place.
3. Connect the cord to the power outlet.
4. Push the switch up to turn ON the machine.
5. Observe the machine carefully for any excessive vibration or noise.

The machine will run smoothly with little vibration and noise. If you hear any unusual noise(s) coming from the machine or if it vibrates excessively, shut the machine OFF immediately and disconnect from the power source. Investigate to determine the problem with your machine.

6. Turn the lathe OFF and remove the disabling feature from the ON/OFF switch and start the machine.

The machine should not start. If the machine does not start, the switch disabling key is working.

If the machine starts, immediately stop the machine. The switch disabling feature is not

working on your machine and it should be fixed.

WARNING!

The spindle speed lever located on the headstock adjusts the pulley width which changes the spindle speed. To prevent the lathe from damage, the spindle speed lever must be used only when the lathe is running.

7. Turn the lathe ON.
8. Pull out the spindle speed lever and turn the speed up and then down by turning the lever slowly.

The machine should speed up and slowly down as you turn the lever.

HEADSTOCK ADJUSTMENT

The headstock on the CX803 features a cam-action lever clamping system allows securing it to the bed. The headstock can be positioned and secured anywhere along the bed and pivoted up to 180°.

TO POSITION THE HEADSTOCK ALONG THE BED:

Disconnect the cord from the power source.

Loosen the headstock lock lever. See figure-6.

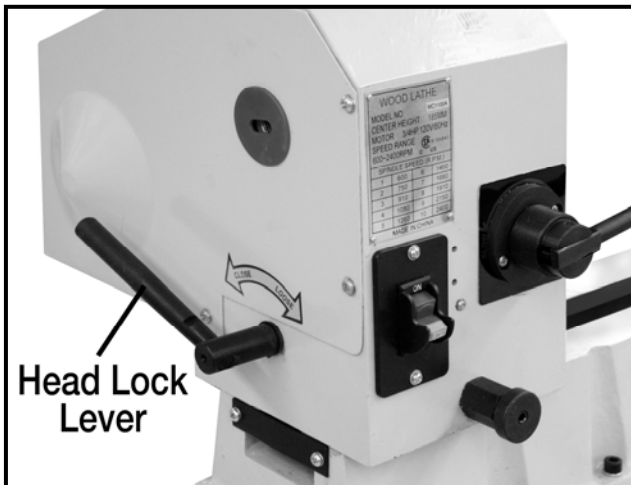


Figure-6 Loosening the head lock lever

Slide the headstock on the bed to the desired position and re-tighten.

TO PIVOT THE HEADSTOCK:

Make sure the cord is disconnected from the power source.

Make sure the headstock lever shown in figure-6, is tight. Pull the pivot locking pin out and pivot the headstock clockwise 90° or 180°. See figure-7.

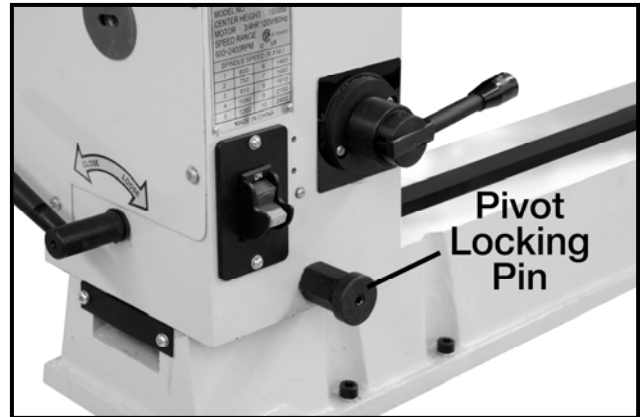


Figure-7 Locking pin

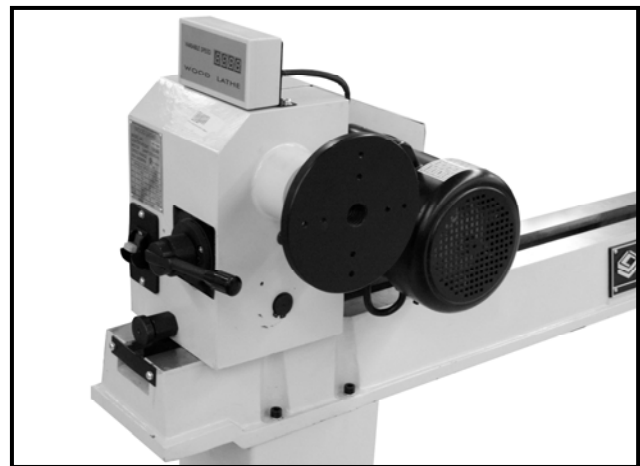


Figure-8 Head set at 90°

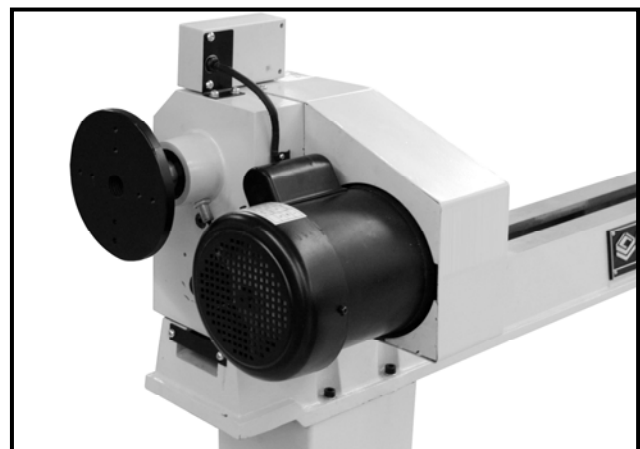


Figure-9 Head set at 180°

When the headstock is at the desired angle, release the pivot locking pin and make sure it is engaged in its detent.

TAILSTOCK ADJUSTMENT

You can position the tailstock along the lathe bed in the same manner as the headstock.

TO POSITION THE TAILSTOCK:

Make sure the cord is disconnected the cord from the power source.

Loosen the lock lever securing the tailstock onto the lathe bed. Slide the tailstock to the desired position and retightening the lock lever. See figure-10.

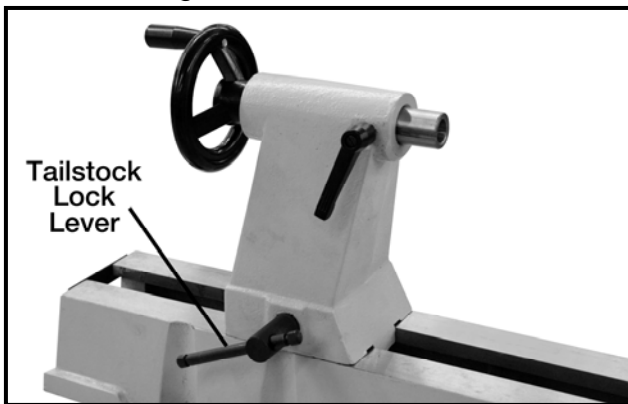


Figure-10 Tailstock lock lever

TOOL REST ADJUSTMENT

The tool rest is equipped with a cam-action clamping system allows securing it to the lathe bed. The CX803 features a 3-way adjustable tool rest with three lock levers. Se figure-11.

The base lock lever is used to secure the tool rest base along the lathe bed.

the pivot arm lock lever is used to secure the pivot arm at a desired distance from the work-piece.

The tool rest lock lever is used to secure the tool rest at a desired height and angle with the work-piece.

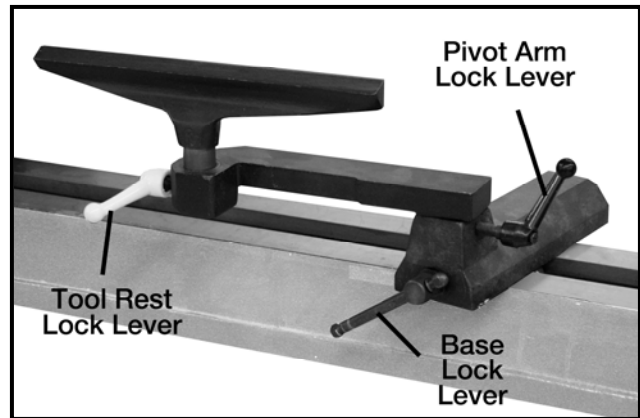


Figure-11 Tool rest lock levers

INSTALLING/REMOVING HEADSTOCK CENTER

The CX803 comes with an MT#2 headstock center and it is installed in the spindle.

TO INSTALL THE SPUR CENTER:

Disconnect the cord from the power source.

Clean the center and the inside of the spindle to make sure there is no dust or debris on the mating surfaces of both.

Slide the center with its tapered end into the spindle and push it with a firm motion. Make sure the center is properly installed.

TO REMOVE THE CENTER:

Disconnect the cord from the power source.

Put on gloves or use a rag and hold one of your hands under the center so that it does not fall on the lathe bed when it is knocked out.

Insert the knockout rod through the opposite end of the headstock and tap the center to remove it.

INSTALLING / REMOVING TAILSTOCK CENTER

The CX803 comes with an MT#2 live center which is installed into the tailstock quill and rotates with the work-piece.

TO INSTALL THE LIVE CENTER:

Loosen the quill lock lever and rotate the quill hand wheel until the quill extends out from the tailstock about 1".

Clean the live center and the inside of the quill and make sure there is not dust or debris or oil substances.

Insert the tapered end of the live center into the quill with a firm motion and make sure it is properly installed.

Tighten the quill lock lever to secure the live center into the quill. See figure-12.

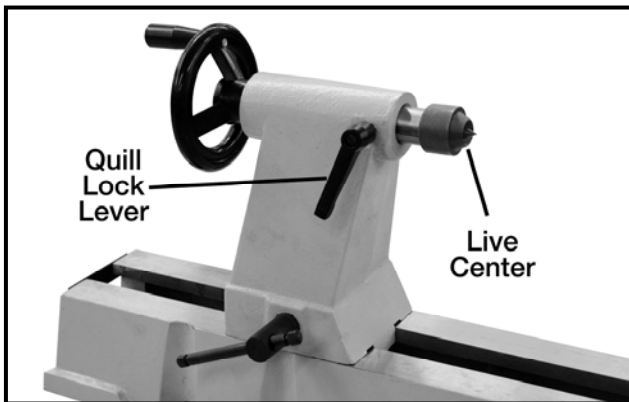


Figure-12 Installing the live center

TO REMOVE THE LIVE CENTER:

Loosen the quill lock lever.

Put on gloves or use a rag and hold one of your hands under the center so that it does not fall on the lathe bed when it is knocked out.

Rotate the tailstock hand wheel counter-clockwise with the other hand. This will cause the quill to retract into the tailstock and the center will come out of the quill.

INSTALLING / REMOVING FACEPLATE

The 6" faceplate is installed on the headstock spindle and it is used when removing material from the face of the work-piece.

TO INSTALL THE FACEPLATE:

Make sure the switch is in the OFF position the cord is disconnected from the power outlet.

Use the two wrenches that come with the machine and tighten the faceplate to the spindle. See figure-13.



Figure-13 Installing the faceplate

To remove the faceplate, hold the faceplate with one wrench and turn the nut on the spindle with the second wrench.

WORKPIECE INSPECTION

Before cutting any wood, make sure to inspect the work-piece for nails, staples, small pieces of stone or metal and any other foreign object which is dangerous to come on contact with the blade.

If the wood contains any of these objects and it comes in contact with the cutting tool, the object might fly and hit the operator or seriously damage the blade. For safety, always inspect your work-piece carefully before cutting and wear eye protection.

Some woods with excessive twisting or warping are un-stable while cutting and are dangerous to cut because during operation the work-piece can move un-expectedly which can either damage the blade or hurt the operator.

SPINDLE TURNING

The turning operation in which the work-piece is mounted between the headstock and the tailstock is called spindle turning.

TO PERFORM SPINDLE TURNING OPERATION:

Select a work-piece and draw diagonal lines from corner to corner across the end of the work-piece to find the center point.

Take a spur and a mallet and tap center marks on both ends of the work-piece.

Drill about 1/4" holes on the center marks on both ends of the work-piece using a 1/4" drill bit.

You can cut the corners of the work-piece lengthwise to make turning easier.

Make sure the spur center is aligned with the mark made on the work-piece and push it about 1/4" into the work-piece end.

Insert the spur into the headstock spindle with the work-piece attached to it and make sure it is secured.

Install the live center into the tailstock quill and tighten the quill lock lever to secure the quill in position.

Now, loosen the tailstock lock lever and slide the tailstock on the lathe bed towards the work-piece until the live center comes in contact with the work-piece. Make sure the live center is aligned with the marked center on the end of the work-piece.

Now, loosen the quill lock lever and rotate the tailstock hand wheel pushing the live center into the work-piece about 1/4" and re-tighten the quill lock lever.

Position the tool rest approximately 1/8" above the work-piece center and 1/4" away from the work-piece.

Before starting the lathe turn the spindle by hand, and make sure the work-piece is not touching the tool rest.

FACEPLATE TURNING

Faceplate turning is the turning operation in which the work-piece is attached to the faceplate and then the faceplate is installed on the headstock spindle (with the work-piece) for turning.

TO PERFORM FACE PLATE TURNING:

Find the center point by drawing diagonal lines from corner to corner on one end of the work-piece.

Cut off the corners of the work-piece to make turning easier and safe.

Position the faceplate on the work-piece and make sure it is centered. Attach the work-piece to the faceplate using wood screws that do not have tapered heads.

Once the work-piece is securely attached to the faceplate, thread the faceplate onto the headstock spindle and tighten the four screws to secure the faceplate.

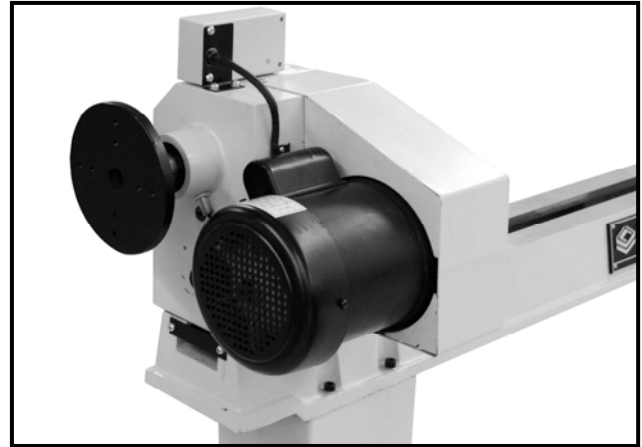


Figure-15 Headstock at 180°

OUTBOARD TURNING

Outboard turning is another variation of faceplate turning and is usually done when the stock diameter exceeds 14" on CX803. The recommended diameter for outboard turning on CX803 is 17" with its minimum turning speed.

When the lathe head is set up at 90° for outboard turning, you can use the tool rest that comes with the lathe. See figure-14.



Figure-14 Headstock at 90°

The headstock can also be set up at 180° but when turning in this manner, you must use a free standing tool rest (not supplied).

MAINTENANCE

During the life of your machine, you will need to practice some regular maintenance to keep your lathe in peak performance condition.

1. Check the lathe daily for:
 - A. Loose mounting bolts
 - B. Worn or damaged wires
 - C. Worn switch
 - D. Any other unsafe condition

2. Protect the unpainted cast iron surfaces of the lathe by clean the chips after every use and wiping with dry piece of cloth.

3. Apply a thin layer of oil on the bed slide ways and the unpainted cast iron surface to keep the bed rust-free.

4. A build up of dust in the motor can cause motor damage. Periodic cleaning of the motor is not only recommended, but mandatory for normal wood lathe performance.

WARNING!

Make sure the switch is in the OFF position and the cord is disconnected from the power source before installing, servicing and removing/replacing any components on the machine. Failure to do so may result serious personal injuries.

BELT REPLACEMENT

The CX803 feature pulleys that allow the lathe to operate at variable speeds and also keep the belt properly tensioned.

TO CHANGE THE BELT:

Make sure the switch is in the OFF position and the cord is disconnected from the power source.

Remove the screw securing the belt cover and open the cover as shown in figure-16.

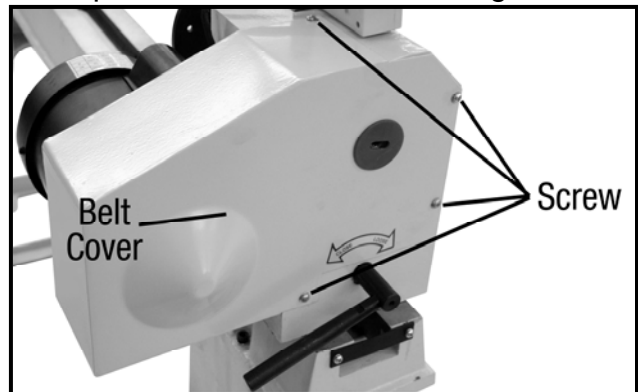


Figure-16 Belt cover

The motor pulley features two plates. Pull the pulley plates apart and this will release tension on the belt. Once the tension is released on the belt, roll it off the pulleys. See figure-17.



Figure-17 Removing the belt from the pulleys

TO INSTALL THE NEW BELT:

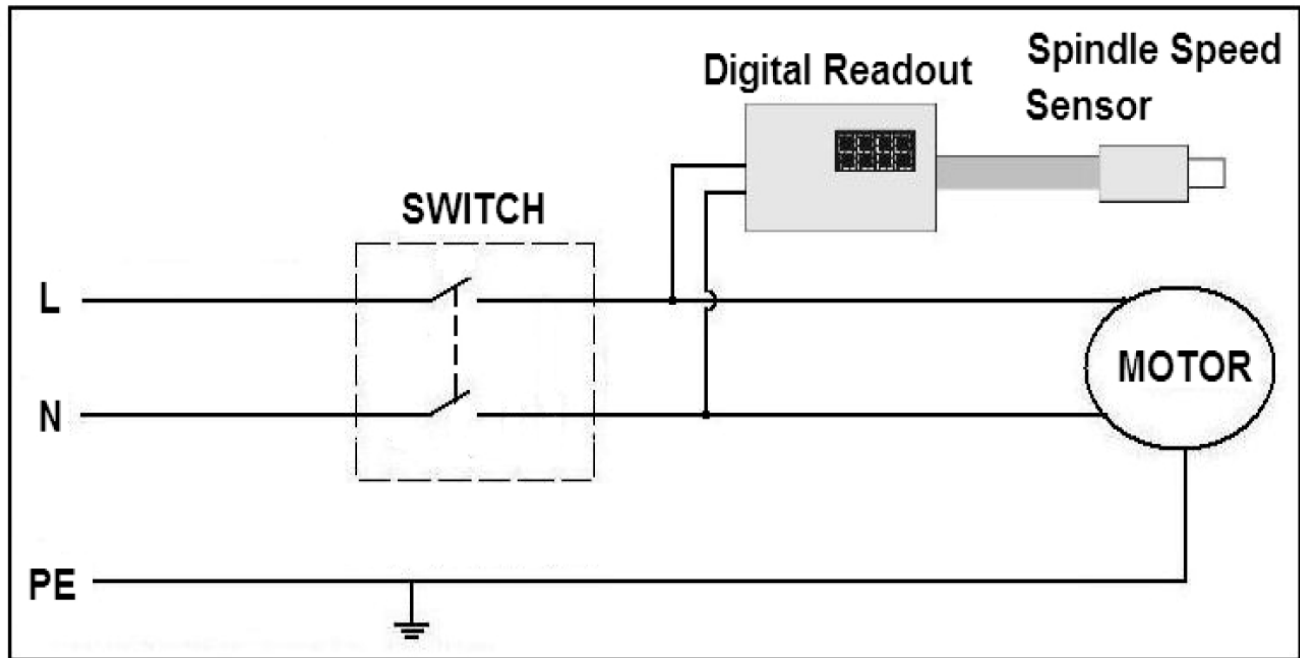
Roll the belt onto the spindle pulley first. Pull the motor pulley plates apart with one hand and then roll the belt into the groove between the pulley plates with the second hand.

Reinstall the belt cover and secure it with the screws removed.

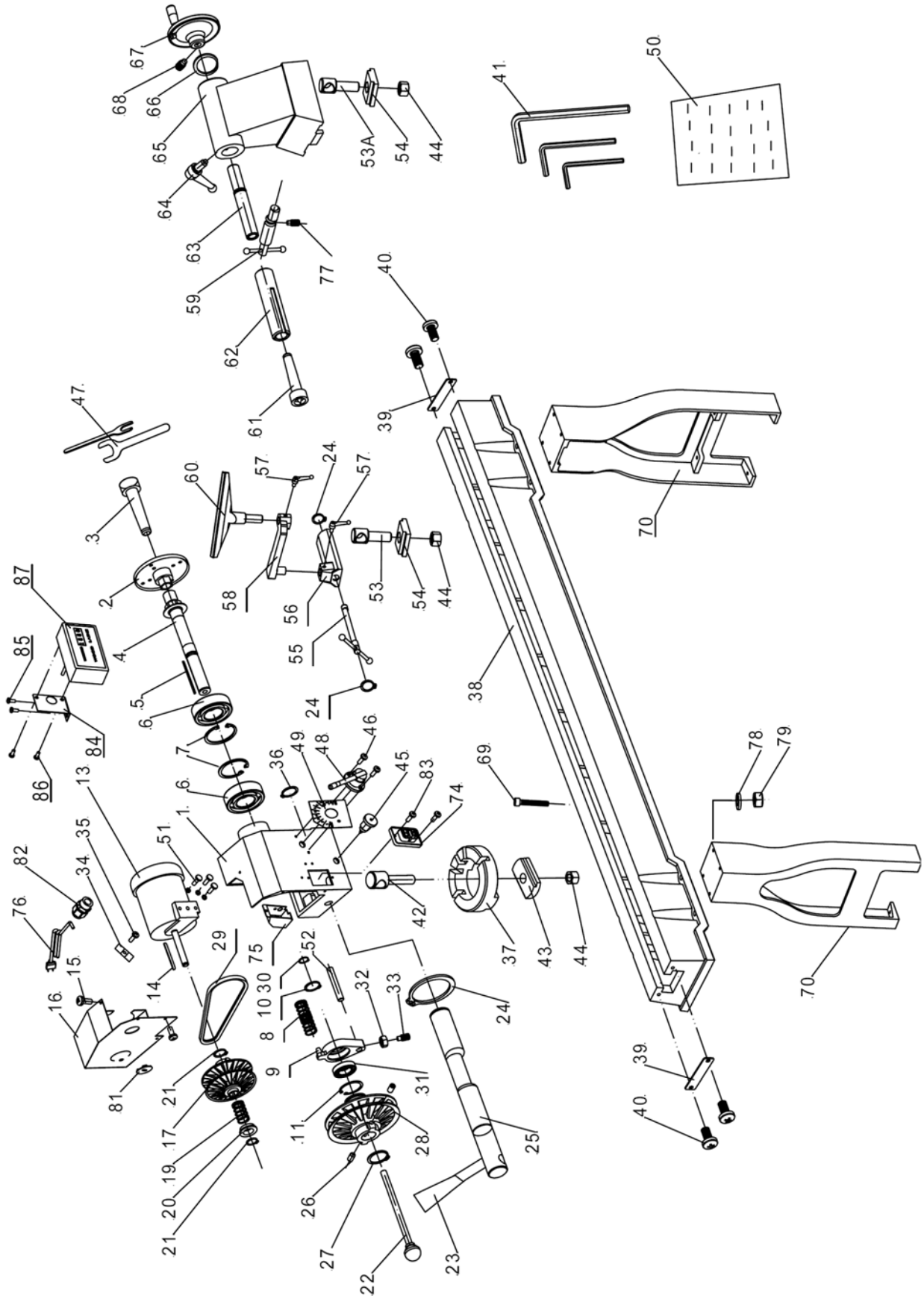
WARNING!

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CX803 WIRING DIAGRAM



CX803 PARTS DIAGRAM



CX803 PARTS LIST

Index	IM	Description
1	16601	HEADSTOCK
2	16602	FACE PLATE 6" @1"-8TPI
3	16603	SPUR CENTER MT2
4	16604	SPINDLE
5	16605	KEY 4 X 4 X 80 DRE
6	16606	BEARING 6205
7	16607	C-RING 52
8	16608	SPRING
9	16609	BRACKET - SHIFTING LEVER
10	16610	C-RING 35
11	16611	C-RING 62
13	166MOT	MOTOR 3/4 HP 120V 60Hz 550w
14	16614	KEY - 4 X 4 X 80 DRE
15	16615	SCREW - RND HD M5-0.8 X 8
16	16616	COVER - MOTOR
17	16617	PULLEY - MOTOR (RIGHT & LEFT)
19	16619	SPRING
20	16620	SLEEVE
21	16621	C-RING 16
22	16622	ROD - PUSH OUT
23	16623	LOCK HANDLE
24	16624	C-RING 19
25	16625	ECCENTRIC ROD
26	16626	SCREW - SET M6-1.0 X 10
27	16627	C-RING 24
28	16628	PULLEY - SPINDLE (LEFT & RIGHT)
29	16629	V-BELT 625
30	16630	C-RING 25
31	16631	BEARING 6007
32	16632	NUT - HEX M8-1.25
33	16633	SET SCREW M8X25
34	16634	CLAMP
35	16635	SCREW - RND HD M4-0.7 X 22
36	16636	C-RING 22
37	16637	TURNING BASE
38	16638	BED
39	16639	BAFFLE
40	16640	SCREW - RND HD M5-0.8 X 10
41	16641	HEX WRENCH
42	16642	SPECIAL BOLT - A M18
43	16643	CLAMP - A

Index	IM	Description
44	16644	NUT - HEX M18
45	16645	ANGULAR SETTING ASSEMBLY
46	16646	SCREW - M5-0.8 X 12
47	16647	WASHER - SPRING M32
48	16648	GEAR ASSEMBLY
49	16649	LABEL - SPEED
50	16650	INSTRUCTION MANUAL
51	16651	BOLT - HEX HD M8-1.25 X 25
52	16652	RACK
53	16653	SPECIAL BOLT - B M18
53A	16653	SPECIAL BOLT - C M18
54	16654	CLAMP - B
55	16655	ECCENTRIC ROD
56	16656	TOOL REST BODY
57	16657	LOCK LEVER
58	16658	EXTENSION TOOL REST
59	16659	LOCK HANDLE - TAILSTOCK
60	16660	TOOL REST
61	16661	TAILSTOCK SPUR
62	16662	TAIL SPINDLE
63	16663	TAIL STOCK SCREW
64	16664	HANDLE ASSEMBLY
65	16665	TAILSTOCK
66	16666	WASHER 24 X 2 X 15.2
67	16667	HANDLE WHEEL
68	16668	SCREW - M8-1.25 X 12
69	16669	SCREW - M8-1.25 X 30
70	16670	STAND UPPER COVER
74	16674	LOCK SWITCH WITH SWITCH PLATE
75	16675	SWITCH BOX
76	16676	POWER CORD SJT 18AWG 3C
77	16677	BOLT- CARRIAGE M6-1.0 X 12
78	16678	WASHER M8
79	16679	NUT - HEX M8-1.25
81	16681	COVER
82	16682	PLASTIC JAM NUT M20-1.5
83	16683	ROUND HEAD SCREW - M4-0.7 X 8
84	16684	BRACKET - DIGITAL READOUT
85	16685	ROUND HEAD SCREW - M5-0.8 X 10
86	16686	ROUND HEAD SCREW - M6-1.0 X 8
87	16687	DIGITAL READOUT 120V



WARRANTY

CRAFTEX 3 YEARS LIMITED WARRANTY

Craftex warrants every product to be free from defects in materials and agrees to correct such defects where applicable. This warranty covers **three years** for parts and 90 days for labor (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 Craftex 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.

Craftex 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.

RETURNS, REPAIRS AND REPLACEMENTS

To return, repair, or replace a Craftex 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 (2879), 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 in writing.
- 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 a letter explaining 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.