



# Colchester

## MASTER VS 3250 Variable Speed Centre Lathe

INSTRUCTION AND SPARE PARTS MANUAL  
BETRIEBSANLEITUNG & ERSATZTEIL — LISTE  
MANUEL D'ENTRETIEN ET DE RECHANGE

# Colchester

**The Colchester Lathe Company Ltd**

ELMSTEAD ROAD, COLCHESTER, ESSEX CO4 3SE, ENGLAND.  
Tel: 0206 865161 Telex: 98255 (LATHES G) Fax: 0206 865026

# INDEX

---

---

## Operating Safety

---

<b>Machine Specification</b>	<b>1</b>
------------------------------	----------

---

## Installation

---

Machine Weight	2
Preparation and Safety Checks	2
Lifting	2
Cleaning	4
Installation	4
Electric Supply Connections	5
Lubrication Checks	5
Foundation Plan	6
Chuck Mounting	7

---

## Operation

---

Lathe Safety	9
Control Layout	10
Speed Selection	11
Spindle Speed Calculations	11
Spindle Rotation	12
Thread and Feed Selection	13
Thread Dial Indicators	14
Apron and Slide Controls	15
Cross Slide and Top Slide	15
Tailstock	16
Coolant	16
Gap Piece Removal	17

---

## Service and Maintenance

---

Lathe Alignment	18
End Gear Train	19
Driving Belt	19
Leadscrew Torque Limiting Device	19
Change Gear Shear Pin	20
Slideways	20
Cross-Slide Nut	20
Spindle Brake	20
Spindle Bearing Adjustment	20a
Lubrication	21
Headstock, Gearbox, and Apron Lubrication	21
Lubrication Chart	22
Electrical	23

---

## Spare Parts Section

---