



Manual Sept 2025

# Stute Wood Lathes



## The Stutey 3040

Motor	3 HP
Weight	300 kg/660 lbs
Workshop Footprint	1130 x 440mm
Indexing holes	24 holes 15 degree
Speed Range - Low	0 - 1554
- High	115 - 3223
Swing over bed - Standard	16 " / 400 mm
- Extended	30 " / 750 mm
Between Centres - Standard	15 " / 375 mm
- Extended	40 " / 1000mm
Spindle Thread - options of	1 1/4 x 8 M30 x 3.5 M33 x 3.5

## Get in Touch

44 Victoria Pde Kilmore, 3764 Victoria. Australia  
Phone : +61 0417 031 568  
Email: [info@stutewoodlathes.com.au](mailto:info@stutewoodlathes.com.au)



## Features

- ✓ The Stutey 3040 uses durable cast iron components and high grade steel.
- ✓ Inbuilt Vacuum Port and 24 hole indexing wheel
- ✓ The bed on the Stutey lathe can extend or rotate to provide more positions to work
- ✓ A replacement belt is positioned in the headstock to provide an easy and simple change over
- ✓ A reversible banjo allows it to be used either on the main bed or the Auxiliary bed.
- ✓ With 3 strong magnets on the back. The controller can be moved to suit any job.
- ✓ 2MT morse taper for the head and tail stock
- ✓ A ruler is attached to the top of the tail stock for easy calibration
- ✓ Digital readout for spindle RPM

[www.stutewoodlathes.com.au](http://www.stutewoodlathes.com.au)

## Contents

<b>Safety Instructions:</b> .....	<b>3</b>
<b>Unpacking</b> .....	<b>4</b>
<b>Motor Wiring Instructions</b> .....	<b>5</b>
<b>Cleaning</b> .....	<b>5</b>
<b>Variable Frequency Drive:</b> .....	<b>6</b>
<b>Motor</b> .....	<b>6</b>
<b>Parameter Settings for Variable Frequency Drive (VFD)</b> .....	<b>7</b>
<i>Input Frequency</i> .....	<i>7</i>
<b>Why we made changes to these parameters</b> .....	<b>8</b>
<b>Spindle Torque vs Spindle Speed</b> .....	<b>10</b>
<b>Motor Power and Torque Curves</b> .....	<b>11</b>
<b>Pendant Controller</b> .....	<b>12</b>
<i>Speed Control (RPM Adjustment)</i> .....	<i>12</i>
<i>Red Button</i> .....	<i>13</i>
<i>Forward/Reverse Switch</i> .....	<i>13</i>
<b>Indexing Feature</b> .....	<b>14</b>
<b>Vacuum Port</b> .....	<b>14</b>
<b>Swing and Bed Adjustment</b> .....	<b>15</b>
<i>Replacement Belt</i> .....	<i>16</i>
<i>Banjo</i> .....	<i>16</i>
<i>Reversible Banjo</i> .....	<i>16</i>
<i>Auxiliary Bed</i> .....	<i>17</i>
<b>Wiring Diagram</b> .....	<b>18</b>
<b>Parts List</b> .....	<b>23</b>
<b>Get in touch:</b> .....	<b>23</b>
<b>Your lathe information</b> .....	<b>24</b>

## Safety Instructions:

Read and understand the entire manual before assembly or operation.

This wood lathe is designed for use only by properly trained and experienced personnel. If you are not familiar with safe lathe operation, do not use it until proper training and knowledge are obtained.

Always wear approved safety glasses or a face shield while using this machine.

Make all machine adjustments or maintenance with the lathe unplugged from the power source.

Read and understand all warnings on the lathe and in this manual. Failure to comply with these may cause serious injury.

Always start the lathe at the lowest speed setting.

The dust generated by some woods and wood products can cause health problems. Operate equipment in well-ventilated areas and provide proper dust removal. Use a dust collection system whenever possible and wear a dust mask or other personal protection. Do not leave the lathe unattended unless it is turned off and has come to a complete stop.



# Unpacking

## Lathe Setup Instructions

### Tools Required

- Adjustable spanner or socket wrench
- Allen keys (metric set)
- Screwdriver (flat and Phillips)
- Soft cloth or rag

---

### Safety Notes

- ⚠ Always use **two people** when lifting or moving the lathe body — it is heavy and awkward to handle.
- ⚠ Wear **safety gloves** when unpacking to avoid cuts from sharp edges or packing staples.
- ⚠ Keep hands clear of pinch points when attaching the motor and tightening pulleys.
- ⚠ Do not connect the machine to power until assembly is complete and all fasteners are tightened.
- ⚠ Ensure the lathe is placed on a **sturdy, level workbench** capable of supporting its weight.

---

### Assembly Steps

#### 1. Unpacking

- Remove the shipping crate carefully.
- Do **not** discard any shipping material until the lathe is fully set up and running properly.
- If the Lathe stand is provided, remove from the crate and follow the instructions to setup the lathe stand.
- Remove the **tailstock, Banjo, and accessory package** from the crate.

#### 2. Positioning the Lathe

- With assistance, lift the **lathe body and bed** onto the prepared workbench.
- Inspect the lathe thoroughly for any signs of damage before proceeding.

#### 3. Attaching the VFD Unit

- Locate the **VFD machine** and the **protective metal casing** along with the RPM digital display and hand held controller.
- Attach casing to the **back of the headstock** using the supplied bolt (already partially installed in the lathe).
- Tighten securely with a spanner.

#### 4. Installing the Motor

- Remove the **bolt and hand lever** already in place on the headstock.
- Position the **motor** in place on the headstock.
- Reinstall the **bolt and hand lever** to secure the motor.
- Attach the **belt** to the motor pulley.
- Tighten the motor into position using the **hand lever**.

#### 5. Pulley Alignment

- Check that the **motor pulley** and the **main pulley** are correctly aligned.
- Adjust as necessary before tightening fully.

# Motor Wiring Instructions

## Safety Notes

Ensure the lathe is **unplugged from all power sources** before wiring.  
Only qualified or competent persons should perform electrical connections.  
Check all connections twice before closing the motor plate.

## Tools Required

Insulated screwdriver

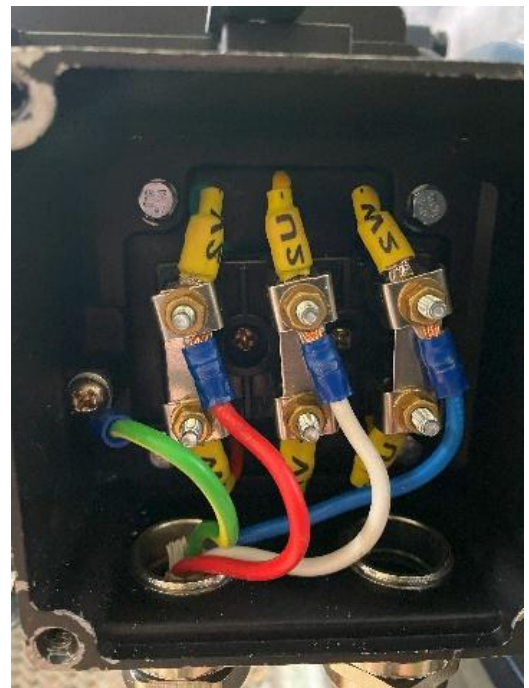
## Wiring Steps

- Remove the front plate on the motor using an adjustable spanner or socket wrench
- Keep nuts and washers safe.
- Insert the power cable through the motor wiring port (cable gland).
- Connect the wires to the correct terminals:

- **Blue wire - W2**
- **White wire - U2**
- **Red wire - V2**
- **Green wire - Earth (Ground)**

- Tighten all screws securely.
- Ensure no bare copper wire is exposed.
- Reattach the front plate and tighten nuts evenly.

The motor is now ready.



## Cleaning

We have applied U-Beaut Neutral Traditional Wax coating on all exposed metal areas to ensure the lathe reaches you in optimum condition. Use mineral turpentine/white spirits or hot soapy water or similar product to remove the protective coating.  
To keep the machine in top condition, spray all exposed metal areas with light viscosity oil. This minimises corrosion. To ensure maximum longevity for your machine, remove all sawdust then re-oil the surfaces after every use



## Variable Frequency Drive:

Your lathe is equipped with an industrial-grade Variable Frequency Drive (VFD), also known as an “inverter.” This drive converts standard household current into industrial three-phase power. When you adjust the spindle speed dial on the pendant controller, the VFD alters the frequency supplied to the motor, effectively changing the motor speed. Additionally, the VFD calculates the spindle RPM and displays it on its screen.

The VFD comes preconfigured with factory settings designed to suit most turners. Its manual, included with the lathe, provides instructions for modifying the settings. However, changing certain parameters could impair your lathe’s functionality or prevent it from operating entirely. While some settings, like ramp-up and ramp-down speeds, can be adjusted to suit your preferences, it is strongly recommended that you avoid making any changes until you are thoroughly familiar with your lathe. If you encounter issues or are dissatisfied with your adjustments, please contact us for the default parameters. The VFD is mounted in a dust proof metal box attached to the back of the lathe.

## Motor

Hi Ratio  $79/90 = 0.7777$

Lo Ratio  $45/120 = 0.3750$

Motor speed 5 to 140 Hz

Motor speed at 50 Hz = 1480 rpm

Hi Ratio 115 rpm to 3223 rpm

Lo Ratio 55 rpm to 1555 rpm

Motor 3Phase 4 Pole

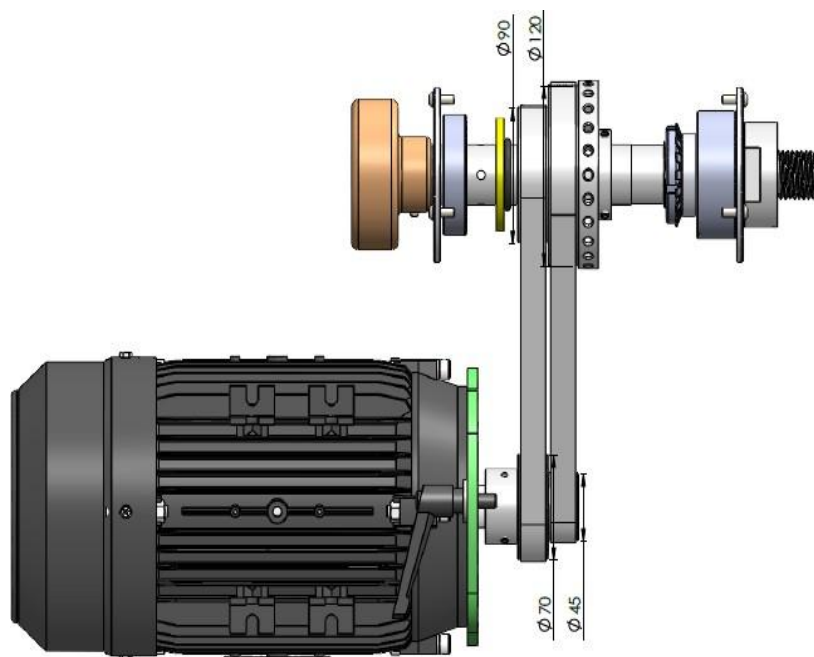
Shaft 28mm

### Belt

Micro - V

J Section, 8 Ribs

711mm long 280J PJ71



## Parameter Settings for Variable Frequency Drive (VFD)

Parameter	Parameter Specification	Parameter Range	Default	Unit	Amended Value
P00	Maximum Voltage	0-220.0/380.0	220/380	V	<b>220</b>
P01	Reference Frequency	0-400.0	50	Hz	<b>AU 50 USA 60</b>
P02	Intermediate Voltage	0-220.0/380.0	110/190	V	<b>110</b>
P03	Intermediate Frequency	0-400.0	25	Hz	<b>40</b>
P06	Maximum Operating	0-400.0	65	Hz	<b>140</b>
P07	Minimum Operating	0-400.0	0	Hz	<b>5</b>
P13	Braking Time	0-2.5	0.5	Seconds	<b>1.0</b>
P18	Operating Arrival	0-100.0	50	Hz	<b>AU 50 USA 60</b>
P21	Revolution for 50 Hz	0-8000	2800	rpm	<b>1480</b>
P22	Carrier Setting	1-20	10		<b>15</b>
P34	Main Rising Velocity	0-1000	25	HZ/Second	<b>10</b>
P42	Main Descent Velocity	0-1000	25	HZ/Second	<b>30</b>
P53	Multi Function Input 4	5 Wire Forward Operation	5		<b>6</b>
P54	Multi Function Input 5	6:Wire Reverse Operation	6		<b>5</b>
P62	Display Options	0: Setting Frequency 1: Operating Frequency 2: Revolution 3: Current 4: Temperature 5: Time	0		<b>1</b>
P68	Under Voltage Setting	0-220/380	60/180	V	<b>60</b>
P69	Overvoltage Setting	220.0 - 400/680	400/600	V	<b>400</b>
P72	Torque Compensation Setting	0-100	0		<b>80</b>
P78	Main Current Overload	0-65535	12000	mA	<b>7800</b>
P124	Fan Start Temperature	0: Fan Running when VFD Starts 30: Fan starts at nominated Temp	0	Deg Cel	<b>30</b>
P127	Remaining Hours	0-65535	65535	H	<b>65550</b>

### Input Frequency

The input frequency to the drive will be either 50 Hz or 60 Hz depending on the country. The VFD drive has two settings for this (P01 and P18) consistent performance.

## Why we made changes to these parameters

- P00 Maximum Voltage:** This is the nominal maximum input voltage to the VFD and a value of 240 Volts seems to work fine.
- P01 Reference Frequency:** This is the input frequency which is 50 HZ for Australia and 60HZ for USA.
- P02 Intermediate voltage:** This value works best when it is half of the value used in P00
- P03 Intermediate Frequency:** We have found that a value of 40 Hz seems to work fine for this application.
- P06 Maximum Operating:** This value is the maximum output frequency from the VFD when the speed control potentiometer is at a maximum. For this application a value of 130 Hz has been chosen as a safe maximum value
- P07 Minimum Operating:** This value is the minimum output frequency from the VFD when the speed control potentiometer is at a minimum. For this application a value of 6 Hz has been chosen as a safe minimum value.  
At low speeds the motor cooling may be compromised especially if run for long periods with a high induced torque
- P13 Braking Time:** This value has been set at 1 second which seems to be a good compromise in stopping quick but not so quick that it produced unnecessary shock loading.
- P18 Operating Arrival:** This is the input frequency which is 50 HZ for Australia and 60HZ for USA. This is important to set correctly
- P21 Revolution for 50 Hz:** This value is a characteristic of the motor and is 1480 rpm. Note that this is a characteristic of the motor and is not affected by the country supply frequency. Regardless on whether the supply frequency is 50 or 60 Hz this value is purely for the VFD drive to understand what the motor speed would be at 50 Hz as a reference.
- P22 Carrier Setting:** The carrier setting (or carrier frequency) is the rate at which the VFD's internal power transistors (IGBTs) switch on and off to create the variable AC voltage for the motor via pulse width modulation (PWM). Setting the carrier frequency involves finding the sweet spot between reducing audible noise and motor stress with higher frequencies, and increased heating and power derating with lower frequencies. A value of 15 kHz seems to be the sweet spot for this setup.
- P34 Main Rising Velocity:** This value is the ramp up speed whenever the Speed control potentiometer is increased or when the selector switch is set to forward or reverse. The optimum value seems to be 10 HZ per second.



- P53 Multi Function Input 4:** This value is set to 6 to determine the motor direction when reverse is selected
- P54 Multi Function Input 5:** This value is set to 5 to determine the motor direction when forward is selected
- P42 Main Descent Velocity:** This value is the ramp down speed whenever the Speed control potentiometer is decreased or when the selector switch is set to stop. The optimum value seems to be 30 HZ per second as it appears quick without inducing high inertia loads.
- P62 Display Options:** This value sets the display parameter on the VFD. It is nominally set to 1 to display the motor input frequency.
- P68 Under Voltage Setting:** Should be no reason to change
- P69 Over Voltage Setting:** Should be no reason to change
- P72 Torque Compensation Setting:** This value seems to have a sweet spot for this application with a setting of 80. At minimum speed the available torque can be increased by increasing this value  
Above 80 seems to have little effect and lower values can result in the motor stalling when subjected to torque loading
- P78 Main Current Overload:** This value is the maximum allowable current load for the motor (7800mA) and is used to limit the VFD drive output current to protect the motor
- P124 Fan Start Temperature:** This value is set to 30 degrees Celsius so that the VFD cooling fan only turns on when its temperature is over 30 degrees
- P127 Remaining Hours:** This is an inbuilt hour meter and records the hours the VFD drive has been powered up.

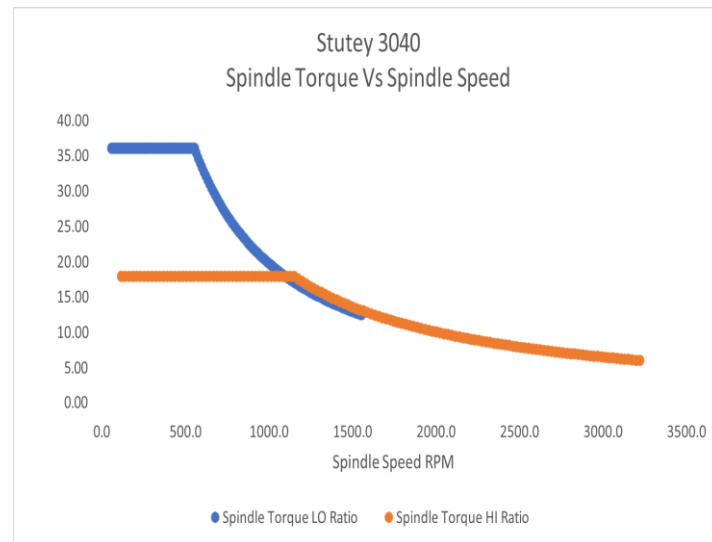
# Spindle Torque vs Spindle Speed

The spindle torque and speed characteristics of the Stutey 3040 lathe are important for selecting the optimal operating conditions for different turning tasks. The relationship between spindle speed (RPM) and torque affects cutting performance, surface finish, and tool life.

## Understanding the Chart:

**Spindle Speed (RPM):** Represented on the horizontal axis. Speeds range from 0 (stopped) to the lathe's maximum rated speed.

**Torque (Nm):** Represented on the vertical axis. Torque is highest at low spindle speeds and gradually decreases as speed increases.



## Key Points:

### High Torque at Low Speeds:

When turning large-diameter or dense hardwood pieces, use lower spindle speeds. Maximum torque ensures steady cutting and prevents stalling under heavy load.

### Reduced Torque at High Speeds:

Higher spindle speeds reduce torque but allow faster material removal for smaller, lighter workpieces.

Best suited for finishing cuts or fine detail work.

### Gradual Speed Changes:

Always start with the spindle at low speed when mounting new workpieces.

Gradually increase speed while monitoring cutting performance and lathe stability.

### Using the Variable Frequency Drive (VFD):

The VFD allows smooth adjustment of spindle speed.

Consult the torque vs speed chart to select speeds that maintain sufficient torque for your workpiece.

## Practical Example:

**Turning a 300 mm diameter hardwood bowl:** Start at a low RPM to maximize torque and maintain control, then gradually increase speed as material is removed.

**Turning a small spindle (20 mm diameter):** Higher RPM can be used without risk of stalling, achieving a smoother finish and faster material removal.

**⚠ Safety Note:** Exceeding the recommended spindle speed for large or unbalanced workpieces may cause vibration, tool chatter, or unsafe operation

# Motor Power and Torque Curves

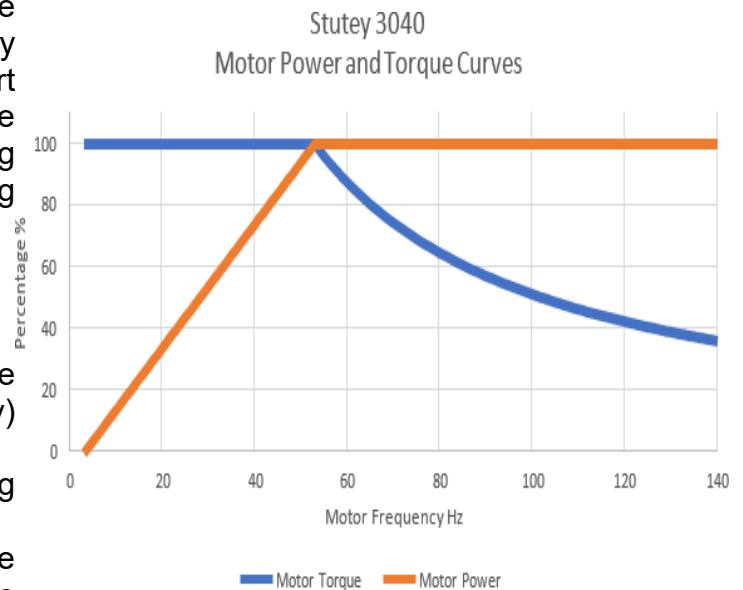
Understanding the motor performance curves is essential for safely and efficiently operating your Stutey 3040 lathe. The chart illustrates how motor power and torque vary with spindle speed, providing guidance on selecting the correct operating range for different turning tasks.

## Chart Components:

**Spindle Speed (RPM):** Displayed on the horizontal axis, ranging from 0 (stationary) to the maximum rated spindle speed.

**Torque (Nm):** Vertical axis, representing the twisting force available at the spindle.

**Motor Power (kW):** Often overlaid on the chart as a separate curve, showing the motor's available power at each speed.



## Key Observations:

**High Torque at Low Speeds:**

The motor produces maximum torque at low RPM, making it ideal for starting cuts on large or dense workpieces.

Low-speed, high-torque operation minimizes stalling under heavy loads.

**Power Peaks at Mid-Speed Range:**

Motor power typically increases with speed up to a peak point, often in the mid-RPM range.

This is the most efficient speed range for sustained cutting without overloading the motor.

**Reduced Torque at High Speeds:**

As spindle speed rises, torque gradually decreases while the motor continues delivering usable power for lighter cutting tasks.

High-speed, lower-torque operation is suitable for finishing cuts and smaller diameter workpieces.

## Practical Implications:

**Heavy Workpieces:** Operate in the low-speed, high-torque zone to maintain control and prevent stalling.

**Medium Workpieces:** Use mid-range speeds to take advantage of peak motor power for efficient material removal.

**Fine Detailing:** High-speed, lower-torque settings allow smooth, precise cuts without overloading the motor.

**⚠ Safety Note:** Exceeding the motor's rated speed or attempting heavy cuts at high RPM can cause excessive vibration, tool chatter, or motor overload.

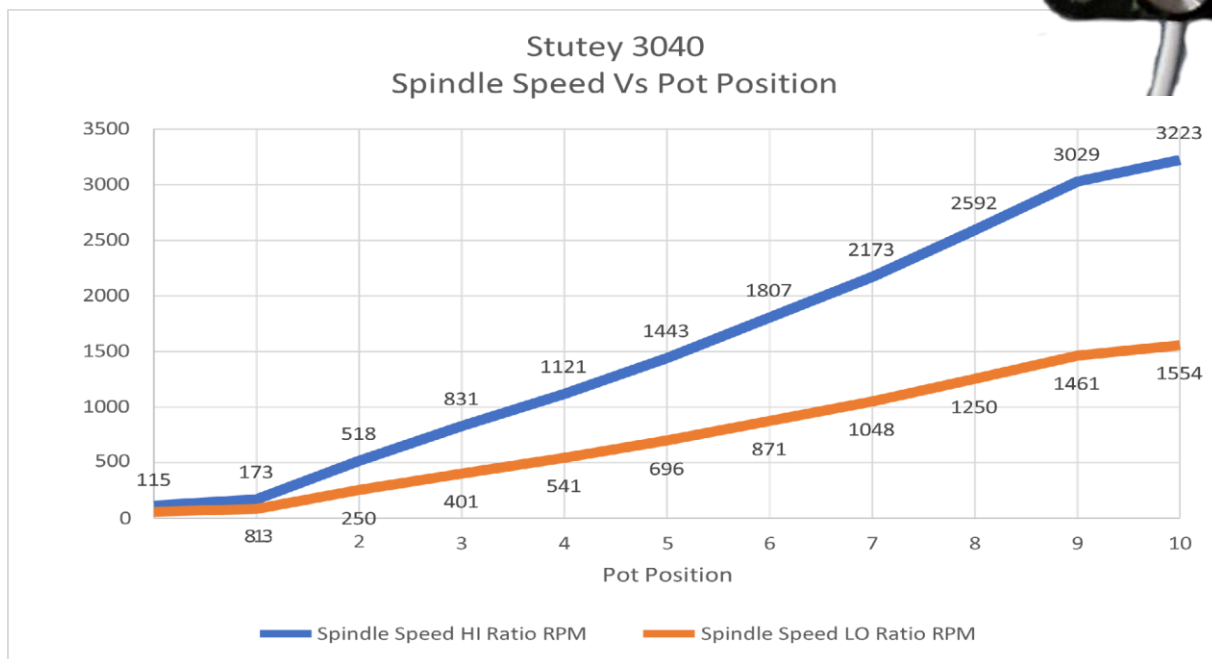
## Pendant Controller

The corded pendant controller is used to control major functions of your lathe. It has 3 rare earth magnets on the back so it can be moved and attached to sections of your lathe as needed.

### Speed Control (RPM Adjustment)

- The speed dial ranges from 0 (slowest) to 10 (fastest).
- Always begin with the speed set to 0 before starting the lathe or mounting a new workpiece.
- Gradually increase the speed to the desired level once the workpiece is securely in place and the lathe is running.

⚠ **Safety Tip:** Never start the lathe at high speed, as this may cause the workpiece to loosen or create unsafe operating conditions.



The exact values will vary slightly between units depending on the exact potentiometer resistance characteristic profile and the induced torque on the motor but will be close to the above graph



## Red Button

Stops the lathe. No further explanation required.

## Forward/Reverse Switch

The forward/reverse switch is initially positioned in the neutral position. Turning the switch sets the spindle to rotate in either the forward or reverse direction.

You can change the spindle direction while the lathe is running. When doing so, the lathe will automatically slow down, stop, and then begin rotating in the opposite direction.

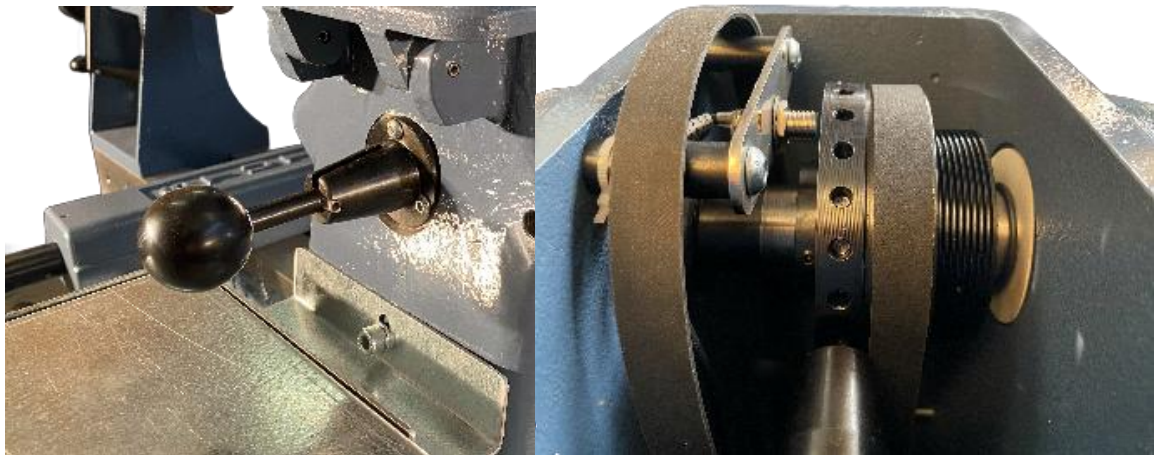
### ⚠ Important Safety:

When operating the lathe in reverse, ensure that your work holding device (such as a chuck or faceplate) is securely fastened to the spindle. Failure to do so may result in serious accidents or equipment damage.

## Indexing Feature

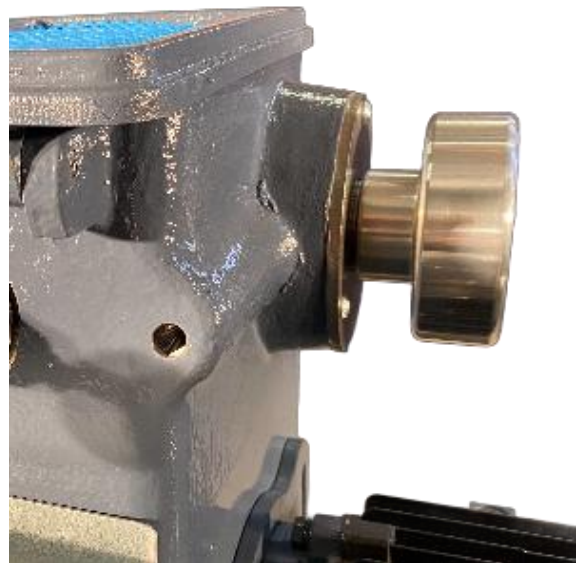
- The spindle indexing system includes **24 holes**, spaced at **15° intervals**.
- The **indexing pin**, located at the rear of the headstock, is **spring-loaded** and equipped with a **detent groove** to securely lock the pin in the disengaged position.
- To rotate or reposition the spindle:
  1. Pull the indexing pin out of the hole.
  2. Rotate the spindle to the desired position.
  3. Release the pin so it engages with the next hole.

⚠ Note: Ensure the pin is fully seated in the hole before beginning any machining operation.



## Vacuum Port

- The lathe includes an **inbuilt vacuum port**, located next to the indexing mechanism at the rear of the headstock.
- The port is fitted with a **¼ BSP inlet**, allowing direct connection of vacuum equipment without the need for rotary adapters.
- For proper operation, the **10 mm diameter hole** through the centre of the **handwheel locking bolt** must be securely sealed before use.

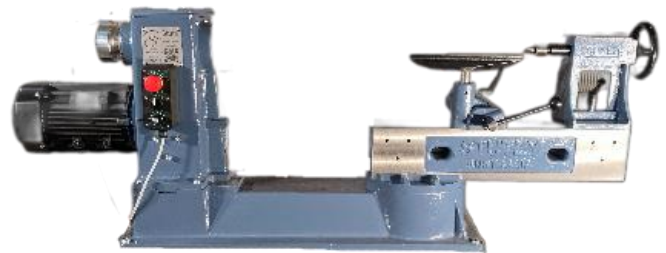


⚠ Important: Failure to seal the handwheel bolt hole will prevent the vacuum system from achieving adequate suction.



## Swing and Bed Adjustment

- In the **normal position**:
- Swing: **16" / 400 mm**
- Distance between centres: **15" / 375 mm**
- By unlocking the **adjustable lever** on the back side of the lathe, the bed can be extended:
- Maximum swing: **30" / 750 mm**
- Maximum distance between centres: **40" / 1000 mm**



Angular adjustment of the sliding bed is also possible:

1. Unlock the adjustable lever.
  2. Raise the steel locking pin.
  3. Rotate the bed up to **360°**.
- This feature allows improved access and control when turning larger workpieces.

⚠ Note: Ensure the bed and locking pin are fully secured before operating the lathe



- The tailstock is secured in position using an **adjustable splined lever**.
- To reposition, lift the lever's hub, rotate it to a convenient angle, and release the hub to lock it back into place.
- The tailstock quill is designed with a **10 mm diameter through-hole** and fitted with a **#2 Morse taper** for tooling and accessories.
- A **steel ruler** is mounted on the top of the tailstock, providing both **metric and imperial measurements** for accurate reference.

⚠ **Tip:** Always ensure the tailstock and quill are firmly locked before starting any machining operation.



## Replacement Belt

- A **spare drive belt** is stored inside the headstock, attached to a designated belt holder.
- This convenient storage location reduces the need to remove or reposition the drive spindle during belt replacement, making the process quicker and easier.

⚠ Note: Always disconnect power before accessing the headstock for belt replacement.



## Banjo

- The banjo accepts a **25.4 mm (1") diameter tool rest post**.
- It is fitted with a **cam lock** for quick and convenient positioning along the bed.
- Tool rest height is secured using a **splined adjustable kip lock** for firm and precise adjustment.



## Reversible Banjo

- The banjo can be reversed for greater flexibility.
  1. Unscrew the handle.
  2. Refit the handle on the **opposite end** of the banjo.

## Auxiliary Bed

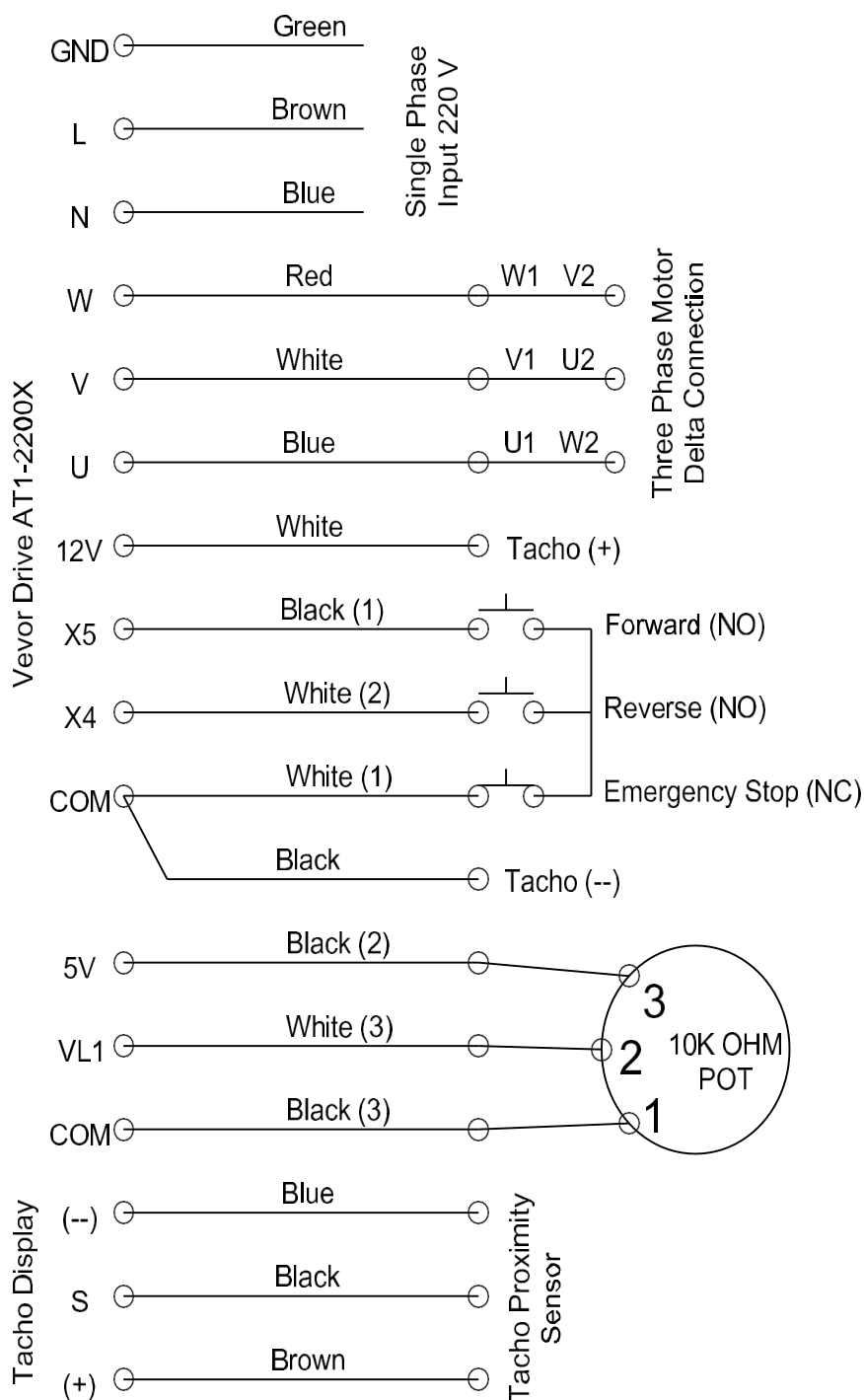
- The auxiliary bed increases the versatility of the **Stutey 3040 lathe** by providing additional mounting and turning options.
- It can be installed in two primary orientations:
  - **Right angle to the spindle axis** – for turning the back of larger diameter pieces.
  - **Parallel to the lathe's centre line** – bridging the gap when the main bed is extended, ideal for long spindle turning.
- The auxiliary bed features **three mounting faces** and can be attached to any of the **four mounting locations** on the main bed, allowing setup flexibility for a wide range of projects.



**⚠ Note:** Always ensure the auxiliary bed is firmly secured before beginning any operation.

## Wiring Diagram

### STUTEY 3040 Lathe Wiring Diagram Using Vevor AT1-2200X Drive



## Stutey Adjustable Lathe Stand Assembly Guide

### ***Compatible with the Stutey3040 Lathe***

#### **Introduction**

This guide provides comprehensive instructions for assembling the Stutey Adjustable Lathe Stand, designed specifically for the Stutey3040 lathe. The stand is made up of six precision-engineered components, fabricated from 3mm thick galvanized steel. Each piece features laser-cut slots and holes that enable flexible height adjustment and fine-tuning to accommodate different user preferences and workspace conditions.

The Stutey Adjustable Lathe Stand is engineered for strength, stability, and ergonomic operation. Proper assembly and adjustment are essential for safe and efficient use of your lathe.

Average male elbow height is 1073mm (42 ¼"), and average female elbow height is 1002mm (39 ½"). If you design for *average adult* at (41 ¾"), your design will be lower than ideal for more than half of all males and higher than ideal for more than half of all females.

When you spend time working on a *work height* recommendation, the natural solution is to promote adjustability. If the worker can be raised or lowered or better still, the work can be raised or lowered, than we can accommodate virtually everyone.

#### **Tools Required**

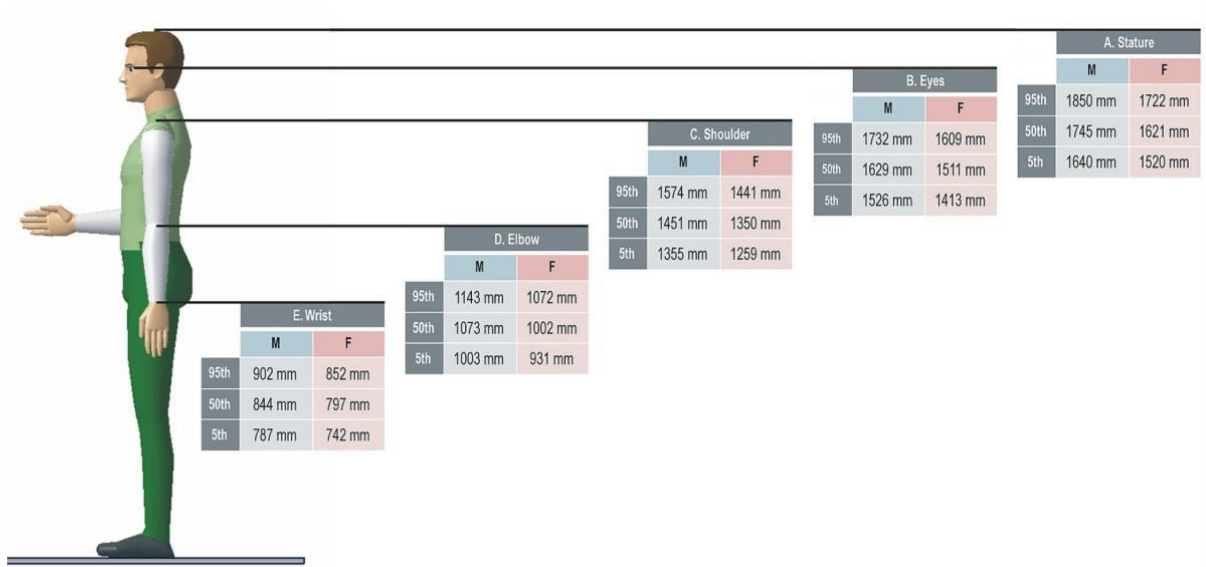
- Tape measure or ruler
- Spirit level
- Metric and imperial socket set or spanners (depending on bolt type)
- Permanent marker or scribe (for marking measurements)
- Safety gloves (recommended)
- Eye protection (recommended)



## Step 1: Determine Your Optimal Working Height

The first and most important step is to determine the height at which your lathe should be positioned for comfortable and safe operation.

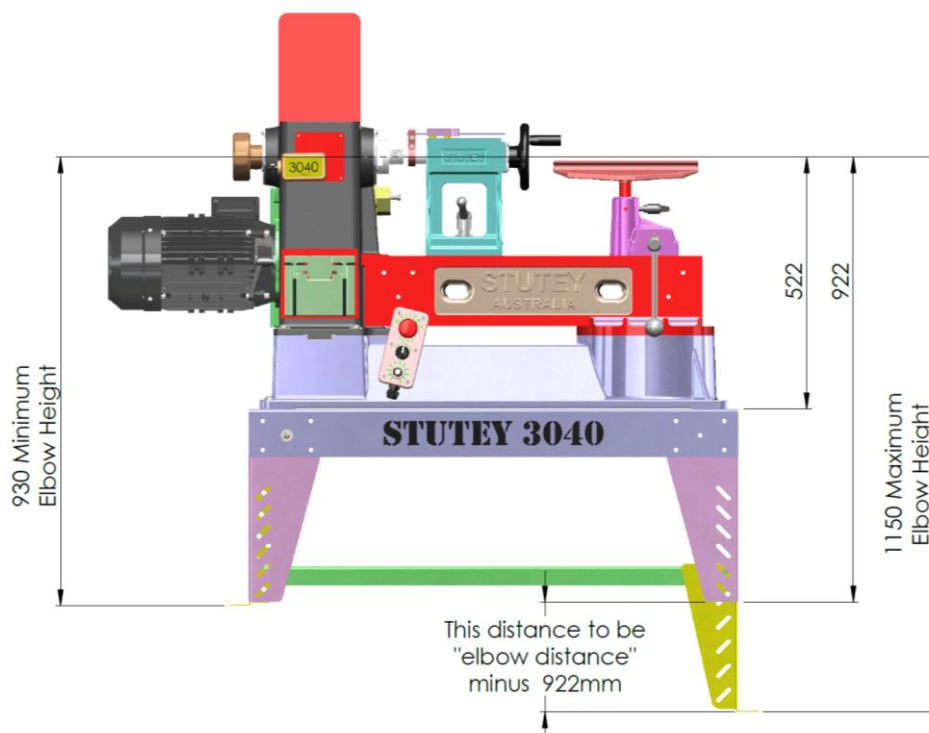
This height is based on the distance from the floor to the bottom of your elbow when you are standing upright with your arms relaxed at your sides.



This elbow Height varies from 931 to 1143 (212mm Variation)

### Why This Measurement Matters:

Working with your lathe at the correct height reduces fatigue and increases precision, allowing you to work safely and efficiently over extended periods.





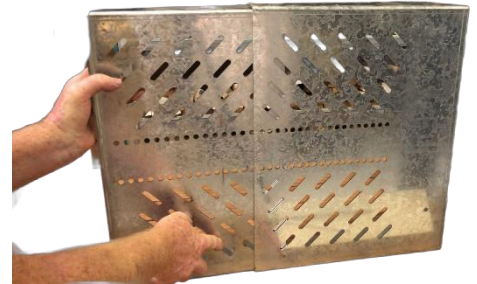
### Step 3: Assemble the Legs

#### 3.1 Measure and Mark the Lower Leg

- Measure from the **bottom of the lower leg section** the calculated measurement to achieve the required elbow height.
- Make a clear mark—this will align with the **bottom edge of the upper leg section** when joined.

#### 3.2 Join the Upper and Lower Leg Sections

- Align the two sections at your marked point.
- Find two clear holes that line up through both sections and insert bolts. Tighten securely.
- Repeat this process for the **other leg**.



#### Tip:

The legs have approximately **8mm** of additional sideways adjustment range, which will be helpful if your workshop floor is uneven.

### Step 4: Attach the Legs to the Stand Top

With both legs prepared, it's time to connect them to the top section of the stand.

#### 4.1 Position the Legs

- Place the legs at each end of the stand top section.
- Align them using the pre-cut slots and holes provided.

#### 4.2 Insert and Tighten the Bolts

- We recommend using **at least 10 bolts per leg** connection point for strength and rigidity.
- Tighten bolts securely but avoid overtightening, which can cause distortion in the steel parts.

### Step 5: Level the Stand

Once the legs are attached and the stand is upright, it's time to level it.

#### 5.1 Check for Level

- Place a spirit level on the top of the stand.
- Adjust the leg height by moving the lower leg section up or down as necessary.

#### 5.2 Secure Final Leg Positioning

- Once the stand top is level, insert additional bolts through the best available holes or slots to lock in the position.
- We suggest **a minimum of six bolts per leg section** to provide a rigid, stable setup.



### Step 6: Understand the Adjustment Options

The variety of slots and holes in the stand components allows for:

- **Height adjustments** to suit elbow heights between **930mm and 1200mm**

- **Fine-tuning for uneven floors**, ensuring your lathe stays level
- **Custom configurations**, catering to personal working styles and preferences

This design ensures the stand can be tailored to meet the specific requirements of different users and workshops.

### Step 7: Install the Shelf

The final structural component is the lower shelf, which provides additional rigidity and can be used for storage.

#### 7.1 Position the Shelf

- Place the shelf between the two legs.
- The shelf can be installed with the tabs facing **upwards** (to prevent items from sliding off) or **downwards** (for a flush look), depending on your preference.

#### 7.2 Secure the Shelf

- Use **four bolts on each side** to attach the shelf securely.
- Tighten bolts evenly to maintain the overall alignment and stability of the stand.

### Final Step: Ready for Lathe Installation

Once all components are assembled, levelled, and securely fastened, your adjustable lathe stand is complete and ready for the installation of your **Stutey3040 lathe**.

Before installing the lathe, double-check:

- The stand is level
- All bolts are securely tightened
- There is no excessive movement or wobble

### Safety Tips

- Always wear safety gloves and eye protection during assembly to avoid injury from sharp metal edges.
- Ensure the stand is placed on a solid, level surface before mounting the lathe.
- Periodically check bolts and connections during use to maintain the stand's stability.

### Maintenance and Adjustments

The adjustable nature of this stand means you can revisit its height and level settings as your workspace changes, or your ergonomic needs evolve. The multiple slots and holes make fine-tuning adjustments quick and easy.

### Congratulations!

You have now successfully assembled your **Stutey Adjustable Lathe Stand**, custom-fit for your Stutey3040 lathe.

## Parts List

Order No:	Description	Order No:	Description
SWL-A03	Spindle Assembly	SWL-P312	Spindle Handwheel
SWL-A04	Indexing Assembly	SWL-P324	Banjo Handle
SWL-A08	Tailstock Quill Assembly	SWL-P327	Banjo Cam Shaft
SWL-A09	Tailstock Locking Assembly	SWL-P330	Turntable Pin
SWL-A13	Banjo Handle Assembly	SWL-P331	Spindle Knocker Rod
SWL-A14	Banjo Clamp	SWL-P341	Indexer Plunger
SWL-A15	Spindle Knocker	SWL-P350	Bed Retaining Shaft
SWL-A17	Turntable Pin Assembly	SWL-P352	Bed Retaining Plate
SWL-A18	Spare Belt Bracket	SWL-P360	Tailstock Quill
SWL-A21	Remote Controller	SWL-P361	Tailstock Screw Shaft
SWL-A23	Tacho Unit	SWL-P362	Tailstock Clamp Plate
SWL-P109	Toolrest 12" x 1"	SWL-P371	Key Tailstock Handwheel
SWL-P207	Handwheel Washer	SWL-P450	Knob 40xM10
SWL-P208	Spindle Spanner	SWL-P451	Knob 25xM8
SWL-P209	Spindle Spanner	Bearing_3209-2rs	Bearing 3209-2RS
SWL-P210	Spare Belt Bracket	Bearing_6208-2rs	Bearing 6208-2RS
SWL-P214	Turntable Washer	YW1B-V4E01R	Emergency Stop Button
SWL-P215	Hook Spanner	YW1S-3E20	Selector Switch
SWL-P301-	Spindle Shaft	RV24YN20S	Potentiometer 10K

## Get in touch:

Address: 44 Victoria Pde Kilmore, 3764. Victoria. Australia

Email: [info@stutewoodlathes.com.au](mailto:info@stutewoodlathes.com.au)

Phone: +61 0417 031 568

## Your lathe information

	Serial Number	Checked/working
Lathe No		
Motor No		
VDF No		
Date Tested		
Hi Ratio		
Lo Ratio		
Headstock/tailstock centred		
Thread details	1 ¼ x 8	
	M30 x 3.5	
	M33 x 3.5	
Controller		
Accessories Included		

