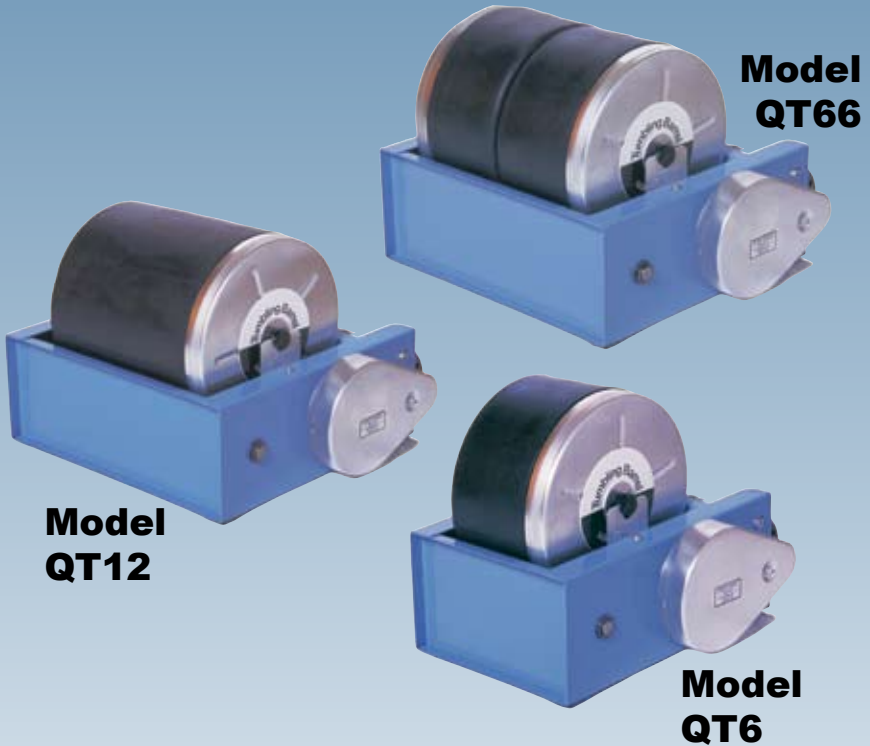


# ROTARY TUMBLER

## INSTRUCTIONS AND PARTS LIST



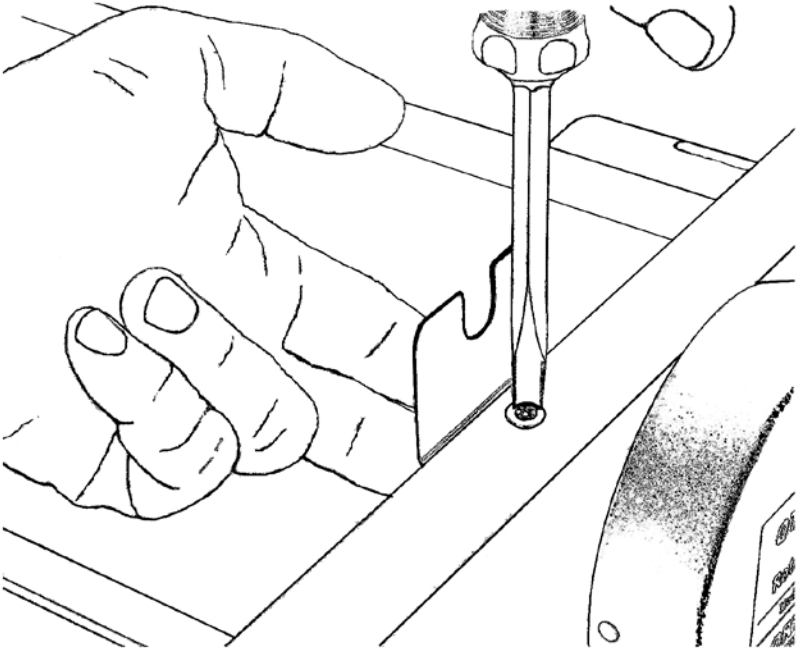
# LORTONE

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12130 Cyrus Way  
Mukilteo, WA 98275  
(425) 493-1600

# SETTING UP YOUR MACHINE

**Install The Barrel Guide:** Using the machine screw provided, install the barrel guide under the frame edge as shown in the picture. Align the slot in the guide with the groove in the knurled nut on the barrel. Adjust the position of the guide so the slot is centered on the groove. Tighten the screw securely with the nut provided.



Install Barrel guide under  
the tumbler frame edge.  
Tighten screw securely.

# GETTING STARTED

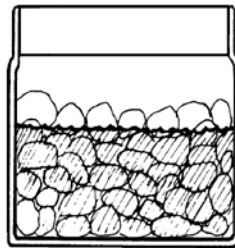
- I. Open the Barrel:** Remove nut and washer, press down on bolt with thumb while lifting up on outside of outer lid with fingers. If outer lid is difficult to remove, insert washer between edge of outer lid and barrel, twist to loosen. After outer lid has been removed, lift inner lid out by center bolt.



- II. Add Rocks:** Fill Barrel about 1/2 to 2/3 full of rock. Rocks should be of assorted sizes for best results.



- III. Add Abrasive:** Add 60/90 Silicon Carbide Abrasive. Use 10 level Tbsp for a 6 Lb. barrel. Use 20 level Tbsp for a 12 lb. barrel.



Add rocks until 2/3 full. Add water to top layer of rocks.

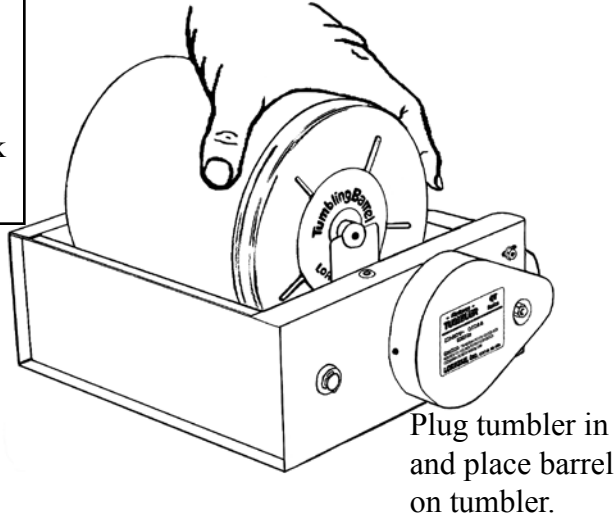
Add water to cover rocks and abrasive.

Do not overfill.

- IV. Close the Barrel:** Wipe the mating surfaces of the barrel and inner lid clean with a damp cloth. Press inner lid into barrel until it rests on shoulder. Press outer lid firmly down onto the barrel. Install washer and tighten nut.

Knurled nut only needs to be snug Do Not Use tools to tighten. Over tightening of the nut can cause the inner lid to distort and leak.

Make sure to align barrel guide with groove in black knurled nut.



Plug tumbler in and place barrel on tumbler.

**V. Tumble:** Plug the tumbler into a suitable outlet. Place the barrel on the tumbler making sure the groove in the barrel nut sits on the tumbler guide. Tumble for 2-3 days. Open and check the rocks. The rough edges should be wearing down. After 5-7 days, open the barrel and rinse the rocks in a bucket of water. **DO NOT** put the rinse water down a household drain as it will clog the drain!

**IMPORTANT:** Clean the rocks and barrel parts thoroughly using mild soap and water!

**VI. Repeat steps II through V:** Use successively finer abrasives according to your tumbling instruction booklet and the chart below:

	Step 1	Step 2	Step 3	Step 4
<b>Compound</b>	60/90 Silicon Carbide	120/220 Silicon Carbide	Pre-Polish Aluminum Oxide	Polish Aluminum Oxide
<b>6 lb Barrel</b>	10 Tbsp	10 Tbsp	12 Tbsp	12 Tbsp
<b>12 lb Barrel</b>	20 Tbsp	20 Tbsp	24 Tbsp	24 Tbsp

# TROUBLESHOOTING

If your tumbler fails to operate correctly, check the following:

## **Barrel does not turn, turns very slowly, or stops after being placed on tumbler.**

No power to unit.	Make sure machine is plugged in correctly. Make sure electrical circuit is operational.
Barrel not installed correctly.	Align barrel correctly.
Barrel too heavy.	Do not exceed rated capacity.
Belt slipping.	Tighten belt.
Drive belt broken.	Remove cover and replace belt.
Motor doesn't run or runs intermittently.	Replace motor.

## **Barrel leaks or barrel lid comes off during operation.**

Inner lid not seated correctly.	Make sure inner lid and barrel shoulder are clean and free of contaminants. Make sure inner lid is seated on shoulder inside barrel.
Knurled nut over tightened.	Tighten knurled nut by hand only until snug. Do not use tools.
Gas build-up in barrel.	Open barrel occasionally to vent gas that might be formed during tumbling.
Barrel or boot gasket damaged.	Replace damaged barrel or boot gasket.

If you need assistance, please contact:  
Lortone Customer Service (425) 493-1600  
equipment@Lortone.com

# MAINTENANCE

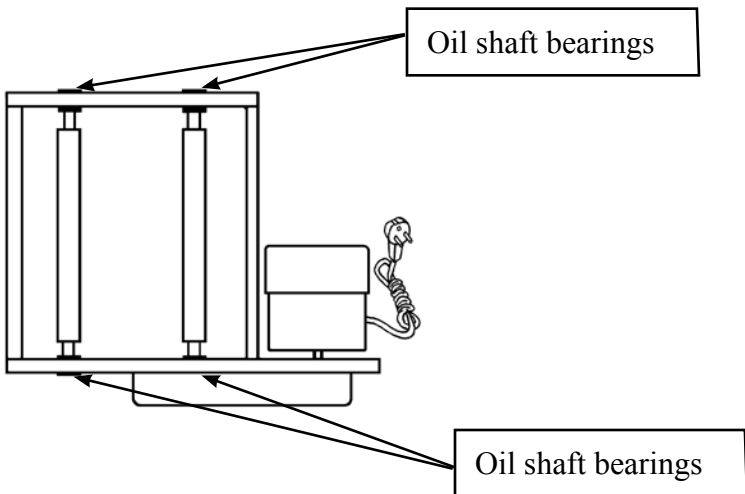
**LORTONE** Tumblers are capable of operating 24 hours/day for years with proper care.

For best operation and results follow these simple, but important steps:

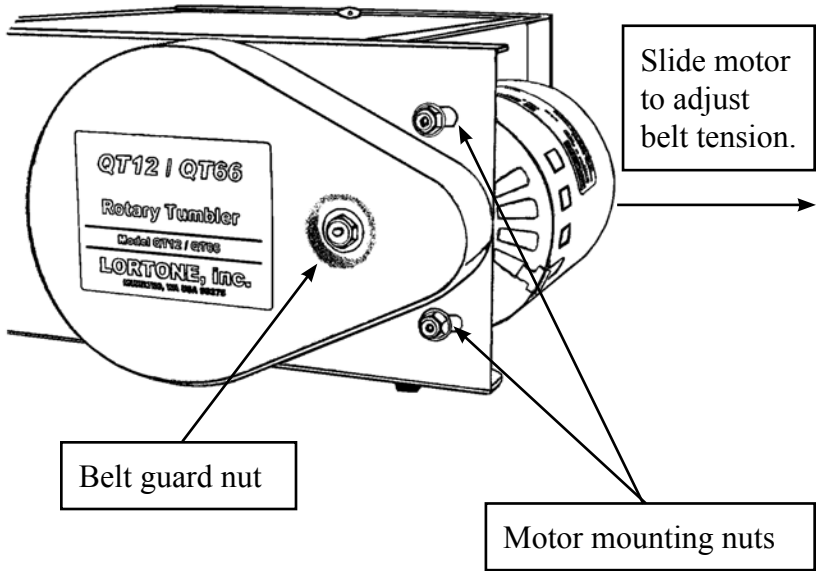
**MOTOR:** The motor is designed for continuous use and does not need oiling or other maintenance. It is normal for the motor to run hot to the touch.

**CLEANING:** The outside of the barrel should be kept clean. Clean by wiping with a wet soapy cloth and rinse well with fresh water. **DO NOT** put the barrel in a dishwasher or clean using solvents. If the outside of the barrel becomes so slick that it slips on the rollers, roughen slightly with very fine sandpaper or steel wool.

**BEARINGS:** Oil each shaft bearing every 30 days of operation, using one drop of lightweight lubricating oil. Do Not Use excessive oil.



**DRIVE BELT:** Keep the drive belt tight enough to drive the barrel without being over tightened. Improper tension (too tight) can cause motor bearing failure and belt stretch. To adjust the belt, loosen the two motor mounting nuts, slide the motor to the right, and re-tighten the nuts.



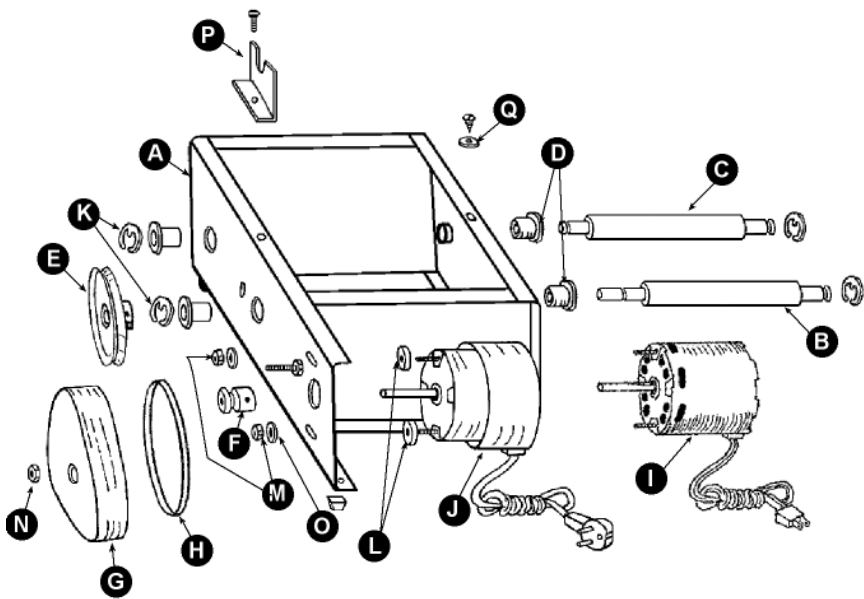
**DRIVE BELT REPLACEMENT:** Remove the belt guard nut and loosen the motor mounting nuts. Remove the old belt and discard. Carefully slip the new belt over the pulleys.

**Caution: Pulley edges are sharp!** Replace the belt guard and tighten the belt guard nut.

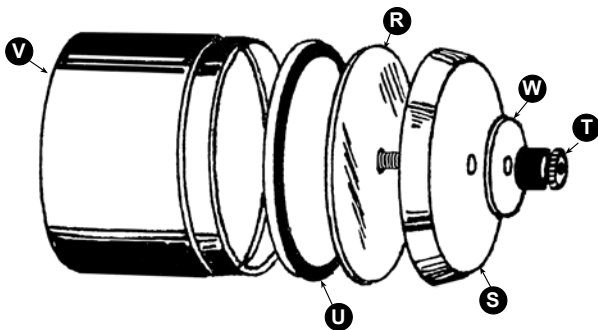
# PARTS LIST QT6

<b>Part No.</b>	<b>Description</b>
<b>A</b> 006-100	Frame
<b>B</b> 006-001	Drive Shaft with Cover
<b>C</b> 006-002	Idler Shaft with Cover
<b>D</b> 203-001	Bearing (4 Required)
<b>E</b> 006-101	Drive Pulley Assembly
<b>F</b> 006-103	Motor Pulley
<b>G</b> 006-102	Belt Guard
<b>H</b> 210-011	Drive Belt
<b>I</b> 301-030	Motor, 110v
<b>J</b> 301-031	Motor, 220v
<b>K</b> 206-013	Retaining Ring (4 Required)
<b>L</b> 489-093	Nylon Washer (4 Required)
<b>M</b> 481-012	Cap nut, 8-32"
<b>N</b> 481-013	Cap nut, 10-32"
<b>O</b> 489-062	Washer, #8
<b>P</b> 006-003	Barrel Guide with Hardware
<b>Q</b> 489-092	Nylon Washer
<b>Part No.</b>	<b>Description</b>
020-093	Complete Rubber Barrel Assembly, 6 lb Capacity
<b>R</b> 020-102	Inner Lid w/Bolt
<b>S</b> 020-003	Outer Lid
<b>T</b> 481-070	Knurled Nut
<b>U</b> 240-012	Boot Gasket
<b>V</b> 240-004	Rubber Barrel Only
<b>W</b> 108-001	Barrel Washer





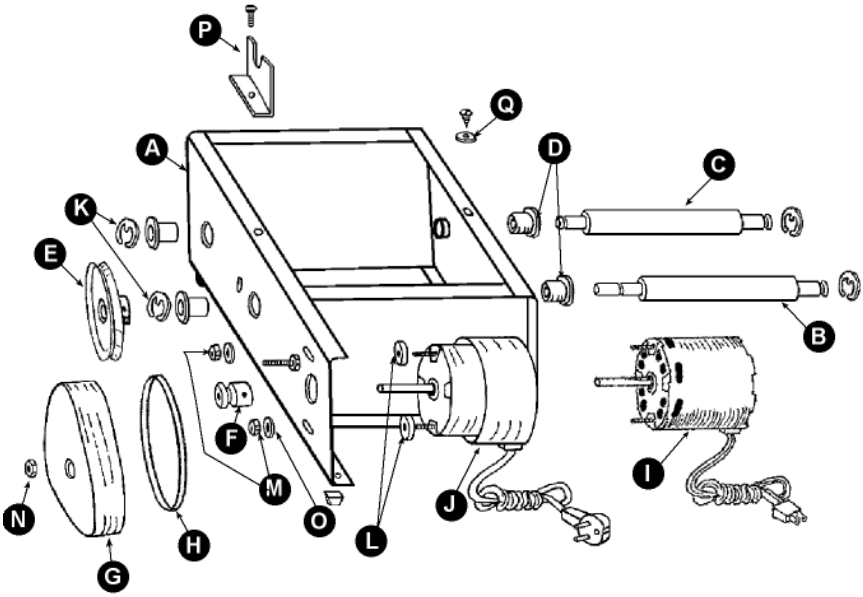
**QT6**



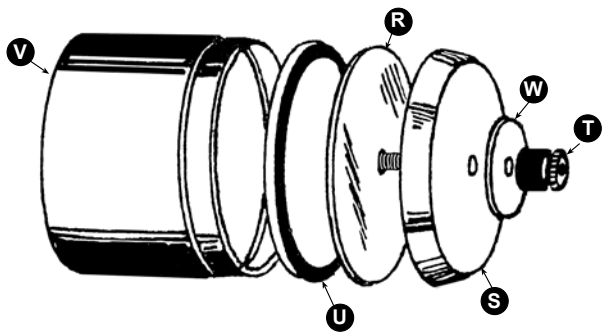
**6 Lb. Barrel**

# PARTS LIST QT12 and QT66

<b>Part No.</b>	<b>Description</b>
<b>A</b> 006-105	Frame
<b>B</b> 006-005	Drive Shaft with Cover
<b>C</b> 006-006	Idler Shaft with Cover
<b>D</b> 203-001	Bearing (4 Required)
<b>E</b> 006-101	Drive Pulley Assembly
<b>F</b> 006-103	Motor Pulley
<b>G</b> 006-102	Belt Guard
<b>H</b> 210-011	Drive Belt
<b>I</b> 301-030	Motor, 110v
<b>J</b> 301-031	Motor, 220v
<b>K</b> 206-013	Retaining Ring (4 Required)
<b>L</b> 489-093	Nylon Washer (4 Required)
<b>M</b> 481-012	Cap nut, 8-32"
<b>N</b> 481-013	Cap nut, 10-32"
<b>O</b> 489-062	Washer, #8
<b>P</b> 006-003	Barrel Guide with Hardware
<b>Q</b> 489-092	Nylon Washer
<b>Part No.</b>	<b>Description</b>
020-094	Complete Rubber Barrel Assembly, 12 lb Capacity (QT12 model) (See 6 Lb. Barrel on page 7&8 for QT66)
<b>R</b> 020-102	Inner Lid w/Bolt
<b>S</b> 020-003	Outer Lid
<b>T</b> 481-070	Knurled Nut
<b>U</b> 240-012	Boot Gasket
<b>V</b> 240-005	Rubber Barrel Only
<b>W</b> 108-001	Barrel Washer



**QT12, QT66**



**12 Lb. Barrel (For QT12)**  
 (See 6 Lb. Barrel on page 7&8 for QT66)

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**LORTONE Rotary Tumblers**  
are quiet, durable grinding  
and polishing machines.  
Follow these basic operating  
and care instructions to help  
keep your tumbler in optimal  
running condition.

**LORTONE**

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Mukilteo, WA 98275  
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