

BED, PAN, AND LEGS

Front sump cover	A-59022	Pan plate	A-95886
bed	L-97288	Strainer	A-95887
Pan	L-95861	Gasket	A-95896
Right leg	L-95888	Gasket	A-95897
Left leg	L-97289	Bedway	A-95971
Front sump gasket	A-59027	Rack	A-95972
Pump and motor	B-97088	Lever	B-95019
Oil level gage	B-85939	Handle	B-95020
Filler - breather cap	B-88671	Stop rod screw	B-36694
Filter	B-91330	Stop rod plunger	B-31995
Sump cover	A-96154	Screw plug	B-32063
Sump cover gasket	B-92238	Patent plate	B-68469
Filler block	A-96153	Tee fitting	B-97147
Block gasket	B-96155	Oil change plate	B-68468
Pump bracket	A-98138	Spring	1557
Side splash guard	A-96162		
Rear splash guard	A-97290		
Front splash guard - special	A-98355		
Stop rod bracket	A-96067		
Stop rod	A-96068		

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6-1-P 2

HEAD (Ref. P/L #9136)

Bearing closer	(2)	A-86066	AS450 clutch hub	(2)	A-86937
Bearing closer		A-86067	AS600 clutch hub	(2)	A-86938
Spacer		B-86074	Spacer shim	(6)	B-88024
Spacer	(2)	B-86079	Spacer shim	(7)	B-88152
Spacer		B-86082	99T gear (Std. Spd.)		A-86828
Shaft		A-86083	93T gear (Spl. High Spd.)		A-86124
Spacer		B-86131	MRC bearing		B-91176
Spacer		B-86203	MRC bearing	(2)	B-91177
59T gear		A-86817	MRC bearing		B-91178
49T gear		A-86820	MRC bearing	(2)	B-91179
27T gear		A-86821	MRC bearing	(2)	B-91180
Pinion shaft		A-86831	MRC bearing	(2)	B-91181
61T clutch gear		A-86931	MRC bearing		B-91182
71T clutch gear		A-86932	MRC bearing		B-91183
71T clutch gear		A-86933	Fawick clutch with		
95T clutch gear		A-86934	B&O hub A-86937	(2)	B-91184
			Fawick clutch with		
			B&O hub A-86938	(2)	B-91185

HEAD

Housing cover	L-96060	#6 legend plate	A-95988
Housing cover	A-96061	Gasket	A-96063
Name plate	A-85059	Shim	A-98530

HEAD - HOUSING PIPING

Flodar BA-2000-6-90	Spraco V-812 spray head	(2)	B-85944
Flodar BA-3000-6 T	8" 3/8 steel tubing		
Weatherhead 3300 x 4 coupling	Weatherhead bulkhead CPLG W-21204	(2)	
Weatherhead 3325 x 4 nipple			
Weatherhead 3350 x 4-45			

HEAD RANGE GEAR (37/1600 RPM - 3" CAPACITY)  
(31/1170 RPM 5" CAPACITY)

931 gear	A-86124	43T gear	A-86829
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HEAD RANGE GEARS (30/1300 RPM - 3" CAPACITY)  
(25/950 RPM - 5" CAPACITY)

99T gear	A-86828	37T gear	A-86830
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PRESELECTOR

Cover	L-95862	Arm	B-95870
Switch bracket	A-95863	Pivot	B-95871
Chart plate	A-95864	Closer	B-95872
Control plate	A-95865	Bushing	B-95873
Handwheel	A-93691	Sprocket	B-95874
Shaft	A-95866	Spacer	B-95875
Dial drum	A-95867	Spacer	B-95876
Drum chart 30/1300	A-95868	Cam #1	B-95877
Drum chart 25/950	A-95869	Cam #2	B-95878
Spacer	B-74747	Cam #3	B-95879
Index lever	B-74796	Cam #4	B-95880
Roller	B-74797	Stud	B-95881
Spring	B-74799	Key	B-95882
Spacer	B-74806	MRC bearing 202-SZ	B-95883
Spacer	B-74807	Microswitch BZ-2RM22-A2	B-95884
Bushing	B-90287	Drum chart 31/1170	A-98020
Handwheel clip dial	A-97329	Drum chart 37/1600	A-98021
Clip	B-31937		

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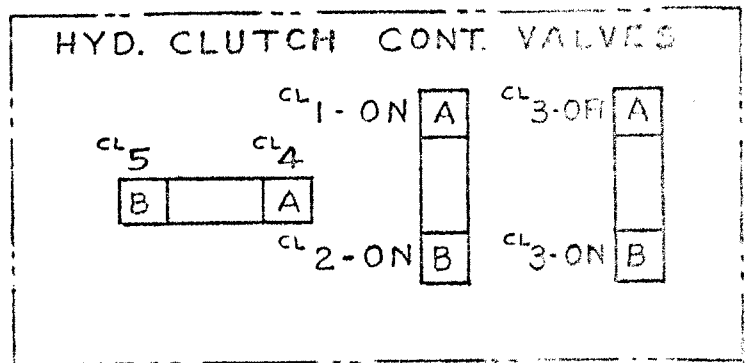
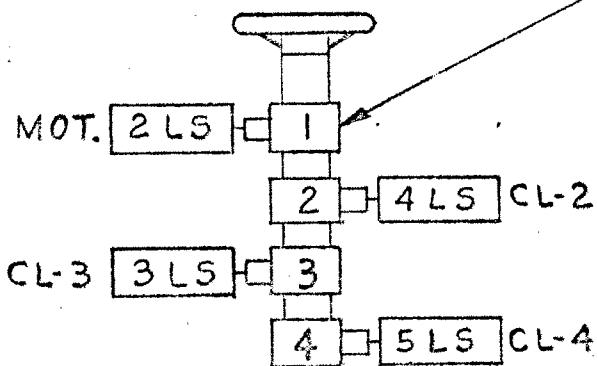
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6-3-P

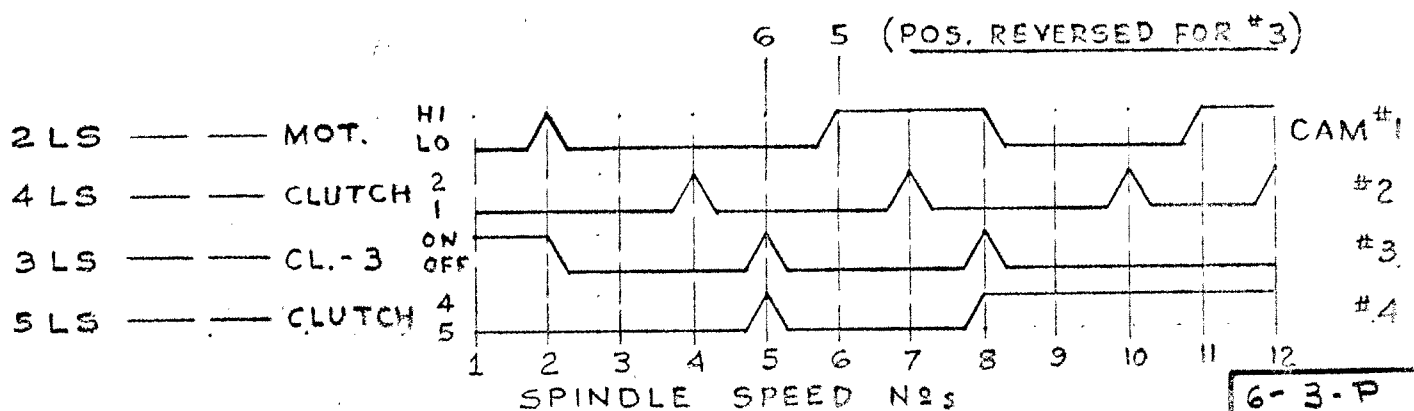
SPINDLE SPEEDS						No	MOT.	CL.	CL.	CL.
NO. 6 UTL			NO. 3 UTL		HI/LO		2/1	3/1-2	HI/LO	
25	30	31	37	30	39	1	L		3	L
50	60	61	74	60	78	2	H		3	L
73	88	90	103	90	115	3	L	1		L
103	123	126	151	125	160	4	L	2		L
115	158	141	193	195	245	5 6	L		3	H
146	176	180	216	175	225	6 5	H	1		L
206	246	253	303	250	315	7	H	2		L
230	316	284	389	385	490	8	H		3	H
338	464	414	568	570	720	9	L	1		H
474	650	580	796	795	1000	10	L	2		H
676	928	833	1142	1135	1440	11	H	1		H
950	1300	1170	1600	1600	2000	12	H	2		H

1 2 3 4  
CAM No

PRE-SELECT UNIT



"AT REAR OF HEAD STK."



6-3-P

3" CAPACITY SPINDLE

Head	L-97291	Spacer	B-90218
Front bearing closer	A-86812	Spacer	B-90219
Rear bearing closer	A-86845	Bearing retainer	B-90220
Bearing spacer	B-86850	Timken bearing cone #3 Prec.	B-91190
Spindle	A-99973	Timken bearing cup #3 Prec.	B-91191
Driving button	B-37291	Timken bearing cup #3 Prec.	B-91192
Key	B-86865	Timken bearing cone #3 Prec.	B-91193
Adjusting nut	A-86846	Timken bearing cone #3 Prec.	B-91546
Adjusting nut	A-86847	Timken bearing cup #3 Prec.	B-91547
Drive plate	A-89769	XPO Kaydon bearing	B-91194
Clutch plate	A-89770	MRC bearing with loose	B-91196
Clutch hub	A-99974	internal clearance	B-91197
Clutch back plate	A-99976	0-ring seal	B-91198
Clutch front plate	A-90213	0-ring seal	B-97725
Clutch body	A-90214	Smally wave spring	B-97350
Clutch sleeve	A-90215	Truarc 5100-500 ret. ring	
70 tooth gear	A-99975		
105 tooth gear	A-90217		
Key	A-99966		

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6-4-P

5" CAPACITY SPINDLE

Head				
Front bearing closer	L-97292	Timken bearing cone #3	Prec.	B-91161
Rear bearing closer	A-98436	Timken bearing cup #3	Prec.	B-91162
Rear spacer	A-95799	Timken bearing cone #3	Prec.	B-91163
Spindle	B-88432	Timken bearing cup #3	Prec.	B-91164
Front spacer	A-99982	Kaydon bearing		B-91165
Key	B-90447	Kaydon bearing		B-91166
Spacer	B-86865	Kaydon bearing		B-91167
Bearing retainer	A-90417	0-ring seal		B-91168
Adjusting nut	B-90220	0-ring seal		B-91169
Adjusting nut	A-88433	Spirolock RS 800		B-97348
Clutch hub	A-88434			
Clutch back plate	A-99983			
Clutch front plate	A-99985			
Clutch body	A-88437			
Clutch sleeve	A-90423			
Drive plate	A-90422			
Clutch plate	A-88440			
Separator spring	A-88441			
96T gear	A-97726			
126T gear	A-99984			
Key	A-90445			
	A-99966			

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6-5-P

SPINDLE CONTROL

Housing extension  
 Control housing  
 Control base  
 Extension cover  
 Lever  
 Manifold  
 Plunger  
 Manifold  
 Spring  
 Spring  
 Lever  
 Handle  
 Plunger  
 Switch  
 Legend plate

L-96001  
 A-96002  
 A-96003  
 A-96004  
 A-96005  
 L-96006  
 A-96007  
 A-96008  
 B-40728-A  
 B-52220  
 A-100298  
 B-92351  
 B-94759  
 B-95884  
 B-97355

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Bushing  
 Shaft  
 Detent plate  
 Guide  
 Washer  
 Stop plate  
 Bushing  
 Hyd. valve  
 Hyd. valve  
 MRC bearing R-4-A-4  
 Manifold gasket  
 Brake detent  
 Pin  
 Collar  
 Lever hub  
 Spring

(3)

(2)

B-96010  
 B-96011  
 B-96012  
 B-96013  
 B-96014  
 B-96015  
 B-96016  
 B-96017  
 B-96081  
 B-96018  
 A-96260  
 B-97342  
 B-97343  
 A-100326  
 A-100327  
 B-100328

6-6-P



COLLET CHUCK 3" CAPACITY

Yoke	A-86967	Ring	B-90472
Yoke bracket	A-86965	Abutment sleeve	A-90473
Finger	A-70711	Handle	B-98019
Wedge shoe stud	B-42434	Yoke pivot	A-95952
Collet	A-44578	Rear spindle guard	A-98018
Collet pad	A-49503	Collet hood guard	A-97436
Finger roller	B-62784	Spindle guard pin	B-86866
Finger roller pin	B-62785	False jaw screw	2231
Wedge	A-74996	Key	2233
Air cylinder	A-86981	Finger holder friction	B-44275
Collet hood	A-88235	Cyl. link	B-86975
Finger holder	A-88236	Yoke link pin	B-86976
Pin	B-88239	Wedge shoe	B-74999
Plunger	B-89916	Cyl. mounting block	A-86980
			(4)
			(2)
			(2)

6-7-P

COLLET CHUCK 5" CAPACITY

Yoke	A-88318		Ring	A-88317
Yoke bracket	A-88319		Wedge shoe	B-88320
Finger	A-70711	(4)	Collet	A-88795
Collet hood	A-88796		Collet pad screw	B-88797
Spindle guard pin	B-32580		Yoke pivot	A-95955
Finger roller	B-62784	(4)	Rear spindle guard	L-98018
Finger roller pin	B-62785	(4)	Collet hood guard	A-97437
Collet pad	A-80597		Handle	B-98019
Pin	B-88239	(4)	Key	2233
Air cylinder	A-88302		Finger holder friction	B-44275
Finger holder	A-88311		Cyl. link	B-86975
Plunger	A-88313		Yoke link pin	B-86976
Wedge	A-88315		Wedge shoe	B-74999
Abutment sleeve	A-88316		Cyl. mounting block	A-86980

6-8-P

HEAD END BRACKET 3" CAPACITY

Spindle gear	A-95789	34T gear	A-95791
Head gear	A-95790	35T-27T gear	A-95792
Head end bracket	L-95771	Spacer	B-95781
Gasket	A-95773	Bearing spacer	B-95782
30T-54T gear	A-95774	Gear stud	B-95783
62T gear	A-95775	Spacer	B-95784
Bearing closer	A-95776	Bearing closer	B-95785
Shaft	A-95777	Bearing spacer	B-95786
Shaft	A-95778	Bearing closer	B-97316
Key	B-60449	Feed shaft	B-95788
Spacer	B-65145	MRC bearing 203-S	B-95768
Coupling	B-65161	MRC bearing 204-S	B-95767
Sight gauge	B-95753	MRC bearing 205S	B-94912
Bearing spacer	B-95779	MRC bearing 205SZ	B-95769
Spacer	B-95780		

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6-9-P

HEAD END BRACKET 5" CAPACITY

Spindle gear	A-95793	28T gear	A-95795
Head gear	A-95794	41T-27T gear	A-95796
Head end bracket	L-95771	Spacer	B-95781
Gasket	A-95773	Bearing spacer	B-95782
36T-54T gear	A-95774	Gear stud	B-95783
62T gear	A-95775	Spacer	B-95784
Bearing closer	A-95776	Bearing closer	B-95785
Shaft	A-95777	Bearing spacer	B-95786
Shaft	A-95778	Bearing closer	B-97316
Key	B-60449	Feed shaft	B-95788
Spacer	B-65145	MRC bearing 203-S	B-95768
Coupling	B-65161	MRC bearing 204-S	B-95767
Sight gauge	B-95753	MRC bearing 205S	B-94912
Bearing spacer	B-95779	MRC bearing 205SZ	B-95769
Spacer	B-95780		B-95770
	(2)		
			(2)
			(2)
			(2)
			(4)

6-10-P



CARRIAGE APRON

Carriage dial	A-95668	Dial feed plate	B-95671
Dial feed plate	B-95670	Gib	B-95965
Carriage apron	L-94820	Bunting bushing	B-65319
Apron cover	L-94821	Spacer	B-65322
Right side cover	A-94822	Dial marker	B-65334
Left side cover	A-94823	Bushing	B-65339
Cross feed lever	A-94824	Sleeve	B-65340
Long. feed lever	A-94825	Screw	B-65341
Gear shift lever	A-94826	Shift pin	B-65342
Worm gear	B-65296	Bearing spacer	B-65352
Feed arrow	B-41719	Bushing	B-65387
Knockout spring	B-31760	Bushing	B-65388
Feed lever spring	B-31917	Lever guard	B-67045
Rev. detent spring	B-31918	Feed lever cam	B-67046
Clutch spring	B-34684	Clutch plug	B-69183
Stud	B-37754	Stop screw	A-69817
Adjusting nut	B-40580	Spacer	B-70631
Spring	B-46766	Stop screw roll	A-71323
Spring	B-52222	Bushing	B-73036
Spring	B-59673	Pin	B-81534
Spacer	B-62521	Handle	B-92351
Triple cluster gear	A-65259	Knob	B-93655
Tooth clutch gear	A-96032	Front gasket	A-94991
Gear shifter stud	B-65275	Left side gasket	A-94992
Bushing	B-65287	Right side gasket	A-94993
Tooth clutch	B-65286	Cam shaft	A-94994
Pinion shaft	A-95669	Gear shift cam	A-94995
Tooth clutch gear	B-65289	Hollow shaft	A-94996
Clutch bolt nut	B-65293	Shaft	A-94997
Spacer	B-65295	Handwheel	A-98229
Tooth clutch	B-96031	Clutch bolt	A-95000
Feed lever plunger	B-65302	Lever	B-95001
Double cluster gear	B-65306	Detent holder	B-97382
Double cluster gear	B-65307	Shifter block	B-95003
Double cluster gear	B-65308	Shifter rod	B-95004
Idle gear	B-65310	K.O. rod plug 15/16	B-95005
Worm	B-65311	Lever stop	B-95006
40T gear	B-65312	C.S. knockout rod	B-95007
Bunting bushing	B-65318	Detent plate	B-95008

6-13-P

CARRIAGE APRON

Cam spacer	B-95009	Handwheel shaft	B-95023
Feed dial	B-95010	Retainer	B-95024
Idler gear stud	B-95012	Spring	B-95025
Sleeve	B-95013	Spacer	B-95026
Bearing spacer	B-95014	Pin	B-95027
25T gear	B-95015	Cross feed lever rod	B-95028
Spacer	B-95016	Reversing gear shaft rod	B-95065
Feed disengage pin	B-95017	Plug	B-95066
K.O. rod plug 1-1/16	B-95018	Carriage apron top gasket	A-95836
Feed lever stud	B-95019	Breather	B-95755
Knob	B-95020	Clutch bushing	B-96021
Washer	B-95021	Worm gear sub assembly	B-95325
Pinion shaft gear	B-95022	Torrington NTA-1828 bearing	B-96033
Victor seals #60096	B-95749	Torrington TRC-1828 plate	B-96034
Victor seals #62302	B-95748	MRC bearing 202-S	B-95757
Victor seals #60454	B-95750	MRC bearing 207-S	B-95758
Aetna bearing E-7	B-95762	MRC bearing R-4	B-95759
Bijur sight gage #B-5734	B-95753	MRC bearing 104-KS	B-95760
Bijur KIC-C-2367 lube pump	B-95754	MRC bearing 107-KS	B-95761
Drill jig bushing #GA-92	B-95756	MRC bearing 204-S	B-95767
Jergens #26908 plunger	B-94759	Brass shoe	1049
Lever stop	B-96137	Brass shoe	2246
Tooth clutch with 40T gear	B-96536	Brass shoe	2281
Tooth clutch with 23T gear	B-96537	Brass shoe	2289
CHIP GUARD	A-99520	WASHER	1066
		WASHER	1071

6-13-P

TURRET SLIDE AND SADDLE

Turret cover	B-36154	Lower cap - read	A-60301
Turret	A-60307	Rack	A-60302
Tumbler	A-62969	Saddle way - front	A-60303
Saddle	L-95513	Saddle way - rear	A-60304
Slide	L-74559	Saddle way - front	A-60305
Turret clamp	A-74561	Pawl cam	B-62959
Pawl	B-67784	Lockbolt lever roller	B-62961
Bevel gear nut	B-13962	Washer	B-62962
Knockout spring	B-31760	Lockbolt	A-62963
Knockout rod plug	B-80810	Stop pin	B-62964
Ind. stop shaft collar	B-33163	Pawl spring	B-62966
Lock bolt spring	B-33479	Lockbolt lever	A-62968
Ind. stop shaft bevel gear	B-33481	Lockbolt lever pin	B-62980
Ratchet	B-36163	Pawl pivot pin	B-62981
Turret Bevel gear	B-36164	Right front gib	B-63014
Binder bolt	B-36180	Lever washer	B-63347
Jam nut	B-80811	Manifold	B-63425
Turret locating ring	A-41143	Latch pivot	B-95515
Chip guard	A-41822	Latch	B-95516
Chip guard support	A-41827	Ratchet pin	B-64965
Steel way screw	B-58225	Turret locating ring pin	B-65368
Carrier nut	B-58792	Pawl stop	B-67791
Clamp nut	B-59767	Clamp stud	B-95517
Gib screw	B-58815	Stop screw roll	A-70945
Lockbolt bushing	B-58820	Spring guide	B-70964
Oil plug	B-58855	Binder hub	B-92239
Manifold	B-60282	Binder handle	B-92325
Stop rod	B-60283	Handle knob	B-92351
Knockout rod	B-80809	Brass shoe	B-95687
Left front gib	B-60286	Tumbler seat	B-71971
Rear gib	B-60287	Lockbolt sleeve	B-72027
Rear gib	B-60288	Spring retainer	B-72028
Stop screw	B-60289	Release trip	B-73875
Ind. stop shaft	B-60290	Clamp stud	B-73876
Stop	B-60291	Clamp release	B-73877
Tumbler screw	B-60292	Link	B-73878
Slide cap - front	B-60297	Washer	B-73879
Slide cap - clamp	B-95514	Slide cap - rear	A-74562
Slide cap - front	A-60298	Guard	B-74563
Lower cap - front	A-60300	Clamp spacer	B-74586



TURRET SLIDE AND SADDLE - Continued

Clamp ring locator	(2)	B-77660	Washer	(4)	1067
Soft pin	(2)	279	Plug	(5)	2247
Pin	(4)	301	Brass shoe	(5)	2254
Shoe	(6)	884	Plug		2313
Shoe	(6)	1049	Plug		2397
Washer	(6)	1060	Plug		2401

G-14-P

SADDLE APRON

Dial	A-95673	Pinion shaft	A-99718
Feed lever	A-95674	Dial feed plate	B-95676
Seal retainer	B-95679	Dial feed plate	B-95677
Apron	L-95728	Tooth clutch	B-96031
Apron cover	A-94828	Tooth clutch	B-65824
Left side cover	A-96025	Gear	B-95730
Turnstile sleeve	A-94831	Rear cover	B-65834
Right side cover	A-96024	Rear gasket	B-65836
Top cover	A-95422	Lever guard	B-67045
Worm gear	B-65296	Feed lever cam	B-67046
Lever	B-65802	Clutch plug	(3)
Lever	B-65803	Bushing	(5)
Triple cluster gear	A-65808	Handle	(3)
Cam	A-69916	Knob	B-95006
Cam shaft	A-94994	Lever stop	B-95009
Front gasket	A-95122	Cam spacer	B-95019
		Feed lever stud	B-95020
Left side gasket	A-96064	Knob	B-95024
Right side gasket	A-96065	Retainer	B-95025
Hollow shaft	A-95125	Spring	(4)
Shaft	A-95126	Spacer	(2)
Clutch bolt	A-95127	Pin	B-95027
Feed arrow	B-42100	Gasket	B-95130
Spring	B-31917	Feed dial	B-95131
Spring	B-52222	Dial feed plate	B-95132
Spacer	B-62521	Detent plate	B-95133
Clutch bolt nut	B-65293	Spacer	B-95134
Double cluster gear	B-65306	Bearing spacer	B-95135
Double cluster gear	B-65307	Spacer	(2)
Double cluster gear	B-65308	Bearing spacer	(2)
Worm	B-65311	Long. feed lever rod	B-95138
Spacer	B-65322	Top gasket	B-95731
Dial marker	B-65334	Turnstile hub	A-99719
Sleeve	B-65340	Turnstile handle	B-65823
Screw	B-65341	Plug	B-95837
Shift pin	B-65342	Arrow breather vent ASP-4BV	B-95755
Bushing	B-65386	Lever stop	B-96138
Feed lever plunger	B-65822	Clutch bushing	B-97309
Lever screw	B-65824		

SADDLE APRON (CONT.)

Victor seal - #62302	MRC bearing -	207-S	B-95758
J.M. hat gasket - #9846	MRC bearing -	R-4	B-95759
Bijur KIC-C-2367 lube pump	MRC bearing -	104-KS	B-95760
Bijur sight gage - B-5734	MRC bearing -	107-KS	B-95761
Jergens plunger #26908	MRC bearing -	204-S	B-95767
Drill jig bushing #GA-92	Brass shoe		1049
	Brass shoe		1066

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6-15-P

COOLANT PUMP & PIPING (1/2 HP)

Manifold	A-95994	Bronze Apollo ball valve	(2) B-94875
Gusher coolant pump	B-97122	No. 70-103-01 1/2" N.P.T.	(2) B-95995
Model 9050 Long-1/2 HP		American Flexible metal hose type F2	(4) B-95996
		Parker No. S-2202-12-12	
		360° hydraulic swivel adaptor	

6-16-2

BAR FEED - 3" CAPACITY

Rear bearing closer	A-70146	Front bearing closer	A-96202
Sup. Tube braeket	A-70155	Chuck guard	A-96203
Lever	B-70163	Revolving head sleeve	A-68204
Sliding head	A-96098	Pin	B-69148
Rear stand	A-96099	Collar	B-70171
Center stand	L-96100	Support tube	B-70172
Front stand	L-97323	Bar	B-70187
Bracket	A-96102	Stand head washer	B-70191
Chuck plate	B-38594	Sprocket guard	A-97324
Spring	B-43666	Sprocket guard	A-96104
Shoe	B-66329	Motor bracket	A-96105
Center plug	B-61952	Chain extension	B-96106
Chuck screw	B-63182	Roller chain bracket	B-96107
Chuck jaws 1 pair	A-63185	Idler shaft	B-96108
Handle	B-93655	Drive shaft	B-96109
Revolving head	A-96201	Chain guard	B-96111
Inner bearing spacer	B-68188	14T sprocket	B-96129
End bearing spacer	B-68191	Boston pillow block	B-96130
Sprocket guard	A-98122	Coupling	B-96131
Inner sleeve No. 1	A-97410	Air motor	B-96132
Inner sleeve No. 2	A-97409	Washer	1056
Inner sleeve No. 3	A-97408	Washer	1069

G-17-P

5 INCH CAPACITY BAR FEED (B&O)

Bracket	A-96102	Lever stud	B-95810
Handle	A-98097	Chain extention	B-96106
Rear bearing closer	A-98098	Roller chain brkt.	B-96107
Support tube brkt.	A-98101	Pin	B-98087
Sliding head	A-98102	Pillow block	B-98088
Rear stand	L-98104	Sprocket	B-98089
Center stand	L-98105	Washer	B-98090
Front stand	L-98106	Idler shaft	B-98091
Spring	B-43666	Chain guard	B-98092
Shoe	B-66329	Drive shaft	A-98093
Jaws	(4) B-77122	Support tube	A-98094
Locknut	A-80770	Collar	A-98095
Sleeve	A-80772	Motor bracket	A-98096
Front brg. closer	A-80773	Drive sprocket guard	A-98099
Guard	A-80774	Idler sprocket guard	A-98100
Chuck	A-80780	Sliding head tube	A-98103
Bearing spacer	(2) A-80781	Air motor	B-98108
Wood's coupling-sleeve	B-91468	Inner sleeve #1	A-98063
Wood's coupling-hub	B-91470	Inner sleeve #2	A-98064
Wood's coupling-hub	B-91531	Inner sleeve #3	A-98065
Knob	B-95020	Inner sleeve #4	A-98066
		Inner sleeve #5	A-98067
		Inner sleeve #6	A-98068

6-18-P

MOTOR DRIVE - LOUIS ALLIS

30/15 HP

Motor plate  
Motor shaft  
Motor

A-96196  
A-95701  
B-95646

36/18 HP

Motor plate  
Motor shaft  
Motor

A-88189  
A-96144  
B-96208

6-19-P

MOTOR DRIVE - STERLING

30/15 HP

Motor plate  
Motor shaft  
Motor

A-88189  
A-98156  
B-98153

6-19-P



ELECTRICAL EQUIPMENT

Control enclosure			
Enclosure bracket			
	L-96125	Control box brace	(3)
	L-96151	Washer	(6)
			A-95274
			1067

G-20-P

SQUARE TURRET

Lever	A-42151				
Base	A-58497			(4)	B-96177
Square turret	A-58496			(12)	2041
Spring	B-31931				2075
Spring L.B.	B-32049				2326
Binder lever collar	B-32475			(2)	2397
Spring plunger	B-32476				B-95803
Lock bolt sleeve screw	B-34175				
Spring	B-34684				
Lockbolt	B-39900				
Lockbolt sleeve	B-39901				
Lockbolt bushing	B-39902				
Bottom plate	B-39905				
Lockbolt cam	B-39910				
Lockbolt lever	B-39912				
Index plunger	B-39914				
Lever shaft	B-42145				
Lever bushing	B-42146				
Lever collar	B-42147				
Lever collar	B-42148				
Lever ball	B-42149				
Center stud	B-43627				
Indexing plate	B-43629				
Center bushing	B-51200				
Center sleeve	B-51201				
Tumbler	A-81956				
Square turret ring	B-58488				
Pivot screw	B-58489				
Tumbler plunger	B-58490				

(4)

6-21-P

CROSS SLIDE TAPER ATTACHMENT

Tool slide taper gib	B-33347	Tool slide stud	B-33344
Swivel slide taper	B-33348	Follower	B-33345
Yoke	B-34819	Bracket	B-36876
Base	A-36875	Bracket stud	B-97266
Tool slide	A-63200	Tee nut	B-96177
Gib screw	B-31890	Knurled head screw	1008
Swivel stud	B-33343	Washers	1069
		Square head screw	2058

3" T.P.F. - 8" Long

Swivel plate  
Swivel slide

A-33704  
A-36852

20° T.P.F. (4.232) 7" Long

Swivel plate  
Follower

A-53001  
B-53055

Stationary Sine Bar Taper Attachment

.500 T.P.F.  
.600 T.P.F.  
.625 T.P.F.

Sine bar slide  
Sine bar  
Sine bar back taper

A-42180  
( A-42181  
( A-42220

2-1/4 T.P.F. - 12" Long

Swivel slide  
Swivel

A-49656  
A-49657

6-22-P

S.C.A.

Bracket	A-71286	Stop lever	B-71298
Lg. fd. lever	A-71859	Knock out adjustment	B-71299
Lever (#4 UTL only)	B-71288	Bushing	B-71301
Leader	A-71289	Knock out rod	B-71302
Lever (#6 UTL only)	B-80822	Lever catch	B-71303
Lever (#3 UTL only)	B-95148	Detent	B-71304
Leader nut	B-32079	Knock out rod plunger	B-71305
Spring	B-48061	Lever rod	B-95810
Leader bushing	B-71290	Lever pivot	B-71307
Follower	B-71291	Pinion shaft	B-71858
Follower rack	A-71292	Kickout plun. spring	B-52312
Closer	B-71293	Cover	B-71319
Disengage block	B-71294	Spring	B-56121
Pin	B-71306	Knob	B-95020
Kickout plunger	B-71297	Gits oiler	#2201
		Socket wrench #270-S	B-98227
		Engr. wrench BW-10A	B-98226

15 IN. CHUCK GUARD

Hood	A-98462
Guard	A-98463
Knob	B-84088
Washer	C-2303

(2)

6-24-P

12" SCROLL CHUCK GUARD (3 IN. CAP.)

A-96228      Guard  
Washer      (2)

A-66243  
1065

Guard hood

G-26-P

POWER RAPID TRAVERSE

Control box	A-98515	Cam shaft	B-76550
Cross slide	L-98516	Lever	B-76551
Carriage	L-98517	Detent	B-76552
Cover	A-98518	Stop block	B-76554
Housing	A-98519	Cover	B-76555
Spring	B-43659	Gasket	B-76556
Bushing	B-72844	Feed screw	A-98520
27T gear	B-75169	Chip guard	A-98521
Stud	B-75188	Feed screw guard const.	A-98522
Spacer	B-74747	Sleeve	B-98523
		Flange	B-98524
		43T gear	D-98525
		Stop block	B-98526
		Speed cont. muffler	B-88698
		Pressure reg.	B-91243
		Air motor	B-96132
		Air valve	B-96503
		Plug	#2281

(3)  
(2)  
(2)

(2)

## USING THE CONVERSION DIAL

### 1. Inch measurement

With the inch engraving on the selector ring to the top, the engraved dial will now revolve at the same speed as the lead screw.

### 2. Millimetre measurement

The conversion dial can be changed from inch to metric by turning the selector ring slowly  $180^\circ$  in a clockwise direction until it can be felt clicking into the detent position. This will show the mm engraving at the top. The engraved dial will now revolve at a higher speed than the leadscrew spindle, 2.54 to 1.

### 3. Reversion to inch measurements

The selector ring is returned to the detent position in a counter-clockwise direction. A small arrow engraved beside the inch and mm engraving shows the direction of rotation in each case.

### 4. Zero set

The engraved dial can be set at zero or any other position on the dial by unscrewing the thumb screw, moving it to the required position and then re-tightening the thumb screw.

6-29-P



INCH/METRIC DIAL

Jergens conversion dial unit No. 65103		Handwheel	A-97151
Machine slave hub by B & O	A-97149	Nut	B-97152
Jergens increment ring 0/333 Machine ring by B & O	B-97150	Adapter	B-97153
		Clip	B-97306
		McMaster Delrin fluted-head finger - Screw No. 94323D191	(6) B-97330

6-29-P

15 IN. AIR POWER CHUCK - SP

Adapter	A-90821	Filter-regulator-lub.	B-96926
Cyl. guard	A-99303	4-way valve	B-95900
Draw rod	A-99513	Speed control plug	(2) B-88698
		S-P 15 in. 3-jaw chuck Model 52	
		S-P 16 in. air cyl. Model RM	
		S-P soft blank T.J. #15-S-325	

6-30-P

AIR POWER CHUCK - CUSHMAN

Adapter  
Spindle guard  
Draw rod  
Anit-rotation bracket

A-90821  
A-99634  
B-90822  
B-98409

Cushman 12-2-3 jaw chuck  
Series 20-672-12-A08  
Cushman 12 in. air cylinder  
Series 10-752-12-000  
Cushman soft top jaws  
Model #25-13071 (1 set)

6-31-P

REAR SQUARE TURRET

Base adapter      A-99935  
Tee nut            (4) B-92332

For remaining parts see Square Turret 6-21-P

6-32-P

TURRET COOLANT DISTRIBUTOR

Adapter	A-85518
Housing	A-98339
Shut-off	B-84993
Locknut	B-85521
Stem	A-98337
Manifold	A-98338

(6)  
(6)

6-33-P

HIGH PRESSURE TURRET COOLANT

Manifold	A-98338	Bronze ball valve	B-100268
Adapter	A-100265	No. 70-104 (3/4 NPT)	
Housing	A-100266	Bronze ball valve	
360 swivel adapter	B-100267	No. 70-103-01 (1/2 NPT) (6)	B-94875
Part No. S 2101-12-12		Pump power package	B-100269

6-34-P



12" SP HYD. POWER CHUCK

Bracket	A-96102
Adapter	A-89034
Draw tube	A-100200
Cyl. guard	A-101201
Anti-rotation bracket	A-101202
Polypack power unit	B-101157
Pressure SW. 836 C9A	
35-375 PSI	
12" - 3 jaw model DD-300	
Power chuck - SP dwg. E-3690	
8 RHC 8" thru-hole rot.	
Hyd. cyl. SP dwg. E-3947	
12 CC - 355 - X hard ser.	
Master jaw pads	
Coupler SP dwg. 14438	(4)
Washer	C-1069

6-36-P



15" S - P HYD. POWER CHUCK

bracket

A-101881  
A-101339  
A-101340  
A-101341  
B-101157

Draw tube  
Cyl. guard  
Adapter  
Polypack power unit  
Pres. SW 836 C9A 35/375 PSI  
15" jaw model CC300  
Power chuck - SP dwg. E-5081  
12" RHC 12" thru hole rot.  
Hyd. cyl. SP dwg. E-2946  
CC - 345 - X hard serrated  
insert with bases  
15CC - 355 - X hard serrated  
master jaw pads  
Coupler SP dwg. C-16716  
Washer

(4) C-1069