

BED, PAN AND LEGS

Bed			
Pan	L-95372	Oil gage cover	B-36350
Right leg	L-95364	Oil gage glass	B-36358
Left leg	A-92230	Oil gage gasket	B-36359
Electrical box bracket	A-92231	Bracket brace	B-92220
Pump bracket	A-105399	Left leg gasket	B-92273
Strainer	A-95366	Right leg gasket	B-92274
Pan plate	A-95367	Oil change plate	B-94101
Rear splash guard	A-95368	Patent plate	B-68469
Side splash guard	A-95369	Oil gage (sub-assembly)	B-59219
Bracket support	A-95370	Strainer knob	#788
	A-95371	Stud	1337
	(2)		(8)
			(set)
			(2)
			(2)

HEAD

Housing cover	L-95378	Gear shift fork	B-38668
Housing plate	A-95359	Shift fork	B-46054
Name plate	A-75125	Bevel gear	B-38680
Gear shift lever	B-52751	Speed change gear	B-38681
Gear shift lever	B-68521	Speed change gear	B-38682
Intermediate shaft	A-68524	Roller	B-69121 (2)
High & low shaft	A-95413	Roller pin	B-38686 (2)
56T gear cam	A-68538	Lever stud	B-38687 (2)
52T gear cam	A-68539	Gear bushing	B-38688
Double gear cluster	A-95331		
Triple gear cluster	A-95332	Feed change gear stud	B-38705
Spindle speed plate	B-72813	Locknut	B-41999
Not shift plate	B-93701	Oil retainer & spacer	B-105247 (1 each)
Chart-speed & change gears	A-95410	Bearing spacer	B-68527 (1 each)
		Bearing spacer	B-68528
Speed range 120/2000		Bearing spacer	B-68529
Motor shaft gear - 34T	A-95416	Bearing spacer	B-68530
Transfer cluster - 38T	A-95417	Shaft spacer	B-68531
120/2000 dial speed plate	B-95534	Spacer	B-68541
		Cam shaft	B-38684
Speed range 140/2400		Button screw	B-38706
Motor shaft gear - 37T	A-95414	Driving button	B-38707
Transfer cluster - 35T	A-95415	Dial	B-92326
140/2400 dial speed plate	B-95533	Washer	C-1067 (2)
		Washer	C-1069 (2)
Speed range 175/3000		Spring	C-2075 (2)
Motor shaft gear - 41T	A-95418	Key	C-2211
Transfer cluster - 31T	A-95419	O-ring	11-016
175/3000 dial speed plate	B-95535	Handle	B-92243
		MRC bearing (5205 S.B.K.)	B-94911
		MRC bearing (205S)	B-94912 (3)
		MRC bearing (206SF)	B-94913

1-1/4 CAPACITY SPINDLE

Spindle
Front bearing closer
Rear bearing closer
45T spindle gear
75T spindle gear
Spindle gear nut
Spacer & oil retainer
Balancing ring
Spindle sheave

A-44321
A-44322
B-44325
A-95503
A-95504
B-44323
B-44324
B-59736
B-92151

No. 3 Precision
Cup Timken bearing
Cone Timken bearing
Cup Timken bearing
Cone Timken bearing
Key

B-93651
B-93652
B-93653
B-93654
C-2343

B & O #4-1/2 Collet

Collet hood guard
Collet hood
Collet ring

A-43978
A-43969
A-43981

Collet
Plunger

A-44871
B-43977

#22 B & S Collet

Collet hood guard
Plunger
Sleeve
Collet hood
Collet ring

A-43978
B-42132
B-42777
B-42778
B-42779

Use following parts only for machine
with ratchet or tipe bar feed

Inner sleeve No. 2
Inner sleeve No. 3
Sleeve screw

A-95470
A-95471
B-94334
(2)

5C Drawback Collet (Hardinge)

Collet hood guard
Collet hood
Finger holder

A-42789
A-91280
B-46937

Abutment sleeve
Plunger

B-46938
B-91289

HEAD END BRACKET

Head end bracket			
Cover	L-95388	Feed shaft extension	A-95391
Left half sheave	A-95389	Feed shaft brg. spacer	B-38794
Right half sheave	A-95394	Top cover	B-41167
Feed shaft	A-95395	204-SZZ ball bearing	B-95392
	A-95390	Gripnotch belt	D-95393
		(2)	

MOTOR DRIVE

Reuland Motor
Pilot
Motor Plate

A-105414
A-105246
A-105245

CONSTRUCTION L-105250

2A-10-P

MOTOR CONTROL

Switch cover			
Switch plate	A-95540	For. & rev. lever	B-93699
Switch plate bracket	A-95541	Spring	B-43666
For. & rev. actuator	A-95542	Controller plate	B-43541
High & low actuator	A-95543	Lever nut	B-43540
For. & rev. hub	A-95544	Micro sw. BZLH-RH5	B-95550
High & low hub	B-92260	Micro sw. BZLH-LH5	B-95549
Switch lever	A-95546	Spring	B-43145
	B-95547	Reid handle BTH-9	B-92351
		Univ. bushing GM-94	B-95545
			(3)
			(2)
			(2)
			(2)

TURRET SLIDE & SADDLE

Slide	L-95574	Lockbolt	A-65398
Saddle	L-95565	Turret locating ring	A-65400
Tumbler	A-65399	Front slide cap	A-95579
Hex turret	A-65395	Lower front saddle cap	A-65403
Turret clamp		Lower rear saddle cap	A-65404
(A-84562 machine processed)	A-74294	Rear saddle way	A-82265
		Rear slide cap	A-95580
A-59188 Sub-assembly		Ind. stop scr. nut carrier	B-12004
		Gib screw	B-31890
Lockbolt lever		Knock out rod plug	B-80810
(Precision casting)	A-95447	Lockbolt spring	B-38432
Lockbolt lever roller	B-65417	Knock out rod	B-95577
Lockbolt lever washer	B-65418	Stop rod	B-95581
Eaton 307 snap ring		Stop	B-38441
		Stop screw	B-38442
A-59193 Sub-assembly		Ind. stop bevel gear	B-38447
		Bevel gear nut	B-38448
Pawl	B-65421	Binder bolt	B-38452
Stop pin	B-38436	Jam nut	B-80811
Pawl pivot	B-38437	Chip guard plate	B-42693
Pawl spring	B-39246	Chip guard	B-42694

TURRET SLIDE AND SADDLE

Knockout spring
 Lockbolt bushing
 Bevel gear
 Way stud
 Oil plug
 Clamp nut
 Lever washer
 Ratchet pin
 Rack
 Back gib
 Back gib
 Front gib
 Lockbolt lever pin
 Pawl cam
 Index stop shaft
 Stop screw roll
 Tumbler screw
 Locating pin
 Clamp stud
 Cover
 Lockbolt sleeve
 Tumbler seat
 Spring retainer

B-31760
 B-47905
 B-95483
 B-58225
 B-58855
 B-59767
 B-63347
 B-64964
 B-65408
 B-65411
 B-65412
 B-65413
 B-65416
 B-95601
 B-95482
 B-65423
 B-65424
 B-65429
 B-68687
 B-70628
 B-72156
 B-72157
 B-72158

Clamp stud
 Release trip
 Clamp release
 Link
 Spacer
 Guard
 Washer
 Set screw block
 Ratchet
 Clamp ring locator
 Front saddle way
 Front saddle way
 Binder hub
 Binder handle
 Handle
 Binder stop
 Shoe
 Timken bearing cone #3 Precision

B-74296
 B-74297
 B-74298
 B-74299
 B-74300
 B-74301
 B-74302
 B-74303
 B-75284
 B-77661
 B-82266
 B-82267
 B-92239
 B-92325
 B-92351
 B-93703
 C-2281
 13181

(6)
 (10)
 (3)
 (2)
 (2)
 (2)

SADDLE APRON

Apron cover
 Apron side cover
 Right side cover
 Turnstile sleeve
 Left side cover
 Top cover
 Worm gear
 Lever
 Lever
 Triple cluster gear
 Cam
 Cam shaft
 Front gasket
 Left side gasket
 Right side gasket
 Hollow shaft
 Shaft
 Clutch bolt
 Spring
 Feed arrow
 Spring
 Spacer
 Clutch bolt nut
 Dbl. cluster gear
 Dbl. cluster gear
 Dbl. cluster gear
 Worm
 Spacer
 Chip guard
 Pinion shaft

L-95728
 A-94828
 A-96024
 A-94831
 A-96025
 A-95422
 B-65296
 A-98921
 B-65803
 A-65808
 A-69916
 A-94994
 A-95122
 A-96064
 A-96065
 A-95125
 A-95126
 A-95127
 B-31917
 B-42100
 B-52222
 B-62521
 B-65293
 B-65306
 B-65307
 B-65308
 B-65311
 B-65322
 A-99520
 A-100093

(2)
 (3)
 (2)
 (2)

Feed lever
 Sleeve
 Screw
 Shift pin
 Bushing
 Lever screw
 Fd. lever plunger
 Tooth clutch
 Tooth clutch
 Gear
 Rear cover
 Rear gasket
 Lever guard
 Fd. lever cam
 Clutch plug
 Bushing
 Handle
 Knob
 Lever stop
 Cam spacer
 Fd. lever stud
 Knob
 Retainer
 Spring
 Spacer
 Pin
 Gasket
 Feed dial
 Seal retainer

(2)
 (3)
 (5)
 (3)
 (4)
 (2)

A-95423
 B-65340
 B-65341
 B-65342
 B-65386
 B-65817
 B-65822
 B-96031
 B-65824
 B-95730
 B-65834
 B-65836
 B-67045
 B-67046
 B-69183
 B-73036
 B-92351
 B-93655
 B-95006
 B-95009
 B-95019
 B-95020
 B-95024
 B-95025
 B-95026
 B-95027
 B-95130
 B-95131
 B-95139

SADDLE APRON (CONT.)

Dial feed plate					
Detent plate					
Spacer					
Brg. spacer	(2)				B-95754
Spacer	(2)				B-95753
Brg. spacer					
Lg. fd. lever rod					
Top gasket					
Turnstile hub					
Turnstile handle					
Plug	(5)				B-95759
Lever stop					B-95760
Clutch bushing					B-95761
					B-95767
					B-95758
O-Rings					
PRP 568-008	(2)				B-95762
PRP 568-010					B-94759
PRP 568-012	(2)				
PRP 568-113					
PRP 568-115	(2)				
PRP 568-210					
PRP 568-213					
Victoprene seal #62302	(2)				
J.M. #9846 hat gasket					
Tru-Arc snap rings	(2)				
5100-78					
5100-137					
5100-250					
Brg. breather vent ASP-2BV					
Bijur KIC-C-2367 lube pump					
1 in. stroke 1 in. stroke					
Bijur B-5734 sight gauge	(3)				
Bijur B-4067 fitting					
Bijur 5C-25 tubing (28 in. long)					
MRC bearings					
R-4	(2)				
104-KS	(2)				
107-KS					
204-S	(2)				
207-S					
Aetna bearings (E-7)	(2)				
Jergens #26908 plunger					
GA-92 drill jig bushing					
5/16 hole 5/16 hole	(2)				

COOLANT PUMP & PIPING

Gusher coolant pump
Model 6-P3 Long 1/4 HP 230/460V
1/2 x 12 in. long American flexible
coolant line with male coupling
and open nozzle
Apollo ball valve

B-91226

Coolant pump & main motor pl.
Flodar BA-1000-10 (tube fitting)

B-93470

1/2 in. pipe 5/8 in tube -
male connector

B-97341

1/2 in. pipe swivel joint -
Parker S2202-8-8

B-94875

2A-15-P

AIR OPERATED COLLET

Bracket	A-97251	Wedge shoe stud	(2)	B-34446
Cylinder mtg. bracket	A-97252	Finger roller pin	(2)	B-34448
Cylinder pivot. bracket	A-97253	Wedge shoe	(2)	B-35887
Lever shaft	A-93659	Finger roller	(2)	B-35892
Plate	A-97254	Yoke lever pin	(2)	B-35897
Collet control plate	A-97255	Finger pivot pin	(2)	B-35898
Link pin	B-37081	Link pin		B-35975
Roller pin	B-51578	Link		B-38804
Cylinder rod end	B-79949	Spacer		B-38805
Yoke lever	A-41695	Yoke lever pin		B-38978
Inner sleeve	A-94328	Spacer		B-38988
Wedge	B-41691	Finger holder friction		B-44273
Finger holder	B-41692	Locknut		B-49945
Abutment sleeve	B-41693			
Sleeve screw	B-94334			
	(2)			
NOTE: Use inner sleeve and sleeve screw only on machine with ratchet or lipe bar feed				
Finger	B-35891	Yoke lever stud		B-41706
Crank lever	B-93449	Spindle wedge key		C-2210
Rear end spindle guard	A-92204	Oil-rite style DOSF		106
BRACKET SPACER	B-106156	Logan RFL unit-Model 401		B-87942
Spindle guard pin	B-32580	Logan mounting bracket		
		Model No. Z-3707		B-97256
		P.H. air cylinder-Series 2A		
		3-1/4 B.-2-3/4 stroke		
		1 in. rod mount.-Style F		
		Thread style 4		B-91812
		Barksdale manual-3 position		
		4 way valve-Model No. 9021-M		B-93456

RATCHET BAR FEED

Rear bar stand	A-34854	Drip trough	A-37840
Front bar stand	A-42308	Link pin	B-37081
Ratchet connection	B-38797	Link pin	B-37711
Lever	B-42310	Spring	B-38192
Stand head	B-81412	Latch	B-38800
Sliding head	A-42312	Link	B-38803
Revolving head	A-83718	Ratchet	B-38819
Chuck guard	A-40606	Feed bar	B-38820
Chuck screw	B-35330	Slotted feed bar	B-38821
Chuck jaws	B-35331	Washer	C-1058
Chuck plate	B-35332	Headless screw or	
Front brg. closer	B-35333	7/16 x 7/8 lg. D.P.S.S.	(2)
Rear brg. closer	B-35334	Dowel pin	C-2130
Bearing spacer	B-35335	Dowel pin	C-283
Support tube	B-42318	Spring	C-292
Support tube coupling	B-42319	Washer	C-1530
Center plug	B-83719	Brass shoe	C-1837
M.R.C. bearing 201-SF	B-88666	Pin	C-2248
			C-2088

(1 pair)

(2)

SQUARE TURRET

Binder bolt	B-42144	Tumbler	A-61146
Base	A-58492	Pivot screw	B-58482
Lockbolt lever	B-63351	Tumbler plunger	B-58483
Lockbolt cam	B-63352	Square turret	A-58491
Lockbolt bushing	B-32046	Spring	B-73527
Lockbolt spring	B-32049	Filister head screw	16
Screw plug	B-32055	Spring	(2) 2075
Lockbolt	B-34234	Square head set screw	(12) 2093
Lockbolt sleeve	B-34235	Straight pin	2326
Tumbler pin	B-34236	Plug	(2) 2397
Bottom plate	B-34243	Gits oiler	(2) B-95803
Binder lever collar	B-34248		
Spring plunger	B-34249		
Tee nut	B-36070		
Lever shaft	B-42145		
Lever bushing	B-42146		
Lever collar	B-42147		
Lever collar	B-42148		
Lever ball	B-42149		
Indexing plate	B-43646		
Center stud	B-43651		
Center bushing	B-51196		
Center sleeve	B-51197		

(4)

(2)

2A-20-P

REAR TOOL POST
(Tool #241)

Body
Tee nut
Adjusting nut

B-41281
B-36070
B-37096

Wedge
Stud
Square head set screw

B-38875
B-38876
2093

(2)

Body-5/8 x 7/8 cutter

B-44190

2A-22-P

LIPE BAR FEED

Bar feed model 181-SL
Bushings - No. 1
 - No. 2
 - No. 3

B-95073
A-102249
A-102244
A-102245

P/L No. 9078

2A-23-P

SPINDLE MOTOR - REMOTE CONTROL

Cover	(2)	B-49450	Lever	(2)	B-52965
Bracket	(2)	A-50015	Plunger	(2)	B-52967
Forward and reverse box	(2)	A-55446	Stop screw	(6)	B-66261
Nut	(2)	B-49452	Hi-Low dog	(3)	B-81112
Spring	(2)	B-49463	Stop screw roll		A-66262
Cap	(2)	B-50003	Switch block		A-81113
Forward and reverse dog	(3)	B-50007	Filler piece		B-86135
Hi-Low dog	(3)	B-50008	Pin	(4)	2371
Bar		B-50016	C2-ID01-A3N limit switch,		
Insulator	(2)	B-51143	Dennison		
			Micro-Switch BZ-2RS	(2)	
			Gits roller - 1219		

FOR REMAINING PARTS ADD TURRET SLIDE AND SADDLE (PAGE 2A-12 -P) PARTS
BUT OMIT B-38442 and B-65423

2A-24-P

SCROLL CHUCK GUARD

Hinge
Hinge
Support

B-42157
B-42158
B-42159

Guard
Hinge pin
Support shaft

A-42160
B-42161
B-42162

L-42156 - Construction

2A-25-P

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° 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.

2A26-P

BED, PAN AND LEGS

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Right leg	A-92230	Oil gage gasket	B-36359
Left leg	A-92231	Bracket brace	B-92220
Electrical box bracket	A-95365	Left leg gasket	B-92273
Pump bracket	A-95366	Right leg gasket	B-92274
Strainer	A-95367	Oil change plate	B-94101
Pan plate	A-95368	Patent plate	B-68469
Rear splash guard	A-95369	Oil gage (sub-assembly)	B-59219
Side splash guard	A-95370	Strainer knob	#788
Bracket support	A-95371	Stud	1337
	(2)		(8)
			(set)
			(2)
			(2)

RECORD LOT 430-3

2A-1-P

HEAD

Housing cover	L-95378	Gear shift fork	B-38668
Housing plate	A-95359	Shift fork	B-46054
Name plate	A-75125	Bevel gear	B-38680
Gear shift lever	B-52751	Speed change gear	B-38681
Gear shift lever	B-68521	Speed change gear	B-38682
Intermediate shaft	A-68524	Roller	B-69121
High & low shaft	A-95413	Roller pin	B-38686
56T gear cam	A-68538	Lever stud	B-38687
52T gear cam	A-68539	Gear bushing	B-38688
Double gear cluster	A-95331	Bearing closer	B-38690
Triple gear cluster	A-95332	Feed change gear stud	B-38705
Spindle speed plate	B-72813	Locknut	B-41999
Not shift plate	B-93701	Oil retainer & spacer	B-44262
Chart-speed & change gears	A-95410	Bearing spacer	B-68527
		Bearing spacer	B-68528
		Bearing spacer	B-68529
		Bearing spacer	B-68530
Speed range 120/2000	A-95416	Shaft spacer	B-68531
Motor shaft gear - 34T	A-95417	Spacer	B-68541
Transfer cluster - 38T	B-95534	Cam shaft	B-38684
120/2000 dial speed plate		Button screw	B-38706
		Driving button	B-38707
Speed range 140/2400		Dial	B-92326
Motor shaft gear - 37T	A-95414	Washer	C-1067
Transfer cluster - 35T	A-95415	Washer	C-1069
140/2400 dial speed plate	B-95533	Spring	C-2075
		Key	C-2211
Speed range 175/3000		O-ring	11-016
Motor shaft gear - 41T	A-95418	Handle	B-92243
Transfer cluster - 31T	A-95419	MRC bearing (5205 S.B.K.)	B-94911
175/3000 dial speed plate	B-95535	MRC bearing (205S)	B-94912
		MRC bearing (206SF)	B-94913

(2)
(2)
(2)

(1 each)
(1 each)

(2)
(2)
(2)

(3)

Zero Speed Sw. Mount.

Bracket	A-93640	Woods 255L075-3/8 P. timing	B-93967
Belt guard	A-93641	belt	
Timing belt pulley	B-93643	A-B Bul. 808-Style C-zero	
Woods 24L075-3/8 P.-24 grooves		speed switch without bracket	
timing belt pulley with 5/8 hole	B-93966		

RECORD LOT 430-3

2A-3-P

MOTOR DRIVE

Standard Dayton motor-5/2.5 H.P.,
frame 213, 1800/900 RPM (blower
cooled), Ref. Drwg. B-210-500-1
Motor bracket (6931)
Bracket gasket
Motor shaft
2-1/4 x 6-3/8 U.S. Gypsum Co.
Expand-X, size 1/2 #40, flat-
tened, black metal screen (2)

B-94333
A-69025
A-59038
A-91257

Oil retainer C-1110
206-SF MRC ball bearing

From zero speed sw. P/L #8187
send only the following parts:

Woods timing belt pulley
Woods timing belt

B-44262

B-93643
B-93967

Send following parts in addition
to above to Standard Dayton for
assembly of motor

Bearing closer C-1110
Locknut C-1110

B-38690
B-41999

RECORD LOT 430-3

2A-10-P