

PARTS CATALOG

FOR

BARDONS & OLIVER

No's. 33, 34, & 34½

AUTOMATIC CUTTING-OFF LATHES

BARDONS & OLIVER, Inc.

BARDONS & OLIVER, INC.

5800 HARPER ROAD

SOLON, OHIO 44139

440-498-5800 FAX 440-498-2001

NOS. 33, 34 & 34½ **AUTOMATIC CUTTING-OFF LATHES** PARTS CATALOG.

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THIS PARTS CATALOG HAS BEEN PREPARED TO SIMPLIFY THE ORDERING OF REPAIR PARTS.

WHEN ORDERING:

1. SPECIFY NUMBER OF PIECES WANTED.
2. GIVE SIZE AND SERIAL NUMBER OF MACHINE.*
3. GIVE NUMBER AND NAME OF PART EXACTLY AS SHOWN IN CATALOG.
4. GIVE PURCHASE ORDER NUMBER COVERING ORIGINAL MACHINE.

EXAMPLE:

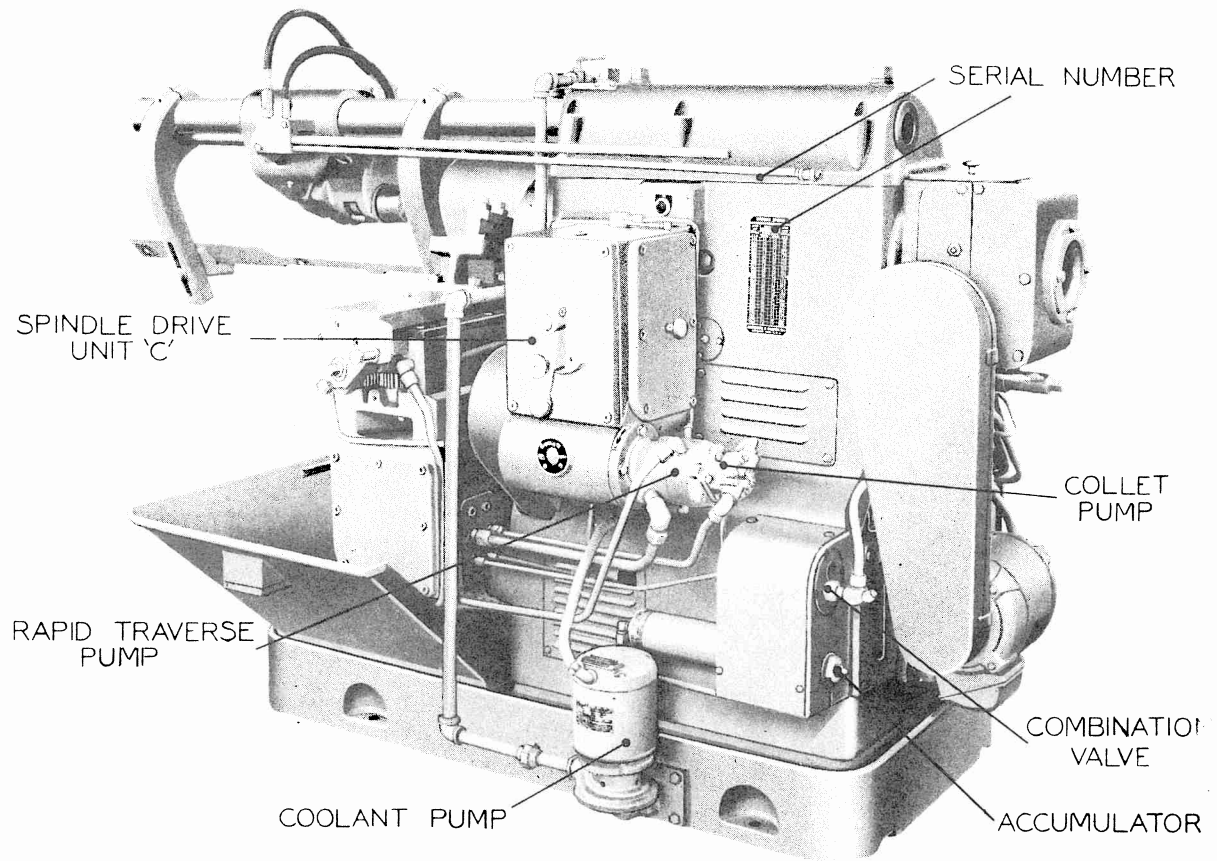
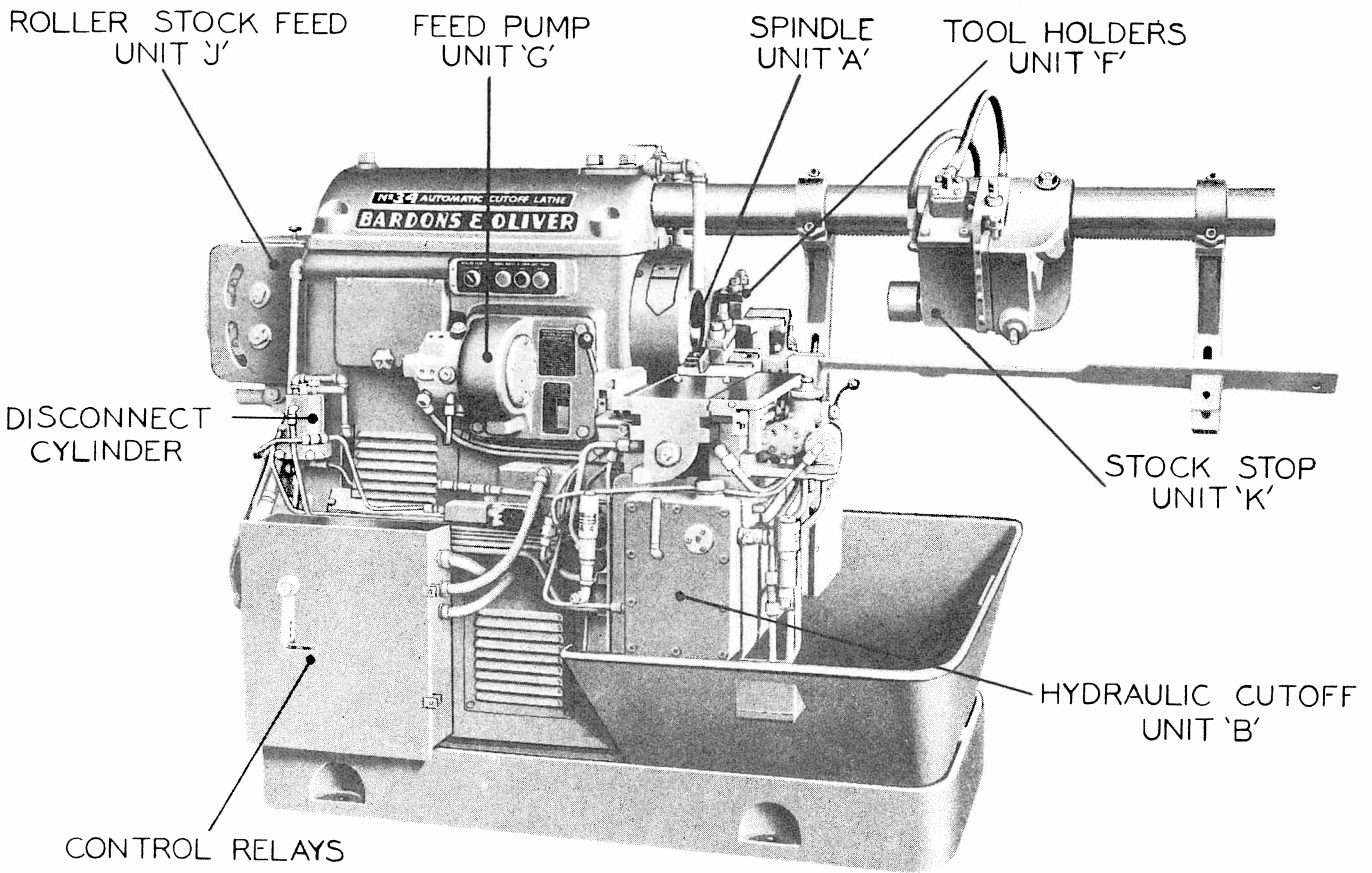
REQUIRED: WEDGE SHOE FOR THE COLLET CHUCK CYLINDER UNIT.

ORDER:

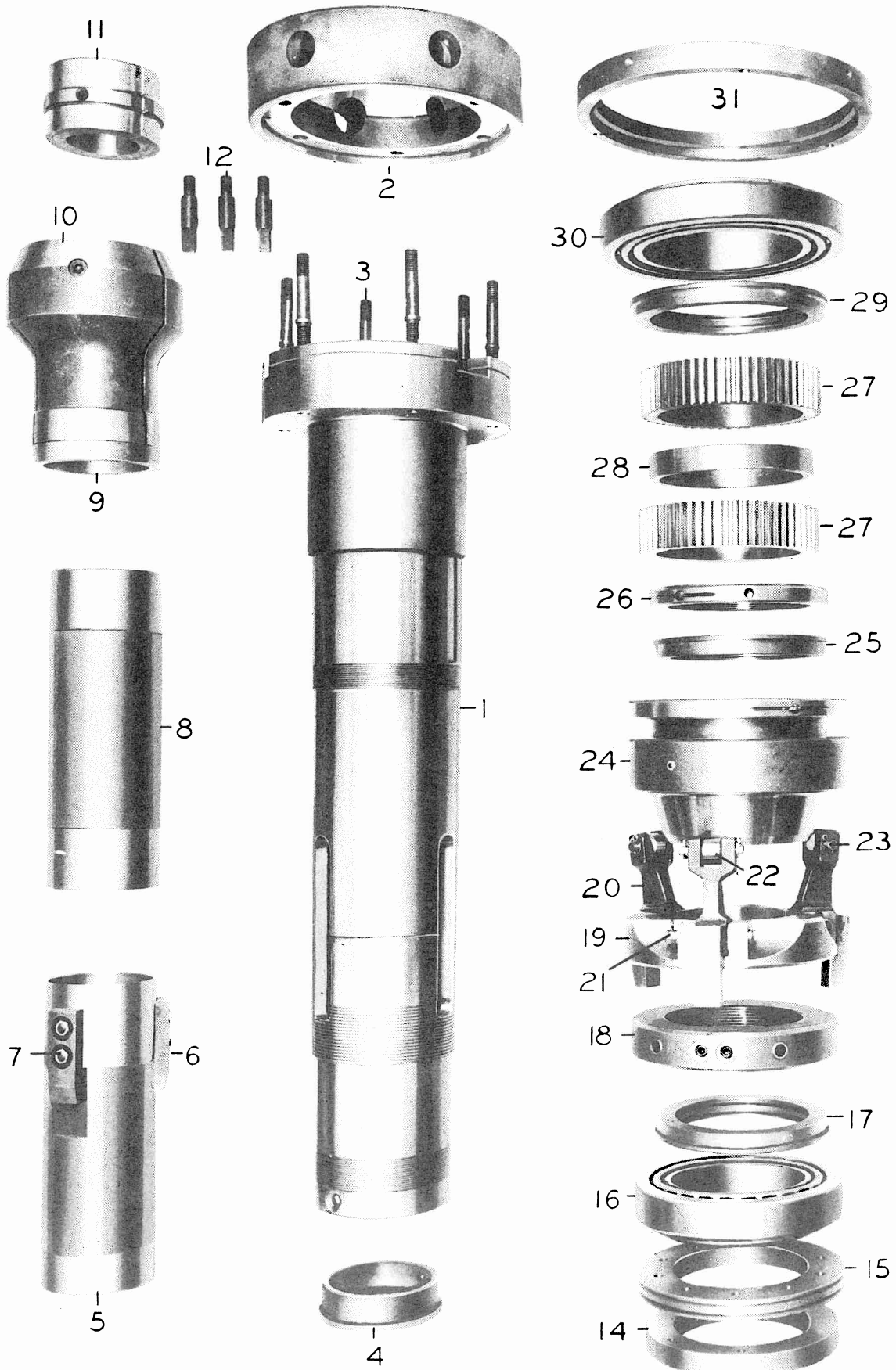
2—D-19 WEDGE SHOE, DRAWING NUMBER B-37092 FOR NO. 33 AUTOMATIC CUTTING-OFF
LATHE SERIAL NO. 18340

*THE SERIAL NUMBER OF THE MACHINE IS STAMPED ON THE SPEED PLATE, ALSO ON THE HOUSING
FLANGE AS SHOWN ON PAGE 1.

NOTE: N.S. MEANS ITEMS NOT SHOWN IN THE PHOTOGRAPH.



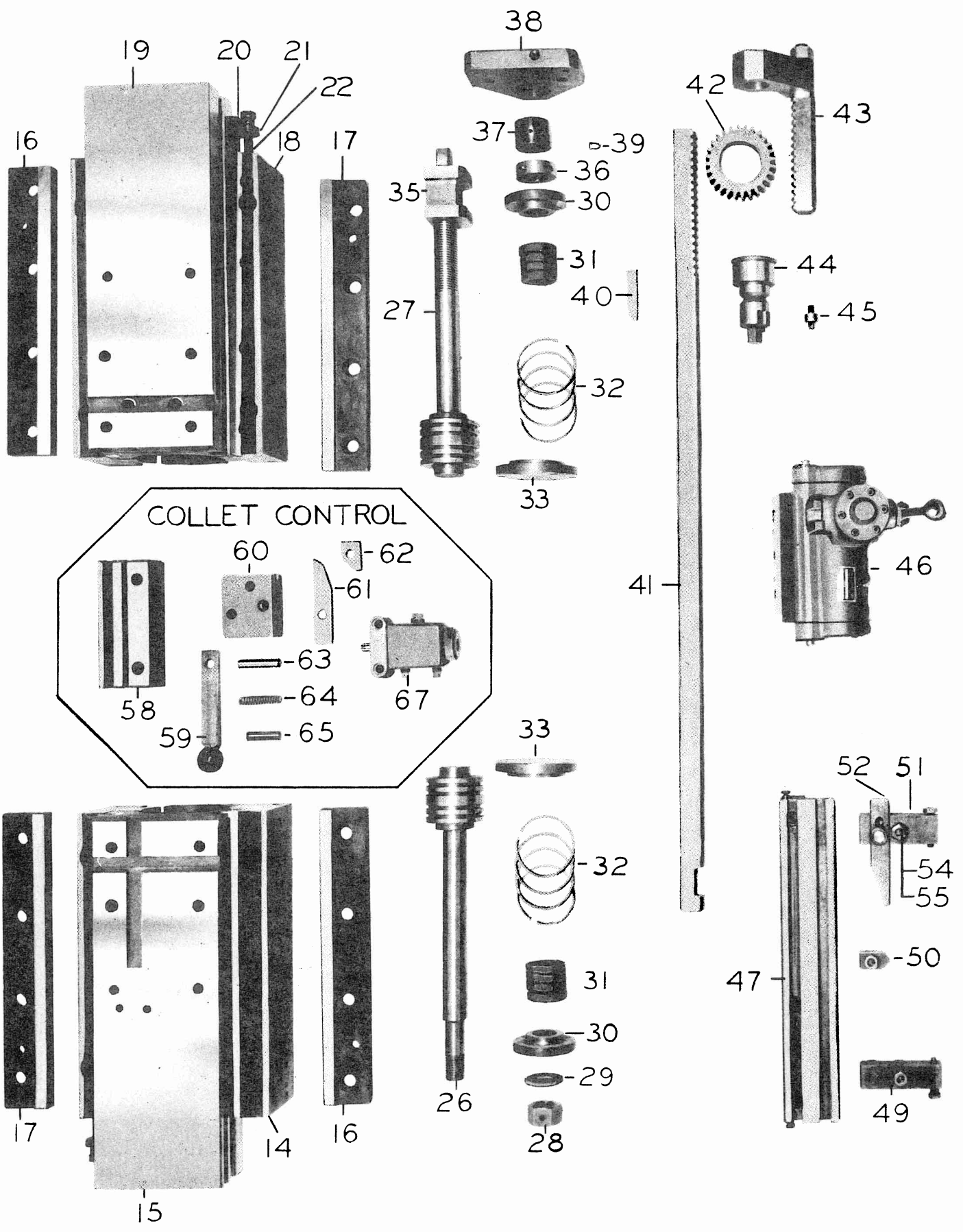
SPINDLE—UNIT 'A'



SPINDLE—UNIT 'A'

		33 ACL	34 ACL	34½ ACL
A-1	Spindle	A-62597	A-62598	A-64889
A-2	Collet Ring	A-28823	A-39478	A-64902
A-3	Collet Ring Stud	(6)B-64645	B-64645	B-64645
A-4	Spindle End Bushing	B-33058	B-39473	B-64921
A-5	Follower & Extension Assembly	A-33001	B-39469	B-64906
A-6	Follower Shoe	(3)A-28829	B-39471	B-64907
A-7	Follower Shoe Screw	(6)C-1962	C-1962	C-1962
A-8	Plunger	B-33000	B-39472	B-64908
A-9	Hinge Ring	A-63017	A-64598	A-64914
A-10	Collet	A-64589	A-64593	A-64901
A-11	Collet Pads	B-50714	B-39923	B-64913
A-12	Collet Pad Screw	(3)C-1240	B-64638	B-64638
A-13	Collet Spring	N.S.(3)B-60090	B-60090	B-60090
A-14	Bearing Adjusting Nut	A-32971	B-39496	B-64887
A-15	Bearing Retaining Ring	B-32973	A-39495	A-64886
A-16	Rear Spindle Bearing	71450	74500	M231610
		71750	74850	M231649
A-17	Oil Retaining Ring	B-64660	B-64646	B-64888
A-18	Adjusting Nut	A-57351	A-57352	A-64900
A-19	Finger Holder	A-28827	A-39494	A-64904
A-20	Finger	(3)A-64167	A-64167	A-64167
A-21	Finger Pivot Pin	(3)B-63245	B-63245	B-63245
A-22	Roller	(3)C-1418	C-1418	C-1418
A-23	Roller Pin	(3)B-57360	B-57360	B-57360
A-24	Wedge Assembly	A-32963	A-39485	A-64903
A-25	Oil Retaining Ring	B-64659	B-39462	B-64883
A-26	Spindle Gear Nut	B-32969	B-39466	B-64891
A-27	Spindle Gear	(2)A-62599	A-62600	A-64890
A-28	Spacer	A-63162	A-63163	A-64895
A-29	Oil Retaining Ring	B-64658	B-39463	B-64884
A-30	Front Spindle Bearing	74537	86650	67820
		74850	86100	67883
A-31	Spindle Guard Ring	B-32972	B-39474	B-64885
A-32	Felt Washer	1 Ea.B-39513	B-39515	A-64894
A-33	Front Spindle Guard	N.S. A-57573	A-39511	A-64893

HYDRAULIC CUTOFF—UNIT 'B'



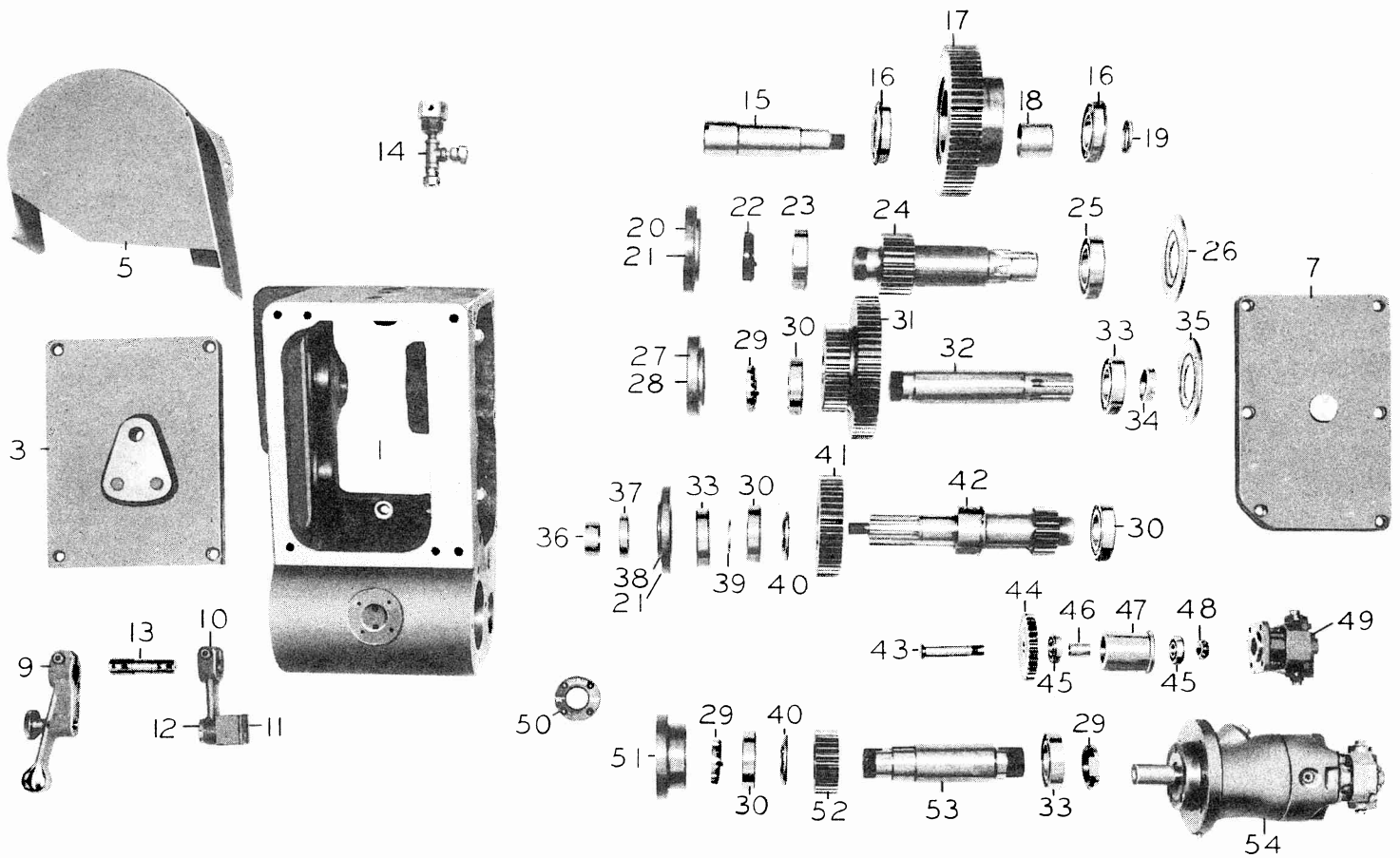
HYDRAULIC CUTOFF—UNIT 'B'

B-1	Knee	N.S.	L-57361	B-30	Packing Gland	B-57220
B-2	R.H. Cover	N.S.	A-65888	B-31	Packing	B-36537
B-3	R.H. Cover Gasket	N.S.	A-59716	B-32	Piston Rings	(8)B-53768
B-4	L.H. Cover	N.S.	A-57229	B-33	Cylinder Head	(2)B-57212
B-5	L.H. Cover Gasket	N.S.	A-59715	B-34	Cylinder Head Gasket	N.S.(2)B-58060
B-6	Front Cover	N.S.	A-57230	B-35	Slide Adj. Nut	B-32989
B-7	Front Cover Gasket	N.S.	A-59738	B-36	Lock Nut	B-52541
B-8	Oil Filler Cap	N.S.	B-36536	B-37	Lock Nut	B-57268
B-9	Cap Gasket	N.S.	B-58943	B-38	Piston Rod Support	A-57232
B-10	Valve Retainer	N.S.	B-57182	B-39	Piston Rod Shoe	B-60094
B-11	Retainer O-Ring	N.S.	1820-15	B-40	Rack Shoe	B-33055
B-12	Needle Valve	N.S.	B-57183	B-41	Equalizing Rack	A-57257
B-13	Valve O-Ring	N.S.(2)	1820-7	B-42	Equalizing Pinion	B-57255
B-14	Front Saddle		L-57191	B-43	Short Rack Assembly	A-61770
B-15	Front Slide		L-57192	B-44	Pinion Stud	B-61455
B-16	Saddle Cap	(2)	A-57210	B-45	Lock Screw	B-33070
B-17	Saddle Cap	(2)	A-57211	B-46	Reversing Valve	
B-18	Rear Saddle		L-57197	B-47	Tee Slot Bracket	A-57454
B-19	Rear Slide		L-57200	B-48	Control Guard	N.S. B-57661
B-20	Taper Gib	(2)	B-57219	B-49	Return Dog	B-36588
B-21	Gib Adj. Nut		C-850	B-50	Feed Dog	B-33096
B-22	Gib Adj. Stud		C-863	B-51	Forward Dog	B-57452
B-23	Saddle Way	N.S.(2)	A-57208	B-52	For. Dog Extension	B-57453
B-24	Saddle Way	N.S.(2)	A-57209	B-53	Return Dog Tee Bolt	N.S. C-2092
B-25	Way Screw	N.S.(20)	B-42367	B-54	For. Dog Tee Bolt	C-2094
B-26	Front Piston Rod		A-66923	B-55	Forward Dog Tee Nut	C-2095
B-27	Rear Piston Rod		A-57920	B-56	Graduated Scale	N.S. B-40416
B-28	Hex Nut		1" -8	B-57	Rack Guard	N.S. A-58033
B-29	Washer		C-1074			

COLLET CONTROL

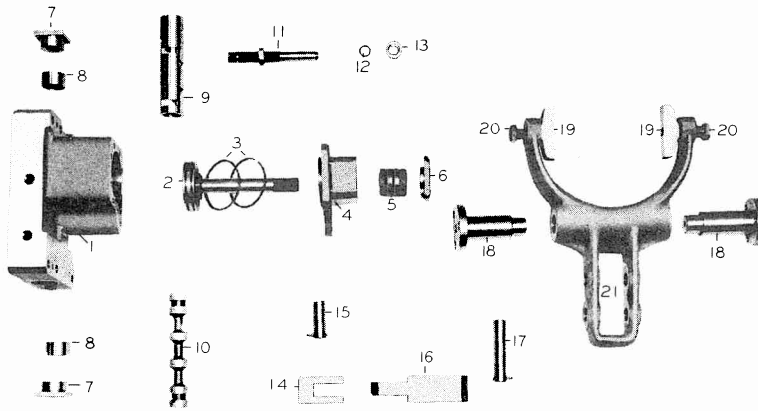
B-58	Tee Slot Bracket	A-59686	B-63	Trip Lever Shaft	B-59664
B-59	Lever	A-59663	B-64	Spring	B-48439
B-60	Lever Block	B-59660	B-65	Pin	B-59665
B-61	Cam Lever	B-59661	B-66	Tee Nut	N.S. B-51004
B-62	Trip Lever	B-59662	B-67	Four Way Valve	

SPINDLE DRIVE—UNIT 'C'



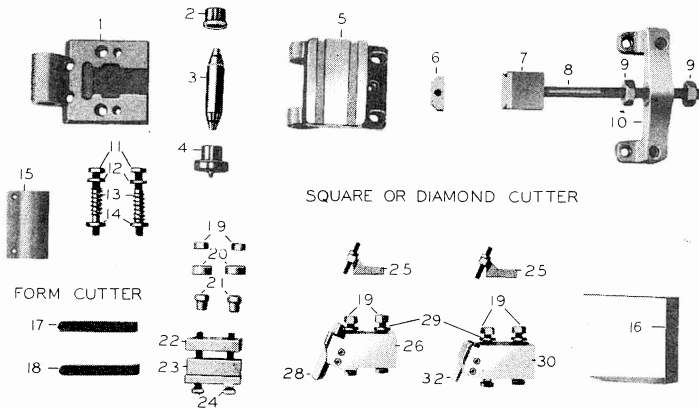
C-1	Bracket		L-62558	C-29	Lockwasher & Nut	
C-2	Bracket Gasket	N.S.	A-62591	C-30	Ball Bearing	(4)209-S
C-3	Front Cover		A-62559	C-31	Two Cluster Gear 37T & 61T	B-68386
C-4	Front Cover Gasket	N.S.	A-62589	C-32	Change Gear Shaft	A-62568
C-5	Belt Guard		A-62587	C-33	Ball Bearing	(3)209-SF
C-6	Belt Guard Gasket	N.S.	A-62588	C-34	Spacer	B-62571
C-7	Change Gear Cover		A-62560	C-35	Closer	B-62569
C-8	Cover Gasket	N.S.	A-62590	C-36	Spacer	B-62576
C-9	Shift Lever		A-50419	C-37	Oil Seal	60782
C-10	Fork Lever		B-50420	C-38	Closer	B-62575
C-11	Fork		B-62594	C-39	Spacer	B-62577
C-12	Fork Collar		B-50456	C-40	Spacer	(2)B-62578
C-13	Fork Lever Stud		B-62595	C-41	Gear 44 T	A-62579
C-14	Lubricating Unit		B-62616	C-42	Drive Pinion Shaft 20 T	A-62573
C-15	Idler Stud		A-62562	C-43	Shaft	B-64788
C-16	Ball Bearing	(2)209-SG		C-44	Gear 29 T	B-64787
C-17	Idler Gear 63 T	A-62561		C-45	Ball Bearing	(2)203-SG
C-18	Spacer	B-62563		C-46	Spacer	B-62586
C-19	Spacer	B-62564		C-47	Lubricating Cartridge	B-62585
C-20	Closer	B-62567		C-48	Lockwasher & Nut	
C-21	Closer Gasket	N.S.(3)B-62592		C-49	Lubricating Pump	
C-22	Lockwasher & Nut		210-S	C-50	Oil Gage Assembly	
C-23	Ball Bearing		A-62565	C-51	Traverse Cartridge	B-62582
C-24	Gear Pinion 26 T		210-SF	C-52	Gear 27 T	B-62583
C-25	Ball Bearing		B-62566	C-53	Traverse Shaft	A-62581
C-26	Closer		B-62570	C-54	Rapid Traverse Pump	
C-27	Closer		B-62570	C-55	Change Gears	To Suit
C-28	Closer Gasket	N.S.	B-62593			

COLLET CHUCK CYLINDER—UNIT 'D'



D-1	Cylinder	L-57145	D-12	O-Ring	1820-12
D-2	Piston Rod	B-57150	D-13	Seal Seat	B-55165
D-3	Piston Rings	(2)	D-14	Connecting Nut	B-50508
D-4	Cylinder Closer	A-57146	D-15	Pin	B-50365
D-5	Piston Rod Packing	B-50335	D-16	Link	B-50507
D-6	Packing Gland	B-57147	D-17	Link Pin	B-33013
D-7	Valve Closer	B-57022	D-18	Yoke Stud	(2) To Suit
D-8	Spacer	B-57021	D-19	Wedge Shoe	(2) B-37092
D-9	Liner	A-57019	D-20	Wedge Shoe Stud	(2) To Suit
D-10	Plunger	B-57020	D-21	Yoke	To Suit
D-11	Stop Screw	B-50332			

RECEDING TOOL HOLDER—UNIT 'E'



E-1	Base Plate	A-66214	E-9	Lock Nut	(2) B-61744
E-2	Pivot Bushing	B-66220	E-10	Rod Support	A-66215
E-3	Pivot	B-66218	E-11	Stud	(2) B-61742
E-4	Pivot Bushing	B-66219	E-12	Washer	(2) C-1071
E-5	Base	A-66213	E-13	Spring	(2) C-1507
E-6	Base Block	B-66096	E-14	Convex Washer	(2) C-1407
E-7	Rest Block	B-66095	E-15	Front Guard	B-66221
E-8	Rod	B-66216	E-16	Rear Guard	A-33732

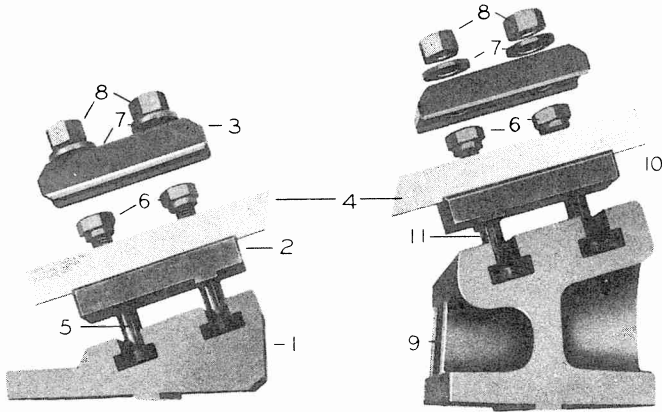
FORM CUTTER

SQUARE OR DIAMOND CUTTER

E-17	Coupling Form Cutter	B-33722	E-25	Backing Screw Block	B-58852
E-18	Nipple Form Cutter	B-33738	E-26	Square Tool Holder	A-58321
E-19	Hex Nut	9/16-12	E-27	Tool Holder Cap	N.S. B-58319
E-20	Clamp Washer	B-33724	E-28	Square Cutter	
E-21	Clamp Nut	B-33724	E-29	Washer	C-1070
E-22	Tool Holder Cap	B-33721	E-30	Diamond Tool Holder	A-57465
E-23	Tool Holder	B-33720	E-31	Tool Holder Cap	N.S. B-57466
E-24	Tee Bolt	(2) B-67026	E-32	Diamond Cutter	B-66404

TOOL HOLDERS—UNIT 'F'

(STD. TUBING TOOL HOLDER - $\frac{1}{4}$ WIDE BLADE)



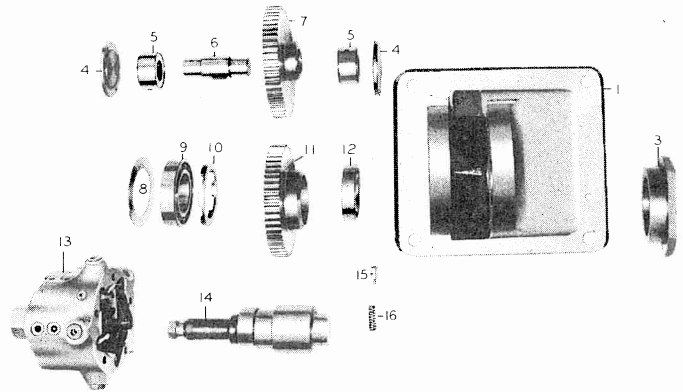
F-1	Front Tool Holder Base	A-67017
F-2	Tool Holder	B-33137
F-3	Tool Holder Cap	B-33138
F-4	Cut-Off Blade	B-28924
F-5	Tee-Bolt	(2)B-66939
F-6	Clamp Nut	(4)B-67110
F-7	Washer	(4)B-66932
F-8	Nut	(4)9/16-12
F-9	Rear Tool Holder Base	A-33113
F-10	Tool Holder	B-33112
F-11	Tee-Bolt	(2)B-67016

When ordering tool holder parts please specify the following:
 1. Bar or Tubing Tool Holder
 2. Width and depth of Cut-off Blade.

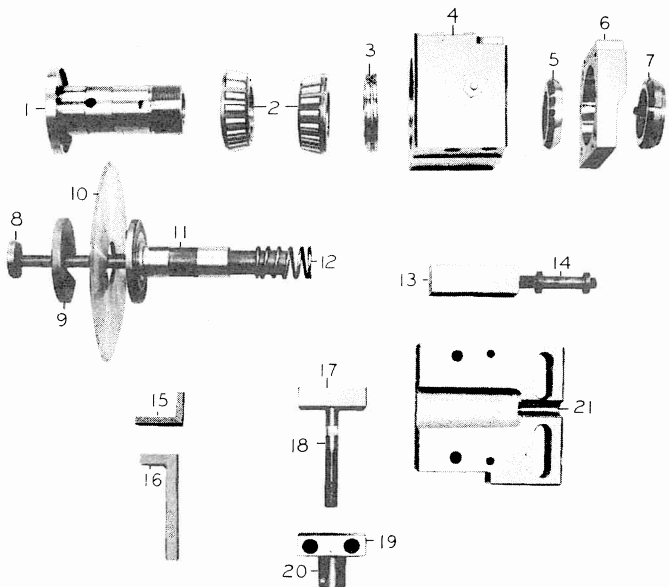
FEED PUMP—UNIT 'G'

33-34 ACL 34 $\frac{1}{2}$ ACL

G-1	Pump Bracket		A-53219	A-64924
G-2	Bracket Gasket	N.S.	B-50849	B-50849
G-3	Pump Cover			
G-4	Bearing Retainer	(2)	B-36545	B-36545
G-5	Roller Bearing	(2)	C-305	C-305
G-6	Gear Shaft		B-36544	B-36544
G-7	Gear		B-33041	B-64926
G-8	Oil Thrower			
G-9	Ball Bearing		212-S	212-S
G-10	Spacer		B-55233	B-55233
G-11	Pump Gear		B-33003	B-64925
G-12	Ball Bearing		210-S	210-S
G-13	Feed Pump			
G-14	Pump Shaft			
G-15	Shaft Detent			
G-16	Detent Spring			
G-17	Strainer	N.S.	B-60093	B-60093

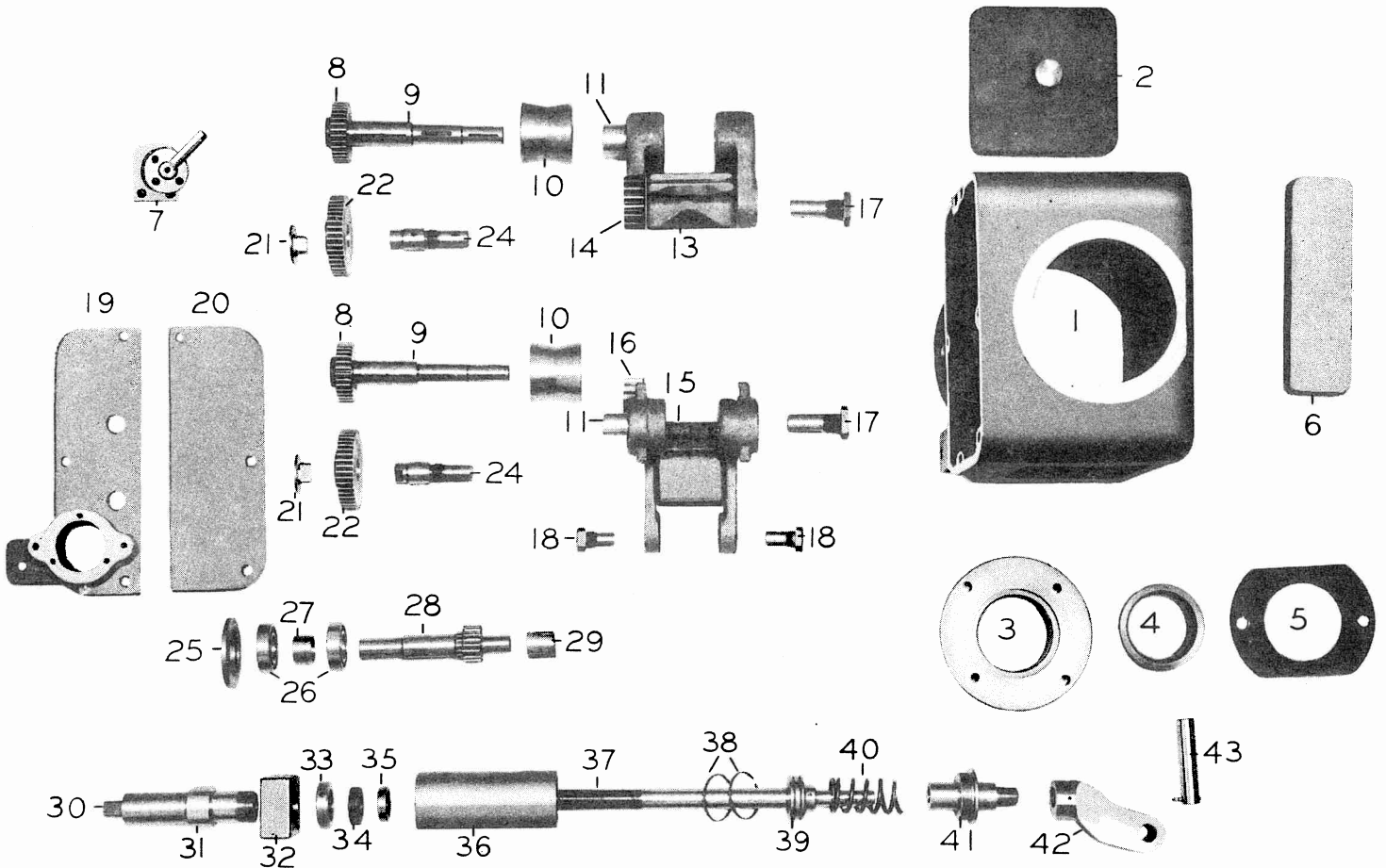


ROLLER CUTTER—UNIT 'H'



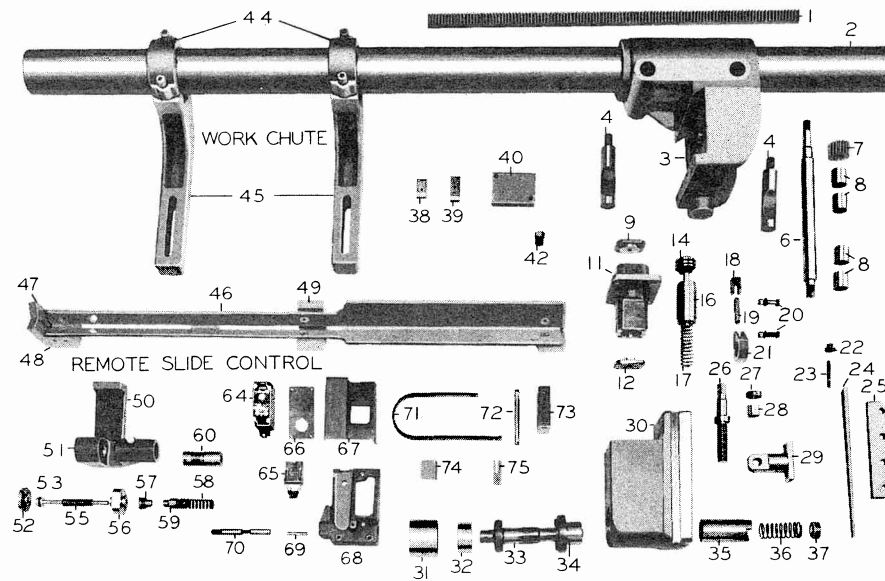
H-1	Bearing Shaft	A-56421
H-2	Roller Bearing	(2) 25521/25584
H-3	Spacer	B-55873
H-4	Bearing Block	A-56004
H-5	Lockwasher & Nut	
H-6	Bearing Closer	A-57337
H-7	Spring Retainer	B-56419
H-8	Bolt	B-56416
H-9	Clamp	B-56420
H-10	Roller Cutter	A-55905
H-11	Cutter Shaft	B-56417
H-12	Spring	B-56426
H-13	Block Guide	B-56002
H-14	Short Adj. Screw	B-56001
H-15	Stripper	B-55904
H-16	Stripper Rest	B-67487
H-17	Adj. Screw Cap	B-55872
H-18	Long Adj. Screw	B-55842
H-19	Adj. Screw Block	B-56003
H-20	Adj. Screw Sleeve	B-55964
H-21	Base Plate	A-56000
H-22	Spring Washer	N.S. B-56418
H-23	Roller Pin	N.S. B-61191

ROLLER STOCK FEED—UNIT 'J'



J-1	Bracket	To Suit	J-25	Closer	B-62666
J-2	Top Cover	A-35861	J-26	Ball Bearing	(2)206-S
J-3	Stock Guide Bushing	To Suit	J-27	Spacer	B-62665
J-4	Spindle End Bushing	To Suit	J-28	Drive Shaft	B-62664
J-5	Retaining Plate	To Suit	J-29	Drive Shaft Bushing	B-36577
J-6	Bracket Cover	A-39641	J-30	Adjusting Extension	B-36709
J-7	Four Way Valve		J-31	Adjusting Sleeve	B-36711
J-8	Gear 33 T	(2)B-33047	J-32	Yoke Adjusting Block	B-50545
J-9	Roller Shaft	(2)B-33050	J-33	Adjusting Sleeve Nut	B-36710
J-10	Roller	(2)B-33057	J-34	Packing Nut	B-36712
J-11	Roller Shaft Bushing	(2)B-53659	J-35	Oil Seal	60250
J-12	Roller Shaft Bushing	N.S.(2)B-53660	J-36	Yoke Cylinder	A-50546
J-13	Upper Yoke	To Suit	J-37	Piston Rod	B-50542
J-14	Upper Yoke Gear Segment	A-61933	J-38	Piston Ring	(2)
J-15	Lower Yoke	To Suit	J-39	Piston	B-53490
J-16	Lower Yoke Gear Segment	A-61932	J-40	Spring	B-36491
J-17	Yoke Bracket Screw	(2)B-36582	J-41	Yoke Cylinder Extension	B-50544
J-18	Adjusting Block Screw	(2)B-36571	J-42	Connecting Link	B-36485
J-19	Drive Bracket	A-62663	J-43	Connecting Pin	B-33013
J-20	Gear Cover	A-56827	J-44	Motor Mounting	N.S. A-62662
J-21	Gear Washer	(2)B-37190	J-45	Vee Belt Guard	N.S. A-62667
J-22	Gear 45 T	(2)B-33046	J-46	Drip Trough	N.S. A-62668
J-23	Gear Bushing	N.S.(2)B-36573	J-47	Rear End Guard	N.S. A-62669
J-24	Yoke Bracket Screw	(2)B-33063			

STOCK STOP—UNIT 'K'



K-1	Rack	To Suit	K-23	Gib Adj. Stud	B-68130
K-2	Stop Bar	To Suit	K-24	Taper Gib	B-57393
K-3	Stock Stop Bracket	A-57388	K-25	Slide Cap	B-57411
K-4	Binder Bolt	(2)B-57412	K-26	Slide Adj. Screw	A-57398
K-5	Binder Bolt Washer	N.S.(2)B-68131	K-27	Adj. Screw Collar	B-57399
K-6	Pinion Shaft	A-57394	K-28	Bushing	D-461
K-7	Pinion	B-57395	K-29	Adjusting Nut	B-57391
K-8	Bushing	(4)B-59124	K-30	Slide	A-57389
K-9	Cylinder Closer	B-57400	K-31	Stop	B-51433
K-10	Closer Gasket	N.S. B-68219	K-32	Ball Bearing	5306-F
K-11	Cylinder	A-61854	K-33	Cam Shaft	A-57406
K-12	Cylinder Closer	B-61853	K-34	Cam	A-57407
K-13	Closer O-Ring	1820-12	K-35	Spring Retainer	B-57408
K-14	Piston	B-62195	K-36	Spring	B-57409
K-15	Piston O-Ring	1866-1	K-37	Cam Shaft Nut	B-57410
K-16	Sleeve	B-61851	K-38	Pipe Clamp	B-65428
K-17	Spring	M-42	K-39	Pipe Clamp	B-58286
K-18	Fork	B-57402	K-40	Pipe Support Block	B-58301
K-19	Link	B-57403	K-41	Pipe Support Rod	N.S. B-63176
K-20	Link Pin	(2)B-57404	K-42	Grease Fitting Screw	B-58303
K-21	Crank Lever	B-57405	K-43	Pinion Shaft Bushing	N.S. B-68129
K-22	Gib Adj. Nut	C-849			

WORK CHUTE

K-44	Cap	(2)B-37058	K-47	Rest	B-67982
K-45	Arm	(2)A-57581	K-48	End Vee Block	B-67981
K-46	Chute	A-54759	K-49	Vee Block	(2)B-51645

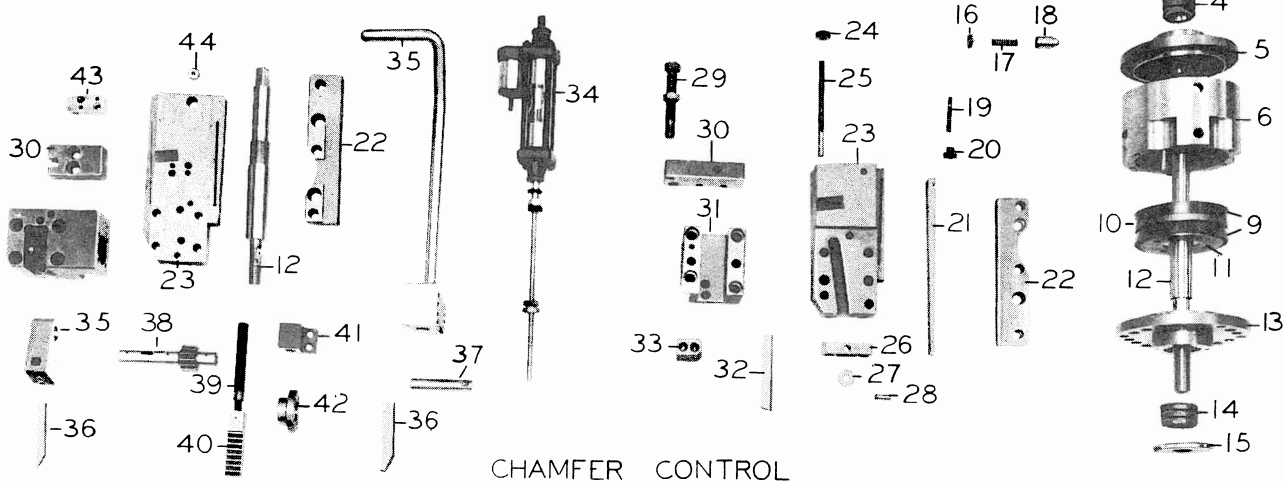
REMOTE SLIDE CONTROL

K-50	Bracket	A-59397	K-63	Solenoid Valve	N.S.
K-51	Cylinder Block	A-59405	K-64	Limit Switch	
K-52	Closer	B-59410	K-65	Selector Switch	
K-53	Piston	B-59404	K-66	Switch Plate	B-57709
K-54	Piston O-Ring	1820-15	K-67	Bracket Cover	A-57704
K-55	Spring	B-40727	K-68	Switch Bracket	A-66839
K-56	Closer	B-59398	K-69	Spring	B-43659
K-57	Guide	B-59403	K-70	Plunger	B-64789
K-58	Spring	B-50339	K-71	Lever	A-64791
K-59	Pusher	B-59402	K-72	Lever Pin	B-64792
K-60	Sleeve	B-57382	K-73	Bracket	B-64793
K-61	Lever	N.S. B-57386	K-74	Block	B-64790
K-62	Valve Bracket	N.S. A-56228	K-75	Stop	B-64944

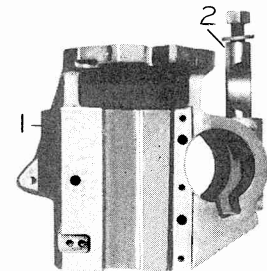
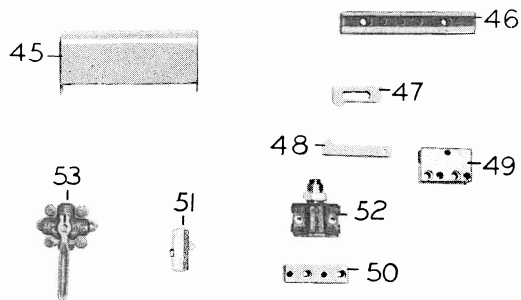
CHAMFER ATTACHMENT—UNIT 'L'

AUTOMATIC
INSIDE

HAND
INSIDE



CHAMFER CONTROL



		HAND INSIDE	AUTO. INSIDE			HAND INSIDE	AUTO. INSIDE
L-1	Bracket	A-58964	A-62635	L-23	Slide	A-58965	A-62636
L-2	Binder Bolt	B-50292	B-50292	L-24	Tool Adj. Nut	B-58957	
L-3	Upper Pack. Gland	B-57952	B-57952	L-25	Tool Adj. Screw	B-58884	
L-4	Upper Packing			L-26	Roller Bracket	B-62176	
L-5	Cylinder Cap	A-57891	A-57891	L-27	Roller	B-62175	B-62175
L-6	Cylinder	A-57890	A-57890	L-28	Roller Pin		
L-7	Cylinder Gasket	N.S.(2)B-58893	B-58893	L-29	Slide Adj. Screw	B-58952	
L-8	Piston Plate	N.S. B-33010	B-33010	L-30	Feed Stop	B-58950	B-62646
L-9	Packing	(2)76725	76725	L-31	Slide Block	A-58960	A-62637
L-10	Packing Plate	B-33011	B-33011	L-32	O.D. Chamfer Tool	B-58954	B-58954
L-11	Piston	B-59667	B-59667	L-33	Screw Stop	B-58958	
L-12	Piston Rod	A-58961	A-62638	L-34	Hydr. Feed Control		
L-13	Cylinder Head	A-57863	A-57863	L-35	I.D. Tool Holder	A-58963	B-62647
L-14	Lower Packing			L-36	I.D. Chamfer Tool	B-58953	B-59602
L-15	Packing Gland	B-57856	B-57856	L-37	Pivot Pin	B-58959	
L-16	Detent Screw	B-34175		L-38	Pinion		B-62640
L-17	Spring	B-49839		L-39	Rack Screw		B-62642
L-18	Detent	B-55194		L-40	Rack		B-62641
L-19	Gib Adj. Stud	C-860	C-860	L-41	Rack Adj. Block		B-62643
L-20	Gib Adj. Nut	C-847	C-847	L-42	Closer		B-62644
L-21	Taper Gib	B-58956	B-58956	L-43	Cutter Adj. Block		B-62645
L-22	Slide Cap	B-58955	A-62639	L-44	Piston Rod Lock		B-62648

CHAMFER CONTROL

L-45	Control Guard	A-58917		L-50	Valve Mounting	B-59765	
L-46	Bracket	A-58916		L-51	Flow Control Valve		
L-47	Dog	B-58890		L-52	Auto. Control Valve		
L-48	Cam	B-58915		L-53	Hand Control Valve		
L-49	Cam Bracket	B-58888					

