

VERTICAL SHAFT ASSEMBLY

PARTS LIST

| ITEM NUMBER | QUANTITY | PART NUMBER | DESCRIPTION |
|----------------|----------|----------------|---------------------------------------|
| 1 | 1 | 20400300 | Body (Ref.) |
| 2 | 1 | 09424 | Groove Pin (5/32 X 1") |
| 3 | 1 | 20400019 | Upper Collar |
| 4 | 1 | 06254 | Oiler |
| 5 | 1 | 08447 | Handwheel Handle |
| 6 | 1 | 20407314 | Vertical Shaft Assembly |
| 7 | 1 | 20400075 | Vertical Shaft Handwheel |
| 8 | 1 | 20400018 | Handwheel Spring |
| 9 | 1 | 20408010 | Gear |
| 10 | 1 | 20400076 | Vertical Shaft Handwheel Hub Assy. |
| 11 | 1 | 20400019 | Lower Collar |
| 12 | 1 | 09424 | Groove Pin (5/32 X 1") |
| 13 | 1 | 20400014 | Shaft Gear |
| 14 | 1 | 07180 | Pilot Key |
| 15 | 1 | 20408011 | Shaft |
| 16 | 1 | 23550 | Adjusting Screw |
| 17 | 1 | 20400016 | Ball Bearing Housing |
| 18 | 1 | 24348 | O-Ring (.125 X 1.625) |
| 19 | 1 | 07884 | Hex Nut (1/2 -20) |
| 20 | 1 | 24351 | Ball Bearing |
| 21 | 1 | 24352 | Retaining Ring |
| 22 | 1 | 09424 | Groove Pin (5/32 X 1") |
| 23 | 1 | 20400015 | Vertical Shaft Helical Gear |
| 24 | 1 | 16074 | Retaining Ring |
| 25 | 1 | 20408012 | Feed Clutch Hub Assy. |
| 26 | 1 | 20400020 | Vertical Shaft Clutch |
| 27 | 1 | 17510 | Spiral Pin (.078 X .625) |
| 28 | 1 | 24394 | Compression Spring |
| 29 | 1 | 20400040 | Hub Detent |
| 30 | 1 | 20400022 | Clutch Lever |
| 31 | 1 | 24353 | Lever Ball 3/4" Diameter |
| 32 | 1 | 20400021 | Feed Clutch Hub Assy. (upper) |
| 33 | 1 | 09978 | Dowel Pin 3/8" x 2 |
| 34 | 1 | 24025 | Set Screw (3/8-24 x 1/2") |
| 35 | 1 | 24354 | Button Socket Head Screw 3/8"-24 x 1" |
| 36 | 1 | 16747 | Dowel Pin (1/4 x 1-1/4) |
| 37 | 1 | 16625 | Oiler 7/16" Drive |

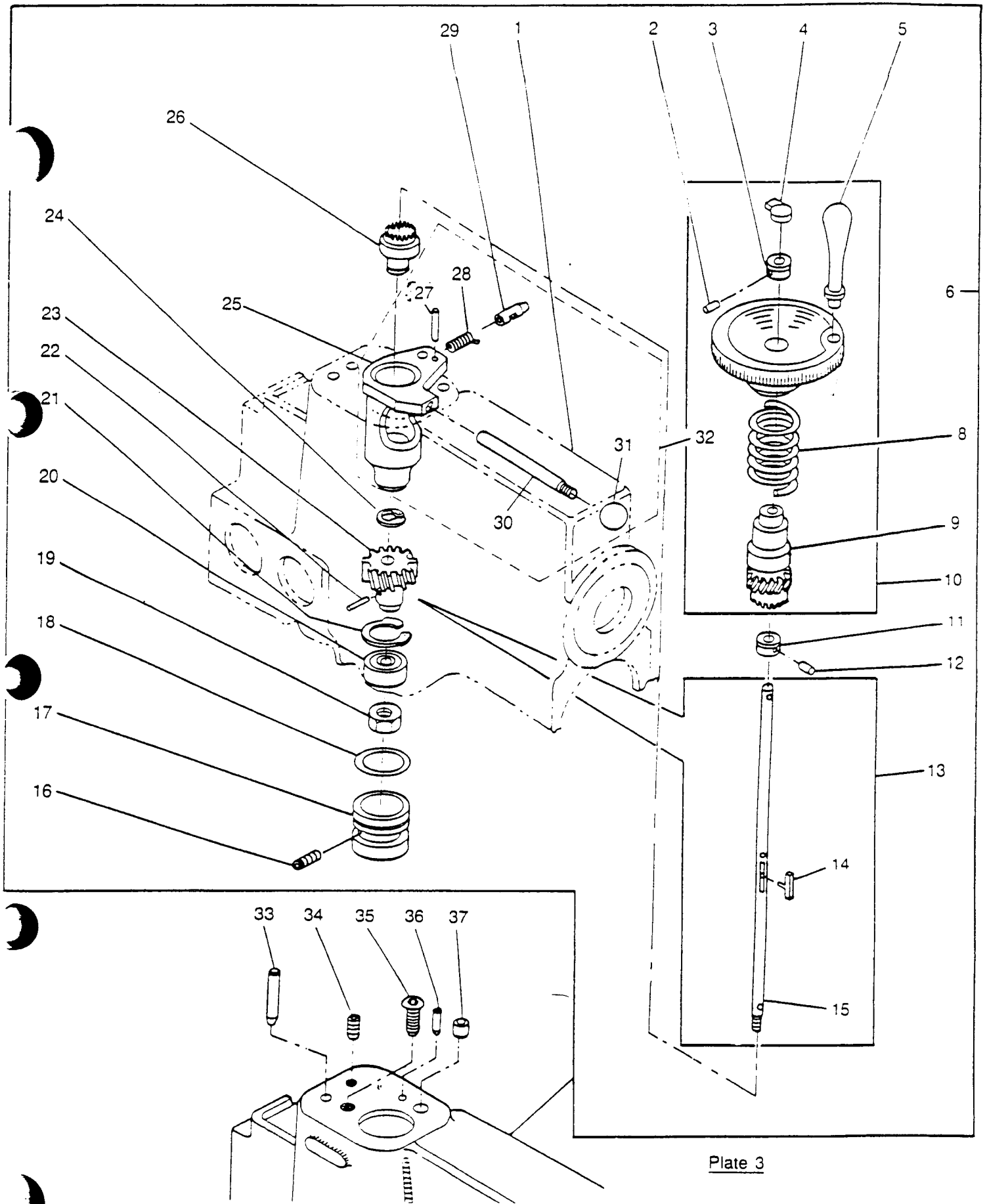


Plate 3

BASIC MACHINE - ALL MODELS

PARTS LIST

| ITEM NUMBER | QUANTITY | PART NUMBER | DESCRIPTION |
|-------------|----------|-------------|---------------------------------------|
| 1 | | 20400300 | Body (Ref.) |
| 2 | 1 | 18428 | Breather |
| 3 | 1 | 14363 | Spindle Bearing (1984 & On) |
| | | 30200006 | Bearing (Prior to 1984)(Not Shown) |
| 4 | 1 | 41569 | Front Bearing Oil Seal |
| 5 | 1 | 30400065 | Work Light Window |
| 6 | 4 | 05021 | Screw (10-32 x 3/8) |
| 7 | 4 | 14160 | Washer (#10) |
| 8 | 1 | 16897 | Spindle Key |
| 9 | 1 | 20400003 | Spindle |
| 10 | 1 | 20400038 | Serial No. Plate |
| 11 | 4 | 05353 | Screw (1/4 x 2 type U) |
| 12 | 1 | 20400013 | Output Shaft Spiral Gear |
| 13 | 1 | 20408018 | Shaft |
| 14 | 1 | 20400012 | Output Shaft Assembly |
| 15 | 2 | 20400097 | Plastic Shim |
| 16 | 2 | 20400010 | Paper Shim |
| 17 | 1 | 20400039 | Cap |
| 18 | 2 | 07711 | Seal |
| 19 | 1 | 20400120 | Pulley for Belt |
| 20 | 4 | 08004 | Hex Head Cap Screw .25-20 x .625 |
| 21 | 4 | 18100 | Internal Lockwasher (1/4") |
| 22 | 4 | 05577 | Washer SAE 1/4" |
| 23 | 2 | 05144 | Hex Head Screw (5/16-18 x 3/4) |
| 24 | 2 | 05888 | Lockwasher (5/16) |
| 25 | 2 | 05489 | Washer (.312 flat SAE) |
| 26 | 1 | 20400821 | Zero Max Support Bracket |
| 27 | 1 | 26790 | Handle with Screws |
| 28 | 1 | 20400094 | Decal |
| 29 | 1 | 20407317 | Zero Max Assembly |
| 30 | 1 | 20400093 | Decal |
| 31 | 4 | 05624 | Screw comes with 24349 - 20400120 |
| 32 | 2 | 25206 | Disc Coupling |
| 33 | 1 | 24349 | Coupling |
| 34 | 2 | 19910 | Button Socket Head Screw(1/4-20x.375) |
| 35 | 1 | 20400061 | Zero Max Coupling Guard |
| 36 | 6 | 05144 | Hex Head Cap Screw (5/16-18 x 3/4) |
| 37 | 6 | 05489 | Washer (.312 flat SAE) |
| 38 | 1 | 20400009 | Worm Bearing Cap |
| 39 | 1 | 05021 | Screw (10-31 x 3/8) |
| 40 | 1 | 20400163 | Pointer |
| 41 | 1 | 24347 | Roller Bearing |
| 42 | 1 | 11558 | Groove Pin (3/16 x 1-1/4") |
| 43 | 1 | 23550 | Adjusting Screw (Ref.)(1/2-20 x 1) |

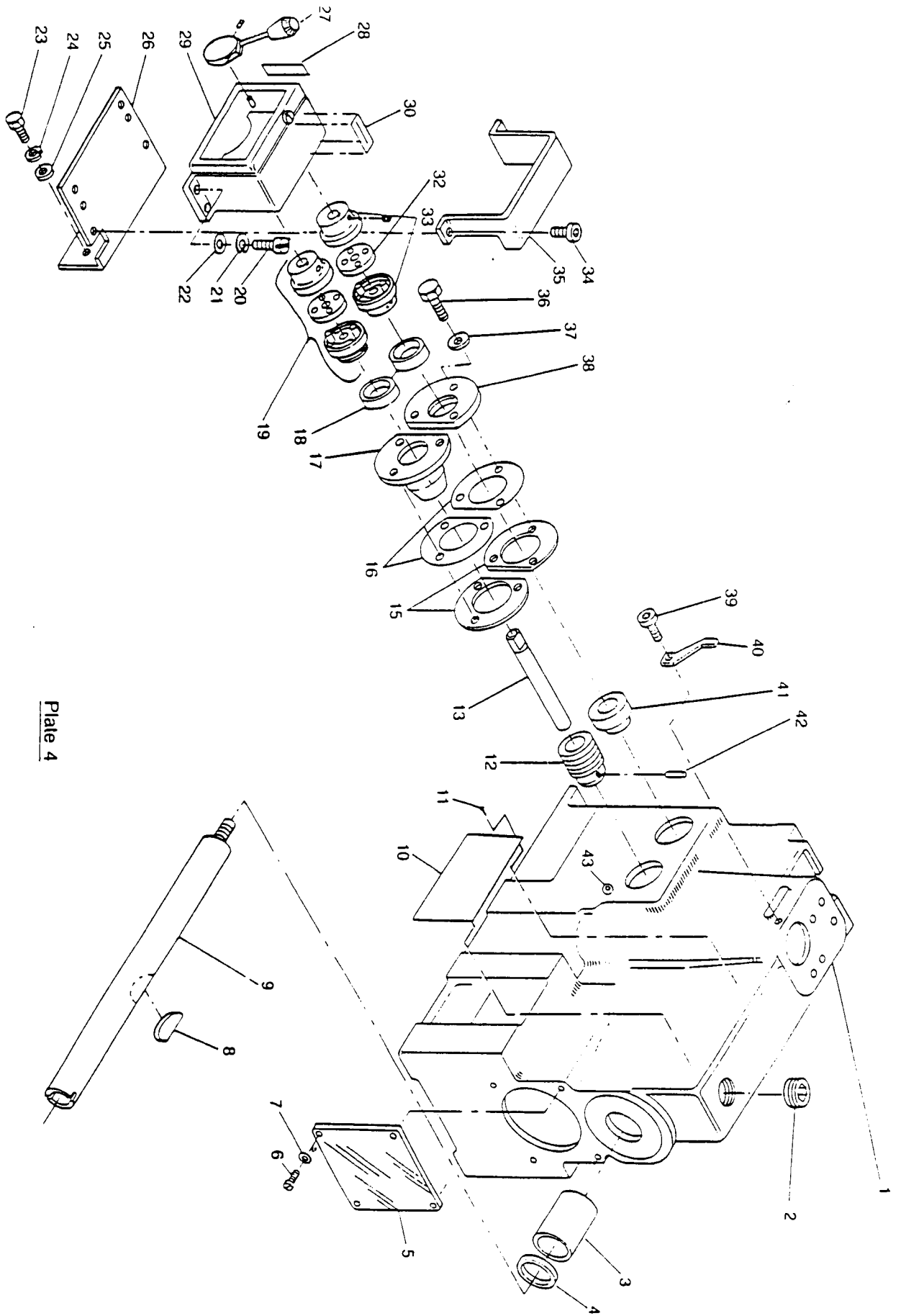
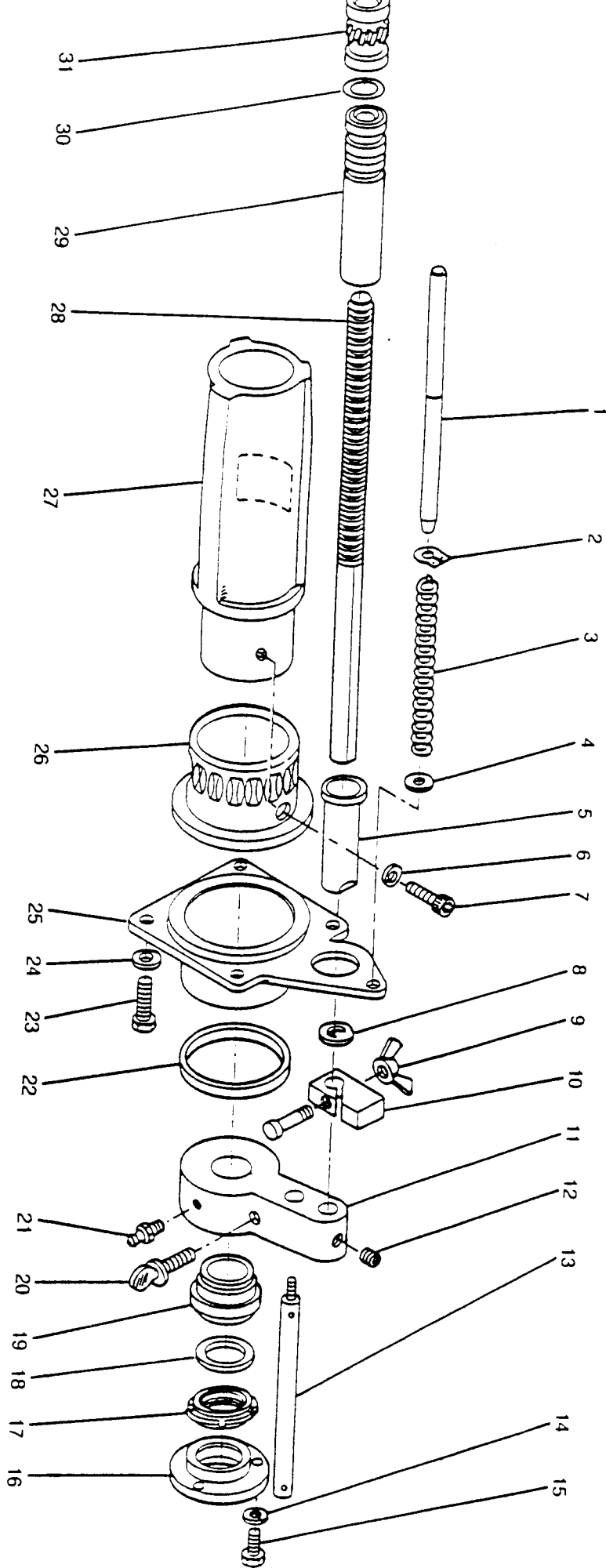


Plate 4

SPINDLE CLAMP ASSEMBLY

PARTS LIST

| ITEM NUMBER | QUANTITY | PART NUMBER | DESCRIPTION |
|----------------|----------|----------------|-------------------------------------|
| 1 | 1 | 20400026 | Push Rod |
| 2 | 1 | 18712 | Retaining Ring |
| 3 | 1 | 24355 | Compression Spring |
| 4 | 1 | 05287 | Washer SAE 3/8" |
| 5 | 1 | 20400063 | Sleeve |
| 6 | 3 | 05888 | Lockwasher (5/16) |
| 7 | 3 | 08480 | Socket Head Cap Screw |
| 8 | 1 | 24755 | Retaining Ring |
| 9 | 1 | 06122 | Wing Nut (5/16-18) |
| 10 | 1 | 20408019 | Release Dog Assembly |
| 11 | 1 | 20400297 | Bearing Housing |
| 12 | 1 | 05256 | Cup Point Socket Screw (3/8-16x1/2) |
| 13 | 1 | 20400151 | Shaft |
| 14 | 3 | 05577 | Lockwasher (.250 flat SAE) |
| 15 | 3 | 06691 | Hex Head Cap Screw (1/4-20 x 1) |
| 16 | 1 | 20400298 | Cover |
| 17 | 1 | 09733 | Bearing Locknut |
| 18 | 1 | 40572 | Thrust Washer |
| 19 | 1 | 24345 | Roller Bearing |
| 20 | 1 | 40851 | Thumb Screw (3/8-16 x 3/4) |
| 21 | 1 | 07334 | Grease Fitting |
| 22 | 1 | 41569 | Oil Seal |
| 23 | 4 | 05144 | Hex Head Cap Screw |
| 24 | 4 | 05489 | Washer (SAE 5/16") |
| 25 | 1 | 20400072 | Rear Bearing |
| 26 | 1 | 20400070 | Spindle Worm Gear |
| 27 | 1 | 20400069 | Work Spindle Sleeve |
| 28 | 1 | 20400023 | Feed Screw |
| 29 | 1 | 20400062 | Guard |
| 30 | 1 | 16207 | O-Ring |
| 31 | 1 | 20400024 | Feed Screw Nut & Gear |



RIGHT REAR OF MACHINE

PARTS LIST

| ITEM NUMBER | QUANTITY | PART NUMBER | DESCRIPTION |
|-------------|----------|-------------|--------------------------------------|
| 1 | 35" | 413535 | 110 Volt Motor Cord |
| | | 413526 | 220 Volt Motor Cord |
| 2 | 1 | 413594 | Cord Bushing |
| 3 | 1 | 413592 | Bushing |
| 4 | 6 ft. | 413525 | Motor Cord |
| 5 | 4 | 05489 | Washer (SAE 5/16") |
| 6 | 4 | 05888 | Lockwasher (5/16") |
| 7 | 4 | 05144 | Hex Head Cap Screw (5/16-18 x 3/4) |
| 8 | 1 | 40524 | Motor |
| 9 | 1 | | Set Screw (Comes with Item 10) |
| 10 | 1 | 24397 | 3-Step Pulley |
| 11 | 1 | 11200505 | Key |
| 12 | 1 | 08246 | Belt |
| 13 | 1 | 05489 | Washer (SAE 5/16") |
| 14 | 1 | 40956 | Thumb Screw (5/16-18 x 1/2) |
| 15 | 1 | 20400324 | Motor Belt Guard |
| 16 | 1 | 40956 | Thumb Screw (5/16-18 x 1/2) |
| 17 | 1 | 20400037 | Pin |
| 18 | 1 | 06977 | Flat Point SocketSetScrew(5/16-18x1) |
| 19 | 1 | 05268 | Washer (1/2" flat SAE) |
| 20 | 1 | 20400036 | Motor Bracket |
| 21 | 1 | 05268 | Washer (1/2" flat SAE) |
| 22 | 1 | 08369 | Screw (1/2-13 x 1-1/4) |
| 23 | 3 | 05489 | Washer (5/16" SAE) |
| 24 | 3 | 05144 | Hex Head Cap Screw (5/16" SAE) |
| 25 | 1 | | Set Screw (Comes with Item 27) |
| 26 | 1 | 11200505 | Key |
| 27 | 1 | 40634 | Pulley |
| 28 | 1 | 07711 | Seal |
| 29 | 1 | 20400009 | Worm Bearing Cap |
| 30 | 1 | 20400010 | Shim |
| 31 | 1 | 24347 | Roller Bearing |
| 32 | 1 | 20400071 | Shaft |

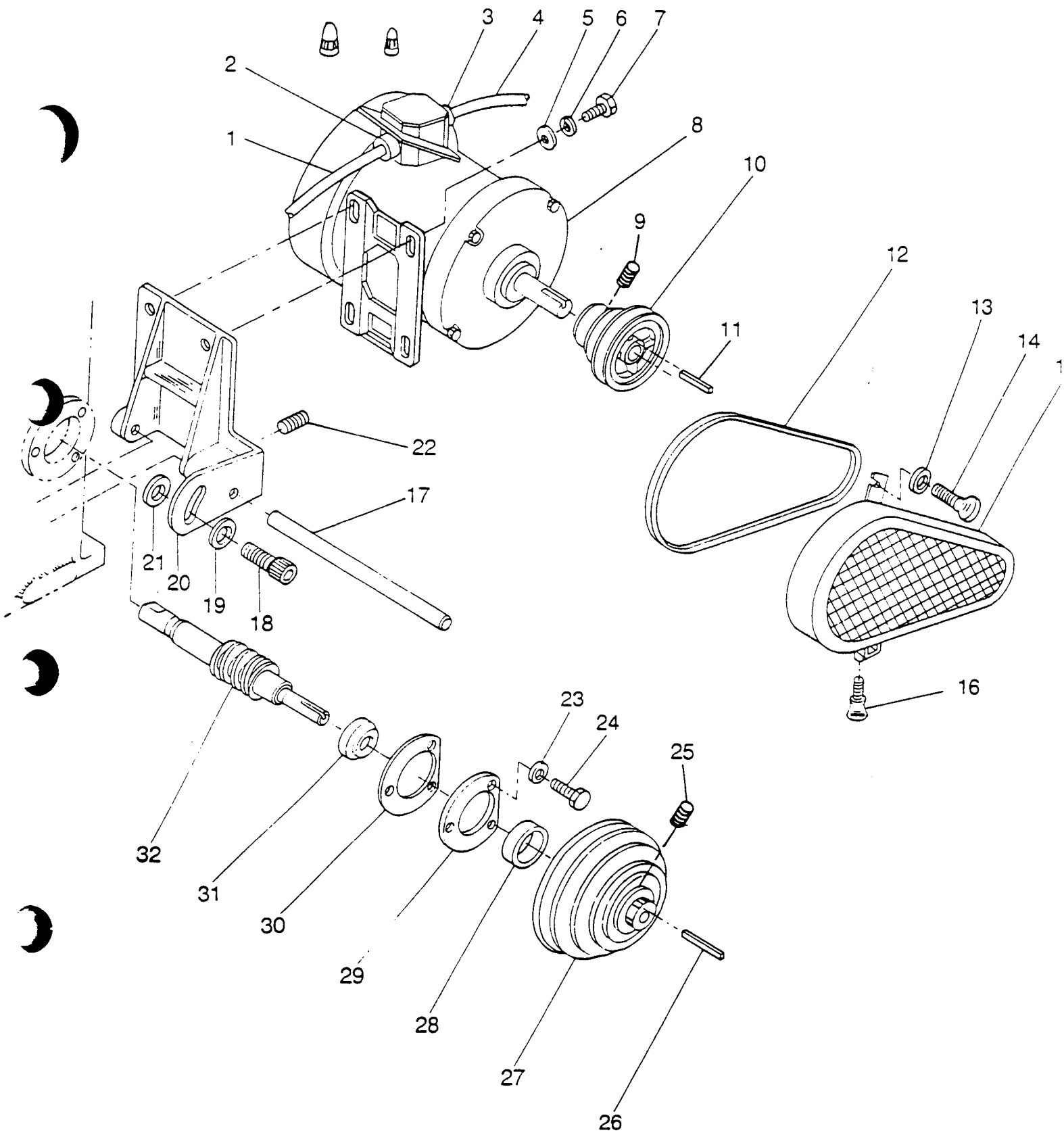


Plate 6

POWER FEED ATTACHMENT FOR FACING DISC BRAKES

PARTS LIST

| ITEM NUMBER | QUANTITY | PART NUMBER | DESCRIPTION |
|-------------|----------|-------------|--|
| 1 | 1 | 20400142 | Gib |
| 2 | 2 | 24357 | Set Screw (3/8-16 x 1-3/4) |
| 3 | 1 | 40531 | Knob |
| 4 | 1 | 11100633 | Screw Plug |
| 5 | 2 | 05208 | Jam Nut |
| 6 | 2 | 06905 | Screw (3/8-16 x 1-1/2) |
| 7 | 1 | 20400118 | Power Facing Feed Slide |
| 8 | 1 | 08158 | Socket Head Cap Screw (3/8-16 x 3/4) |
| 9 | 2 | 05508 | Socket Head Cap Screw (5/16-18 x 1) |
| 10 | 1 | 20400162 | Belt Idler |
| 11 | 1 | 08711 | Bushing |
| 12 | 1 | 20400165 | Idler Bracket |
| 13 | 1 | 25836 | Bushing |
| 14 | 1 | 20400126 | Pulley |
| 15 | 1 | 09697 | Cup Point Socket Screw (10-32 x 1/2) |
| 16 | 1 | 40583 | Belt |
| 17 | 1 | 14597 | Drain Plug |
| 18 | 4 | 10027 | Socket Head Cap Screw |
| 19 | 1 | 20400117 | Power Facing Feed Knee |
| 20 | 1 | 20400122 | Slide Feed Screw Nut |
| 21 | 1 | 20400130 | Collar |
| 22 | 1 | 11139 | Bushing |
| 23 | 1 | 20400131 | Plate Assembly |
| 24 | 1 | 20408022 | Plate |
| 25 | 4 | 08158 | Socket Head Cap Screw (3/8-16 x 3/4) |
| 26 | 1 | 20400123 | Feed Screw Assembly |
| 27 | 1 | 20408021 | Shaft |
| 28 | 1 | 09925 | Pin (1/4 x 2) |
| 29 | 1 | 05134 | Woodruff Key (#7) |
| 30 | 1 | 20400132 | Collar |
| 31 | 1 | 20400166 | Pulley |
| 32 | 1 | 25052 | Belt |
| 33 | 1 | 20400167 | Pulley Guard |
| 34 | 1 | 19343 | Screw (10-32 x 3/8) |
| 35 | 1 | 20400144 | Stop Nut |
| 36 | 1 | 20400159 | Power Feed Screw Drive Nut |
| 37 | 1 | 20400136 | Crank (add 08447V) |
| 38 | 4 | 19343 | Button Socket Head Screw (10-32 x 3/8) |
| 39 | 1 | 20400129 | Pulley |
| 40 | 1 | 11539 | Cup Point Socket Screw (10-32 x 1/4) |
| 41 | 1 | 05133 | Woodruff Key (#3) |
| 42 | 1 | 20400128 | Drive Shaft |
| 43 | 1 | 05133 | Woodruff Key (#3) |
| 44 | 1 | 25836 | Bushing |
| 45 | 1 | 20400246 | Idler Arm |
| 46 | 1 | 05287 | Washer (.375 flat SAE) |
| 47 | 1 | 08711 | Bushing |
| 48 | 1 | 07283 | Socket Head Cap Screw (3/8-16 x 1) |
| 49 | 1 | 20400162 | Belt Idler |
| 50 | 1 | 05287 | Washer (.375) |
| 51 | 1 | 07283 | Socket Head Cap Screw (3/8-16 x 1) |

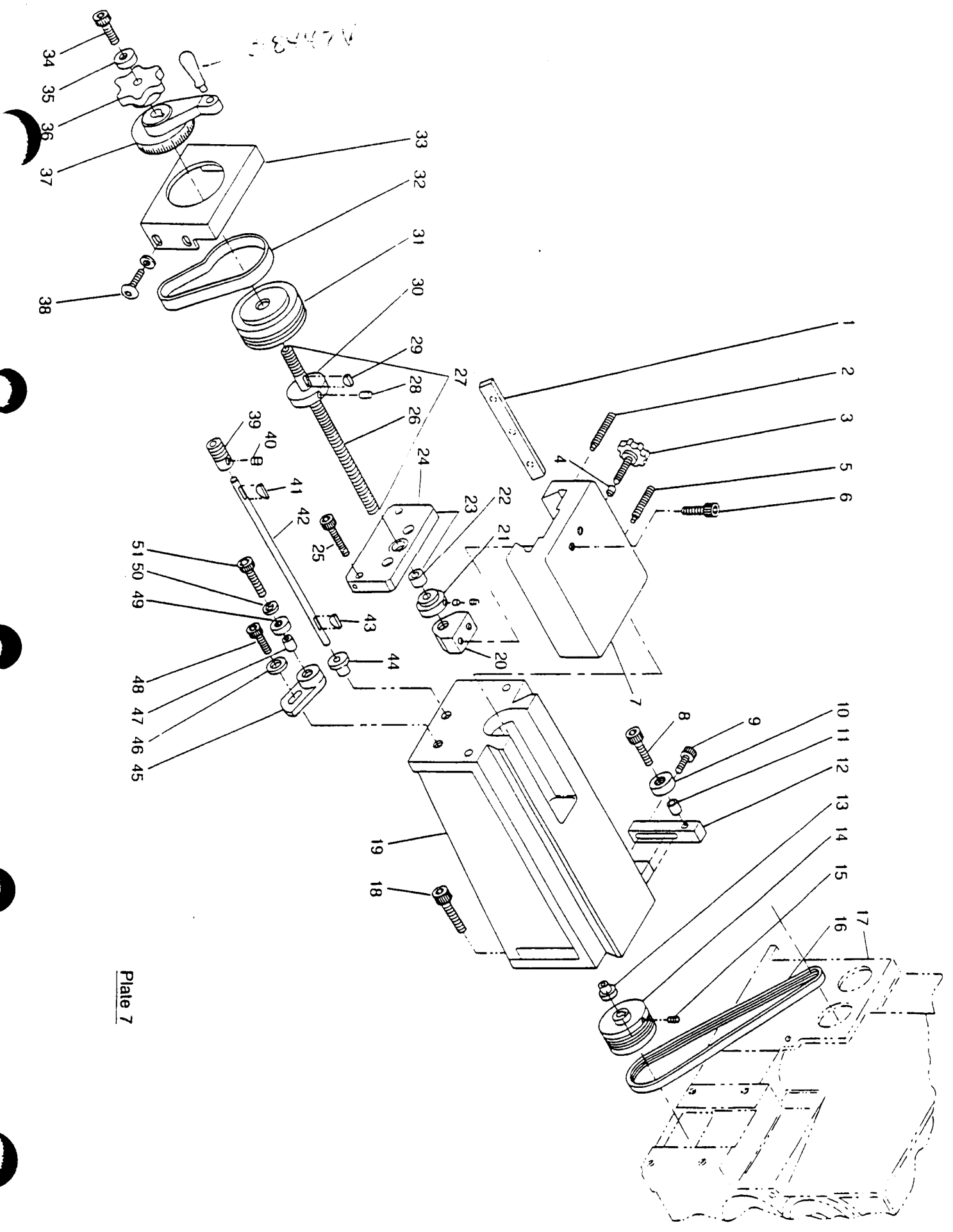
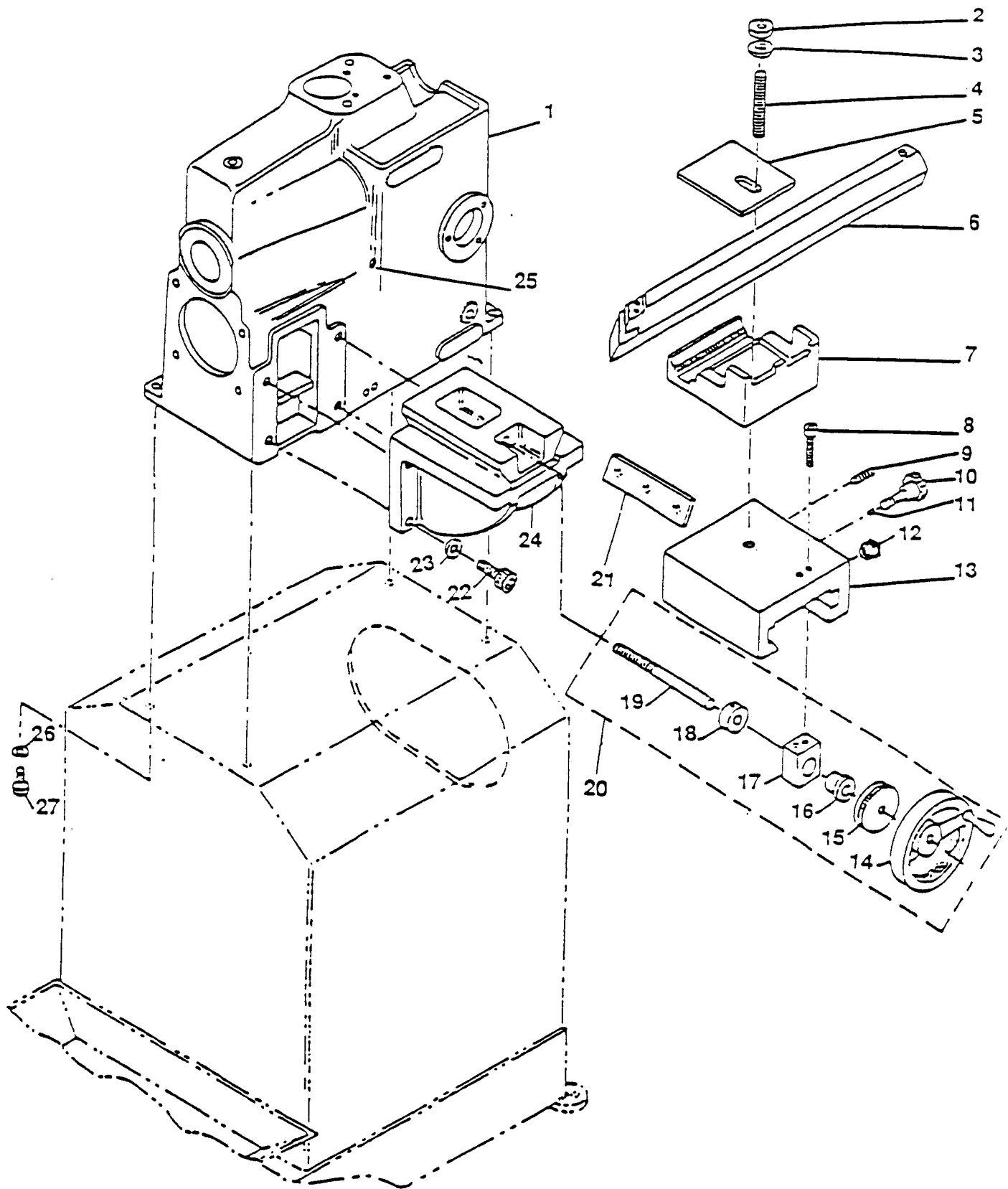


Plate 7

DRUM TURNING ASSEMBLY (204C ONLY)

PARTS LIST

| ITEM NUMBER | QUANTITY | PART NUMBER | DESCRIPTION |
|----------------|----------|----------------|----------------------------------|
| 1 | | 20400300 | Body |
| 2 | 1 | 05199 | Check Nut 1/2"-13 x 5/16 |
| 3 | 1 | 40695 | Washer |
| 4 | 1 | 20400303 | Stud |
| 5 | 1 | 20400030 | Tool Holder Clamp |
| 6 | 1 | 20400219 | Tool Bar (20400343 on "S" Model) |
| 7 | 1 | 20400301 | Tool Holder Turret |
| 8 | 2 | 07282 | Screw |
| 9 | 2 | 24357 | Set Screw |
| 10 | 1 | 40531 | Slide Lock |
| 11 | 1 | 11100633 | Brass Plug |
| 12 | 2 | 05208 | Jam Nut |
| 13 | 1 | 20400302 | Slide |
| 14 | 1 | 28954V | Handwheel 5" |
| 15 | 1 | 20400316 | Index Dial |
| 16 | 1 | 40562 | Bushing |
| 17 | 1 | 20408020 | Index Block |
| 18 | 1 | 13988 | Collar |
| 19 | 1 | 20400307 | Feed Screw |
| 20 | 1 | 20407307 | Screw Assy. |
| 21 | 1 | 20400033 | Tool Slide Gib |
| 22 | 4 | 08328 | Socket Head Cap Screw |
| 23 | 4 | 05583 | Lockwasher |
| 24 | 1 | 20400002 | Knee |
| 25 | 1 | 08194 | Plug |
| 26 | 4 | 05889 | Washer |
| 27 | 4 | 05340 | Hex Head Cap Screw |



DRUM TURNING ASSEMBLY

CLAW ASSEMBLY

PARTS LIST

| ITEM NUMBER | QUANTITY | PART NUMBER | DESCRIPTION |
|----------------|----------|----------------|---------------------------|
| 1 | 2 | 40753 | Knob |
| 2 | 2 | 40350 | Washer (.312 flat fender) |
| 3 | 1 | 25812 | Pin (.75 x 2) |
| 4 | 1 | 20500854 | R.H. Tool Holder |
| 5 | 1 | 20500855 | L.H. Tool Holder |
| 6 | 1 | 40535 | Spring |
| 7 | 1 | 20400311 | Mounting Plate |
| 8 | 1 | 20500858 | Block |
| 9 | 2 | 20400270 | Feed Screw |
| 10 | 2 | 08057 | Key (#5) |
| 11 | 2 | 20400269 | Dial |
| 12 | 1 | 19934 | Pin (3/16 x 1-1/2) |
| 13 | 2 | 10307 | Screw (1/4-20 x 2) |
| 14 | 2 | 10307 | Screw (1/4-20 x 2) |
| 15 | 1 | 19934 | Pin (3/16 x 1-1/2) |
| 16 | 1 | 20500858 | Block |
| 17 | 2 | 30084 | Screw |
| 18 | 2 | 29279 | Clamp |
| 19 | 2 | 29687 | Insert |
| 20 | 2 | 08792 | Screw (1/4-20 x 1/2) |
| 21 | 1 | 20500066 | Plate |
| 22 | 1 | 20400320 | Guard |
| 23 | 1 | 20400303 | Stud |
| 24 | 1 | 05199 | Nut (1/2-13) |
| 25 | 1 | 40695 | Washer |
| 26 | 1 | 20500849 | Clamp Plate |

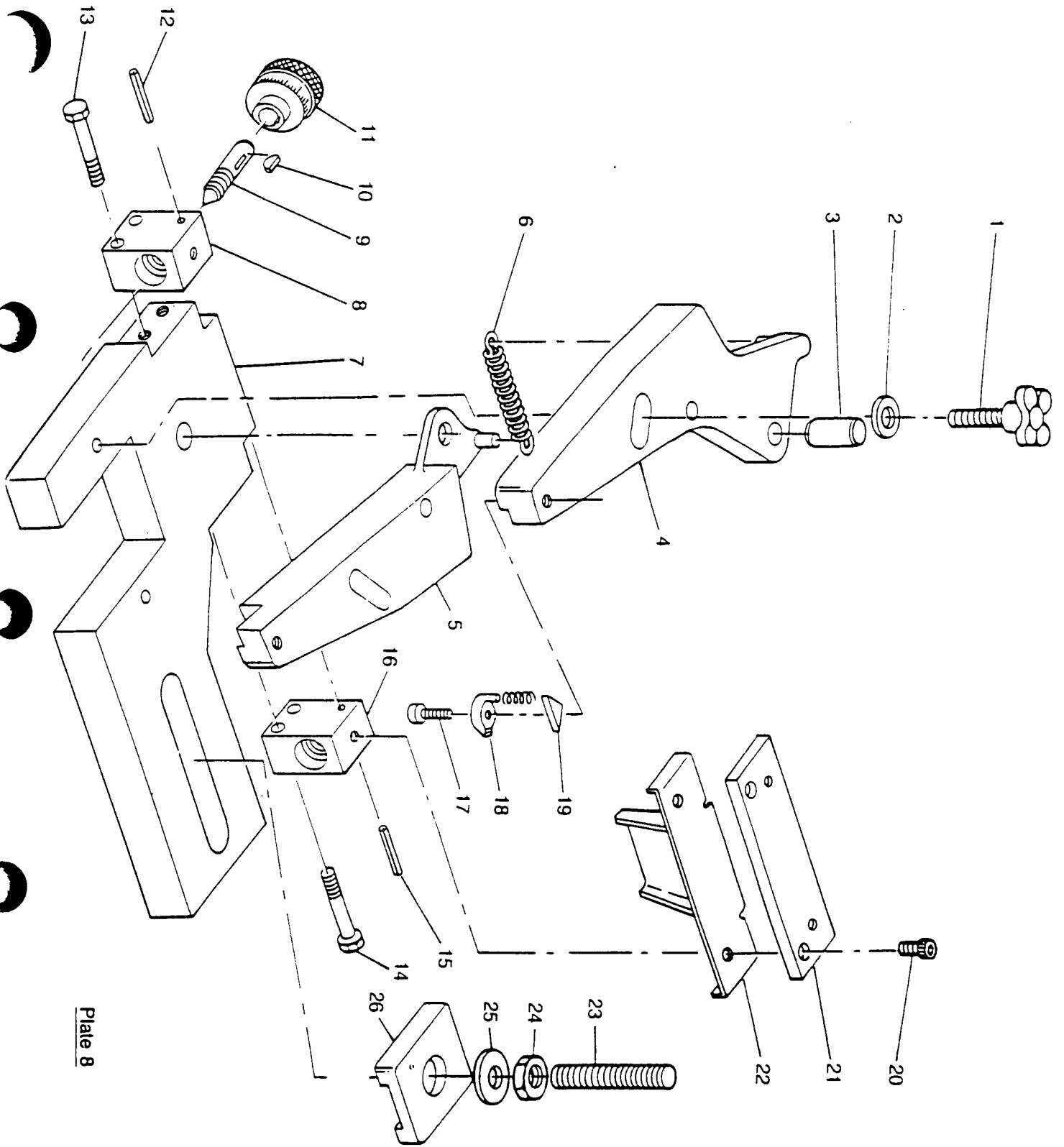


Plate 8

ELECTRICAL EQUIPMENT

PARTS LIST

| ITEM NUMBER | QUANTITY | PART NUMBER | DESCRIPTION |
|----------------|----------|----------------|------------------------------|
| 1 | | 20400300 | Body (Ref.) |
| 2 | 1 | 413571 | Elec. Cover |
| 3 | 5 | 413594 | Small Coupler |
| 4 | 1 | 41526 | Wire Clip |
| 5 | 1 | 05021 | Screw (10-32 x 3/8) |
| 6 | 1 | 413564 | Switch |
| 7 | 2 | 11666 | Elec. Box |
| 8 | 2 | 05021 | Screw (10-32 x 3/8) |
| 9 | 1 | 29282 | Boot |
| 10 | 1 | | Nut (Comes with Switch) |
| 11 | 1 | 413642 | Motor and Light Decal |
| 12 | 1 | 41207 | Washer |
| 13 | 1 | 413571 | Elec. Cover |
| 14 | 1 | 41171 | Step Washer |
| 15 | 1 | 40524 | Motor |
| 16 | 1 | | On Motor |
| 17 | 1 | 40999 | Socket and Bulb Holder Assy. |
| 18 | 1 | 40586 | Bulb 120V 60W 60A/52WM |
| 19 | 1 | 10606 | Pipe Nipple (3/8 std close) |
| 20 | 1 | 20400290 | Bracket |
| 21 | 1 | 05950 | Nut (1/4-20) |
| 22 | 1 | 07959 | Nipple Check Nut |
| 23 | 1 | 19641 | Hex Cap Screw (1/4-20 x 3/4) |
| 24 | 1 | 413592 | Large Coupler |

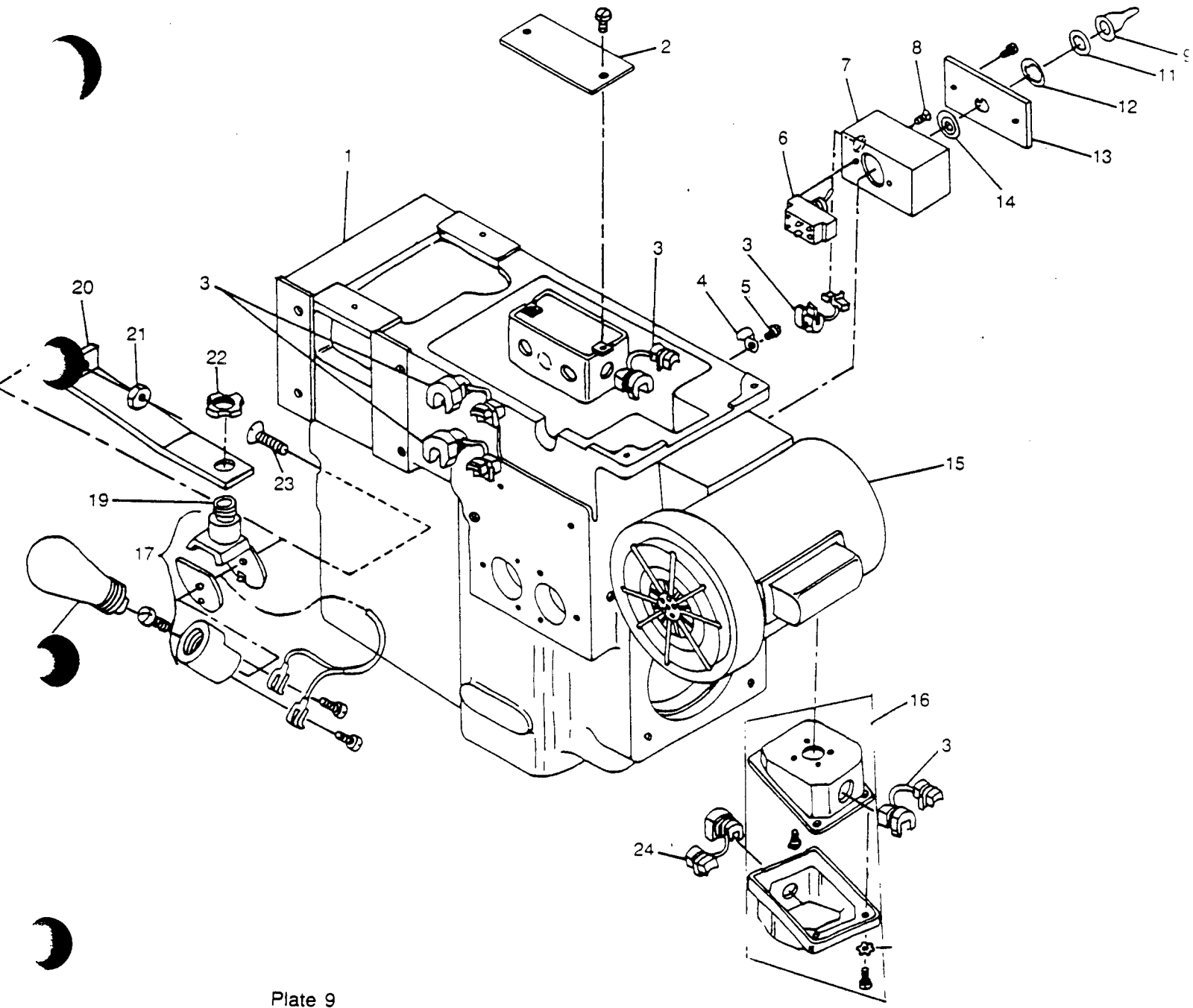
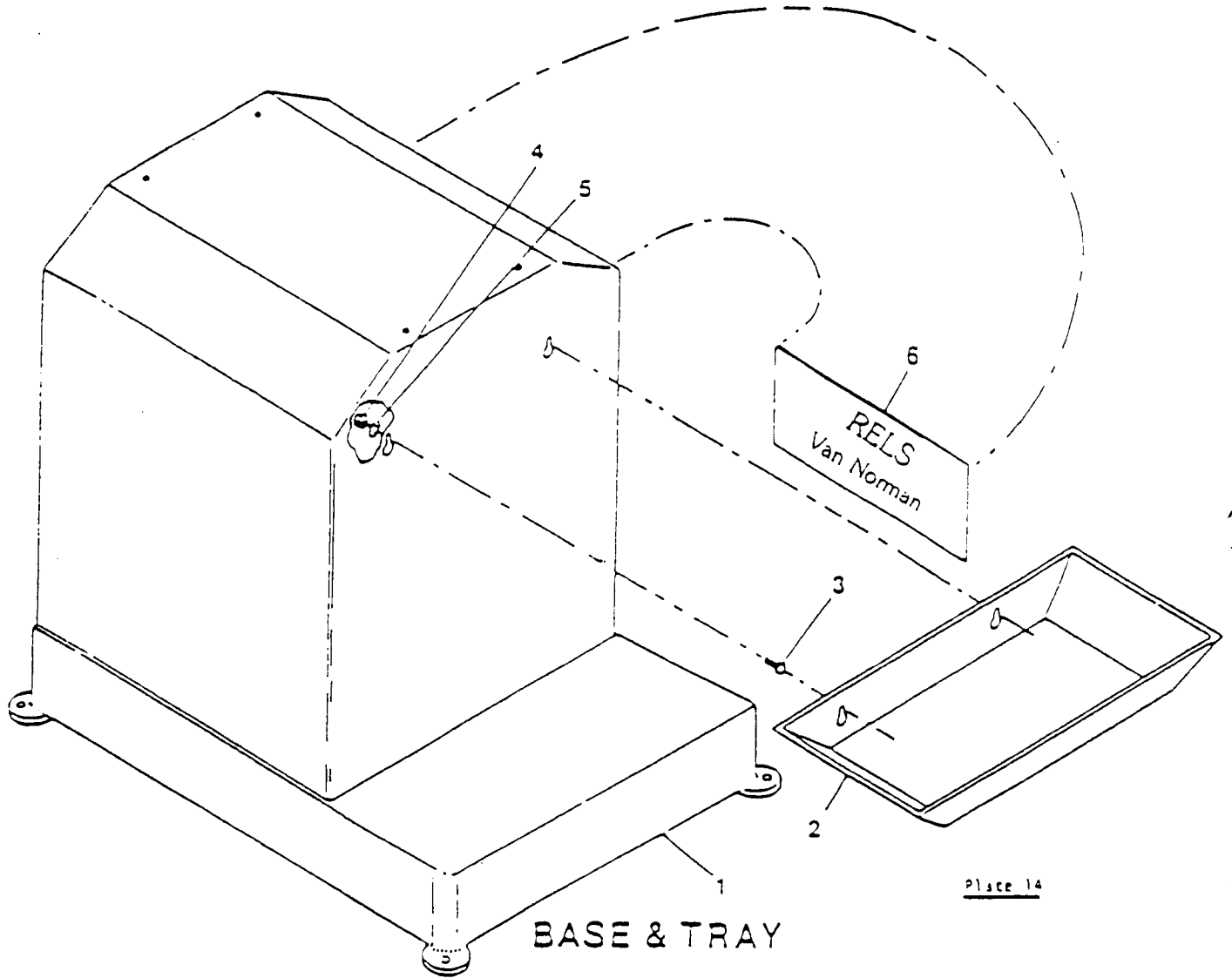


Plate 9

BASE AND TRAY

PARTS LIST

| ITEM NUMBER | QUANTITY | PART NUMBER | DESCRIPTION |
|-------------|----------|-------------|-------------|
| 1 | 1 | 204-07830 | Base |
| 2 | 1 | 205-07056 | Tray |
| 3 | 2 | 205-00058 | Stud |
| 4 | 2 | 05194 | Nut |
| 5 | 2 | 05287 | Washer |
| 6 | 1 | 41922 | Nameplate |



Place 14

BASE & TRAY