

PARTS LIST

<u>ITEM #</u>	<u>PART #</u>	<u>QTY.REQ'D.</u>	<u>DESCRIPTION</u>
1	434013	1	HOUSING
2	434014	1	COVER, HOUSING
3	420200	1	GASKET RTV COMPOUND
4	420772	4	SCREW
6	433605	1	SPINDLE
7	433618	1	BEARING, CONE
8	433619	1	BEARING, CUP
9	433616	1	BEARING, CONE
10	433772	1	BEARING, CUP
11	433622	1	SEAL
12	431146	1	SEAL
13	433620	1	SEAL
14	408129	1	SEAL
15	433611	1	SHIM
16	433612	1	SHIM
17	433613	1	SHIM
18	411342	1	KEY
19	433606	1	GEAR, WORM
20	433974	1	SCREW
21	408365	1	LOCK WASHER
22	408364	1	LOCK NUT
23	433607	1	SHAFT, WORM
24	433614	2	BEARING, CONE
25	433615	2	BEARING, CUP
26	433608	1	CARRIER, BRG.
27	421643	1	GASKETS
28	411389	4	SCREW
29	420149	1	SEAL
30	433628	1	DOVE TAIL, BOTTOM

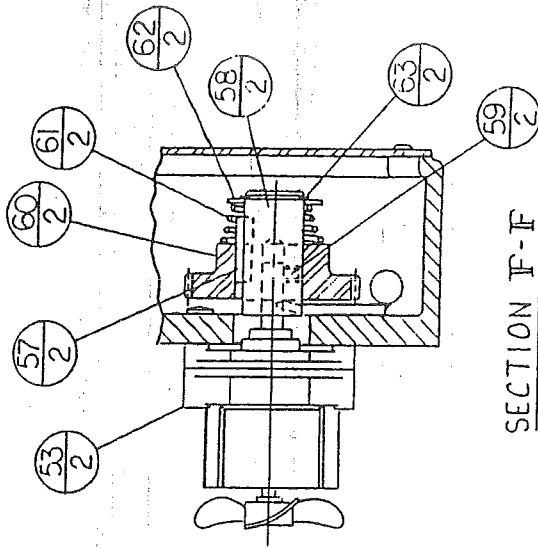
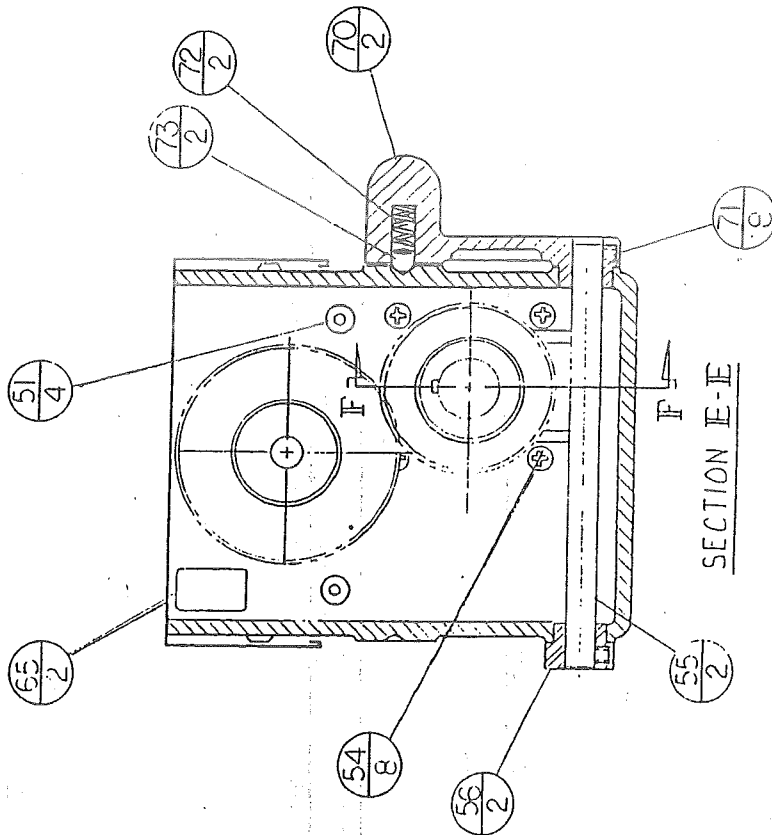
ITEM #	PART #	QTY.REQ'D	DESCRIPTION
31	433634	4	SCREW
32	433790	2	WEAR STRIP ASSY.
33	433635	1	WAY WIPER ASSY, TOP
34	433638	10	SCREW
35	433629	1	DOVE TAIL, CENTER
36	433627	1	DOVE TAIL, TOP
37	433630	8	SCREW
38	413294	8	WASHER
39	413291	8	NUT, HEX
40	433639	2	SCREW, TURN
41	433643	1	SCREW, DRUM FEED
42	433644	1	SCREW, ROTOR FEED
44	433645	4	RING, RETAINING EXTERNAL
45	432413	4	RING, RETAINING INTERNAL
47	433623	2	BEARING, BALL
48	433907	2	HOUSING, FEEDBOX
49	433646	1	NUT, DRUM FEED
50	433647	1	NUT, ROTOR FEED
51	433610	4	SCREW
52	417258	2	SCREW
53	433641	2	MOTOR 1/60, 6 RPM
54	434081	8	SCREW
55	434384	2	ASSEMBLY, SHIFTING YOKE
56	434016	2	COLLAR
57	421431	2	KEY
58	433652	2	DRIVE ADAPTER
59	433974	2	SCREW
60	433653	2	GEAR, SPUR 55 TEETH
61	433655	2	SPRING, CONICAL
62	433654	2	WASHER
63	421077	2	RING, RETAINING EXTERNAL
64	433651	2	GEAR, SPUR 70 TEETH
65	433649	2	SWITCH, LIMIT
68	433908	2	COVER, HOUSING FEEDBOX
69	434017	2	SNAP-IN NYLINER

ITEM #	PART #	QTY. REQ'D	DESCRIPTION
70	433909	2	HANDLE, SHIFTER
71	433974	8	SCREW
72	1A2169	2	SPRING
73	408373	2	BALL
74	433667	1	GUARD, ROTOR WAY DRIVE MOTOR
75	433677	1	GUARD, DRUM WAY DRIVE MOTOR
76	433638	4	SCREW
77	433735	2	TELESCOPING WAY ASSEMBLY
78	433638	12	SCREW
79	433682	4	SPACER
80	433688	4	SCREW
81	433687	4	SCREW
82	408409	1	SCREW
82	433665	1	HAND WHEEL
82	433666	1	HANDLE, REVOLVING
82	433669	1	DECAL, CALIBRATED 0-80 DRUM
82	433828	1	HAND WHEEL ASSEMBLY, DRUM
82	433974	1	SCREW
83	408409	1	SCREW
83	433665	1	HAND WHEEL
83	433666	1	HANDLE, REVOLVING
83	433781	1	DECAL, CALIBRATED 0-95 ROTOR
83	433829	1	HAND WHEEL ASSEMBLY, ROTOR
83	433974	1	SCREW, SET
84	433729	1	BASE, MOTOR ASSEMBLY
85	433626	1	SHAFT, MOTOR BASE PIVOT
86	421674	2	SCREW, SET
87	433670	1	MOTOR 115/230 VOLT, 1 PHASE, 1 H.P.
88	433683	4	WASHER
89	433684	4	SCREW
90	433671	1	SHEAVE
91	433672	1	SHEAVE
92	433673	1	V-BELT
93	433675	1	GUARD, BELT
94	433638	2	SCREW

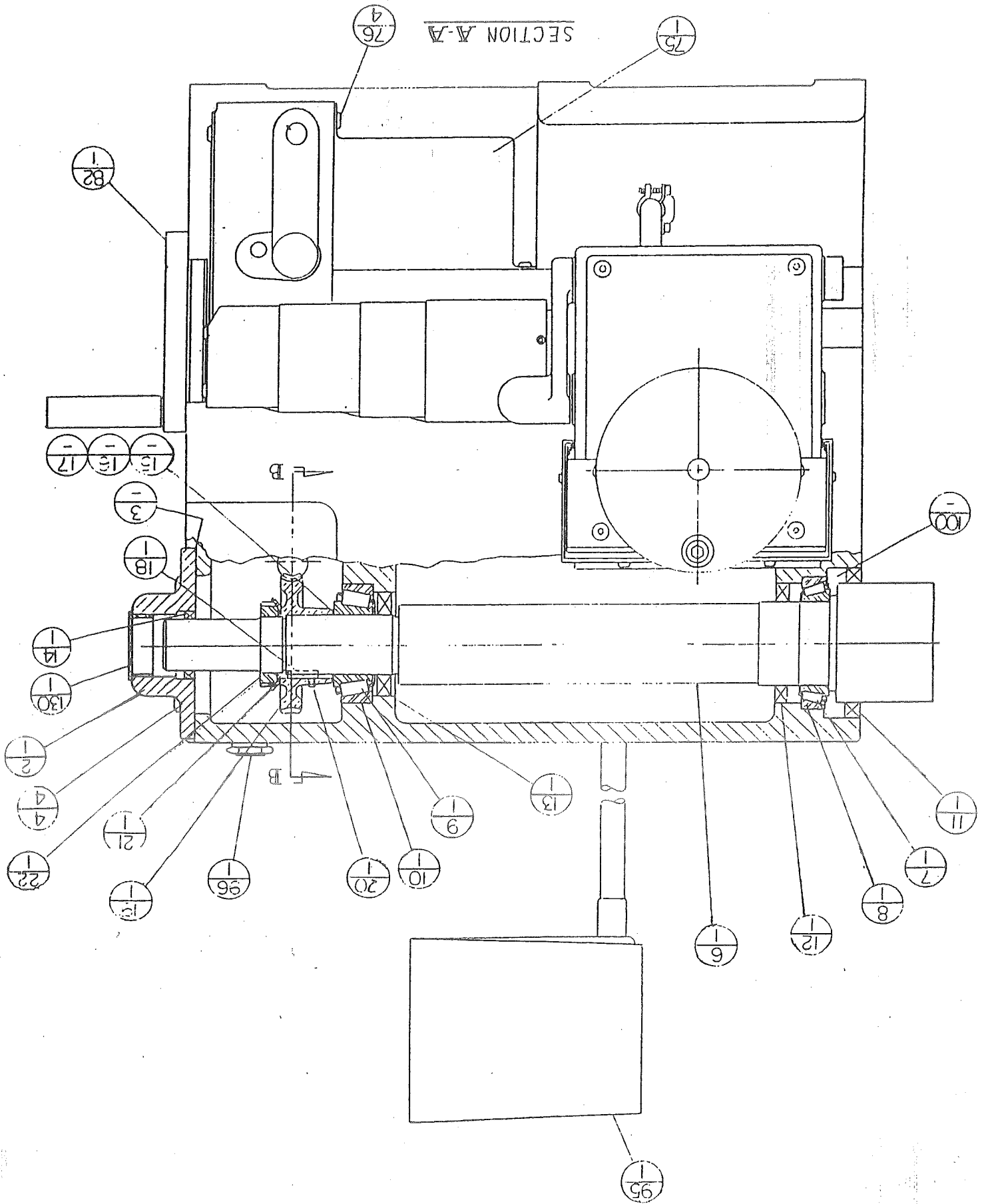
ITEM #	PART #	QTY.REQ'D	DESCRIPTION
95	433685	1	LAMP
96	433674	1	FITTING, RELIEF
97	413281	1	PLUG, PIPE
98	411476	32 oz.	OIL, GULF AGMA NO 7C
99	433830	TRACE	STOR-AND-LUBE
100	411478	1 oz.	GREASE #2
101	433727	1	POWER CORD ASSEMBLY
102	433726	1	MOTOR CORD ASSEMBLY
103	433698	1	WIRE, ELECTRICAL
108	433719	5	CLAMP, CABLE 2 SCREW
109	433721	1	CONDUIT, FLEXIBLE
110	434133	8	CONNECTOR, CRIMP-ON
111	434132	2	CONNECTOR, CRIMP-ON
112	434132	2	CONNECTOR, CRIMP-ON
113	433818	1	SCREW
114	434402	1	SCREW
115	433693	1	SWITCH, TOGGLE
116	433695	1	DECAL, TOGGLE SWITCH
117	433732	1	LABEL, CAUTION
118	433733	1	LABEL, CAUTION
119	433819	1	NAMEPLATE, ACCU IND.
120	433820	1	NAMEPLATE, SERIAL NO.
121	433633	1	BOLT, T SLOT
122	433777	1	HOLDER, BORING BAR
123	4B4280	1	WASHER
124	433617	1	NUT, HEAVY HEX.
125	433778	1	BORING BAR
126	433780	2	SCREW, SET
127	433779	1	HOLDER, TOOL BIT
128	433771	1	SCREW, SET
129	433717	3	CARBIDE BIT & SCREW
130	434009	1	CAPPLUG
131	433974	4	SCREW, SET
132	434199	1	WAY WIPER ASSY, CENTER
133	434378	1	PATENT NUMBER PLATE

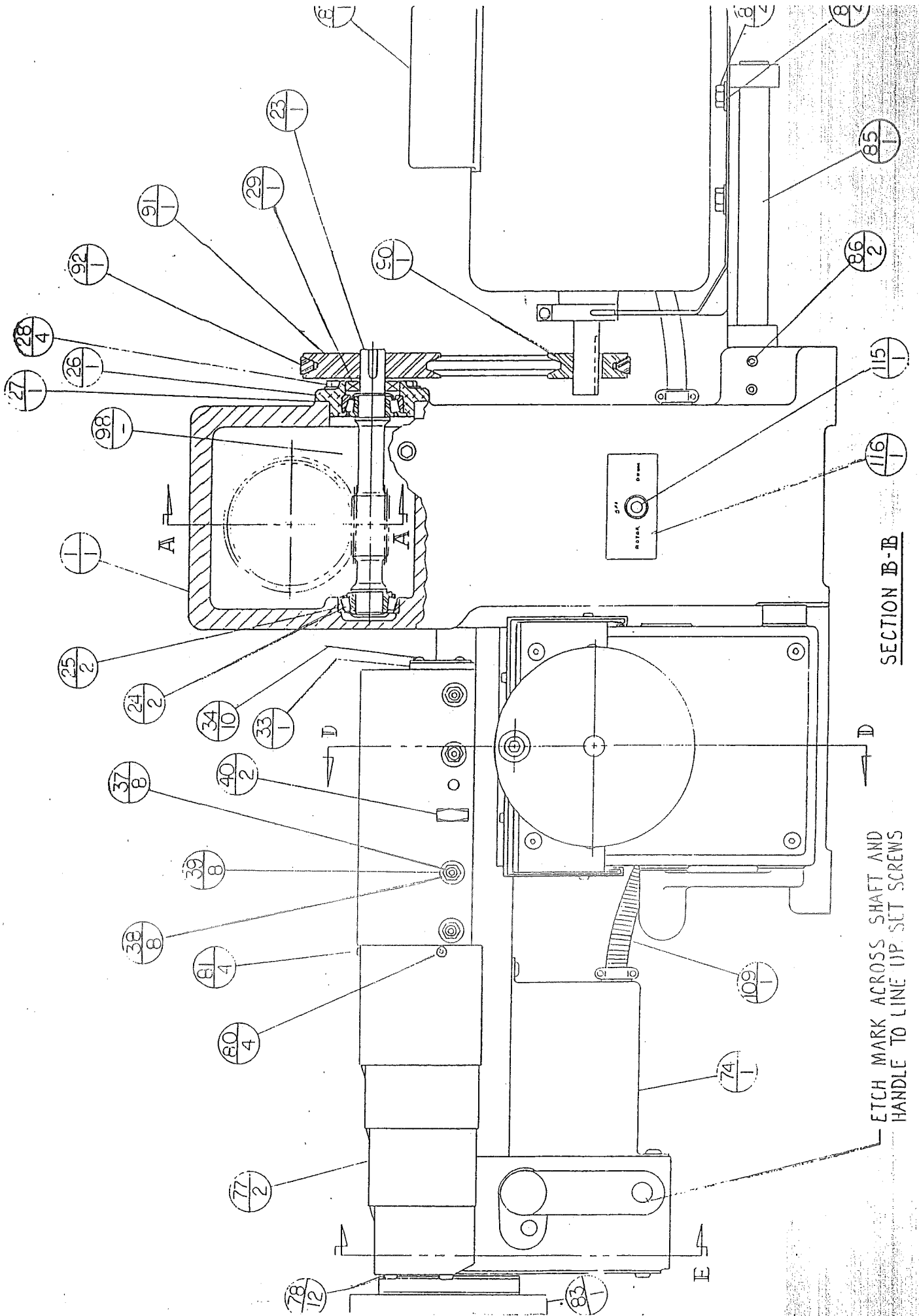
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200	433702	1	BAR, DRAW
201	4B4280	1	WASHER
202	433617	1	NUT, HEAVY HEX.
203	433703	2	PLATE, FACE 1
204	433704	2	PLATE, FACE 2
205	433705	1	CENTERING CONE, DRUM #1
206	433706	1	CENTERING CONE, DRUM #2
207	433707	1	CENTERING CONE, DRUM #3
208	433708	1	ADAPTER #1
209	433709	1	ADAPTER #2
210	433710	1	ADAPTER #3
211	433711	1	ADAPTER #4
212	433617	1	NUT, HEAVY HEX.
213	433712	1	SPACER, ARBOR
214	433715	1	WASHER, ASSEMBLY SELF-ALIGNING
215	433713	1	NUT, HEX
216	433774	1	SPACER
217	433716	1	SPRING, ARBOR
218	433782	1	SILENCER, DRUM
219	433785	1	SILENCER, LARGE VENTED ROTOR
220	433789	1	SILENCER, SMALL NON-VENTED ROTOR
221	433913	1	WRENCH, 1½ OPEN END
222	433963	1	ADAPTER #5
300	433752	1	BASE, ROTO-TRUER
301	433753	1	BASE, CUTTER TENSION BAR
302	433754	1	BASE, ROTO-TRUER POINTER
303	433755	1	TOOL HOLDER, R.H.
304	433756	1	TOOL HOLDER, L.H.
305	433757	1	CUTTER TENSION BAR
306	433758	1	POINTER, ROTO-TRUER
307	433759	2	ADJUSTING WHEEL, ROTO-TRUER
308	433760	2	ADJUSTMENT SCREW
309	433761	2	CALIBRATED WHEEL, ROTO-TRUER
310	433762	2	DECAL, CALIBRATED WHEEL
311	433763	1	TOOL BIT HOLDER R.H.
312	433764	1	TOOL BIT HOLDER L.H.

ITEM #	PART #	QTY.REQ'D	DESCRIPTION
314	433765	2	SCREW, SHOULDER
315	420212	1	SCREW
316	420211	1	SCREW
317	433766	2	SCREW
318	433767	2	SCREW, THUMB
319	433768	2	WASHER, WAVE
320	433769	2	SCREW, DRIVE
321	433770	1	SPRING, ROTO-TRUER
322	433771	2	SCREW, SET
323	411388	2	SCREW, SET
324	421674	2	SCREW, SET
325	4B9806	4	SCREW, SET
326	433773	4	ROD, NYLON



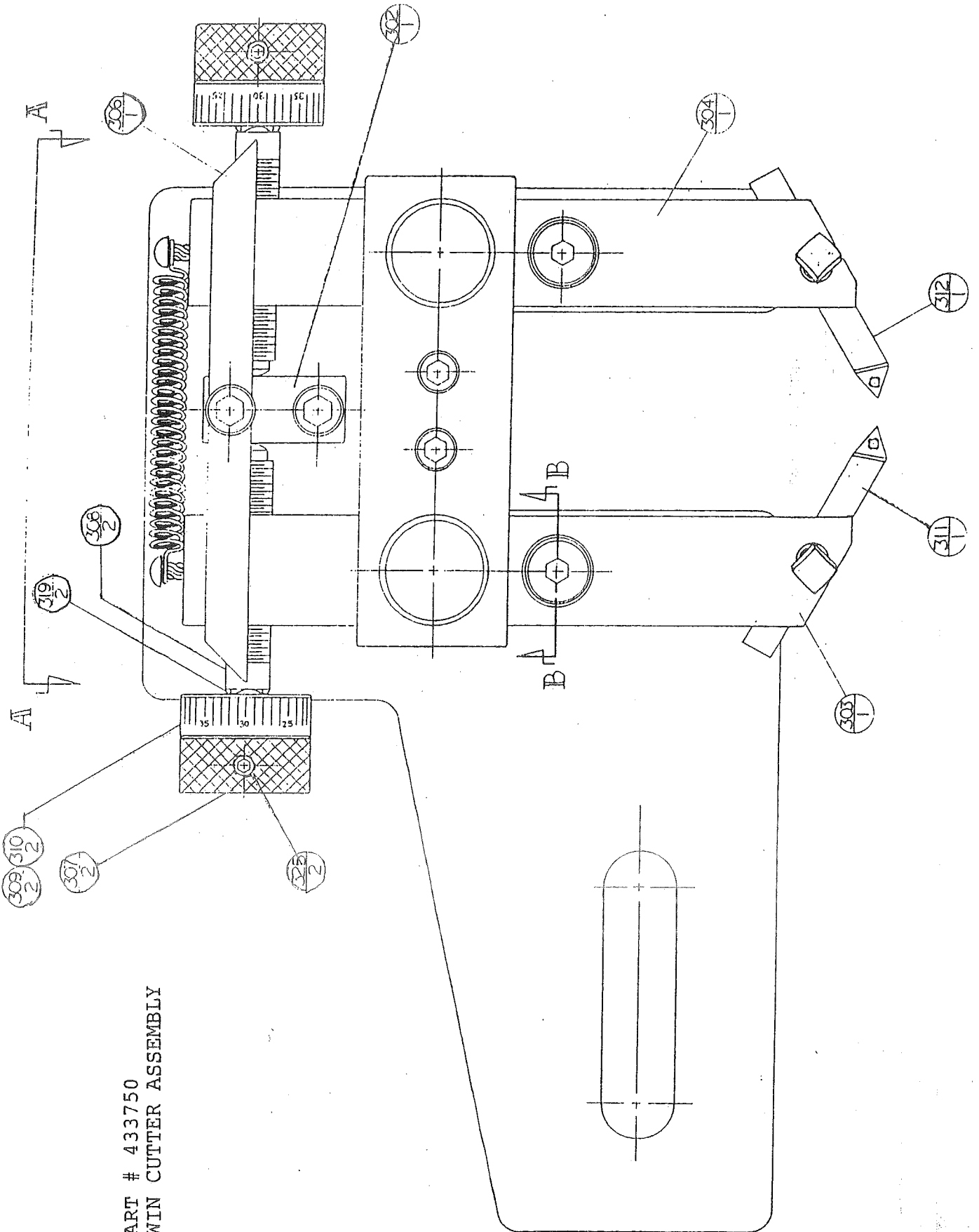
SECTION A-A



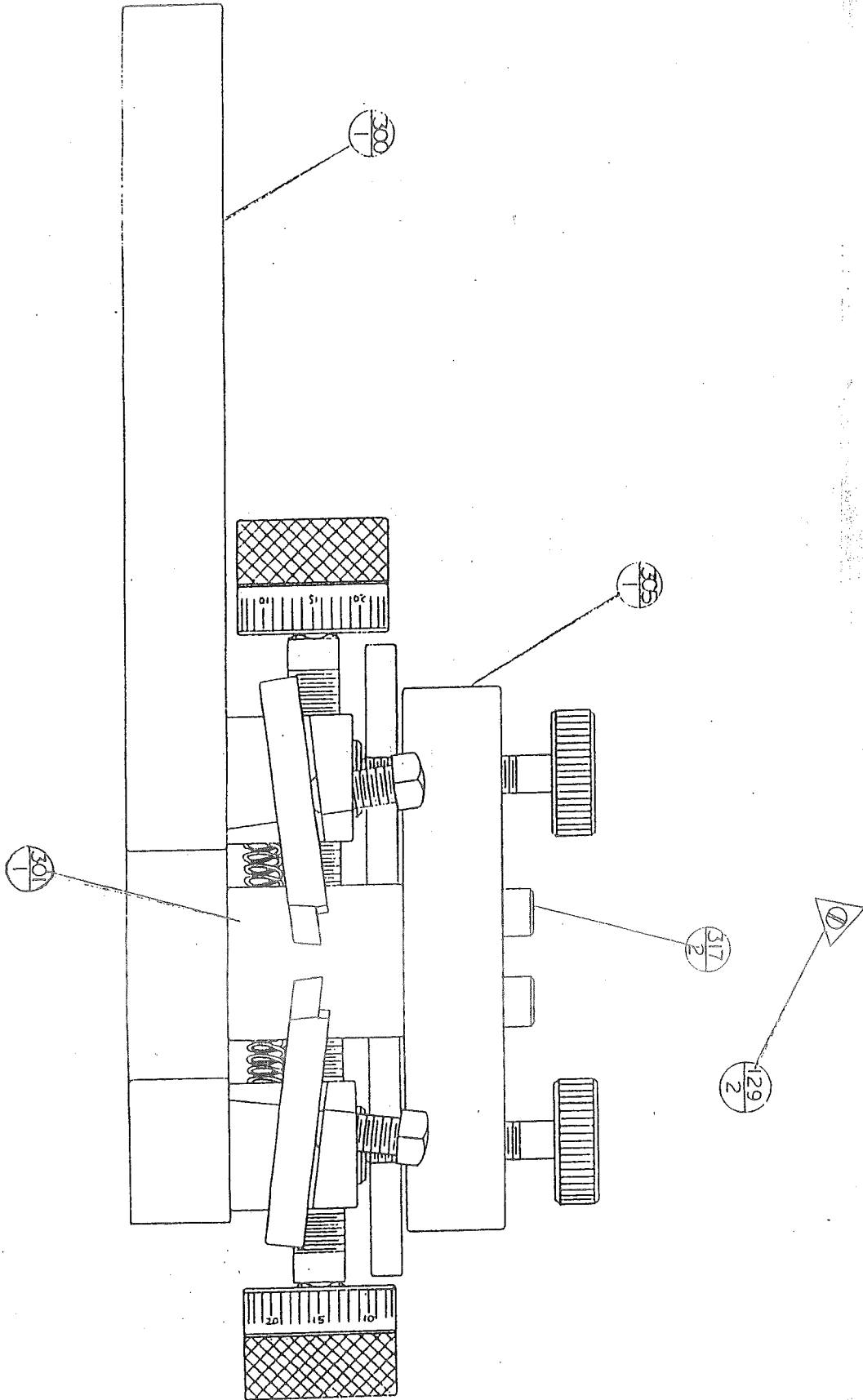


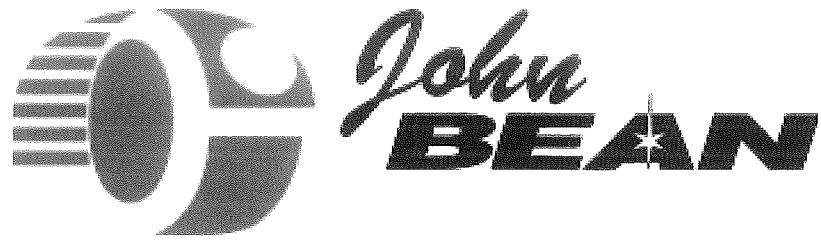
SECTION B-B

ETCH MARK ACROSS SHAFT AND HANDLE TO LINE 11P. SET SCREWS

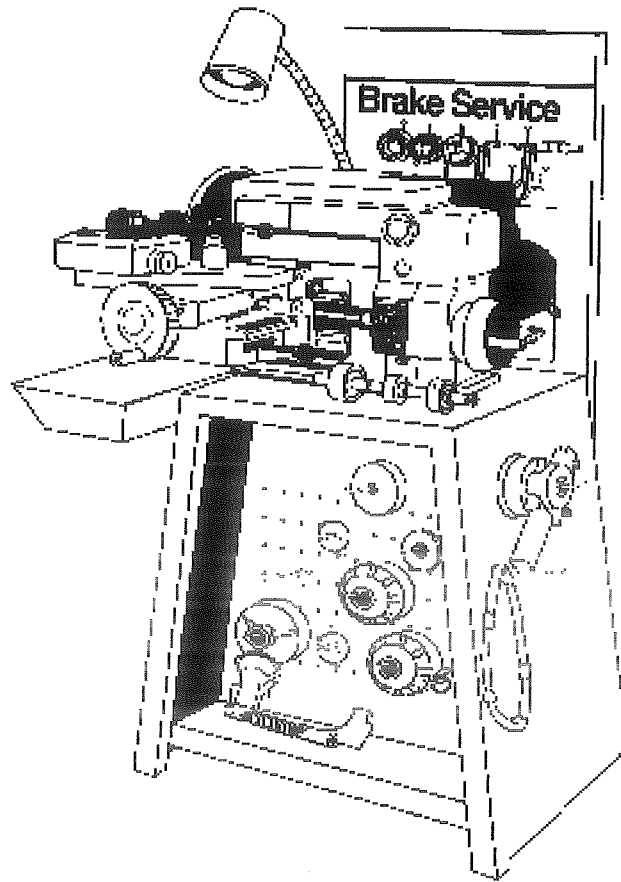


PART # 433750
TWIN CUTTER ASSEMBLY





600 Series Brake Lathe Parts Reference



FORM 3814-10

Figure 1 - Main Housing Group

- 9010319 - End Cover Assembly
- 90226 - Chip Deflector Assembly
- 9010322 - Gear Train Assembly
- 90152 - Ball & Lock Kit Assembly
- 90234 - Hang Sheet

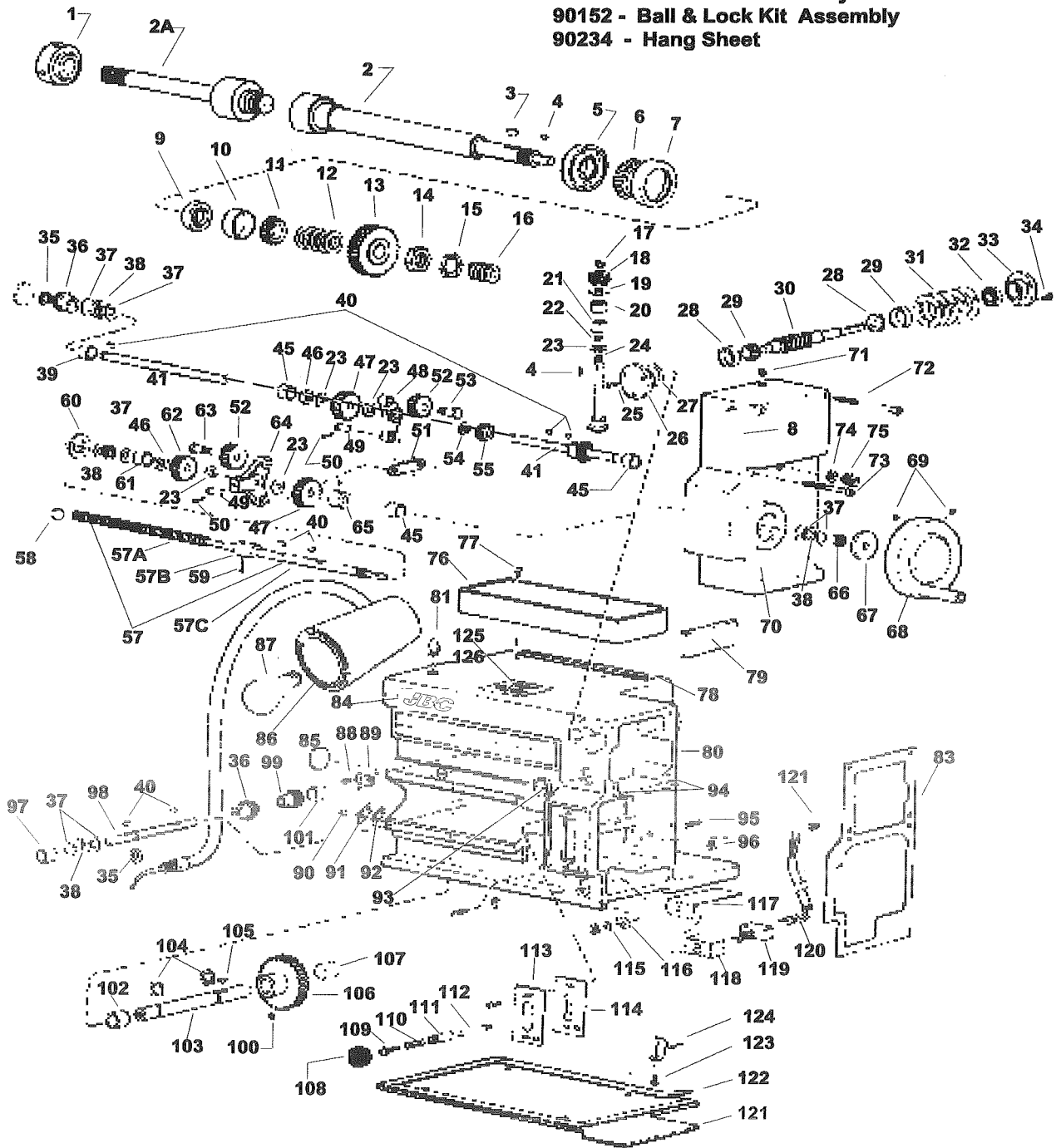


Figure 2 - Cross Slide Carriage and Tool Post Group

9010323 - Carriage Assembly
 90220 - Shut Off Assembly - Switch

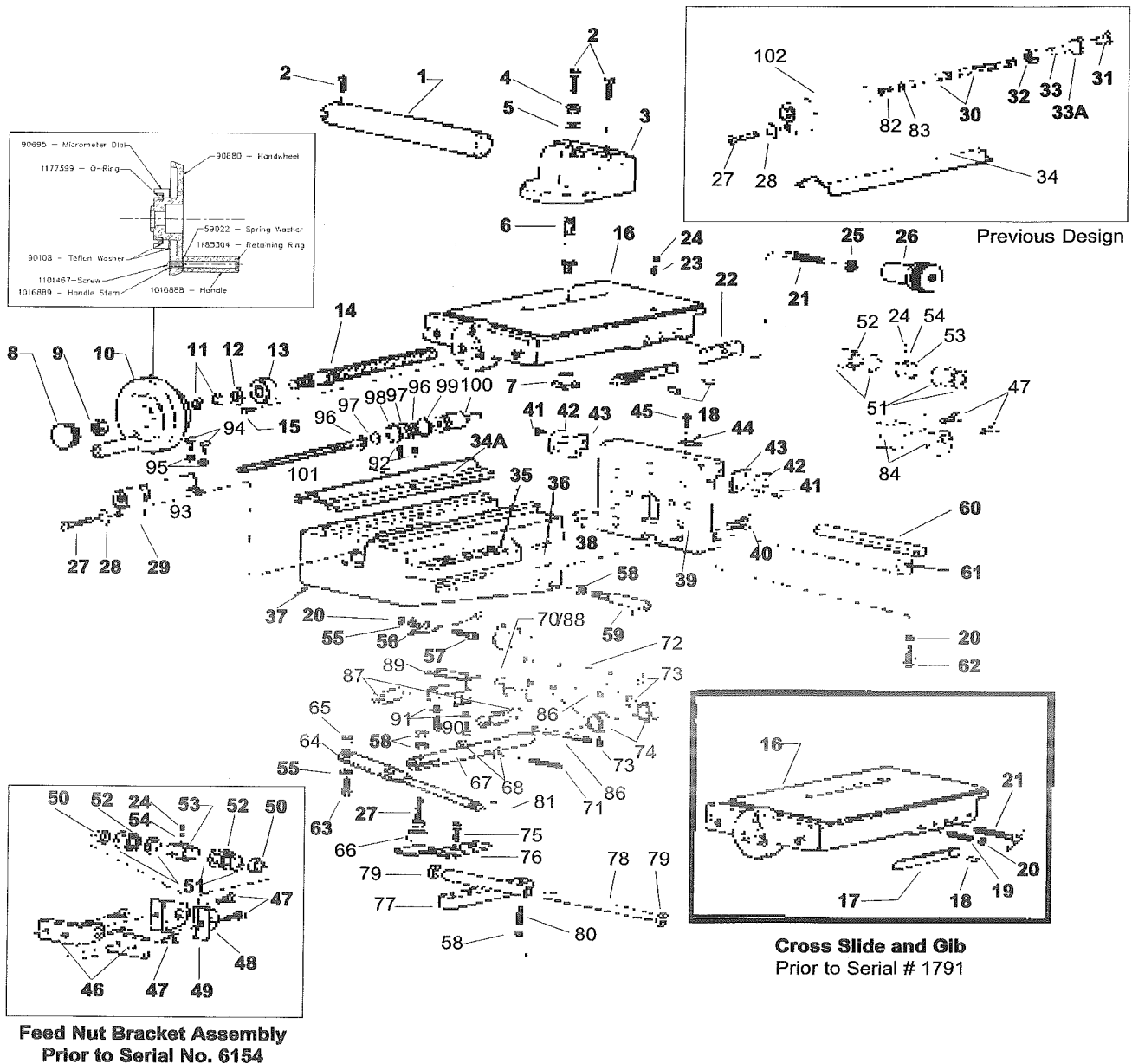
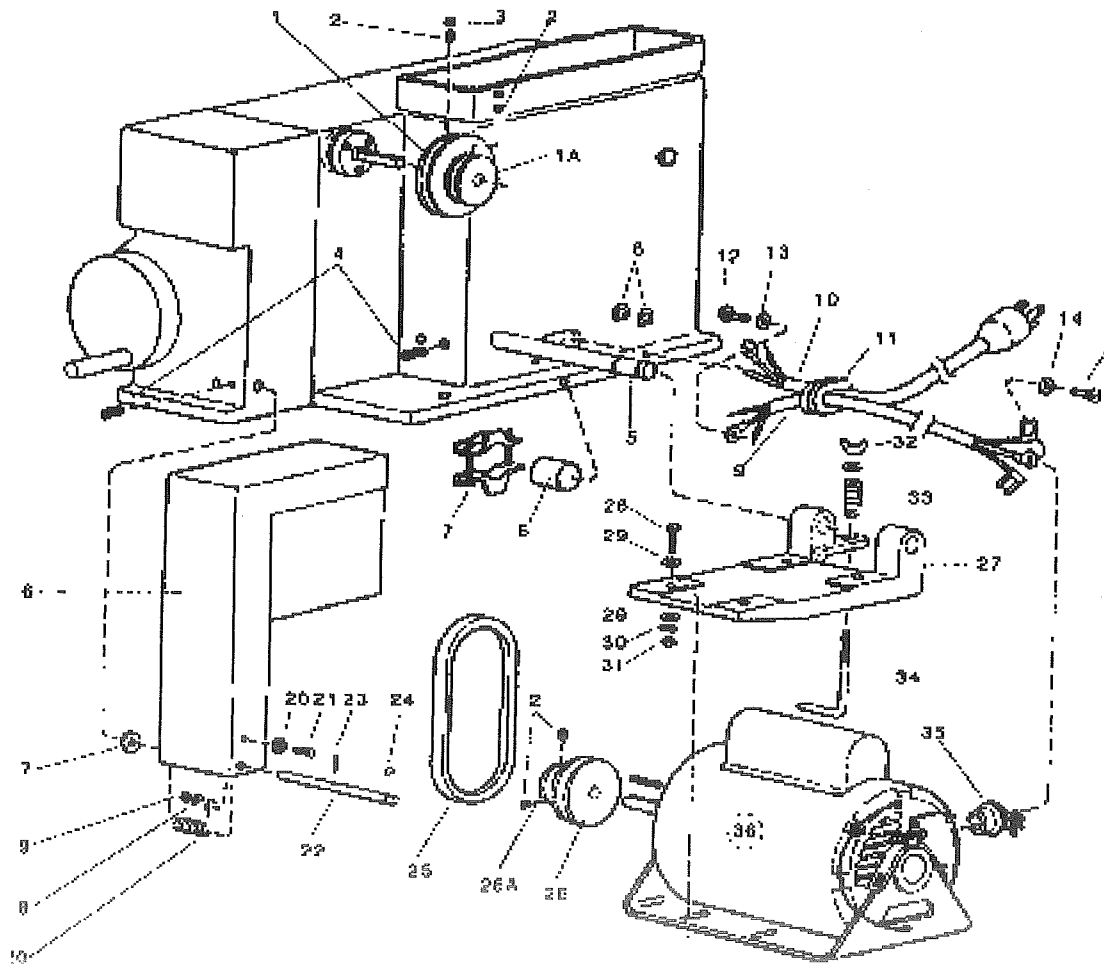


Figure 3 Motor and Guard Group



- 90160 - Belt Guard Assembly
- 90193 - Lathe Motor Assembly
- 90188 - Motor Mount Assembly



USA

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309 Exchange Avenue
Conway, Arkansas 72032
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LATIN AMERICA

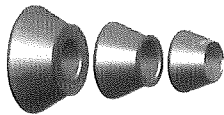
Snap-on Tools International, Ltd.
2801 80th Street
Kenosha, WI 53143
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Cones and Cone Kits



3 Piece Centering Cone Set

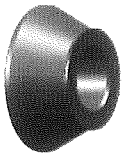
1.65" - 3.94"

42mm - 100mm

40 mm

150 400 021

Recommended on Coats® balancers for maximum coverage



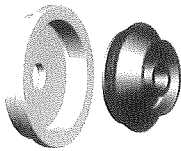
Centering Cone # 5

3.50" - 5.20"

89mm - 132mm

40 mm

150 400 049



Light Truck Cone Kit

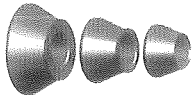
4.72" - 6.85"

120mm - 174mm

40 mm

150 400 091

3 Piece Centering Cone Set



40 mm

150 400 085

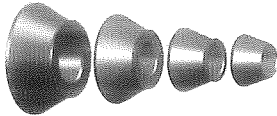
Centering Cone # 2



40 mm

150 400 009

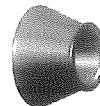
4 Piece Centering Cone Set



40 mm

150 400 134

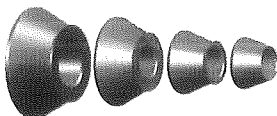
Centering Cone # 3



40 mm

150 400 010

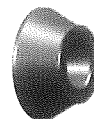
4 Piece Centering Cone Set



40 mm

150 400 070

Centering Cone # 4 (Tacoma Cone)



40 mm

150 400 012

Centering Cone # 1



40 mm

150 400 008

Distance Spacer for Light Truck Cone Kit



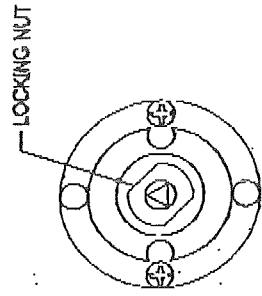
40 mm

190 400 018

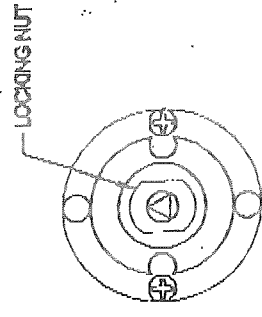
- 1.) Align sides and center of template with existing hole on the lathe.
- 2.) Center punch the "X"s where the 3/16" holes are to be drilled.
- 3.) Drill the center punch marks with a 3/16" drill.
- 4.) Drill out the existing switch mounting hole with a 5/8" drill.
- 5.) Determine correct shaft length. If lathe has an access cover, fully insert the shaft into the switch. Most installations through the casting will be made with the shaft fully inserted into the switch; however, some castings may be slightly thicker and require adjustment. This should be determined prior to locking the shaft length as once the shaft is locked, it cannot be unlocked to readjust.
- 6.) Lock the shaft length. Set the switch to the drum "on" position. Using a 12 mm open end wrench, rotate the locking nut approximately 45 degrees. Set the switch to the "Off" position. The locking nut should be positioned as in figure 2 below.
- 7.) Mount the switch using the supplied screws. Use the short screws if the lathe has access cover or the long screws if mounting through the casting.

Some lathes with an access cover may have a problem with interference between the switch and the housing casting. If this is the case, use a die grinder or file to remove casting material until switch fits without interference. See reverse side of this installation sheet for alternate method if interference is a problem.

IMPORTANT: REMOVE ANY FILINGS FROM CASTING BEFORE INSTALLING SWITCH.



Shaft Unlocked
Figure 1

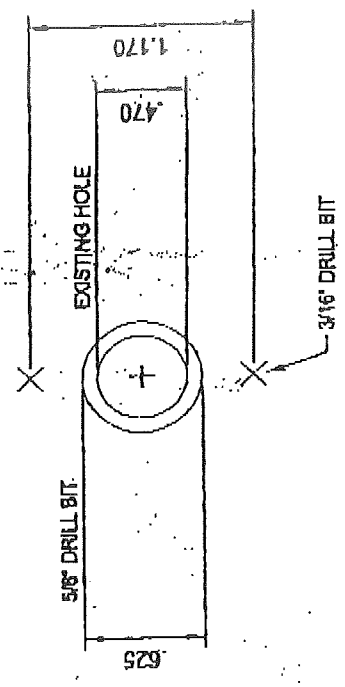


Shaft Locked
Figure 2



TOP

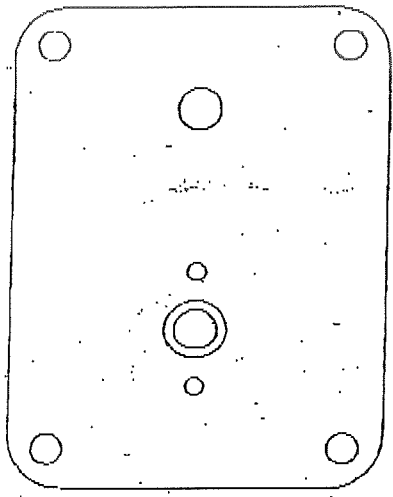
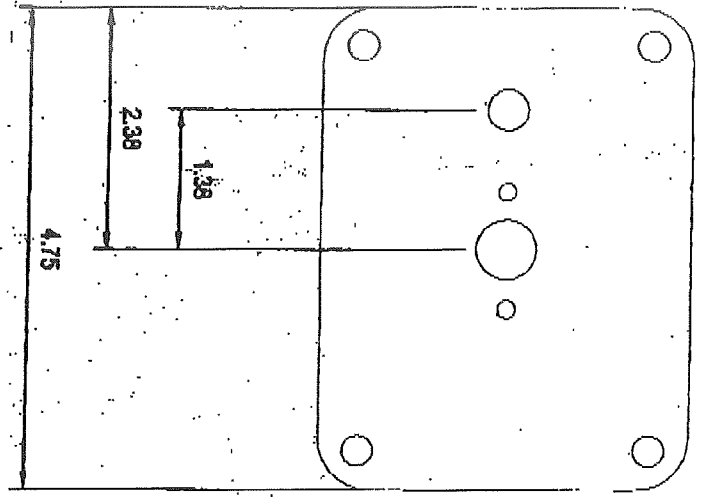
ROTARY SWITCH CONVERSION TEMPLATE




Accu Industries, Inc.
 PO BOX 16640 RICHMOND VA 23227
 11120 AIR PARK ROAD ASHLAND VA 23008
 TELEPHONE (804) 798-9922 FAX (804) 798-8742

8922 WITH ACCESS COVER

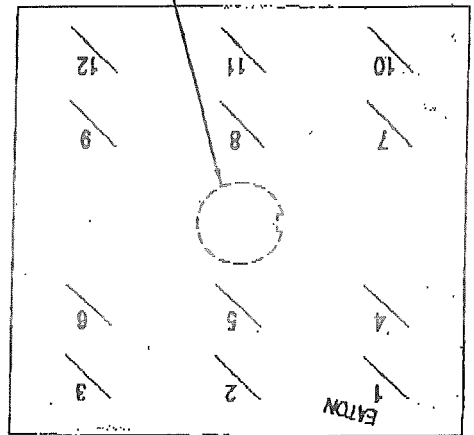
8944 WITH ACCESS COVER



NOTE: To eliminate having to grind the casting, drill the rotary switch hole pattern at the center of the access cover and cover the existing hole with a small Accu-Turn label.

NOTE: To eliminate having to grind the casting, drill the rotary switch hole pattern at the variable speed controller position. Attach access cover to lathe, as normal, with rotary switch in lower position.

Note position of key-way in front of switch while working from the back of the switch.



BACK OF TOGGLE SWITCH

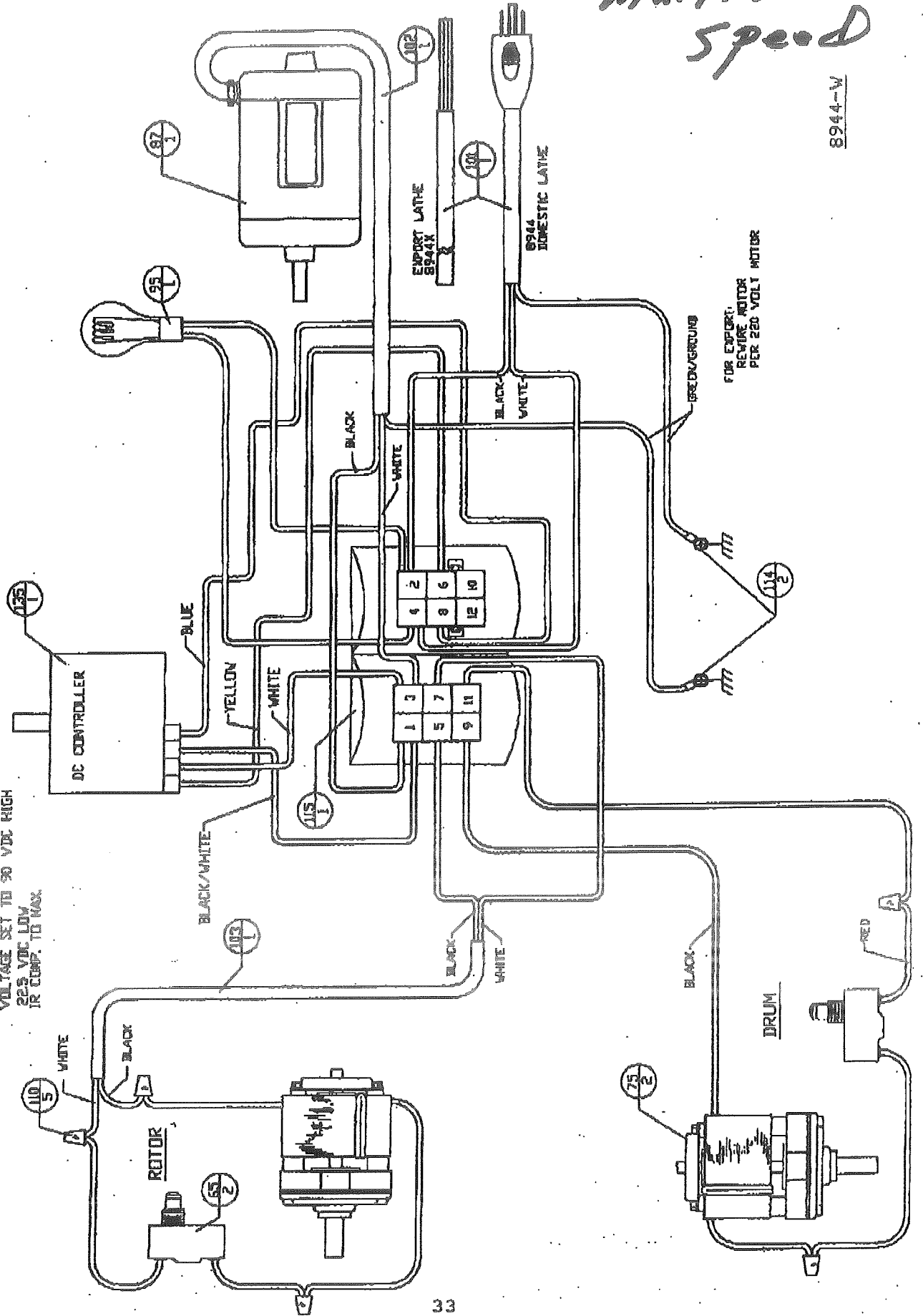
- 1) Cut wires close to switch and change one wire at a time.
- 2) Leave the jumpers on the rotary switch between pins 6-10 and 8-12

8944 wires	8922 & 8989 wires	ROTARY SWITCH	TOGGLE SWITCH
Black to main motor	Black to main motor	1	1 and 3
Black to power cord	Black to power cord	2	2
White to power cord	White to power cord	3	11 and 12
White to main motor	White to main motor	4	10 and 12
Blue DC wire	White to power cord	8	8
Yellow DC wire	Black to power cord	9	5
Rotor feed motor	Rotor feed motor	9	6
Rotor feed motor	Rotor feed motor	11	6
Rotor feed motor	Rotor feed motor	6	8
Drum feed motor	Drum feed motor	7	7
Drum feed motor	Drum feed motor	5	4
Drum feed motor	Drum feed motor	7	10

Multi-Speed

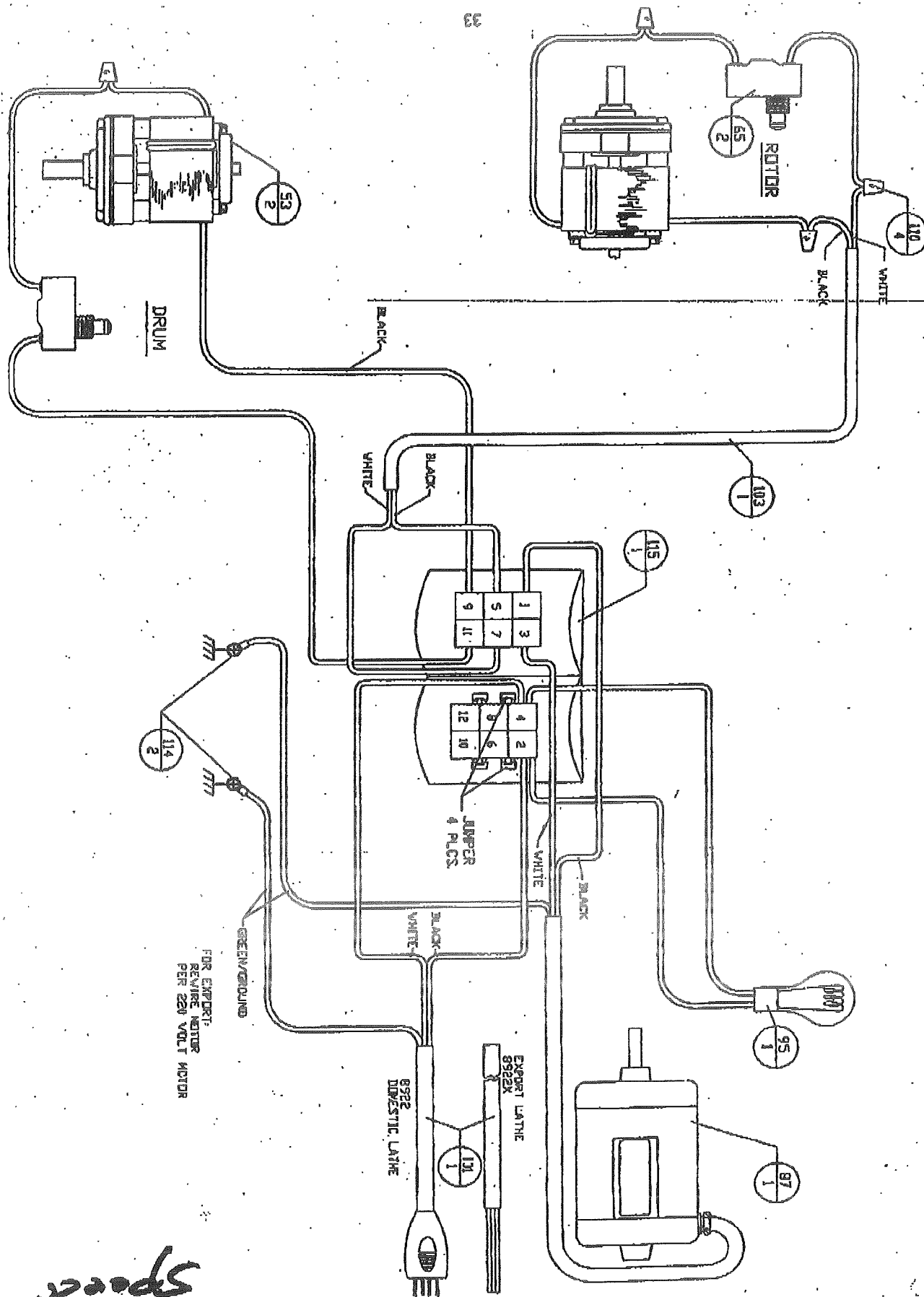
8944-W

VOLTAGE SET TO 90 VDC HIGH
22.5 VDC LOW
IR COMP. TO MAX.



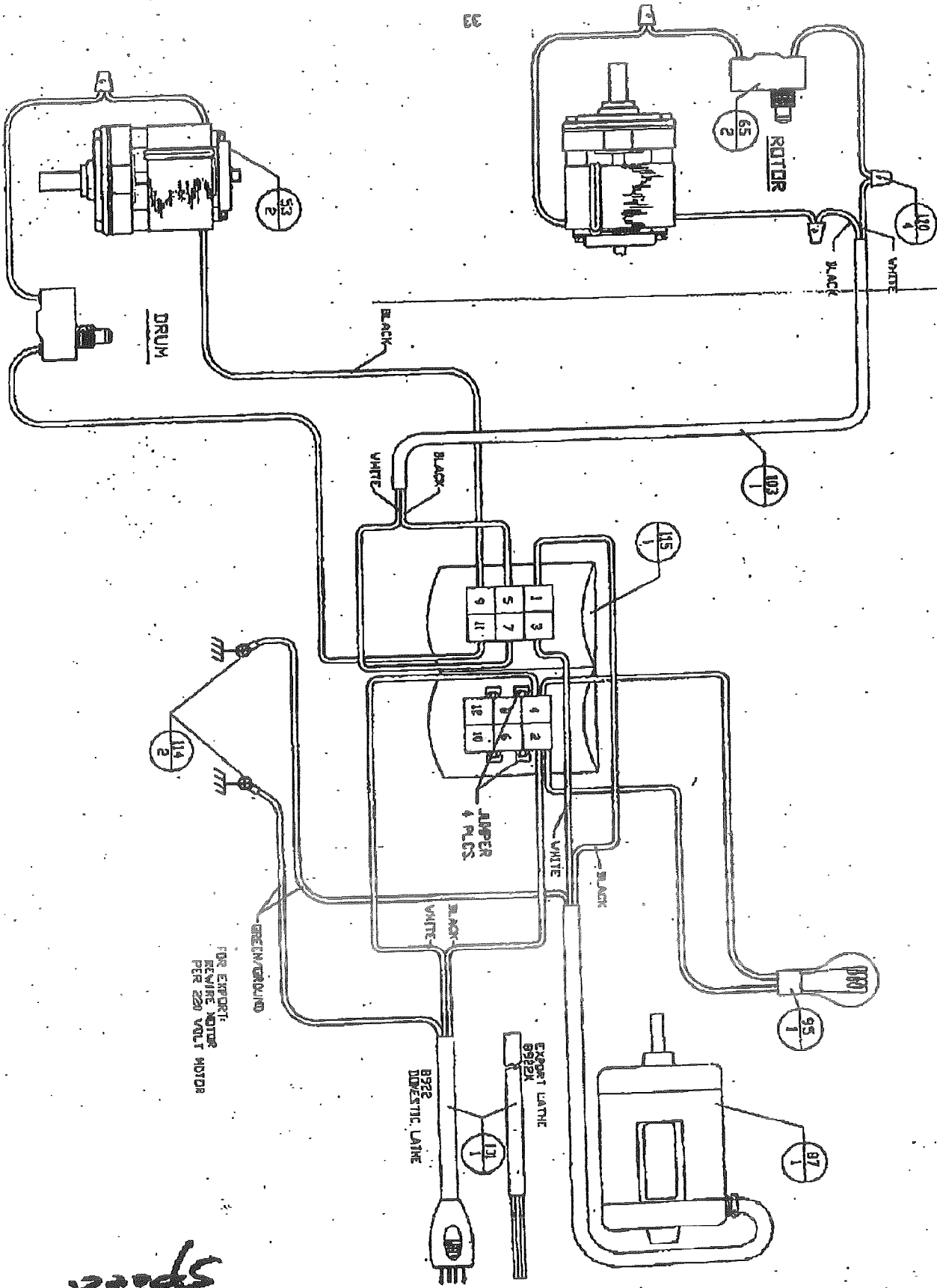
FOR EXPORT,
REWIRE MOTOR
PER 220 VOLT MOTOR

33



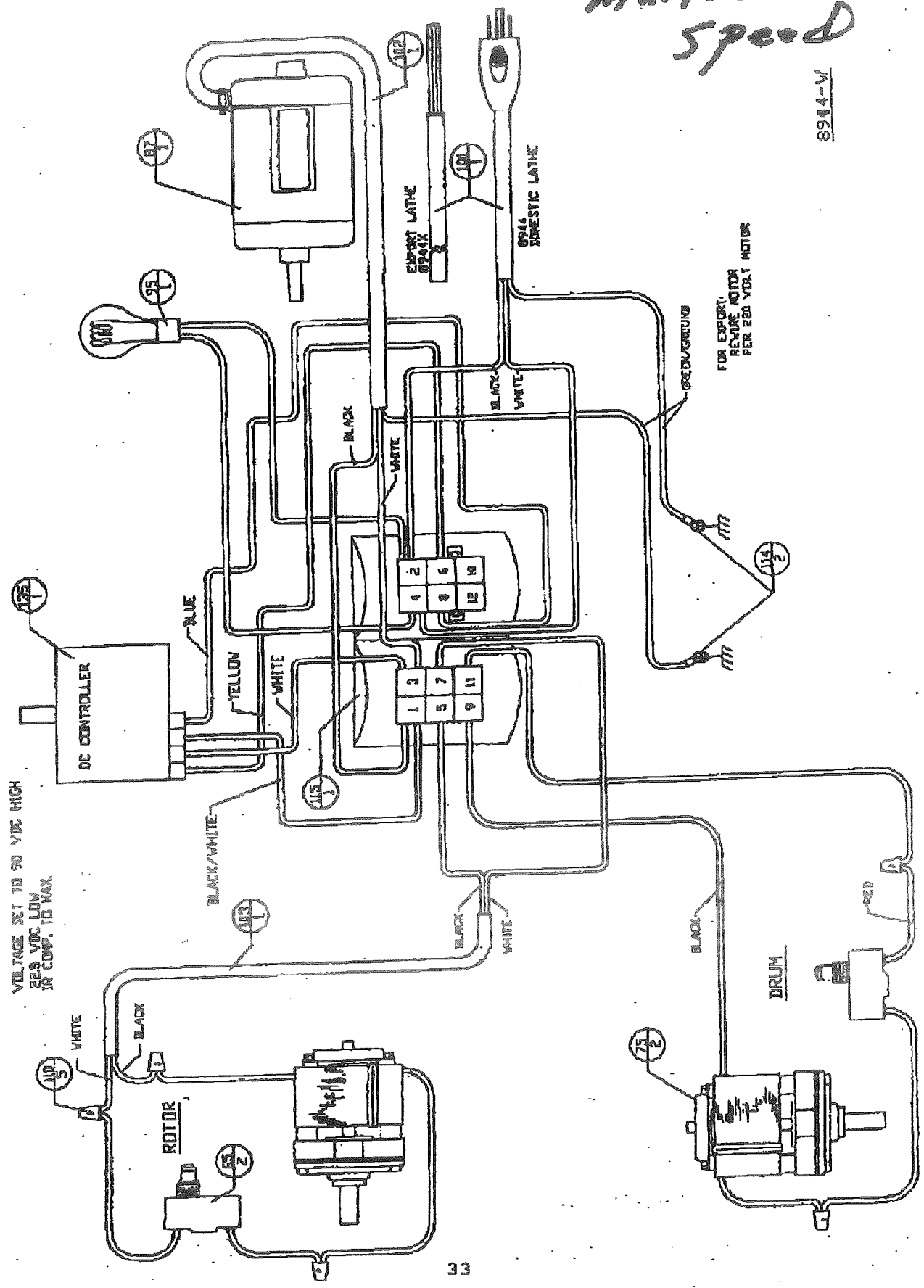
Single Speed

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Multi-Speed

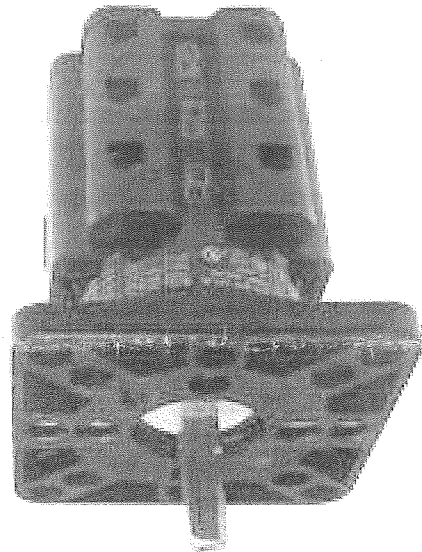
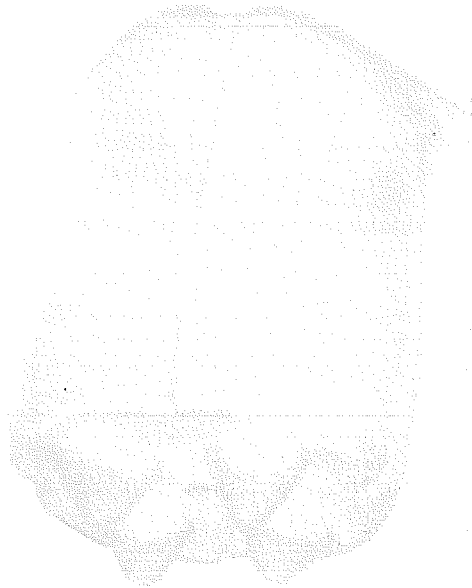
8944-V



VOLTAGE SET TO 90 VDC HIGH
22.5 VDC LOW
OR COMP. TO MAX.

FOR EXPORT,
REMOVE ROTOR
PER 200 VOLT MOTOR

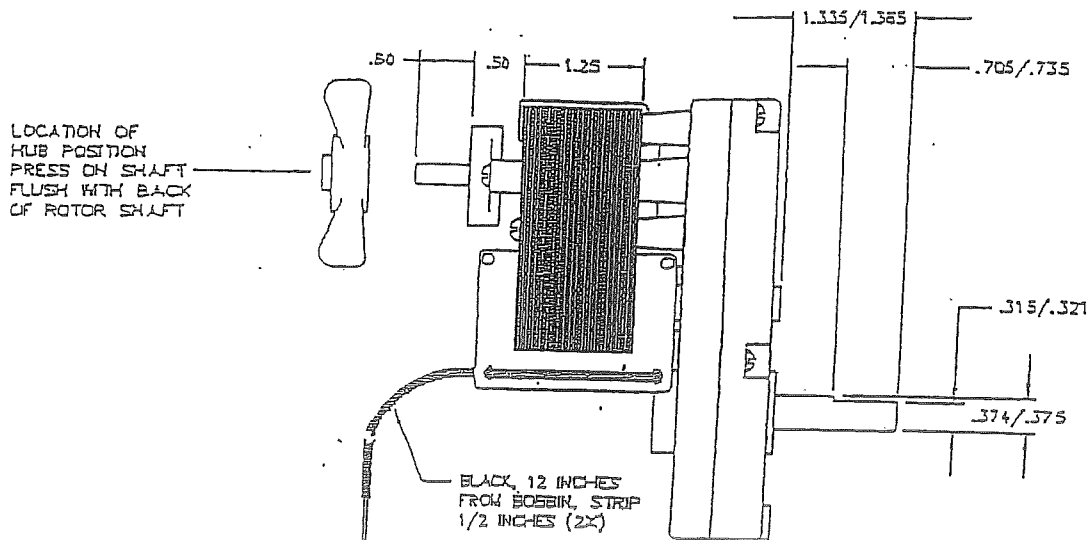
184389



Installation instructions For

SM 433641
Feed Motor

Please make sure when fan is installed,
that the fan is flush with the shaft.

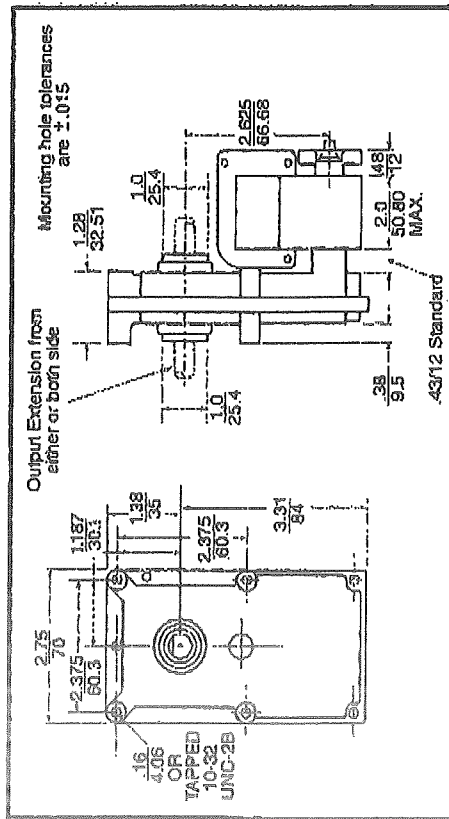
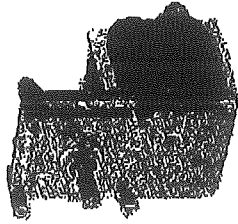




Scott Plooster
Sales Engineer

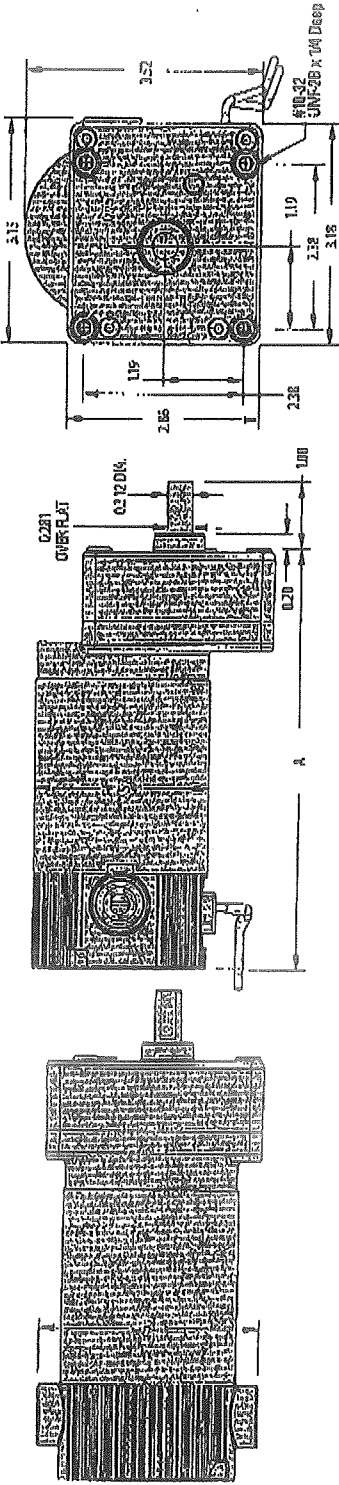
MINARIK CORPORATION
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Ron,

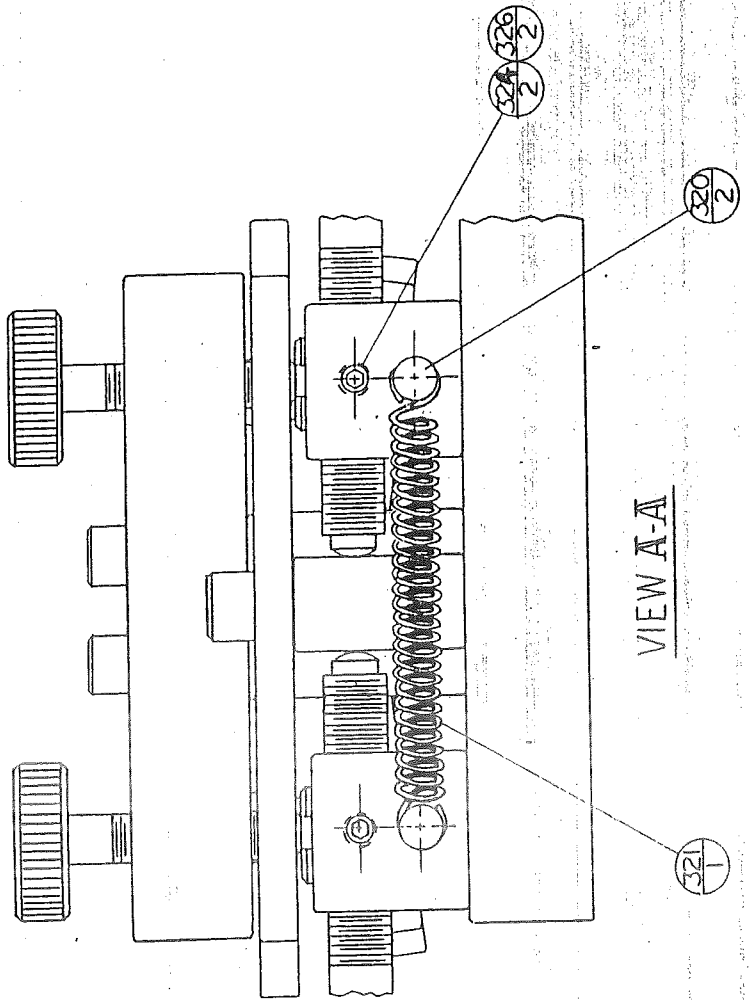
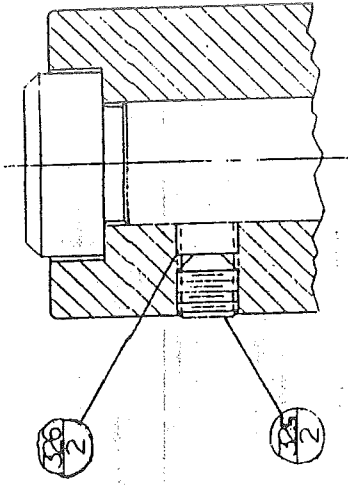
This is a motor I can get for you to replace your 90vac motor. Please check dimensionally if this is a drop in replacement. It should be close.

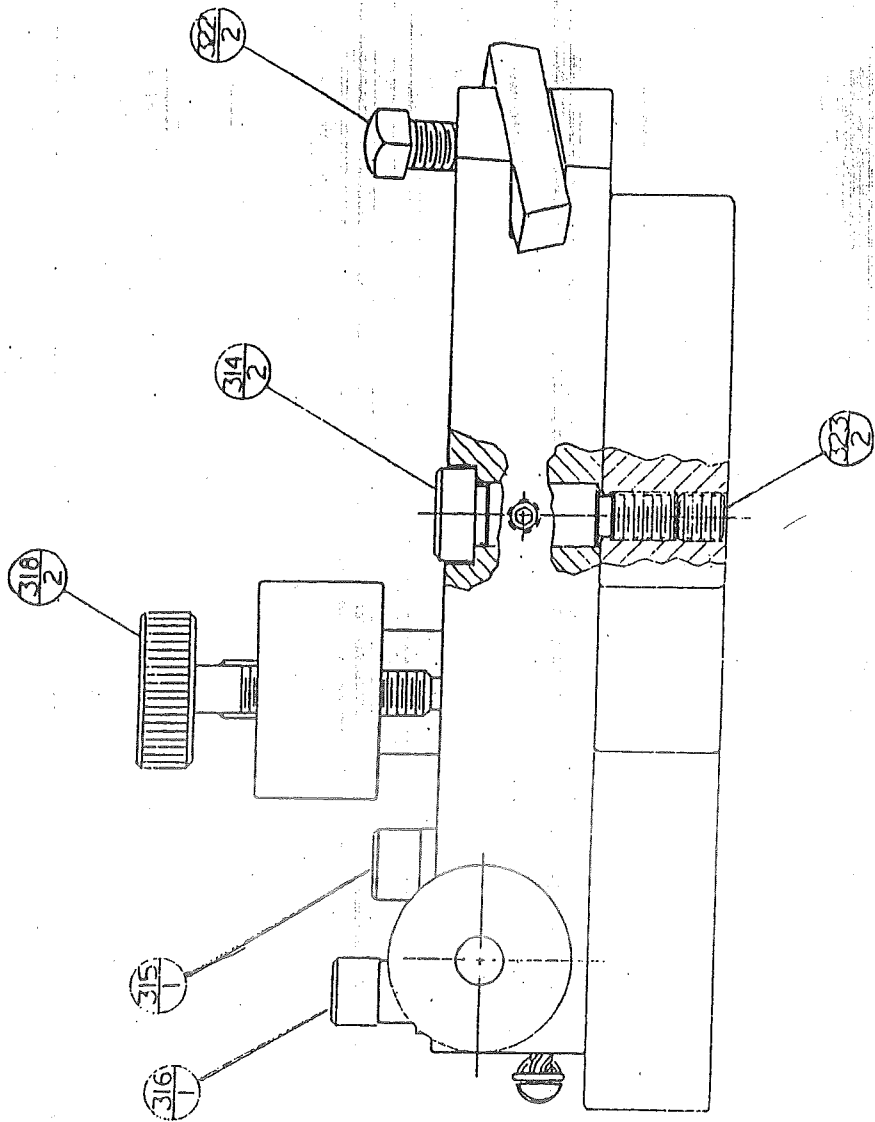


Scott Plooster
Sales Engineer

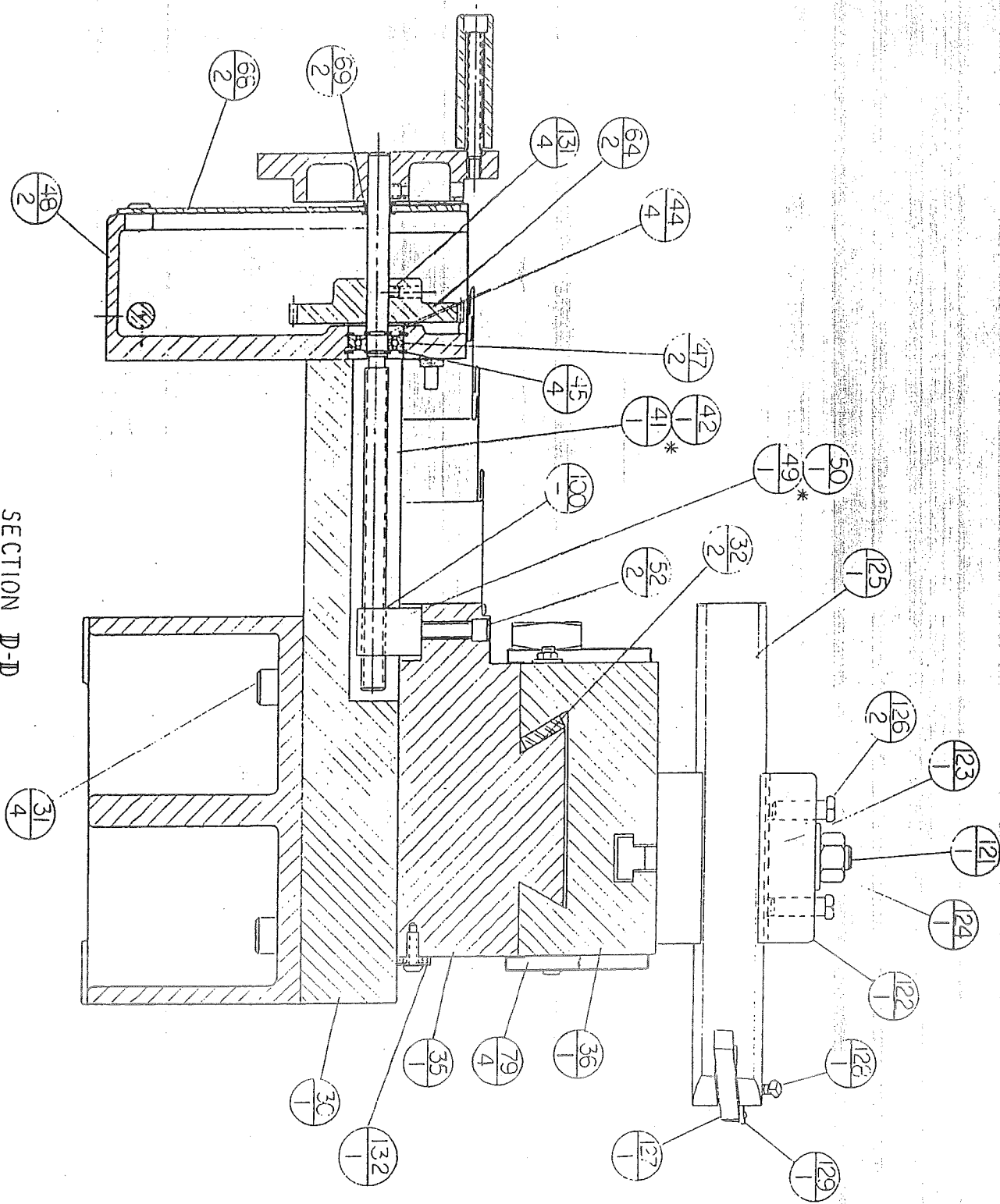
MINARIK CORPORATION
www.minarik.com

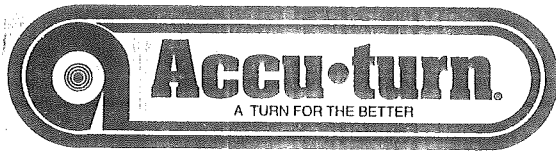
3225 Neil Armstrong Blvd Suite 600, Eagan, MN 55121
Tel: (952) 876-2944 Fax: (952) 876-2960
Cell: (612) 209-1655 E-mail: splooster@minarik.com





SECTION D-D





DEALER PARTS PRICE LIST
EFFECTIVE 10/01/95

PART #	DESCRIPTION	List Price	NUMBER	DESCRIPTION	List Price
BRAKE LATHE PARTS					
1A2169	Spring	2.00	433768	Washer, Wave	2.00
406680	Shim-Feed Screw Brng.	8.00	433769	Screw, Drive-use #420772	N/A
408129	Seal	10.00	433770	Spring, Twin Cutter	4.00
408364	Lock Nut	13.00	433771	Screw, Set	1.00
408365	Lock Washer	4.00	433773	Ball, Nylon	1.00
408373	Ball	1.00	433777	Holder, Boring Bar	105.00
408409	Screw	1.00	433778	Boring Bar	135.00
411478	Grease #2-use #433994	1.00	433780	Screw, Set	2.00
411488	Oil, Mobil Synthetic Gear Oil	1.00	433781	Decal, Calib. 0-95 Motor	6.00
413281	Plug, Drain	1.00	433790	Wear Strip Assembly	41.00
413291	Nut, Hex	1.00	433819	Nameplate, Accu-Ind.	13.00
413294	Washer	1.00	433828	Hand Wheel Assy, Drum	101.00
417258	Screw	1.00	433829	Hand Wheel Assy, Rotor	101.00
420149	Seal	6.00	433907	Housing, Feedbox	240.00
420772	Screw, Drive	1.00	433908	Cover, Housing, Feedbox	14.00
421077	Ring, Retaining Ext.	1.00	433909	Handle, Shifter	44.00
421431	Key	4.00	433919	Operation & Maint. Manual	4.00
421643	Gaskets (pkg 1 ea/4 sizes)	4.00	433974	Screw	1.00
430866	Oil, SHC-634 Gear Oil	1.00	433994	Grease, Exxon Lidok	1.00
432413	Ring, Retaining Int.	1.00	434009	Cap Plug	1.00
433156	Rotor Feed Screw Assy	52.00	434016	Collar	6.00
433157	Drum Feed Screw Assy	48.00	434017	Snap-in Nyliner	2.00
433158	Set Screw	4.00	434081	Screw	1.00
433289	Hand Wheel Assy-use #434362	N/A	434132	Connector, Crimp-on	1.00
433611	Shim	4.00	434199	Way Wiper Assy, Center	14.00
433612	Shim	4.00	434228	Screw, Set	1.00
433613	Shim	4.00	434317	Telescoping Way Cover-8989	295.00
433616	Bearing, Conc	37.00	434359	Toggle Switch	106.00
433617	Heavy Hex Nut	1.00	434360	Toggle Decal-8911	8.00
433618	Bearing, Conc	119.00	434362	Hand Wheel	77.00
433619	Bearing, Cup	43.00	434384	Assembly, Shifting Yoke	24.00
433620	Seal	7.00	434420	Gasket .015	2.00
433622	Seal	13.00	434439	Drive Adapter	23.00
433623	Bearing, Ball	17.00	434572	Motor Base Shaft, Pivot	19.00
433625	Set Collar	17.00	434573	Motor 115/230 V, 1 phs, 1 HHP	483.00
433630	Screw	1.00	434577	Belt Guard	152.00
433635	Way Wiper Assy, Top	18.00	434578	Screw	38.00
433638	Screw	1.00	434581	Tension Bar	32.00
433639	Screw, Turn	23.00	434582	Spring Selector	18.00
433641	Motor 1/60 HP, 6 RPM	133.00	434738	Spring Washer, Belleville	6.00
433645	Ring, Retaining Ext.	1.00	434777	Chip Tray	125.00
433646	Nut, Drum Feed	43.00	434778	Peg Board Hooks	1.00
433647	Nut, Rotor Feed	43.00	434800	Yellow Cap Plug	1.00
433648	Screw	1.00	435253	Shaft, Worm	189.00
433649	Switch, Limit	43.00	435254	Gear, Worm	120.00
433651	Gear, Spur 70 Teeth	114.00	435536	Roll Pin	1.00
433652	Drive Adapter-use #434439	N/A	435586	Screw, Hex, Flanged	1.00
433653	Gear, Spur 55 Teeth	56.00	435591	Univ. Bleeder Fitting	13.00
433654	Washer	2.00	435592	Vacuum Hose w/ Fitting	39.00
433655	Spring, Conical	2.00	435593	GM Adapter Socket	22.00
433665	Hand Wheel-use #434362	N/A	435594	GM Adapter Socket Small	22.00
433666	Handle, Revolving	14.00	435596	Silencer Element	12.00
433667	Guard, Rotor Way Drive Mtr	30.00	435603	Canister Seal	10.00
433669	Decal, Calibrated 0-80 Drum	4.00	435609	Elastic Cord	18.00
433670	Motor 115/230V, 1phs/1HP-8922	347.00	435615	Breather Valve	12.00
433673	V-Belt	11.00	436105	Guard, Belt	215.00
433674	Fitting, Relief	17.00	436107	Drive Adapter	37.00
433675	Guard, Belt	30.00	436111	Sheave	37.00
433677	Guard, Drum Way Drive Mtr.	30.00	436115	Variable Controller	173.00
433682	Spacer, Way Cover	4.00	436116	D.C. Feed Motor	366.00
433684	Screw	1.00	436253	Tire	22.00
433685	Lamp	130.00	436259	Way Wiper Kit	25.00
433687	Screw	1.00	436265	Accu-Turn Sign-Bench	49.00
433688	Screw	1.00	436266	Fan	6.00
433693	Switch, Toggle	40.00	436275	Multi-Speed Decal	12.00
433695	Decal, Toggle Switch	2.00	436276	8944 Decal	9.00
433726	Motor Cord Assembly	20.00	436279	8922 Decal (Oval)	6.00
433727	Power Cord Assembly	30.00	436312	Spec Book	4.00
433732	Label, Warning	2.00	436357	Controller Knob-8944	8.00
433733	Label, Caution	2.00	436358	Controller Plate-8944	8.00
433735	Telescoping Way Cover Assy.	179.00	436368	Cal. Wheel-Inch Only	22.00
433755	Tool Holder, R.II.	124.00	436531	Rubber Mat	28.00
433756	Tool Holder, L.II.	124.00	4B4280	Washer	1.00
433759	Adj. Wheel, Twin Cutter	24.00	4B9806	Screw, Set	1.00
433760	Adjustment Screw	14.00	535622	Hub Base	197.00
433761	Calib. Wheel, Twin Cutter	24.00	535623	Taper Cone	67.00
433762	Decal, Calibrated Wheel	6.00	535624	Spacer	43.00
433765	Screw, Shoulder	6.00	535625	Nut	58.00
433766	Screw	2.00	535638	Feed Screw, Truck Drum	56.00
433767	Screw, Thumb	13.00			