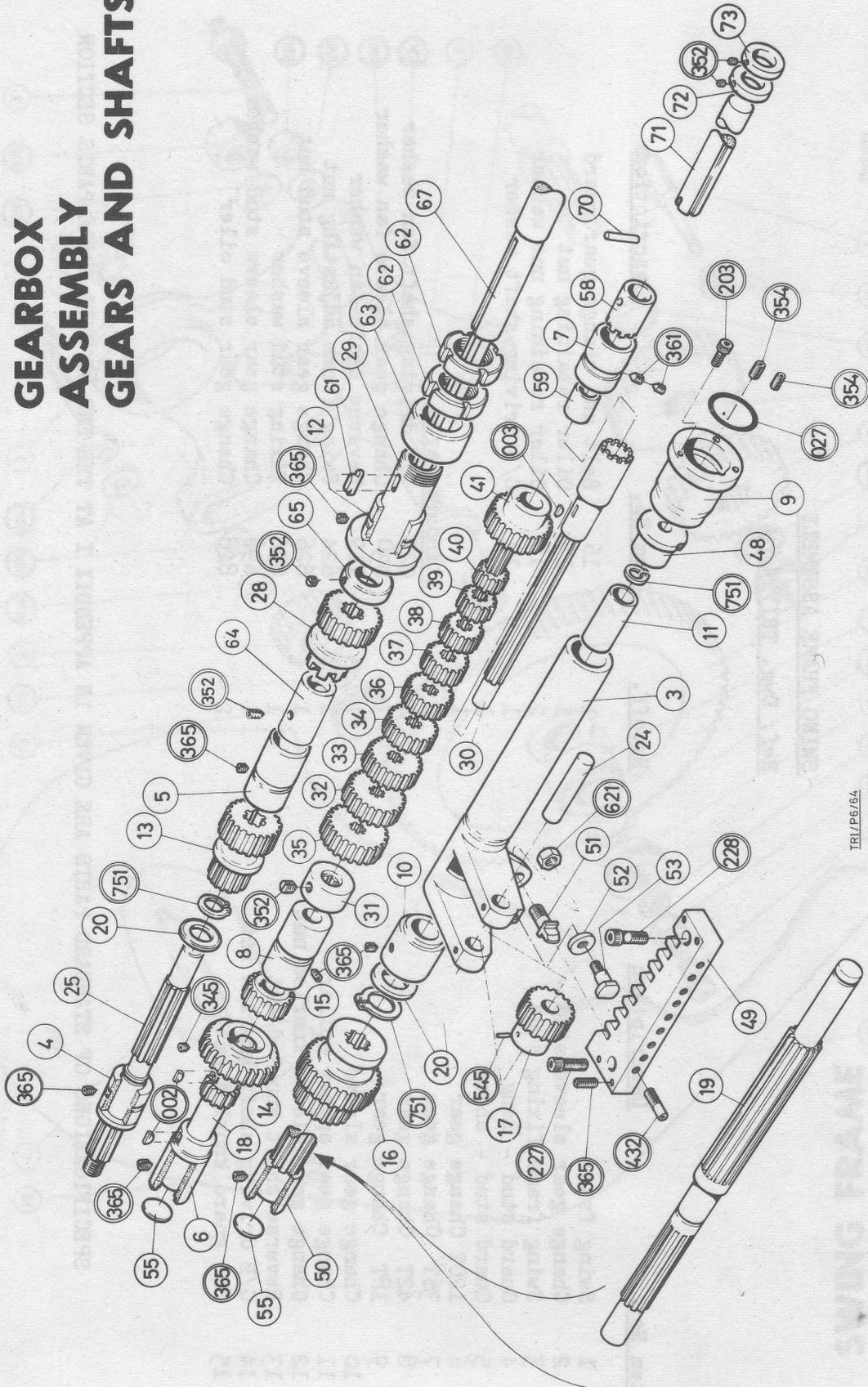




# GEARBOX ASSEMBLY GEARS AND SHAFTS



TR1/P6/64

SWING FRAME  
ASSEMBLY

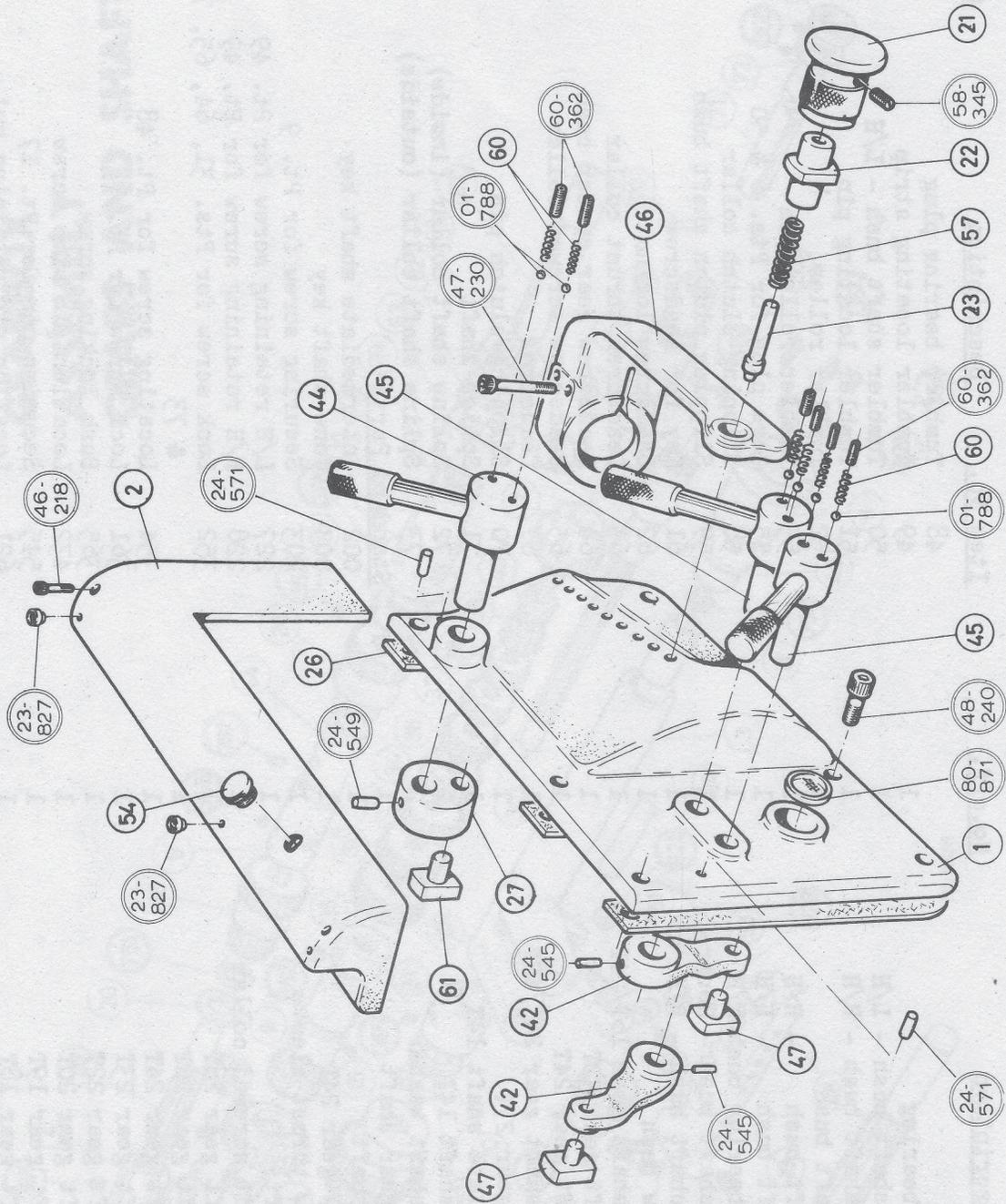
GEARBOX ASSEMBLY

Ref. Dwg. TRI/P6/64

<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>
<u>Gears and Shafts</u>					
3	Tumbler bearing	1	48	Tumbler bearing plug	1
4	Driving shaft bush - L/H	1	49	Tumbler locating strip	1
5	Driving shaft bush - R/H	1	50	Tumbler shaft bush - L/H	1
6	Inter shaft bush	1	51	Tumbler locating pin	1
7	Cone shaft bush - R/H	1	52	Tumbler roller	1
8	Cone shaft bush - L/H	1	53	Tumbler roller pin	1
9	Tumbler bearing bush-R/H	1	55	Core plug for Pts. 6 & 50	2
10	Tumbler shaft bush - Centre	1	58	Slipping clutch collar	1
11	Tumbler shaft bush - R/H	1	59	Slipping clutch shaft bush	1
12	Leadscrew bush	1	61	Key for leadscrew	1
13	Driving shaft gear 16T/24T	1	62	Leadscrew locknut	2
14	Intershaft gear 32T	1	63	Leadscrew thrust collar	1
15	Intershaft gear 24T	1	64	Leadscrew gear spacer bush	1
16	Tumbler shaft gear 24T/42T	1	65	Leadscrew screwed collar	1
17	Tumbler gear 27T	1	67	Leadscrew	1
18	Intermediate shaft 14T	1	70	Slipping clutch pin	1
19	Tumbler shaft 14T	1	71	Spline shaft	1
20	Driving shaft washer	1	72	Spline shaft collar (inside)	1
24	Tumbler gear shaft	2	73	Spline shaft collar (outside)	1
25	Driving shaft	1	<u>Standard Parts</u>		
28	Leadscrew gear 24T	1	002	Intermediate shaft key	2
29	Leadscrew thrust sleeve	1	003	Cone shaft key	1
30	Cone shaft	1	203	Securing screw for Pt. 9	3
31	Cone shaft screwed collar	1	227	L/H retaining screw for Pt. 49	1
32	Cone shaft gear 28T	1	228	R/H retaining screw for Pt. 49	1
33	Cone shaft gear 26T	1	352	Lock screw for Pts. 31, 64, 65, 72 & 73	4
34	Cone shaft gear 24T	1	354	Locating screw for Pt. 48	2
35	Cone shaft gear 23T	1	361	Lock screw for Pt. 7	2
36	Cone shaft gear 22T	1	365	Bush locking screw	1
37	Cone shaft gear 20T	1	432	Location pin stop screw	9
38	Cone shaft gear 19T	1	545	Securing pin for Pt. 17	1
39	Cone shaft gear 18T	1	621	Location pin retaining nut	1
40	Cone shaft gear 16T	1	627	Oil ring for Pt. 9	1
41	Cone shaft pinion 24T	1	751	Gear retention clip	3

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX I AT THE END OF THIS SPARE PARTS SECTION

# STANDARD GEARBOX — covers and levers



TRI/P5/64

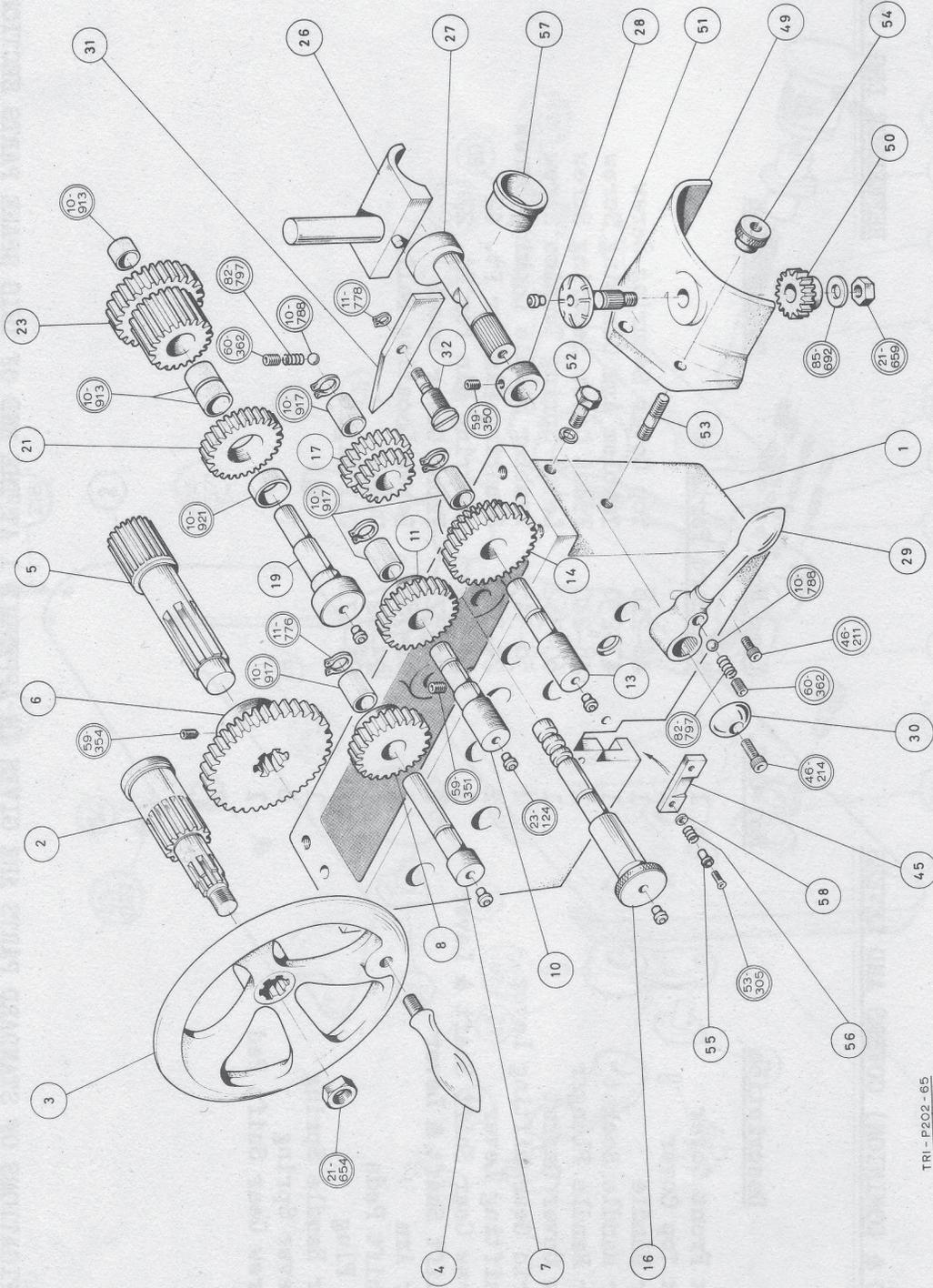
GEARBOX (STANDARD & DOMINION) COVERS AND LEVERS

REFERENCE DRG. TRI/P5/64.

<u>Item No.</u>	<u>Description</u>	<u>No. Off.</u>	<u>Item No.</u>	<u>Description</u>	<u>No. Off.</u>
1	Gearbox Front Cover	1			
2	Gearbox Top Cover	1			
21	Tumbler Handle	1			
22	Tumbler Handle Socket	1			
23	Tumbler Handle Plunger	1			
26	Gearbox Cover Gasket	1			
27	Eccentric Gearshifting Lever	1			
42	Gear Shifting Lever	2			
43/44	Leadscrew Gear Shift Shaft & Lever	1			
43/45	Gear Shift Shaft & Lever	2			
46	Tumbler Arm	1			
47	Gear Shift Pads	2			
54	Filler Plug	1			
57	Tumbler Handle Spring	1			
60	Gear Lever Spring	6			
61	Leadscrew Gear Shift Pad	1			
			<u>Standard Parts</u>		
			46-218	Top Cover Securing Screw	2
			47-230	Tumbler Arm Clamping Screw	1
			48-240	Front Cover Securing Screw	6
			60-362	Lever Spring Tension Screw	6
			58-345	Tumbler Handle Locking Screw	1
			24-545	Securing Pin for Pt. 42	2
			24-549	Securing Pin for Pt. 27	1
			24-571	Front Cover Dowel	2
			01-788	Lever Locating Balls	6
			23-827	Oiler	2
			80-871	Oil Sight	1

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX 1 AT THE END OF THIS SPARE PARTS SECTION

# APRON ASSEMBLY



TRI - P202 - 65

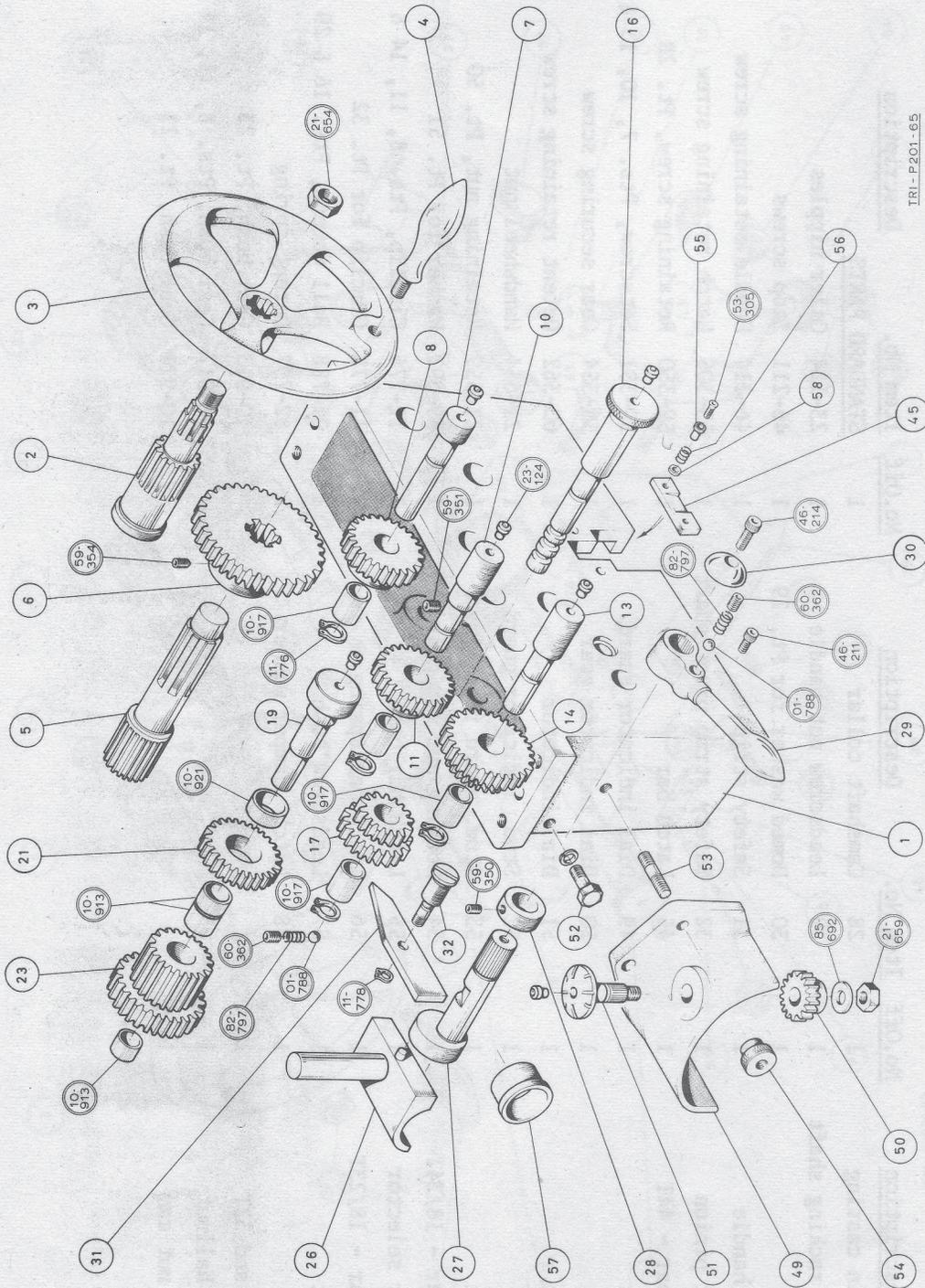
APRON ASSEMBLY

REFERENCE DRG. TRI-F202-65

<u>Item No.</u>	<u>Description</u>	<u>No. Off</u>	<u>Item No.</u>	<u>Description</u>	<u>No. Off</u>	<u>Item No.</u>	<u>Description</u>	<u>No. Off</u>
1	Apron, main casting	1	28	Camshaft collar	1	STANDARD PARTS		
2	Handwheel racking shaft	1	29	Leadscrew nut handle	1	23-124	Oiler nipples	5
3	Handwheel	1	30	Domed washer for Pt. 29	1	46-211	Stop screws	2
4	Handwheel handle	1	31	Safety strip	1	46-214	Handle retaining screw	1
5	Rack shaft pinion	1	32	Safety strip pivot shaft	1	53-305	Latch retaining screw	2
6	Sliding gear - 44T	1	45	Latch bar	1	59-350	Retaining screw, Pt. 28	1
7	Gear shaft	1	49	Dial indicator guard	1	59-351	Setscrew, Pts. 7, 10, 13 & 19	4
8	Gear, 27T	1	50	Dial indicator gear	1	59-354	Gear securing screw	1
10	Gear shaft	1	51	Dial indicator	1	60-362	Detent retaining screw	2
11	Gear, 27T	1	52	Stud, indicator guard	1	21-654	Handwheel nut	1
13	Gear shaft	1	53	Stud, guard retaining	1	21-659	Retaining nut, Pt. 50	1
14	Double gear - 18/34T	1	54	Locking nut for guard	1	85-692	Washer for Pt. 51	1
16	Shaft gear selector	1	55	Latch bar bush	2	11-776	Circlip, Pts. 8, 11, 14 & 17	4
17	Double gear - 18/23T	1	56	Latch bar spring	2	11-778	Circlip for Pt. 32	1
19	Gear shaft	1	57	Leadscrew bush	1	01-788	Ball detent, Pts. 16 & 29	2
21	Gear, 27T	1	58	Latch damper washer	2	82-797	Detent spring	2
23	Gear - 22 and 32T	1				10-913	Gear bush, Pt. 23	3
26	Leadscrew halfnut	1				10-917	Gear bush, Pts. 8, 11, 14 & 17	4
27	Leadscrew nut cam	1				10-921	Gear bush, Pt. 21	1

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX 1 AT THE END OF THIS SECTION

# APRON ASSEMBLY



TRI - P201-65

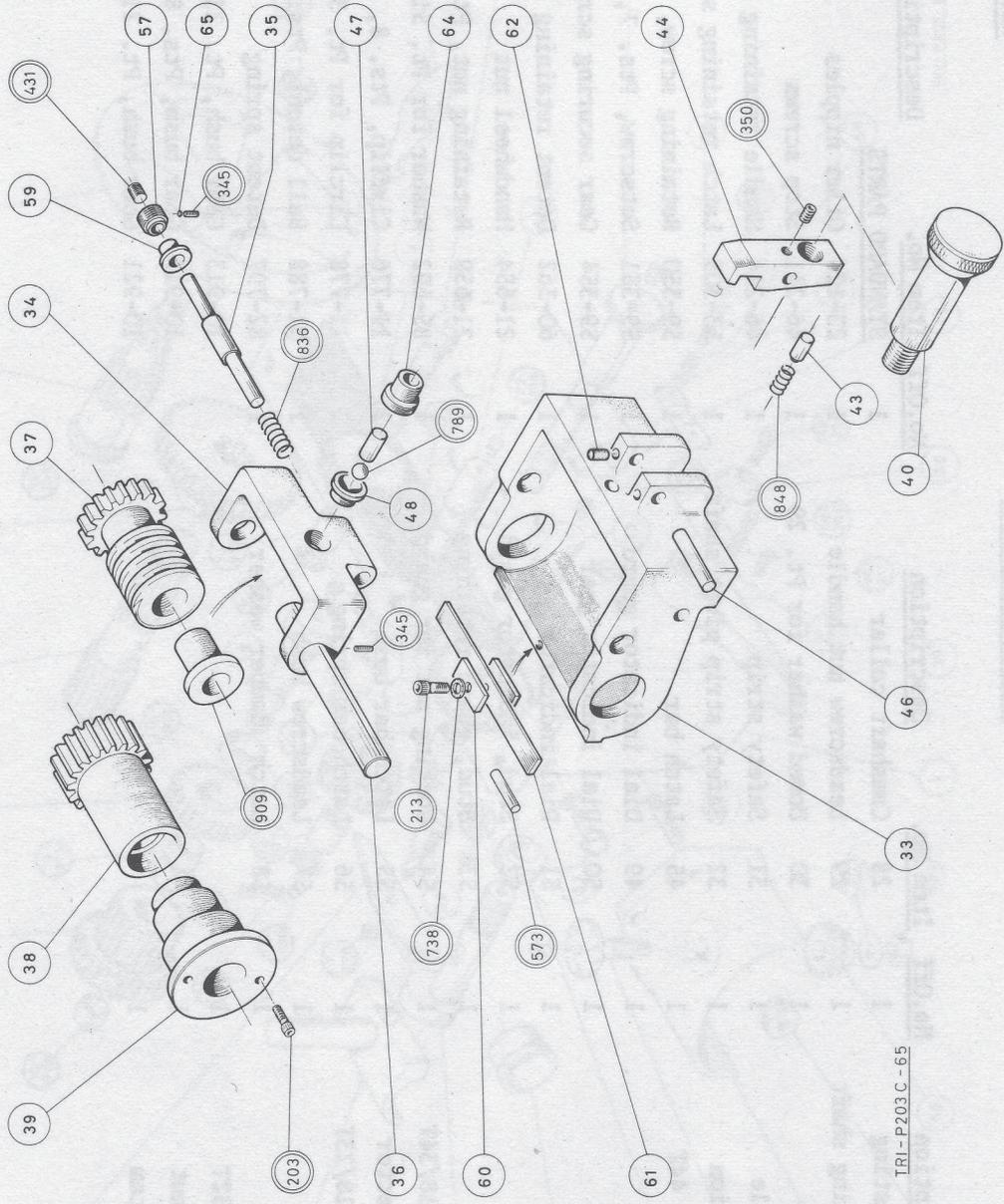
APRON ASSEMBLYGap Bed Lathes

REFERENCE DRG. TRI-P201-65

<u>Item No.</u>	<u>Description</u>	<u>No. Off</u>	<u>Item No.</u>	<u>Description</u>	<u>No. Off</u>	<u>Item No.</u>	<u>Description</u>	<u>No. Off.</u>
1	Apron, main casting	1	28	Camshaft collar	1	STANDARD PARTS		
2	Handwheel racking shaft	1	29	Leadscrew nut handle	1	23-124	Oilier nipples	5
3	Handwheel	1	30	Domed washer for Pt. 29	1	46-211	Stop screws	2
4	Handwheel handle	1	31	Safety strip	1	46-214	Handle retaining screw	1
5	Rack shaft pinion	1	32	Safety strip pivot shaft	1	53-305	Latch retaining screw	2
6	Sliding gear - 44T	1	45	Latch bar	1	59-350	Retaining screw, Pt. 28	1
7	Gear shaft	1	49	Dial indicator guard	1	59-351	Setscrew, Pts. 7, 10, 13 & 19	4
8	Gear, 27T	1	50	Dial indicator gear	1	59-354	Gear securing screw	1
10	Gear shaft	1	51	Dial indicator	1	60-362	Detent retaining screw	2
11	Gear, 27T	1	52	Stud, indicator guard	1	21-654	Handwheel nut	1
13	Gear shaft	1	53	Stud, guard retaining	1	21-659	Retaining nut, Pt. 50	1
14	Double gear - 18/34T	1	54	Locking nut for guard	1	85-692	Washer for Pt. 51	1
16	Shaft gear selector	1	55	Latch bar bush	2	11-776	Circlip, Pts. 8, 11, 14 & 17	4
17	Double gear - 18/25T	1	56	Latch bar spring	2	11-778	Circlip for Pt. 32	1
19	Gear shaft	1	57	Leadscrew bush	1	01-788	Ball detent, Pts. 16 & 29	2
21	Gear, 27T	1	58	Latch damper washer	2	82-797	Detent spring	2
23	Gear - 22 and 32T	1				10-913	Gear bush, Pt. 23	3
26	Leadscrew halfnut	1				10-917	Gear bush, Pts. 8, 11, 14 & 17	4
27	Leadscrew nut cam	1				10-921	Gear bush, Pt. 21	1

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX 1 AT THE END OF THIS SECTION

# APRON



TRI-P203 C - 65





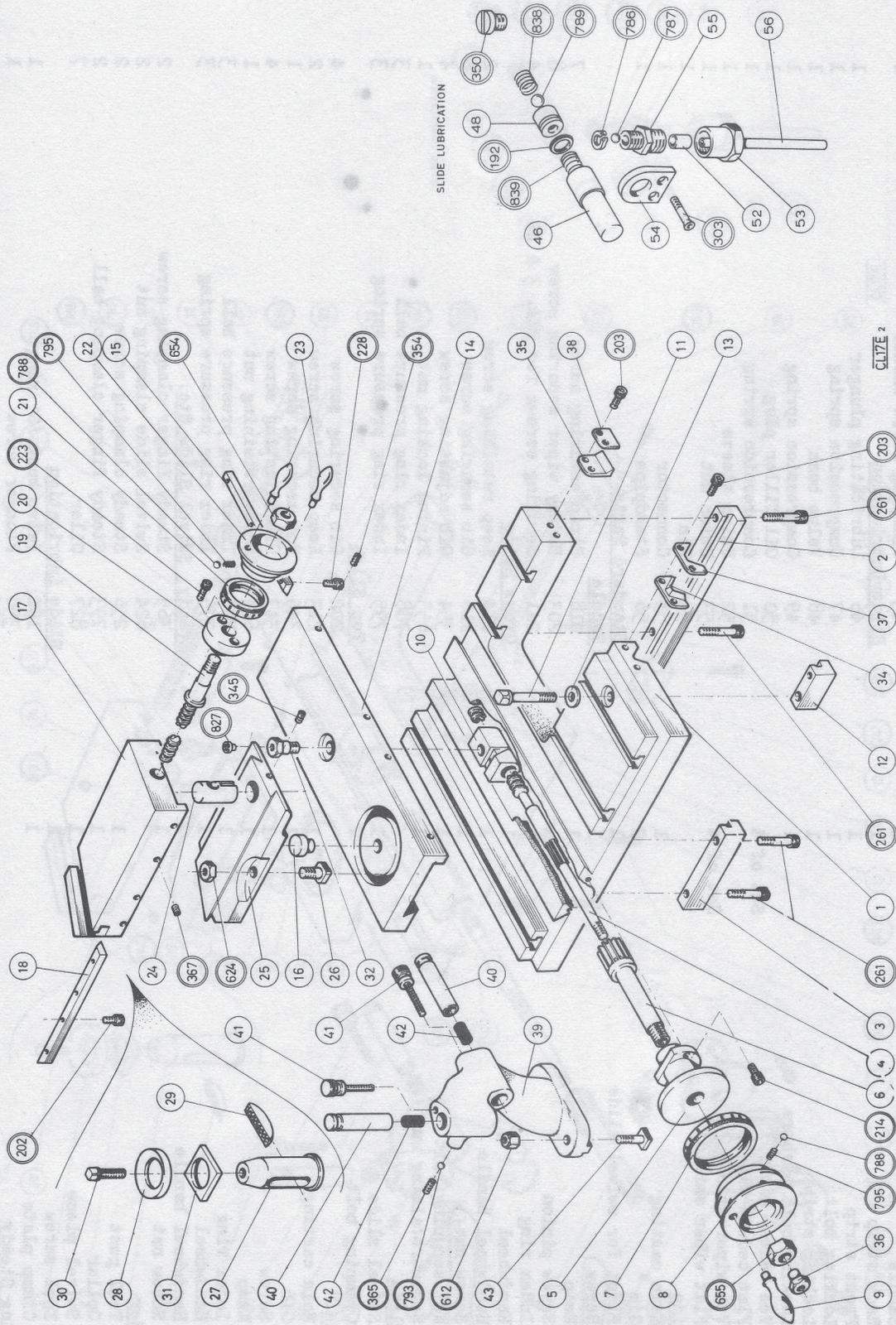
SADDLE AND SLIDES ASSEMBLY - Straight Bed Lathes

Ref. Dwg. CL17EL

<u>Item No.</u>	<u>Description</u>	<u>No. off.</u>	<u>Item No.</u>	<u>Description</u>	<u>No. off.</u>
<u>Saddle</u>					
1	Saddle	1	42	Finger insert	2
2	Back strip	1	43	Clamping screw washer	2
3	Front strip	1	<u>Slide Lubrication</u>		
11	Locking bolt	1	46	Lubricating plunger	1
12	Locking strip	1	47	Compression spring	1
13	Locking bolt washers	1	48	Valve bush	1
34	Vee bedway wiper )		49	Compression spring	1
35	Flat bedway wiper )	Set of 4	50	Oil filler plug	1
37	Vee wiper shield )		51	Compression spring	1
38	Flat wiper shield )	Set of 4	52	Union sleeve	1
			53	Union nut	1
			54	Pin	1
<u>Cross Slide</u>			55	Connector	1
14	Main casting	1	56	Standpipe	1
15	Gib	2	<u>Standard Parts</u>		
16	Pivot for swivel slide	1	<u>Saddle</u>		
4	Screw	1	018	Strip securing screw	7
5	Keep	1	203	Bedway wiper securing screw	8
6	Screw pinion	1	241	Securing screws for Pts. 3 & 12	4
7	Index ring	1	<u>Cross Slide</u>		
8	Handwheel	1	214	Keep retaining screw	2
9	Handwheel handle	1	216	Gib securing screw	6
10	Screw nut	1	354	Gib adjusting screw	4
32	Nut securing bolt	1	655	Pinion locking nut	1
36	Screw retaining nut	1	788	Index ring pressure ball	3
<u>Swivel Slide</u>			795	Index ring pressure spring	3
25	Swivel slide	1	<u>Top Slide</u>		
26	Clamping bolt	2	202	Gib securing screw	4
<u>Top Slide</u>			213	Keep securing screw	2
17	Main casting	1	345	Nut securing screw	1
18	Gib	1	347	Gib adjusting screw	4
19	Screw	1	654	Screw retaining nut	1
20	Keep	1	788	Index ring pressure ball	3
21	Index ring	1	795	Index ring pressure spring	3
22	Handwheel	1	<u>Steady, Swivel Slide Etc.</u>		
23	Handwheel handle	2	365	Steady finger clamping screw	2
24	Screw nut	1	624	Swivel slide clamping nut	2
<u>Toolholder</u>			256	Steady clamping screw	2
27	Tool post	1	793	Steady finger clamping ball	2
28	Collar	1	827	Oiler	7
29	Swivel piece	1	<u>Slide Lubrication</u>		
30	Tool screw	1	192	Valve bush 'O' ring	1
31	Clamp plate	1	350	Plunger screw	1
<u>Travelling Steady</u>			786	Connector ball	1
39	Main casting	1	787	Lubricating plunger ball	1
40	Finger	2	789	Valve bush ball	1
41	Finger adjusting screw	2			

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX I AT THE END OF THIS SPARE PARTS SECTION

# SADDLE AND SLIDES GAP BED LATHES



SLIDE LUBRICATION

CLITE 2

SADDLE AND SLIDES ASSEMBLY - Gap Bed Lathes

Ref. Dwg. CLI17E2

Item No.	Description	No. off.	Item No.	Description	No. off.
1	Saddle	1	20	Keep	1
2	Back strip	1	21	Index ring	1
3	Front strip	1	22	Handwheel	1
11	Locking bolt	1	23	Handwheel handle	1
12	Locking strip	1	25	Screw nut	1
13	Locking bolt washer	1			
34	Vee bedway wiper )	set of 4	<u>Toolpost</u>		
35	Flat bedway wiper )	set of 4	27	Toolpost	1
37	Vee wiper shield )		28	Collar	1
38	Flat wiper shield )		29	Swivel piece	1
			30	Toolpost screw	1
			31	Clamp plate	1
				<u>Travelling Steady</u>	
14	Main casting	1	39	Main casting	1
15	Gib	2	41	Finger adjusting screw	2
16	Pivot for swivel slide	1	40	Finger	1
4	Screw	1	42	Finger insert	1
6	Screw pinion	1	43	Clamping bolt	1
5	Keep	1		<u>Slide Lubrication</u>	
7	Index ring	1	46	Lubricating plunger	1
8	Handwheel	1	48	Valve bush	1
9	Handwheel handle	1	52	Union sleeve	1
10	Screw nut	1	53	Union nut	1
32	Nut securing bolt	1	54	Plunger retaining plate	1
36	Screw retaining nut	1	55	Connector	1
			56	Standpipe	1
				<u>Standard Parts</u>	
			<u>Saddle</u>		
26	Swivel slide	1	261	Saddle strip securing screw	6
27	Clamping bolt	1	203	Bedway wiper securing screw	8
			<u>Top Slide</u>		
17	Main casting	1	202	Gib securing screw	4
18	Gib	1	367	Gib adjusting screw	4
19	Screw	1	654	Screw retaining nut	1
			788	Index ring pressure ball	3
			795	Index ring pressure spring	3
			223	Nut securing screw	1
			223	Keep securing screw	2
				<u>Steady, Swivel Slide, Etc.</u>	
			365	Steady finger clamping screw	2
			793	Steady finger clamping ball	2
			612	Steady clamping nut	2
			624	Swivel slide clamping nut	2
			827	Oiler	7
				<u>Slide Lubrication</u>	
			192	Valve bush 'O' ring	1
			350	Plunger screw	1
			787	Connector ball	1
			789	Valve bush ball	1
			839	Plunger spring	1
			838	Valve spring	1
			350	Oil filler plug	1
			786	Circlip	1

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX I AT THE END OF THIS SPARE PARTS SECTION



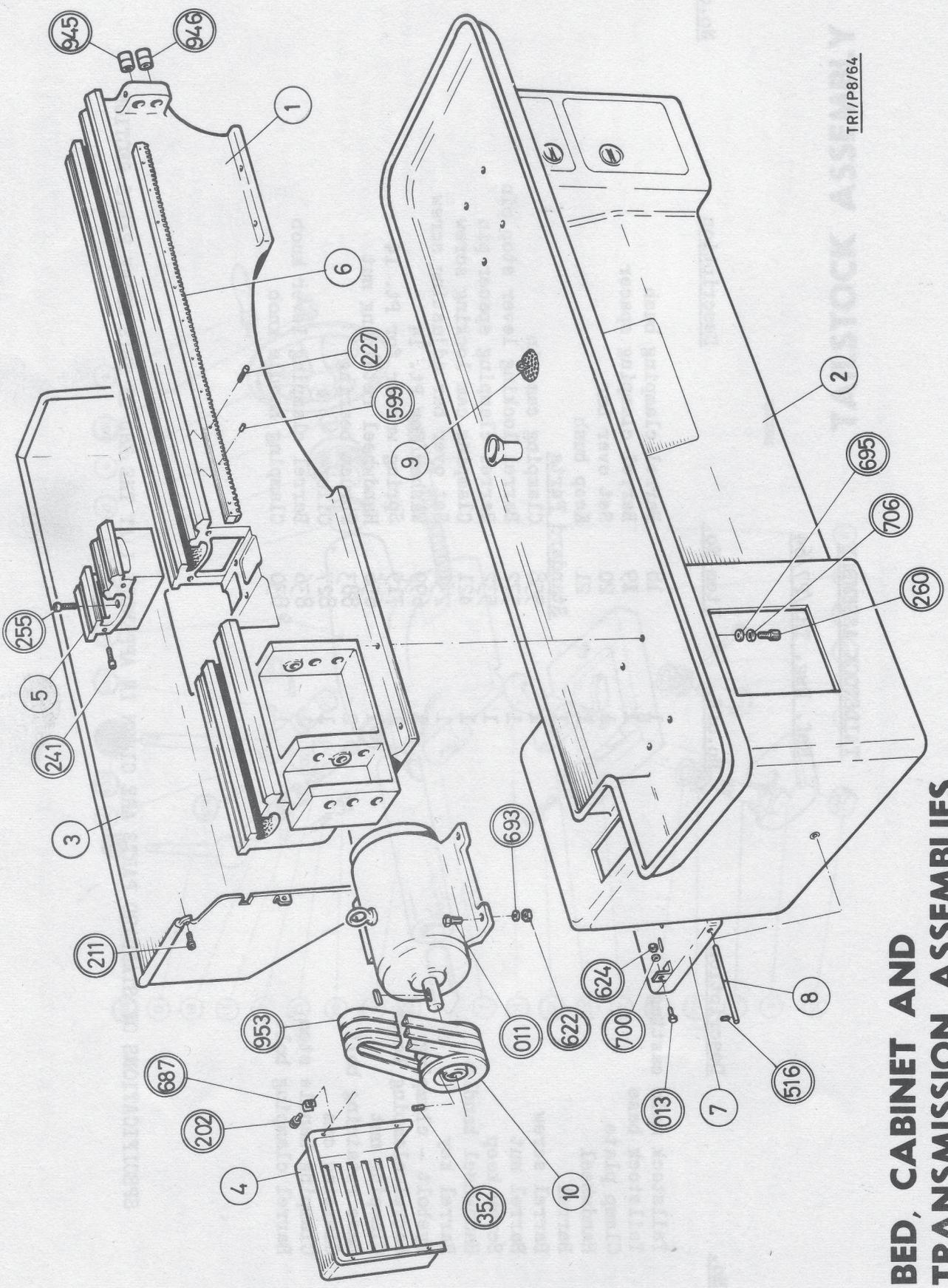
TAILSTOCK ASSEMBLY

Ref. Dwg. TRI/P7/64

<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>
1	Tailstock main casting	1	18	Barrel clamping bush	2
2	Tailstock base	1	19	Barrel clamping spacer	1
3	Clamp plate	1	20	Set over bar	1
4	Handwheel	1	21	Keep bush	1
5	Barrel	1	<u>Standard Parts</u>		
6	Barrel screw	1	558	Clamping cam pin	1
7	Barrel nut	1	572	Barrel locking lever stop pin	1
8	Screw keep	1	532	Barrel clamping spacer pin	1
9	Handwheel handle	1	421	Clamping cam locking screw	1
10	Barrel key	1	231	Set over bar adjusting screw	2
11	Eyebolt - clamping	1	699	Washer for Pt. 14	2
12	Barrel clamping lever	1	719	Spring washer for Pt. 14	2
13	Clamping nut	1	656	Handwheel retaining nut	1
14	Base retaining bolt	2	883	Thrust bearing	1
15	Clamping cam	1	827	Oiler	3
16	Clamping handle stem	1	836	Barrel clamping lever knob	1
17	Barrel clamping bolt	1	830	Clamping handle knob	1

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX I AT THE END OF THIS SPARE PARTS SECTION

TRI/P8/64



# BED, CABINET AND TRANSMISSION ASSEMBLIES

BED, CABINET AND TRANSMISSION ASSEMBLIES

Ref. DWG. TRI/P8/64

<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>
1	Bed	1	202	Securing screw for Pt. 4	7
2	Cabinet	1	516	Pivot rod clamping screw	1
3	Splash guard	1	352	Motor pulley securing screw	1
4	Motor compartment cover	1	013	Motor platform securing bolt	1
5	Gap piece	1	011	Motor securing bolt	4
6	Rack	1	695	Bed securing washer	8
7	Motor platform	1	693	Motor securing washer	4
8	Motor plate pivot rod	1	599	Rack dowels	5
9	Coolant filter	1	624	Nut for Pt. 13	1
10	Motor pulley	1	622	Nut for Pt. 11	4
	<u>Standard Parts</u>		687	Nut for Pt. 4	7
260	Bed securing screw	8	700	Motor platform securing washer	1
255	Verticle securing screw for gap piece	2	706	Spring washer for Pt. 260	8
241	Horizontal securing screw for gap piece	2	945	Leadscrew bush	2
227	Rack securing screw	6	946	Feedshaft bush	2
211	Splash guard securing screw	3	953	Vee driving belts	3

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX I AT THE END OF THIS SPARE PARTS SECTION



STEADY REST

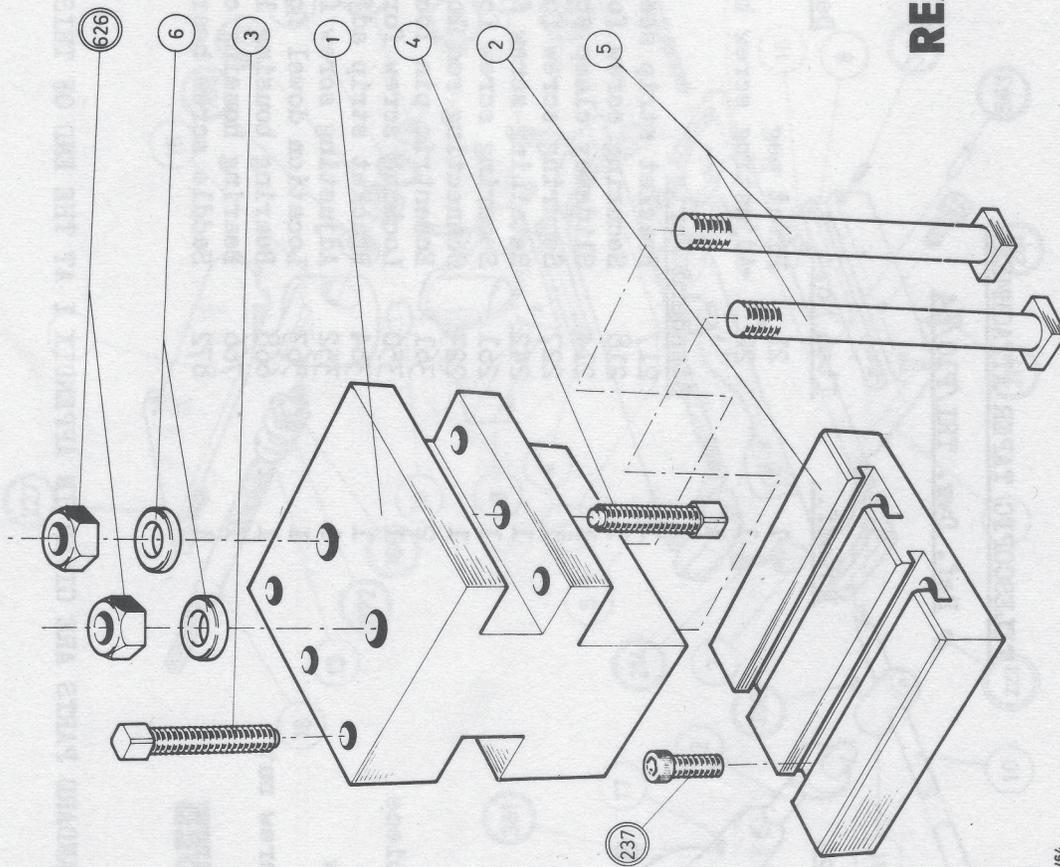
Ref. Dwg. TRI/P9/64

<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>
1	Steady main casting	1	011	Steady clamp bolt	1
2	Steady top casting	1	016	Pivot bolt	1
3	Clamp plate	1	019	Clamp plate bolt	1
4	Steady clamp fork	1	365	Steady finger guide screw	3
5	Steady finger	3	616	Steady clamp nut	1
6	Steady screw	3	639	Pivot bolt lock nut	2
7	Steady finger insert	3	698	Clamp plate bolt washer	1
8	Loop pin	1	793	Steady finger guide ball	3

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX I AT THE END OF THIS SPARE PARTS SECTION







# REAR TOOLPOST

TR/P11/64

REAR TOOLPOST

Ref. Dwg. TRI/P11/64.

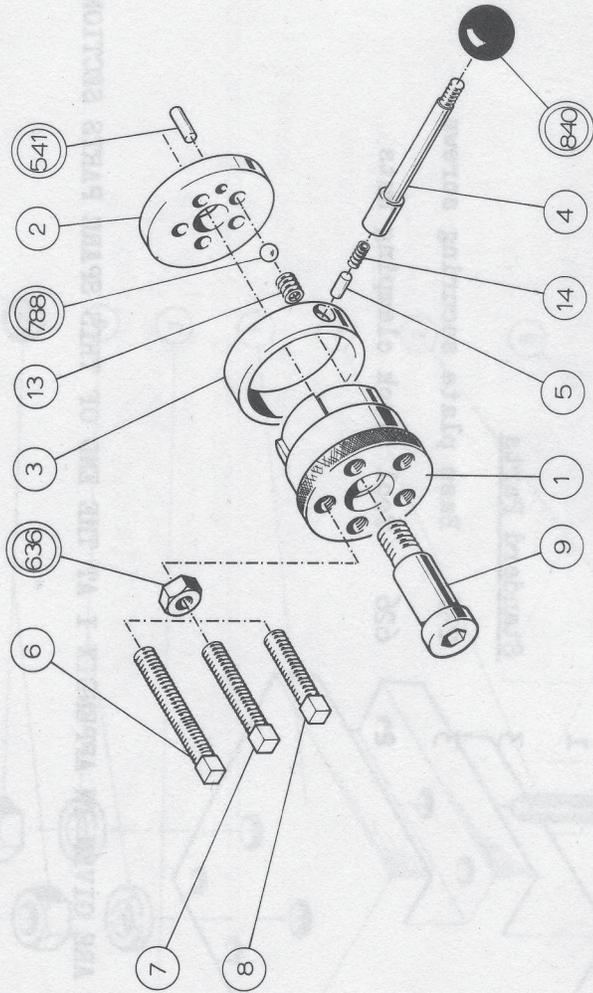
REAR TOOLPOST

Ref. Dwg. TRI/P11/64.

<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>
1	Tool block	1	6	Tool block clamping washers	2
2	Base plate	1			
3	Tool screws - long	3	<u>Standard Parts</u>		
4	Tool screws - short	3	237	Base plate securing screws	4
5	Tool block clamping bolts	2	626	Tool block clamping nuts	2

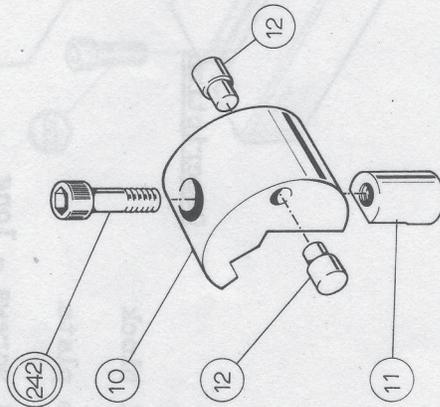
SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX I AT THE END OF THIS SPARE PARTS SECTION

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX I AT THE END OF THIS SPARE PARTS SECTION



STU/P21/63

# TURRET STOP AND BED STOP

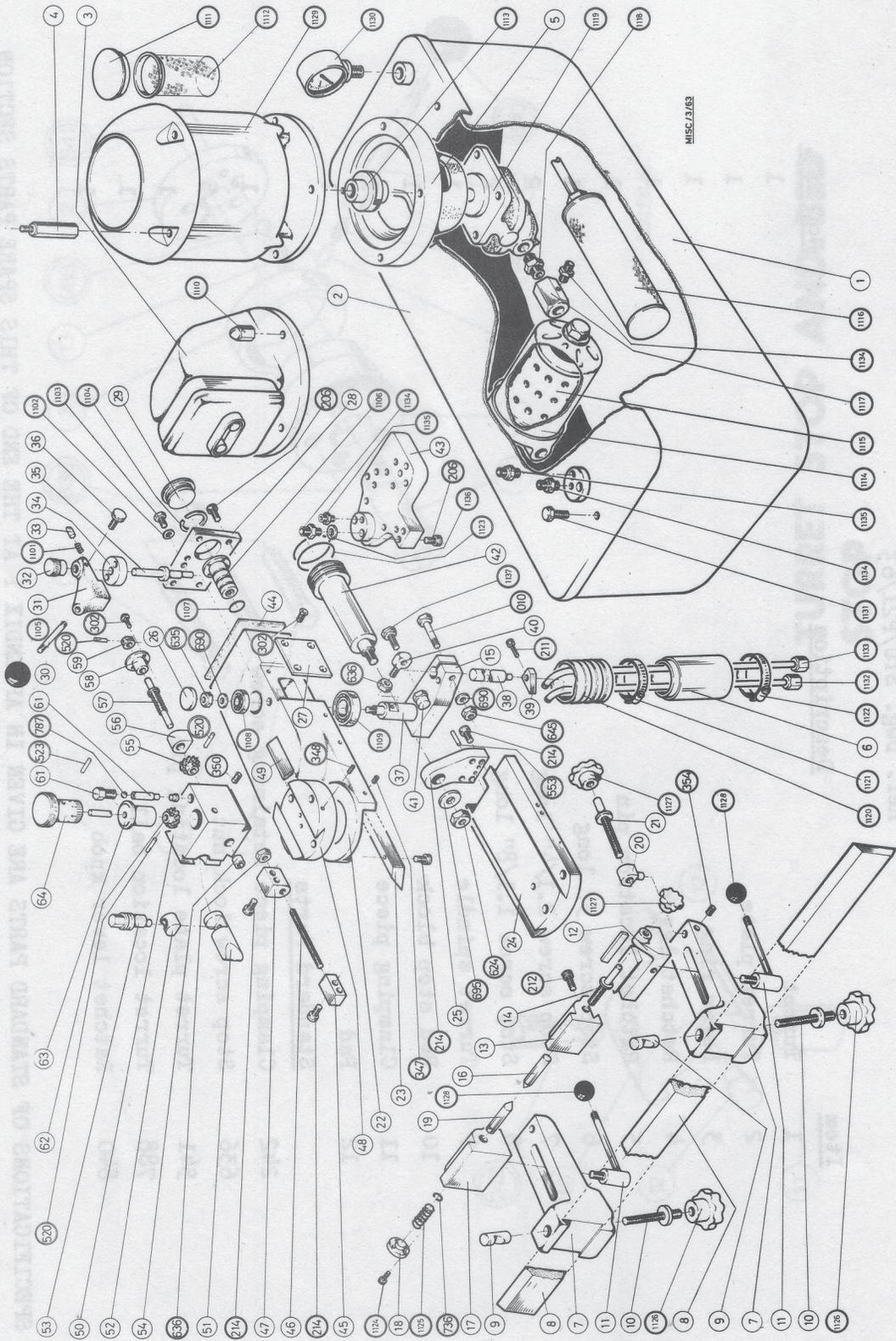


TURRET STOP AND BED STOP

Ref. Dwg. STU/P21/63

<u>Item</u>	<u>Description</u>	<u>No. off.</u>
1	Turret	1
2	Turret plate	1
3	Lever ring	1
4	Ratchet lever	1
5	Ratchet location pin	1
6	Stop screw 3" long	1
7	Stop screw 2.1/4" long	2
8	Stop screw 1.1/8" long	2
9	Turret spindle	1
10	Bed stop block	1
11	Clamping piece	1
12	Pad	1
	<u>Standard Parts</u>	
242	Clamping piece retaining screw	1
636	Stop screw lock nut	5
541	Turret plate locating pin	1
788	Turret location ball	1
840	Ratchet lever knob	1

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX I AT THE END OF THIS SPARE PARTS SECTION



# SERIES 300 HYDRAULIC PROFILING UNIT

IDENTIFICATION OR EXPLANATION OF PARTS AND SUBASSEMBLY PARTS  
 LISTED IN THIS SECTION

PARTS LIST FOR SERIES 300 HYDRAULIC PROFILING UNIT

TYPE "300" HYDRAULIC PROFILING ATTACHMENT

Ref. Dwg. MISC/3/63

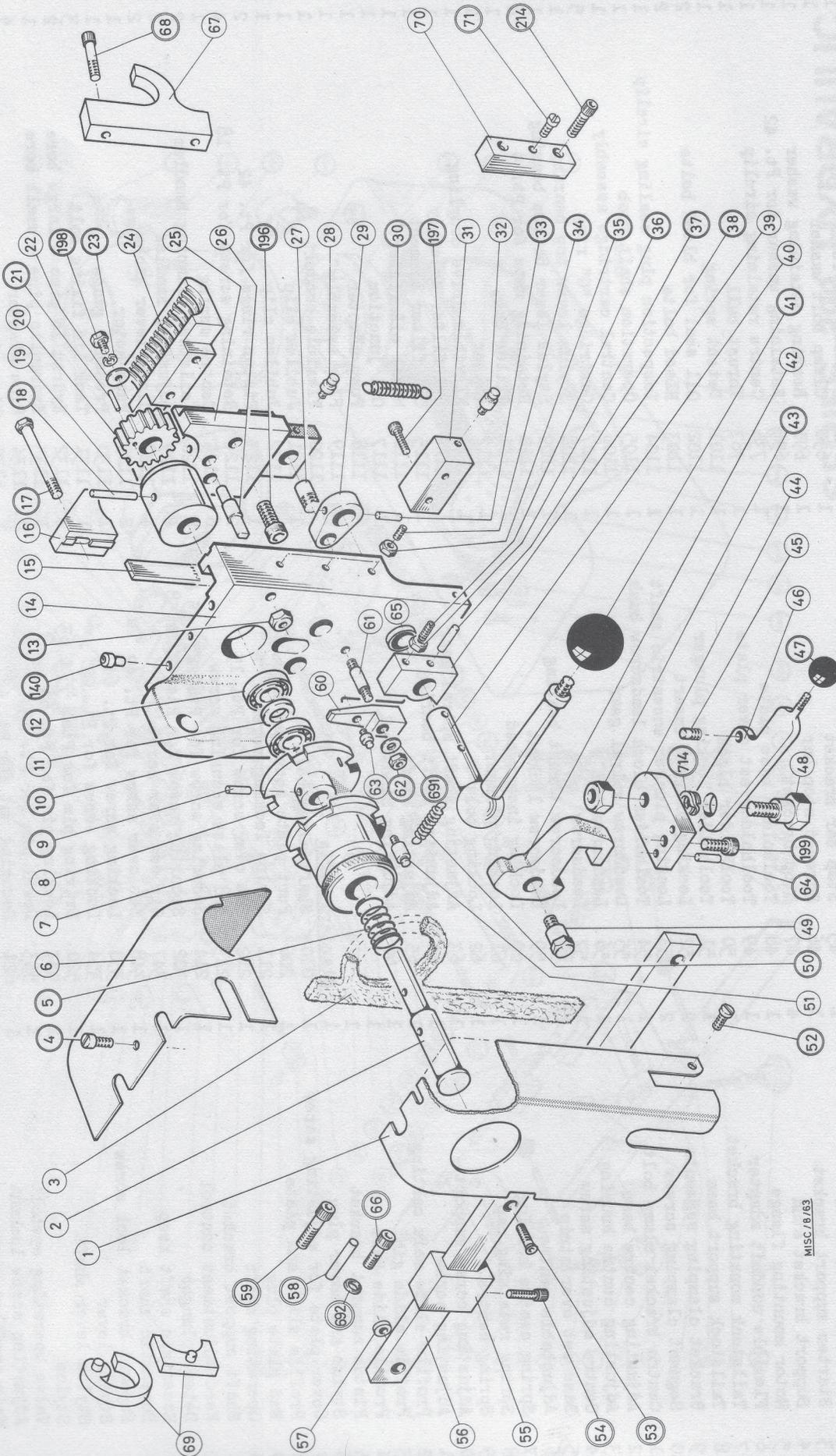
Item No.	Description	No.off.	Item No.	Description	No.off.	Item No.	Description	No.off.
1	Hydraulic tank	1	44	End plate gasket	1	645	Locking nut for Pt. 38	1
2	Hydraulic tank cover	1	45	Stop bar bracket	1	690	Clamp bolt washer	1
3	Starter support bracket	1	46	Screwed stop bar	1	691	Bearing retaining washer	1
4	Support bracket stud	4	47	Stop bracket	1	695	Retaining washer for Pt. 42	1
5	Motor mounting flange	1	48	Toolholder base plate	1	736	Centre retaining circlip	1
6	Flexible conduit adapter	1	49	Toolholder set cover plate	1	787	Thrust ball	1
7	Tailstock mounting bracket	1	50	Toolholder block	1	1101	Detent spring	1
8	Tailstock support beam	2	51	Toolholder locking plunger	1	1102	Oil seal for bleed bolts	2
9	Bracket clamping segments	1	52	Toolholder locking insert	1	1103	Bleed bolts	2
10	Segment clamping screws	2	53	Locking plunger eccentric shaft	1	1104	Inspection plug sealing circlip	1
11	Centre bracket clamp bolt	2	54	Locking plunger eccentric shaft	1	1105	Operation shaft knob	1
12	Adjusting centre base	2	55	Toolholder block leadscrew bush	1	1106	Central cartridge assembly	1
13	Adjusting centre housing	1	56	Leadscrew spiral gear	1	1107	Cartridge "O" ring	5
14	Centre adjusting screw	1	57	Leadscrew nut	1	1108	Stylus lever top bearing	1
15	Base set over strip	1	58	Leadscrew thrust bearing	1	1109	Stylus lever bottom bearing	1
16	Adjustable centre	1	59	Leadscrew locknut	1	1110	Retaining nuts for Pt. 4	4
17	Spring centre housing	1	60	Locking insert pad	1	1111	Filler cap	1
18	Spring retaining cap	1	61	Locking plunger	1	1112	Filter	1
19	Spring centre	1	62	Locking bolt	1	1113	Flexible drive coupling	1
20	Adjusting screw support	1	63	Adjusting shaft spiral gear	1	1114	Oil filter assembly	1
21	Adjusting screw	1	64	Adjusting shaft bearing	1	1115	Oil filter element	1
22	Profile slide main casting	1	65	Adjusting shaft	1	1116	Metal oil filter	1
23	Profile slide gib	1	66	Adjusting handwheel	1	1117	Oil junction	1
24	Profile slide base	1				1118	Pump adapter	1
25	Piston support bracket	1				1119	Plug assembly	1
26	Stylus arm cover plug	1				1120	Flexible conduit	1
27	Cover plate for adjusting screw	1				1121	Jubilee clip	1
28	Profile slide and plate	1				1122	Jubilee clip	1
29	End plate plug	1				1123	Piston rings for Pt. 42	2
30	Operating shaft	1				1124	Retaining screws for Pt. 18	4
31	Shaft support bracket	1				1125	Centre spring	1
32	Feed adjustment control	1				1126	Tailstock clamping handles	2
33	Detent plunger	1				1127	Adjusting handles	2
34	Eccentric shaft keep	1				1128	Clamp lever knobs	2
35	Eccentric shaft	1				1129	Pump motor	1
36	Support bracket lock screw	1				1130	Pressure gauge	1
37	Stylus lever	1				1131	Tank lid fixing bolt	3
38	Stylus lever shaft	1				1132	Hydraulic pipe - large bore	2
39	Stylus	1				1133	Hydraulic pipe - small bore	4
40	Valve operating eyebolt	1				1134	Pipe adapter	7
41	Adjusting screw locknut	1				1135	Pipe adapter	4
42	Main profiler piston	1				1136	Oil seal washers	1
43	Port plate	1				1137	Tapper screw	1

Standard Parts

010	Shaft clamp bolt	1
206	Port plate securing screw	9
211	Stylus locking screw	1
212	Set over screw for Pt. 15	2
213	End plate securing screw	6
214	Securing screw for Pts. 25, 45 & 47	8
302	Securing screw for Pts. 27 & 58	6
347	Gib set over screw	4
348	Set over screw for Pt. 49	2
350	Locking screw for Pt. 64	1
354	Locking screw for Pt. 20	1
520	Driving pin for Pts. 55 & 63	2
523	Locking pin for Pt. 66	1
553	Dowel pin for Pt. 25	2
624	Securing nut for Pt. 42	1
635	Retaining nut for Pt. 37	1
636	Locking nut for Pt. 40	1

SPECIFICATIONS OF STANDARD PARTS ARE GIVEN IN APPENDIX I AT THE END OF THIS SPARE PARTS SECTION

# RAPID-THREADER ATTACHMENT



MISC./B/63



APPENDIX 1

SPECIFICATION OF STANDARD PARTS

Item No.

001	Woodruff Key	No. 3.
002	" "	No. 9.
009	Feather Key	1/4" x 1/3" x 1".
011	Hex. Head Bolt	3/8" UNC x 1.1/4".
015	" " "	1/2" " x 1.3/4".
021	" " "	7/8" " x 4".
032	Ball Journal	Hoffman XLS 2.1/4".
058	Taper Washer	3/8" I/D x 5".
060	Oilring Type B 4/115	1/2" I/D.
061	Ball Journal	Hoffman XLS 2.
062	Oilseal - Weston W 16211237 R	1.1/8" I/D x 1.628 x 3/8".
180	Ball Journal.	Hoffman 2 1/8" x 1 1/8" x 3/8".
181	Oilseal - Weston	WB 16911037 R21.
182	Washer Dowty	List 5MK 10PP 49C.
183	Needle Bearing Ina	SC 1412. 1 1/8" x 7/8" x 3/4".
184	" " "	SC 128 1" x 3/4" x 1/2".
201	Socket Cap Head Screw	No. 10 - 24 t.p.i. x 3/8".
202	" " " "	No. 10 - 24 " x 1/2".
203	" " " "	No. 10 - 24 " x 5/8".
206	" " " "	No. 10 - 24 " x 1".
207	" " " "	No. 10 - 24 " x 1.1/4".
212	" " " "	1/4" UNC x 1/2".
213	" " " "	1/4" " x 5/8".
214	" " " "	1/4" " x 3/4".
215	" " " "	1/4" " x 7/8".
216	" " " "	1/4" " x 1".
217	" " " "	1/4" " x 1.1/4".
218	" " " "	1/4" " x 1.1/2".
219	" " " "	1/4" " x 1.3/4".
223	" " " "	5/16" " x 1/2".
225	" " " "	5/16" " x 3/4".
228	" " " "	5/16" " x 1.1/4".
229	" " " "	5/16" " x 1.1/2".
230	" " " "	5/16" " x 1.3/4".
231	" " " "	5/16" " x 2".
242	" " " "	3/8" " x 1.1/2".
246	" " " "	3/8" " x 2.1/2".
253	" " " "	7/16" " x 2".
260	" " " "	1/2" " x 1.1/2".
300	Socket Countersunk Head Screw	No. 10 - 24 t.p.i x 1/4".
314	" " " "	1/4" UNC x 1.3/8".
318	" " " "	5/16" " x 3/4".
319	" " " "	5/16" " x 1".
342	Socket Head Set Screw	No. 10 - 24 t.p.i x 3/16".
343	" " " "	No. 10 - 24 " x 1/4".
344	" " " "	No. 10 - 24 " x 5/16".
345	" " " "	No. 10 - 24 " x 3/8".
350	" " " "	1/4" UNC x 1/4".
351	" " " "	1/4" " x 5/16".
355	" " " "	1/4" " x 5/8".
361	" " " "	5/16" " x 5/16".
362	" " " "	5/16" " x 3/8".

SPECIFICATION OF STANDARD PARTS (CONTINUED)

Item No.

363	Socket Head Set Screw	5/16" UNC x 7/16".
365	" " " "	5/16" " x 5/8".
366	" " " "	5/16" " x 3/4".
378	" " " "	7/16" " x 7/16".
419	Socket Head Set Screw 1/2 dog	1/4" UNC x 3/8".
429	" " " " " "	5/16" x 3/8".
485	Socket Countersunk Head Screw	2 BA x 3/8".
495	Socket Cap Head Screw	3 BA x 5/8".
497	" " " "	3 BA x 1.1/4".
520	Mills Pin GP 1	1/8" x 1/2".
539	" " GP 3	5/16" x 1/2".
541	" " GP 3	3/16" x 5/8".
542	" " GP 3	3/16" x 3/4".
543	" " GP 3	3/16" x 7/8".
544	" " GP 3	3/16" x 1".
545	" " GP 3	3/16" x 1.1/4".
546	" " GP 3	3/16" x 1.1/2".
547	" " GP 4	3/16" x 5/8".
558	" " GP 3	1/4" x 3/8".
559	" " GP 3	1/4" x 1.1/8".
563	" " GP 3	1/4" x 1.1/4".
577	" " GP 4	5/16" x 1".
579	" " GP 3	1/8" x 5/16".
590	" " GP 3	3/8" x 1.3/4".
607	Grover Spring Dowel Pin	3/16" x 15/16".
612	Deep Nut - Steel	3/8" UNC.
621	Standard Nut - Steel	5/16" "
622	" " "	3/8" "
623	" " "	7/16" "
624	" " "	1/2" "
632	" " "	No. 10-24 t.p.i.
636	" " "	3/8" UNC.
637		
644	Thin Locknut	1/2" "
650	Nyloc Nut	3/8" UNF.
651	" "	7/16" "
652	" "	1/2" "
654	" "	5/8" "
659	Simmonds Aero Nut	5/16" UNC.
660	Nyloc Nut	3/8" "
663	Wedglock Nut	1/2" "
675	Simmonds Nut Type T	5/8" UNF.
692	BS Steel Washer	5/16" I/D.
693	" " "	3/8" I/D.
694	" " "	7/16" I/D.
695	" " "	1.1/2" I/D.
698	" " "	5/8" I/D.
716	Double Coil Spring Washer - Light Series	1/2" I/D.
718	Double Coil Spring Washer - Light Series	5/8" I/D.
725	Schnoor Disc Spring Washer Type K	Size 6201.
736	External Circlip - Type 1400 - Anderton	1/2" Dia.

SPECIFICATION OF STANDARD PARTS (CONTINUED)

Item No.

743	External Circlip - Type 1400 - Anderton	5/8" Dia.
744	External Circlip - Type 5101/66 - Salter	11/16" Dia.
745	External Circlip - Type 5101/66 - Salter	3/4" Dia.
749	External Circlip - Type 5101/66 - Salter	7/8" "
754	External Circlip - Type 5101/66 - Salter	1.1/8" Dia.
766	External Circlip - Type 1300 - Anderton	28 mm Dia.
773	Internal Circlip - Type 1300 - Anderton	3.464" Dia.
774	Internal Circlip - Type 1300 - Anderton	2.1/8" Dia.
778	"E" Type Circlip - Type 1500 - Anderton	5/16" Dia.
782	"E" Type Circlip - Type E 210 - Anderton	1.1/4" Dia.
786	Steel ball.	5/32" "
788	" "	1/4" "
789	" "	5/16" "
790	" "	3/8" "
792	" "	5/8" "
793	Pho. Bronze Ball	1/4" "
795	Compression Spring	1/4" O/D x 1/2" FL. x 22 SWG.
803	Compression Spring	5/16" O/D x 1.1/4" FL.
813	" "	1.3/8" O/D x 1" FL.
815	Extension Spring	5/16" O/D x 1.7/8" OA.
817	Standard Extension Spring	1/2" O/D x .080" x 2.3/16" OA.
827	Garland Diaphragm Oiler	1/4" Dia.
828	Winkley Oiler	5/16" Dia.
830	Plastic Knob - Black	1.1/2" O/D x 7/16" UNC.
833	" " - Red	1.1/2" O/D x 5/16" "
835	" " - Black	1.1/4" O/D x 7/16" "
836	" " - "	1.1/2" O/D x 7/16" "
838	" " - "	1" O/D x 3/8" UNC.
840	" " - "	3/4" O/D x 1/4" UNC.
841		
846	Oilring-Pioneer	P.O. 06204310.
852	" -Dowty	1.484" I/D x .139".
855	" -Pioneer	P.O./23720021.
858	" - "	P.O.52506/MP/658.
863	Oilseal-Weston W 1620037	1" I/D x 1.5/8" O/D x 3/8".
865	" -Weston W 16912537	1.1/4" I/D x 1.11/16". O/D x 3/8".
871	Oilsight - Tecalemit I.C. 4610	1.1/4" O/D.
872	Thrust Bearing	Hoffman A 10.
882	Thrust Bearing	Hoffman 5/8" WSP.
885	Thrust Bearing	Hoffman W 1.1/4".
886	Needle Bearing Ina	HK. 1516 21mm x 15mm x 16mm.
887	" " "	SC 1212 1" x 3/4" x 3/4".
888	" " "	SC 1112 7/8" x 11/16" x 3/4".
889	" " "	HK 2820 35mm x 28mm x 20mm.
906	Countersunk Head Rivet	5/32" Dia.
908	Hollow Copper Rivet	5/32" Dia.
997	Brake Shoes	4" Dia. Ferodo