

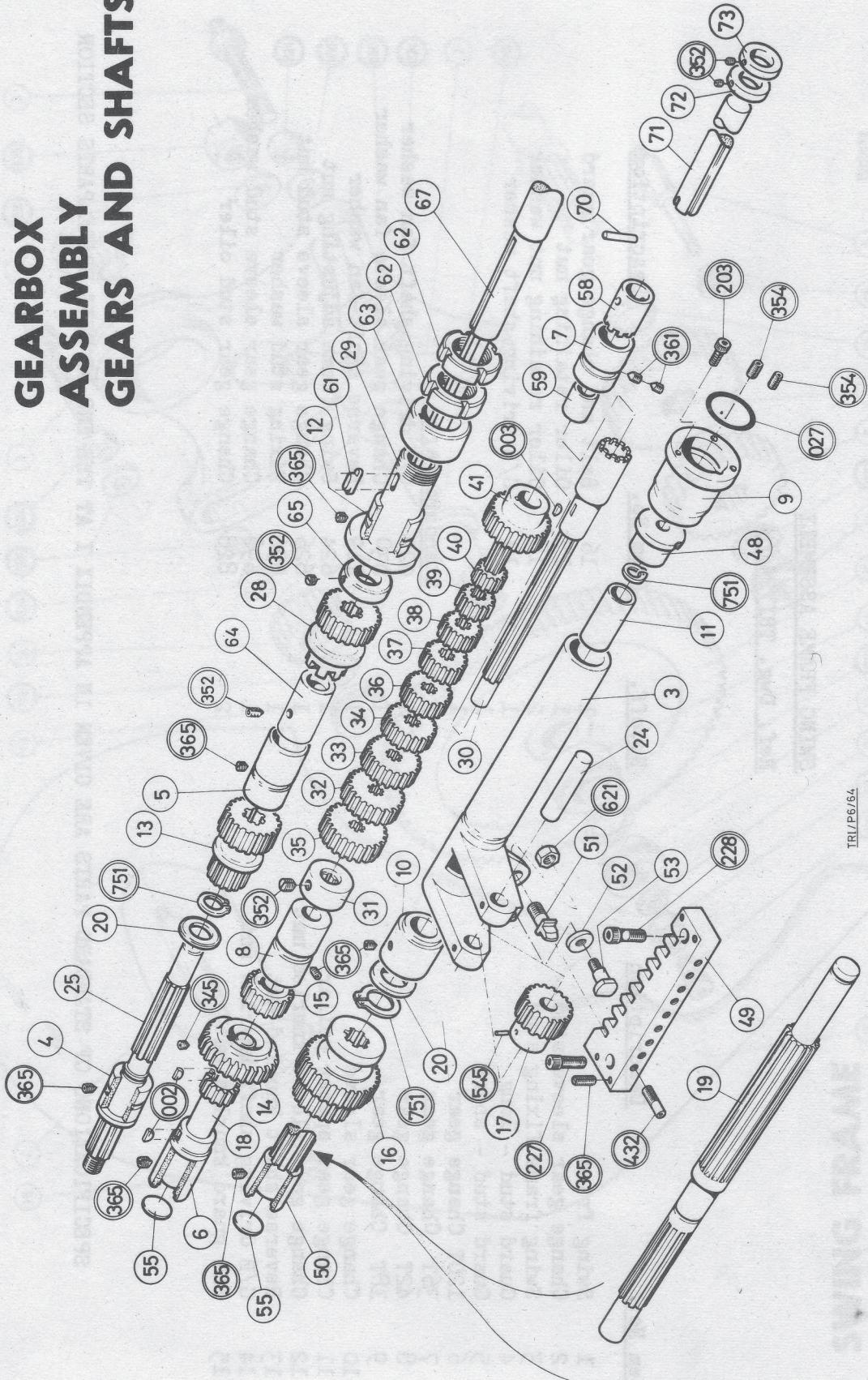
SWING FRAME ASSEMBLY

Ref. Dwg. TRI/P4/64

<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>
1	Swing frame	1	16	Belt and change gear guard	1
2	Change gear sleeve stud	1	17	Oiler retaining nut	1
3	Swing frame fixing stud	2	18	Oiler retaining nut washer	1
4	Guard stud - long	1	19	G/B driving shaft washer	1
5	Guard stud - short	1			
6	120T Change gear	1			
7	36T Change gear	1	029	G/B driving shaft fan washer	1
8	42T Change gear	1	030	Change gear sleeve fan washer	1
9	18T Change gear	1	119	Reverse shaft fan washer	2
10	Change gear sleeve	1	624	Swing frame adjusting nut	4
11	Change gear spacer collar	1	626	Change gear sleeve stud nut	1
12	Change gear sleeve knurled nut	1	696	Fixing stud washer	4
13	Reverse shaft knurled nut	1	698	Change gear sleeve stud washer	1
14	G/B driving shaft knurled nut	1	828	Change gear stud oiler	1
15	End guard knurled nut	2			

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

GEARBOX ASSEMBLY GEARS AND SHAFTS



TRI/P6/64

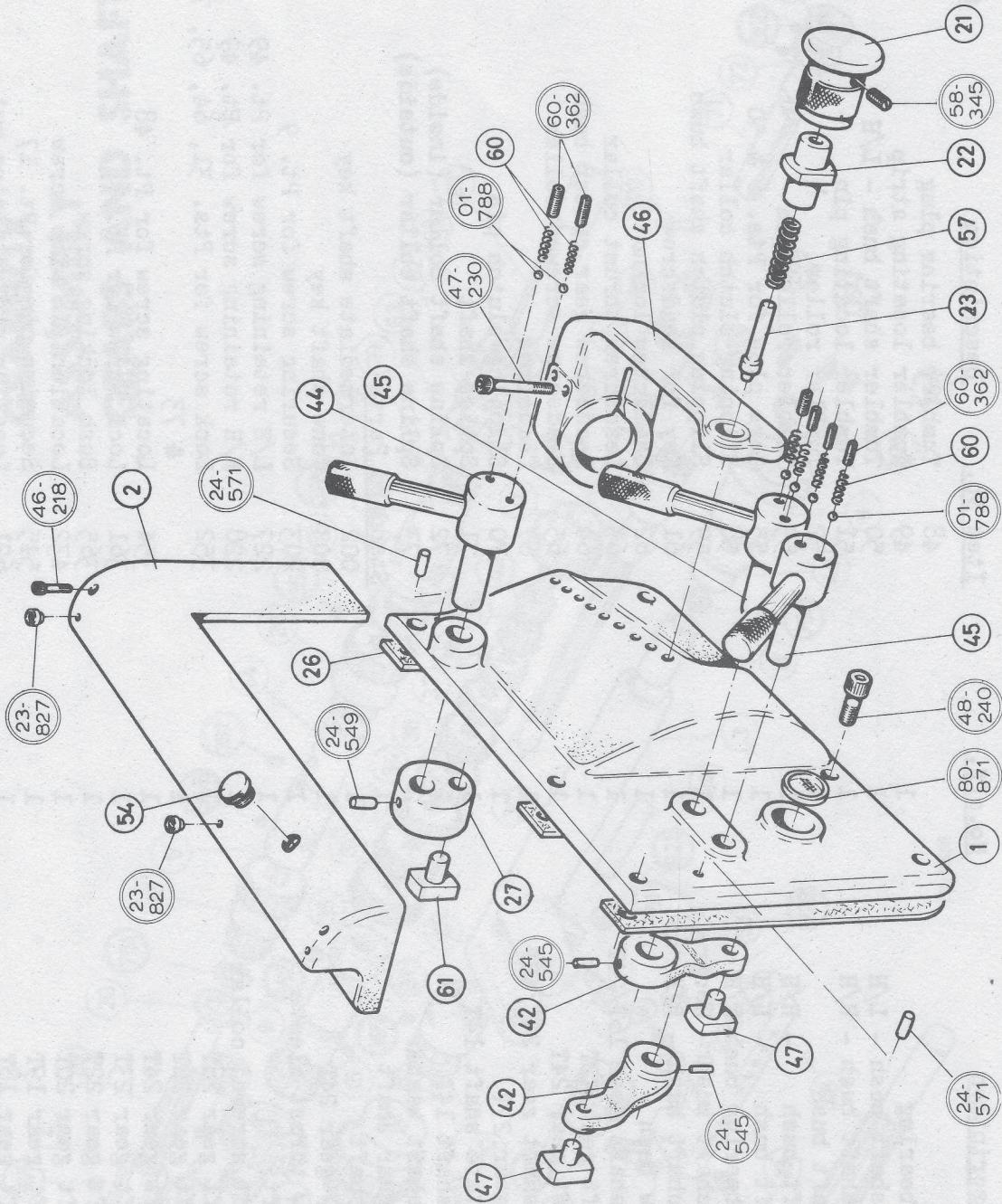
GEARBOX ASSEMBLY

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	2	72	Spline shaft collar (inside)	1
24	Tumbler gear shaft	1	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	4
34	Cone shaft gear 24T	1	& 73		
35	Cone shaft gear 25T	1	354	Locating screw for Pt. 48	2
36	Cone shaft gear 22T	1	361	Lock screw for Pt. 7	2
37	Cone shaft gear 20T	1	365	Bush locking screw	1
38	Cone shaft gear 19T	1	432	Location pin stop screw	9
39	Cone shaft gear 18T	1	545	Securing pin for Pt. 17	1
40	Cone shaft gear 16T	1	621	Location pin retaining nut	1
41	Cone shaft pinion 24T	1	627	Oil ring for Pt. 9	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

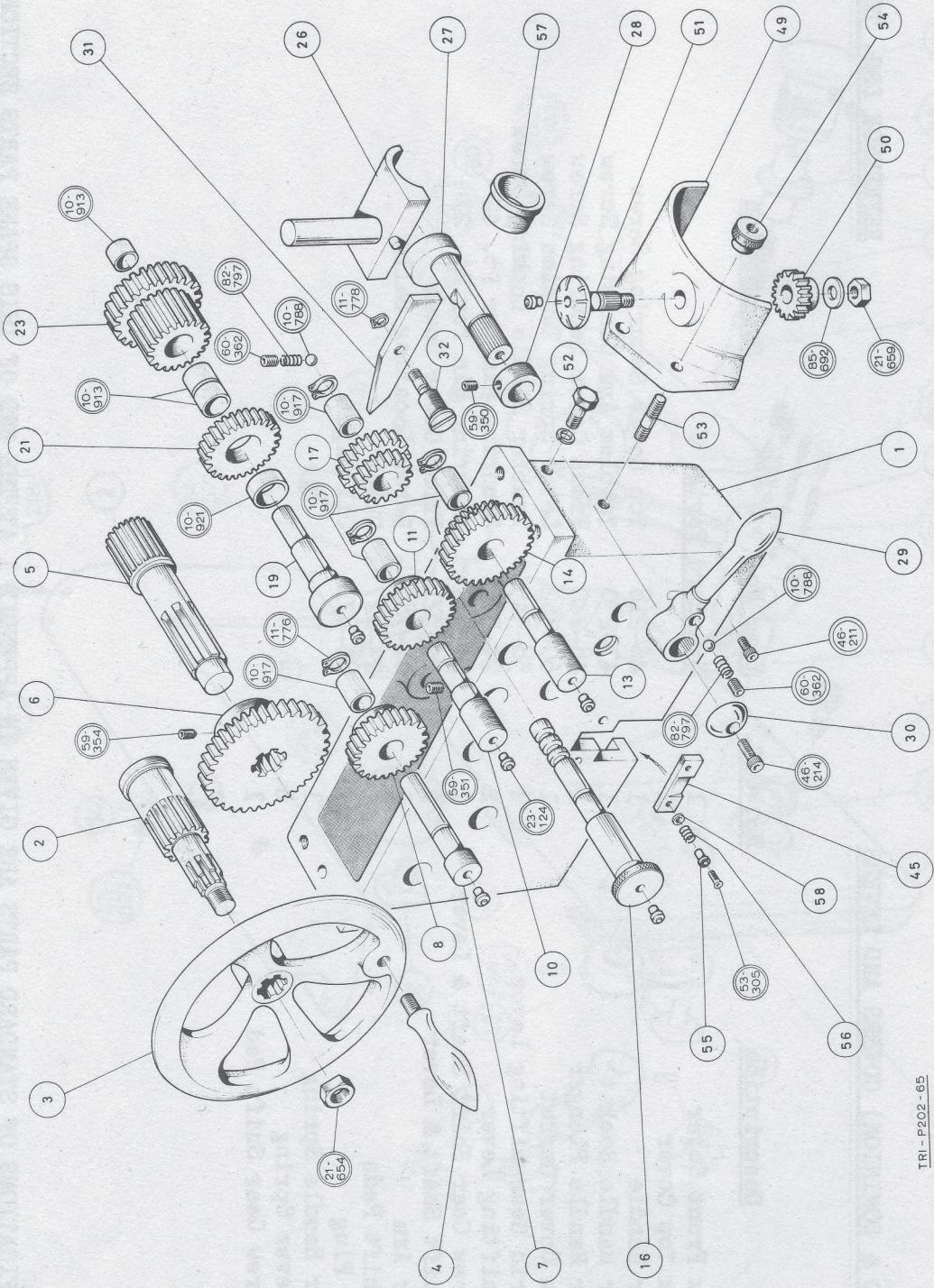
GEARBOX (STANDARD & DOMINION) COVERS AND LEVERS

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	1	Standard Parts	
2	Gearbox Top Cover	1	46-218	Top Cover Securing Screw	2
21	Tumbler Handle Socket	1	47-230	Tumbler Arm Clamping Screw	1
22	Tumbler Handle Plunger	1	48-240	Front Cover Securing Screw	6
23	Gearbox Cover Gasket	1	60-362	Lever Spring Tension Screw	6
26	Eccentric Gearshifting Lever	1	58-345	Tumbler Handle Locking Screw	1
27	Gear Shifting Lever	1	24-545	Securing Pin for Pt. 42	2
42	Leadscrew Gear Shift Shaft & Lever	2	24-549	Securing Pin for Pt. 27	2
43/44	Gear Shift Shaft & Lever	1	24-571	Front Cover Dowel	1
43/45	Gear Shift Shaft & Lever	2	01-788	Lever Locating Balls	6
46	Tumbler Arm	1	23-827	Oiler	2
47	Gear Shift Pads	2	80-871	Oil Sight	1
54	Filler Plug	1			
57	Tumbler Handle Spring	1			
60	Gear Lever Spring	6			
61	Leadscrew Gear Shift Pad	1			

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

APRON ASSEMBLY



TRI - P2002 - 65

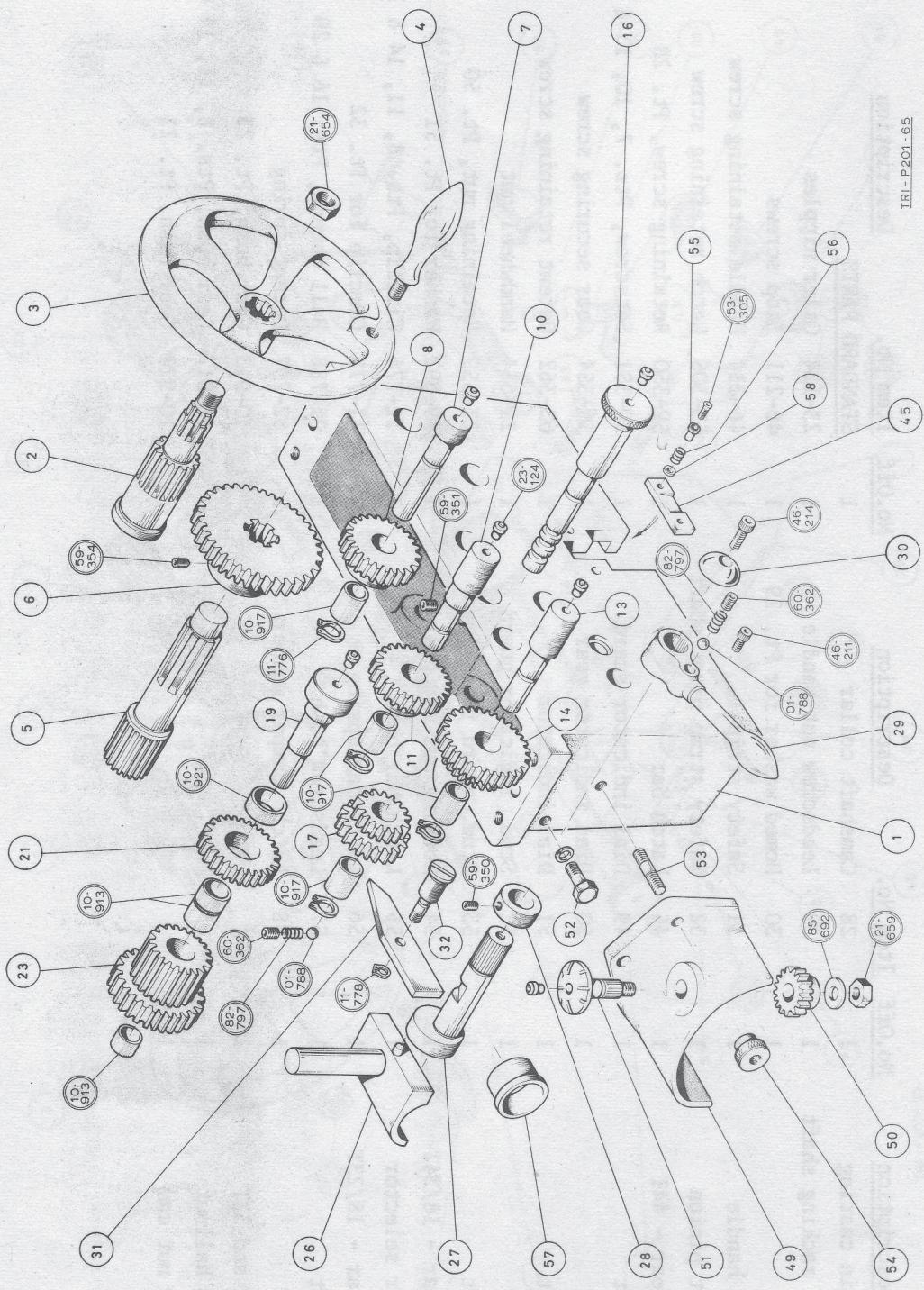
APRON ASSEMBLY

REFERENCE DRG. TRI-P202-65

<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	Headscrew 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



APRON ASSEMBLY

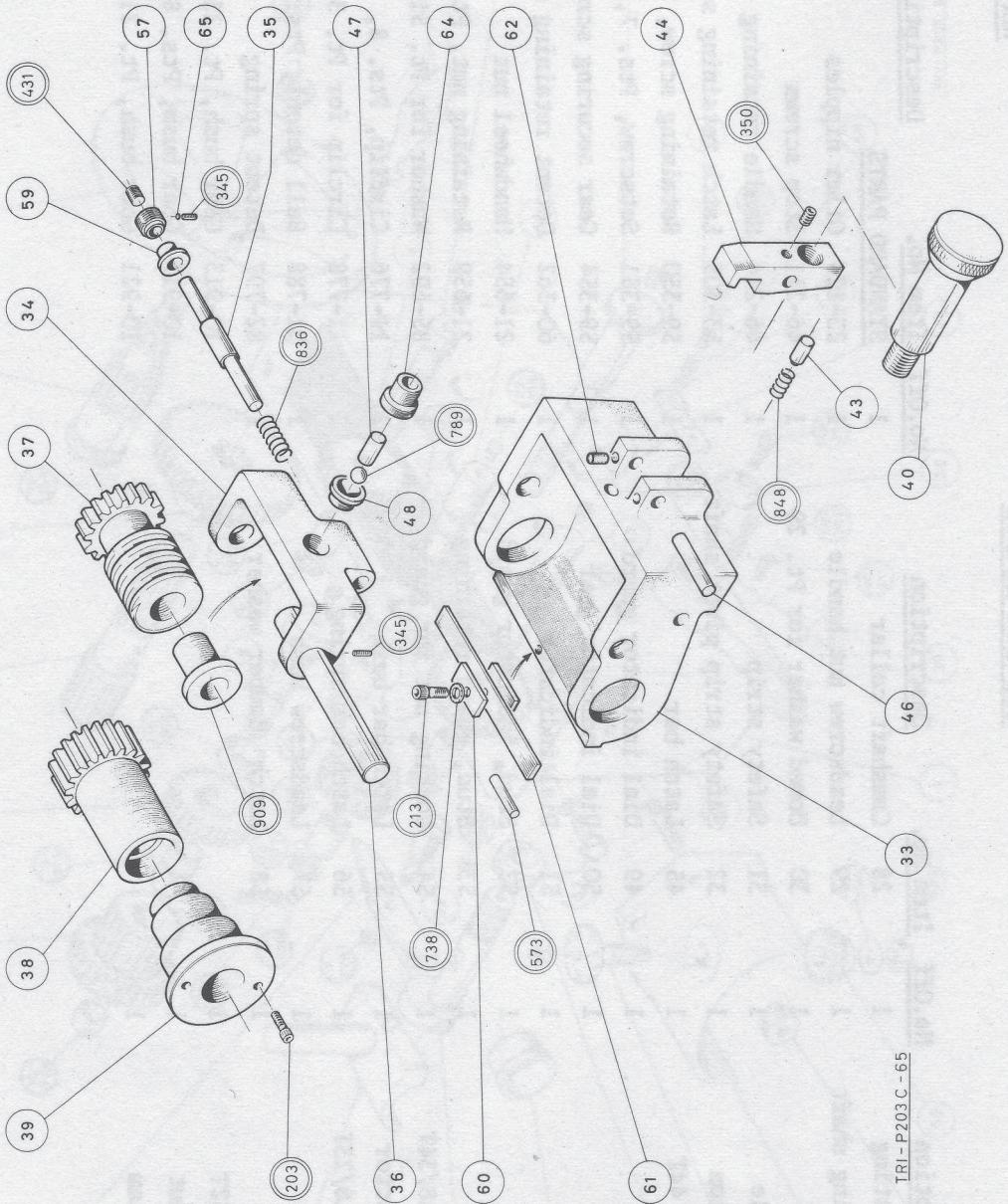
Gap Bed Lathes

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	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	Headscrew 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

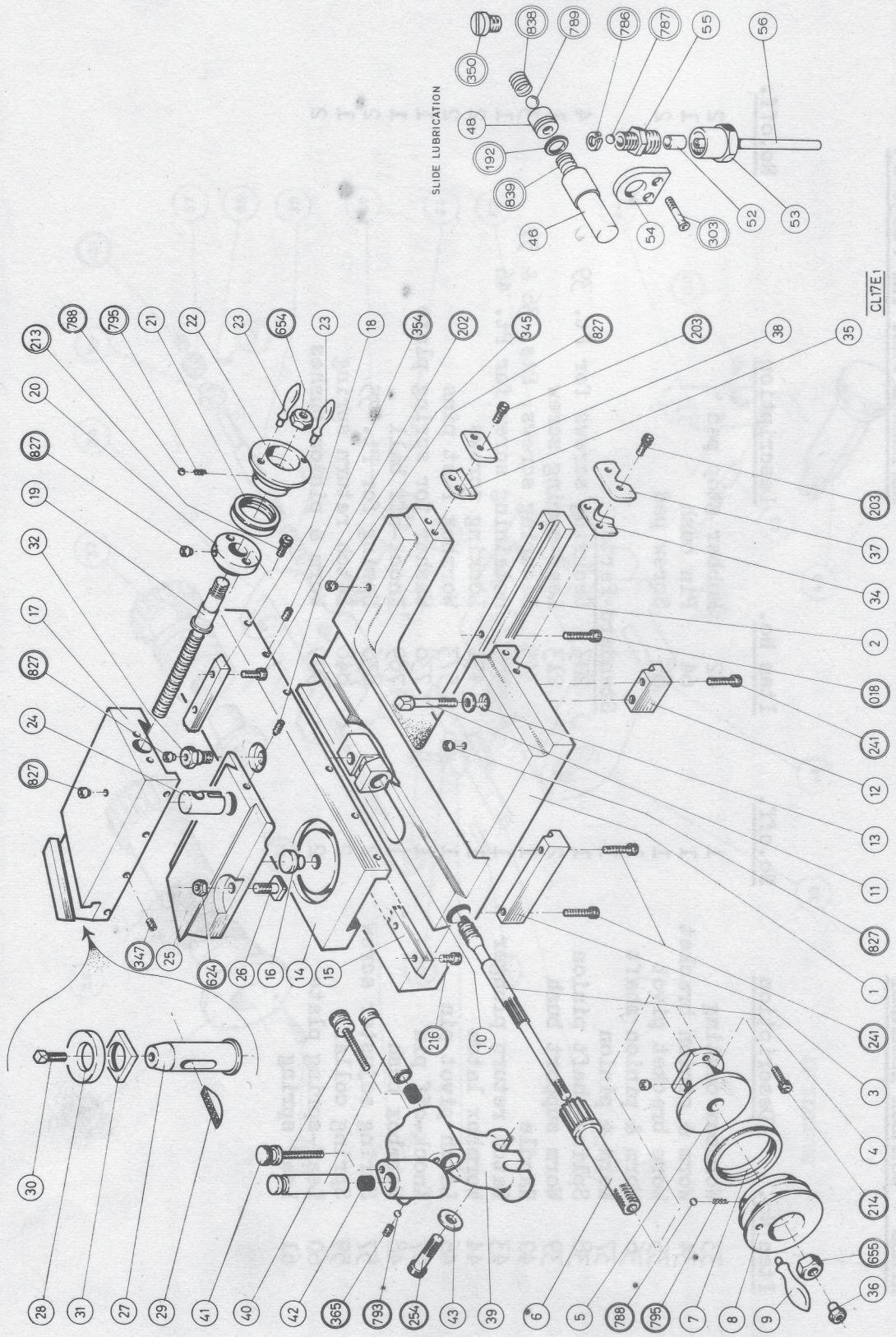
APRON - WORMBOX ASSEMBLY

REFERENCE DRG. TRI-P203C-65

<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.off.</u>
33	Wormbox casting	1	62	Rubber stop pad	2
34	Worm & pinion bracket	1	64	Pin bush	1
35	Worm bracket pivot	1	65	Screw pad	2
36	Worm & pinion shaft	1			
37	Worm & pinion	1			
38	Spline-shaft pinion	1	203	Securing screws for Pt. 39	4
39	Worm support bush	2	213	Leaf-spring screw	1
40	Handle	1	345	Securing screws, Pts. 36 & 57	3
43	Latch return plunger	1	350	Retaining screw for Pt. 46	1
44	Wormbox latch	1	431	Locking screws	2
46	Latch pivot pin	1	573	Wormbox rest pins	2
47	Knock-off pin	1	738	Washer for spring plate	1
48	Wormbox bush	1	789	Knock-off ball	1
57	Spring adjuster screw	2	836	Spring for Pt. 35	2
59	Spring collar	2	848	Latch return spring	1
60	Leaf-spring plate	2	909	Worm & pinion bushes	2
61	Leaf spring	1			

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

SADDLE AND SLIDES STRAIGHT BED LATHES

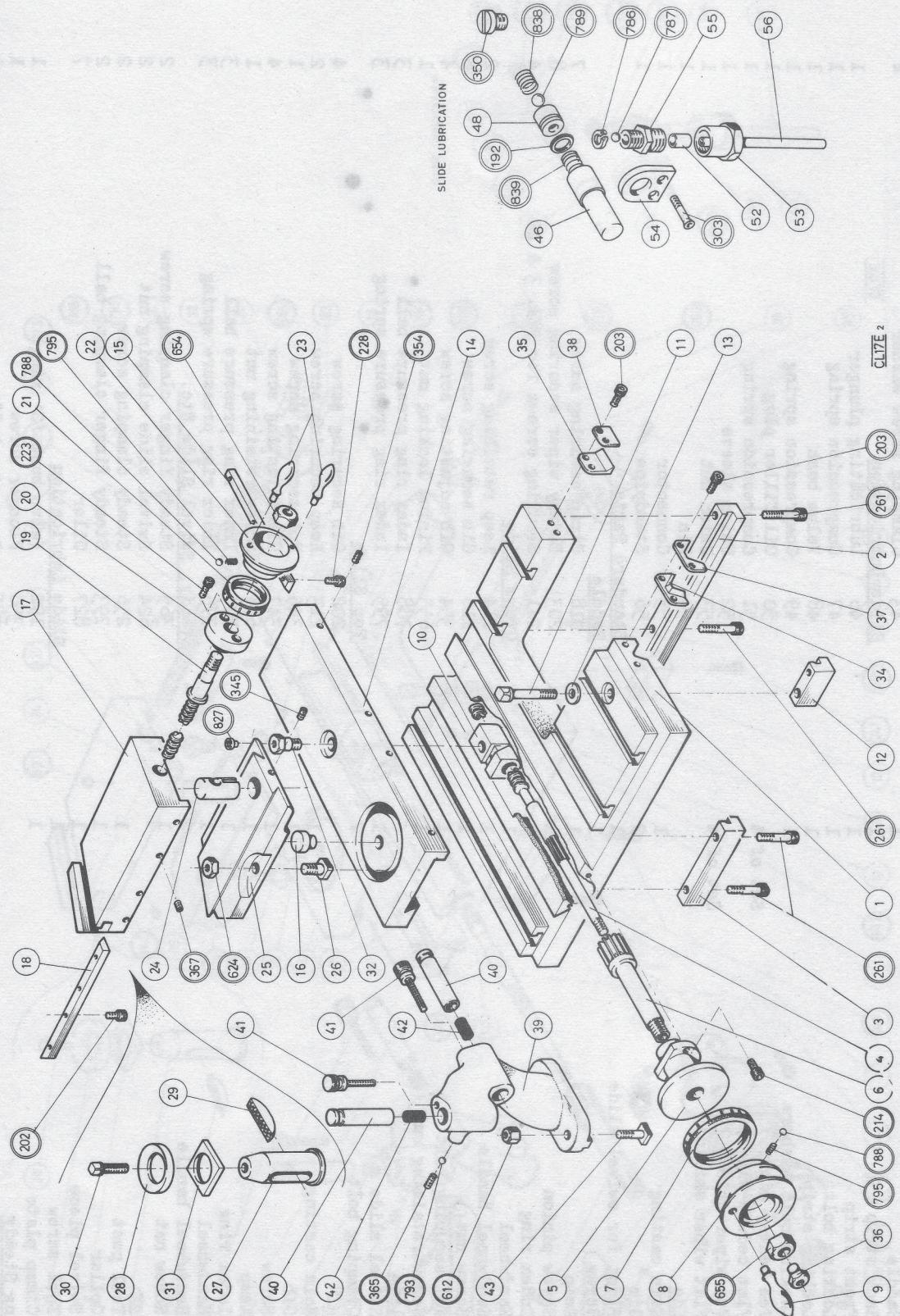


SADDLE AND SLIDES ASSEMBLY - Straight Bed Lathes

<u>Item No.</u>	<u>Description</u>	<u>No. off.</u>	<u>Ref. Dwg. CL17E1</u>	<u>Item No.</u>	<u>Description</u>	<u>No. off.</u>
<u>Saddle</u>				42	Finger insert	2
1	Saddle	1		43	Clamping screw washer	2
2	Back strip	1		Slide Lubrication		
3	Front strip	1		46	Lubricating plunger	1
11	Locking bolt	1		47	Compression spring	1
12	Locking strip	1		48	Valve bush	1
13	Locking bolt washers	1		49	Compression spring	1
34	Vee bedway wiper)	1		50	Oil filler plug	1
35	Flat bedway wiper)	Set of 4		51	Compression spring	1
37	Vee wiper shield)			52	Union sleeve	1
38	Flat wiper shield)			53	Union nut	1
<u>Cross Slide</u>				54	Pin	1
14	Main casting	1		55	Connector	1
15	Gib	2		56	Standpipe	1
16	Pivot for swivel slide	1		<u>Saddle</u>		
4	<u>Screw</u>	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		216	Gib securing screw	4
32	Nut securing bolt	1		354	Gib adjusting screw	1
36	Screw retaining nut	1		655	Pinion locking nut	1
<u>Swivel Slide</u>				788	Index ring pressure ball	3
25	Swivel slide	1		795	Index ring pressure spring	3
26	Clamping bolt	2		<u>Top Slide</u>		
17	Main casting	1		202	Gib securing screw	4
18	Gib	1		213	Keep securing screw	2
19	Screw	1		345	Nut securing screw	1
20	Keep	1		347	Gib adjusting screw	4
21	Index ring	1		654	Screw retaining nut	1
22	Handwheel	1		788	Index ring pressure ball	3
23	Handwheel handle	2		795	Index ring pressure spring	3
24	Screw nut	1		<u>Swivel Slide Etc.</u>		
27	Tool post	1		365	Steady finger clamping screw	2
28	Collar	1		624	Swivel slide clamping nut	2
29	Swivel piece	1		256	Steady clamping screw	2
30	Tool screw	1		793	Steady finger clamping ball	2
31	Clamp plate	1		827	Oiler	7
<u>Travelling Steady</u>				<u>Slide Lubrication</u>		
39	Main casting	1		192	Valve bush 'J' ring	1
40	Finger	2		350	Plunger screw	1
41	Finger adjusting screw	2		786	Connector ball	1
				787	Lubricating plunger ball	1
				789	Valve bush ball	1

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

SADDLE AND SLIDES GAP BED LATHES



SADDLE AND SLIDES ASSEMBLY - Gap Bed Lathes

Ref. Dwg. CL17E2

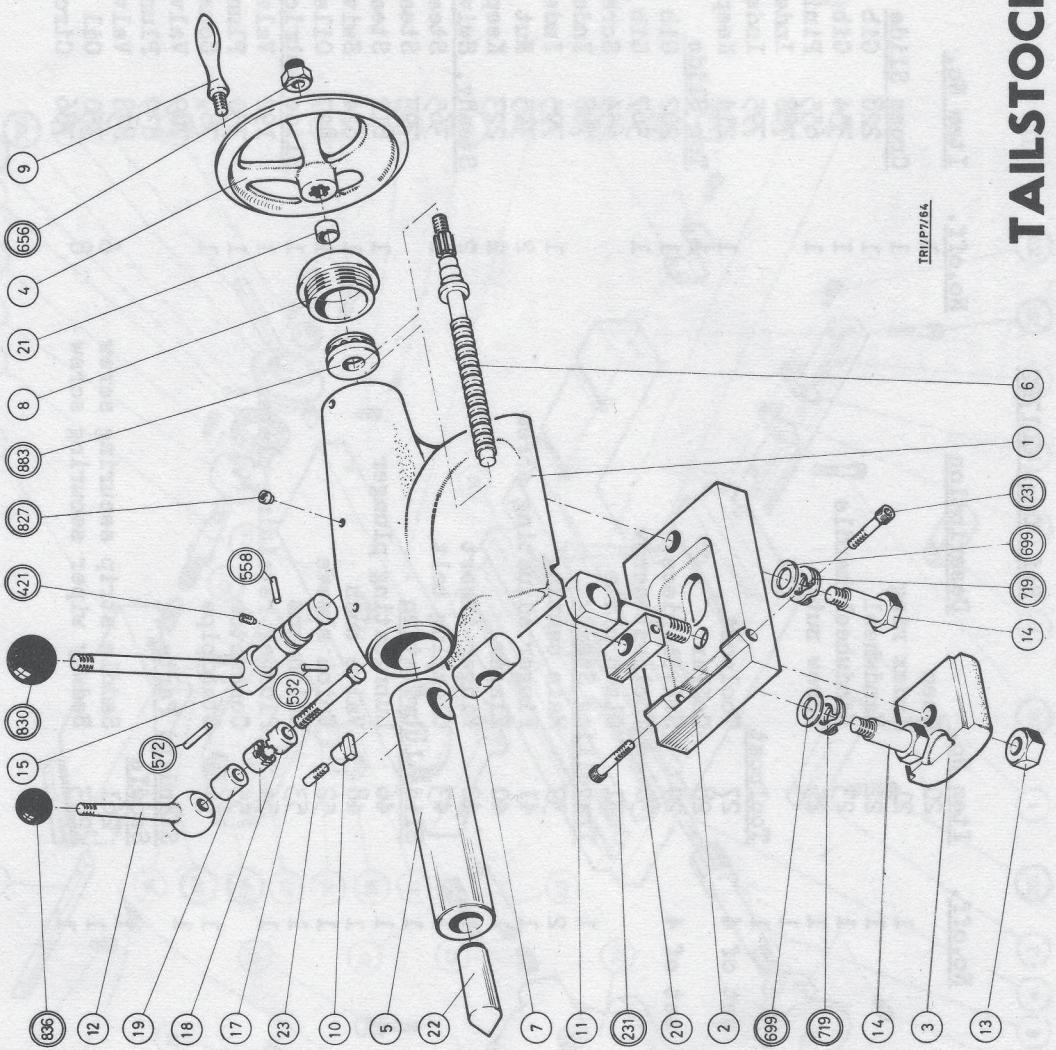
WIRLOCK V22EW/STX

<u>Item No.</u>	<u>Description</u>	<u>No.of.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.of.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.of.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.of.</u>
1 Saddle	Saddle	1	20 Keep	Keep	1	1 Cross Slide	Gib	1	228	Gib securing screw	6
2 Back strip	Back strip	1	21 Index ring	Index ring	1	22 Handwheel	Gib	1	354	Gib adjusting screw	4
3 Front strip	Front strip	1	22 Handwheel handle	Handwheel handle	1	23 Screw nut	Pinion locking nut	1	655	Pinion locking nut	1
5 Locking bolt	Locking bolt	1	24			788	Index ring pressure ball	1	788	Index ring pressure ball	6
11 Locking strip	Locking strip	1	Toolpost	Toolpost	1	795	Index ring pressure spring	1	795	Index ring pressure spring	6
12 Locking bolt washer	Locking bolt washer	1	27 Toolpost	Toolpost	1	214	Keep retaining screw	2	214	Keep retaining screw	2
13 Vee bedway wiper	Vee bedway wiper)	28 Collar	Collar	1	202	Gib securing screw	4	202	Gib securing screw	4
34 Flat bedway wiper	Flat bedway wiper)	29 Swivel piece	Swivel piece	1	367	Gib adjusting screw	4	367	Gib adjusting screw	4
35 Vee wiper shield	Vee wiper shield)	30 Toolpost screw	Toolpost screw	1	654	Screw retaining nut	1	654	Screw retaining nut	1
38 Flat wiper shield	Flat wiper shield)	31 Clamp plate	Clamp plate	1	788	Index ring pressure ball	3	788	Index ring pressure ball	3
ross Slide			32 Travelling Steady	Travelling Steady	1	795	Index ring pressure spring	3	795	Index ring pressure spring	3
14 Main casting	Main casting	1	39 Main casting	Main casting	1	2	Nut securing screw	1	345	Nut securing screw	1
15 Gib	Gib	2	40 Finger	Finger	2	223	Keep securing screw	2	223	Keep securing screw	2
16 Pivot for swivel slide	Pivot for swivel slide	1	41 Finger adjusting screw	Finger adjusting screw	2	2	Steady, Swivel, Slide, Etc.	2	2	Steady, Swivel, Slide, Etc.	2
4 Screw	Screw	1	40 Finger	Finger	2	365	Steady finger clamping screw	2	365	Steady finger clamping screw	2
6 Screw pinion	Screw pinion	1	42 Finger insert	Finger insert	2	793	Steady finger clamping ball	2	793	Steady finger clamping ball	2
5 Keep	Keep	1	43 Clamping bolt	Clamping bolt	2	612	Steady clamping nut	2	612	Steady clamping nut	2
7 Index ring	Index ring	1	44 Lubrication	Lubrication	1	624	Swivel slide clamping nut	2	624	Swivel slide clamping nut	2
8 Handwheel	Handwheel	1	46 Lubricating plunger	Lubricating plunger	1	1	Oiler	7	827	Oiler	7
9 Handwheel handle	Handwheel handle	1	48 Valve bush	Valve bush	1	Slide Lubrication					
10 Screw nut	Screw nut	1	52 Union sleeve	Union sleeve	1	192	Valve bush 'O' ring	1	192	Valve bush 'O' ring	1
32 Nut securing bolt	Nut securing bolt	1	53 Union nut	Union nut	1	350	Plunger screw	1	350	Plunger screw	1
36 Screw retaining nut	Screw retaining nut	1	54 Plunger retaining plate	Plunger retaining plate	1	1	Connector ball	1	787	Connector ball	1
26 Swivel slide	Swivel slide	1	55 Connector	Connector	1	789	Valve bush ball	1	789	Valve bush ball	1
27 Clamping bolt	Clamping bolt	1	56 Standpipe	Standpipe	1	839	Plunger spring	1	839	Plunger spring	1
op Slide			Standard Parts	Standard Parts	1	838	Valve spring	1	838	Valve spring	1
17 Main casting	Main casting	1	Saddle	Saddle	1	350	Oil filler plug	1	350	Oil filler plug	1
18 Gib	Gib	1	261 Saddle strip securing screw	Saddle strip securing screw	6	1	Circlip	1	786	Circlip	1
19 Screw	Screw	1	203 Bedway wiper securing screw	Bedway wiper securing screw	8						

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

TAILSTOCK ASSEMBLY

TRU/P7/66.

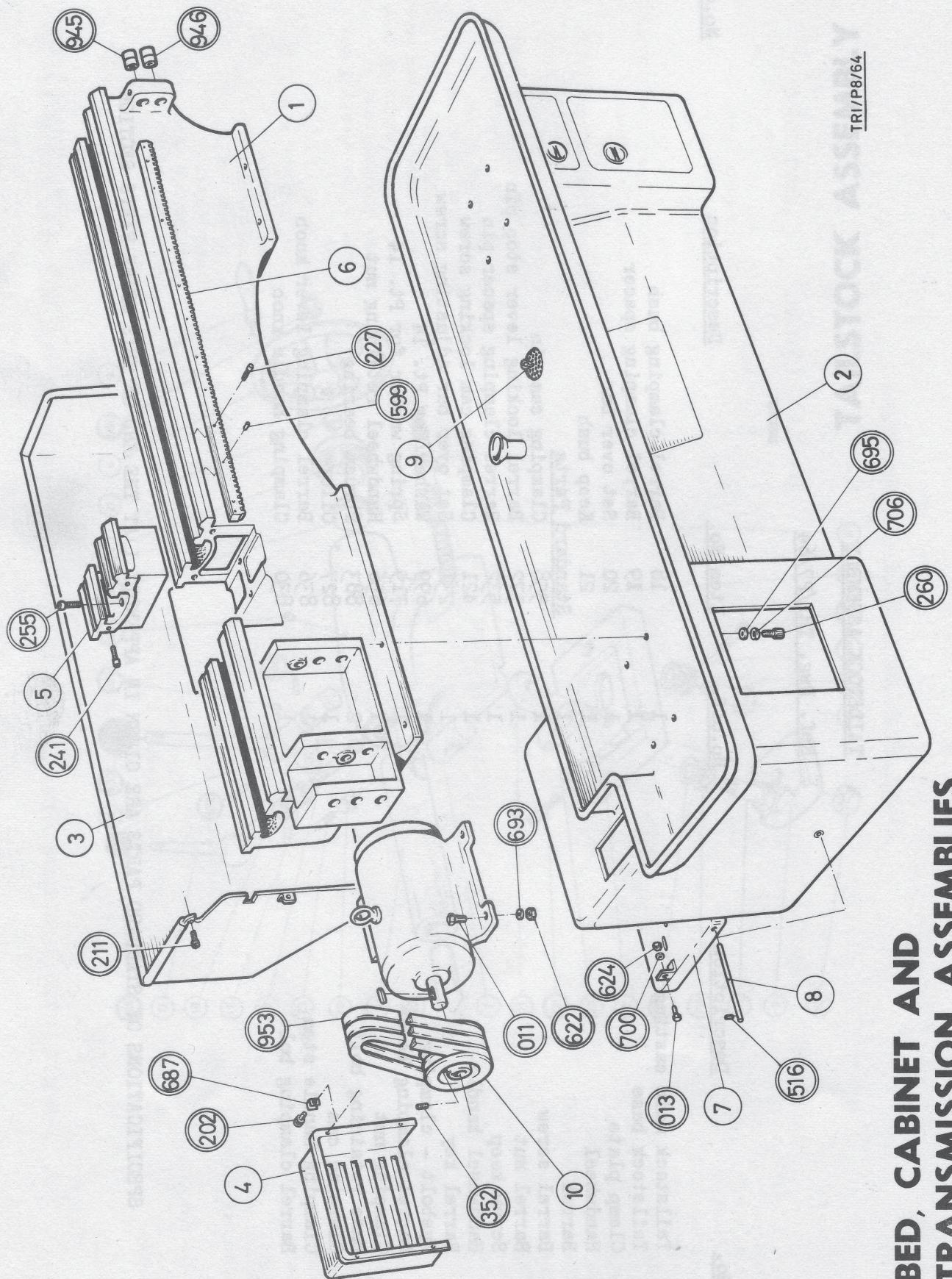


TAILSTOCK ASSEMBLY

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	1
16	Clamping handle stem	1	836	Barrel clamping lever knob	3
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



BED, CABINET AND
TRANSMISSION ASSEMBLIES

TRI/P8/64

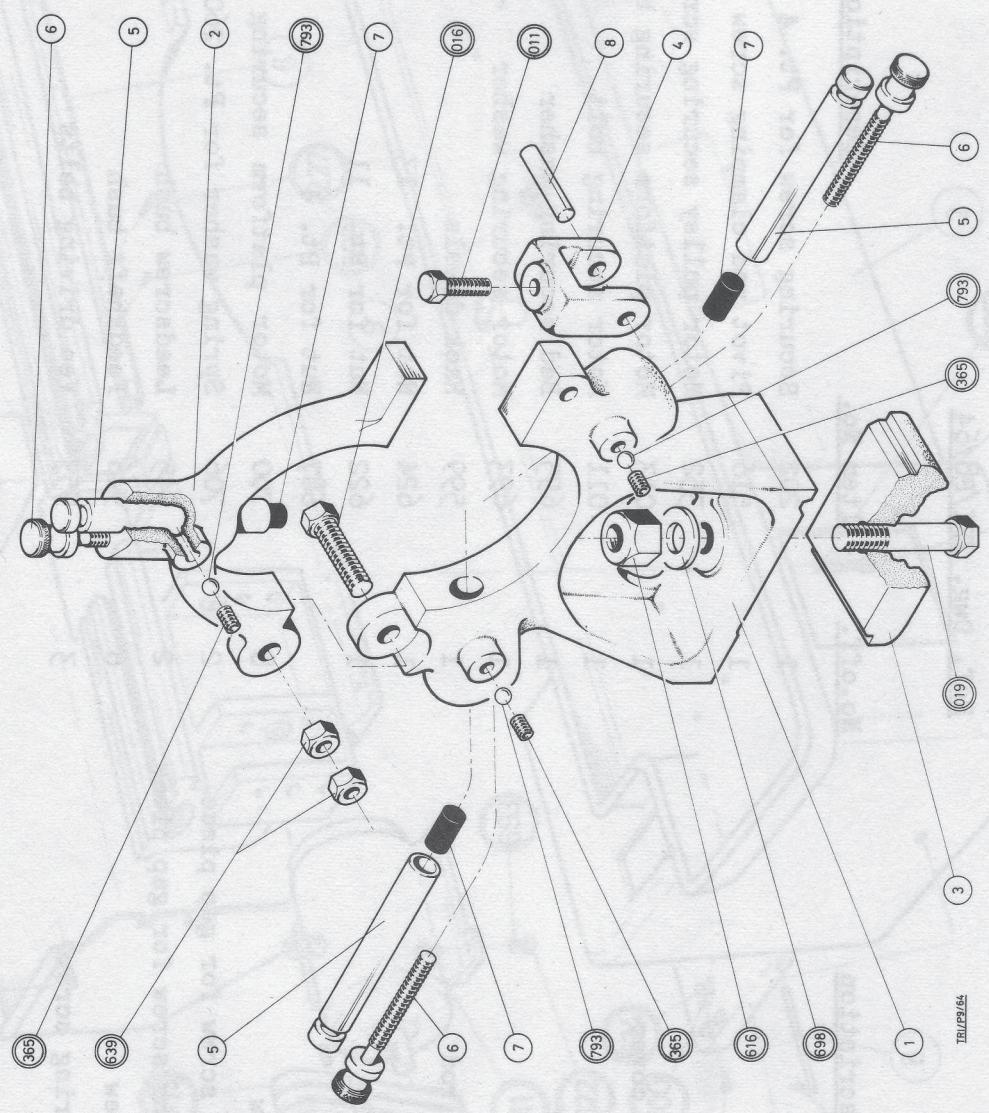
BED, CABINET AND TRANSMISSION ASSEMBLIES

Ref. Dwg. TRI/P8/64

<u>Item No.</u>	<u>Description</u>	<u>No.of.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.of.</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



TRIP/PU/64

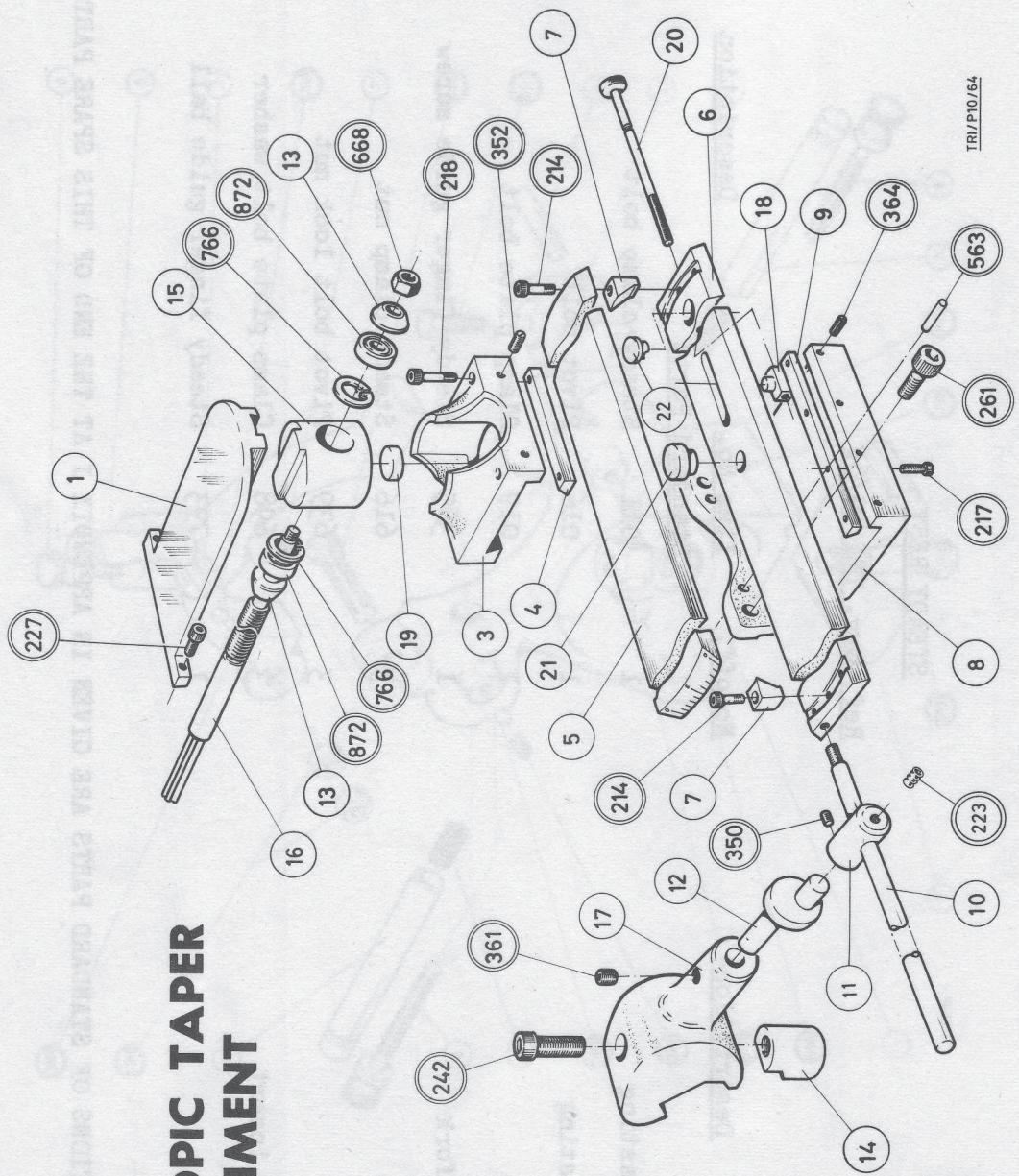
STEADY REST

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

TELESCOPIC TAPER ATTACHMENT



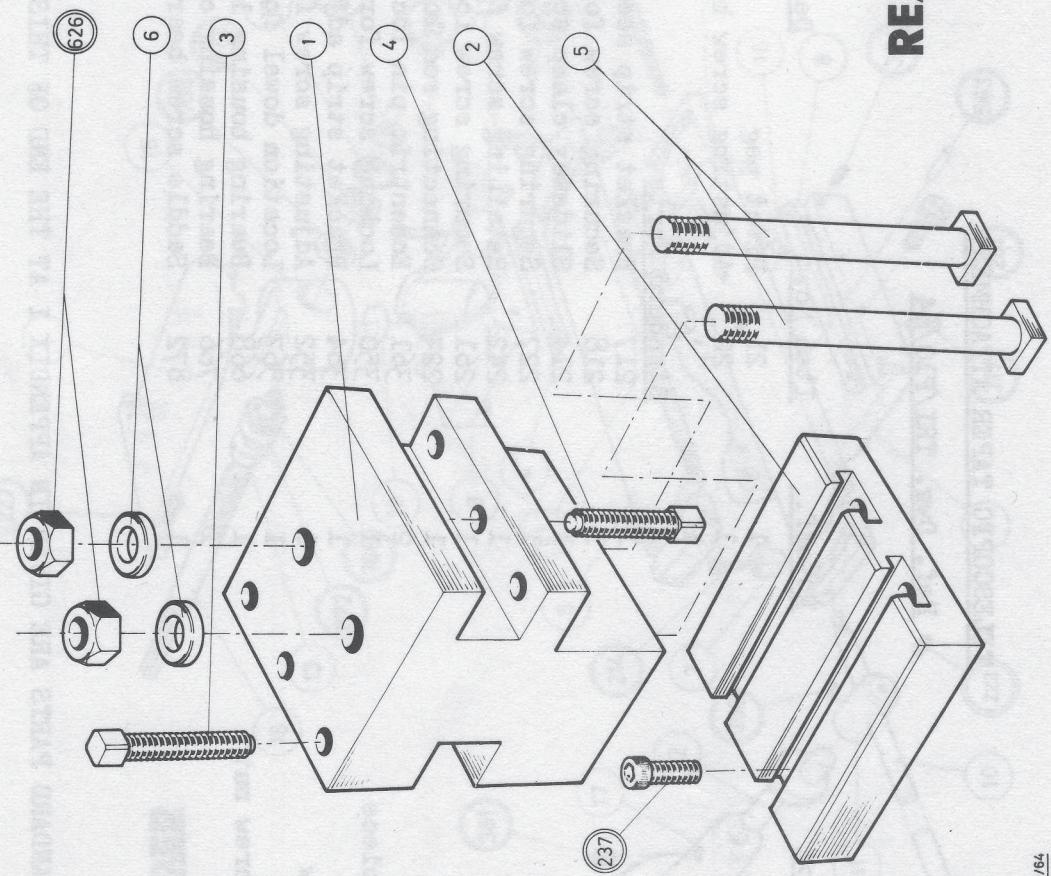
TELESCOPIC TAPER ATTACHMENT

Ref. Dwg. TRI/P10/64

<u>Item No.</u>	<u>Description</u>	<u>No.of.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.of.</u>
1	Bottom slide extension	1	21	Pivot peg	1
3	Slide block	1	22	Adjusting screw keep	1
4	Slide block strip	1			
5	Swivel slide	1			
6	Plate	1			
7	Slideway clamp	1	217	Bracket strip securing screw	4
8	Taper turner bracket	1	218	Securing screw for Pt. 4	2
9	Bracket strip	1	214	Slideway clamp screw	2
10	Connecting rod	1	227	Securing screw for Pt. 1	2
11	Anchor bracket extension	1	242	Retaining screw for Pt. 1	1
12	Eccentric pin	1	261	Securing screw for Pt. 8	2
13	Bearing housing washer	2	223	Connecting rod locking screw	1
14	Anchor bracket clamping piece	1	361	Eccentric pin locking screw	1
15	Bearing housing	1	350	Locking screw for Pt. 11	2
16	Taper turner saddle screw	1	364	Bracket strip adjusting screw	3
17	Anchor bracket	1	352	Adjusting screw for Pt. 4	2
18	Swivel slide adjusting screw nut	1	563	Location dowel for Pt. 8	2
19	Bearing housing spacer	1	668	Bearing housing locking nut	1
20	Swivel slide adjusting screw	1	766	Bearing housing circlip	2
			872	Saddle screw bearing	2

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

REAR TOOLPOST



TRI/P11/64

REAR TOOLPOST

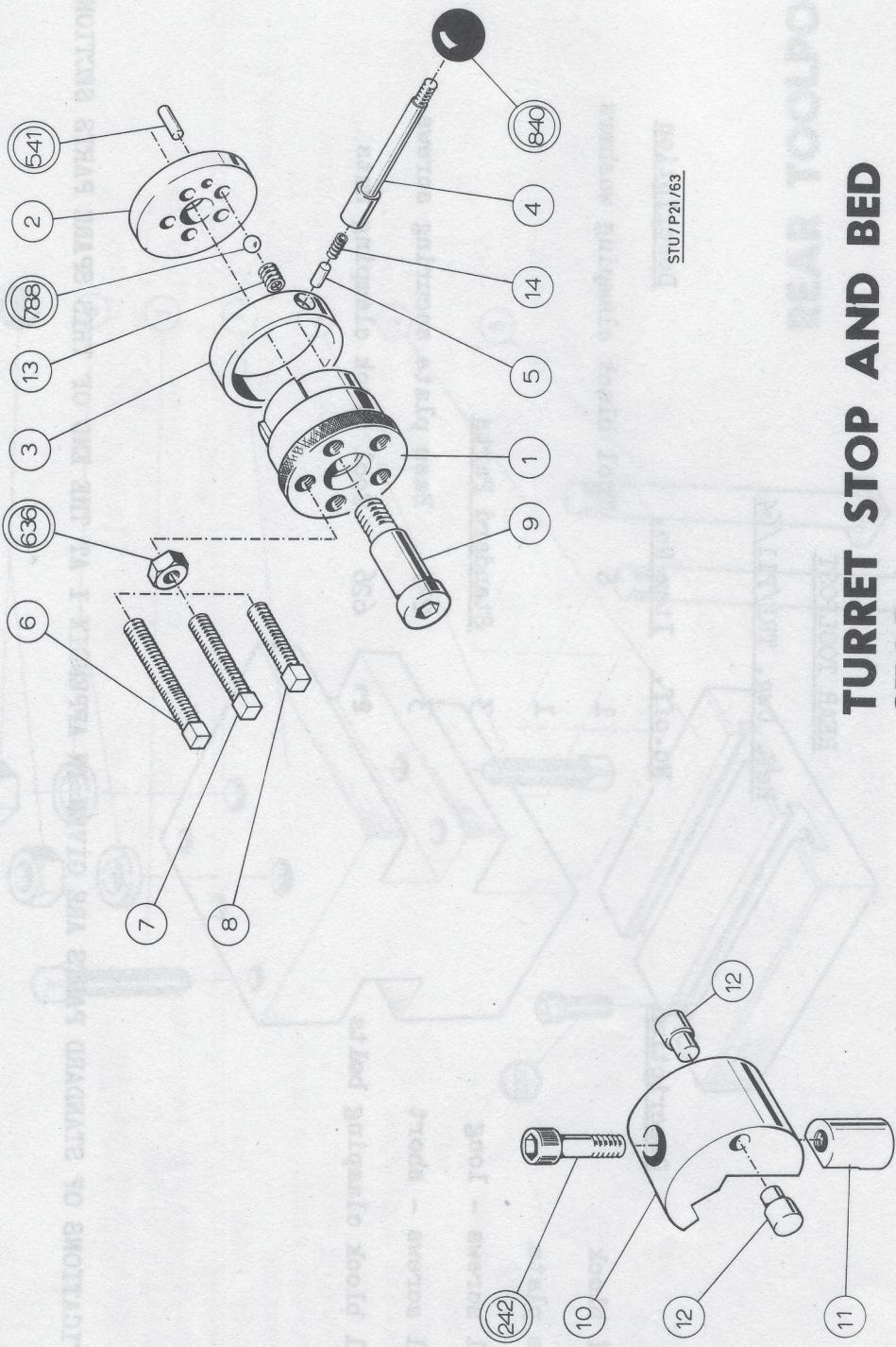
Ref. Dwg. TRI/P11/64.

<u>Item No.</u>	<u>Description</u>	<u>No.of.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.of.</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

TURRET STOP AND BED STOP

STU/P21/63



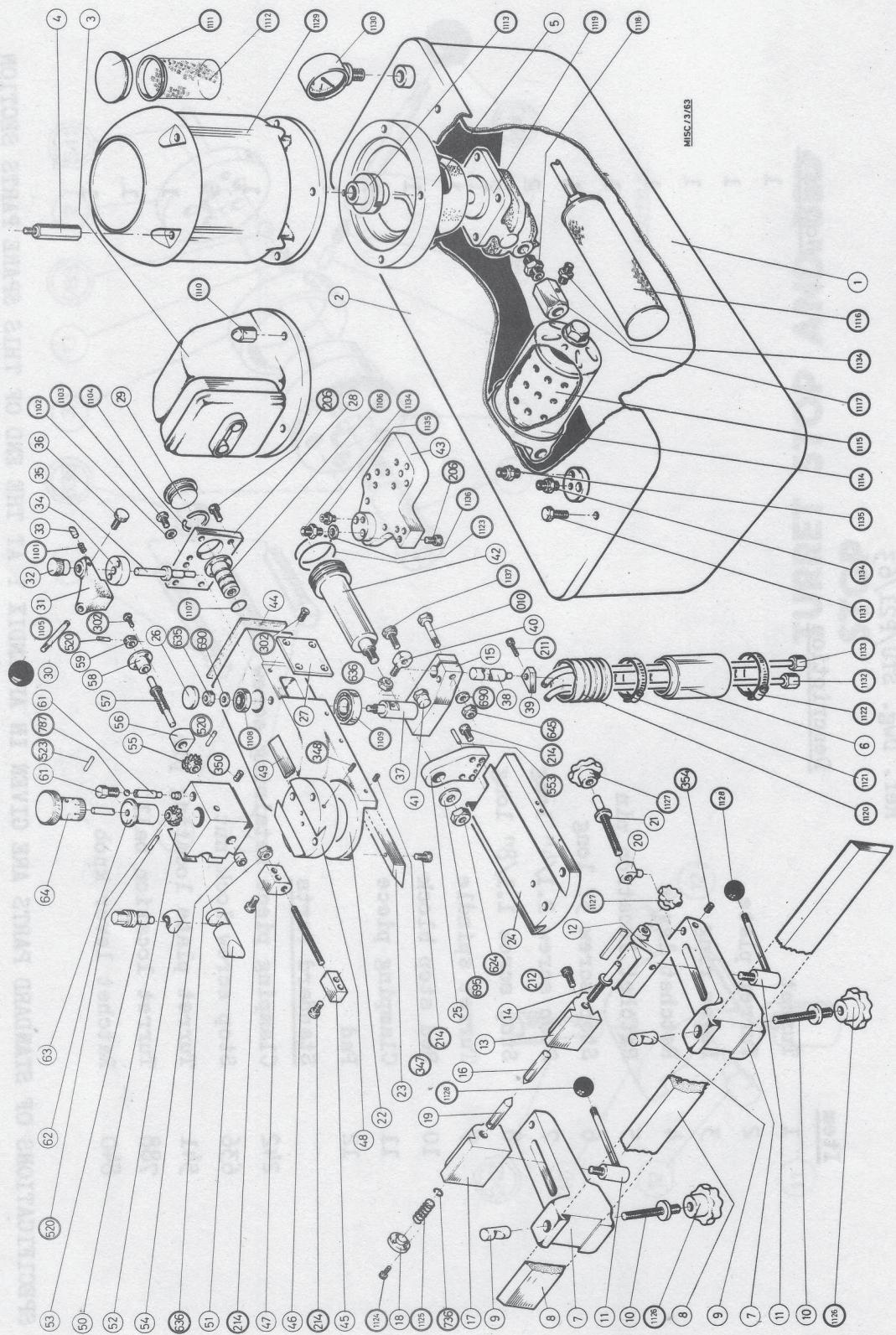
TURRET STOP AND BED STOP

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

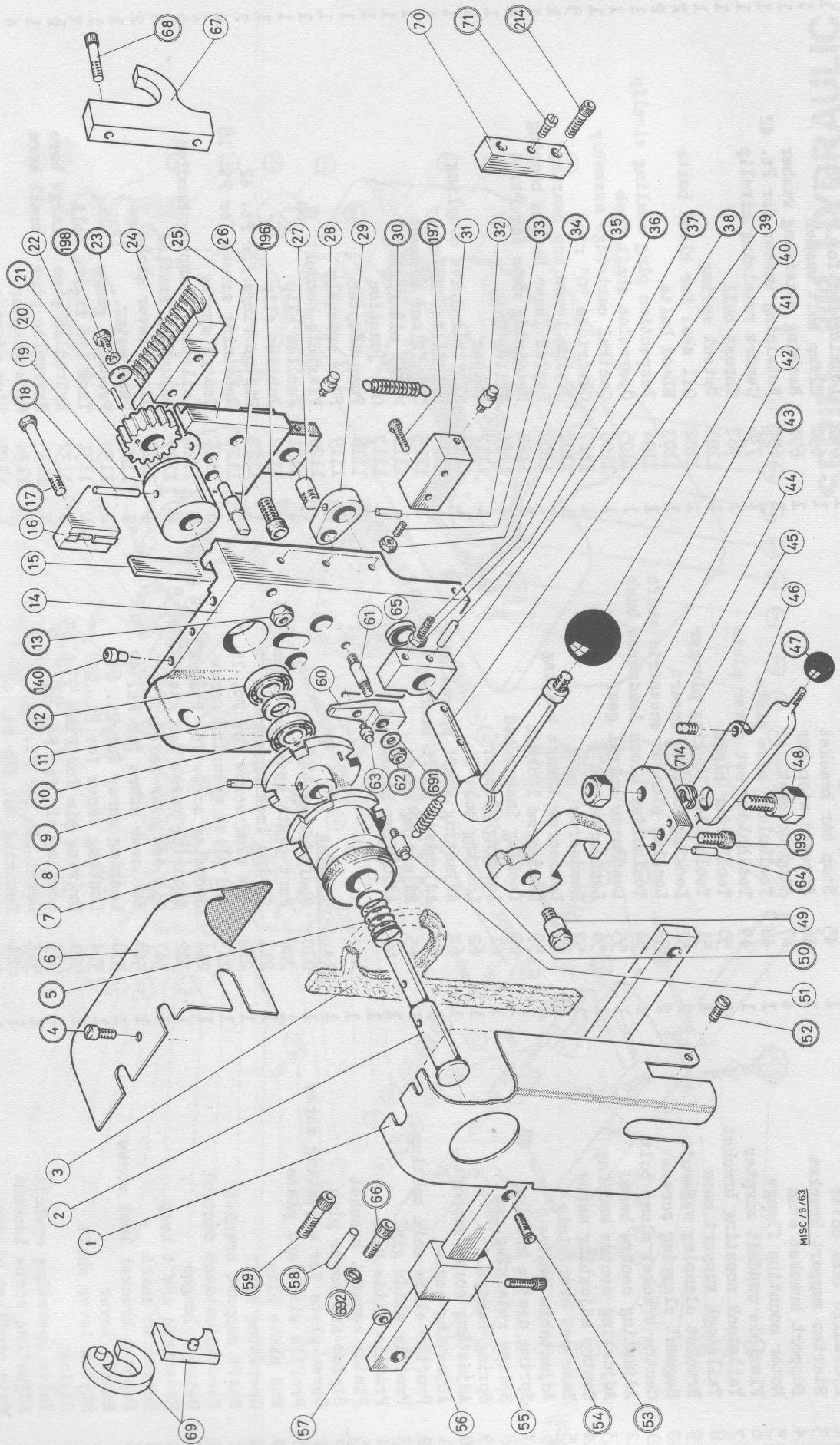
SERIES 300 HYDRAULIC PROFILING UNIT



<u>Item No.</u>	<u>Description</u>	<u>No.of.</u>	<u>Item No.</u>	<u>Description</u>	<u>No.of.</u>
1	Hydraulic tank	1	44	End plate gasket	1
2	Hydraulic tank cover	1	45	Stop bar bracket	1
3	Starter support bracket	1	46	Screwed stop bar	1
4	Support bracket stud	4	47	Stop bracket	1
5	Motor mounting flange	1	48	Toolholder base plate	1
6	Flexible conduit adapter	1	49	Toolholder set cover plate	1
7	Tailstock mounting bracket	2	50	Toolholder block	1
8	Tailstock support beam	1	51	Toolholder locking plunger	1
9	Bracket clamping segments	2	52	Locking plunger insert	1
10	Segment clamping screws	2	53	Locking plunger eccentric shaft	1
11	Centre bracket clamp bolt	2	54	Toolholder block leadscrew bush	1
12	Adjusting centre base	1	55	Leadscrew spiral gear	1
13	Adjusting centre housing	1	56	Leadscrew nut	1
14	Centre adjusting screw	1	57	Leadscrew	1
15	Base set over strip	1	58	Leadscrew thrust bearing	1
16	Adjustable centre	1	59	Leadscrew locknut	1
17	Spring centre housing	1	60	Locking insert ped	1
18	Spring retaining cap	1	61	Locking plunger	1
19	Spring centre	1	62	Locking bolt	1
20	Adjusting screw support	1	63	Adjusting shaft spiral gear	1
21	Adjusting screw	1	64	Adjusting shaft bearing	1
22	Profile slide main casting	1	65	Adjusting shaft	1
23	Profile slide gib	1	66	Adjusting handwheel	1
24	Profile slide base	1			
25	Piston support bracket	1			
26	Stylus arm cover plug	1			
27	Cover plate for adjusting screw	1	010	Shaft clamp bolt	1
28	Profile slide and plate	1	206	Port plate securing screw	1
29	End plate plug	1	211	Stylus locking screw	1
30	Operating shaft	1	212	Set over screw for Pt. 15	1
31	Shaft support bracket	1	213	End plate securing screw	6
32	Feed adjustment control	1	214	Securing screw for Pts. 25, 45 & 47	8
33	Detent plunger	1	302	Securing screw for Pts. 27 & 58	6
34	eccentric shaft keep	1	347	Gib set over screw	4
35	eccentric shaft	1	348	Set over screw for Pt. 49	2
36	Support bracket lock screw	1	350	Locking screw for Pt. 64	1
37	Stylus lever	1	354	Locking screw for Pt. 20	1
38	Stylus lever shaft	1	520	Driving pin for Pts. 55 & 63	2
39	Stylus	1	523	Locking pin for Pt. 66	1
40	Valve operating eyebolt	1	553	Dowel pin for Pt. 25	2
41	Adjusting screw locknut	1	624	Securing nut for Pt. 42	1
42	Main profiler piston	1	635	Retaining nut for Pt. 57	1
43	Port plate	1	636	Locking nut for Pt. 40	1
		1	1137	Tapper screw	1
			1121	Jubilee clip	1
		9	1122	Jubilee clip	1
			1123	Piston rings for Pt. 42	2
			1124	Retaining screws for Pt. 18	4
			1125	Centre spring	1
			1126	Tailstock clamping handles	2
			1127	Adjusting handles	2
			1128	Clamp lever knobs	2
			1129	Pump motor	1
			1130	Pressure gauge	1
			1131	Tank lid fixing bolt	3
			1132	Hydraulic pipe - large bore	2
			1133	Hydraulic pipe - small bore	1
			1134	Pipe adapter	4
			1135	Pipe adapter	7
			1136	Oil seal washers	4
			1137	Tapper screw	1

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

RAPID-THREADER ATTACHMENT



RAPID-THREADER ATTACHMENT - English

Ref. Dwg. MISC/8/63

Item No.	Description	No.of.	Item No.	Description	No.of.	Item No.	Description	No.of.
1	Front cover	1	33	Dowel (Included in item 29)	1	65	Handle shaft bearing	1
2	Setting dial assembly (Assy. includes items 5, 7, 8 & 9)	1	34	Gib adjusting screws	3	66	Centre hole mounting screw	1
			35	Gib adjusting screw locknut	3	67	Lower steady (8½" or 17" lathes only)	1
3	Cover sealing felt	1	36	Locking lever adjusting screw	1	68	Lower steady screw	2
4	Cover fixing screws	2	37	Locking lever adjusting screw	1	69	Half-mut lever lock - "C" type	1
				locknut			- Plate type (8½" or 17" only)	1
5	Spring (Included in item 2)	1	38	Dowel (Included in item 29)	1	70	Cover spacing block (later models)	1
6	Back cover	1	39	Block (Included in item 29)	1	71	Cover spacing block screw (later models)	1
7	Dial housing (Included in item 2)	1	40	Handle (Included in item 29)	1			
8	Dial plate (Included in item 2)	1	41	Handle knob	1			
9	Dowel (Included in item 2)	1	42	Disengaging lever	1	140	Oil nipple	2
10	Ball race - Hoffmann	1	43	Knock-off lever pivot locknut	1	196	Half-mut screws	2
11	Ball race spacer	1	44	Knock-off lever bracket	1	197	Spring anchor block screws	2
12	Ball race - Hoffmann	1	45	Boss for knock-off lever	1	198	Pinion retaining screw	1
13	Steady adjusting nut	1	46	Knock-off lever	1	199	Knock-off bracket screws	2
14	Main bracket	1	47	Knock-off lever knob	1	214	Cover spacing block screws	2
			48	Knock-off lever pivot screw	1	227†	Mounting screws (for 6" & 6½" lathes)	2
15	Gib	1	49	Disengaging pivot screw	1	228†*	Mounting screws (for 6", 6½" & 7½" lathes)	3
16	Steady bolt	1	50	Locking lever spring	1			
17	Steady bolt	1	51	Spring anchor	1	229 *	Centre hole mounting screws (for 7½" lathes)	1
18	Taper pin	1	52	Front cover screw	1	242†	Mounting screws (for 8½" lathes)	2
19	Pinion driving collar	1	53	Stop bar screw	1	244 *	Centre hole mounting screws (for 8½" lathes)	1
20	Pinion	1	54	Stop adjusting screw	1			
			55	Adjustable stop	1			
21	Pin (Included in Pinion, item 20)	1	56	Stop bar (to suit lathe)	1			
22	Pinion retaining washer	1	57	Stop bar spacer	1	691	Locking lever pivot washer	1
23	Pinion retaining screw lock washer	1	58	Dowel pin	2	692	Centre hole mounting screw washer (for 6" & 7½" lathes)	1
24	Half nut	1	59	Mounting screw (to suit lathe)	2	714	Knock-off lever friction washer	1
25	Slide	1	60	Locking lever	1			
26	Selector pin	1	61	Locking lever pivot stud	1	† Item No. 59 refers:		
27	Slide driving pin	1	62	Locking lever pivot nut	1	Size selected for lathe		
28	Spring retaining pin	1	63	Pin for locking lever	1	* Item No. 66 refers:		
29	Cam-handle shaft assembly (Assy. includes items 33, 38, 39 & 40)	1	64	Dowel for knock-off lever (not later models)	1	Size to suit lathe		
30	Main spring	2						
31	Spring anchor block	1						
32	Spring retaining pin	1						

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

APPENDIX 1SPECIFICATION OF STANDARD PARTSItem 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 $\frac{1}{8}$ " x 1 $\frac{1}{8}$ " x $\frac{3}{8}$ ".
181	Oilseal - Weston	WB 16911037 R21.
182	Washer Dowty	List 5MK 10PP 49C.
183	Needle Bearing Ina	SC 1412. 1 $\frac{1}{8}$ " x $\frac{7}{8}$ " x $\frac{3}{4}$ ".
184	" " "	SC 128 1" x $\frac{3}{4}$ " x $\frac{1}{2}$ ".
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 " xl.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" " xl.1/4".
218	" " " "	1/4" " xl.1/2".
219	" " " "	1/4" " xl.3/4".
223	" " " "	5/16" " x 1/2".
225	" " " "	5/16" " x 3/4".
228	" " " "	5/16" " xl.1/4".
229	" " " "	5/16" " xl.1/2".
230	" " " "	5/16" " xl.3/4".
231	" " " "	5/16" " x 2".
242	" " " "	3/8" " xl.1/2".
246	" " " "	3/8" " x 2.1/2".
253	" " " "	7/16" " x 2".
260	" " " "	1/2" " xl.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