

RC 6236 x 1000

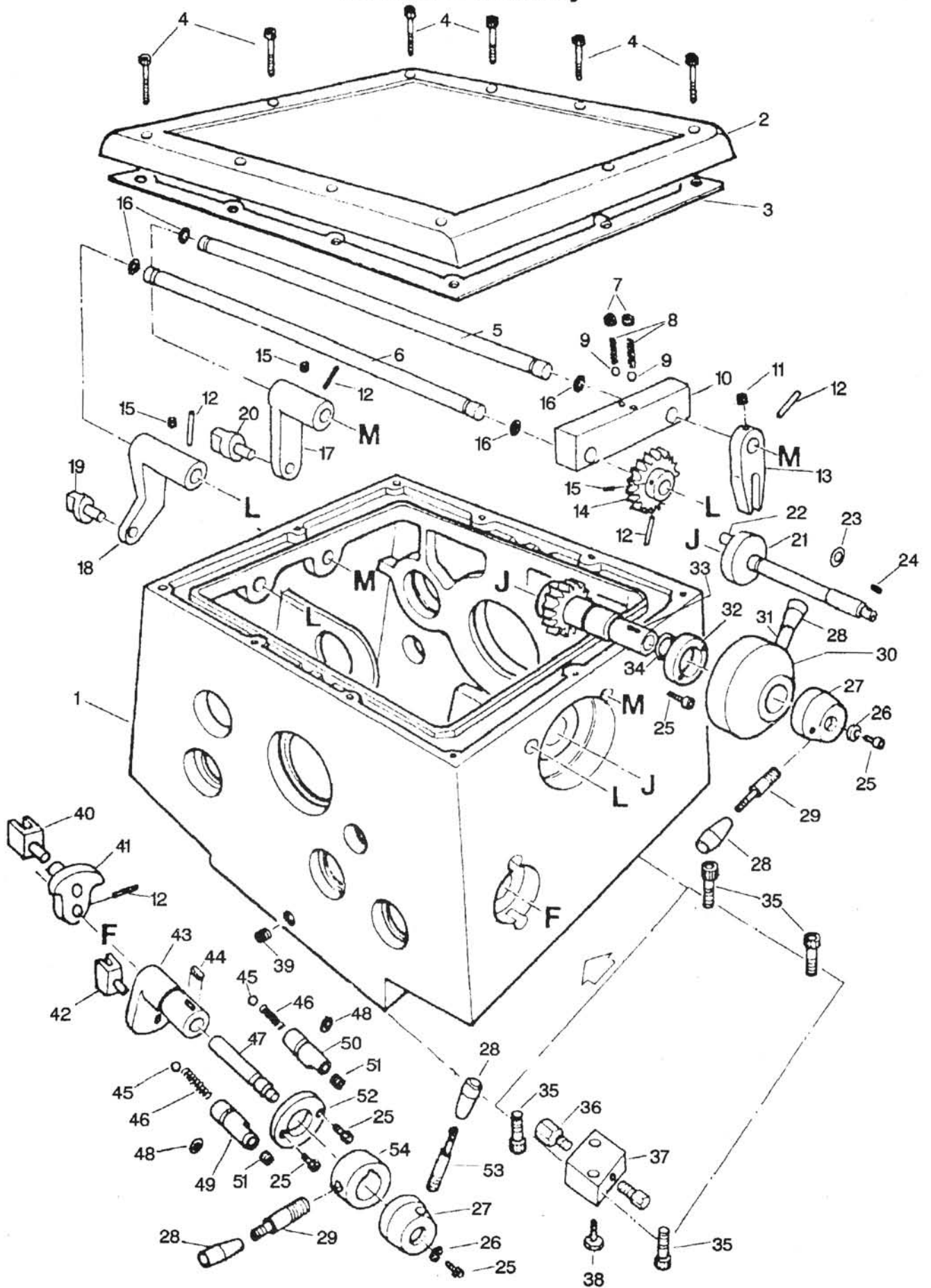
GH-1340A (C6232A2) GH-1440A (C6236A2)

GEARED HEAD PRECISION LATHE

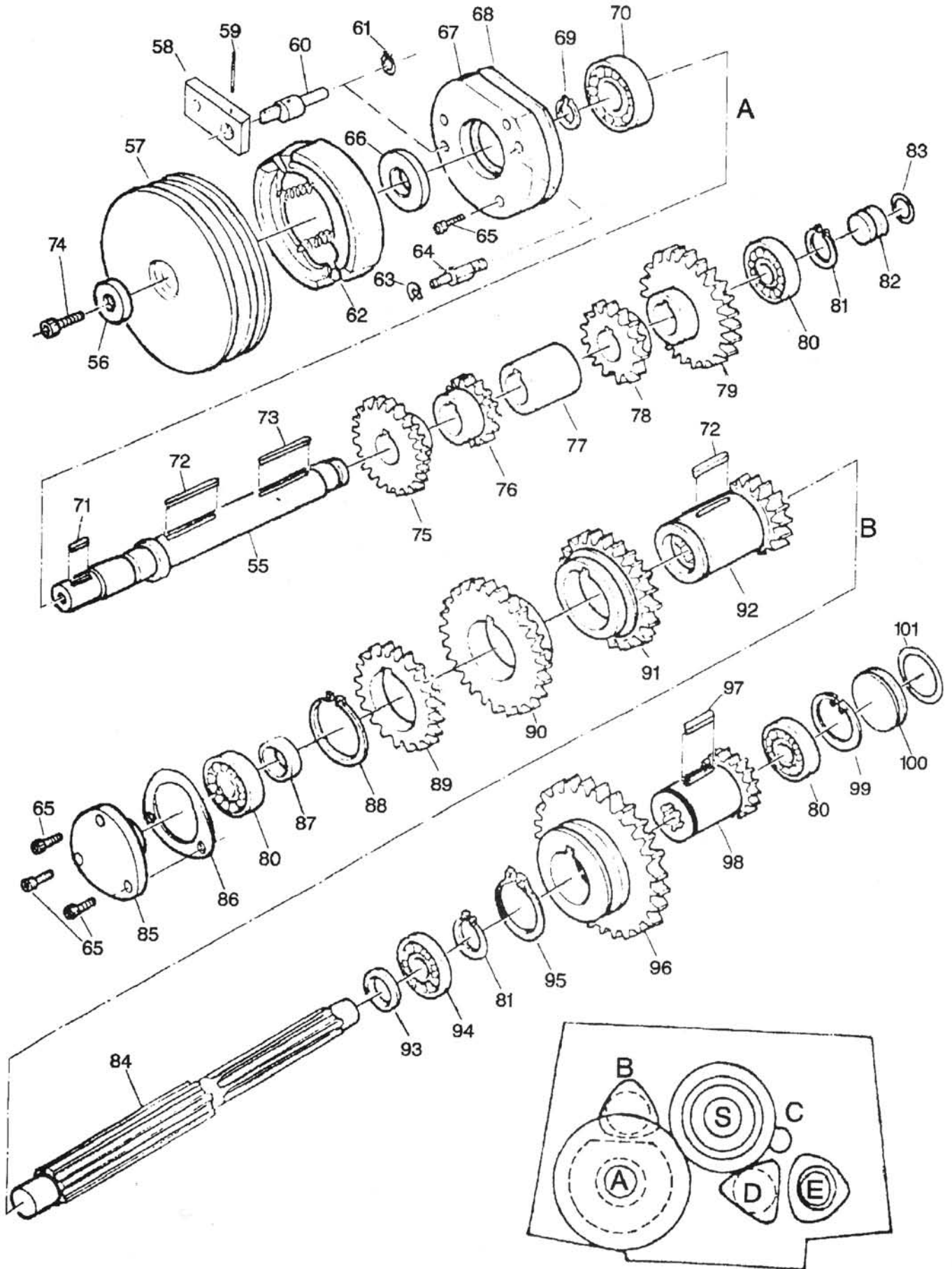
PARTS LIST



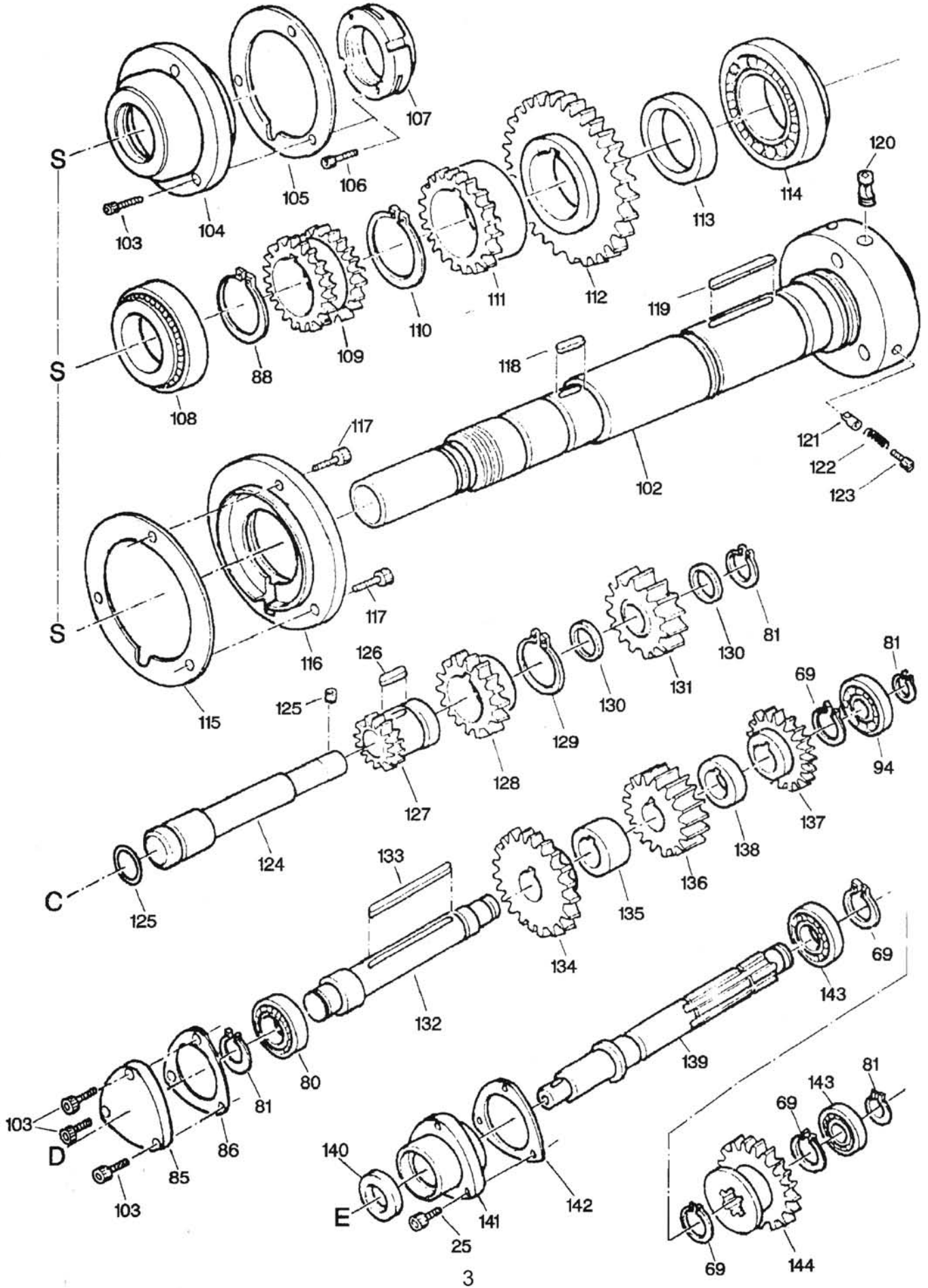
Headstock Assembly



Headstock Assembly



Headstock Assembly



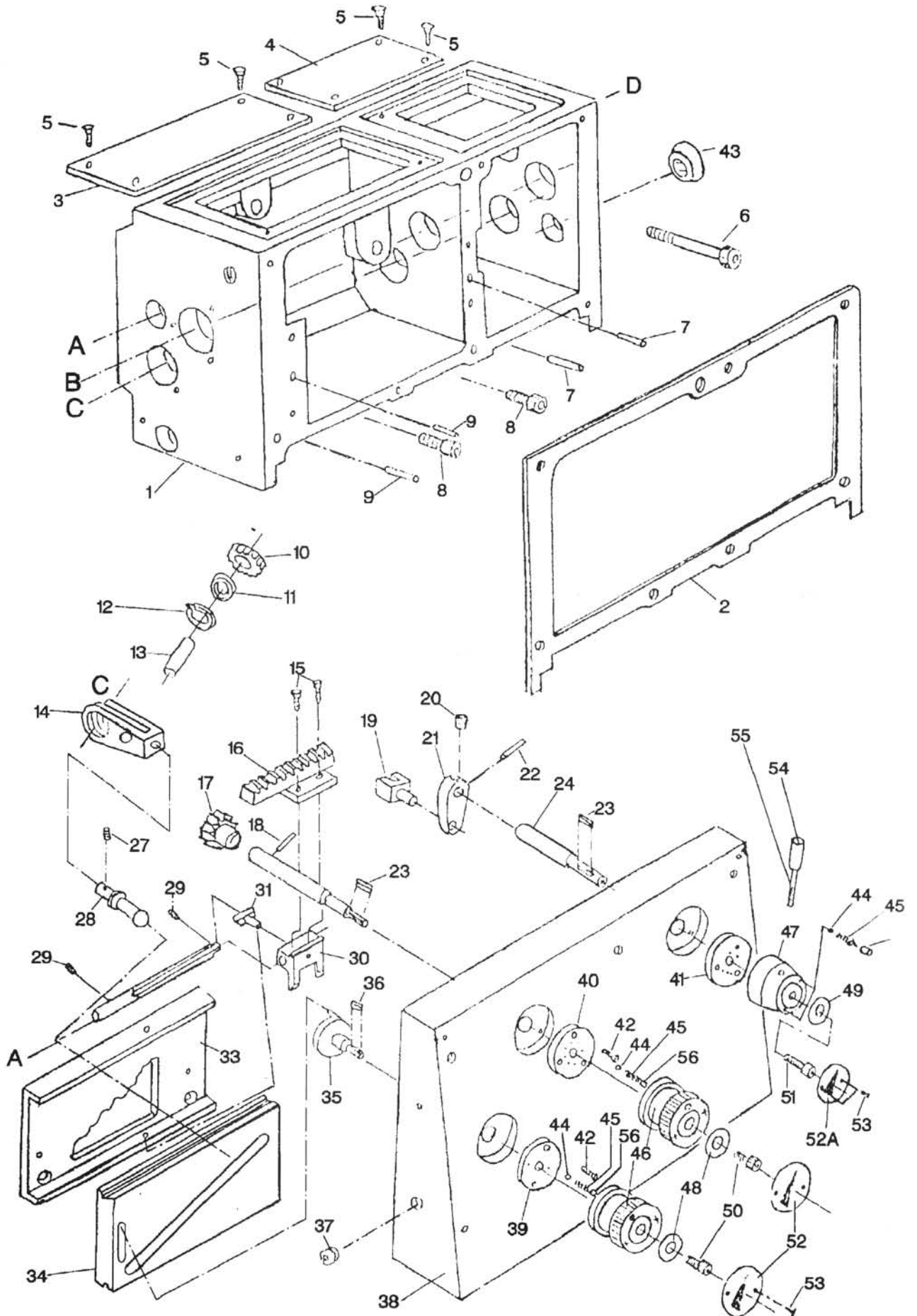
Headstock Assembly

Index NO.	Part NO.	Description	Size	Qty
1	04-01	Head Casting		1
2	04-04	Headstock Cover		1
3	04-09	Gasket		1
4	GB70	Hex Socket Cap Screw	M6x35	10
5	04-72	Gear Shift Shaft		1
6	04-02	Gear Shift Shaft		1
7	GB77	Set Screw	M8x12	2
8	GB2089-1x5x22	Spring		2
9	GB3080-6	Steel Ball	6	2
10	04-89	Block		1
11	GB78	Set Screw	45x12	1
12	GB879-5x30	Taper Pin		5
13	04-96	Shift Fork		1
14	04-87	Gear	45T	1
15	GB78	Set Screw	M6x6	3
16	GB3452.1	O-Ring	14x2.65	4
17	04-75	Shift Lever		1
18	04-08	Shift Lever		1
19	04-07	Gear Shifter		1
20	04-76	Gear Shifter		1
21	04-93	Shift Crank		1
22	04-94	Crank Pin		1
23	GB3452.2	O-Ring	11.2x2.65	1
24	GB1096	Key	4x10	1
25	GB70	Hex Socket CSP Screw	M6x12	8
26	04-62	Retaining Clip		2
27	04-97	Shifting Hub		2
28	GB4141.14	Handle Knob	10x50	4
29	04-81	Handle Shaft		2
30	04-98	Shifting Body		1
31	04-80	Handle Shaft		1
32	04-68	Inner Ring		1
33	04-88	Gear and Shaft Assembly	35T	1
34	GB3452.3	O-Ring	26.5x2.65	1
35	GB70	Hex Socket Cap Screw	M12x35	4
36	04-82	Alignment Bolt		2
37	04-83	Alignment Block		1
38	GB5781	Alignment Bolt	M10x40	2
39	04-84	Drain Plug		1
40	04-73	Shift Fork		1
41	04-72	Shifting Crank		1
42	04-71	Shift Fork		1
43	04-70	Shifting Crank		1
44	GB1096	Key	5x18	1

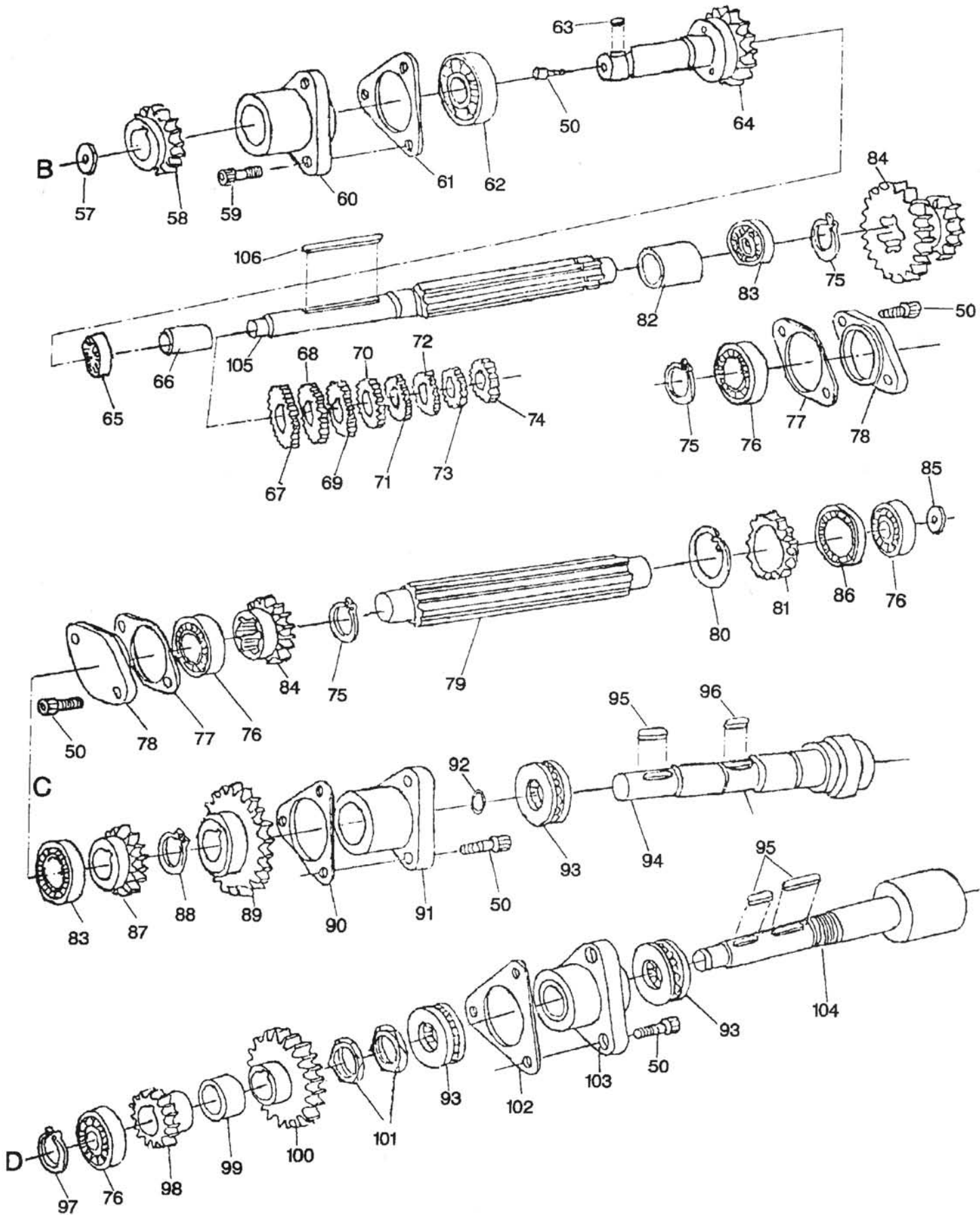
45	GB30809	Steel Ball	9	2
46	GB2089-0.9x9x40	Sping		2
47	04-67	Shaft		1
48	GB3452.4	O-Ring	15x2.65	2
49	04-69	Shaft		1
50	04-63	Shaft		1
51	GB77	Set Screw	M12x1	2
52	04-68	Cover		1
53	04-95	Lever		1
54	04-61	Collar		1
55	04-21	Shaft(A)		1
56	04-12	Washer		1
57	04-11	Pulley		1
58	GH1340A-11-10	Brake Block		1
59	GB879-5x25	Pin		1
60	11-09	Brake Actuator Shaft		1
61	GB896.6-12	Retainer Ring	12	1
62	11-15	Brake Shoe Assembly		1
63	GB894.1-12	Retainer Ring	12	1
64	11-11	Brake Retainer Stud		1
65	TS-150305	Hex Socket Cap Screw	M6x20	6
66	HG4-692-67	Spacer	SD25x45x10	1
67	04-13	Cover		1
68	04-14	Gasket		1
69	GB894.2-25	Retainer Ring	25	5
70	BB6205	Ball Bearing		1
71	GB1096	key	8x20	1
72	GB1096	Key	8x50	2
73	GH1340-04-18	Key	7x50	1
74	TS-150404	Hex Socket Cap Screw	M8x20	1
75	GH1340A-04-15	Gear	38T	1
76	GH1340A-04-16	Gear	23T	1
77	GH1340A-04-17	Collar		1
78	GH1340A-04-19	Gear	30T	1
79	GH1340A-04-20	Gear	46T	1
80	BB-6204	Ball Bearing		4
81	GB894.2-20	Retainer Ring	20	1
82	04-40	Plug		1
83	GB3452.5	O-Ring	19x2.65	1
84	04-65	Shaft(B)		1
85	04-53	Bearing Cap		2
86	04-52	Bearing Cap Gasket		2
87	04-64	Collar		1
88	GB894.2-50	Retainer Ring		2
89	04-66	Gear	39T	1
90	04-22	Gear	54T	1
91	04-23	Gear	47T	1
92	04-24	Gear	31T	1
93	04-25	Spacer		1
94	BB-6105	Ball Bearing		2
95	GB894.2-37	Retainer Ring		1
96	04-26	Gear	60T	1
97	GB1096	Key	8x28	1
98	04-27	Gear	21T	1
99	GB893.1-41	Retainer Ring		1
100	04-28	Plug		1
101	GB3452.6	O-Ring	40x3.55	1

102.....04-31.....	Spindle.....	1
103.....GB70.....	Hex Socket Cap Screw.....M6x16.....	6
104.....04-59.....	Spindle Bearing Cover.....	1
105.....04-60.....	Gasket.....	1
106.....GB70.....	Hex Soxket Cap Screw.....M5x14.....	2
107.....04-58.....	Lock Collar.....	1
108.....GB297.....	Tapered Roller Bearing.....D7210.....	1
109.....04-57.....	Gear.....38T.....	1
110.....GB894.2-55.....	Retainer Ring.....	1
111.....04-32.....	Gear.....43T.....	1
112.....04-34.....	Gear.....82T.....	1
113.....04-33.....	Collar.....	1
114.....GB297.....	Tapered Roller Bearing.....D7511.....	1
115.....04-30.....	Gasket.....	1
116.....04-29.....	Front Bearing Cover.....	1
117.....GB70.....	Hex Socket Cap Screw.....M6x25.....	3
118.....GB1096.....	Key.....8x32.....	1
119.....GB1096.....	Key.....8x56.....	1
120.....04-85.....	Camlock.....	3
121.....04-86.....	Camlock Set Pin.....	3
122.....GB1096-0.6x4x22.....	Sping.....	3
123.....GB70.....	Hex Socket Cap Screw.....M8x18.....	3
124.....04-37.....	Shaft(C).....	1
125.....GB3452.7.....	O-Ring.....23.6x2.65.....	1
126.....GB1096.....	Key.....5x16.....	1
127.....04-55.....	Gear.....21T.....	1
128.....04-54.....	Gear.....32T.....	1
129.....GB894.2-38.....	Retainer Ring.....	1
130.....04-36.....	Spacer.....	2
131.....04-35.....	Gear.....32T.....	1
132.....04-47.....	Shaft(D).....	1
133.....GB1096.....	Key.....6x90.....	1
134.....04-46.....	Gear.....42T.....	1
135.....04-45.....	Collar.....	1
136.....04-44.....	Gear.....32T.....	1
137.....04-41.....	Gear.....32T.....	1
138.....04-39.....	Collar.....	1
139.....04-42.....	Shaft(E).....	1
140.....HG4-692-67A.....	Spacer.....25x40x10.....	1
141.....04-49.....	Housing.....	1
142.....04-48.....	Housing Gasket.....	1
143.....BB-6104.....	Ball Bearing.....	2
144.....04-43.....	Gear.....38T.....	1

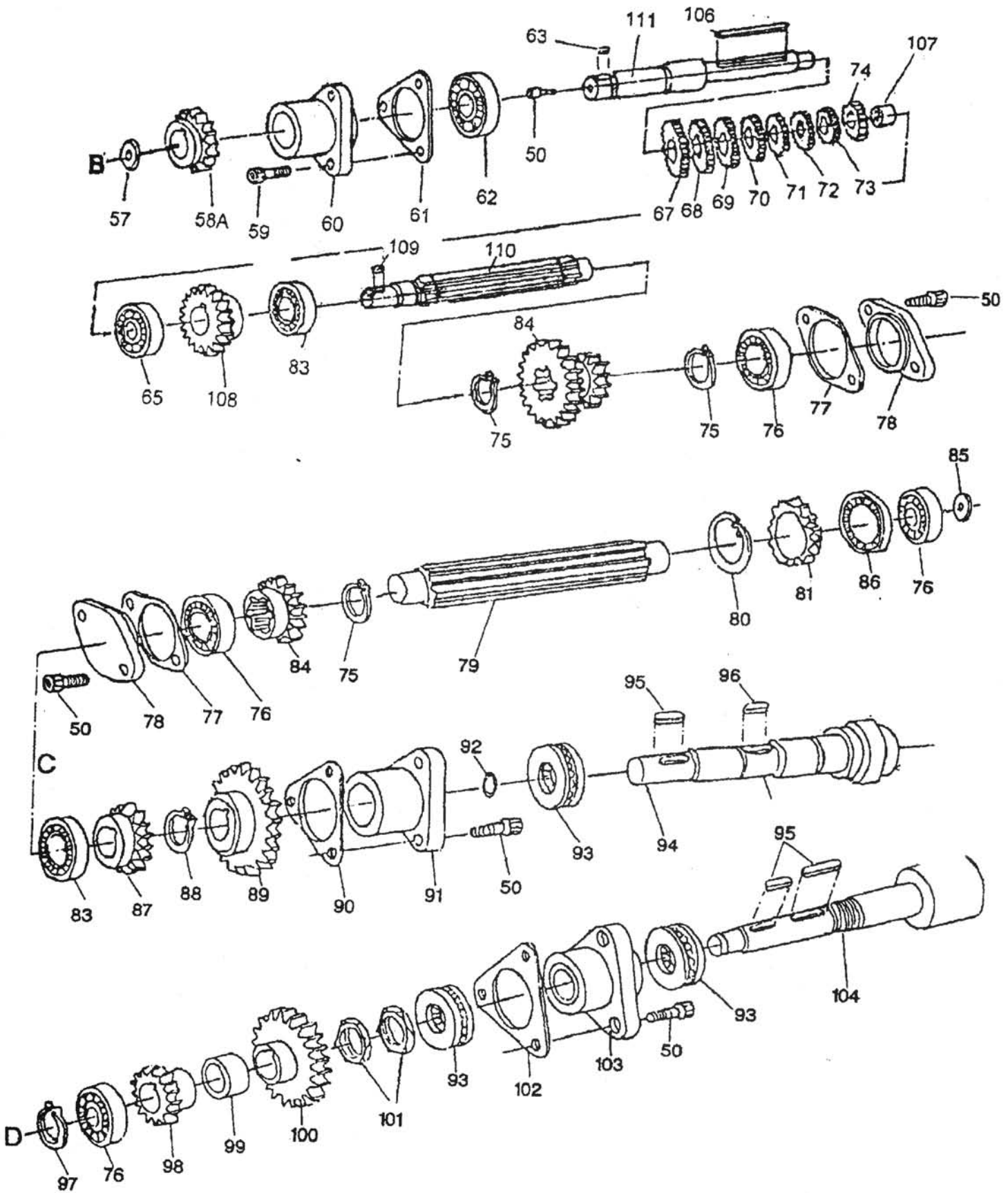
Gearbox Assembly



Gearbox Assembly(Inch system)



Gearbox(Metric system)

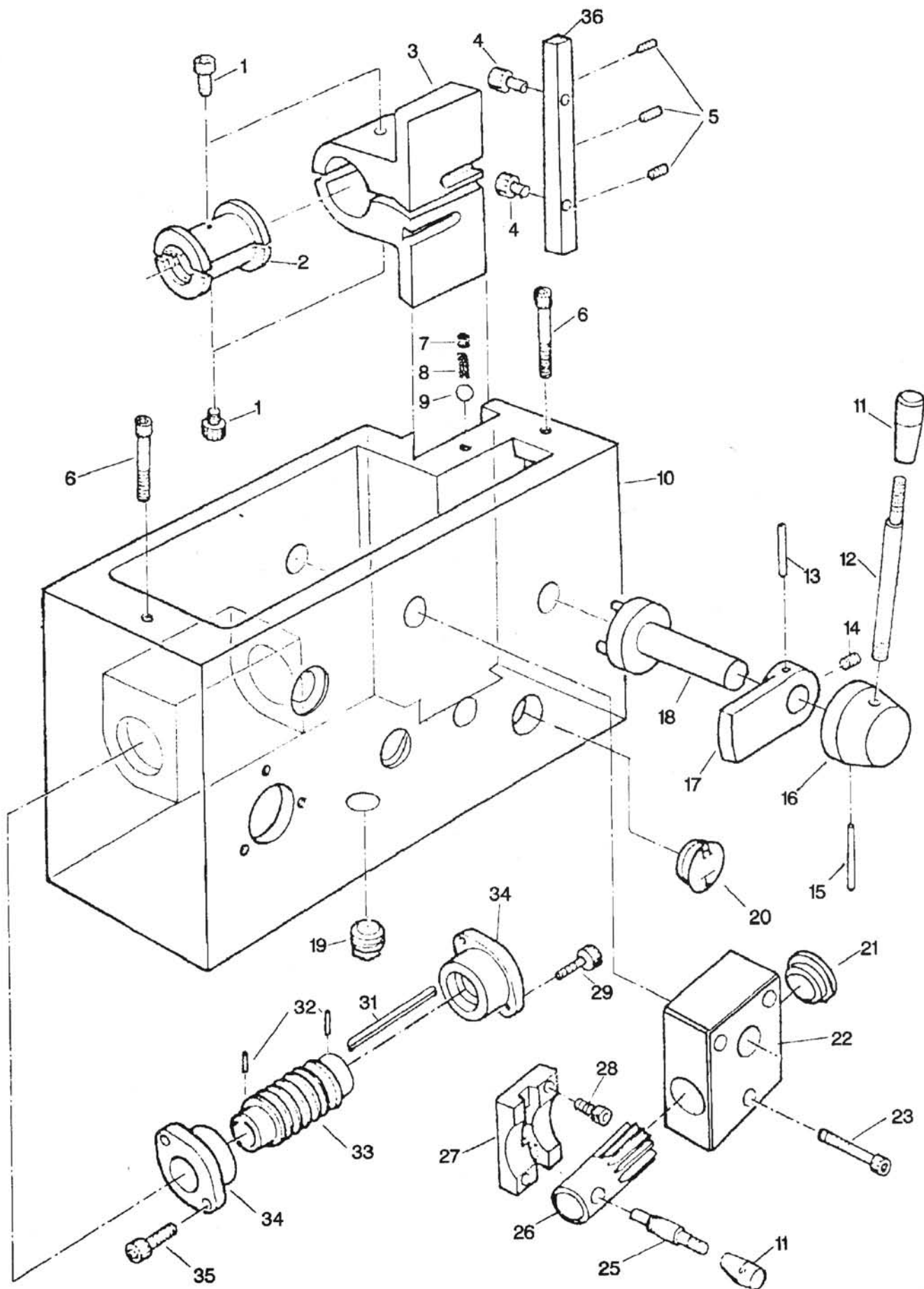


Gearbox Assembly

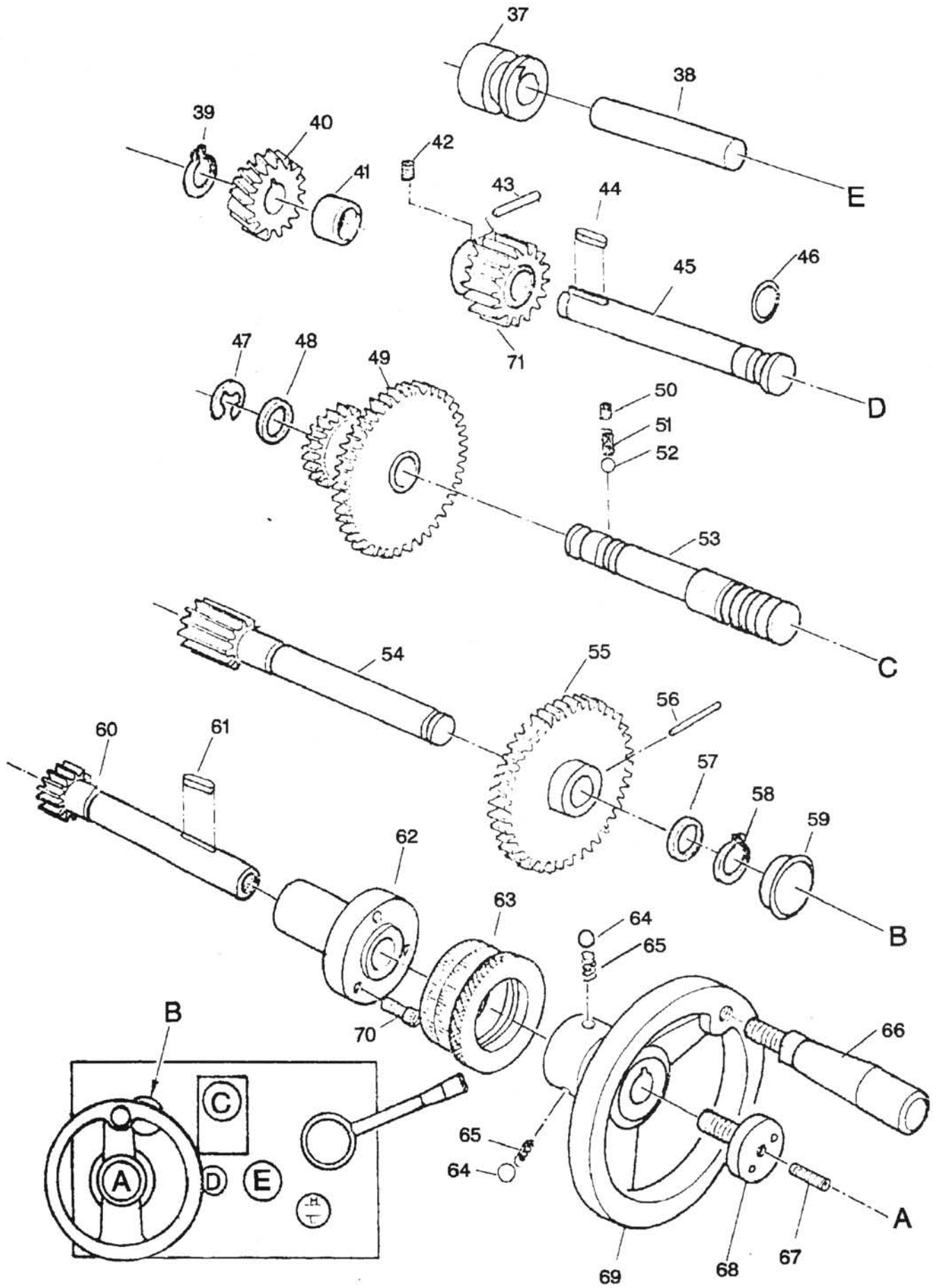
1	05-63	Gearbox Casting		1
2	05-61	Gasket		1
3	05-07	Front Cover		1
4	05-54	Cover		1
5	GB819	Flat Head Machine Screw	M4x10	8
6	GB70	Hex Socket Cap Screw	M8x40	1
7	GB117	Pin	5x20	2
8	GB70	Hex Socket Cap Screw	M8x25	2
9	GB117	Pin	5x28	2
10	05-05	Locating Fork		1
11	1000098	Spacer		1
12	GB893.1-19	Retainer Ring		1
13	05-51	Shaft		1
14	05-03	Shifter		1
15	GB70	Hex Socket Cap Screw	M6x10	2
16	05-13	Rack		1
17	05-14	Gear	26T	1
18	GB879-5x20	Pin		1
19	05-55	Shift Fork		1
20	GB79	Set Screw	M6x8	1
21	05-56	Shift Lever		1
22	GB879-5x20	Pin		1
23	GB1096	Key	4x10	2
24	05-57	Shaft		1
27	GB78	Set Screw	M6x8	1
28	05-02	Shaft		1
29	GB78	Set Screw	M6x8	2
30	05-12	Shift Fork		1
31	05-01	Shift Key		3
33	05-05	Locating Plate		1
34	05-04	Control Plate		1
35	05-60	Shift Hub		1
36	GB1096	Key	4x10	1
37	Q/2B285.3	Plug		1
38	05-66	Cover		1
39	05-59	Locating Disk		1
40	05-10	Locating Disk		1
41	05-58	Locating Disk		1
42	GB819	Flat Head Machine Screw	M5x10	6
43	GB1160-12	Hub		1
44	GB308-6.5	Steel Ball		9
45	GB2089-0.8x5x25	Spring		4
46	05-09	Shift Hub		2
47	05-68	Shift Hub		1
48	05-08	Washer		2
49	05-08	Washer		1
50	GB70	Hex Socket Cap Screw	M6x16	7
51	GB70	Hex Socket Cap Screw	M6x16	1
52	05-70	Indicator Disk		2
52A	04-90	Indicator Disk		1
53	GB818	Pan Head Machine Screw	M3x6	6
54	GB4141.14-BM10x50	Handle Cap		1
55	05-69	Handle Shaft		1
56	GB77	Set Screw	M8x8	4
57	05-42	Retaining Clip		1

58.....	05-41.....	Gear.....	52T.....	1
58A.....	05-41/1.....	Gear.....	60T.....	1
59.....	GB70.....	Hex Socket Cap Screw.....	6x20.....	3
60.....	05-39.....	Flange.....		1
61.....	05-38.....	Gasket.....		1
62.....	BB-6104.....	Ball Bearing.....		1
63.....	GB1096-5x14.....	Key.....		1
64.....	05-40.....	Gear Shaft Assembly.....		1
65.....	7000102.....	Ball Bearing.....		1
66.....	05-36.....	Shaft Collar.....		1
67.....	05-35.....	Gear.....	28T.....	1
68.....	05-34.....	Gear.....	26T.....	1
69.....	05-33.....	Gear.....	24T.....	1
70.....	05-32.....	Gear.....	23T.....	1
71.....	05-31.....	Gear.....	22T.....	1
72.....	05-30.....	Gear.....	20T.....	1
73.....	05-29.....	Gear.....	18T.....	1
74.....	05-28.....	Gear.....	16T.....	1
75.....	GB894.1-20.....	Retainer Ring.....		2
76.....	BB-6202.....	Ball Bearing.....		4
77.....	05-48.....	Gasket.....		2
78.....	05-47.....	Flange.....		2
79.....	05-52.....	Shaft.....		1
80.....	GB893.1-32.....	Retainer Ring.....		2
81.....	05-49.....	Gear.....	16T.....	1
82.....	05-67.....	Shaft Collar.....		1
83.....	BB-61.3.....	Ball Bearing.....		2
84.....	05-37.....	Gear.....	26T.....	1
85.....	GH1340A-05-66.....	Washer.....		1
86.....	1000804.....	Bearing.....		2
87.....	05-25.....	Gear.....	21T.....	1
88.....	GB876-15.....	Retainer Ring.....		1
89.....	05-19.....	Gear.....	36T.....	1
90.....	05-53.....	Gasket.....		1
91.....	05-17.....	Flange.....		1
92.....	GB-3452.1-15x2.65.....	O-Ring.....		1
93.....	BB-8104.....	Ball Bearing.....		2
94.....	05-16.....	Shaft.....		1
95.....	GB1096.....	Key.....	5x14.....	1
96.....	GB1096.....	Key.....	6x14.....	1
97.....	GB894.1-15.....	Retainer Ring.....		1
98.....	05-26.....	Gear.....	16T.....	1
99.....	05-24.....	Collar.....		1
100.....	05-22.....	Gear.....	32T.....	1
101.....	05-20.....	Nut.....		2
102.....	05-53.....	Gasket.....		1
103.....	05-18.....	Flange.....		1
104.....	05-23.....	Shaft.....		1
105.....	05-27.....	Shaft.....		1
106.....	GB1096.....	Key.....	5x76.....	1
107.....	05-67/1.....	Shaft Collar.....		1
108.....	05-36/1.....	Gear.....	26T.....	1
109.....	GB1096.....	Key.....	5x8.....	1
110.....	05-27/1.....	Shaft.....		1
111.....	05-40/1.....	Shaft.....		1

Apron Assembly



Apron Assembly

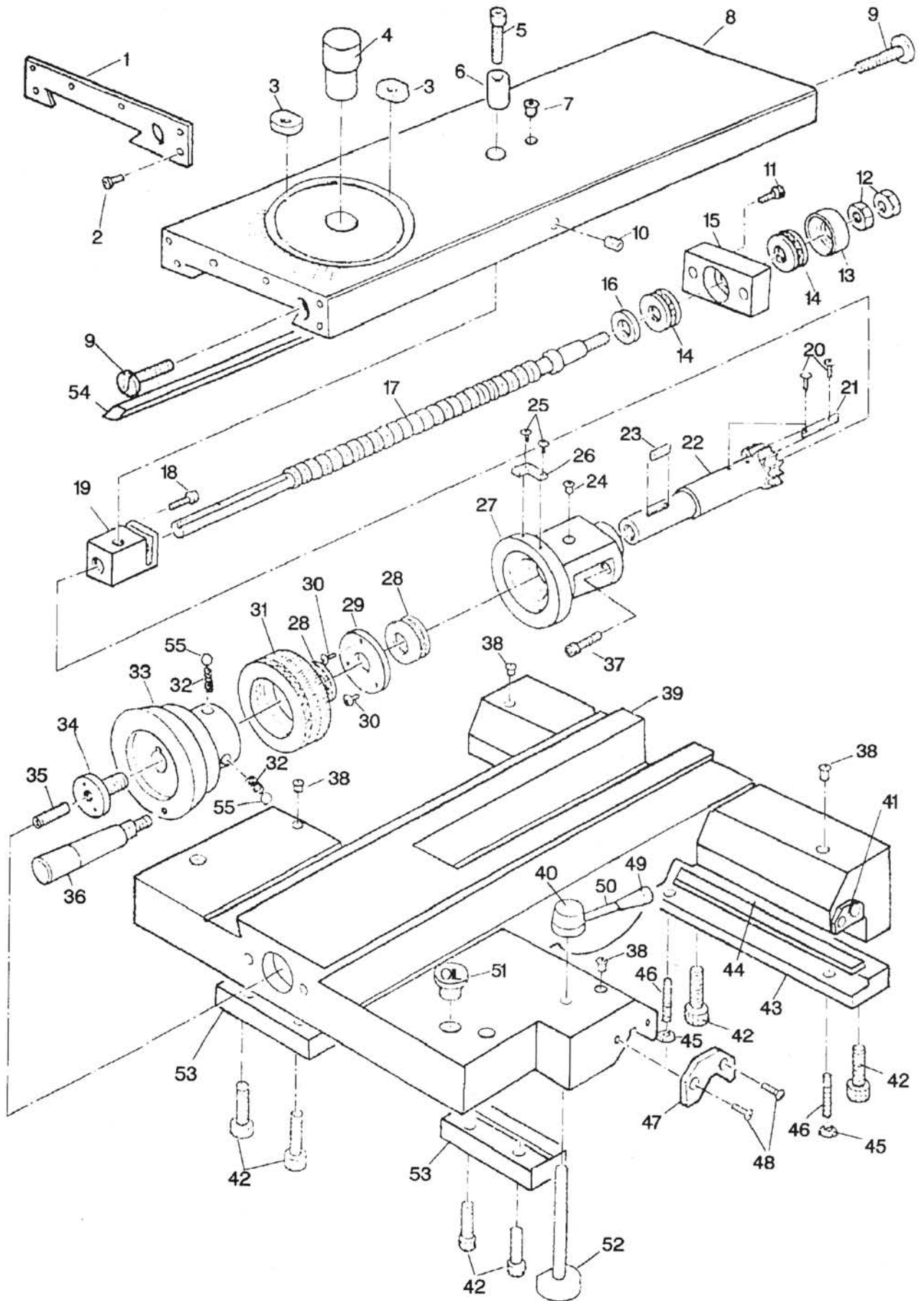


Apron Assembly

1.....	GB70.....	Hex Socket Cap Screw.....	M6x10.....	2
2.....	06-37.....	Half Nut.....		1
3.....	06-36.....	Bracket.....		1
4.....	GB70.....	Hex Socket Cap Screw.....	M6x16.....	2
5.....	GB78.....	Set Screw.....	M6x10.....	3
6.....	GB70.....	Hex Socket Cap Screw.....	M8x40.....	2
7.....	GB78.....	Set Srew.....	M8x8.....	1
8.....	06-39.....	Spring.....		1
9.....	GB308-6.....	Steel Ball.....	6.....	1
10.....	06-01.....	Casting.....		1
11.....	GB4141.14-BM10x50.....	Knob.....		2
12.....	GH1340A-06-05.....	Handle Shaft.....		1
13.....	GB879.....	Pin.....	5x35.....	1
14.....	GB78.....	Set Screw.....	M6x6.....	1
15.....	GB879-5x50.....	Pin.....		1
16.....	06-29.....	Hub.....		1
17.....	06-40.....	Safety Catch.....		1
18.....	06-42.....	Half Nut Cam.....		1
19.....	Q/ZB285.3.....	Drain Plug.....		1
20.....	GB1160-12.....	Sight Glass.....		1
21.....	06-02.....	Plug.....		1
22.....	GH1340-06-16.....	Block.....		1
23.....	GB70.....	Hex Socket Cap Screw.....	M6x45.....	3
25.....	06-18.....	Handle Shaft.....		1
26.....	GH1340A-06-17.....	Spline Shaft.....		1
27.....	GH1340A-06-04.....	Bracket.....		1
28.....	GB70.....	Hex Socket Cap Screw.....	M6x12.....	2
29.....	GB70.....	Hex Socket Cap Screw.....	M6x16.....	2
31.....	GB1096-5x56.....	Key.....		1
32.....	GB879-3x5.....	Pin.....		2
33.....	06-27.....	Worm.....		1
34.....	06-34.....	Flange.....		2
35.....	GB70.....	Hex Socket Cap Screw.....	M6x12.....	2
36.....	06-33.....	Gib.....		1
37.....	06-44.....	Bushing.....		1
38.....	06-43.....	Shaft.....		1
39.....	GB894.1-16.....	Reainer Ring.....		1
40.....	06-28.....	Gear.....	22T.....	1
41.....	06-26.....	Collar.....		1
42.....	GB78.....	Set Screw.....	M6x6.....	1
43.....	GB879-5x35.....	Pin.....		1
44.....	GB1096-4x15.....	Key.....		1
45.....	06-19.....	Shaft.....		1
46.....	GB3452.1.....	Ring.....	17x1.8.....	1
47.....	GB896-12.....	Retainer Ring.....		1
48.....	06-10.....	Bushing.....		1
49.....	GB1340A-06-15.....	Cluster Gear.....	50T/20T.....	1
50.....	GB80.....	Set Screw.....	M8x8.....	1
51.....	06-14.....	Spring.....		1
52.....	GB608-6.....	Steel Ball.....	6.....	1
53.....	GH1340A-06-13.....	Shaft.....		1
54.....	06-06.....	Shaft.....		1
55.....	06-08.....	Gear.....	50T.....	1
56.....	GB879-5x30.....	Pin.....		1
57.....	06-10.....	Bushing.....		1

58.....	GB894.1-16.....	Retainer Ring.....	1
59.....	06-11.....	Plug.....	1
60.....	06-07.....	Shaft.....	1
61.....	GB1096.....	Key.....	5x15.....1
62.....	06-09.....	Wheel Flange.....	1
63.....	06-31.....	Indicator Ring.....	1
64.....	GB308-6.....	Steel Ball.....	6.....2
65.....	06-32.....	Spring.....	2
66.....	GB4141.5-M10x80.....	Handle.....	2
67.....	GB78.....	Set Screw.....	M6x25.....1
68.....	06-30.....	Wheel Stud.....	1
69.....	06-12.....	Wheel.....	1
70.....	GB70.....	Hex Socket Cap Screw.....	M6x16.....3
71.....	06-20.....	Gear.....	24T.....1

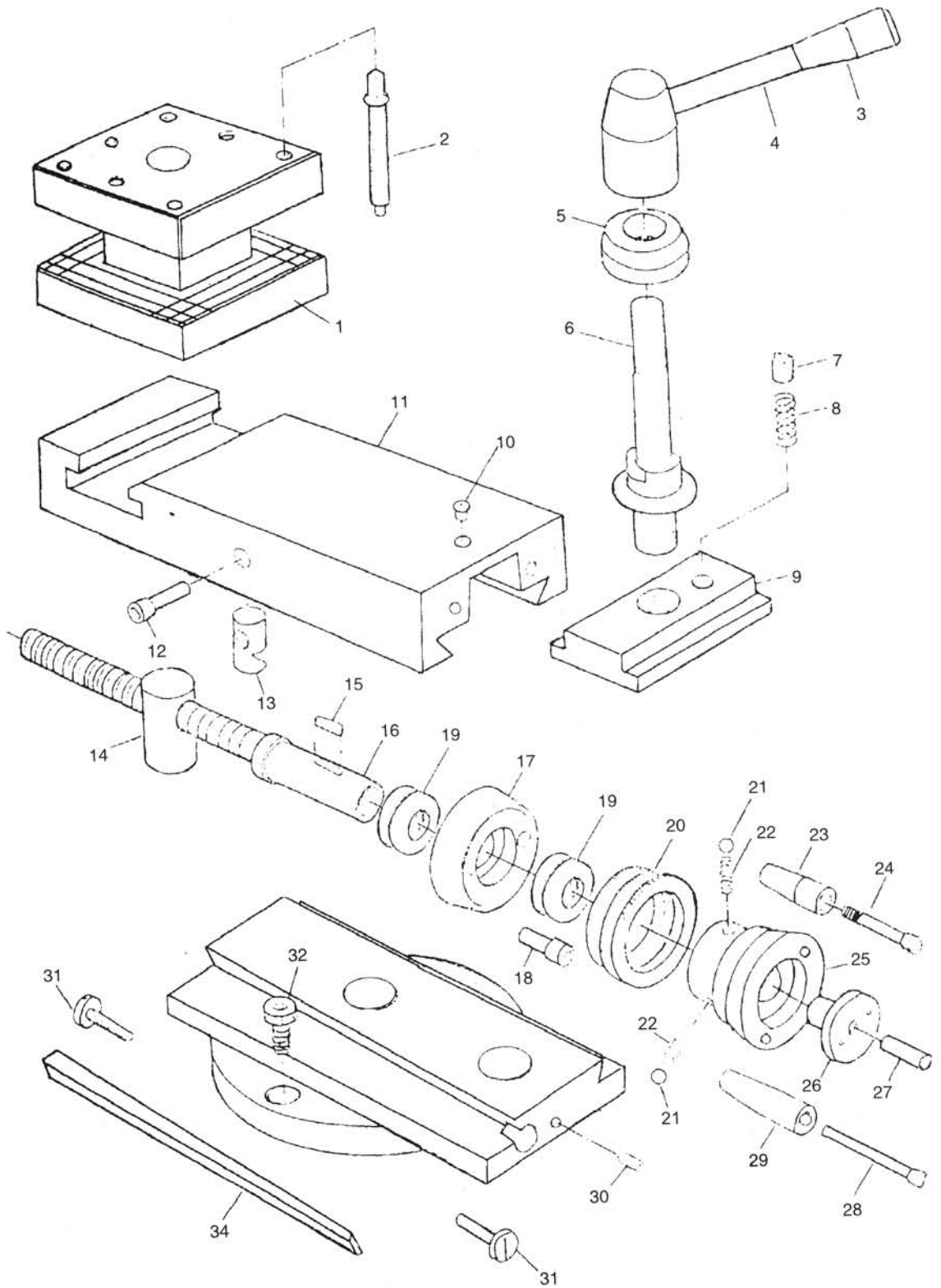
Saddle and Cross Slide Assembly



Saddle and Cross Slide Assembly

1	07-12	Plate w/Wiper	1
2	GB827-2x8	Pan Head Screw	6
3	07-07	Clamp Nut	2
4	07-08	Hub	1
5	GB70	Hex Socket Cap Screw M6x20	1
6	07-05	Sleeve	1
7	GB1155-8	Oiler 8	1
8	07-01	Cross Slide Body	1
9	07-28	Gib Adjusting Screw	2
10	GB80	Set Screw	1
11	GB70	Hex Socket Cap Screw M6x30	2
12	GB6172	Hex Nut M10	2
13	07-02	Bearing Cap	1
14	BB-8101	Thrust Bearing	2
15	07-03	Block	1
16	07-25	Spacer	1
17	07-06	Leadscrew	1
18	GB70	Hex Socket Cap Screw M6x12	1
19	07-22	Crossfeed Nut	1
20	GB819	Pan Head Machine Screw M3x5	2
21	07-21	Key	1
22	07-20	Gear Shaft	1
23	GB1096	Key 4x20	1
24	GB1155-6	Oiler	1
25	GB827-2x8	Pan Head Screw M5x10	2
26	07-14	Plate	1
27	07-19	Housing	1
28	BB-8102	Thrust Bearing	2
29	07-18	Washer	1
30	GB818	Pan Head Machine Screw M5x10	2
31	07-17	Index Ring	1
32	GB2089-0.7x5x9	Spring	2
33	07-16	Compound Handle	1
34	07-15	Cover Screw	1
35	GB78	Set Screw M6x25	1
36	GB4141.5-M10x80	Handle Knob	1
37	GB70	Hex Socket Cap Screw M6x20	1
38	GB1155-8	Oiler	4
39	GH1340A-01	Cross Slide Body	1
40	07-45	Hub	1
41	07-31	Wiper	2
42	GB70	Hex Socket Cap Screw M8x20	6
43	07-24	Rear Pressure Plate	1
44	07-23	Gib	1
45	GB6170	Lock Nut M6	3
46	GB78	Set Screw M6x20	3
47	07-51	Wiper w/Plate	1
48	GB818	Pan Head Machine Screw M5x10	8
49	GB4141.14-M10x50	Konb	1
50	07-46	Handle Shaft	1
51	04-06	Oil Cap	1
52	07-47	Lock Stud	1
53	07-27	Front Pressure Plate	2
54	07-38	Gib	1

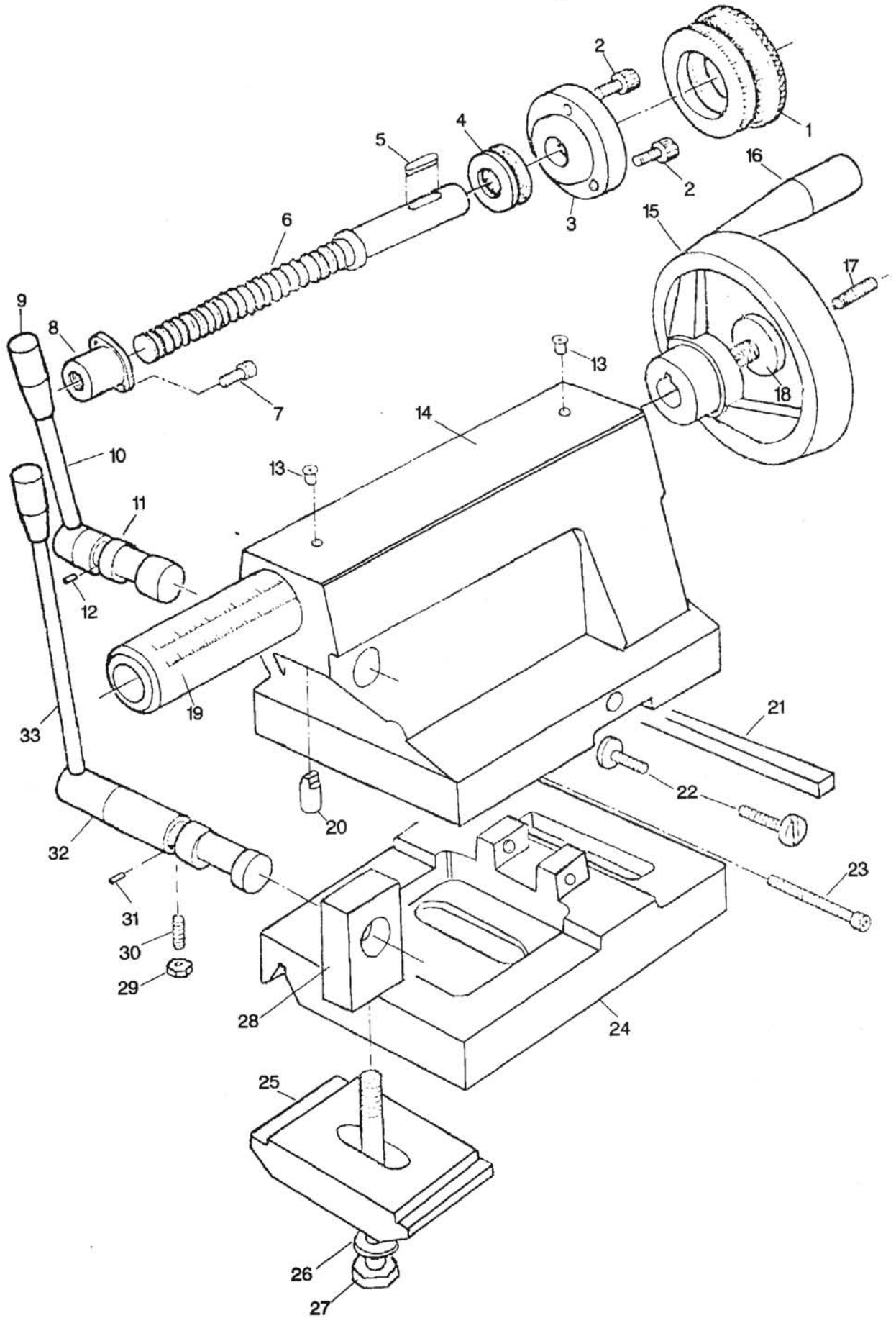
Top Slide and Tool Post



Saddle and Cross Slide Assembly

1.....	07-32.....	Tool Post.....	1
2.....	GB83-10x50.....	Tool Lock Screw.....	8
3.....	GB4141.14-M10x50.....	Knob.....	1
4.....	07-36.....	Handle Shaft.....	1
5.....	07-33.....	Spacer.....	1
6.....	07-34.....	Tool Post Pin.....	1
7.....	07-29.....	Tool Post Position Pin.....	1
8.....	GB2089-1x8x11.....	Spring.....	1
9.....	07-37.....	Clamp Nut.....	1
10.....	GB1155-8.....	Oiler.....	1
11.....	07-49.....	Compound Slide.....	1
12.....	GB70.....	Hex Socket Cap Screw.....	M6x20.....
13.....	07-09.....	Position Pin.....	1
14.....	07-39.....	Nut.....	1
15.....	GB1096-4x14.....	Key.....	1
16.....	07-40.....	Compound Screw.....	1
17.....	07-41.....	Screw Bushing.....	1
18.....	GB70.....	Hex Socket Cap Screw.....	M6x20.....
19.....	BB-8103.....	Thrust Bearing.....	2
20.....	07-42.....	Index Ring.....	1
21.....	GB308-6.....	Steel Ball.....	6.....
22.....	GB2089-0.7x5x9.....	Spring.....	1
23.....	07-43.....	Handle.....	1
24.....	GB70.....	Hex Socket Cap Screw.....	M5x25.....
25.....	07-48.....	Handwheel.....	1
26.....	07-15.....	Handle Screw.....	1
27.....	GB78.....	Set Screw.....	M6x25.....
28.....	GB70-M5x40.....	Set Screw.....	M4x40.....
29.....	07-44.....	Handle.....	1
30.....	GB80.....	Set Screw.....	M6x16.....
31.....	07-28.....	Gib Adjusting Screw.....	2
32.....	GB70.....	Hex Socket Cap Screw.....	M8x16.....
34.....	07-10.....	Gib.....	1

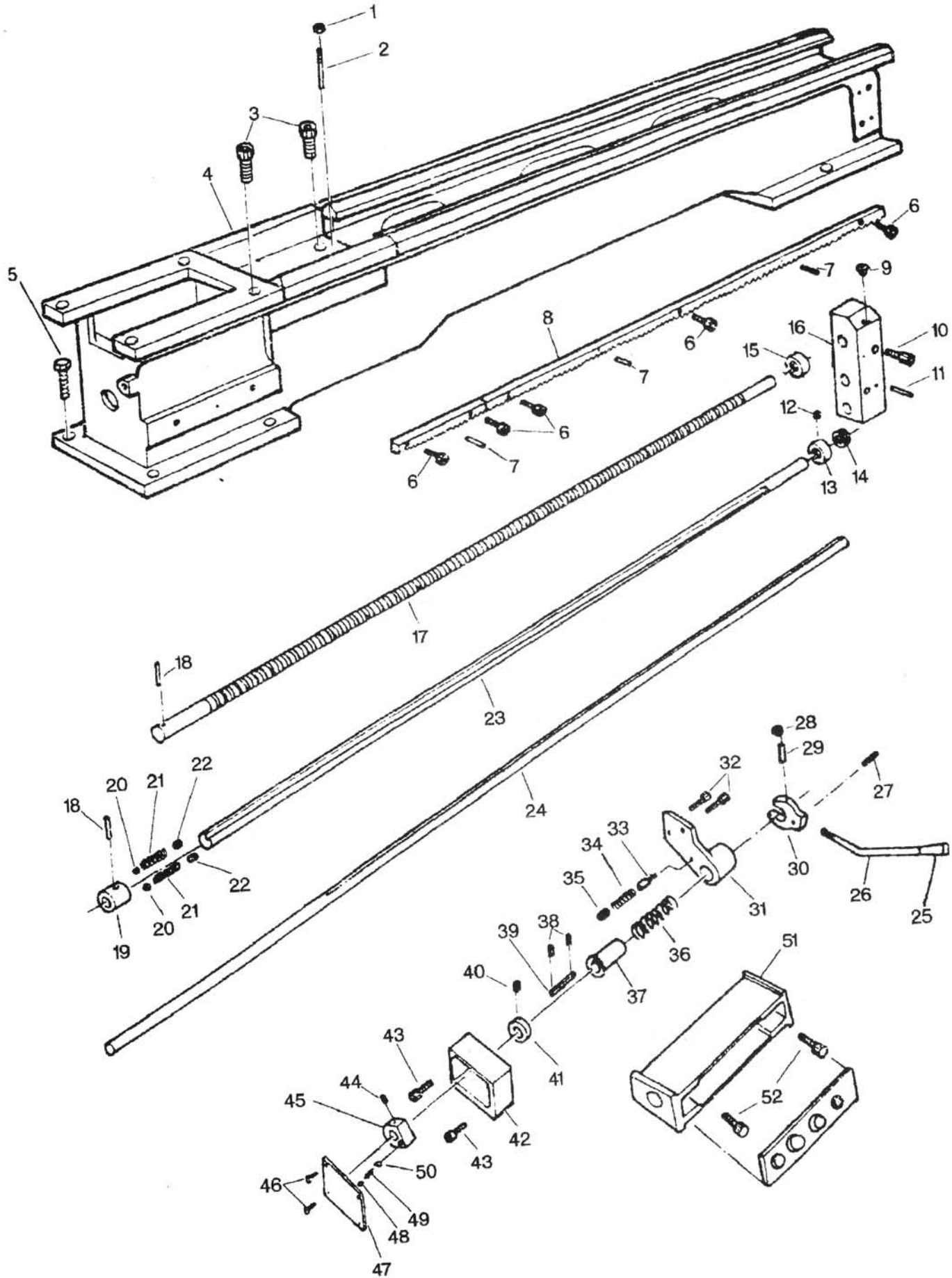
Tailstock Assembly



Tailstock Assembly

1.....	08-09.....	Index Ring.....	1
2.....	GB70.....	Hex Socket Cap Screw..... M6x20.....	3
3.....	08-08.....	Hub.....	1
4.....	BB-8103.....	Thrust Bearing.....	1
5.....	GB1096.....	key..... 4x20.....	1
6.....	08-05.....	Screw.....	1
7.....	GB70.....	Hex Socket Cap Screw..... M6x16.....	2
8.....	08-06.....	Flange.....	1
9.....	GB4141.5-B10x50.....	Knob.....	2
10.....	08-17.....	Lever Handle.....	1
11.....	08-03.....	Eccentric Shaft.....	1
12.....	GB879-5x12.....	Pin.....	1
13.....	GB1155.....	Oiler..... 10.....	2
14.....	08-01.....	Tailstock Body.....	1
15.....	08-20.....	Wheel.....	1
16.....	GB4141.5-M10x80.....	Handle.....	1
17.....	GB78.....	Set Screw..... M6x25.....	1
18.....	08-12.....	Wheel Screw.....	1
19.....	08-04.....	Spindle.....	1
20.....	08-02.....	Stop Pin.....	1
21.....	08-19.....	Gib.....	1
22.....	08-18.....	Gib Adjusting Screw.....	2
23.....	GB70.....	Hex Socket Cap Screw..... M8x45.....	2
24.....	08-13.....	Tailstock Base.....	1
25.....	08-14.....	Tailstock Clamp Plate.....	1
26.....	GB95.....	Washer 12.....	2
27.....	GB5782.....	Hex Cap Bolt..... M12x75	1
28.....	08-16.....	Block.....	1
29.....	GB41.....	Nut..... M6	1
30.....	GB77.....	Set Screw M6x16	1
31.....	GB879.....	Pin 5x12.....	1
32.....	08-15.....	Eccentric Shaft.....	1
33.....	08-10.....	Lever Handle.....	1

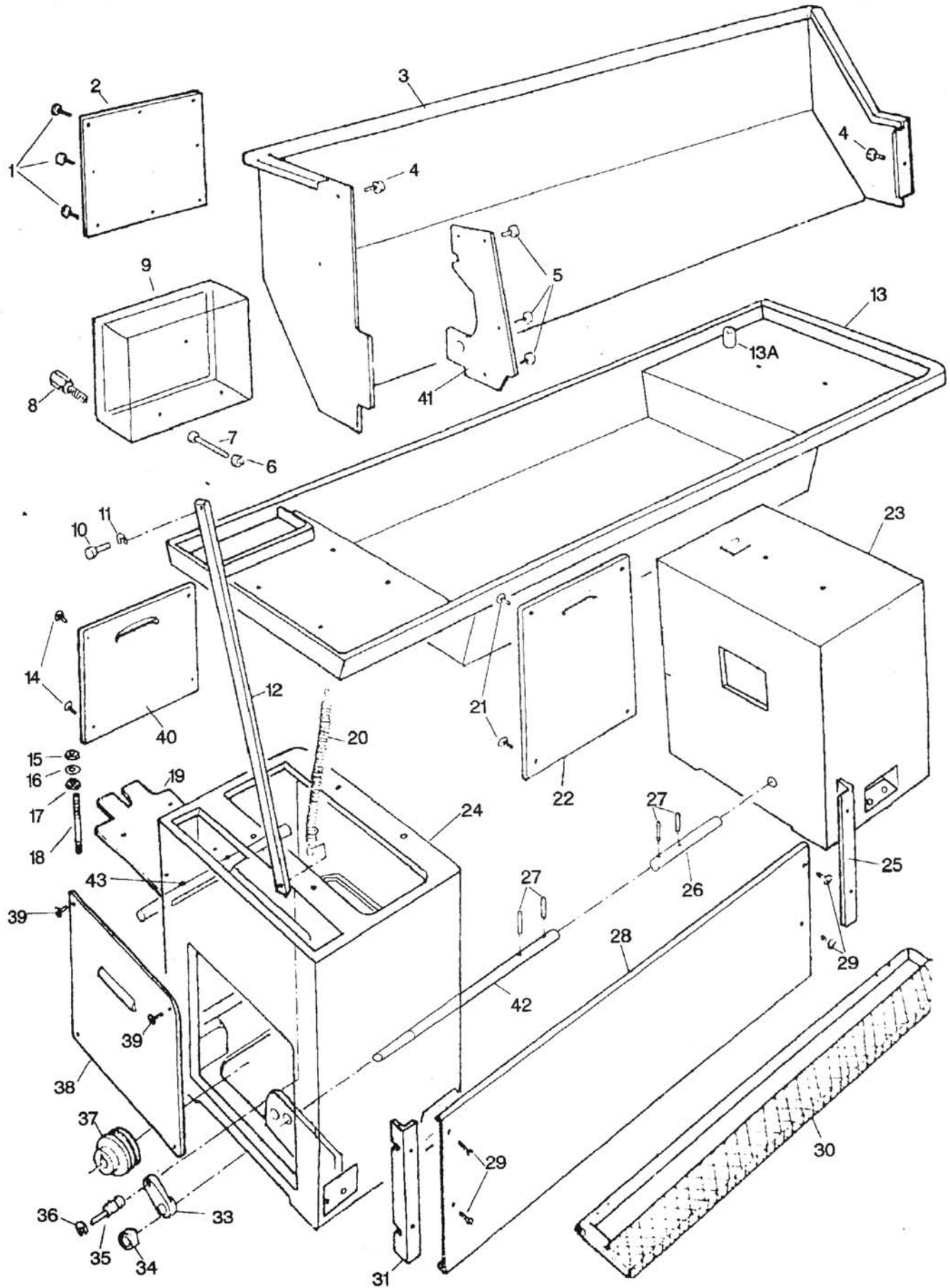
Bed and Shaft Assembly



Bed and Shaft Assembly

1	GB6172	Nut	M8	1
2	GB881	Pin	8x60	1
3	GB70	Hex Socket Cap Screw	M10x40	2
4	01-39	Gap		1
5	GB5781	Hex Cap Bolt	M12x50	4
6	GB70	Hex Socket Cap Screw	M6x25	6
7	GB879	Pin	5x35	6
8	01-07	Rack		1
9	Gb-1155-10	Oiler	10	1
10	GB70	Hex Socket Cap Screw	M8x55	2
11	GB117	Pin	5x60	2
12	GB79	Set Screw	M8x10	1
13	01-16	Collar		1
14	01-18	Plug		2
15	01-10	Collar		1
16	01-13	End Bracket		1
17	01-11	Lead Screw		1
18	GB879	Pin	5x35	2
19	01-05	Clutch		1
20	GB308-6	Steel Ball	6	2
21	01-38	Spring		2
22	GB79	Set Screw	M8x10	2
23	01-15	Feed Shaft		1
24	01-17	Spindle Control Shaft		1
25	GB4141.14-BM10x50	Knob		1
26	01-081/6	Control Handle		1
27	GB879	Set Screw	3x20	1
28	GB41	Nut	M6	2
29	GB78	Set Screw	M6x20	1
30	01-086/6	Control Fork		1
31	01-084/6	Control Bracket		1
32	GB70	Hex Socket Cap Screw	M6x16	2
33	01-082/6	Pin		1
34	GB2089-0.8x5x25	Spring		1
35	GB78	Set Screw	M8x8	1
36	GB2089-3x35x70	Spring		1
37	01-085/6	Sleeve		1
38	GB79	Set Screw	M3x6	2
39	01-083/6	Key		1
40	GB79	Set Screw	M6x10	1
41	01-03	Collar		1
42	12-02	Switch Box		1
43	GB70	Hex Socket Cap Screw	M6x20	2
44	GB73	Set Screw	M6x16	1
45	01-28	Shift Collar		1
46	GB818	Pan Head Machine Screw	M4x10	4
47	12-03	Cover Plate		1
48	GB79	Set Screw	M8x16	1
49	GB2089-1x5x22	Spring		1
50	GB308-6	Steel Ball	6	1
51	12-01	Control Panel Assembly		1
52	GB70	Hex Socket Cap Screw	M8x25	2

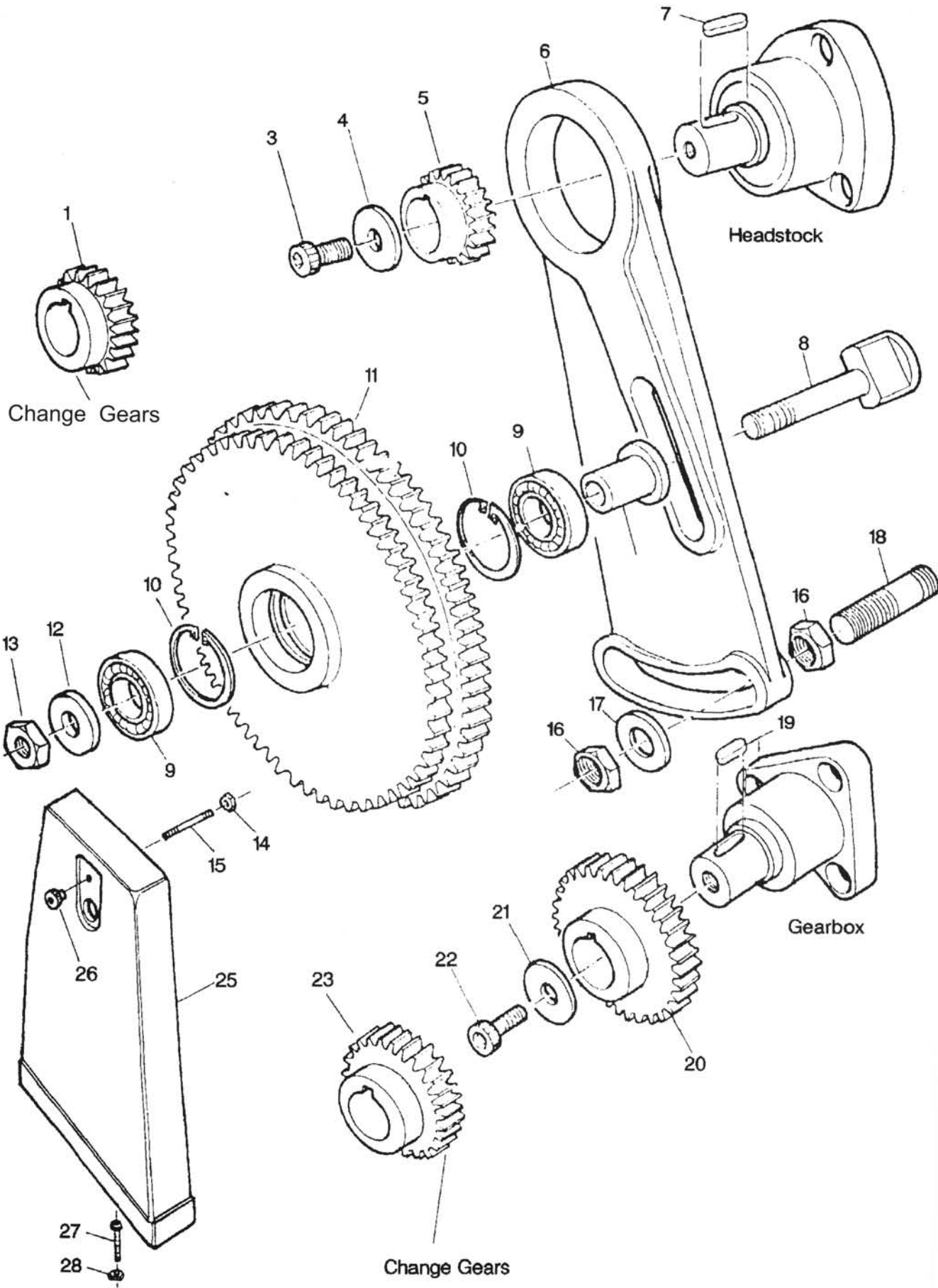
Stand and Brake Assembly



Stand and Brake Assembly

1.....	GB70.....	Hex Socket Cap Screw.....	M5x16.....	8
2.....	12-06.....	Electrical Box Cover.....		1
3.....	01-09.....	Splash Guard.....		1
4.....	GB70.....	Hex Socket Cap Screw.....	M6x10.....	3
5.....	GB70.....	Hex Socket Cep Screw.....	M6x10.....	3
6.....	GB6170.....	Hex Nut.....	M6.....	4
7.....	GB70.....	Hex Socket Cap Screw.....	M6x20.....	4
8.....	01-26.....	Bolt.....		1
9.....	12-07.....	Electrical Box.....		1
10.....	11-12.....	Pin.....		1
11.....	GB896-6.....	Clip.....	6.....	1
12.....	11-08.....	Connector Bar.....		1
13.....	01-33.....	Chip Tray.....		1
13A.....	GH1340-SP.....	Spacer.....		6
14.....	GB70.....	Hex Socket Cap Screw.....	M6x10.....	4
15.....	GB41.....	Hex Nut.....	M12.....	1
16.....	GB97.2.....	Washer.....	12.....	1
17.....	GB41.....	Hex Nut.....	M12.....	1
18.....	01-23.....	Screw.....		1
19.....	01-22.....	Plate.....		1
20.....	11-04.....	Spring.....		1
21.....	GB70.....	Hex Socket Cap Screw.....	M6x10.....	4
22.....	01-34.....	Cover.....		1
23.....	01-20.....	Pedestal (right).....		1
24.....	01-01.....	Pedestal (left).....		1
25.....	01-32.....	Bracket.....		1
26.....	11-01.....	Shaft.....		1
27.....	GB879.....	Pin.....	5x15.....	4
28.....	01-21.....	Front Plate.....		1
29.....	GB70.....	Hex Socket Cap Screw.....	M6x10.....	8
30.....	11-023/3.....	Brake Pedal.....		1
31.....	01-32.....	Bracket.....		1
33.....	11-06.....	Link.....		1
34.....	11-07.....	Link Nut.....		1
35.....	11-05.....	Shaft Pin.....		1
36.....	GB896-6.....	Retaining Clip.....		1
37.....	01-24.....	Pulley.....		1
38.....	01-02.....	Cover.....		1
39.....	GB70.....	Hex Socket Cap Screw.....		4
40.....	01-25.....	Cover.....		1
41.....	01-04.....	Cover Plate.....		1
42.....	11-03.....	Shaft.....		1
43.....	01-29.....	Shaft.....		1

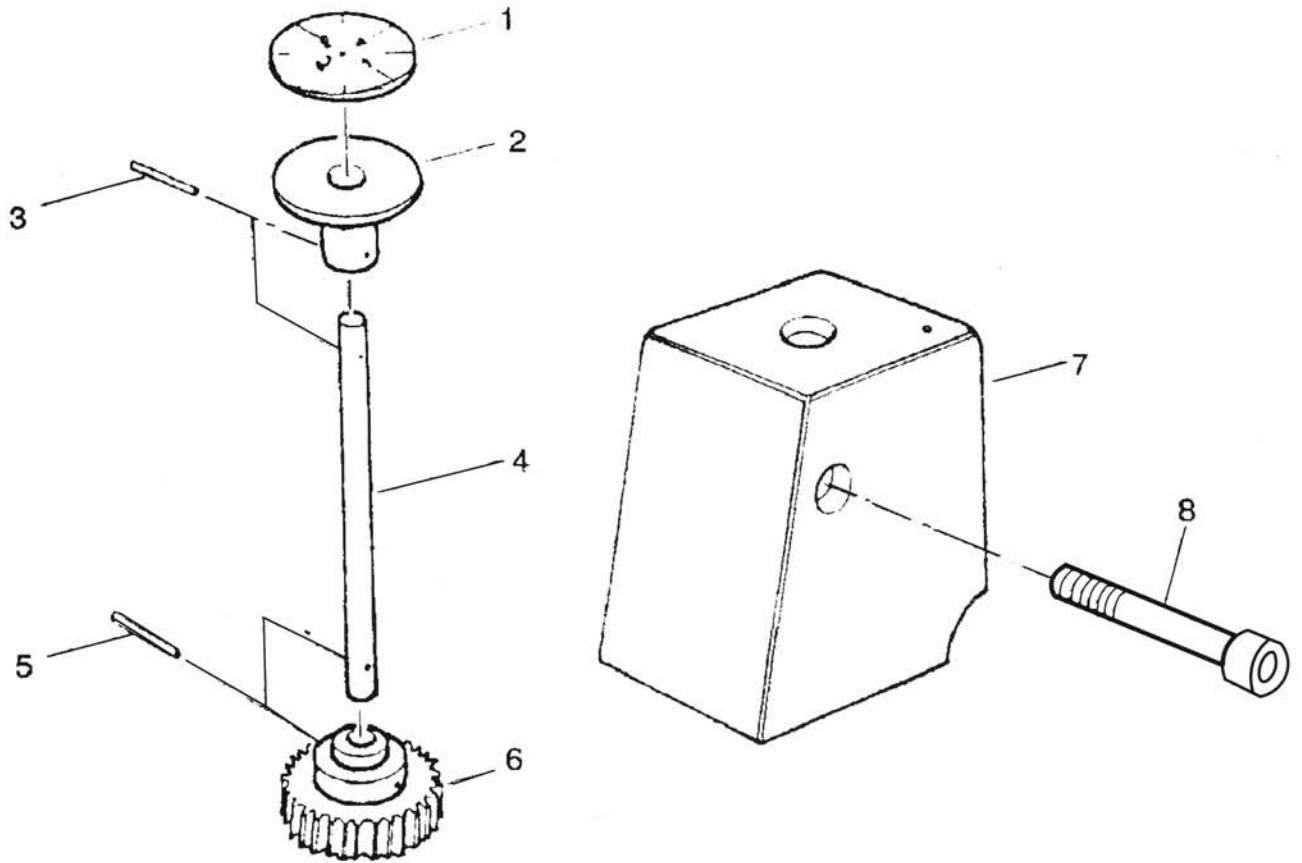
End Gear Assembly



End Gear Assembly

1.....	15-02A	Gear.....	40T.....	1
15-02B.....	Gear(Inch).....	45T.....	1
15-02C.....	Gear(Metric).....	32T.....	1
3.....	GB70.....	Hex Socket Cap Screw.....	M5x16.....	1
4.....	04-51.....	Washer.....		1
5.....	04-50A.....	Gear(for GH-1340A Inch System).....	25T.....	1
04-50B.....	Gear(for GH-1440A Inch System).....	30T.....	1
04-50C.....	Gear(Metric System).....	24T.....	1
6.....	05-46.....	Quadrant.....		1
7.....	GB1096.....	Key.....	5x14.....	1
8.....	05-43.....	Threaded Shaft.....		1
9.....	BB-6103.....	Ball Bearing.....		2
10.....	GB8931-35.....	Retaining Ring.....		2
11.....	05-65.....	Gear.....	120/127T.....	1
12.....	05-44.....	Washer.....		1
13.....	GB6175.....	Nut.....	M10.....	1
14.....	GB6175.....	Nut.....	M10.....	1
15.....	GB1097.....	Stud.....	M10x80.....	2
16.....	GB41.....	Nut.....	M12.....	2
17.....	GB97.2.....	Washer.....	12-140HV.....	1
18.....	01-36.....	Stud.....		1
19.....	GB1096.....	Key.....	5x14.....	1
20.....	05-41A.....	Gear(for GH-1340A Inch System).....	50T.....	1
04-41B.....	Gear.....	60T.....	1
21.....	05-42.....	Washer.....		1
22.....	GB70.....	Hex Sock Cap Screw.....	M6x16.....	1
23.....	15-03A.....	Gear(Inch).....	32T.....	1
15-03B.....	Gear(Inch).....	40T.....	1
15-03C.....	Gear(Metric).....	65T.....	1
15-03D.....	Geat(Metric).....	66T.....	1
15-03E.....	Gear(Metric).....	70T.....	1
25.....	04-78.....	Gear Cover.....		1
26.....	04-77.....	Lock Knob.....		1
27.....	GB70.....	Hex Sock Cap Screw.....	M6x25.....	1
28.....	GB6172.....	Nut.....	M6.....	1

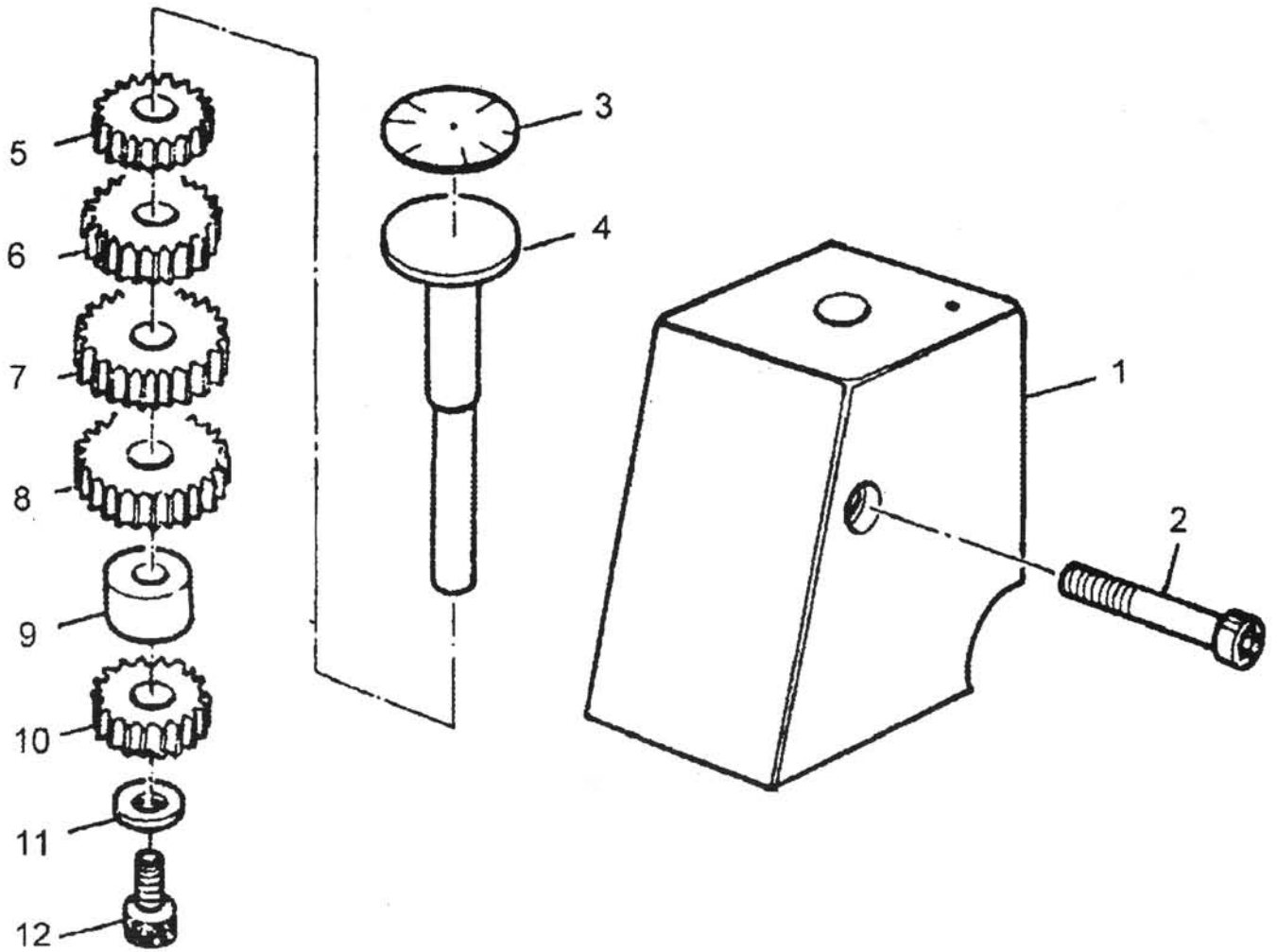
Threading Dial Assembly(Inch system)



Threading Dial Assembly(Inch system)

1.....	09-01.....	Indicator Dial.....	1
2.....	09-02.....	Dial.....	1
3.....	GB879-3x12.....	Pin.....3x12.....	1
4.....	09-03.....	Shaft.....	1
5.....	GB879-5x20.....	Pin.....	1
6.....	09-04.....	Gear.....32T.....	1
7.....	09-05.....	Body.....	1
8.....	GB70.....	Hex Socket Cap Screw.....M6x45.....	1

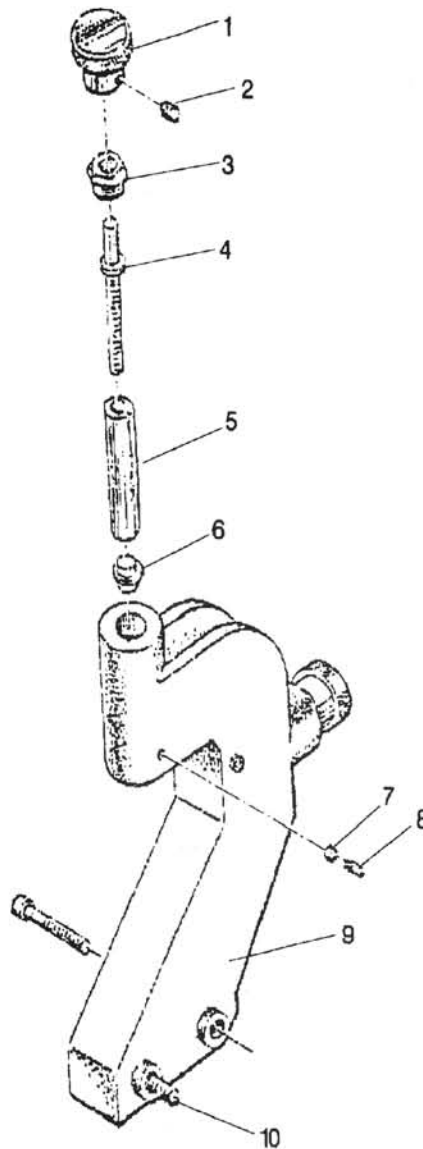
Threading Dial Assembly(Metric system)



Threading Dial Assembly(Metric system)

1.....09-11.....	Body.....	1
2.....GB70.....	Hex Socket Cap Screw.....M6x60.....	1
3.....09-12.....	Indicator Dial.....	1
4.....09-13.....	Shaft.....	1
5.....09-14.....	Gear.....21T.....	1
6.....09-15.....	Gear.....22T.....	1
7.....09-16.....	Gear.....26T.....	1
8.....09-17.....	Gear.....27T.....	1
9.....09-18.....	Collar.....	1
10.....09-19.....	Gear.....20T.....	1
11.....09-20.....	Washer.....	1
12.....GB70.....	Hex Socket Cap Screw.....M6x16.....	1

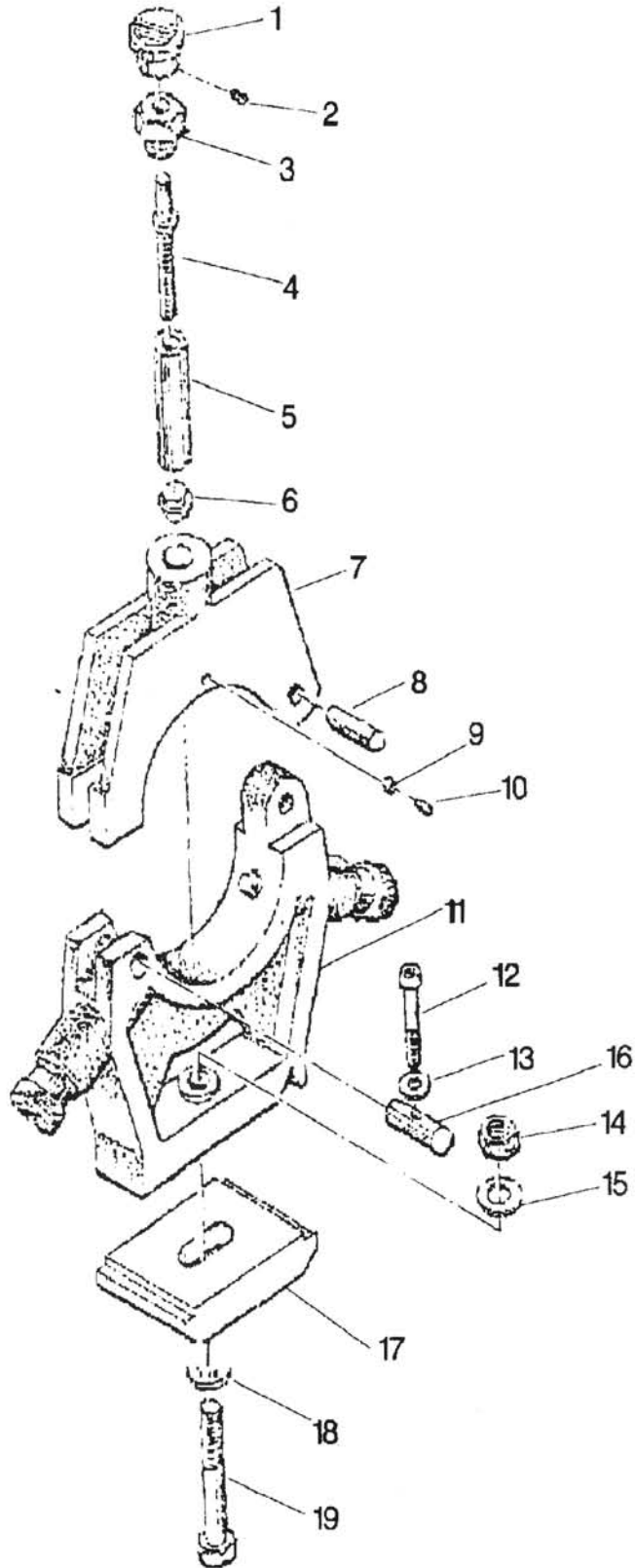
Follow Rest



Follow Rest

1.....	10B-03.....	Knob.....	2
2.....	GB78.....	Set Screw.....M6x6.....	2
3.....	10B-04.....	Bushing.....	2
4.....	10B-05.....	Screw.....	2
5.....	10B-02.....	Sleeve.....	2
6.....	10B-06.....	Brass Finger.....	2
7.....	GB6170.....	Hex Nut.....M6.....	2
8.....	GB79.....	Set Screw.....M6x6.....	2
9.....	10B-01.....	Body Casting.....	1
10.....	GB70.....	Hex Socket Cap Screw.....M6x45.....	2

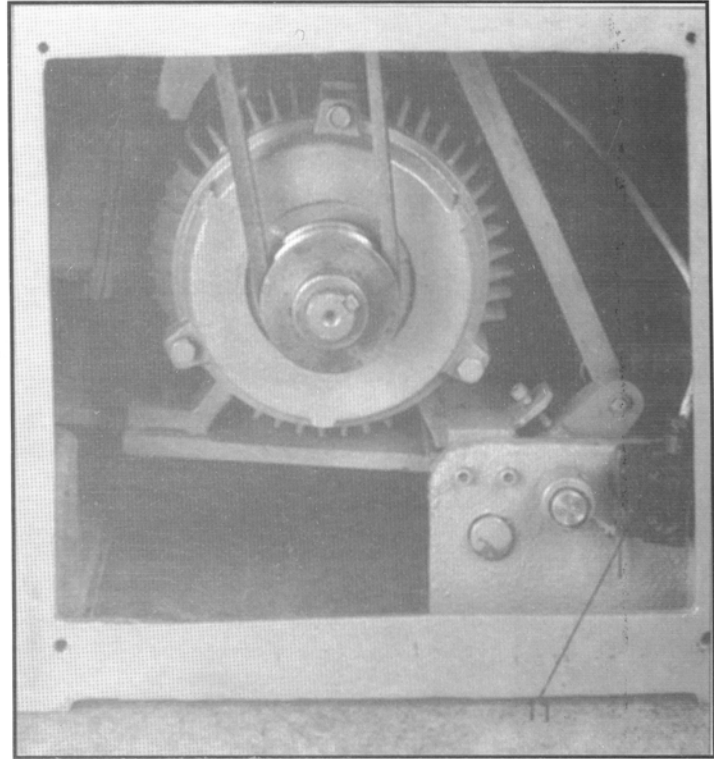
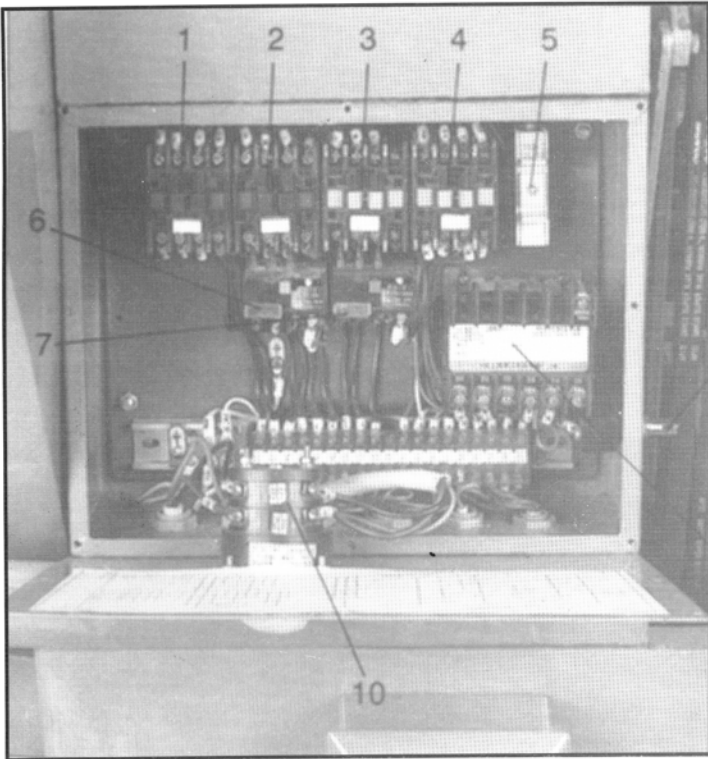
Steady Rest



Steady Rest

1.....	10A-04.....	Knob.....	3
2.....	GB78.....	Set Screw..... M6x6.....	3
3.....	10A-05.....	Bushing.....	3
4.....	10A-06.....	Screw.....	3
5.....	10A-07.....	Sleeve.....	3
6.....	10A-08.....	Brass Finger.....	3
7.....	10A-03.....	Upper Body Casting.....	1
8.....	GH1340A-08SR.....	Pin.....	1
9.....	GB6170.....	Hex Nut..... M6.....	3
10.....	GB79.....	Set Screw..... M6x16.....	3
11.....	10A-01.....	Lower Body Casting.....	1
12.....	GB70.....	Hex Socket Cap Screw..... M6x50.....	1
13.....	GB97.1.....	Flat Washer..... 6.....	1
14.....	GB6170.....	Hex Nut..... M12.....	1
15.....	GB97.1.....	Flat Washer.....	1
16.....	10A-02.....	Lock Pin.....	1
17.....	10A-09.....	Clamp Plate.....	1
18.....	GB97.1.....	Flat Washer.....	1
19.....	GB5872.....	Hex Cap Bolt..... M12x80.....	1

Electrical Components

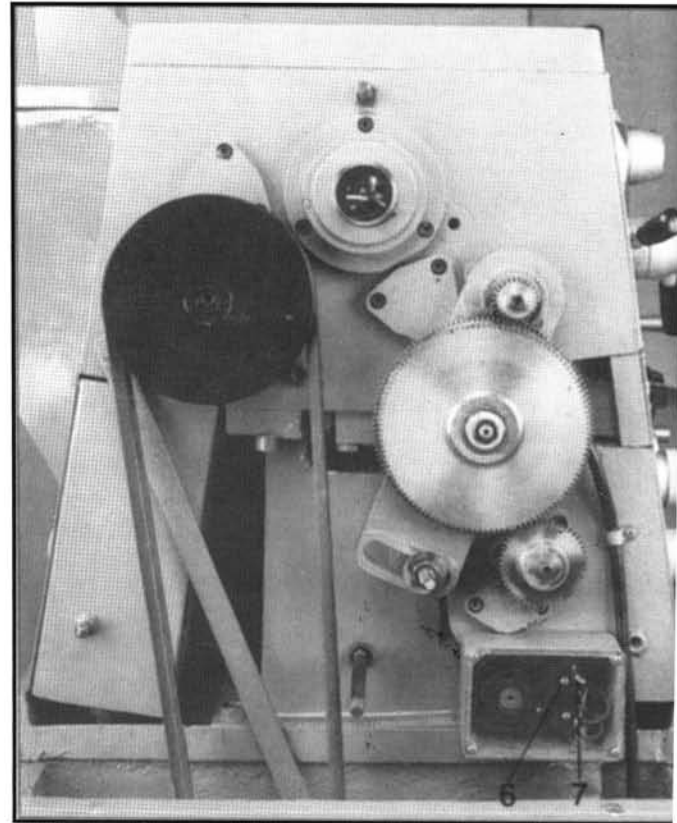


RC 6236x1000: Moteur NINGBO GEXIN ELECTRIC TYPE: YD 112M-8/4-TH

1.5/2.4 Kw	4.8/5.0 A	Rating: S1
INS CL: B	Conn: Δ/YY	50 Hz 400V
700/1410 t/min	IP44	46 Kg

1.....	GH1340A-KM1.....	Magnetic Starter(forward).....	1
2.....	GH1340A-KM2.....	Magnetic Starter(reverse).....	1
3.....	GH1340A-KM3.....	Coolant Pump Contactor.....	1
4.....	GH1340A-KA1.....	Control Contactor.....	1
5.....	GH1340A-FUSE.....	2 Amp Fuse..... local puchase.....	1
6.....	GH1340A-FR1.....	Motor Overload Relay.....	1
7.....	GH1340A-FR2.....	Coolant Pump Overload Relay.....	1
8.....	GH1340A-TC.....	Control Transformer.....	1
9.....	GH1340A-SQ2.....	Door Switch.....	1
10.....	GH1340A-QS1.....	Power On/Off Switch.....	1
11.....	GH1340A-SQ3.....	Brake Switch.....	1

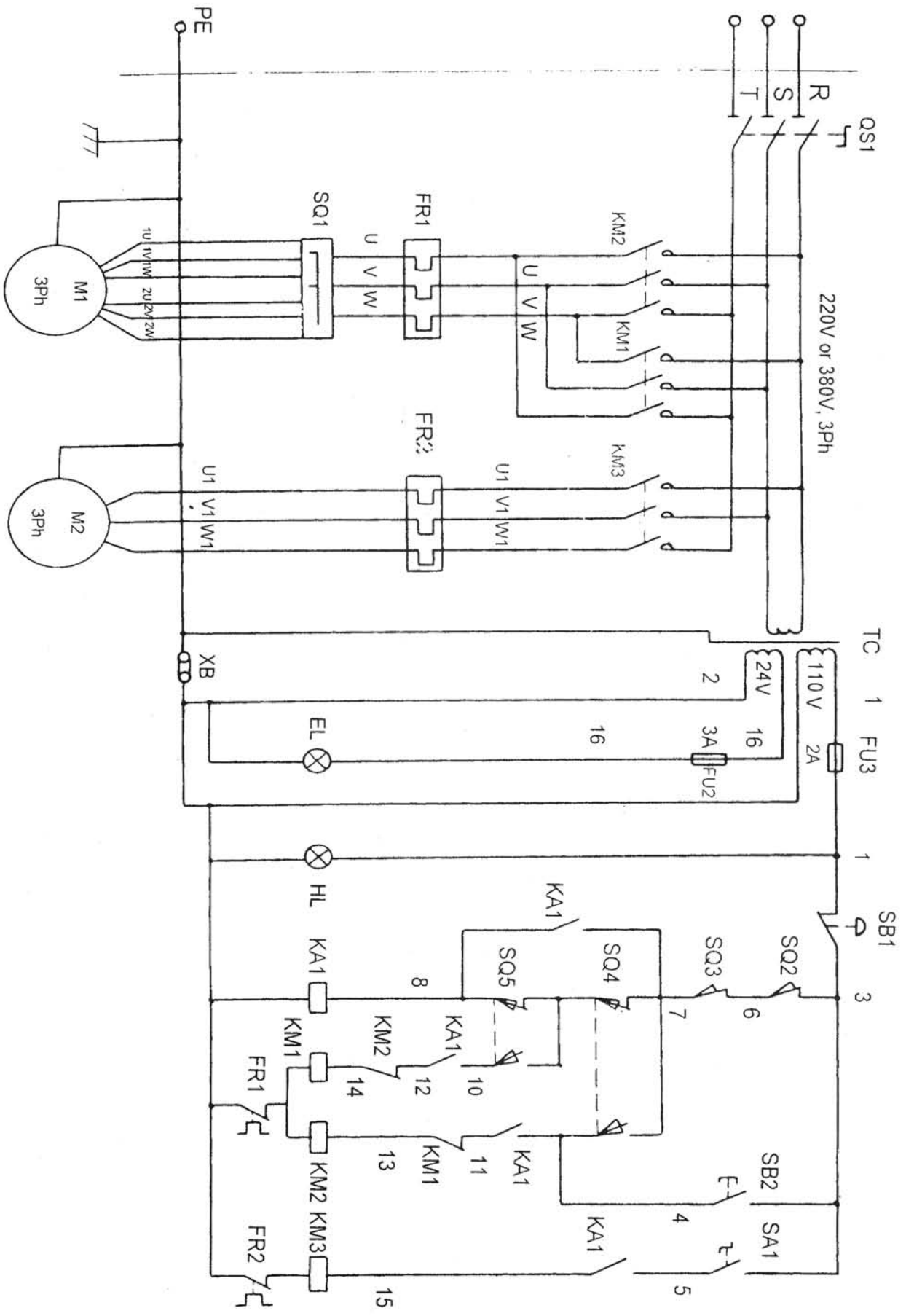
Electrical Components



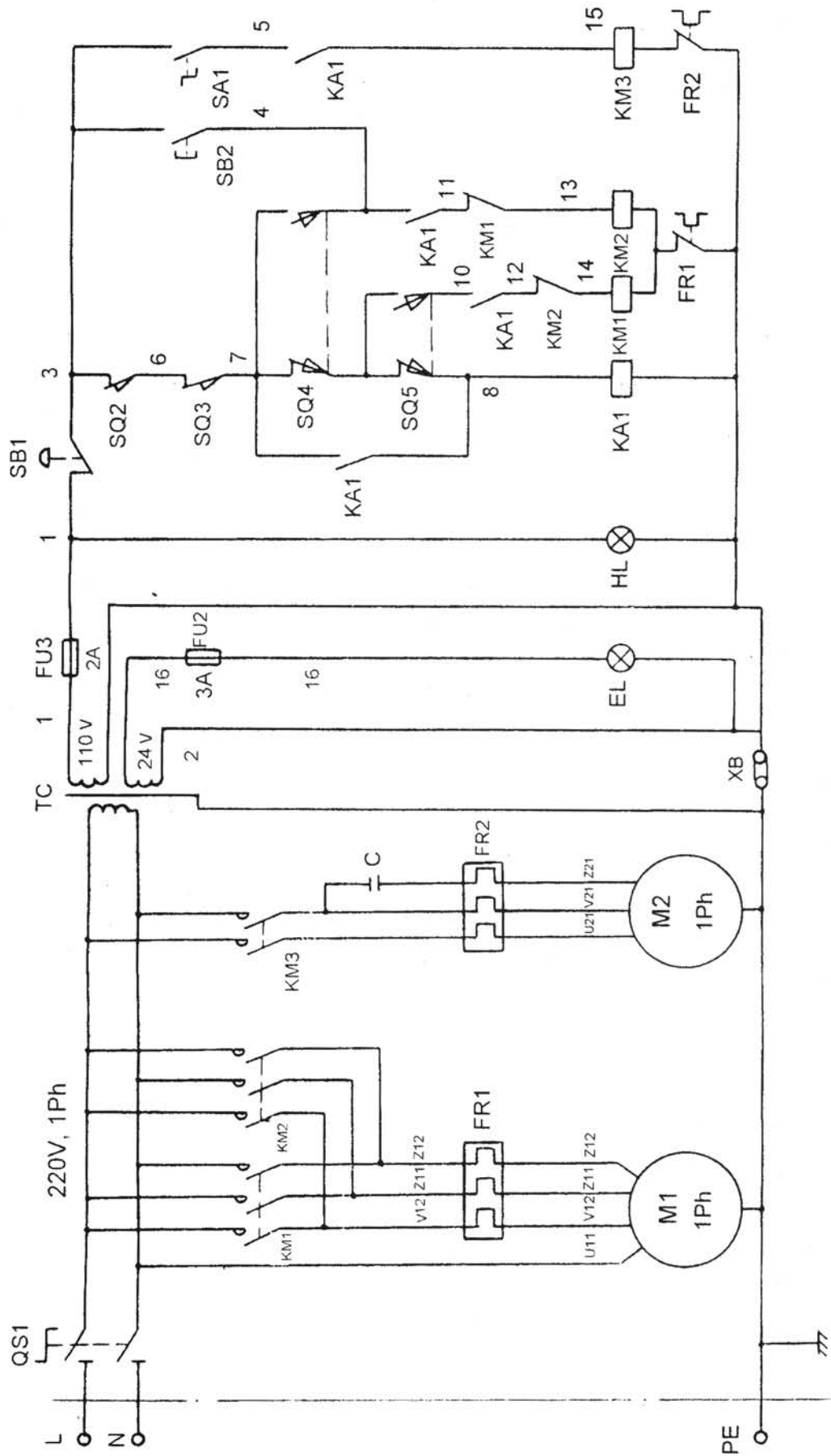
1.....	GH1340A-SB1.....	Off Switch.....	1
2.....	GH1340A-SB2.....	Jog Switch.....	1
3.....	GH1340A-HL.....	Power Indicator Light.....	1
4.....	GH1340A-SA1.....	Coolant Pump Switch.....	1
5.....	GH1340A-SQ1.....	2-Speed High/Low Switch.....	1
6.....	GH1340A-SQ4.....	Forward Switch.....	1
7.....	GH1340A-SQ5.....	Reverse Switch.....	1
	GH1340A-M1.....	Main Motor(not shown).....	1
	GH1340A-M2.....	Coolant Pump Motor(not shown).....	1

Electrical Schematic Symbol Glossary

Symbol	Component	Location
SB1	Off Switch	Front Panel
SB2	Jog Swith	Front Panel
HL	Power Indicator Light	Front Panel
EL	Machine Lamp	On carriage
SQ3	Brake Switch	Inside Bottom Cover-Headstock End
SQ2	Door Switch	Inside Change Gear Cover
SQ4	Forward Switch	Inside Change Gear Cover
SQ5	Reverse Switch	Inside Change Gear Cover
QS1	Power On/Off Switch	On Electrical Panel Cover-Rear Of Machine
SQ1	2-Speed High/Low Switch	Under Headstock on Stand
SA1	Coolant Pump Switch	Front Panel
KM3	Coolant Pump Contactor	Electrical Control Box-Rear of Machine
KA1	Control Contactor	Electrical Control Box-Rear of Machine
FR1	Motor Overload Relay	Electrical Control Box-Rear of Machine
FR2	Coolant Pump O/L Relay	Electrical Control Box-Rear of Machine
KM1	Magnetic Starter-Forward	Electrical Control Box-Rear of Machine
KM2	Magnetic Starter- Reverse	Electrical Control Box-Rear of Machine
TC	Control Transformer	Electrical Control Box-Rear of Machine
M1	Main Motor	Inside Stand - Headstock End
M2	Coolant Pump Motor	Inside Stand - Tailstock End



Electrical Schematic(For 3Ph only)



Electrical Schematic(For 1Ph only)