



PARTS MANUAL

MODEL: 3612-1H3

SERIAL NO: 358-76101 to 358-78155

BAND SAWING MACHINE

MACHINE SPECIFICATIONS

MODEL SERIAL NO.

VOLTAGE CYCLE PHASE

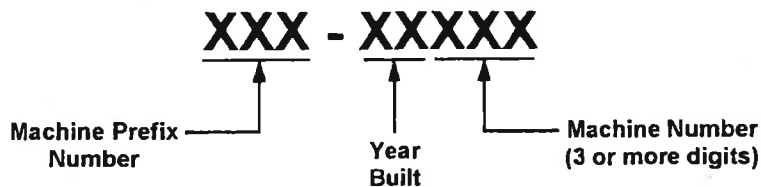
For your information and future reference, insert pertinent data concerning your machine in the spaces provided above. This information is stamped on the data plate attached to the machine frame.

Always specify machine model and serial number on all parts orders and correspondence concerning your machine. This will help avoid unnecessary delays and inconvenience during processing.

The specifications contained herein were in effect at the time this manual was approved for printing. The DoALL Company, whose policy is one of continuous product improvement, reserves the right, however, to change specifications or design at any time without notice and without incurring obligations.

How to read your serial number:

Example: 500-001234

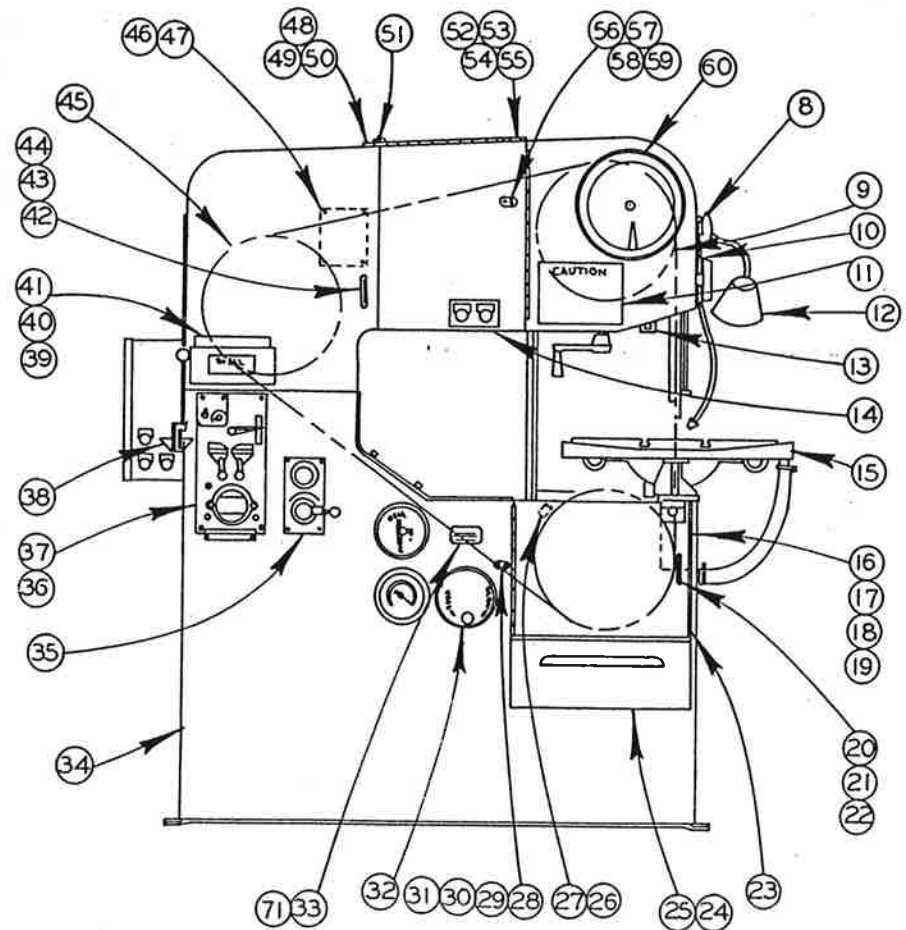
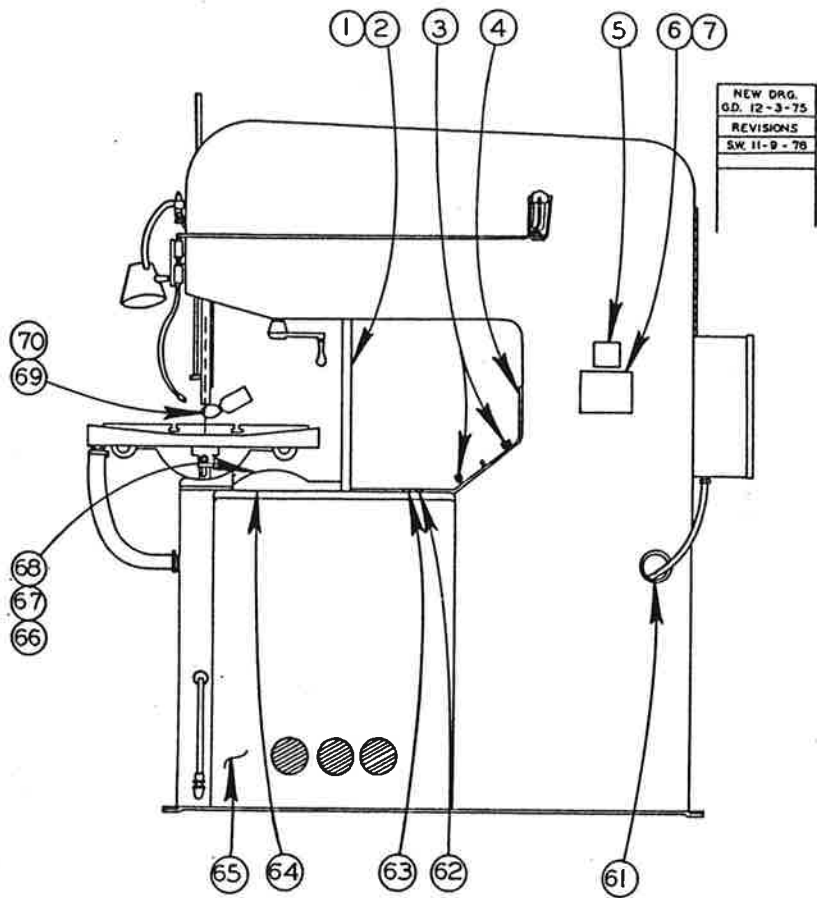


DoALL COMPANY
254 NORTH LAUREL AVENUE
DES PLAINES, ILLINOIS 60016 U.S.A.

YOUR SERVICE REPRESENTATIVE:

FICHE NO. B-56 CLASS Contour-Matic MODEL 3612-1H3 SERIAL NO. 358-76101 TO 358-78155

PAGE NO.	DESCRIPTION	FIRST SERIAL	LAST SERIAL	DWG.	P. LIST	FICHE NO.
CM-1-61	Final Assembly	ALL		A-3	A-4	
CM-8-32	Air Pump, Piston Type	ALL		A-5	A-6	
CM-7-25	Band Filing	ALL		A-7	A-8	
CM-7-25	Band Polishing	ALL		A-7	A-8	
CM-2-34	Band Tension Indicator	ALL		A-9	A-10	
H1-19.0	Blade Shear	See Buttwelder		F-9	F-10	H-2
CM-1-61	Chip Brush	ALL		A-3	A-4	
CM-3-54	Contour Attachment	ALL		A-11	A-12	
CM-8-50	Coolant Assembly, Recirculating Mist	ALL		A-13	A-14	
CM-8-16	Coolant Pump	ALL		B-1	B-2	
CM-9-1	Disc Cutter	ALL		B-3	B-4	
CM-1-52	Door Latches	ALL		B-5	B-6	
CM-5-63	Drive	ALL		B-7	B-8	
CM-6-69	Electrical Assembly	ALL		B-9	B-10	
H1-20.0	Etching Pencil	See Buttwelder		F-11	F-12	H-2
CM-9-24	Foot Switch, 3-Way	ALL		B-11	B-12	
CM-2-67	Head	358-76101 to 358-78129		B-13	B-14	
CM-2-85	Head	358-78130 to Present		C-1	C-2	
CM-2-86	Head Sub-Assemblies	358-78130 to Present		C-3	C-4	
	Heavy Work Clamps	See Parallel Work Clamp				
CM-4-101	Hydraulic System	ALL		C-5	C-6	
CM-8-54	Job Selector	ALL		C-7	C-8	
CM-8-53	Job Selector (Used with Card System)	ALL		C-9	C-10	
CM-8-31	Lamp	ALL		C-11	C-12	
CM-9-3	Magnifier, Post Mounted	ALL		C-13	C-14	
CM-8-31	Magnifier, Lamp Mounted	ALL		C-11	C-12	
CM-5-64	Motor Base Assembly	ALL		D-1	D-2	
CM-10-31	Parallel Work Clamp	ALL		D-3	D-4	
CM-2-79	Post Elevating Mechanism	358-76101 to 358-78129		D-5	D-6	
CM-10-7	Protractor Work Stop & Align. Gage	ALL		D-7	D-8	
CM-7-23	Saw Guide Selection, Insert Type 1 of 2	ALL		D-9	D-10	
CM-7-29	Saw Guide Selection, Insert Type 2 of 2	ALL		D-11	D-12	
CM-7-27	Saw Guide Selection, Roller Type	ALL		D-13	D-14	
CM-3-26	Secondary Table	ALL		E-1	E-1	
CM-3-83	Servo Contour Feed	ALL		E-3	E-4	
CM-3-73	Servo Contour Feed	ALL		E-5	E-6	
CM-3-74	Servo Contour Feed	ALL		E-7	E-8	
CM-3-72	Servo Contour Feed	ALL		E-9	E-10	
CM-4-12	Shift Mechanism	ALL		E-11	E-12	
CM-5-53	Speed Indicator	ALL		E-13	E-14	
CM-3-25	Table	ALL		F-1	F-2	
CM-4-92	Table Feed Cylinder	ALL		F-3	F-4	
CM-10-16	Table Angle Plate & Extensions	ALL		F-5	F-6	
CM-4-11	Transmission	ALL		F-7	F-8	
CM-10-9	Universal Cal. Work Fixture	ALL		F-9	F-10	
CM-10-1	Universal Vise	ALL		F-11	F-12	
CM-4-66	Valve, Table & Servo Feed Control	ALL		F-13	F-14	
CM-5-12	Variable Pulley	ALL		G-1	G-2	
CM-5-63	Wheel, Lower	ALL		B-7	B-8	
CM-2-68	Wheel, Third	ALL		G-3	G-4	
CM-2-68	Wheel, Upper	358-76101 to 358-78129		G-3	G-4	
CM-2-86	Wheel, Upper	358-78130 to Present		C-3	C-4	
CM-9-5	Work Holding Jaw, Contour	ALL		G-5	G-6	
CM-3-75	Work Holding Clamp, Servo Contour	ALL		G-7	G-8	



FINAL ASSEMBLY

CM-1-61

MODEL FIRST MACH LAST MACH
3612-1H3 358-76101 358-78155

PRINTED IN U.S.A.

FINAL ASSEMBLY

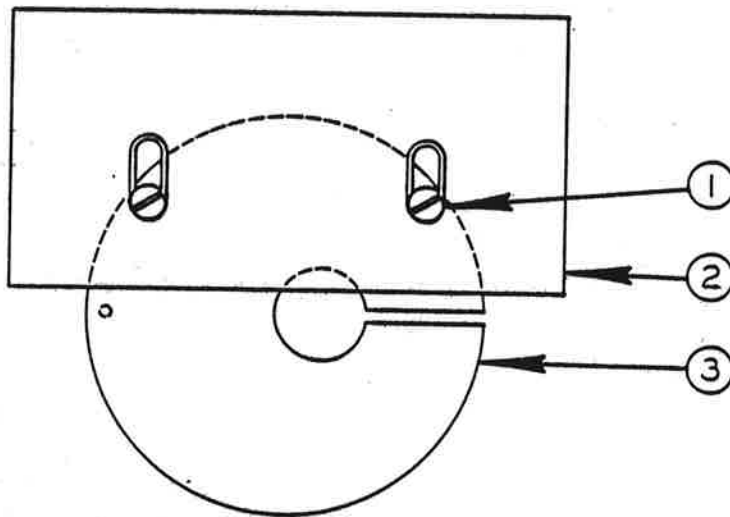
INDEX NO. Ref.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
1	091-990192	Final Assembly		41	094-015195	. Card Holder Ass'y.	1
		. Scr., Truss Hd. Mach. 1/4-20		42	090-168428	. Handle Ass'y.	A.R.
		NC x 3/8	6	43	105-021018	. Door Latch	A.R.
2	094-063963	. Saw Band Guard Ass'y.	1	44	091-984229	. Scr., Soc. Set 1/4-20NC x 3/8	A.R.
3	111-024014	. Scr., Thumb	2	45	094-068145	. Third Wheel & Hinge Ass'y. (See	
4	090-375015	. Cover Plate Ass'y.	1			Detail)	1
5	091-292730	. Escutcheon (Pat. No's.)	1	46	090-061805	. Cover Plate	1
6	093-020568	. Escutcheon (Mach. Spec's.)	1	47	091-988386	. Scr., Rd. Hd. Mach. #6-32NC	
7	091-993972	. Scr. Drive #2 x 1/4 PK Type U	8			x 1/4	4
8	090-234147	. Upper Door Latch Ass'y.	1	48	091-988691	. Scr., Rd. Hd. Mach. #10-24NC	
9	505485	. Head Ass'y. (See Detail)	1			x 1/2	5
10	505094	. Recirculation Mist Coolant Ass'y.		49	091-991117	. Nut, Hex. #10-24NC	5
		(See Detail)	1	50	091-201418	. Bracket Ass'y.	1
11	094-044765	. Escutcheons (Caution)	1	51	091-971150	. Felt	A.R.
12	094-061413	. Work Lamp Ass'y. (See Detail) ..	1	52	090-382227	. Cover Weld't.	1
13	091-434571	. Escutcheons (Band Tensions)	1	53	091-988691	. Scr., Rd. Hd. Mach. #10-24	
14	505390	. Electrical Ass'y. (See Detail) ...	1			NC x 1/2	A.R.
15	50775	. Hyd. Table Line Ass'y. (See Detail)	1	54	091-991117	. Nut, Hex. #10-24NC	A.R.
16	091-238907	. Cover Plate	1	55	090-010190	. Washer	1
17	091-988972	. Scr., Rd. Hd. Mach. 1/4-20NC		56	090-060641	. Door Stop Bracket	A.R.
		x 3/4	6	57	090-122359	. Grommet	A.R.
18	091-993212	. Washer, Lock 1/2 Std.	8	58	091-993196	. Washer, Lock # Std.	A.R.
19	091-991141	. Nut, Jam 1/4-20NC	6	59	091-988675	. Scr., Rd. Hd. Mach. #10-24	
20	090-168428	. Handle Ass'y.	2			NC x 3/8	A.R.
21	105-021018	. Door Latch	2	60	090-468174	. Job Selector Line Ass'y. (See	
22	091-984229	. Scr., Soc. Set, 1/4-20NC x 1/4	2			Detail)	1
23	091-971119	. Rubber Channel	A.R.	61	091-972364	. Grommet Strip	A.R.
24	090-448028	. Chip Basket Ass'y.	1	62	091-086017	. Plug Button	1
25	090-448036	. Coolant Drawer Ass'y.	1	63	090-062910	. Plug Button	4
26	091-993212	. Washer, Lock 1/4 Std.	8	64	091-057018	. Seal Strip	1
27	090-274077	. Wheel Brush Ass'y.	1	65	090-517624	. Rear Cover Ass'y.	1
	090-166844	. Brush	1	66	091-993212	. Washer, Lock 1/4 Std.	8
	090-166646	. Brush Holder	1	67	091-980052	. Scr., Hex. Hd. Mach. 1/4-20	
28	090-060641	. Door Stop Bracket	2			NC x 3/8	2
29	090-122359	. Grommet	2	68	090-410762	. Lower Wheel Cover	1
30	091-988675	. Scr., Rd. Hd. Mach. #10-24NC		69	091-408344	. Saw Band 1/2" x 6 x 174" Long	
		x 3/8	4	70	093-045250	. Band Tag	1
31	091-993196	. Washer Lock #10 Std.	4	71	091-993972	. Drive Scr. #2 x 1/4 PK Type U	
32	406793	. Drive Ass'y. (See Detail)	1				1
33	091-369025	. Escutcheon (Caution)	1				
34	095-048096	. Frame Ass'y.	1				
35	505093	. Hydraulic Ass'y. (See Detail) ...	1				
36	091-990192	. Scr., Truss Hd. Mach. 1/4-20					
		NC x 3/8	A.R.				
37	091-322727	. DBW-15 Butt Welder Option	1				
38	091-318071	. Blade Shear Line Ass'y.	1				
39	091-991141	. Nut, Jam 1/4-20UNC	A.R.				
40	091-988972	. Scr., Rd. Hd. Mach.	A.R.				

CODE NO. C-8-57
CM-8-32
Z-7-8

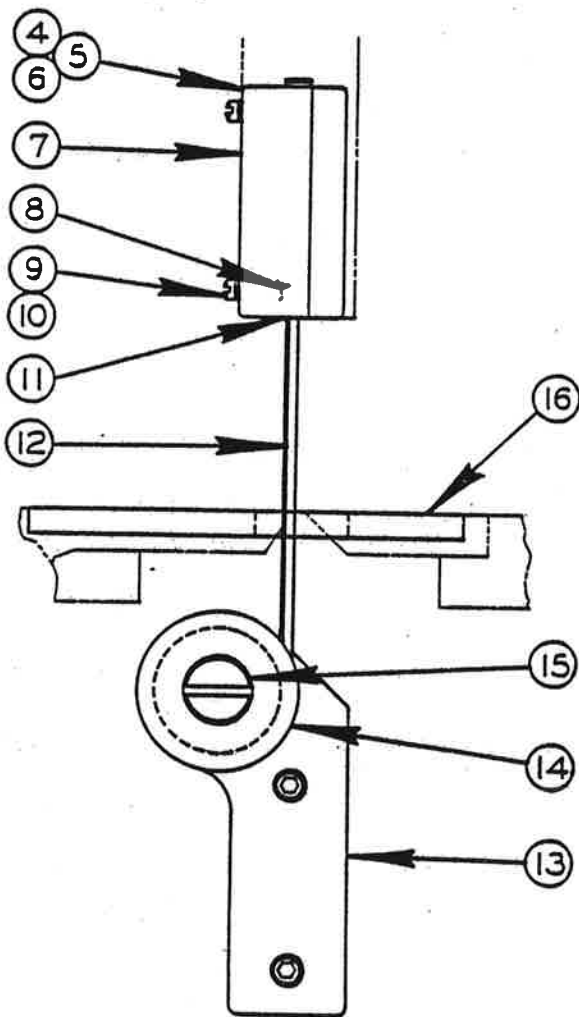
AIR COMPRESSOR

INDEX NO.	CATALOG NO.	DESCRIPTION	QUINCY CO. PART NO.	UNITS PER ASS'Y
Ref.	094-008950	Air Compressor (Quincy)		
1	091-186395	. Breather Assembly	2151-X	1
2	091-186403	. Replacement Felt	2149	1
3	091-186015	. Cylinder	2101	1
4	091-186023	. Stud Breather	7178	1
5	091-186031	. Breather Valve Bumper	2118	2
6	091-186049	. Breather Valve	2117	1
7	091-186056	. Bearing Cup	6553	1
8	091-186064	. Bearing Cone	6554	1
9	091-186411	. 6" Pulley For X-2 Compressor		Use
	091-186429	. 8" Pulley For X-2 Compressor		One
10	091-186072	. Bearing Carrier	6972	1
11	091-186080	. Bearing Plate Gasket	2115	2
12	091-186098	. Connecting Rod Assembly	2105	1
13	091-186106	. Connecting Rod Bolt Wire	2830	1
14	091-186114	. Oil Pan	2122	1
15	091-186122	. Oil Pan Gasket	2123	1
16	091-186130	. Oil Drain Plug	2140	1
17	091-186148	. Connecting Rod Bolt	2120	1
18	091-186155	. Connecting Rod Bolt Lockwasher	2121	1
19	091-186163	. Bearing Cup	6551	1
20	091-186171	. Bearing Cone	6552	1
21	091-186189	. Crank Shaft	6975	1
22	091-186197	. Bearing Carrier	6973	1
24	091-209437	. Piston Compressor Ring	6489	3
25	091-186262	. Suction Valve Spring	2132	1
26	091-186270	. Suction Valve Bumper	2131	1
27	091-186239	. Piston Pin Assembly	2126-X	1
28	091-186247	. Piston	2104	1
29	091-186254	. Head Gasket	2124	1
30	091-186288	. Suction Valve Bumper Gasket	2130	1
31	091-186304	. Cylinder Head	2100	1
32	091-186312	. Suction Valve Seat	2129	1
33	091-186320	. Discharge Valve Bumper	2133	1
34	091-186338	. Intercooler Gasket	2134	1
35	091-186346	. Discharge Valve Spring	1780	1
36	091-186296	. Valve	1194	2
37	091-186361	. Discharge Valve Guide	2136	1
38	091-186379	. Discharge Valve Guide	2137	1
39	091-186387	. Oil Gauge Assembly	2316-X	1
40	094-008356	. Air Compressor (6" Pulley)		Use
	094-019577	. Air Compressor (8" Pulley)		One
41	090-372525	. Adapter Plate Weldment		1
42	091-980276	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4		4
43	091-992628	. Washer, Flat 5/16 Std.		4
44	091-991224	. Nut, Hex. 5/16-18NC		4
45	091-993238	. Washer, Lock 5/16 Std.		4
46	090-021031	. Relief Valve		1
47	135-008472	. Service Tee		1
48	090-020041	. Barbed Insert		1

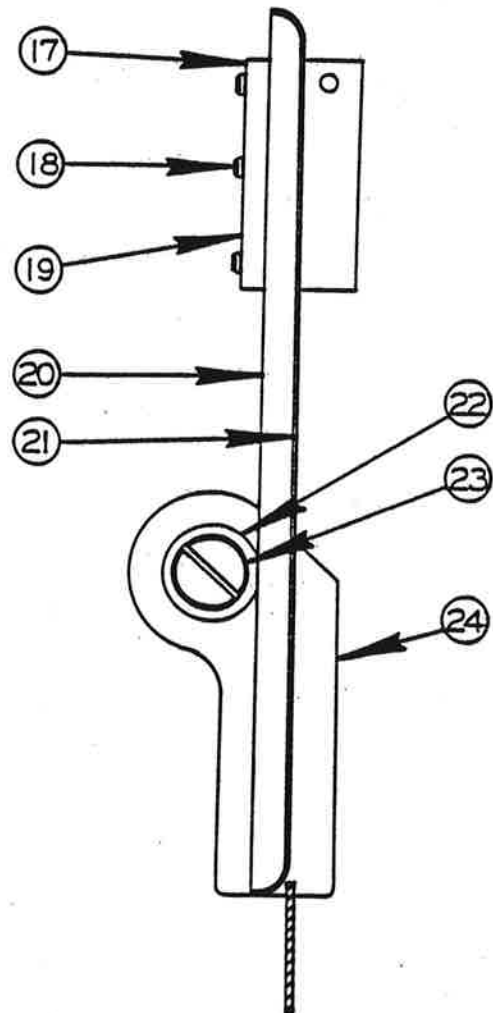
REVISED AND REDRAWN
S.C.L. 1-2-75



SMALL PARTS FILING ASSEMBLY



BAND FILING ASSEMBLY

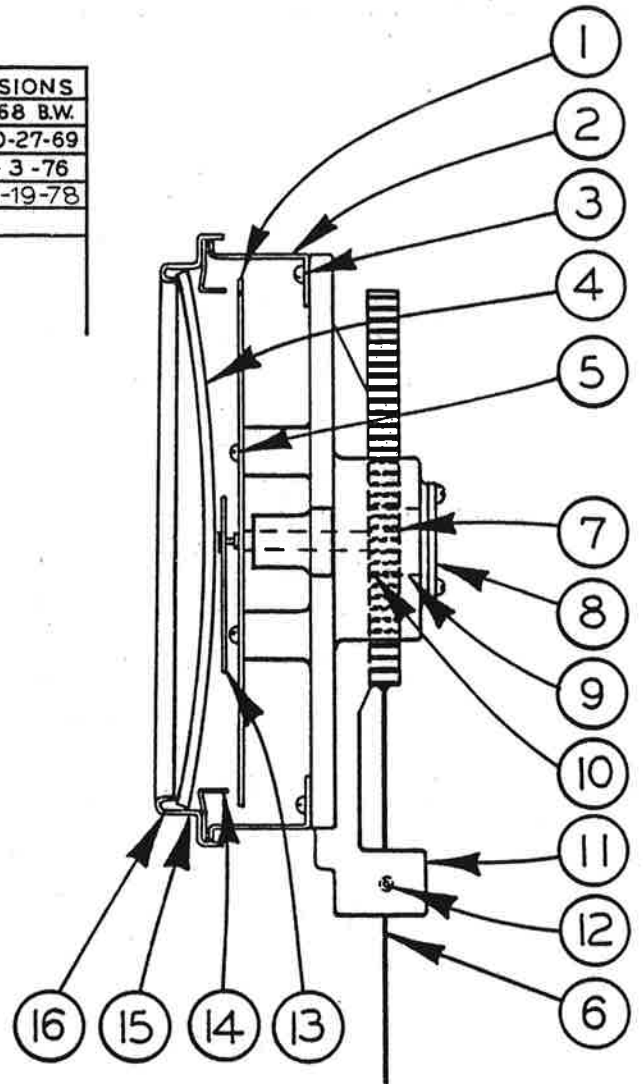
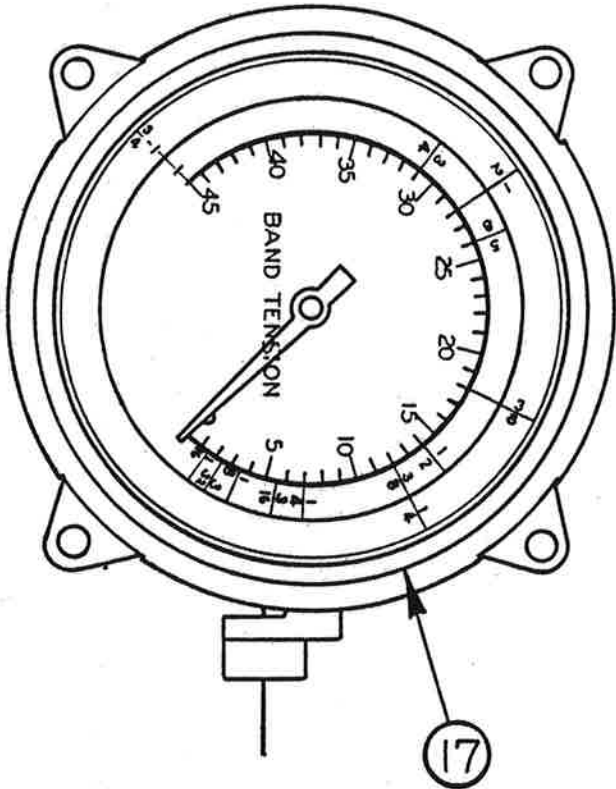


BAND POLISHING ASSEMBLY

BAND FILING & POLISHING ASSEMBLIES

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASSY	INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASSY
Ref.	090-076456	Small Parts Filing Ass'y (1612, 1612-0, 1612-H, 1612-1, 2013, 2013-1, 2013-0, 2013-10, 2012-1A, 2012-A, 2012-AT, 2012-1AT, 2612-H, 2612-1, 3612, 3613-0, 3612-H, 3613-1)		9	091-986885	.. Screw, Fil. Hd. Mach. #4-40NC x 5/8 (Ass'ys #27487, #27490, #34096, #34099)	2
1	091-987487	.. Screw, Fil. Hd. Mach. #10-24NC x 3/8	2		091-986992	... Screw, Fil. Hd. Mach. #10-24 NC x 5/8 (Ass'y #37488, #27491, #34097, #34103, #27489, #27492, #34098, #34104)	2
2	090-120460	.. Small Part Plate	1	10	091-993154	.. Washer, Lock #4 Std. (Ass'ys #27490, #34099)	2
3	090-120452	.. Center Plate	1		091-993196	.. Washer, Lock #10 Std. (Ass'ys #27488, #27491, #34097, #34103, #27489, #27492, #34098, #34104)	2
Ref.	090-447806	Band Filing Ass'y (1612, 1612-0, 1612-H, 1612-1, 1613-2, 1612-3, 2013, 2013-1, 2013-0, 2013-10, 2012-A, 2012-1A, 2012-AT, 2012-1AT, 2612-2H, 2613-3, 3612-H, 3613-1, 3612-3, 6013-3)		11	106-093073	.. Insert (Ass'ys #27487, #34096)	1
Ref.	091-119487	Band Filing Ass'y (1612, 1612-0, 1612-H, 1612-1, 1612-3, 2013, 2013-1, 2013-0, 2013-10, 2012-A, 2012-1A, 2012-AT, 2012-1AT, 3612-H, 3612-3)		11	106-093032	.. Insert (Ass'ys #27490, #34099)	1
Ref.	091-327734	Band Filing Ass'y (1612, 1612-0, 2013, 2013-1, 2013-0, 2013-10, 2012-A, 2012-AT, 2612-H, 2612-1, 3612, 3613-0)		11	106-093016	.. Insert (Ass'ys #27488, #34097)	1
Ref.	094-049947	Band Filing Ass'y (1612, 1612-0, 2013, 2013-1, 2013-0, 2013-10, 2012-A, 2012-AT, 2012-1AT, 2612-H, 2612-1, 3612, 3613-0)		11	106-093057	.. Insert (Ass'ys #27491, #34103)	1
Ref.	090-485327	Band Filing Ass'y (1612-3, 2612-2H, 2613-3, 3612-3, 6013-3)		11	106-093099	.. Insert (Ass'ys #27489, #34098)	1
Ref.	094-014388	Band Filing Ass'y (1613-3, 2612-2H, 2613-3, 3612-3, 6013-3)		11	106-093115	.. Insert (Ass'ys #27492, #34104)	1
Ref.	090-447814	Band Filing Ass'y (2613-2, 3613-2, 6013-2)		12	106-093081	.. File Guide (Ass'ys #27487, #34096)	1
Ref.	090-455973	Band Filing Ass'y (3613-2, 6013-2)		12	106-093040	.. File Guide (Ass'ys #27490, #34099)	1
4	090-274879	.. 1/4" File Guide Ass'y (Ass'ys #44780, #404994, #44781)	1	12	106-093024	.. File Guide (Ass'ys #27488, #34097)	1
	090-274903	.. 1/4" File Guide Ass'y (Ass'ys #111948, #132773, #45597)	1	12	106-093065	.. File Guide (Ass'ys #27491, #34103)	1
	090-340969	.. 1/4" File Guide Ass'y. (Ass'y #48532)	1	12	106-093107	.. File Guide (Ass'ys #27489, #34098)	1
	090-340993	.. 1/4" File Guide Ass'y (Ass'y #401438)	1	12	106-093123	.. File Guide (Ass'ys #27492, #34104)	1
5	090-274887	.. 3/8" File Guide Ass'y (Ass'ys #44780, #404994, #43781)	1		134-093137	.. Guide Plates (Not Shown) (Ass'ys #27490, #34099)	2
	090-274911	.. 3/8" File Guide Ass'y (Ass'ys #111948, #132773, #45597)	1		134-094028	.. Pin (Not Shown) (Ass'ys #27490, #34099)	2
	090-340977	.. 3/8" File Guide Ass'y (Ass'y #48532)	1		090-013715	.. Adapter	1
	090-341033	.. 3/8" File Guide Ass'y (Ass'y #401438)	1	13	134-093129	.. File Guide Back-up (Ass'ys #44780, #111948, #132773, #404994, #44781, #45597)	1
6	090-274895	.. 1/2" File Guide Ass'y (Ass'ys #44780, #404994, #44781)	1	13	091-109314	.. File Guide Back-up (Ass'ys #48532, #401438)	1
	090-274929	.. 1/2" File Guide Ass'y (Ass'ys #111948, #132773, #45597)	1	15	134-090018	.. Screw Assembly	1
	090-340985	.. 1/2" File Guide Ass'y (Ass'y #48532)	1		090-038019	.. Head	1
	090-341041	.. 1/2" File Guide Ass'y (Ass'y #401438)	1		090-038027	.. Screw	1
7	090-274176	.. Bracket (Ass'y #27487)	1	16	090-106279	.. Center Plate (Ass'ys #44780, #111948, #48532, #401438)	1
	090-274184	.. Bracket (Ass'y #27490)	1		091-201285	.. Center Plate (Ass'ys #132773, #404994)	1
	090-340951	.. Bracket (Ass'y #34096)	1	Ref.	091-069575	Band Polishing Ass'y (1611-H, 1611-U, 1612, 1612-0, 1612-H, 1612-1, 2013, 2013-1, 2013-0, 2013-10, 2012-A, 2012-1A, 2012-AT, 2012-1AT, 2612-H, 2612-1, 3612-U, 3612, 3613-0, 3612-H, 3613-1)	1
	090-340944	.. Bracket (Ass'y #34099)	1	Ref.	090-290230	Band Polishing Ass'y (1612-1, 1613-2, 1612-3, 3613-1, 3613-2, 3612-3)	1
	090-274200	.. Bracket (Ass'y #27488)	1	Ref.	090-274853	Band Polishing Ass'y (26-2, 60-2, 2612-2H, 2613-2, 6013-2)	1
	090-274218	.. Bracket (Ass'y #27491)	1	Ref.	090-274846	Band Polishing Ass'y (16-2, 16-3, 36-2, 36-3)	1
	090-340936	.. Bracket (Ass'y #34097)	1	Ref.	090-274861	Band Polishing Ass'y (26-3, 60-3, 2613-3, 6013-3)	1
	090-340928	.. Bracket (Ass'y #34103)	1	Ref.	091-069583	Band Polishing Ass'y (2612-1)	1
	090-274192	.. Bracket (Ass'y #27489)	1	17	090-166869	.. Band Polishing Sub-Ass'y (Ass'ys #106957, #29023, #27485, #27484, #106958)	1
	090-274226	.. Bracket (Ass'y #27492)	1		090-274143	.. Band Polishing Sub-Ass'y (Ass'y #27486)	1
	090-340910	.. Bracket (Ass'y #34098)	1	18	091-986968	.. Screw, Fil. Hd. Mach. #10-24 NC x 3/8	3
	090-340902	.. Bracket (Ass'y #34104)	1		106-103013	.. Backup Plate (Ass'y #16686)	1
8	106-093149	.. Washer (Ass'ys #27487, #27490, #34096, #34099)	2		135-099232	.. Backup Plate (Ass'y #27414)	1
	106-093131	.. Washer (Ass'ys #27488, #27491, #34097, #34103, #27489, #27492, #34098, #34104)	2		134-105055	.. Backup Cloth	1
				19	090-274127	.. Bracket	1
				20	106-103013	.. Backup Plate (Ass'y #16686)	1
				21	135-099232	.. Backup Plate (Ass'y #27414)	1
				22	134-105055	.. Backup Cloth	1
				23	134-104025	.. Guide Backup	1
				23	134-090018	.. Screw Assembly	1
				24	090-038019	.. Head	1
					090-038027	.. Screw	1
					090-013715	.. Adapter	1
					090-105701	.. Center Plate (Not Shown) (Ass'ys #106957, #106958)	1

REVISIONS
6-21-68 B.W.
S.W. 10-27-69
SW 5-3-76
SW 6-19-78

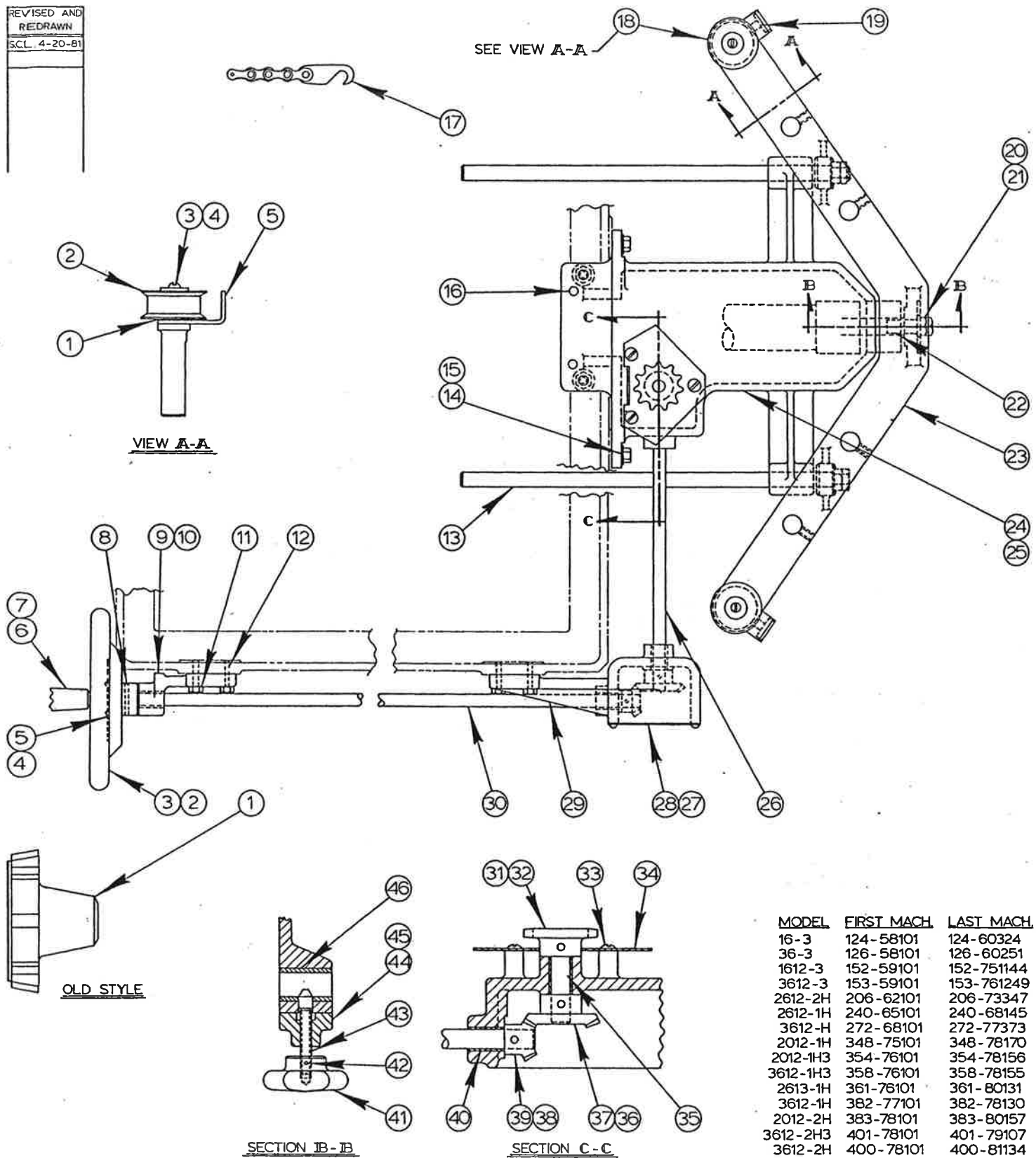


BAND TENSION INDICATOR ASSEMBLY

TENSION INDICATOR ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	090-455106	Tension Indicator Assembly (2612-2H & 2613-2)	
Ref.	090-455114	Tension Indicator Assembly (6013-2)	
Ref.	090-457169	Tension Indicator Assembly (3613-2, 3613-1, 3612-3, 3612-1H3, 3612-2H3)	
Ref.	090-457177	Tension Indicator Assembly (1612-X1, 1613-2, 1612-3, 1612-1)	
Ref.	090-404815	Tension Indicator Assembly (2612-H, 2612-1, 2612-1H, 2612-D, 2614-1, 2613-1H, 2612-1H3)	
1	091-019661	. Dial (2612-2H, 2613-2)	1
	091-020156	. Dial (6013-2)	1
	091-018051	. Dial (3613-2, 3612-3, 3613-1, 3612-1H3, 3612-2H3)	1
	091-018044	. Dial (1612-X1, 1613-2, 1612-3, 1612-1)	1
	091-219204	. Dial (2612-H, 2612-1, 2612-D, 2614-1, 2613-1H, 2612-1H3)..	1
2	135-024719	. Case	1
3	091-988386	. Screw, Rd. Hd. Mach. 6-32NC x 1/4	4
4	090-039801	. Glass	1
5	091-988279	. Screw, Rd. Hd. Mach. 4-36 x 1/4	4
*6	090-071440	. Rack & Wire Sub-Assembly	1
7	091-115972	. Shaft	1
8	135-019743	. Cap	1
9	135-019735	. Spacer	1
10	135-024735	. Spur Gear	1
11	135-019701	. Bracket	1
12	091-984062	. Screw, Soc. Set 8-32NC x 1/4	1
13	091-119297	. Pointer	1
14	090-039777	. Ring	1
15	090-046442	. Bezel	1
16	090-039785	. Rubber Gasket	1
17	090-174780	. Bezel	1

*NOTE: Refer to Head Assembly for Casing Part Number.



MODEL	FIRST MACH	LAST MACH
16-3	124-58101	124-60324
36-3	126-58101	126-60251
1612-3	152-59101	152-751144
3612-3	153-59101	153-761249
2612-2H	206-62101	206-73347
2612-1H	240-65101	240-68145
3612-H	272-68101	272-77373
2012-1H	348-75101	348-78170
2012-1H3	354-76101	354-78156
3612-1H3	358-76101	358-78155
2613-1H	361-76101	361-80131
3612-1H	382-77101	382-78130
2012-2H	383-78101	383-80157
3612-2H3	401-78101	401-79107
3612-2H	400-78101	400-81134

CONTOUR ATTACHMENT ASSEMBLY
(MANUAL)

CONTOUR ATTACHMENT ASSEMBLY

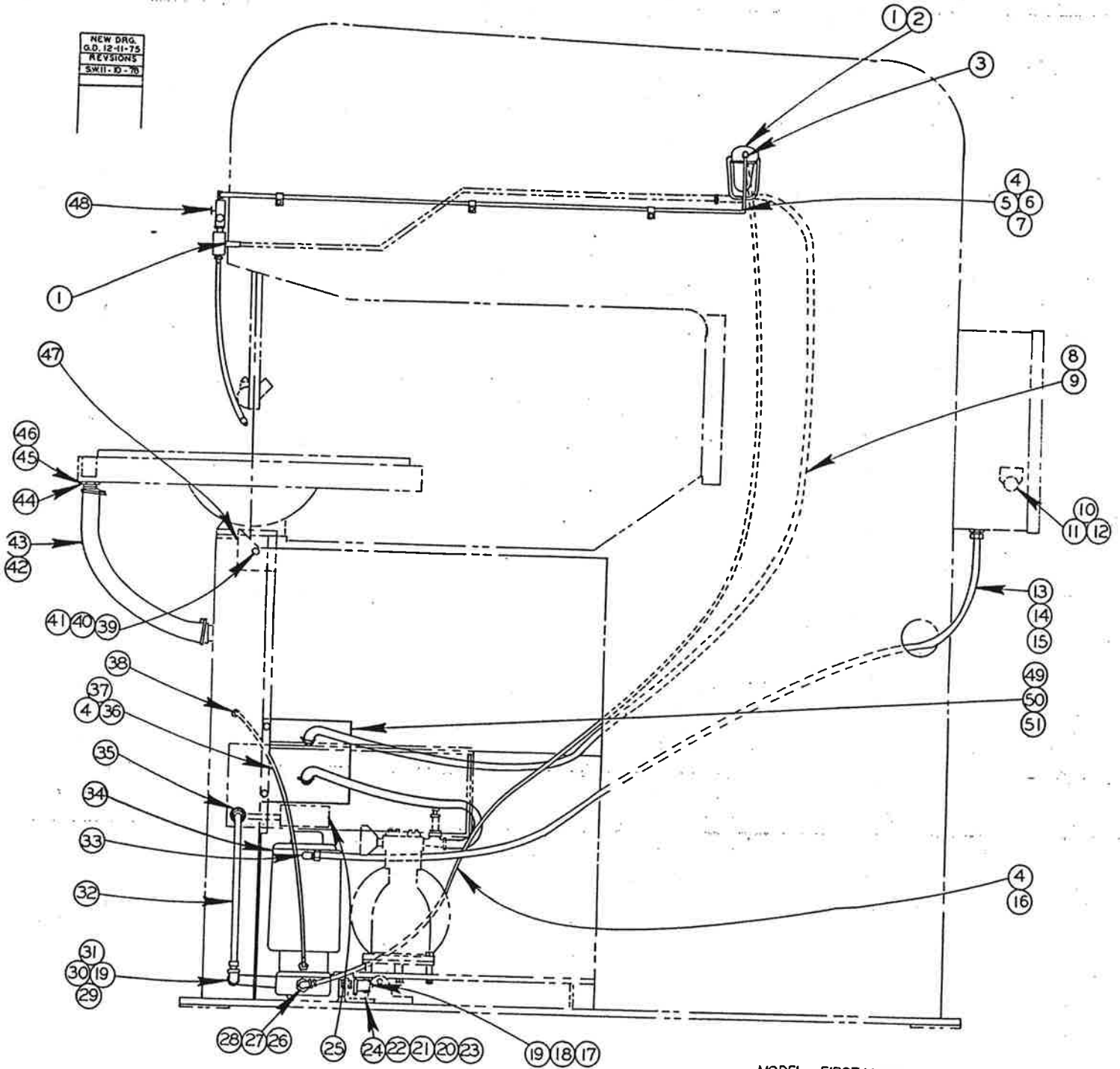
INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
REF.	080-521032	Contour Attachment Assembly	
1	090-239542	. Knob (Old Style)	1
2	094-033693	. Contour Handwheel Assembly (New Style)	1
3	090-486432	. . Servo Handwheel	1
4	091-256297	. . Name Plate	1
5	091-993972	. . Screw, Rd. Hd. Drive # 2 x 1/4	2
6	091-181164	. . Handle	1
7	091-181172	. . Pin	1
8	090-042615	. Roll Pin	1
9	090-426024	. Bracket	1
10	135-006476	. Oilite Bearing	1
11	091-980284	. Screw, Hex. Hd. Cap 5/16 - 18 NC x 7/8	4
12	135-005163	. Dowel Pin	4
13	090-095050	. Shaft	2
14	091-980466	. Screw, Hex. Hd. Cap 3/8 - 16 NC x 1	4
15	091-993329	. Washer, Lock 3/8 Std.	4
16	135-032183	. Dowel Pin	2
17	135-050136	. Chain Assembly	1
	135-006740	. . Chain	1
	091-995464	. . Rivet 3/16 x 7/16	1
	135-003291	. . Chain Connector	1
18	135-006716	. Horizontal Roller Assembly (See Detail)	2
19	134-174010	. Thumb Nut	2
20	091-991323	. Nut, Hex. Jam 1/2 - 13 NC	6
21	091-992669	. Washer, Flat 1/2 S.A.E. Std.	3
22	090-119520	. Spacer	1
23	090-521055	. Support Bar	1
24	090-523234	. Contour Attachment Sub-Assembly	1
25	090-521048	. . Bracket	1
26	090-095068	. . Shaft	1
27	090-016965	. . Cover	1
28	091-988386	. . Screw, Rd. Hd. Mach., #6 - 32 NC x 1/4	2
29	090-426032	. . Gear Box	1
30	093-068666	. . Shaft	1
31	135-006724	. . Sprocket	1
32	090-042607	. . Roll Pin	3
33	091-990184	. . Screw, Truss Hd. Mach., 1/4 - 20 NC x 5/16	3
34	135-006732	. . Sprocket Retainer	1
35	090-016932	. . Shaft	1
36	090-144353	. . Bevel Gear	2
37	091-984104	. . Screw, Soc. Set #10 - 24 NC x 1/4	5
38	090-144346	. . Bevel Gear	2
39	090-042433	. . Roll Pin	2
40	135-006476	. . Oilite Bearing	4
41	090-095100	. Handwheel	1
42	090-042177	. . Roll Pin	1
43	090-095092	. . Stud	1
44	090-239658	. . Housing	1
45	091-982389	. . Screw, Soc. Hd. Cap 1/4 - 20 NC x 5/8	4
46	090-095076	. . Bearing	1

The Following Not Shown:

080-402621	. Work Holder Jaw Assembly (See Detail)	1
091-452094	. Escutcheon (Caution)	1
091-993972	. Screw, Rd. Hd. Drive #2 x 1/4	4

REF.	135-006716	Horizontal Roller Assembly	
1	106-233380	. Washer	A.R.
2	135-075919	. Roller	1
3	091-988857	. Screw, Rd. Hd. Mach., # 10 - 32 NF x 1/2	1
4	135-075927	. Washer	1
5	135-020055	. Guide and Post Sub-Assembly	1

NEW DRG.
 O.D. 12-11-75
 REVISIONS
 SWII-D-76



RECIRCULATING MIST COOLANT ASSEMBLY

CM-8-50

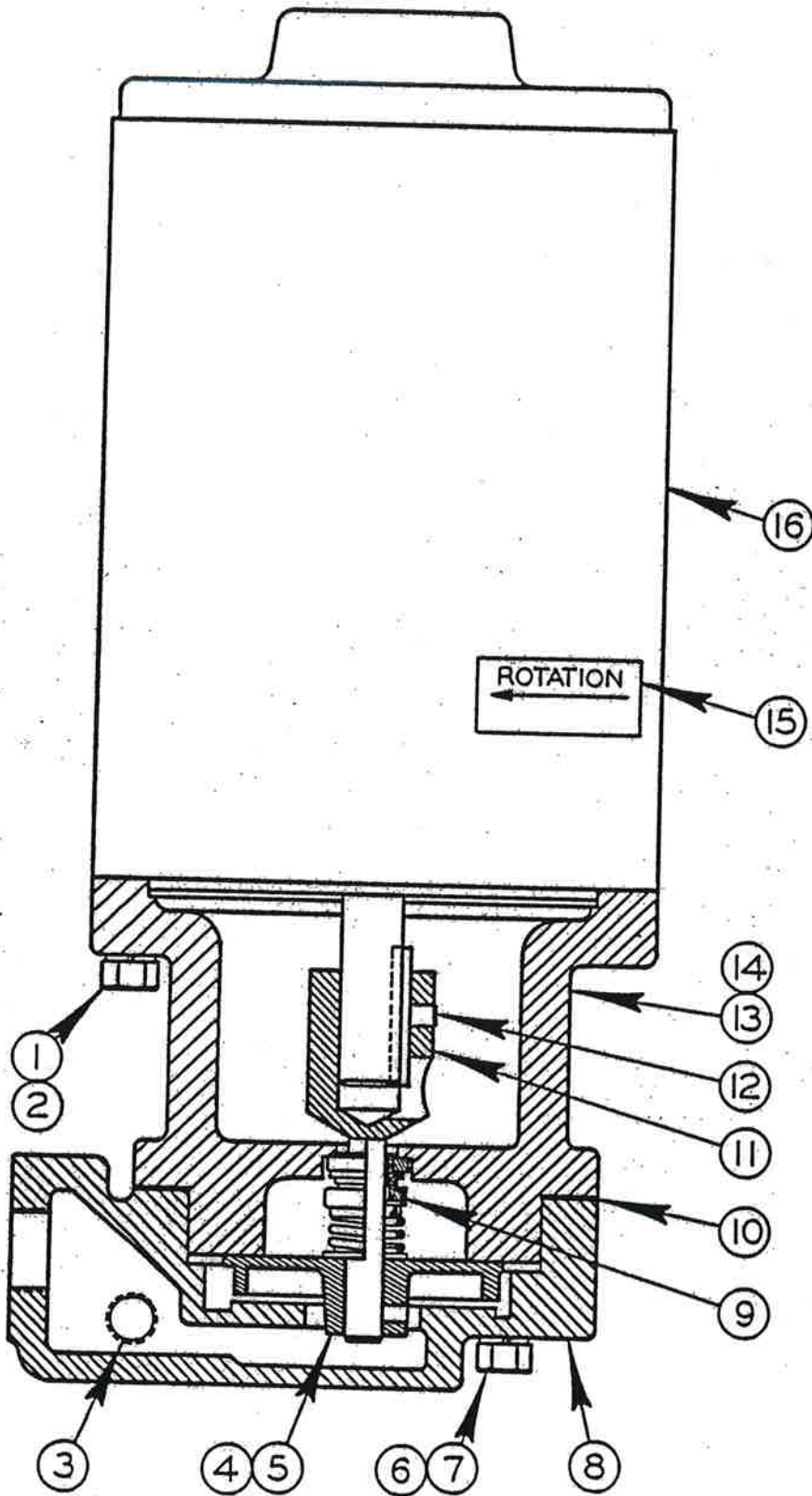
MODEL	FIRST MACH.	LAST MACH.
3612-1H3	358-76101	358-78155

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RECIRCULATING MIST COOLANT ASSEMBLY

INDEX NO. Ref.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
	505094	Recirculating Mist Coolant Assembly	
1	114-145287	. Close Nipple	2
2	090-158064	. Filter	1
3	091-081166	. 90° Barbed Insert	2
4	091-047134	. Hose Clamp	6
5	090-172479	. Tubing Clamp	3
6	091-990168	. Scr. Truss Hd. Mach. #10-24NC x 1/2	3
7	091-571448	. Clear Plastic Tubing 1/4 I.D. x 3/8 O.D.	A.R.
8	090-179029	. Hose Clamp	2
9	091-970947	. Hose 3/8 I.D. x 11/16 O.D.	A.R.
10	091-293407	. Pushbutton Operator	1
11	091-241026	. Legend Plate	1
12	091-287094	. Overload Relay	1
13	090-145459	. Connector 1/2"	1
14	091-971564	. Conduit 1/2 Sealtite	A.R.
15	091-971853	. #12 Wire, Black	A.R.
16	091-971440	. Clear Plastic Tubing 1/4 I.D. x 3/8 O.D.	A.R.
17	135-033769	. Pipe Nipple	1
18	114-003486	. 90° Elbow	1
19	090-082124	. Barbed Insert	2
20	091-980441	. Scr. Hex. Hd. Cap 3/8-16NC x 3/4	2
21	090-118324	. Pump Bracket	1
22	091-980474	. Scr. Hex. Hd. Cap 3/8-16NC x 1-1/4	2
23	091-991265	. Nut, Hex. 3/8-16NC	2
24	091-993329	. Washer, Lock 3/8 Std.	4
25	090-209214	. Coolant Strainer Ass'y.	1
26	135-035061	. Reducer Bushing	1
27	117-135210	. 90° Street Elbow	1
28	091-033167	. Barbed Insert	1
29	091-209049	. Barbed Insert	2
30	090-179037	. Hose Clamp	2
31	091-970988	. Hose 1/2 I.D. x 27/32 O.D.	A.R.
32	091-971093	. Hose 5/8" O.D.	A.R.
33	090-145046	. 90° Connector	1
34	090-418781	. Coolant Pump Ass'y. (See Detail)	1
35	090-118753	. Coupler	1
36	090-160011	. Barbed Insert	2
37	091-971440	. Clear Plastic Tubing 1/4 I.D. x 3/8 O.D.	A.R.
38	105-275069	. 90° Street Elbow	1
39	105-024012	. Thumb Screw	1
40	091-980060	. Scr. Hex. Hd. Cap 1/4-20NC x 1/2	1
41	091-993212	. Lock Washer 1/4 Std.	1
42	091-061002	. Hose	1
43	091-217521	. Hose Clamp	2
44	090-170416	. Nipple	1
45	090-156183	. Nut Lock	1
46	090-109802	. Seal Ass'y.	1
47	090-411000	. Front Drip Pan Ass'y.	1
48	093-050425	. Coolant Manifold Ass'y.	1
49	090-389347	. Air Dome Sub-Assembly	1
50	091-980250	. Screw, Hex. Hd. Cap 5/16-18NC x 1/2	2
51	091-993238	. Washer, Lock Spring 5/16" Med.	2

REVISED AND REDRAWN
S.W. 5-22-70
S.W. 4-25-73
S.C.L. 11-30-73
S.C.L. 12-10-75
S.W. 3-21-77



MODEL FIRST MACH. LAST MACH.
TF-24 231-65102 231-66127

NOTE:
USED ON SAWS IF
SUPPLIED.

*41878
COOLANT PUMP

CODE NO. CM-8-16

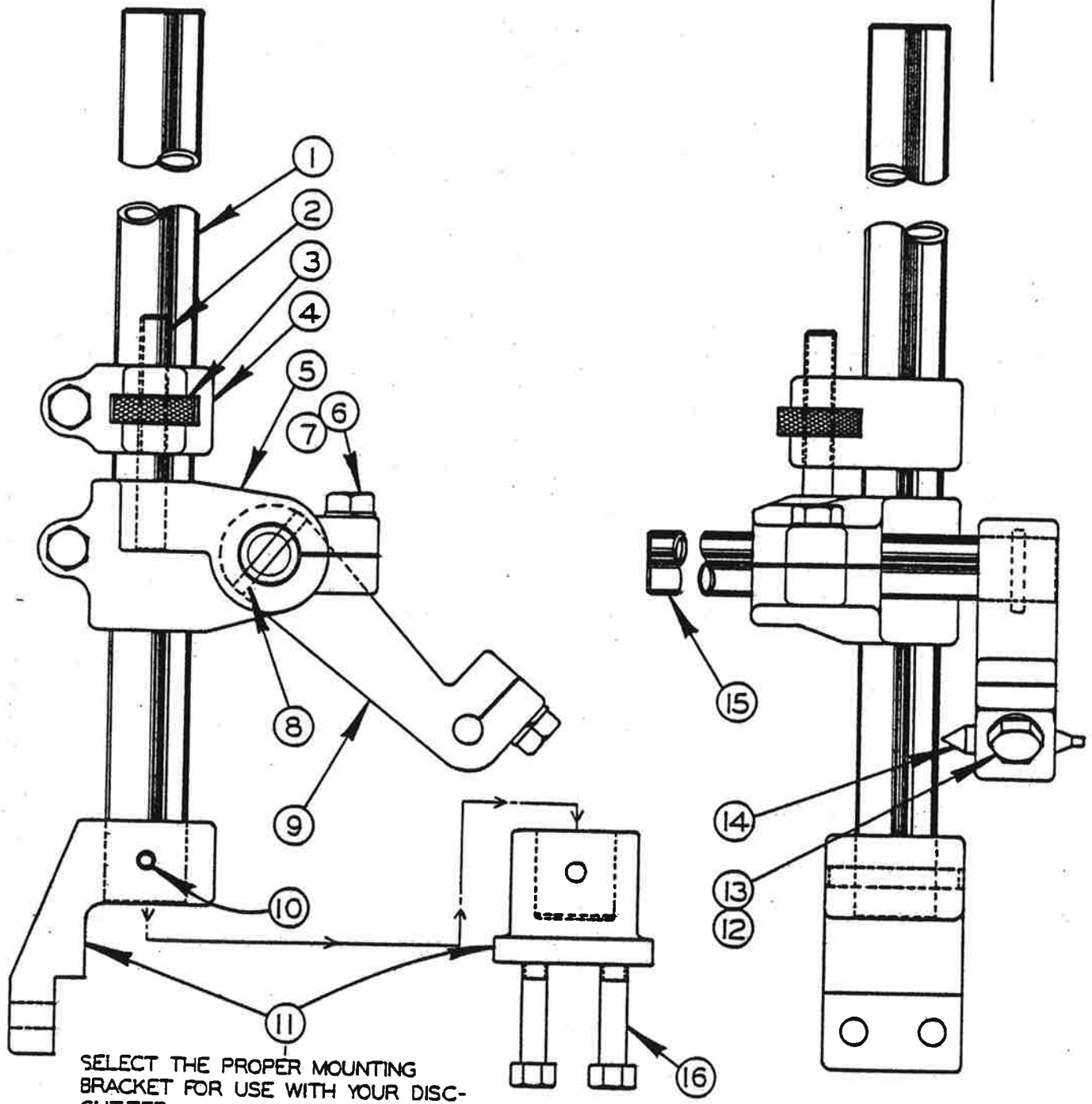
PS-6-7

TF-5-60

COOLANT PUMP ASSEMBLY

INDEX NO. REF.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
	090-418781	Coolant Pump Assembly	
1	091-980474	. Screw, Hex. Hd. Cap 3/8-16NC x 11/4	4
2	091-993329	. Washer, Lock 3/8	4
3	091-227488	. Pipe Plug	1
4	090-029299	. Impeller (2875-3450 RPM)	USE
	090-251067	. Impeller (25 V Motor, 1450 RPM)	ONE
5	091-984179	. Screw, Soc. Set #10-32NF x 1/4	1
6	091-980334	. Screw, Hex. Hd. Cap 5/16-18NC x 2	4
7	091-993238	. Washer, Lock 5/16	4
8	090-404492	. Impeller Housing	1
9	090-029307	. Roto Flex Seal	1
10	090-029281	. Gasket	1
11	090-071101	. Stub Shaft	1
12	091-984328	. Screw, Soc. Set 1/4-28NF x 1/4	1
13	090-418864	. Adapter	1
14	111-055091	. Pipe Plug	1
15	090-046558	. Rotation Decal	1
16	090-070400	. Motor (Specify V, HP Cycle, Phase)	1

NEW DRG. S.W. 8-22-60
REVISIONS



SELECT THE PROPER MOUNTING BRACKET FOR USE WITH YOUR DISC-CUTTER.

DISC CUTTER ASSEMBLY

C-10-2 CM-9-1 Z-9-4

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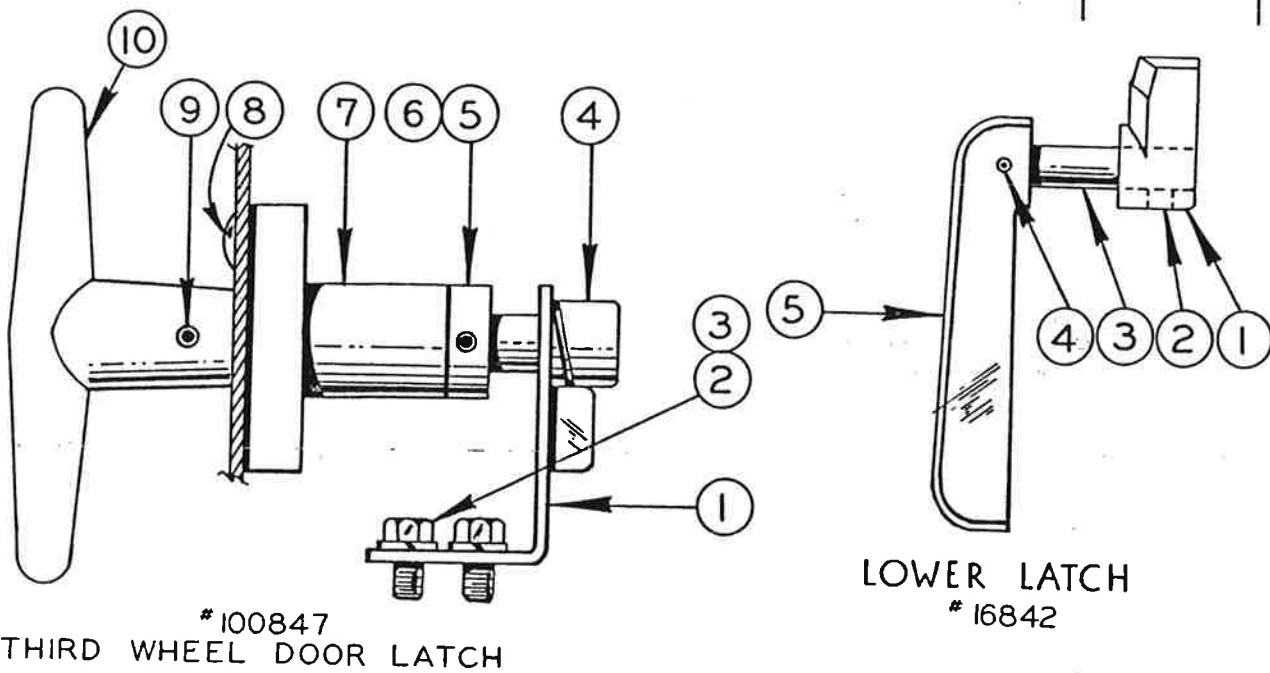
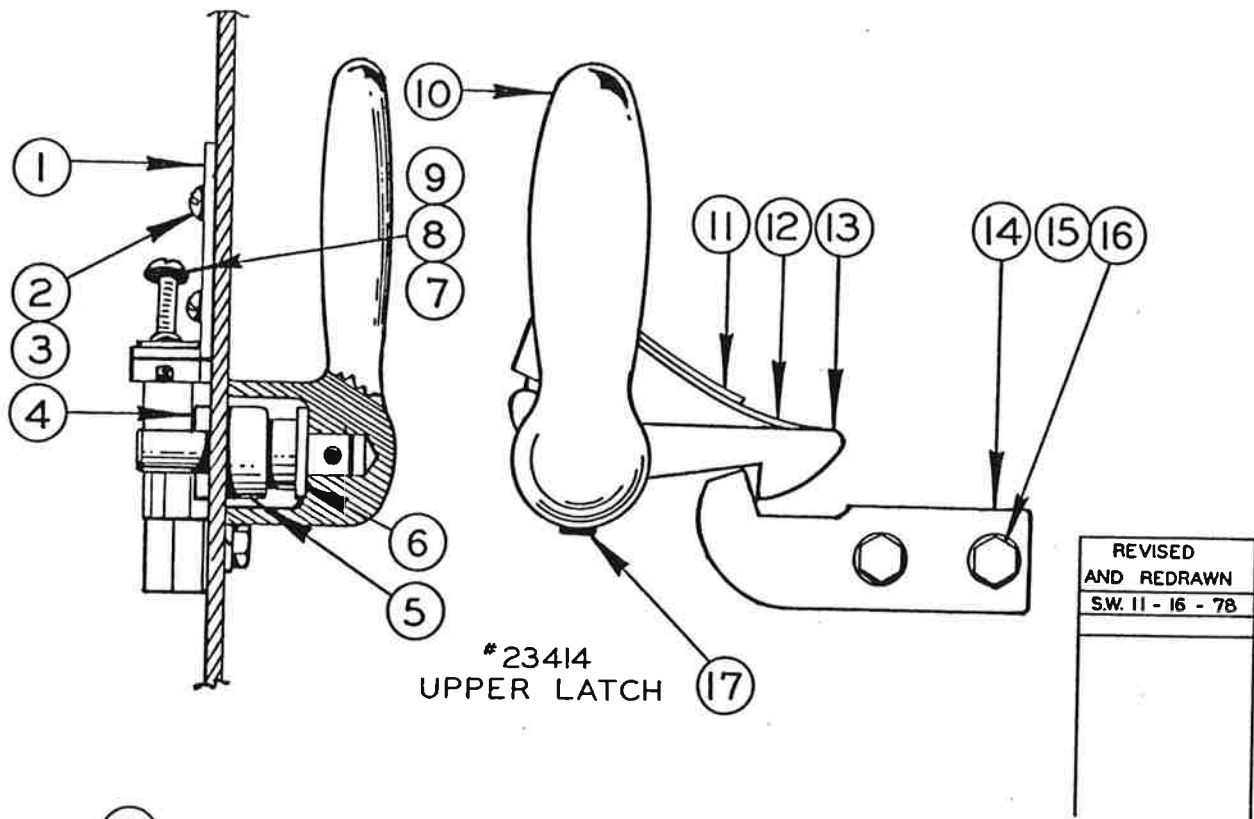
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CM-9-1

Z-9-4

DISC CUTTER ASSEMBLY

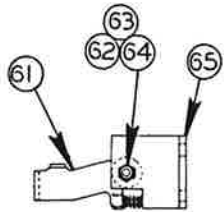
INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
REF.	094-020807	Disc Cutter Assembly (Contour & Contour-Matic Machines)	
REF	090-400441	Disc Cutter Assembly (Zephyr, 6013-3, 6013-H3)	
1	135-033991	. Radius Arm	1
2	105-154132	. Adjustment Screw	1
3	105-154124	. Adjustment Wheel	1
4	105-151096	. Adjustment Housing	1
5	135-034007	. Radius Arm Clamp	1
6	091-980466	. Screw, Hex. Hd. Cap 3/8-16NC x 1	3
7	091-993329	. Washer, Lock 3/8 Std.	3
8	090-042615	. Roll Pin	1
9	135-034023	. Center Pin Clamp	1
10	090-042763	. Roll Pin (Used on Ass'y #094-020807)	1
	090-042755	. Roll Pin (Used on Ass'y #090-400441)	1
11	090-390196	. Bracket (Used on Ass'y #094-020807)	1
	090-200452	. Bracket (Used on Ass'y #090-400441)	1
12	091-980292	. Screw, Hex. Hd. Cap 5/16-18NC x 1	3
13	091-993238	. Washer, Lock 5/16 Std.	3
14	105-154157	. Center Pin	1
15	135-034015	. Center Adjustment Tube	1
16	091-980334	. Screw, Hex. Hd. Cap 5/16-18NC x 2 (DZ-36 Only) ..	2
	091-980318	. Screw, Hex. Hd. Cap 5/16-18NC x 1 1/2 (All other Models)	2
Following Items Not Shown:			
	134-203082	. Wrench	1
	091-980284	. Screw, Hex. Hd. Cap 5/16-18NC x 7/8 (Used Only on Ass'y #094-020807)	



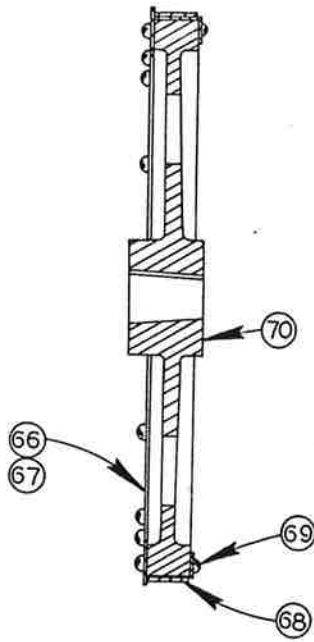
MODEL	FIRST MACH.	LAST MACH.
1612-1	148-59101	148-731539
1613-2	150-59101	150-75655
1612-3	152-59101	152-751144
3613-1	149-59101	149-73706
3613-2	151-59101	151-756083
3612-3	153-59101	153-761249
3612-1H3	358-76101	358-78155

DOOR LATCH ASSEMBLIES

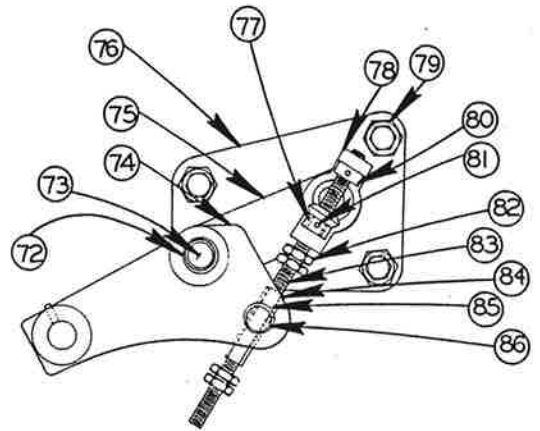
INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	090-234147	Upper Door Latch Assembly	
1	090-083593	. Bracket	2
2	091-988519	. Screw, Rd. Hd. Mach. 8-32NC x 1/4.....	4
3	091-993717	. Washer, Lock Shakeproof External #8 Std.	4
4	105-014062	. Door Latch Bushing	1
5	090-089814	. Nut, Hex. 5/8-11NC	1
6	091-992644	. Washer, Flat SAE 3/8	1
7	091-988592	. Screw, Rd. Hd. Mach. 8-32NC x 1.....	2
8	091-993188	. Washer, Lock Spring #8 Med.	2
9	091-991091	. Nut, Jam 8-32NC	2
10	090-234139	. Upper Door Handle Sub-Assembly	1
11	091-452201	. Spring	1
12	091-452193	. Spring	1
13	134-011055	. Upper Door Latch	1
14	090-065574	. Door Latch Hook	1
15	091-980060	. Screw, Hex. Hd. Cap 1/4-20NC x 1/2	2
16	091-993212	. Washer, Lock 1/4"	2
17	091-984252	. Screw, Soc. Set 1/4-20NC x 1/2	1
Ref.	090-168428	Lower Door Latch	
1	105-021018	. Door Latch	1
2	091-984229	. Screw, Soc. Set 1/4-20NC x 1/4	1
3	134-014109	. Pivot Pin	1
4	090-042292	. Roll Pin	1
5	134-011048	. Handle	1
Ref.	091-008474	Third Wheel Door Latch	
1	090-094673	. Latch Bracket	1
2	091-980060	. Screw, Hex. Hd. Cap 1/4-20NC x 1/2.....	2
3	091-993212	. Washer, Lock 1/4" Std.	2
4	090-094681	. Latch Sub-Assembly	1
5	134-054105	. Collar	1
6	091-984229	. Screw, Soc. Set 1/4-20NC x 1/4	2
7	111-011037	. Door Latch Bearing	1
8	091-990200	. Screw, Truss Hd. Mach. 1/4-20NC x 1/2	3
9	090-042573	. Roll pin	2
10	090-062738	. Door Handle	1



SHIFT LOCK SUB-ASS'Y
23643

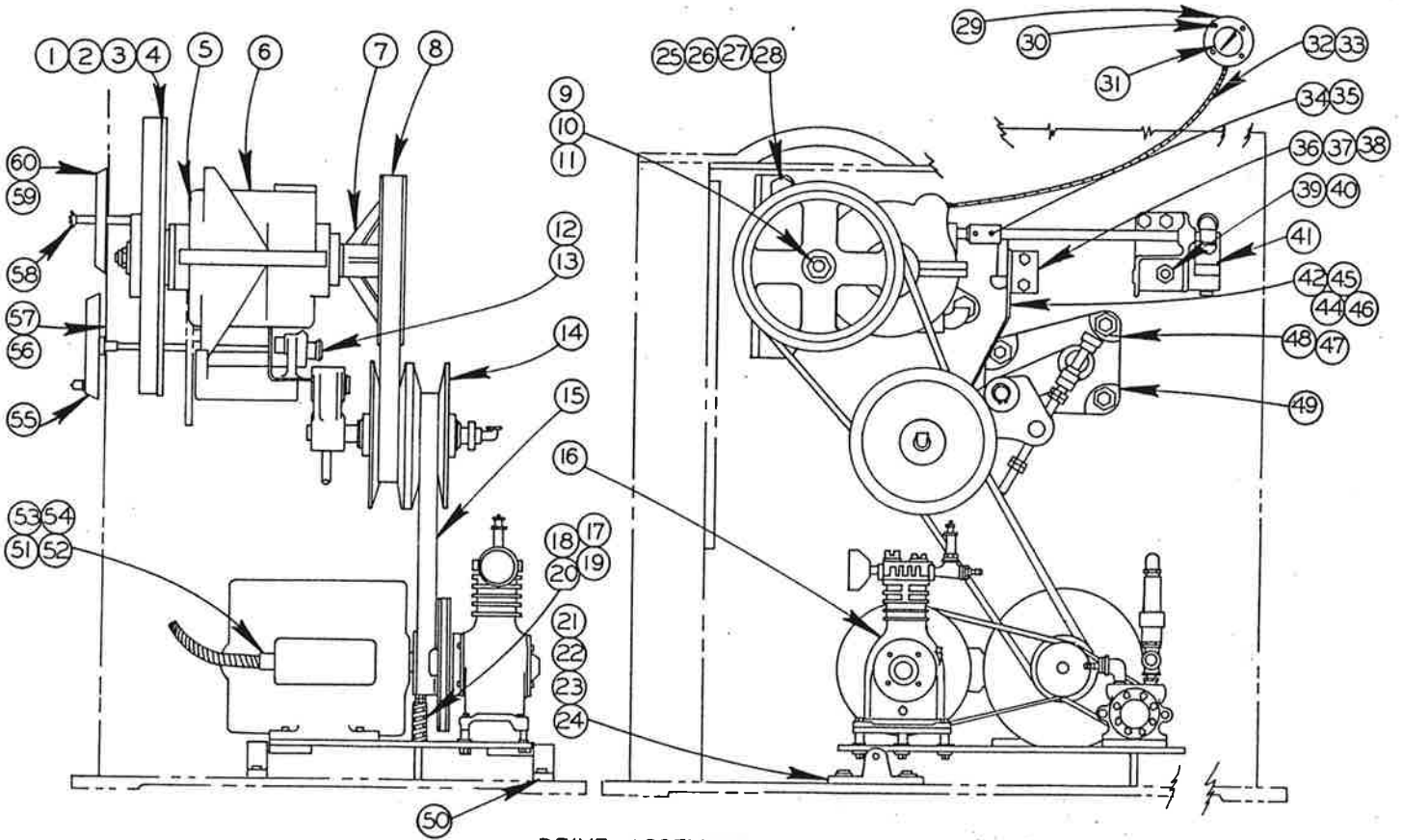


WHEEL ASS'Y
*406811



VARIABLE HANGER SUB-ASS'Y
42352

NEW DRG.
G.D. 12-9-75
REVISIONS
SW 11-9-78



DRIVE ASSEMBLY

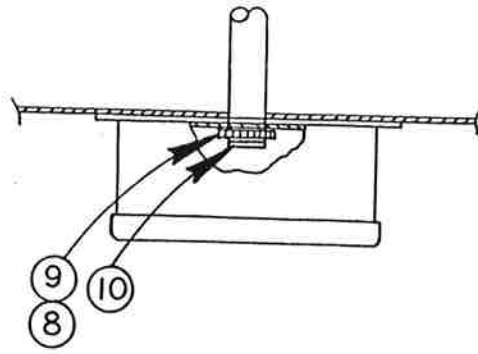
CM-5-63

MODEL FIRST MACH. LAST MACH.
3612-1H3 358-76101 358-78155

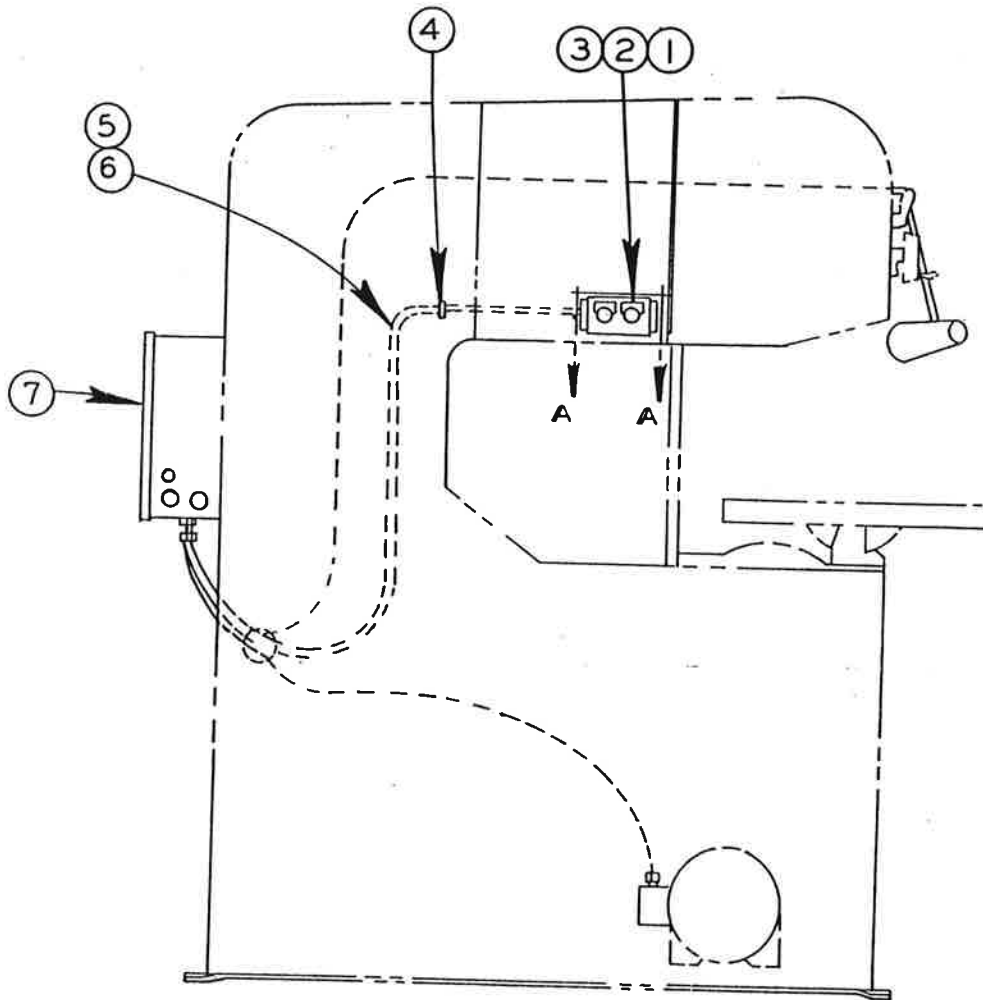
DRIVE ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	406793	Drive Assembly		49	090-423526	. Variable Hanger Sub-Ass'y. (See Detail)	1
1	094-068111	. Wheel Ass'y. (See Detail)	1			. Spacer	1
2	105-046049	. Woodruff Key	1	50	090-177254	. Wire #12 Stranded	A.R.
3	090-125964	. Nut, Lock	1	51	090-007212	. Sealtite Conduit 1/2	A.R.
4	091-992685	. Washer, 3/4 Std.	1	52	090-005208	. Conduit Elbow	1
5	090-096041	. Caulking Compound	A.R.	53	090-145079	. Reducing Washer	2
6	090-501867	. Transmission Ass'y. (MX-2) (See Detail)	1	54	091-350785	. Hand Wheel Sub-Ass'y.	1
7	090-421371	. Transmission Pulley	1	55	090-216482	. Hand Wheel Brg.	1
8	135-023067	. Variable Speed Belt	1	56	105-051049	. Scr. Rd. Hd. Mach. 1/4-20NC x 3/8	3
9	090-052069	. Nut, Lock	1	57	091-988931	. Shift Knob	1
10	091-992677	. Washer, 5/8 Std.	1	58	134-135086	. Shift Knob Plate	1
11	106-335151	. Woodruff Key	1	59	090-425455	. Scr. Soc. Hd. Cap #10-24 x 5/8	3
12	091-984104	. Scr., Soc. Set #10-24NC x 1/4	1	60	091-982215	Shift Lock Sub-Ass'y.	
13	090-042599	. Roll Pin	3			. Lock Lever	1
14	135-093359	. Variable Sub-Ass'y. (See Detail).	1	Ref	090-236431	. Washer 5/16 Std.	2
15	090-028788	. Variable Speed Belt	1	61	090-216508	. Nut, Hex. Jam 5/16-18NC ..	2
16	505091	. Motor Base Ass'y. (See Detail) ..	1	62	091-993014	. Scr. Hex. Hd. Cap 5/16-18 NC x 1	1
17	090-018755	. Spring	1	63	091-991232	. Bracket - Shift Lock	1
18	135-087658	. Stud	1	64	091-980292		
19	091-991273	. Nut, Hex. Jam 3/8-16NC	2				
20	091-992644	. Washer 3/8 S.A.E.	A.R.	65	090-088808		
21	091-993329	. Washer, Lock 3/8 Std.	A.R.				
22	090-220385	. Hinge	2	Ref.	094-068111	Wheel Assembly	
23	091-980474	. Scr., Hex. Hd. Cap 3/8-16NC x 1-1/4	4	66	090-314527	. Back-up Plate	6
				67	091-988675	. Scr. Rd. Hd. Mach. #10-24NC x 3/8	A
24	091-993329	. Washer, Lock 3/8 Std.	10			. Tire & Rim Ass'y.	1
25	090-028234	. Screw	3	68	093-047447	. Retainer	2
26	091-991455	. Nut, Hex. Jam 7/8-14NF	3	69	090-046756	. Wheel	1
27	091-980730	. Scr., Hex. Hd. Cap 1/2-13NC x 3	3	70	094-067949		
28	091-993279	. Nut, Lock	1	Ref.	090-423526	Variable Hanger Sub-Ass'y.	
29	090-174780	. Speed Indicator Bezel	1	72	135-075588	. Retaining Ring	2
30	091-988717	. Scr., Rd. Hd. Mach. #10-24NC x 5/8	4	73	090-088857	. Shim	A.R.
31	090-210956	. Speed Indicator Head (See Detail)	1	74	090-423518	. Arm	1
32	090-102104	. Speedometer Cable	1	75	090-414509	. Gear Bracket	1
33	090-078320	. Cable Key	2	76	090-519927	. Bracket	1
34	091-984229	. Scr., Soc. Set 1/4-20NC x 1/4	1	77	090-099714	. Miter Gear	2
35	090-042599	. Roll Pin	A.R.	78	090-073511	. Oil Lite Bushing	3
36	090-236431	. Shift Lock Sub-Ass'y. (See Detail)	1	79	090-059569	. Adjusting Screw	3
37	091-980441	. Scr., Hex. Hd. Cap 3/8-16NC x 3/4	2	80	134-054105	. Collar	1
				81	090-042599	. Roll Pin	2
38	090-052176	. Spring	1	82	105-134100	. Nut, Stop	4
39	091-980508	. Scr., Hex. Hd. Cap 3/8-16NC x 2	3	83	090-221417	. Screw	1
				84	090-079799	. Spacer	1
40	091-993329	. Washer, Lock 3/8 Std.	A.R.	85	090-088840	. Spacer	1
41	090-236449	. Gear Shift Ass'y. (See Detail) ..	1	86	090-061755	. Trunnion Pin	1
42	090-052192	. Lock Rod	1				
44	135-064707	. Collar	1				
45	091-984096	. Scr., Soc. Set #10-24NC x 3/16	1				
46	091-995126	. Cotter Pin	2				
47	091-980532	. Scr., Hex. Hd. 3/8-16NC x 2-3/4	3				
48	091-993329	. Washer, Lock 3/8 Std.	A.R.				

NEW DRG.
G.D. 12-11-75
REVISIONS
S.W. 11-9-78



VIEW A A



ELECTRICAL ASSEMBLY

MODEL FIRST MACH. LAST MACH.
 3612-1H3 358-76101 358-78155

CM - 6-69

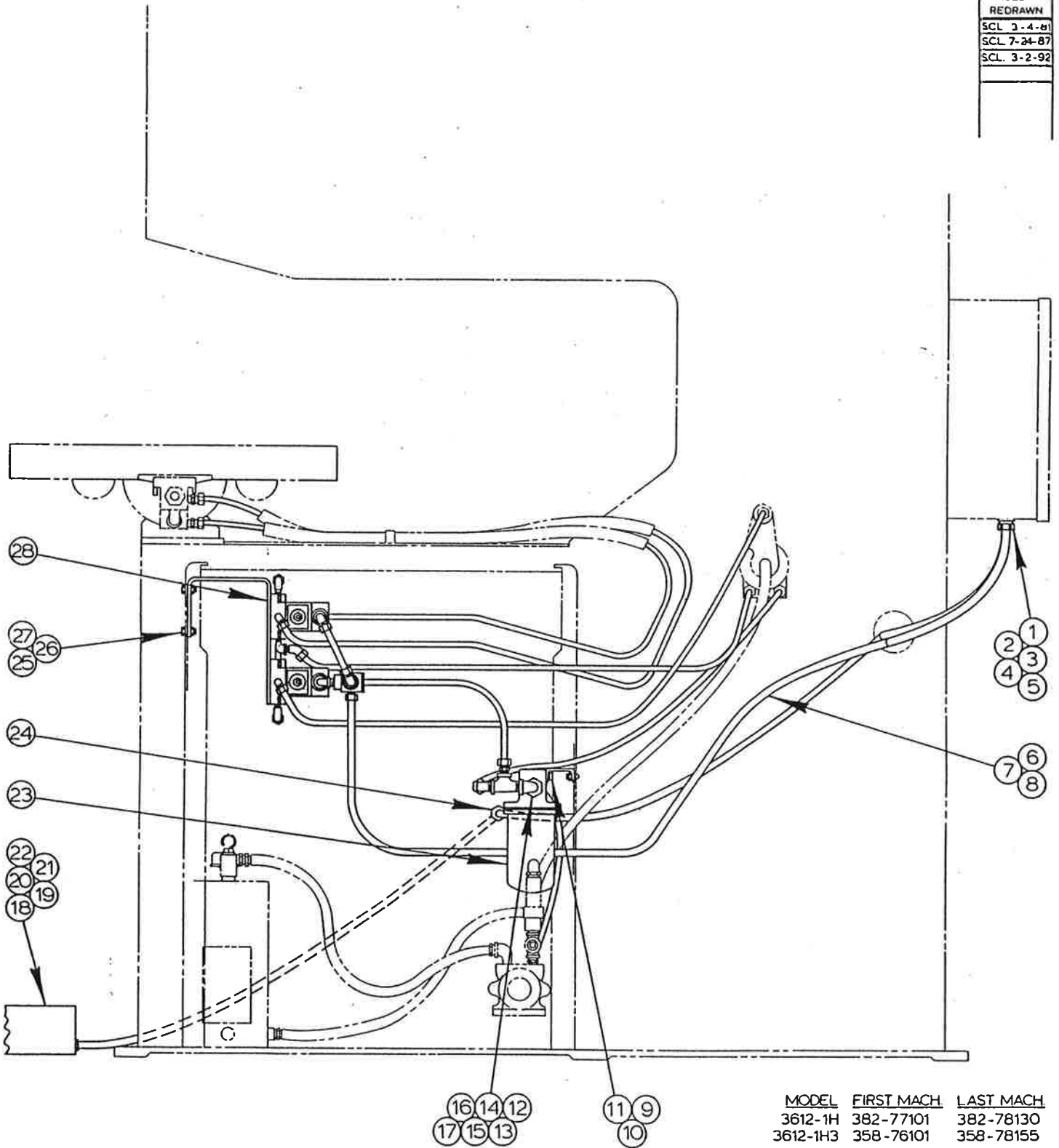
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CODE NO. CM-6-69

ELECTRICAL ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	505390	Electrical Assembly	
1	091-371666	. Pushbutton Box Ass'y.	1
2	091-988691	. Scr., Rd. Hd. Mach. #10-24NC x 1/2	4
3	091-993196	. Washer, Lock #10 STD.	4
4	090-142696	. Coupling 1/2	1
5	091-971564	. Sealtite Conduit 1/2	A.R.
6	091-971903	. Wire 19 Strand #14 Red	A.R.
7	091-420570	. Control Box Ass'y.	1
8	090-144114	. Washer, Flange 1/2	2
9	090-145053	. O-Ring 1/2	2
10	090-195439	. Nut, Bond 1/2"	2

REVISED AND REDRAWN
SCL 3-4-81
SCL 7-24-87
SCL 3-2-92



MODEL	FIRST MACH.	LAST MACH.
3612-1H	382-77101	382-78130
3612-1H3	358-76101	358-78155
3612-2H3	401-78101	401-92232

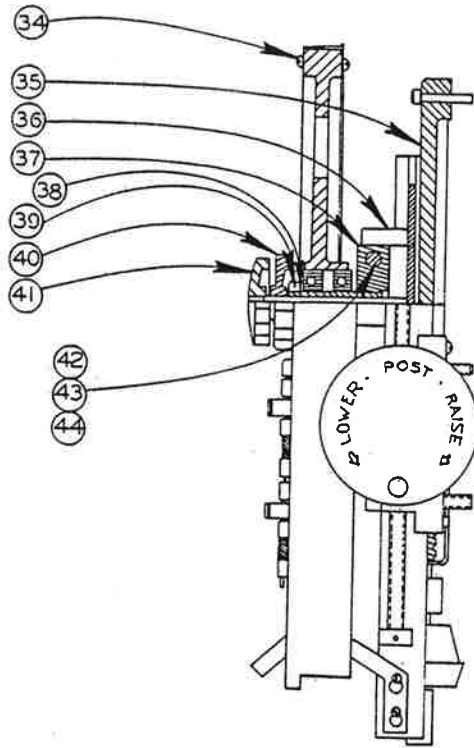
3-WAY FOOT SWITCH ASSEMBLY

CODE NO. CM-9-24

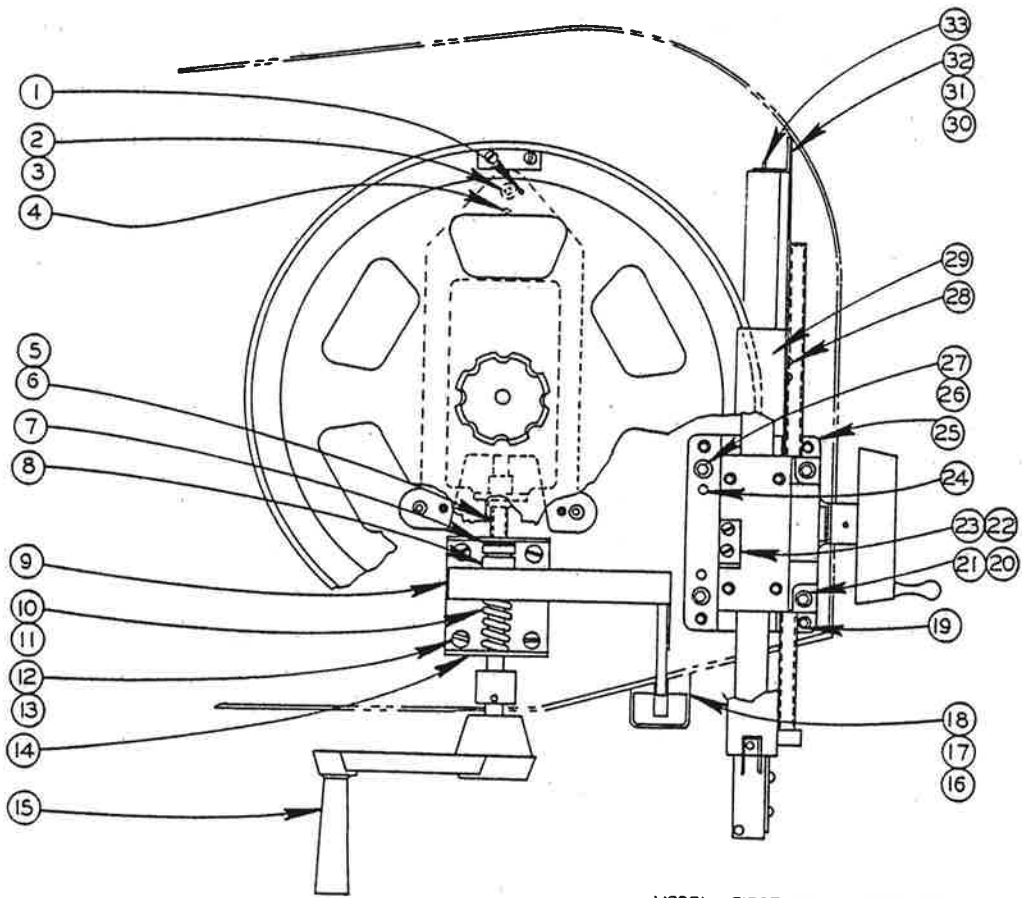
FOOT SWITCH ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
1	085-052009	Foot Switch Assembly (3-Way)	
2	090-195439	. Bond Nut.....	4
3	090-107897	. Cord Grip Connector	1
4	090-144114	. Flange Washer.....	2
5	090-145053	. O-Ring	2
6	090-145459	. Sealtite Connector.....	1
7	091-971564	. Sealtite Conduit 1/2 I.D.....	A.R.
8	091-971879	. Wire, #14 White (Nylon Jacket).....	A.R.
9	091-974147	. Wire, #14 Red (19 Strand)	A.R.
10	091-211193	. Bracket.....	1
11	091-982785	. Screw, Soc. Hd. Cap 3/8-16NC x 3/4.....	2
12	091-993329	. Washer, Lock 3/8 Std.....	2
13	091-223685	. Hex. Reducer Bushing.....	2
14	105-115133	. 90° Street Elbow.....	1
15	135-009827	. Service Tee.....	1
16	093-090595	. 90° Male Elbow.....	1
17	093-090124	. Male Connector.....	2
18	091-972653	. Nylon Tubing 3/8 O.D.....	A.R.
19	091-329276	. Foot Switch Assembly.....	1
20	091-329368	. . Foot Switch.....	1
21	091-298885	. . Escutcheon (Reverse).....	1
22	091-298877	. . Escutcheon (Forward)	1
23	091-993964	. . Screw, Rd. Hd. Drive #2 x 3/16.....	8
	091-211128	. Oil Filter (Schroeder Bros.).....	1
	091-211136	. . Oil Filter Element.....	1
24	090-151424	. 90° Cord Grip Connector.....	1
25	091-987685	. Screw, Flat Hd. Mach. 5/16-18NC x 3/4.....	6
26	091-993238	. Washer, Lock 5/16 Std.....	6
27	091-991224	. Nut, Hex. 5/16-18NC.....	6
28*	094-062684	. Valve Manifold Assembly (Foot Switch) (See Detail).....	1

*NOTE: If Valve Manifold Assembly Was Located Near The Throat Area Of Your Machine, Order 094-068632 Valve Manifold Assembly (See Detail).



NEW DRG.
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MODEL FIRST MACH. LAST MACH.
3612-1143 358-76101 358-78129

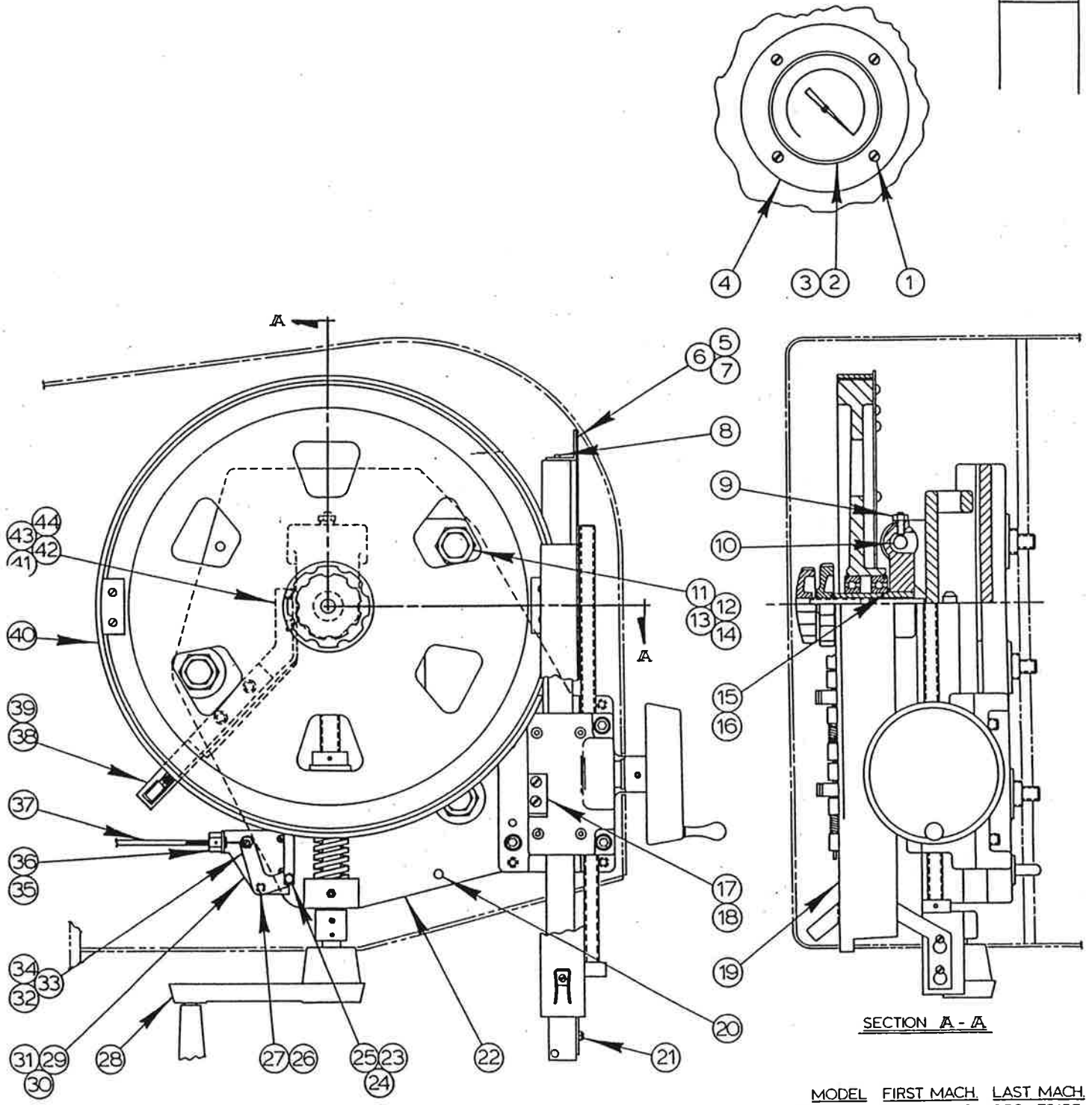
HEAD ASSEMBLY
CM-2-67

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HEAD ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	505092	Head Assembly	
1	090-042631	• Roll Pin	2
2	091-982637	• Screw, Soc. Hd. Cap 5/16-18NC x 1 3/4	3
3	091-993311	• Washer, Lock 5/16" Std.	7
4	091-986133	• Screw, Soc. Set 5/16-18NC x 1	3
5	090-042631	• Roll Pin	1
6	091-433961	• Tension Shaft Sub-Assembly	1
7	091-992669	• Washer, Flat 1/2" Std.	2
8	135-086155	• Thrust Bearing	1
9	091-422501	• Pointer Sub-Assembly	1
10	091-004051	• Spring	1
11	091-992669	• Washer, Flat 1/2" Std.	A.R.
12	091-993311	• Washer, Lock 5/16" Std.	A.R.
13	091-982785	• Screw, Soc. Hd. Cap 3/8-16NC x 3/4	2
14	091-432914	• Bracket	1
15	090-285271	• Handle Assembly	1
16	091-069195	• Bracket	1
17	091-993188	• Washer, Lock #8 Std.	2
18	091-988519	• Screw, Rd. Hd. Mach. #8-32NC x 1/4	2
19	091-218719	• Screw, Soc. Set (Self Locking)	4
20	091-993329	• Washer, Lock 3/8" Std.	4
21	091-982876	• Screw, Soc. Hd. Cap 3/8-16NC x 5/16	2
22	091-398115	• Stop	1
23	091-988667	• Screw, Rd. Hd. Mach. #10-24NC x 5/16	2
24	135-004455	• Dowel Pin	1
25	39055	• Post Elevating Assembly (See Detail)	1
26	091-993329	• Washer, Lock 3/8" Std.	A.R.
27	091-982819	• Screw, Soc. Hd. Cap 3/8-16NC x 1 1/2	2
28	091-986984	• Screw, Flat Hd. Mach. #10-24NC x 1/2	2
29	094-065117	• Post Saw Band Guard Assembly	1
30	091-988519	• Screw, Rd. Hd. Mach. #8-32NC x 1/4	2
31	091-992578	• Washer, #8 Std.	2
32	093-051357	• Guard Bracket Assembly	1
33	091-053041	• Roll Pin	1
34	094-068137	• Wheel Assembly	1
35	095-046215	• Head Casting	1
36	094-073848	• Slide Sub-Assembly	1
37	093-023463	• Wheel Hinge Sub-Assembly (See Detail)	1
38	105-015077	• Washer, Bearing Lock	1
39	105-015069	• Nut, Bearing Lock	1
40	105-011092	• Upper Wheel Tilting Lock Nut	1
41	091-306761	• Tilting Screw Sub-Assembly	1
42	090-130063	• Pin	1
43	135-096139	• Retaining Ring	2
44	091-333104	• Shim	A.R.
	091-333112	• Shim	A.R.
	091-333120	• Shim	A.R.
	091-333138	• Shim	A.R.
	091-333146	• Shim	A.R.

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SCL 7-24-81
SCL 7-15-87
SCL 3-2-92



SECTION A - A

MODEL	FIRST MACH	LAST MACH
3612-1H3	358-78130	358-78155
3612-2H3	401-78101	401-92232

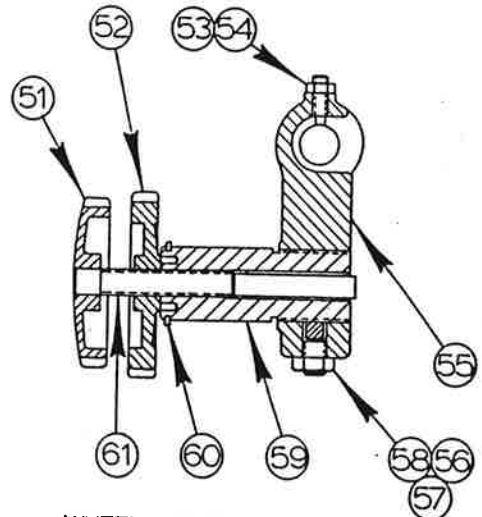
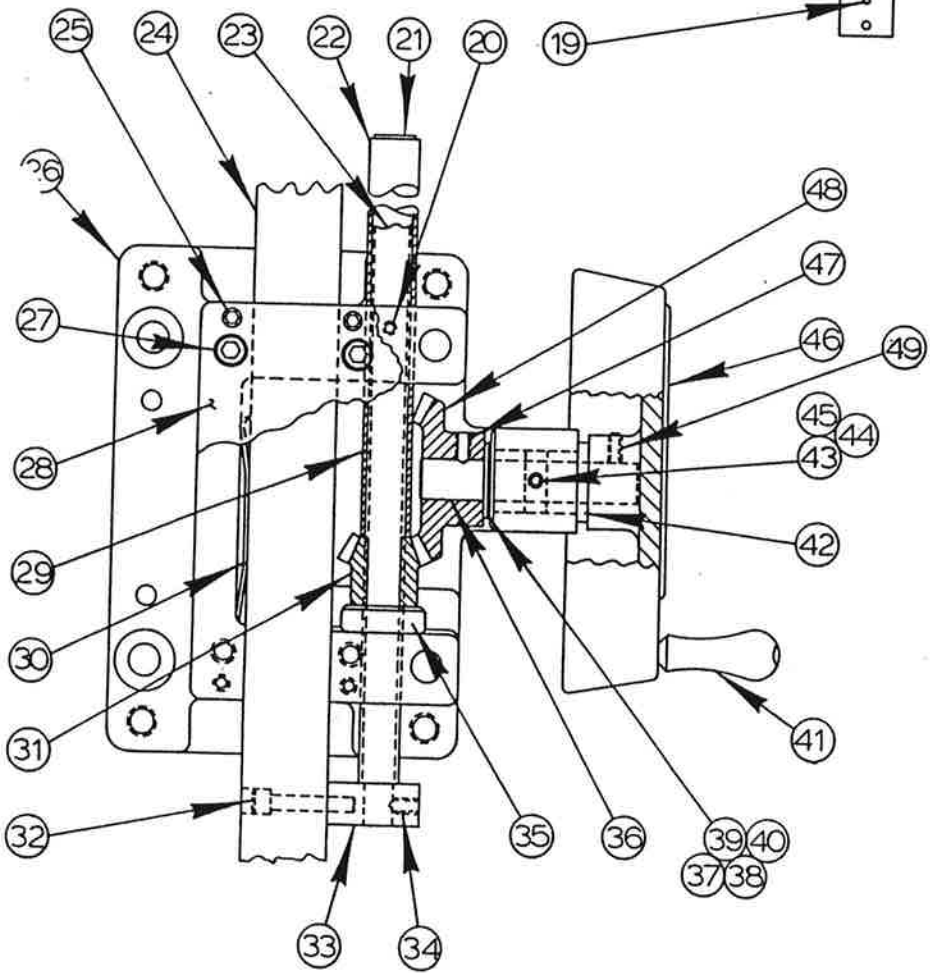
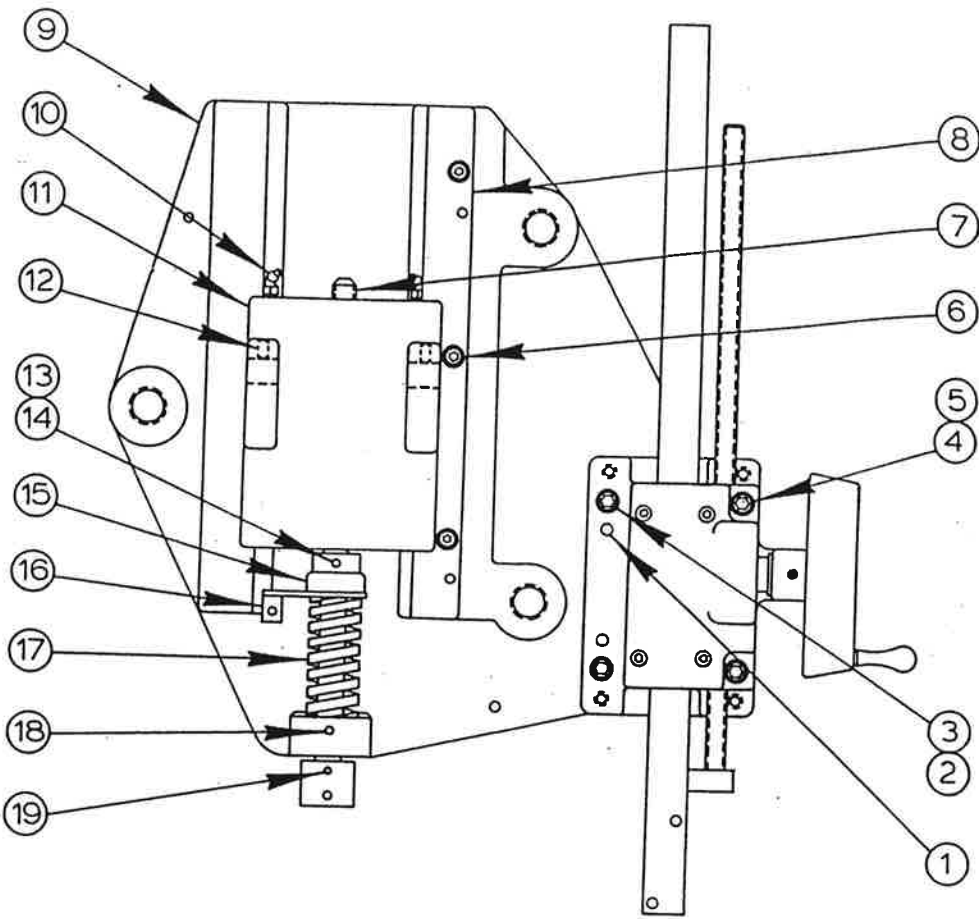
HEAD ASSEMBLY

HEAD ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	095-054854	Head Assembly	
1	091-988675	. Screw, Rd. Hd. Mach. #10-24NC x 3/8.....	4
2	094-095239	. Band Tension Indicator Assembly (Inch/English)(See Detail).....	1
	094-091105	. Band Tension Indicator Assembly (Metric/International)(See Deatil).....	1
3	090-071440	. Rack Sub-Assembly.....	1
	135-019727	. . Gear Rack.....	1
	090-033564	. . Wire.....	1
4	090-174780	. Bezel.....	1
5	093-051357	. Guard Bracket Assembly.....	1
6	091-988519	. Screw, Rd. Hd. Mach. #8-32NC x 1/4.....	3
7	091-992578	. Washer, Flat #8 S.A.E. Std.....	2
8	091-053041	. Roll Pin.....	1
9	090-306010	. Wheel Hinge Assembly (See Detail).....	1
10	135-086106	. Upper Wheel Hinge Pin.....	1
11	090-059163	. Lock Bolt.....	3
12	091-991455	. Nut, Hex. Jam 7/8-16NF.....	3
13	091-980755	. Screw, Hex. Hd. Cap 1/2-13NC x 3-3/4.....	3
14	091-993279	. Washer, Lock 3/8 Std.....	3
15	090-134073	. Back-Up Washer.....	A.R.
16	090-178278	. Spacer.....	A.R.
17	091-398115	. Stop.....	1
18	091-988667	. Screw, Rd. Hd. Mach. #10-24NC x 5/16.....	2
*19	094-065117	. Saw Band Guard Assembly.....	1
20	090-059187	. Dowel Pin.....	2
21	091-986984	. Screw, Fil. Hd. Mach. #10-24NC x 1/2.....	2
*22	094-082799	. Head Sub-Assembly (Standard)(See Detail).....	1
23	091-008466	. Link.....	2
24	091-004044	. Pin.....	
25	090-046178	. Retaining Ring.....	
26	091-001909	. Crank Assembly.....	1
	091-001917	. . Bell Crank.....	1
	091-001925	. . Spacer.....	1
27	135-085827	. Retaining Ring.....	1
28	090-285271	. Handle Assembly (Band Tension).....	1
	090-047929	. . Steel Ball.....	1
	091-137661	. . Spring.....	1
	090-453309	. . Handle Assembly.....	1
	091-462853	. . Shaft.....	1
	091-318006	. . Handle Bar.....	1
	091-181164	. . Handle.....	1
	091-181172	. . Pin.....	1
29	091-000851	. Pivot Assembly.....	1
	091-004002	. . Pivot Plate.....	1
	091-004010	. . Pivot Pin.....	1
30	091-988691	. Screw, Rd. Hd. Mach. #10-24NC x 1/2.....	4
31	091-993196	. Washer, Lock #10 Std.....	4
32	091-001891	. Swivel.....	1
33	091-004028	. Radius Washer.....	1
34	091-995076	. Cotter Pin.....	1
35	090-033556	. Casing Clamp.....	1
36	091-984062	. Screw, Soc. Set #8-32NC x 1/4.....	2
37	091-973172	. Nylon Tubing 3/16 O.D.....	A.R.
38	090-166844	. Wheel Brush.....	1
39	091-049775	. Brush Holder Weldment.....	1
40	094-082807	. Bandwheel Assembly (Flanged)(See Detail).....	1
41	090-313818	. Mounting Bar.....	1
42	091-982199	. Screw, Soc. Hd. Cap #10-24NC x 3/8.....	4
43	091-992586	. Washer, Flat #10 S.A.E. Std.....	4
44	091-993196	. Washer, Lock #10 Std.....	2

*NOTE: Also See Extra Work Height Assembly If Applicable.

REVISED AND
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SCL 7-27-81
SCL 7-16-87
SCL 3-2-92



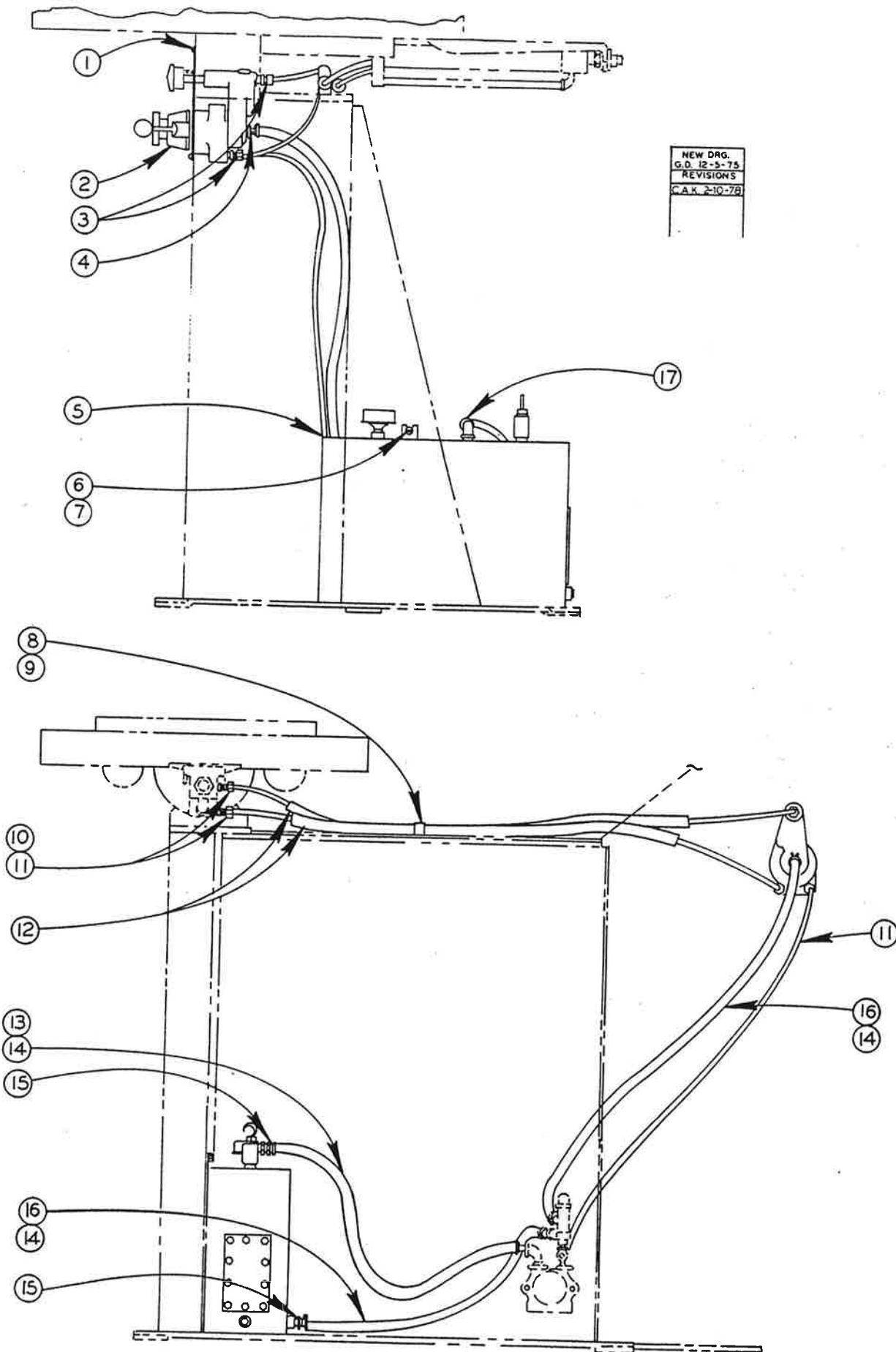
WHEEL HINGE ASSEMBLY

MODEL	FIRST MACH.	LAST MACH.
3612-1H3	358-78130	358-78155
3612-2H3	401-78101	401-92232

HEAD SUB-ASSEMBLY

HEAD SUB-ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	094-082799	Head Sub-Assembly (Standard)	
Ref.	094-082369	Head Sub-Assembly (6" Extra Work Height)	
Ref.	094-091147	Head Sub-Assembly (12" Extra Work Height)	
Ref.	094-091154	Head Sub-Assembly (18" Extra Work Height)	
1	090-089756	. Dowel Pin.....	
2	091-982819	. Screw, Soc. Hd. Cap 3/8-16NC x 1-1/2.....	2
3	091-993329	. Washer, Lock 3/8 Std.....	2
4	091-982876	. Screw, Soc. Hd. Cap 3/8-16NC x 3.....	2
5	090-051509	. Washer, Lock 3/8 Hi-Collar.....	2
6	091-982611	. Screw, Soc. Hd. Cap 5/16-18NC x 1-1/4.....	3
7	090-285263	. Screw.....	1
8	090-346685	. Gib.....	1
9	095-003737	. Head Casting.....	1
10	090-059197	. 90° Grease Fitting.....	1
11	090-410275	. Slide Block.....	2
12	091-984336	. Screw, Soc. Set 1/4-28NF x 1/2.....	1
13	105-014146	. Collar.....	2
14	090-042615	. Roll Pin.....	1
15	135-086155	. Thrust Bearing.....	4
16	091-000836	. Rod Anchor.....	1
17	091-004051	. Spring.....	1
18	135-094738	. Grease Fitting.....	1
19	091-003970	. Adaptor.....	1
20	091-984096	. Screw, Soc. Set #10-24NC x 3/16.....	1
21	091-235812	. Plug Button.....	1
22	091-235804	. Tube (Standard).....	1
	091-428169	. Tube (6" Extra Work Height).....	1
	091-428177	. Tube (12" Extra Work Height).....	1
23	091-428185	. Tube (18" Extra Work Height).....	1
	091-209247	. Screw (Standard).....	1
	093-057545	. Screw (6" Extra Work Height).....	1
	093-057552	. Screw (12" Extra Work Height).....	1
	093-057560	. Screw (18" Extra Work Height).....	1
24	090-391186	. Post (Standard).....	1
	093-057511	. Post (6" Extra Work Height).....	1
	093-057529	. Post (12" Extra Work Height).....	1
	093-057537	. Post (18" Extra Work Height).....	1
25	091-985903	. Screw, Soc. Set 1/4-20NC x 1/2 (Half Dog Pt.).....	4
26	094-017688	. Housing.....	1
27	091-982363	. Screw, Soc. Set 1/4-20NC x 1/2.....	4
28	090-386442	. Cover.....	1
29	091-240317	. Bearing.....	1
30	105-013064	. Spring.....	1
31	091-209254	. Gear.....	A.R.
32	091-982256	. Screw, Soc. Hd. Cap #10-24NC x 1.....	1
33	091-209205	. Block.....	2
34	091-154278	. Screw, Soc. Set #10-24NC x 1/4 (Self-Locking).....	1
35	135-028108	. Thrust Bearing.....	1
36	091-209239	. Shaft.....	1
37	091-333104	. Shim (.035).....	1
38	091-333112	. Shim (.0149).....	A.R.
39	091-333120	. Shim (.005).....	A.R.
40	091-333138	. Shim (.003).....	A.R.
41	091-046904	. Handle.....	A.R.
42	091-209221	. Bearing.....	1
43	090-039710	. Spring.....	2
44	091-407650	. Friction Plug.....	1
45	091-984229	. Screw, Soc. Set 1/4-20NC x 1/4.....	1
46	090-386434	. Handwheel.....	1
47	091-564765	. Screw, Soc. Set #10-24NC x 3/8 (Self-Locking).....	1
48	090-144353	. Bevel Gear.....	2
49	091-984104	. Screw, Soc. Set #10-24NC x 1/4.....	1
Ref.	090-306010	Wheel Hinge Assembly (Upper Wheel)	
51	105-011084	. Tilting Screw Knob.....	1
52	105-011092	. Upper Wheel Tilting Locknut.....	1
53	091-991141	. Nut, Hex. Jam 1/4-20NC.....	1
54	090-038621	. Screw, Soc. Set 1/4-20NC x 3/4 (Dog Pt.).....	1
55	090-222688	. Wheel Hinge.....	1
56	091-991273	. Nut, Hex. Jam 3/8-16NC.....	1
57	135-085785	. Insert.....	1
58	091-984492	. Screw, Soc. Set 3/8-16NC x 1/2.....	1
59	090-164088	. Wheel Axis Stud.....	1
60	135-075968	. Snap Ring.....	1
61	105-014252	. Upper Wheel Tilting Screw.....	1



NEW DRG.
G.O. 12-5-75
REVISIONS
C.A.K. 2-10-78

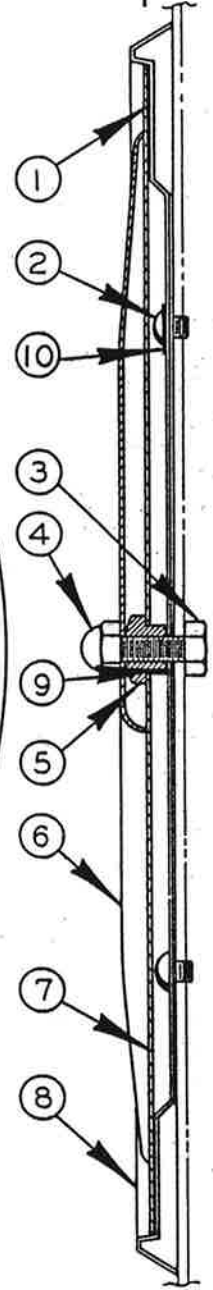
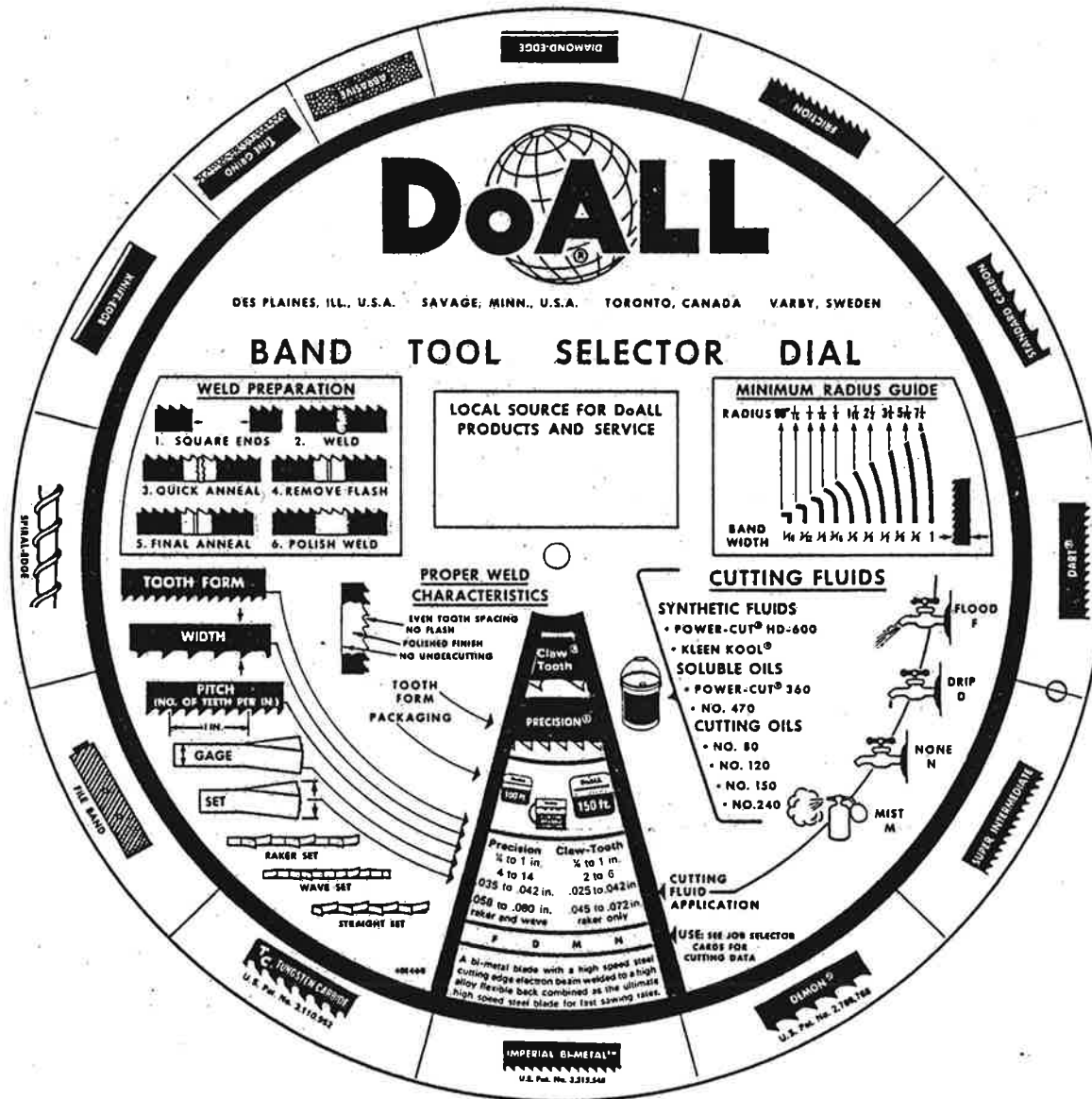
HYDRAULIC ASSEMBLY

CM-4-101

C-5

MODEL FIRST MACH. LAST MACH.
3612-1H3 358-76101 358-76155

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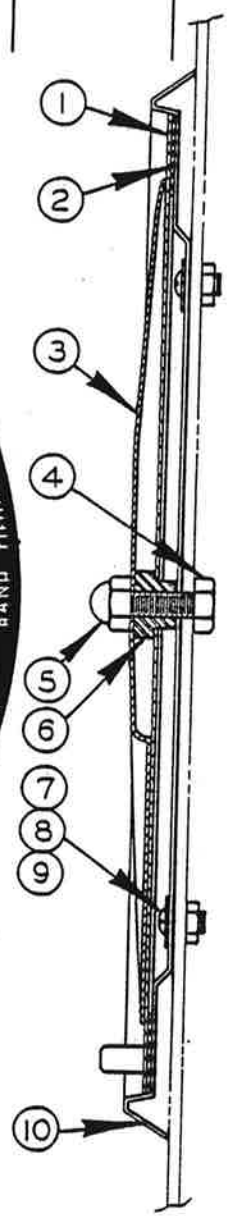


JOB SELECTOR ASSEMBLY

JOB SELECTOR

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	094-014610	Job Selector	
1	106-143043	. Outer Edge Felt	4
2	091-988907	. Screw, Rd. Hd. Mach. 1/4-20NC x 1/4	4
3	091-980292	. Screw, Hex. Hd. Cap 5/16-18NC x 1	1
4	090-044496	. Cap Nut 5/16-18NC	1
5	091-201988	. Bushing	1
6	094-014602	. Job Selector Plate	1
7	094-014594	. Job Selector Dial	1
8	090-598665	. Job Selector Frame	1
9	091-992628	. Washer, Flat SAE 5/16" Std.	1
10	091-992602	. Washer, Flat SAE 1/4" Std.	4

REVISED AND REDRAWN
S.W. 12-16-74



JOB SELECTOR ASSEMBLY

C-8-104 CM-8-53 Z-6-54

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CODE NO. C-8-104
CM-8-53
Z-6-54

INDEX NO.	CATALOG NO.	JOB SELECTOR DESCRIPTION	UNITS PER ASS'Y
Ref.	090-468174	Job Selector (1612-U, 3012-U, 1611-H, 2612-1H, 2013, 2013-0, 2012-A, 2012-AT, 1612-0, 3613-0, 1612, 3612, 2013-1, 2013-10, 2012-1A, 2012-1AT, 3612-1H, 3612-1, 3613-10)	
*Ref.	090-435603	Job Selector (1612-1, 3613-1, 2612-1, 2613-2, 6013-2, 2618-4, HS-6013, ZW-3620, ZV-3620, ZS-3620)	
1	090-220781	. Job Selector Dial	1
2	106-143043	. Outer Edge Felt	4
3	094-008380	. Job Selector Plate	1
4	091-990283	. Screw, Truss Hd. Mach. 5/16-18NC x 3/4	1
	*091-980276	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4	1
5	090-044496	. Acorn Nut 5/16-18NC	1
6	106-144017	. Bushing	Use
	*090-027012	. Bushing	One
*7	091-988907	. Screw, Rd. Hd. Mach. 1/4-20NC x 1/4	4
*8	091-993741	. Washer, Lock Shakeproof 1/4 Internal	4
*9	091-991141	. Nut, Hex. Jam 1/4-20NC	4
*10	090-426727	. Job Selector Frame	1

NOTE: Job Selectors #090-468174 & #090-435603, First Used 9/17/62. Before This Date #094-008380 Plate and #090-220781 Dial, Must Be Replaced Together As A Unit.

*NOTE: Starred Items Used Only On Assembly #090-435603.

*NOTE: Last Used On Models:

MODEL	LAST MACH.
1613-2	150-69593
3613-2	151-69515
1612-3	152-691017
2613-3	198-69361
3612-3	153-691054
6013-3	199-70125
1612-H	288-69204
2612-H	284-69135
2612-2H	206-69308
3612-H	272-69152

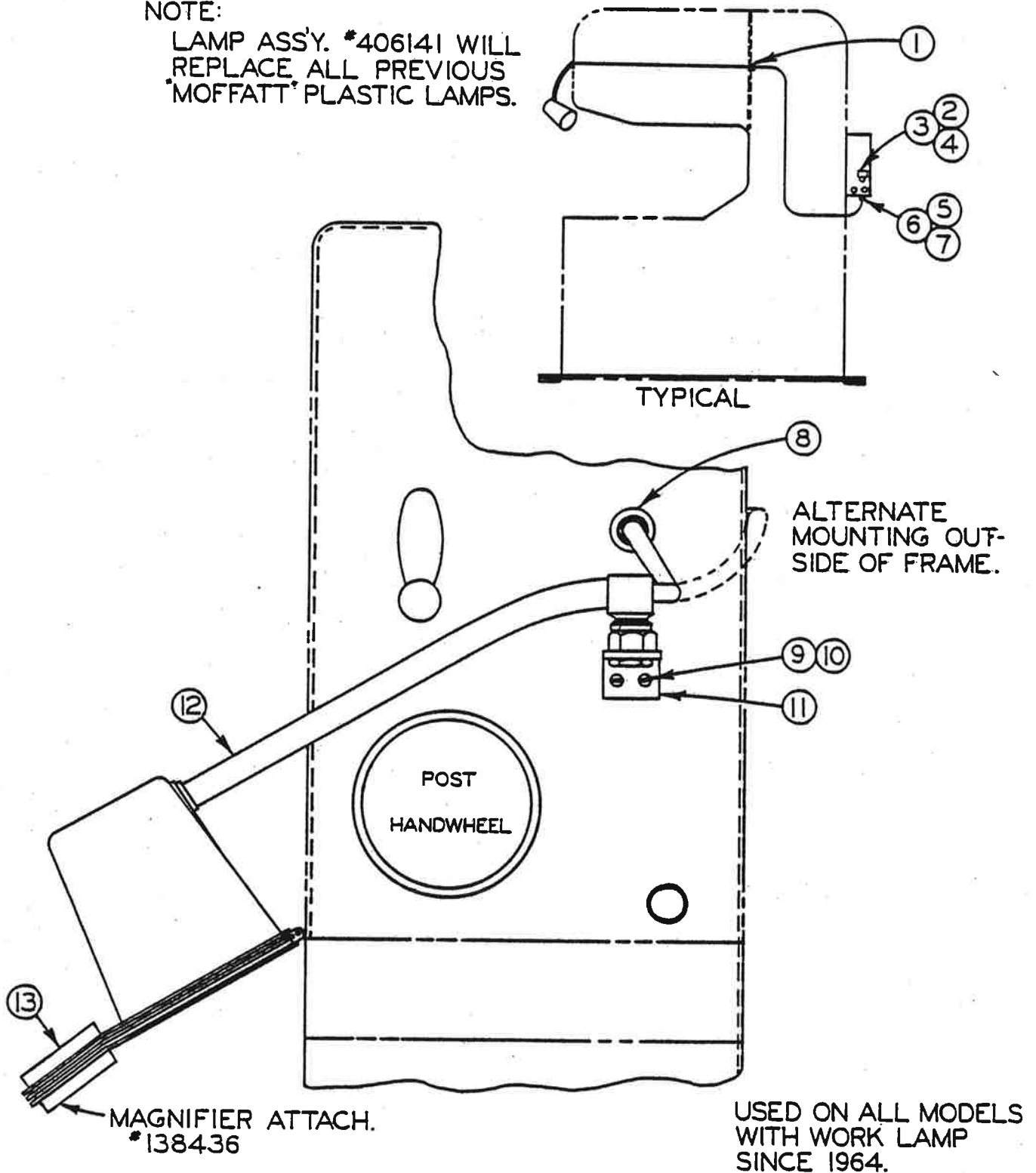
O.S.H.A. REQUIREMENT:

WIRE WORK LAMP DIRECT TO CONTROL BOX. MOUNT LAMP SWITCH ON SIDE OF CONTROL BOX OR THE CONTROL PANEL.

REVISIONS
REDRN
5-23-75 W.S.

NOTE:

LAMP ASS'Y. *406141 WILL REPLACE ALL PREVIOUS 'MOFFATT' PLASTIC LAMPS.



LAMP & MAGNIFIER ASSEMBLIES

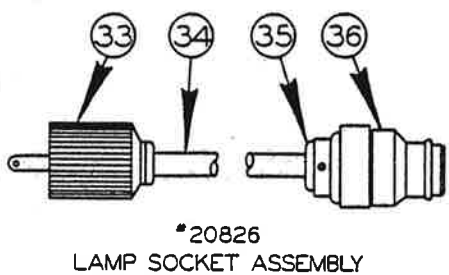
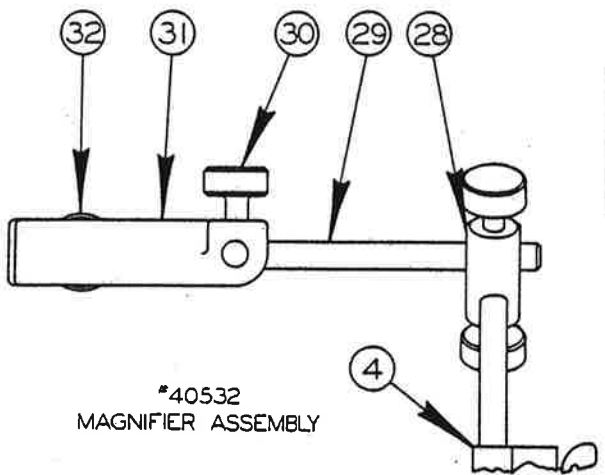
C-8-8 CM-8-31 PS-8-103 TF-4-100 F9-6.1 Z-7-61

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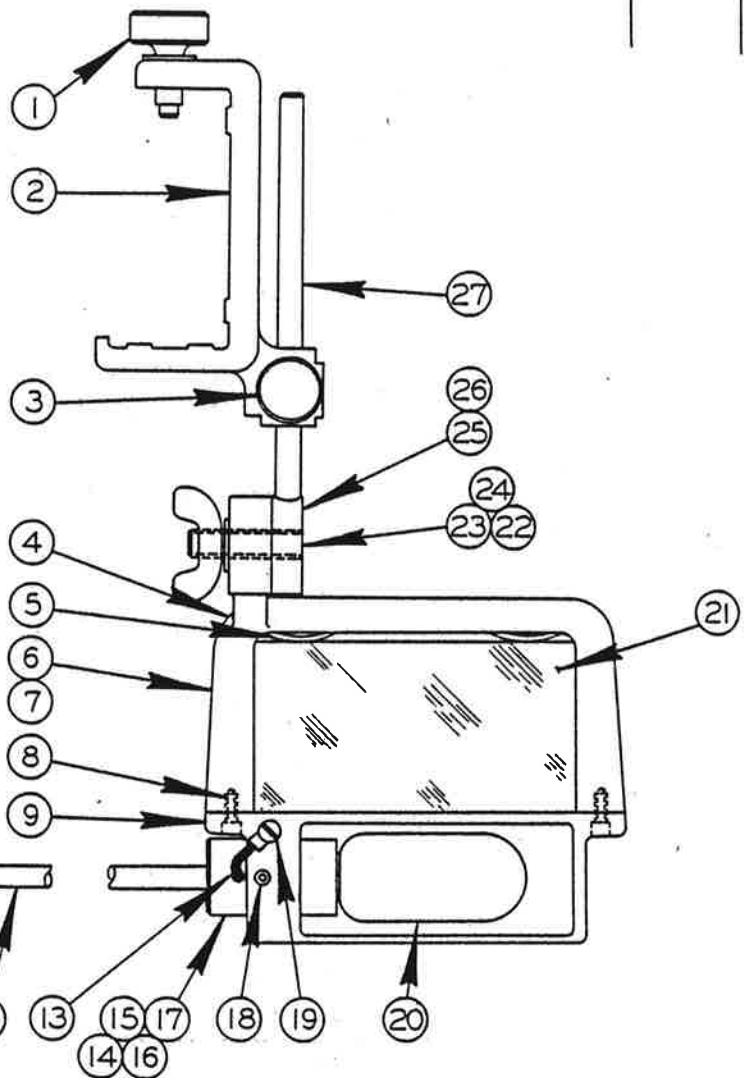
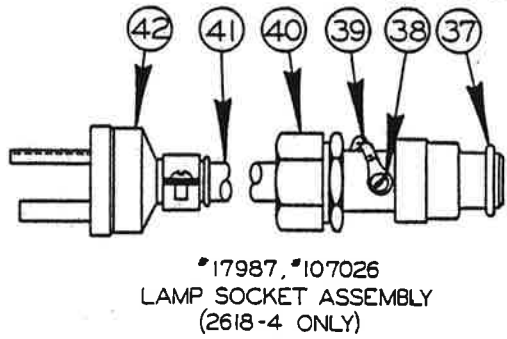
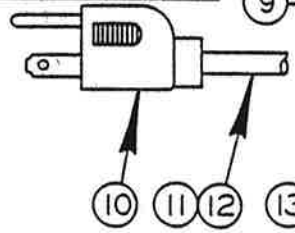
C-8-8
CM-8-31
PS-8-103
CODE NO. TF-4-100
F9-6.1
Z-7-61

LAMP & MAGNIFIER

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	094-061413	Lamp Assembly	
1	090-157454	. Bushing	1
2	090-152455	. Selector Switch, 2-Position	1
3	091-048207	. Contact Block	1
4	091-333591	. Legend Plate	1
5	090-145459	. Cord Grip Connector	1
6	090-144114	. Washer	1
7	090-145053	. "O"-Ring	1
8	090-151390	. Cord Grip	1
9	091-988659	. Screw, Rd. Hd. Mach. #10-24NC x 1/4"	2
10	091-993196	. Washer, Lock #10 Std.	2
11	091-025049	. Bracket	1
12	091-384529	. Lamp Sub-Assembly, 19" Flexible Cable, 11'-1/2" Connecting Cord	1
13	091-384362	. Magnifier Attachment, Mounts to Lampshade on Lamp Part #091-384529.....	1



ZEPHYRS ONLY

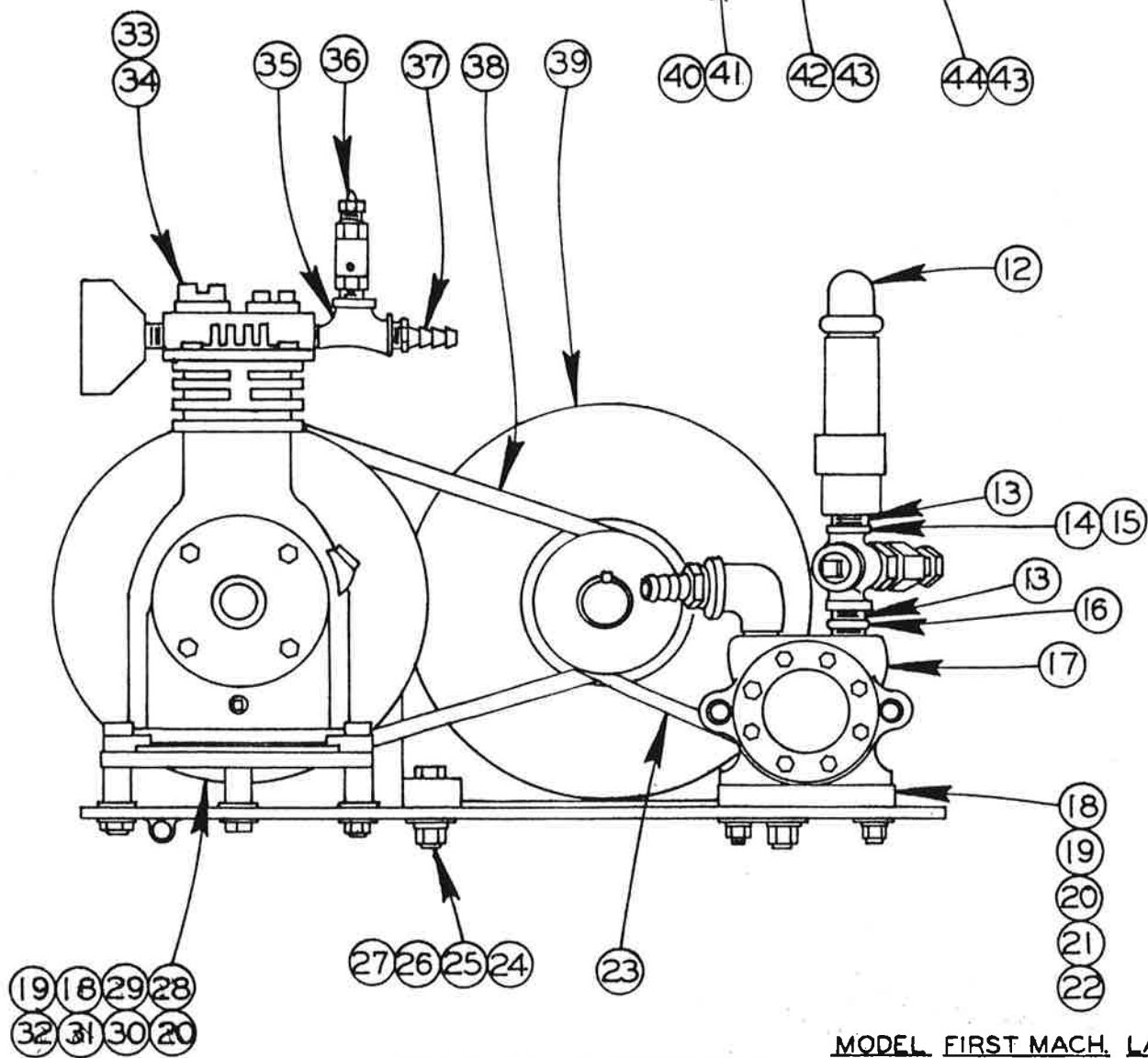
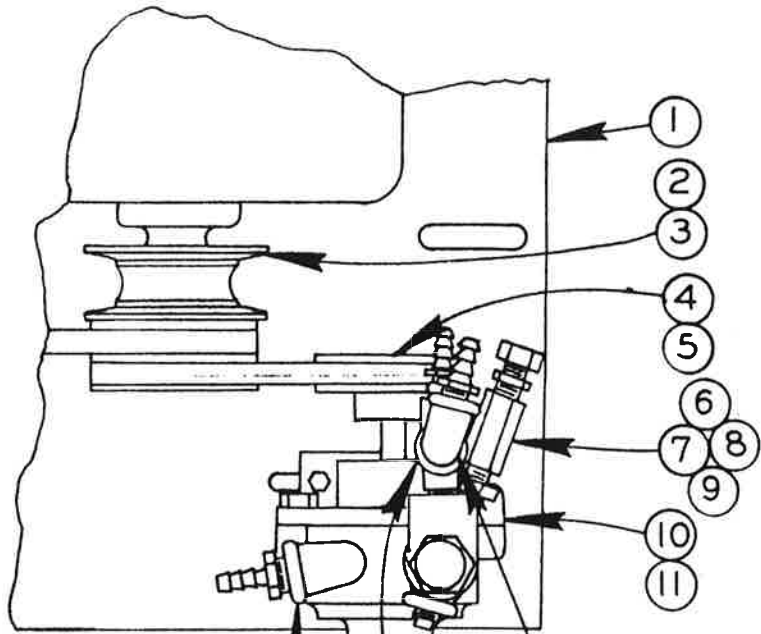


MAGNIFIER ATTACHMENT
ASSEMBLY

MAGNIFIER ATTACHMENT ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	135-005551	Magnifier Attachment Assembly(1612, 1612-0, 1612-H, 1612-1, 1613-2, 1612-3, 2012-A, 2012-AT, 2013, 2013-0, 2012-1A, 2012-1AT, 2013-1, 2013-10, 2612-H, 2612-1, 3612, 3613-0, 3612-H, 3613-1, 3613-2, 3612-3, 2614-1, 2012-1H, 2012-2H, 2012-1H3, 2012-2H3, 3612-1H3, 3612-2H3)	
Ref.	090-428723	Magnifier Attachment Assembly(2613-2, 2613-3, 6013-2, 6013-3, 6013-H3, 2612-1H3)	
Ref.	090-477670	Magnifier Attachment Assembly(2618-4)	
Ref.	090-405325	Magnifier Attachment Assembly(ZS-3620, ZV-3620, ZW-3620)	
1	134-174010	. Thumbnut(Ass'ys #135-005551, #090-428723, #090-477670)	1
	091-982421	. Screw, Soc. Hd. Mach. 1/4-20NC x 1	2
2	093-001899	. Post Clamp(Assembly #135-005551)(1-1/2"Post)	Use
	090-243932	. Post Clamp(Assembly #090-428723)(2-3/4"Post)	
	090-477639	. Post Clamp(Assembly #090-477670)(3-1/4"Post)	
	094-000734	. Post Clamp(Assembly #090-477670)(Extra Work Height)	One
3	135-005544	. Thumb Nut	1
4	090-451055	. Magnifier Sub-Assembly (Assembly #135-005551, #090-428723)	Use
	090-477688	. Magnifier Sub-Assembly (Assembly #090-477670)	
	090-412529	. Magnifier Sub-Assembly (Assembly #090-405325)	One
5	135-021046	. Lens Spring	2
6	135-052694	. Magnifier Housing Sub-Assembly	1
7	135-005528	. Frame	1
8	091-986901	. Screw, Fil. Hd. Mach. #6-32NC x 3/8	2
9	135-005536	. Housing	1
10	093-021681	. Lamp Socket Assembly (Assembly #090-451055 Only)	1
11	091-305383	. Electrical Cord	1
12	091-038372	. Wire Terminal	2
13	091-038349	. Wire Terminal	1
14	091-035360	. Socket Bushing	1
15	091-338848	. Socket 75-W, 125-V	1
16	091-305375	. Strain Relief	1
17	091-984062	. Screw, Soc. Set #8-32NC x 1/4	1
18	091-984104	. Screw, Soc. Set #10-24NC x 1/4	1
19	091-988519	. Screw, Rd. Hd. Mach. #8-32NC x 1/4	1
20	091-338749	. Lamp (Assembly #090-451055, #090-412529)	Use
	090-195124	. Lamp (Assembly #090-477688)	One
21	134-175017	. Magnifying Lens	1
22	135-005593	. Pivot Stud	1
23	091-992628	. Washer 5/16" SAE Std.	1
24	135-005627	. Wing Nut	1
25	135-005601	. Post Arm Swivel Sub-Assembly (Assembly #090-451055)	Use
	091-070250	. Arm Assembly (Assembly #090-477688)	
	135-008761	. Post Arm Swivel Sub-Assembly(Assembly #090-477688, 36" Zephyrs)	
	090-183757	. Post Arm Swivel Sub-Assembly(Assembly #090-412529)	One
26	135-005585	. Swivel (Assembly #135-005601, #091-070250)	Use
	135-008720	. Swivel (Assembly #135-008761, #090-183757)	One
27	135-005569	. Arm (Assembly #135-005601)	Use
	091-070243	. Arm (Assembly #091-070250)	
	135-008712	. Arm (Assembly #135-008761)	
	091-363440	. Rod (Assembly #090-183757)	One
Ref.	090-405325	Magnifier Attachment Assembly(ZS-3620, ZV-3620, ZW-3620)	
28	090-031089	. Joint	1
29	090-031071	. Arm	1
30	135-005544	. Thumb Nut	3
31	090-229030	. Post Clamp	1
32	134-174010	. Thumb Nut	1
Ref.	090-208265	. Lamp Socket Assembly (Zephyrs)	1
33	091-353946	. Midget Card Connector	1
34	090-007923	. Rubber Cord	A.R.
35	091-353888	. Bushing	2
36	091-353912	. Socket	1
Ref.	090-179870	. Lamp Socket Assembly (2618-4 L.A. Machines)	1
Ref.	091-070268	. Lamp Socket Assembly (2618-4)	1
37	090-183476	. Socket	1
38	091-988519	. Screw, Rd. Hd. Mach. #8-32NC x 1/4	1
39	091-038349	. Wire Terminal	1
40	090-183468	. Cord Grip Connector	1
41	090-007956	. Rubber Cord	A.R.
42	090-162132	. Plug U-Ground	1

NEW DRG.
GD. 12-10-75
REVISIONS
S.W. 11-9-78



MOTOR BASE ASSEMBLY

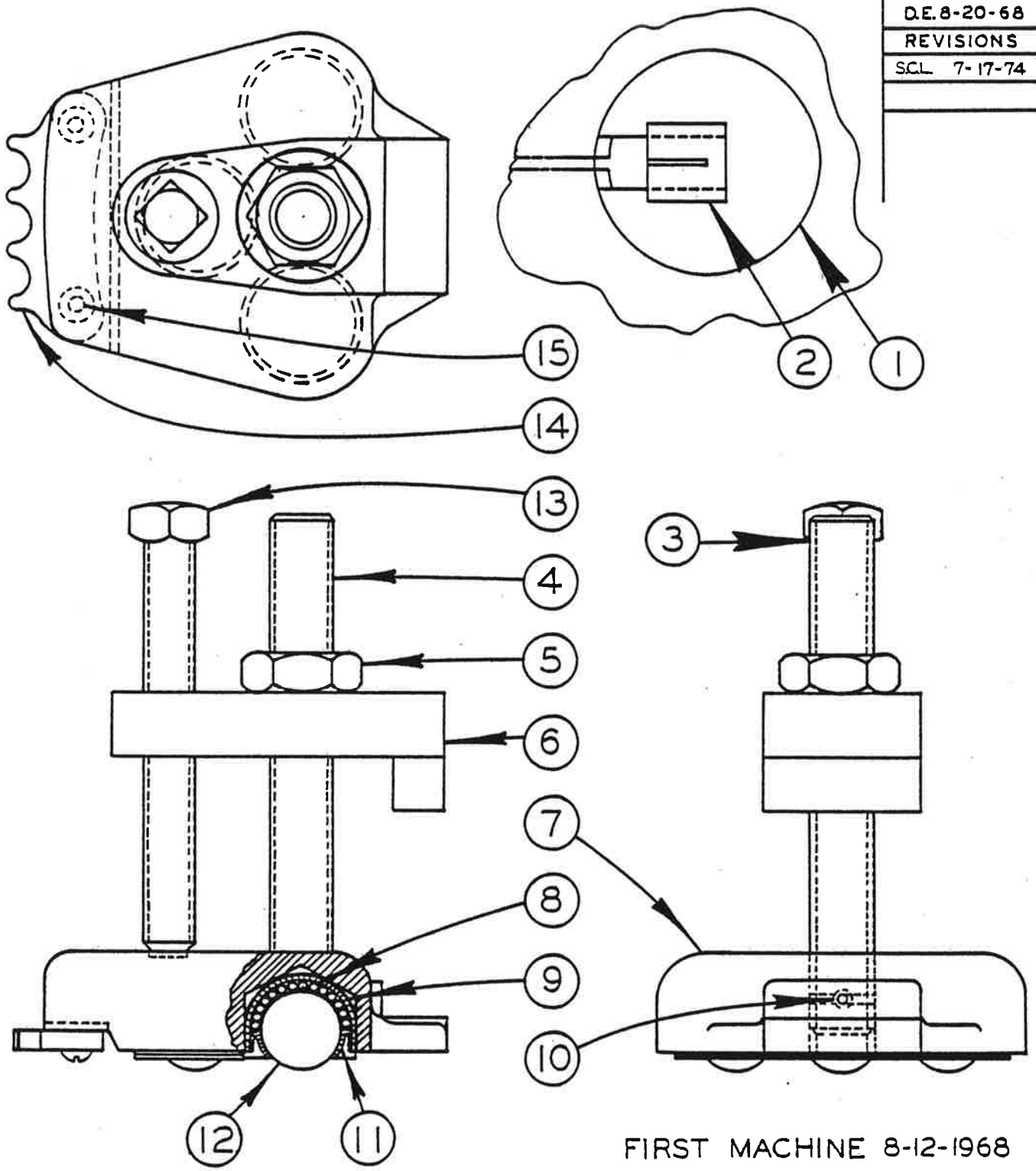
MODEL FIRST MACH. LAST MACH.
 3612-1H3 358-76101 358-78155

CM-5-64

MOTOR BASE ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	505091	Motor Base Assembly	
1	094-067923	. Base Plate Ass'y.	1
2	090-253170	. Pulley	1
3	091-984245	. Scr. Soc. Set 1/4-20NC x 3/8	1
4	090-020520	. Pulley	1
5	091-984377	. Scr. Soc. Set 5/16-18NC x 1/2	1
6	090-014010	. Male Connector	1
7	093-034189	. Orifice	1
8	114-035074	. Close Nipple	1
9	105-115174	. Reducer	1
10	091-087841	. Mounting Foot	1
11	091-980656	. Scr. Hex. Hd. Cap 1/2-13NC x 1	2
12	091-236521	. Relief Valve	1
13	135-011278	. Close Nipple	2
14	090-020280	. Cross	1
15	106-335185	. Pipe Plug	1
16	135-003002	. Reducer Bushing	1
17	090-061136	. Hydraulic Pump	1
18	091-992628	. Washer, Flat 5/16 Std.	8
19	091-993238	. Washer, Lock 5/16 Std.	7
20	091-991224	. Nut, Hex. 5/16-18NC	7
21	090-052101	. Spacer Block	1
22	091-980318	. Scr. Hex. Hd. Cap 5/16-18NC x 1-1/2	2
23	090-096801	. V-Belt	1
24	091-980482	. Scr. Hex. Hd. Cap 3/8-16NC x 1-1/2	4
25	091-993329	. Washer, Lock 3/8 Std.	4
26	091-991265	. Nut, Hex. 3/8-16NC	4
27	091-992644	. Washer 3/8 Std.	4
28	091-211631	. Plate Weld't. Ass'y.	1
29	091-980342	. Scr., Hex. Hd. Cap 5/16-18NC x 2-1/4	2
30	091-980292	. Scr., Hex. Hd. Cap 5/16-18NC x 1	2
31	091-211607	. Spacer	2
32	091-211615	. Spacer	1
33	094-019577	. Air Compressor (See Detail)	1
34	091-384461	. Oil (ASTM 465)	A. R.
35	135-008472	. Service Tee	1
36	091-180885	. Safety Valve	1
37	090-020041	. Barbed Insert	1
38	135-003408	. V-Belt	1
39	091-113548	. Elec. Motor 3 H.P. 1800/60 TEFC	1
40	114-003478	. 90° Street Elbow	1
41	090-096678	. Barbed Insert	1
42	135-009827	. Service Tee	1
43	090-149287	. Barbed Insert	2
44	105-115133	. 90° Street Elbow	1

NEW DRG.
D.E. 8-20-68
REVISIONS
SCL 7-17-74



FIRST MACHINE 8-12-1968

HEAVY
PARALLEL WORK CLAMP

C-10-38 CM-10-31 Z-10-17

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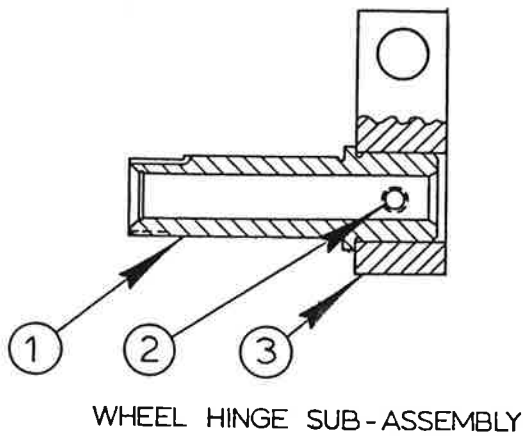
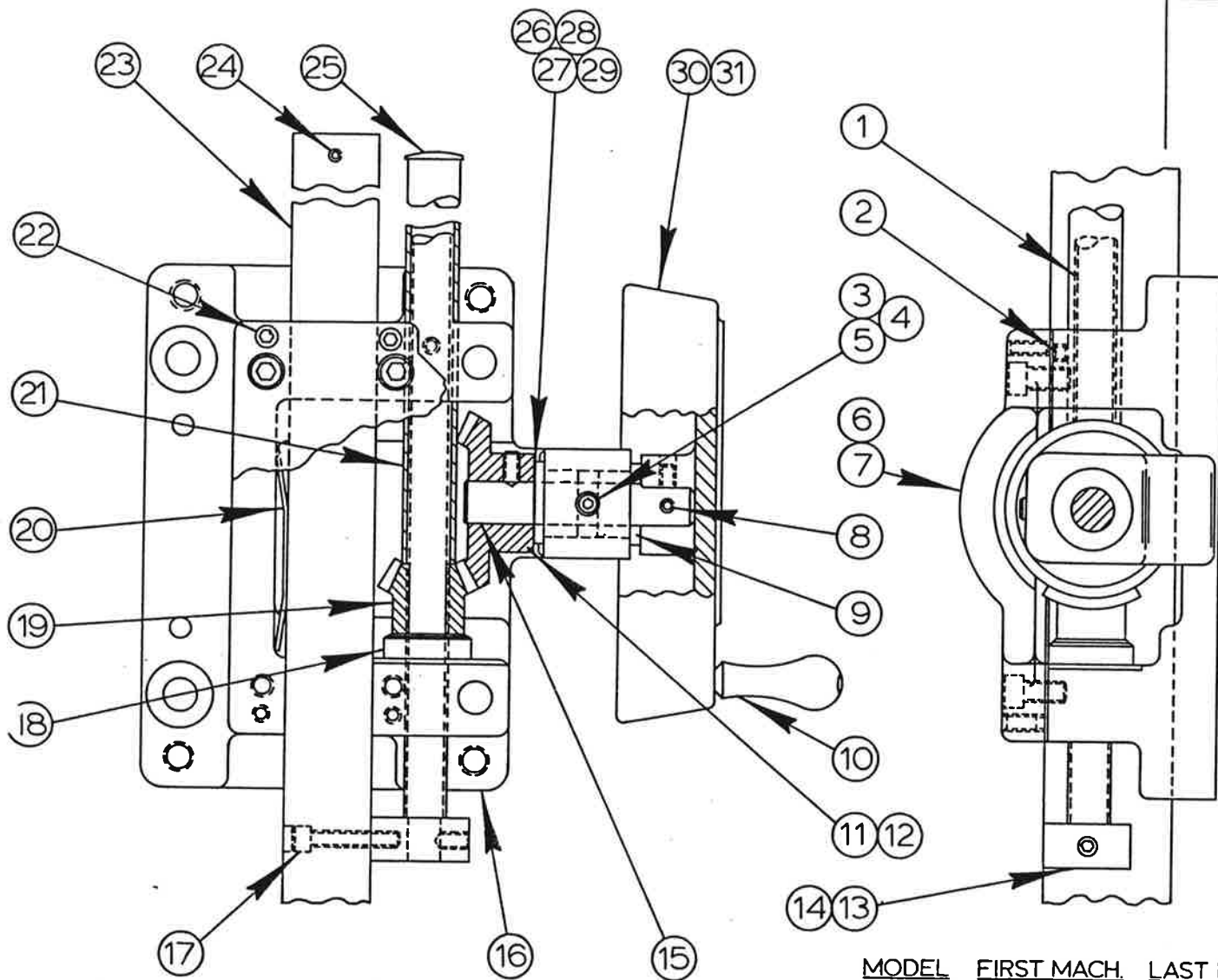
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CM-10-31

Z-10-17

HEAVY
PARALLEL WORK CLAMP ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
REF.	090-450099	Parallel Work Clamp Assembly	
1	090-279506	. Center Plate	1
2	106-244130	. Center Support	1
3	090-376294	. Parallel Work Clamp Sub-Assembly	4
4	106-244155	. . Clamp Stud	1
5	091-991356	. . Nut, Hex. 5/8-11NC	1
6	106-243074	. . Parallel Arm	1
7	090-376286	. . Clamp Body	1
8	106-245053	. . Steel Ball	195
9	106-243062	. . Ball Cup	3
10	091-984112	. . Screw, Soc. Set #10-24NC x 3/8	1
11	135-037976	. . Ball Retainer Ring	3
12	106-245046	. . Steel Ball	3
13	106-245087	. . Set Screw	1
14	105-133136	. . Work Holding Jaw Sprocket	1
15	091-986893	. . Screw, Rd. Hd. Mach. #10-24NC x 1/2	4

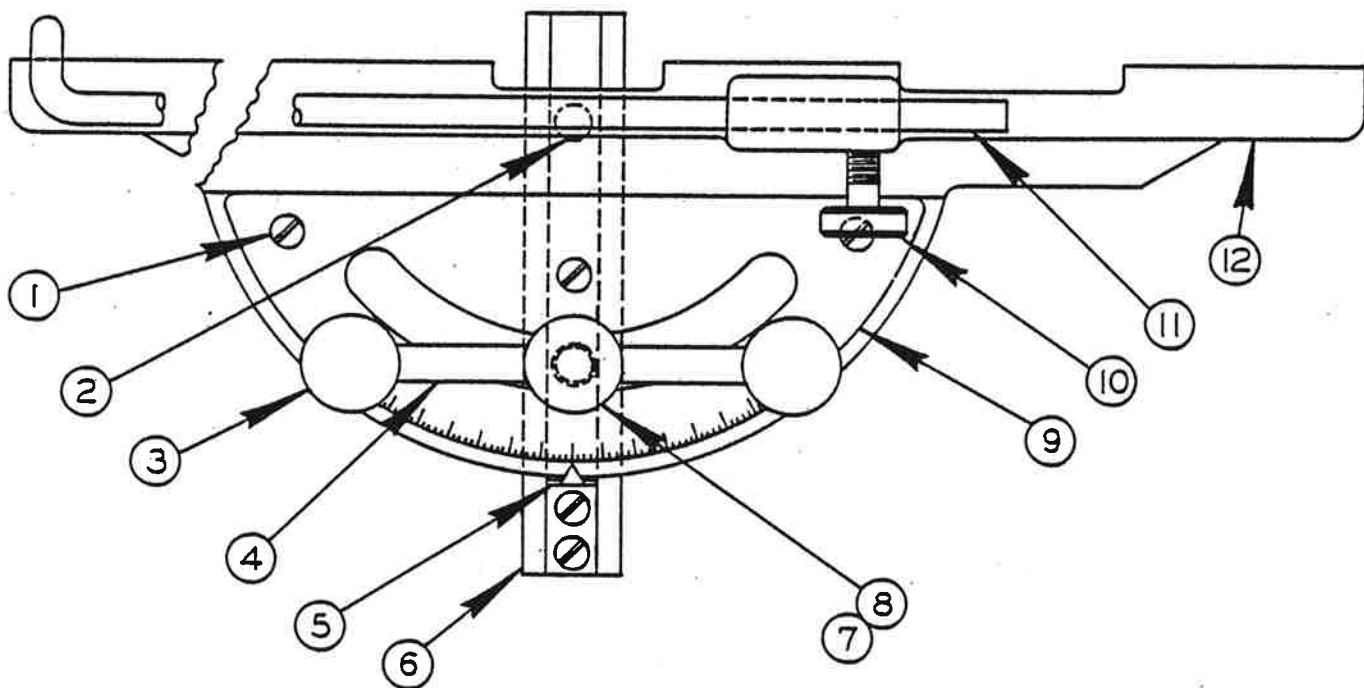


POST ELEVATING ASSEMBLY

MODEL	FIRST MACH.	LAST MACH.
1612	287-70269	287-76450
3612	291-70150	291-77235
1612-0	277-70830	277-751728
3613-0	278-70287	278-77825
1612-H	288-70310	288-75436
3612-H	272-70208	272-77373
3612-1	380-77101	380-78126
3613-10	381-77101	381-79276
3612-1H	382-77101	382-78130

POST ELEVATING ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	090-390550	Post Elevating Assembly (Standard)	
1	091-209247	. Screw.....	1
2	091-984096	. Screw, Soc. Set #10-24NC x 3/16.....	1
3	090-039710	. Spring.....	1
4	091-984229	. Screw, Soc. Set 1/4-20NC x 1/4.....	1
5	091-407650	. Friction Plug.....	1
6	090-386442	. Cover.....	1
7	091-982363	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2.....	4
8	090-042599	. Roll Pin.....	1
9	091-209221	. Bearing.....	2
10	091-046904	. Handle.....	1
11	090-144353	. Bevel Gear.....	1
12	091-564765	. Screw, Soc. Set #10-24NC x 3/8 (Self-Locking).....	1
13	091-209205	. Block.....	1
14	091-154278	. Screw, Soc. Set. #10-24NC x 1/4 (Self-Locking).....	1
15	091-209239	. Shaft.....	1
16	094-017688	. Housing.....	1
17	091-982256	. Screw, Soc. Hd. Cap #10-24NC x 1.....	2
18	135-028108	. Thrust Bearing.....	1
19	091-209254	. Gear.....	1
20	105-013064	. Spring.....	1
21	091-235804	. Tube.....	1
22	091-985903	. Screw, Soc. Set 1/4-20NC x 1/2 (Half Dog).....	4
23	090-391186	. Post.....	1
24	090-042250	. Roll Pin.....	1
25	091-235812	. Plug Button.....	1
26	091-333104	. Shim (.035).....	A.R.
27	091-333112	. Shim (.0149).....	A.R.
28	091-333120	. Shim (.005).....	A.R.
29	091-333138	. Shim (.003).....	A.R.
30	090-386434	. Handwheel.....	1
31	091-984104	. Screw, Soc. Set #10-24NC x 1/4.....	1
Ref.	093-023463	Wheel Hinge Sub-Assembly	
1	105-014245	. Axis Stud.....	1
2	091-984237	. Screw, Soc. Set. 1/4-20NC x 5/16.....	1
3	091-206243	. Block.....	1



PROTRACTOR WORK STOP
AND
ALIGNMENT GAGE ASSEMBLY

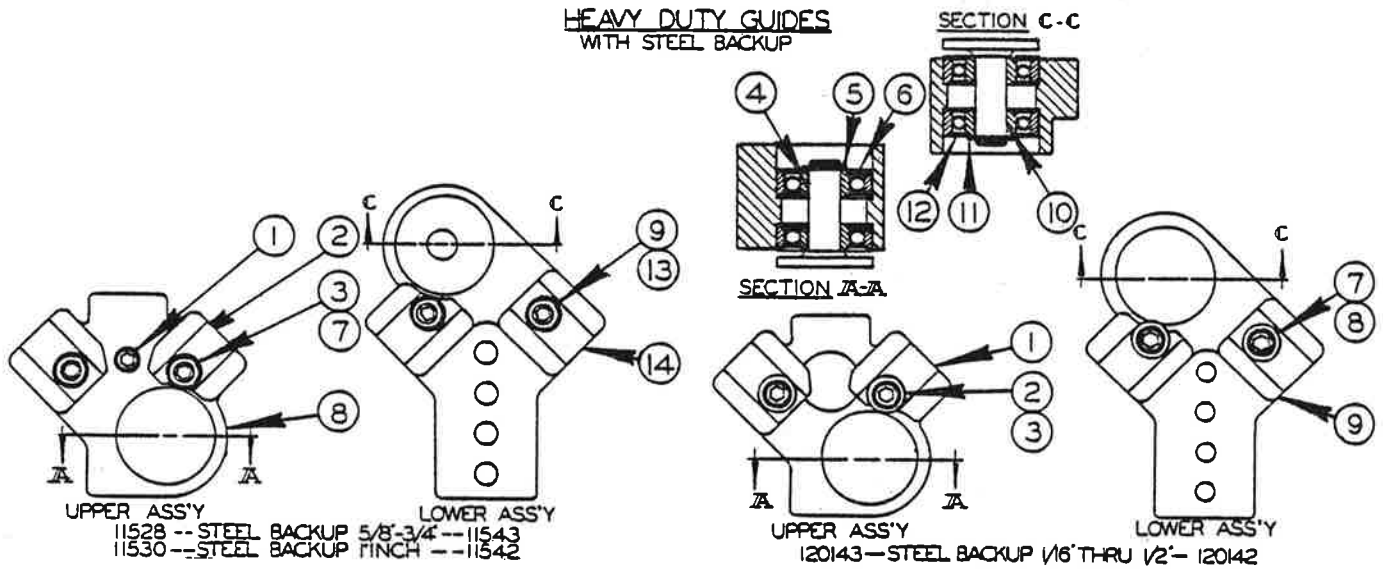
CODE NO. CM-10-7

PROTRACTOR WORK STOP & ALIGNMENT ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
REF.	090-514951	Protractor Work Stop & Alignment Assembly	
REF.	090-547589	Protractor Work Stop & Alignment Assembly	
1	091-988675	. Screw, Rd. Hd. Mach #10-24NC x 3/8	5
2	114-004732	. Dowel Pin	1
3	091-339713	. Knob	2
	*114-115183	. Knob	2
4	090-116344	. Shaft	1
5	090-116336	. Pointer	1
6	090-253022	. Tee Nut	1
	*090-291329	. Tee Nut	1
7	090-116351	. Stud	1
	*091-011189	. Stud	1
8	091-992651	. Washer, Plain 7/16 S.A.E. Std.	1
9	135-016145	. Protractor Plate	1
10	134-174010	. Thumb Screw	1
11	135-019768	. Gage Rod	1
12	090-514969	. Mitre Head	1

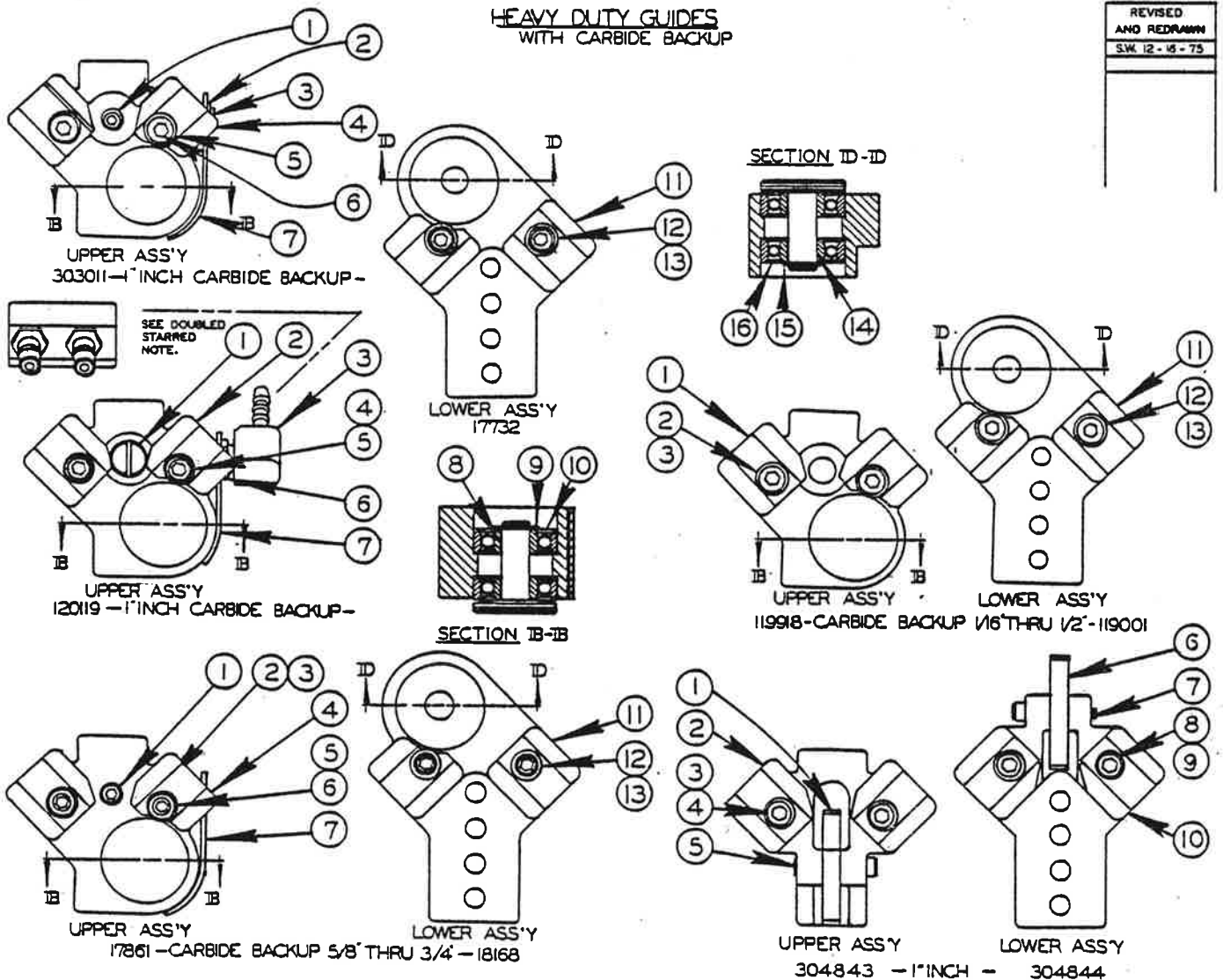
*NOTE: Starred Items Are Part Of Assembly #090-547589

**HEAVY DUTY GUIDES
WITH STEEL BACKUP**



**HEAVY DUTY GUIDES
WITH CARBIDE BACKUP**

REVISED AND REDRAWN S.W. 12-16-75



SAW GUIDE SELECTION

*121230

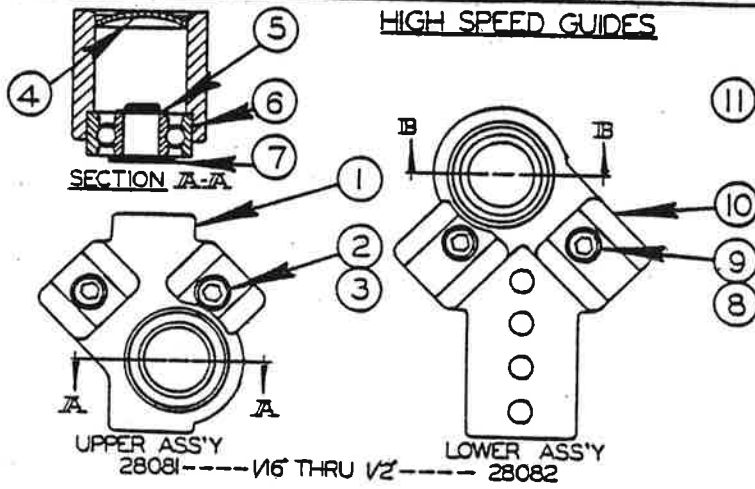
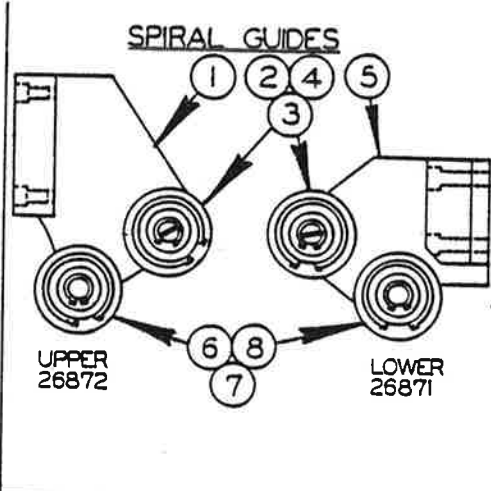
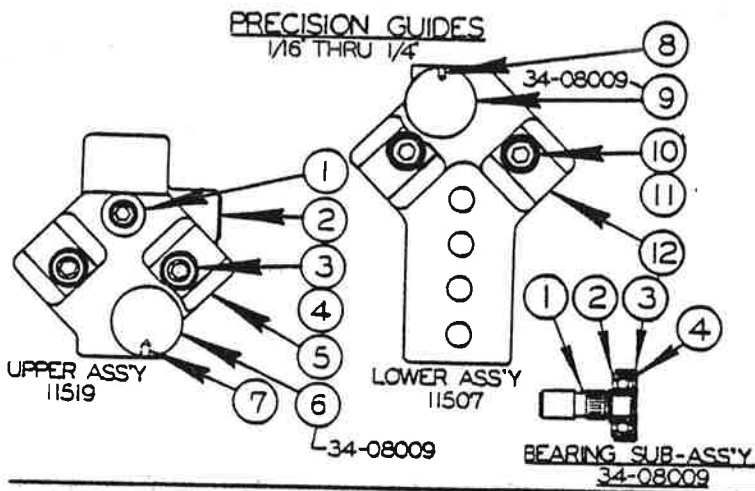
C-7-18 CM-7-23

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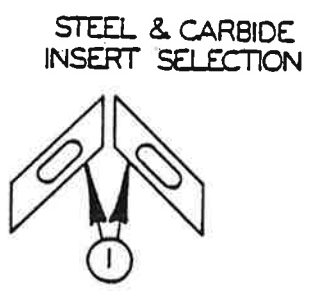
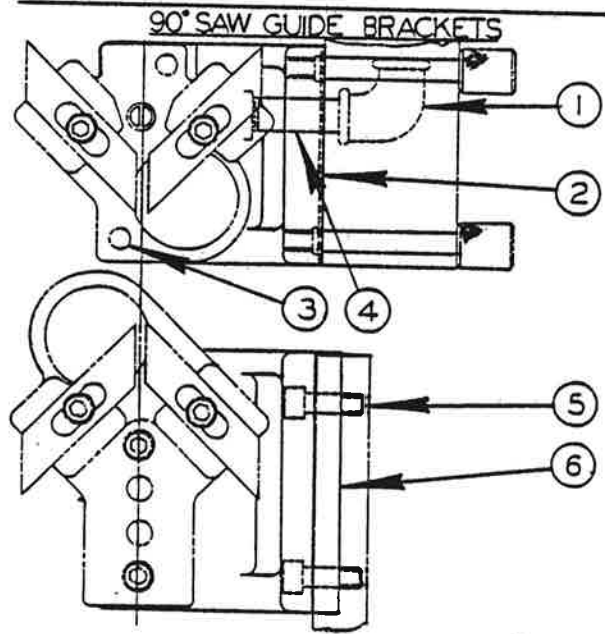
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 SAW GUIDE SELECTION

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
HEAVY DUTY GUIDES (STEEL BACKUP)							
Ref.	091-201434	Upper Saw Guide Ass'y. (1/16" to 1/2")		15	090-115411	. Retaining Ring	1
1	090-380767	. Upper Saw Guide Block	1	16	090-115296	. Bearing	2
2	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4		Ref.	090-178617	Upper Saw Guide Ass'y. (5/8" to 3/4")	
3	134-085026	. Washer	2	1	091-984450	. Screw, Soc. Hd. Set 5/16-24NF x 1/2	1
4	090-115403	. Bearing Cap	1	2	091-332023	. Pipe Plug	1
5	090-115411	. Retaining Ring	1	3	091-354415	. Locknut	1
6	090-115296	. Bearing	2	4	090-252529	. Upper Saw Guide Block	1
Ref.	091-201426	Lower Saw Guide Ass'y. (1/16" to 1/2")		5	091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1	2
7	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4		6	134-085026	. Washer	2
8	134-085026	. Washer	2	7	090-183377	. Guide Guard	1
9	090-377383	. Lower Saw Guide Block	1	8	090-172180	. Bearing Cap	1
10	090-115403	. Bearing Cap	1	9	090-115411	. Retaining Ring	1
11	090-115411	. Retaining Ring	1	10	090-115296	. Bearing	2
12	090-115296	. Bearing	2	Ref.	090-181686	Lower Saw Guide Ass'y. (5/8" to 3/4")	
Ref.	090-115288	Upper Saw Guide Ass'y. (5/8" to 3/4")		11	090-252586	. Lower Saw Guide Block	1
Ref.	090-115304	Upper Saw Guide Ass'y. (1")		12	091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1	2
1	091-984450	. Screw, Soc. Hd. Set 5/16-24NF x 1/2	1	13	134-085026	. Washer	2
2	091-203695	. Soc. Hd. Pipe Plug	1	14	090-172180	. Bearing Cap	1
3	091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1 (5/8" to 3/4")	2	15	090-115411	. Retaining Ring	1
	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4 (1")	2	16	090-115296	. Bearing	2
4	090-115403	. Bearing Cap	1	Ref.	093-030112	Upper Saw Guide Ass'y. (1")	
5	090-115411	. Retaining Ring	1	1	091-984450	. Screw, Soc. Set 5/16-24NF x 1/2"	1
6	090-115296	. Bearing	2	2	091-354415	. Locknut	1
7	134-085026	. Washer	2	3	091-332023	. Pipe Plug	1
8	090-252529	. Upper Saw Guide Block (5/8" to 3/4")	USE	4	090-252537	. Upper Saw Guide Block	1
	090-252537	. Upper Saw Guide Block (1")	ONE	5	134-085026	. Washer	2
Ref.	090-115437	Lower Saw Guide Ass'y. (5/8" to 3/4")		6	091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1	2
Ref.	090-115429	Lower Saw Guide Ass'y. (1")		7	090-183377	. Guide Guard	1
9	091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1 (5/8" to 3/4")	2	8	090-172180	. Bearing Cap	1
	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4 (1")	2	9	090-115411	. Retaining Ring	1
10	090-115403	. Bearing Cap	1	10	090-115296	. Bearing	2
11	090-115411	. Retaining Ring	1	Ref.	091-201194	Upper Saw Guide Ass'y. (1")	
12	090-115296	. Bearing	2	1	090-335092	. Coolant Nozzle	1
13	134-085026	. Washer	2	2	090-336314	. Upper Saw Guide Block	1
14	090-252586	. Lower Saw Guide Block (5/8" to 3/4")	USE	3	091-081166	. 90° Barbed Insert	1
	090-252578	. Lower Saw Guide Block (1")	ONE	4	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4	2
HEAVY DUTY GUIDES (CARBIDE BACKUP)							
Ref.	091-199182	Upper Saw Guide Ass'y. (1/16" to 1/2")		5	134-085026	. Washer	2
1	090-380767	. Upper Saw Guide Block	1	6	091-354415	. Locknut	1
2	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8	2	7	090-183377	. Guide Guard	1
3	134-085026	. Washer	2	8	090-172180	. Bearing Cap	1
8	090-172180	. Bearing Cap	1	9	090-115411	. Retaining Ring	1
9	090-115411	. Retaining Ring	1	10	090-115296	. Bearing	2
10	090-115296	. Bearing	2	Ref.	090-177320	Lower Saw Guide Block (1")	
Ref.	091-190017	Lower Saw Guide Ass'y. (1/16" to 1/2")		11	090-252578	. Lower Saw Guide Block	1
11	090-377383	. Lower Saw Guide Block	1	12	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4	2
12	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8	2	13	134-085026	. Washer	2
	134-085026	. Washer	2	14	090-172180	. Bearing Cap	1
13	134-085026	. Washer	2	15	090-115411	. Retaining Ring	1
14	090-172180	. Bearing Cap	1	16	090-115296	. Bearing	2
				Ref.	093-048437	. 1 Inch Upper Saw Guide Block Sub-Assembly	
				1	091-212100	. Back-Up Insert	1
				2	094-064300	. Upper Saw Guide Block	1
				3	091-982447	. Scr. Soc. Hd. Cap 1/4-20NC x 1-1/4	2
				4	134-085026	. Washer	2
				5	091-402040	. Pivot Bolt	1
				Ref.	093-048445	. 1 Inch Lower Saw Guide Block Sub-Assembly	
				6	091-212100	. Back-Up Insert	1
				7	091-402040	. Pivot Bolt	1
				8	091-982447	. Scr. Soc. Hd. Cap 1/4-20NC x 1-1/4	2
				9	134-085026	. Washer	2
				10	094-067683	. Lower Saw Guide Block	1

**NOTE: If Your Machine Was Equipped With Two Coolant Lines to the Upper Saw Guide, Order Additional Parts 091-094524 Swivel Joint, Qty. 1, 090-160011 Barbed Insert Qty. 2 and Delete 091-081166 90° Barbed Insert, Qty. 1.



REVISED AND REDRAWN 5W 12 - 17 - 75



INSERT GAGE

.025	-34-08320
.032	-13-08303
.035	-13-08307

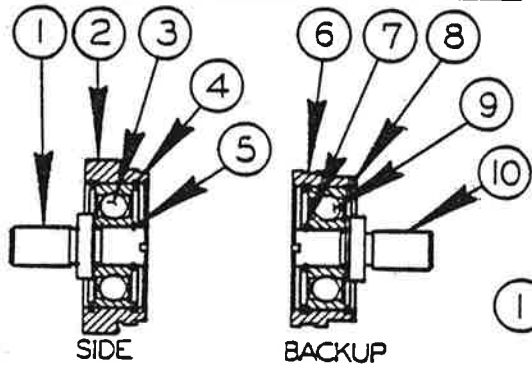
* 44804
ACCESSORY

SAW GUIDE SELECTION
*121230

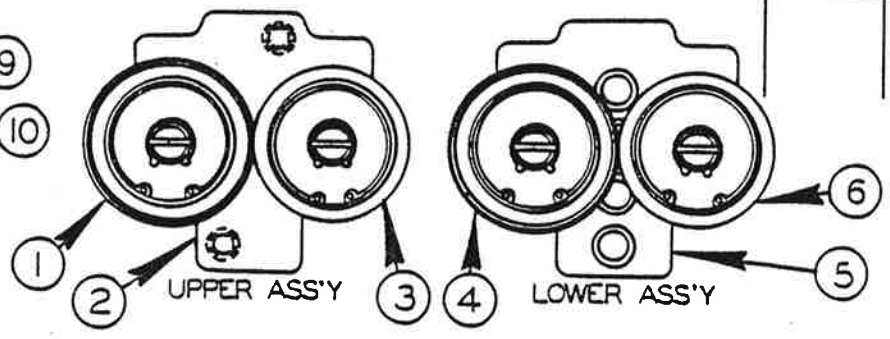
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 SAW GUIDE SELECTION

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.	
PRECISION GUIDES				
Ref.	090-115197	Upper Saw Guide Assembly (1/16" to 1/4")		
1	091-984450	. Screw, Soc. Set 5/16-24NF x 1/2	1	
2	091-203695	. Soc. Hd. Pipe Plug	1	
3	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8	2	
4	134-085026	. Washer	2	
5	090-252495	. Upper Saw Guide Block	1	
6	134-080092	. Bearing Sub-Assembly (See Detail)	1	
7	091-985010	. Screw, Soc. Set #8-32NC x 1/4	1	
Ref.	090-115072	Lower Saw Guide Assembly (1/16" to 1/4")		
8	091-985010	. Screw, Soc. Set #8-32NC x 1/4	1	
9	134-080092	. Bearing Sub-Assembly (See Detail)	1	
10	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8	2	
11	134-085026	. Washer	2	
12	090-252479	. Lower, Saw Guide Block	1	
Ref.	134-080092	Bearing Sub-Assembly		
1	134-084185	. Shaft	1	
2	135-090439	. Bearing	1	
3	134-083096	. Roller Seal	1	
4	134-083120	. Washer	1	
SPIRAL GUIDES				
1	090-268723	Spiral Saw Guide Assembly (Upper)		
2	135-069532	. Eccentric Guide	1	
3	NA Alone	. Tire Only	1	
4	NA Alone	. Rim Only	1	
5	090-268715	Spiral Saw Guide Assembly (Lower)		
6	135-069524	. Plain Guide	1	
7	NA Alone	. Tire Only	1	
8	NA Alone	. Rim Only	1	
HIGH SPEED GUIDES				
Ref.	090-280819	Upper Saw Guide Assembly (1/16" to 1/2")		
1	090-279811	. Upper Saw Guide Block	1	
2	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8	2	
3	134-085026	. Washer	2	
4	091-373399	. Plug	1	
5	090-115411	. Retaining Ring	1	
6	135-022804	. Bearing	1	
7	090-184151	. Bearing Cap	1	
Ref.	090-282827	Lower Saw Guide Assembly (1/16" to 1/2")		
8	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8	2	
9	134-085026	. Washer	2	
10	090-279837	. Lower Saw Guide Block	1	
11	091-373399	. Plug	1	
12	090-184151	. Bearing Cap	1	
13	135-022804	. Ball Bearing	1	
14	090-115411	. Retaining Ring	1	
90° SAW GUIDE BRACKETS				
Ref.	090-448044	90° Saw Guide Assembly		
1	135-036473	. 90° Elbow	1	
2	090-275975	. Upper Angle Block	1	
3	091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1	2	
4	090-116583	. Nipple	1	
5	091-982397	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4	2	
6	090-275966	. Lower Angle Block	1	
	090-292616	. Center Plate 24 x 24 Table (Not Shown)	USE	
	093-021780	. Center Plate 30 x 30 Table (Not Shown)	ONE	
STEEL AND CARBIDE INSERT SELECTION				
1	Ref.	Steel Insert (4 Req'd)	Ref.	Carbide Insert (4 Req'd)
	090-044991	1/16"	090-161688	1/4"
	090-044983	3/32"	090-161704	3/8"
	090-044975	1/8"	090-132911	1/2"
	090-044967	3/16"	091-058941	5/8"
	090-044959	1/4"	090-132929	3/4"
	090-039603	3/8"	090-089822	1"
	090-039595	1/2"		
	090-039587	5/8"		
	090-039579	3/4"		
	090-039561	1"		

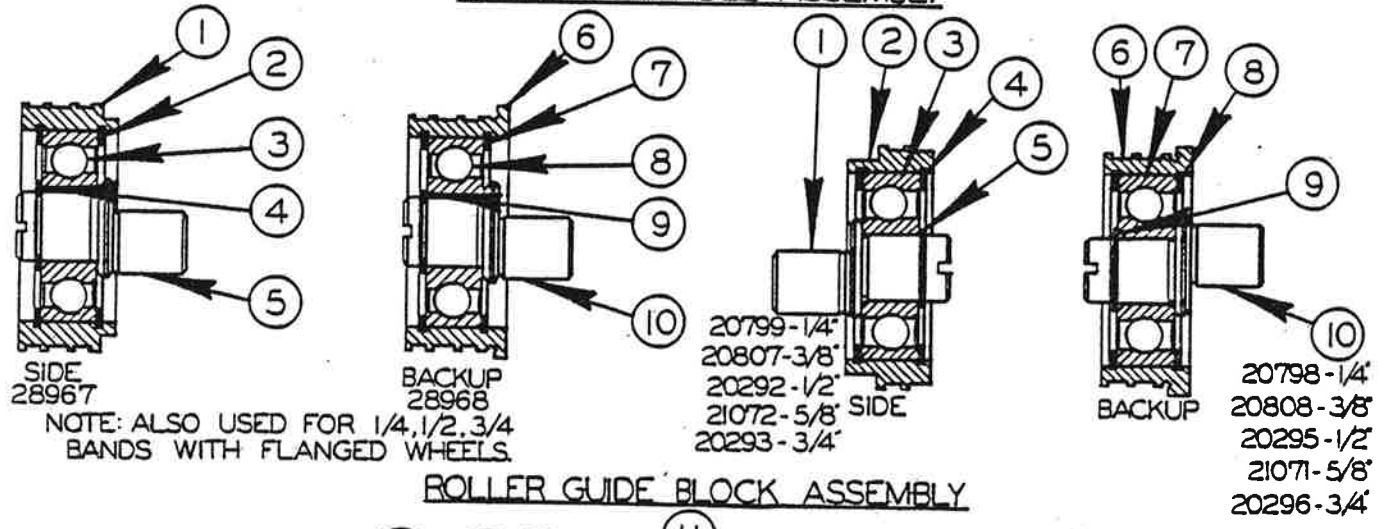
TYPE I
ROLLER & SPINDLE ASSEMBLY



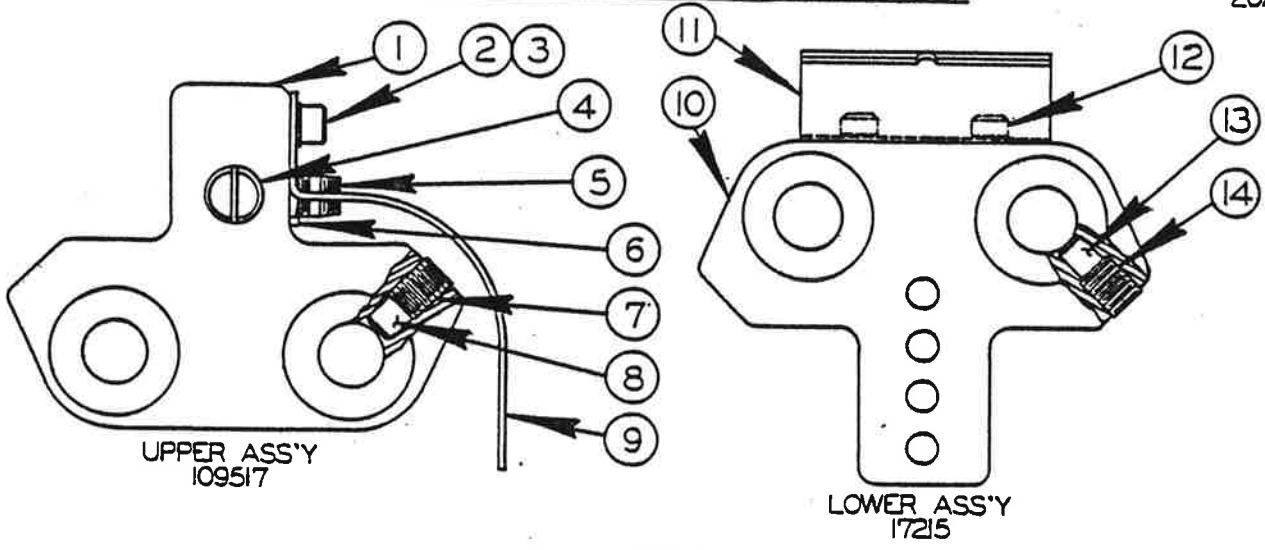
TYPE IA
ROLLER SAW GUIDES W/ROLLERS



TYPE II
ROLLER & SPINDLE ASSEMBLY



ROLLER GUIDE BLOCK ASSEMBLY

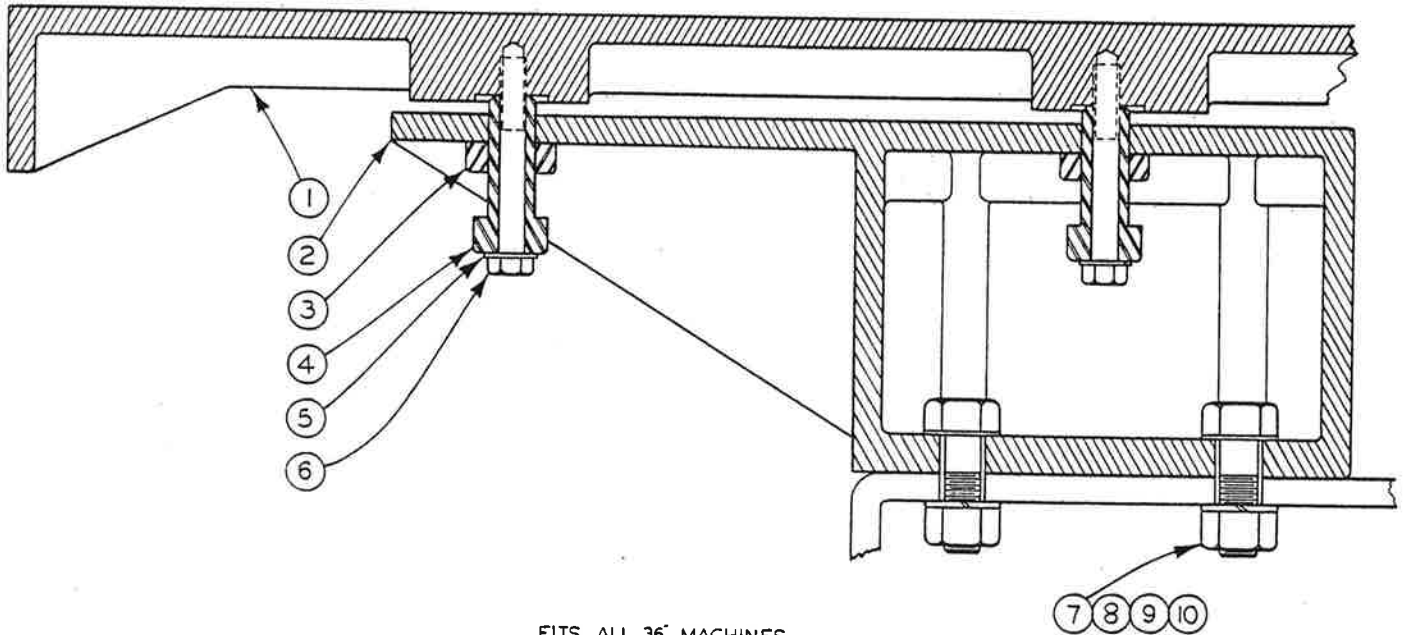


121230
SAW GUIDE SELECTION

CODE NO. C-7-19
CM-7-27

SAW GUIDE SELECTION

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y	INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
TYPE I - ROLLER AND SPINDLE ASSEMBLY							
REF.	090-289844	Roller Sub-Assembly 1/4" Side		REF.	090-289687	Backup Roller Guide Assembly	
REF.	090-289802	Roller Sub-Assembly 3/8" Side		6	091-007583	. Guide Roller 1"	1
REF.	090-289745	Roller Sub-Assembly 1/2" Side		7	090-013038	. Retaining Ring	2
1	090-182965	. Bearing Shaft	1	8	090-017799	. Bearing	1
2	090-289851	. Roller 1/4"	Use	9	090-015686	. Retaining Ring	1
	090-289810	. Roller 3/8"		10	090-135302	. Spindle	1
	090-289752	. Roller 1/2"	One	Ref.	090-207994	Guide Roller Ass'y 1/4" Side	
3	090-115296	. Bearing (N.D. Z99500XR1E) ...	1	Ref.	090-208075	Guide Roller Ass'y 3/8" Side	
4	091-000463	. Internal Ring	2	Ref.	090-202920	Guide Roller Ass'y 1/2" Side	
5	090-115411	. Snap Ring	1	Ref.	090-210725	Guide Roller Ass'y 5/8" Side	
REF.	090-289828	Flanged Roller Sub-Assembly 1/4" Backup		Ref.	090-202938	Guide Roller Ass'y 3/4" Side	
REF.	090-289786	Flanged Roller Sub-Assembly 3/8" Backup		1	090-135302	. Spindle	1
REF.	090-289760	Flanged Roller Sub-Assembly 1/2" Backup		2	090-135310	. Guide Roller 1/4"	Use
	090-289836	. Flanged Roller 1/4"	Use		090-135401	. Guide Roller 3/8"	
	090-289794	. Flanged Roller 3/8"			090-135336	. Guide Roller 1/2"	
	090-289778	. Flanged Roller 1/2"			090-135427	. Guide Roller 5/8"	
6	090-115411	. Snap Ring	One		090-135351	. Guide Roller 3/4"	One
7	091-000463	. Internal Ring	1	3	090-017799	. Bearing	1
8	090-115296	. Bearing (N.D. Z99500XR1E) ...	2	4	090-013038	. Retaining Ring	2
9	090-182965	. Bearing Shaft	1	5	090-015686	. Retaining Ring	1
10				Ref.	090-207986	Backup Roller Guide Ass'y 1/4"	
TYPE IA - ROLLER SAW GUIDES WITH ROLLERS							
REF.	090-292566	Upper Roller Saw Guide Assembly 1/4"		Ref.	090-208083	Backup Roller Guide Ass'y 3/8"	
REF.	090-292582	Upper Roller Saw Guide Assembly 3/8"		Ref.	090-202953	Backup Roller Guide Ass'y 1/2"	
REF.	090-295064	Upper Roller Saw Guide Assembly 1/2"		Ref.	090-210717	Backup Roller Guide Ass'y 5/8"	
1	Ref.	Select flanged backup roller sub-ass'y from type 1 detail and parts list.		Ref.	090-202961	Backup Roller Guide Ass'y 3/4"	
2	090-289604	. Upper Saw Guide Block	1	6	090-135328	. Backup Roller 1/4"	Use
3	Ref.	Select side roller sub-ass'y from type 1 detail and parts list.			090-135419	. Backup Roller 3/8"	
	091-982397	. Scr., Soc. Hd. Cap 1/4-20NC x 3/4 (Not Shown)	2		090-135344	. Backup Roller 1/2"	
	091-993212	. Washer, Lock 1/4 Std. (Not Shown)	2	7	090-135435	. Backup Roller 5/8"	
REF.	090-292574	Lower Roller Saw Guide Ass'y 1/4"		8	090-017799	. Backup Roller 3/4"	One
REF.	090-292590	Lower Roller Saw Guide Ass'y 3/8"		9	090-013038	. Bearing	1
REF.	090-295056	Lower Roller Saw Guide Ass'y 1/2"		10	090-015686	. Retaining Ring	2
4	Ref.	Select flanged backup roller sub-ass'y from type 1 detail and parts list.			090-015686	. Retaining Ring	1
5	090-289612	. Lower Saw Guide Block	1		090-135302	. Spindle	1
6	Ref.	Select side roller sub-ass'y from type 1 detail and parts list.		Ref.	091-095174	Roller Guide Block Assembly	
	091-982397	. Scr., Soc. Hd. Cap 1/4-20NC x 3/4 (Not Shown)	2	1	090-335175	Upper Guide Sub-Assembly	
	091-993212	. Washer, Lock 1/4 Std.	2	2	091-982363	. Upper Guide Block	1
TYPE II - ROLLER AND SPINDLE ASSEMBLY							
REF.	090-289679	Side Roller Guide Assembly		3	091-993212	. Scr., Soc. Hd. Cap 1/4-20NC x 1/2	1
1	091-007583	. Guide Roller 1"	1	4	. Washer, Lock 1/4 Std.	1	
2	090-013038	. Retaining Ring	2	5	090-335092	. Coolant Nozzle	1
3	090-017799	. Bearing	1	6	114-145287	. Close Nipple	1
4	090-015686	. Retaining Ring	1	7	107-0151045	. Hex. Pipe Nipple	1
5	090-135302	. Spindle	1	8	091-984484	. Scr., Soc. Hd. Set 3/8-16NC x 3/8	2
				9	090-017419	. Plug	2
					090-336363	. Coolant Guard	1
				Ref.	090-172156	. Cloth Bag (Not Shown)	1
				10	090-277435	Lower Guide Sub-Assembly	
				11	090-021403	. Lower Guide Block	1
				12	091-982355	. Chip Deflector	1
						. Scr., Soc. Hd. Cap 1/4-20NC x 3/8	2
				13	090-017419	. Plug	2
				14	091-984492	. Scr., Soc. Hd. Set 3/8-16NC x 1/2	2

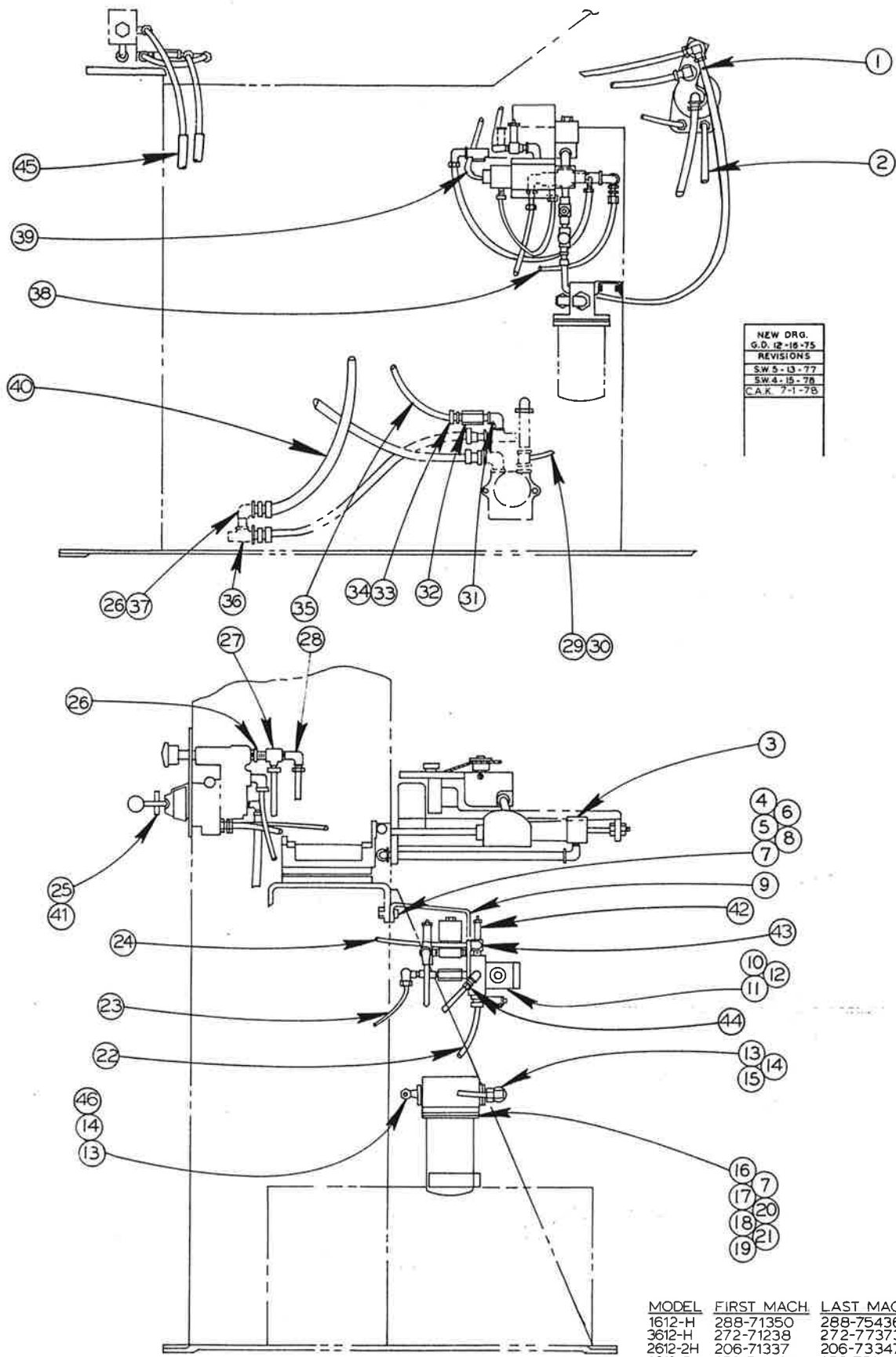


FITS ALL 36" MACHINES
 *50369

SECONDARY TABLE MOUNTING ASSY.

SECONDARY TABLE ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	50369	Secondary Table Assembly	
Ref.	48046	Secondary Table Assembly (3612-3)	
Ref.	503536	Secondary Table Assembly (3612-1H3)	
1	111-031068	. Secondary Table	1
2	090-208273	. Secondary Table Support (Use on Ass'y. #50369)	USE
	090-480450	. Secondary Table Support (Use on Ass'y. #48046 & 503536)	ONE
3	091-991364	. Nut, Jam 5/8-11NC	4
4	111-034047	. Secondary Table Support Stud	4
5	091-995589	. Washer, Lock 3/8" Shakeproof Int.	4
6	091-980532	. Screw, Hex. Hd. Cap 3/8-16NC x 2-3/4	4
7	091-980672	. Screw, Hex. Hd. Cap 1/2-13NC x 1-1/2	4
8	091-993048	. Washer, Wrought 1/2" Std.	4
9	091-991315	. Nut, Hex. 1/2-13NC	4
10	091-993279	. Washer, Lock 1/2" Std.	4
	090-086885	. Cover Plate Assembly (Not Shown) (Ass'y. #503536) ..	1

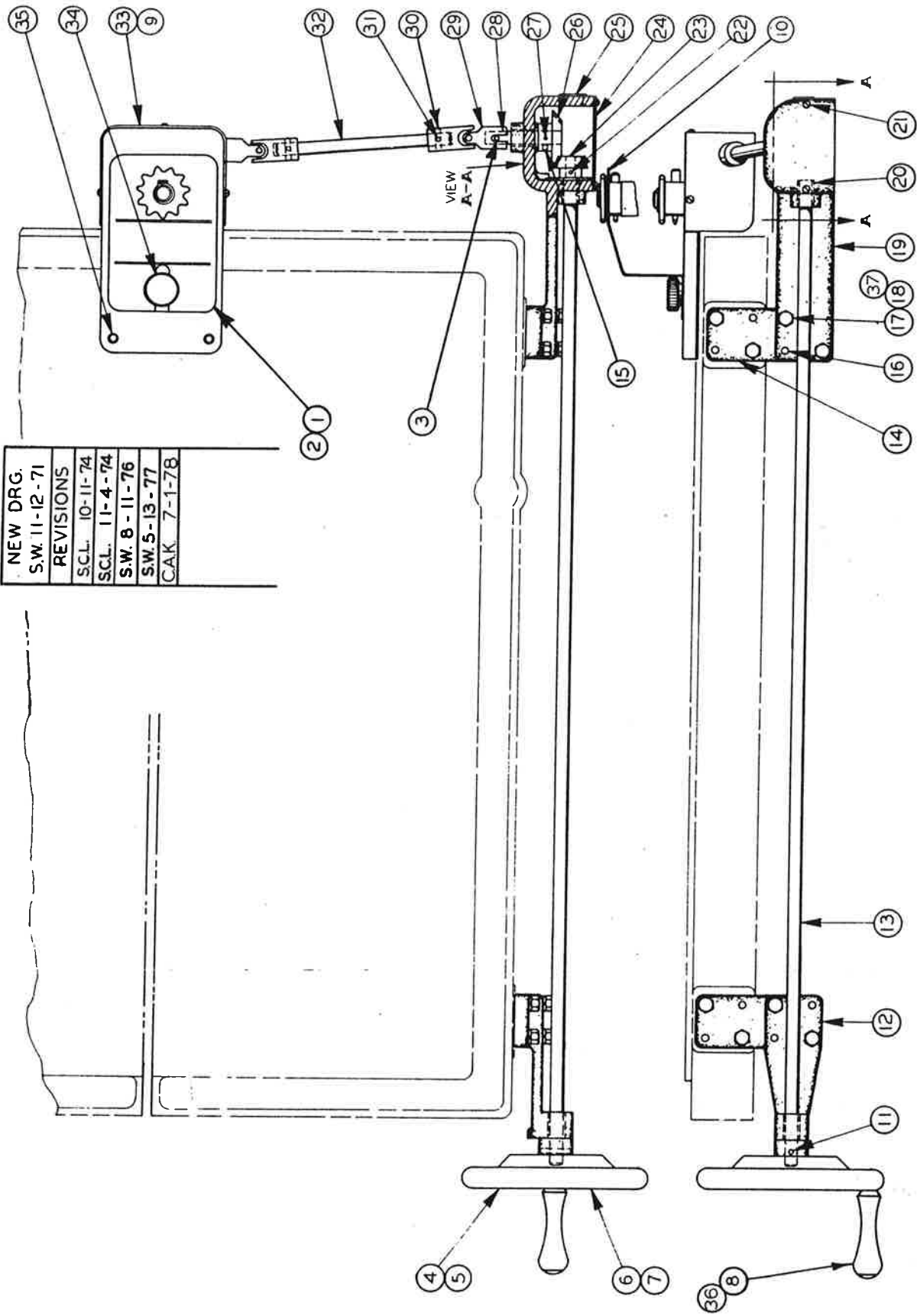


SERVO CONTOUR FEED ATTACH.

MODEL	FIRST MACH	LAST MACH
1612-H	288-71350	288-75436
3612-H	272-71238	272-77373
2612-2H	206-71337	206-73347
1612-3	152-711085	152-751144
3612-3	153-721144	153-761249
2613-3	198-71392	198-76433
6013-3	199-72130	199-75138
2612-H	284-71170	284-76223
3612-1H3	358-76101	358-78165

3612-1H 382-77101 382-78130

NEW DRG.
S.W. 11-12-71
REVISIONS
SCL. 10-11-74
SCL. 11-4-74
S.W. 8-11-76
S.W. 5-13-77
CAK 7-1-78



MODEL	FIRST MACH	LAST MACH
1612-H	298-71350	288-75436
3612-H	272-71238	272-77373
2612-2H	206-71337	206-73347
1612-3	152-711085	152-751144
3612-3	153-721144	153-761249
2613-3	198-71392	198-76433
6013-3	199-72130	199-75138
2612-H	284-71170	284-76223
3612-IH3	358-76101	358-78155
3612-IH	382-77101	382-78130

SERVO CONTOUR FEED ATTACHMENT

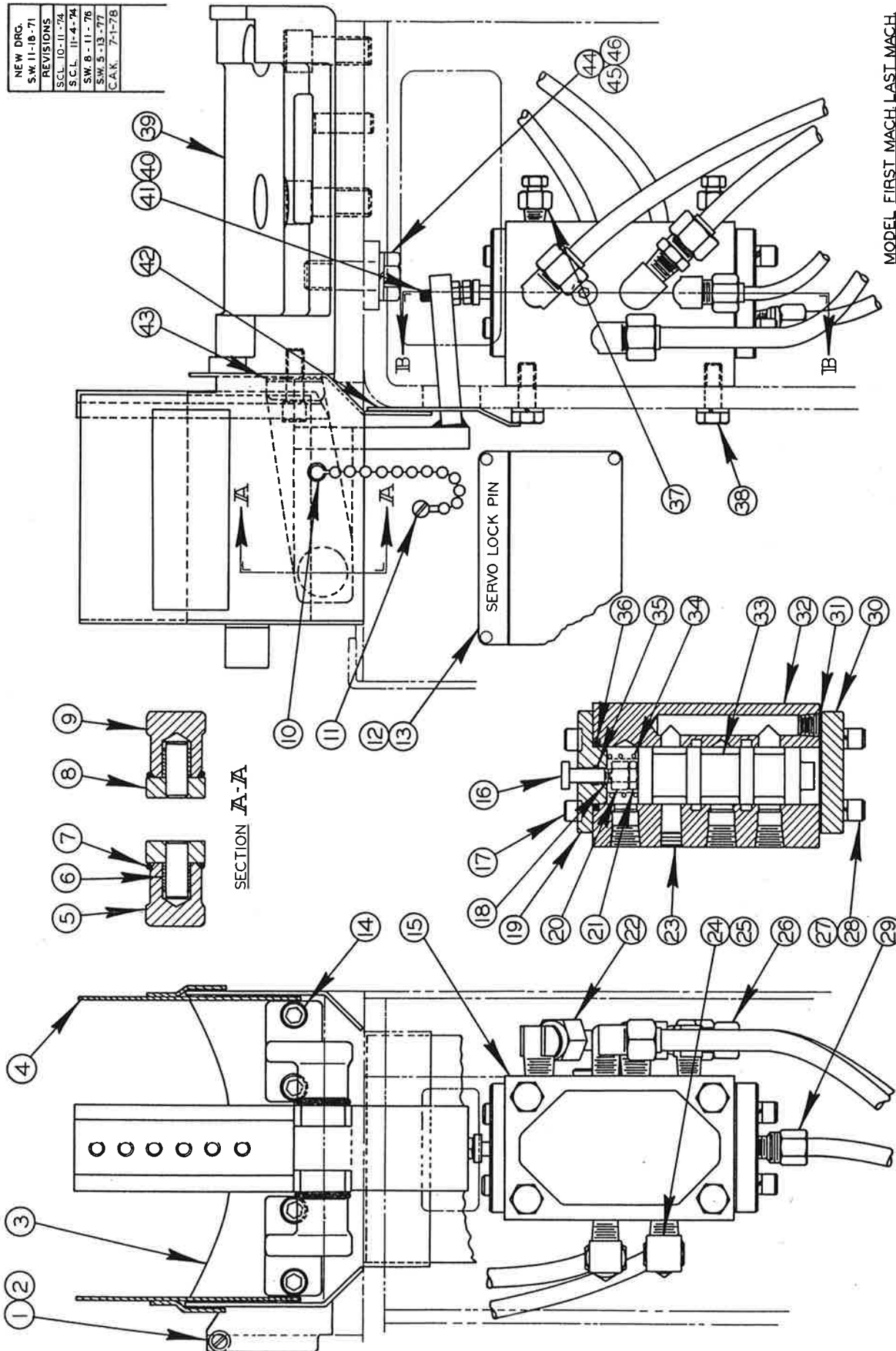
CM-3-73

PRINTED IN USA

SERVO-CONTOUR FEED ATTACHMENT

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	501039	Servo-Contour Feed Attachment (1612-H)	
Ref.	501794	Servo-Contour Feed Attachment (2612-H)	
Ref.	501038	Servo-Contour Feed Attachment (3612-H,3612-1H3,3612-1H,3612-2H,3612-2H3)	
Ref.	501109	Servo-Contour Feed Attachment (2612-2H)	
Ref.	501040	Servo-Contour Feed Attachment (1612-3)	
Ref.	501179	Servo-Contour Feed Attachment (2613-3,6013-H3)	
Ref.	503601	Servo-Contour Feed Attachment (3612-3)	
Ref.	504152	Servo-Contour Feed Attachment (6013-3,6013-H3)	
1	090-499260	. Shaft Extension Assembly	1
2	135-050136	. Chain Assembly	1
3	090-042441	. Roll Pin	1
4	090-486440	. Servo Handwheel Sub-Assembly	1
5	090-486432	. . Servo Handwheel	1
6	091-114280	. . Name Plate	1
7	091-993972	. . Screw, Drive #2 x 1/4 Type "U"	2
8	091-181164	. . Handle	1
9	091-086215	. Shim (2613-3,6013-3,6013-H3)	1
10	090-499138	. Chain Guide	1
11	090-042615	. Roll Pin	1
12	090-202052	. Bracket	1
13	091-086223	. Shaft (1612-H,3612-H,1612-3,3612-3,2612-2H,2612-H,3612-1H3,3612-2H,3612-2H3)	Use
	091-086173	. Shaft (2613-3,6013-3,6013-H3)	One
14	091-086231	. Adapter (1612-H,3612-H,1612-3,3612-3,2612-2H,3612-2H3,2612-H,3612-1H3,3612-1H,3612-2H)	Use
	091-080140	. Adapter (2613-3,6013-3,6013-H3)	Two
15	091-984104	. Screw, Soc. Set #10-24NC x 1/4	2
16	114-115185	. Dowel Pin (2612-2H)	8
	091-338756	. Dowel Pin (1612-H,3612-H,1612-3,2613-3,3612-3,6013-3,3612-1H3,3612-1H,3612-2H,3612-2H3,6013-H3,2612-H)	A.R.
17	091-980300	. Screw, Hex. Hd. Cap 5/16-18NC x 1 1/4	A.R.
18	091-993238	. Washer, Lock 5/16"Std.	8
19	090-202045	. Gear Box	1
20	135-006476	. Bearing	3
21	091-988386	. Screw, Rd. Hd. Mach. #6-32NC x 1/4	2
22	090-042433	. Roll Pin	1
23	090-144346	. Gear	1
24	090-016965	. Cover	1
25	090-033259	. Plug Button	1
26	090-144353	. Gear	1
27	090-042607	. Roll Pin	1
28	091-095257	. Shaft	1
29	091-095547	. Universal Joint	1
30	090-042573	. Roll Pin	2
31	091-984229	. Screw, Soc. Set 1/4-20NC x 1/4	2
32	091-087601	. Shaft (1612-H,3612-H,1612-3,3612-3,2612-2H,3612-1H3,3612-1H,3612-2H,3612-2H3)	Use
	091-180935	. Shaft (2612-H)	
	091-086181	. Shaft (2613-3,6013-3,6013-H3)	One
33	090-479312	. Contour Attachment Sub-Assembly (See Detail)	1
34	091-087288	. Thumb Screw	1
35	114-004732	. Dowel Pin (2613-3,6013-3,6013-H3)	2
	090-107269	. Dowel Pin (1612-H,3612-H,2612-2H,1612-3,3612-3,2612-H,3612-1H3,3612-1H,3612-2H,3612-2H3)	2
36	091-181172	. . Pin	1
37	091-980318	. Screw, Hex. Hd. Cap 5/16-18NC x 1 1/2 (Ass'y #501179, 504152)	4
Following Items Not Shown:			
	091-086017	. Plug Button	1
	091-092205	. Bracket	4
	090-105016	. Spacer	1
	091-991414	. Nut, Hex. 3/4-16NF	1
	090-108531	. Wrench	1

NEW DRG.
S.W. 11-18-71
REVISIONS
SCL 10-11-74
SCL 11-4-74
S.W. 9-11-76
S.W. 3-13-77
CAK 7-1-78



MODEL	FIRST MACH	LAST MACH
1612-H	288-71350	288-75436
3612-H	272-71238	272-77373
2612-2H	206-71337	206-73347
1612-3	152-71085	152-751144
3612-3	153-721144	153-761249
2613-3	198-71392	198-76433
6013-3	199-72130	199-75138
2612-H	284-71170	284-76223
3612-1H3	358-76101	358-78155
3612-1H	382-77101	382-78130

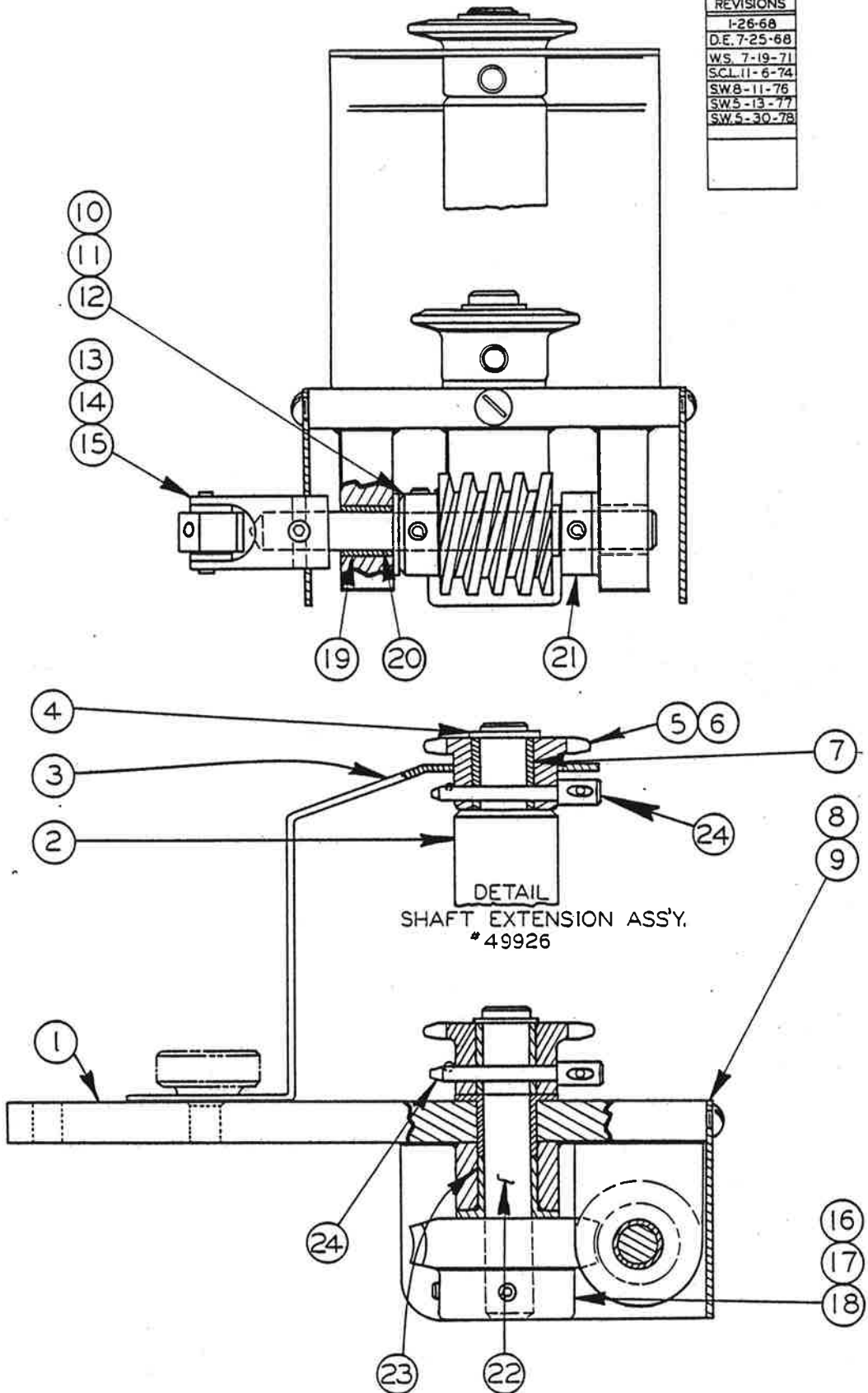
SERVO CONTOUR FEED ATTACHMENT

SERVO-CONTOUR FEED ATTACHMENT

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	501039	Servo-Contour Feed Attachment(1612-H)	
Ref.	501794	Servo-Contour Feed Attachment(2612-H)	
Ref.	501038	Servo-Contour Feed Attachment(3612-H,3612-1H,3612-1H3,3612-2H,3612-2H3)	
Ref.	501109	Servo-Contour Feed Attachment(2612-2H)	
Ref.	501040	Servo-Contour Feed Attachment(1612-3)	
Ref.	501179	Servo-Contour Feed Attachment(2613-3,6013-H3)	
Ref.	503601	Servo-Contour Feed Attachment(3612-3)	
Ref.	504152	Servo-Contour Feed Attachment(6013-3,6013-H3)	
1	091-988410	. Screw,Rd. Hd. Mach. #6-32NC x 1/2	1
2	091-092874	. Spacer	1
3	094-027976	. Guard	1
	094-028230	. Guard(2612-H, 2612-2H)	1
	094-029071	. Chip Guard Weldment (2613-3, 6013-3, 6013-H3)	1
4	094-027984	. Chip Guard Assembly(1612-H,3612-H,1612-3,3612-3,3612-1H3,3612-1H,3612-2H,3612-2H3)	1
	094-028222	. Chip Guard Assembly(2612-2H,2612-H)	1
5	093-000438	. L.H. Pivot Bracket	1
6	091-235705	. Sleeve Bearing	2
7	090-065053	. "O"-Ring	2
8	090-399643	. Bellcrank Assembly(1612-H,3612-H,1612-3,3612-3,3612-1H3,3612-1H,3612-2H,3612-2H3)	1
	093-000727	. Bellcrank Assembly(2612-2H,2612-H)	1
	093-001709	. Bellcrank Assembly (2613-3,6013-3,6013-H3)	1
9	093-000420	. R.H. Pivot Bracket	1
10	091-235937	. Pin Weldment	1
11	091-988543	. Screw, Rd. Hd. Mach. #8-32NC x 1/2	1
	090-014036	. 90° Male Elbow	2
12	091-236026	. Escutcheon	1
13	091-993998	. Screw, Drive #4 x 1/4" Type "U"	4
14	091-982603	. Screw, Soc.Hd. Cap 5/16-18NC x 1	4
15	094-027547	. Servo-Valve Sub-Assembly	1
16	091-068874	. Plunger	1
17	091-983494	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2	4
18	090-073511	. Bearing	1
19	091-068742	. End Cap	1
20	091-110973	. Hex. Nut	1
21	091-991208	. Nut, Hex. Jam 1/4-28NF	1
22	091-071084	. 90° Male Elbow	3
23	091-203695	. Socket Pipe Plug	2
24	091-050534	. Street Elbow	2
25	090-014010	. Male Connector	2
26	090-014077	. 90° Male Elbow	1
27	091-982397	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4	4
28	091-993212	. Washer, Lock 1/4" Std.	4
29	090-099359	. Male Connector	1
30	091-092841	. End Cap	1
31	091-081042	. Gasket	1
*32	090-479304	. Valve Body	1
*33	090-329376	. Spool	1
34	091-101717	. Spring	1
35	090-015124	. "O"-Ring	1
36	135-095214	. "O"-Ring	1
37	091-000398	. Drain Valve	2
38	091-980276	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4	4
39	094-027562	. Cradle	1
	090-488701	. Cradle Support(2613-3,6013-3,6013-H3)	1
40	091-980086	. Screw, Hex. Hd. Cap 1/4-20NC x 3/4	1
41	091-991141	. Nut, Hex. Jam 1/4-20NC	1
42	091-277392	. Gasket	1
43	091-283861	. Shim 1/32 Thk.	A.R.
	091-283879	. Shim .010 Thk.	A.R.
	091-283887	. Shim .007 Thk.	A.R.
	091-283895	. Shim .003 Thk.	A.R.
	091-283903	. Shim (2612-2H)	A.R.
	091-327650	. Shim Option List	1
44	091-993279	. Washer, Lock 1/2" Std.	1
45	091-230516	. Washer	1
46	091-980664	. Screw, Hex. Hd. Cap 1/2-13NC x 1 1/4"	1

*NOTE: When Replacing Valve Body or Valve Spool, order Complete Servo-Valve Sub-Assembly #094-027547.

REVISIONS
1-26-68
D.E. 7-25-68
WS 7-19-71
SCL 11-6-74
SWB-11-76
SW5-13-77
SW5-30-78



CONTOUR FEED ATTACHMENT

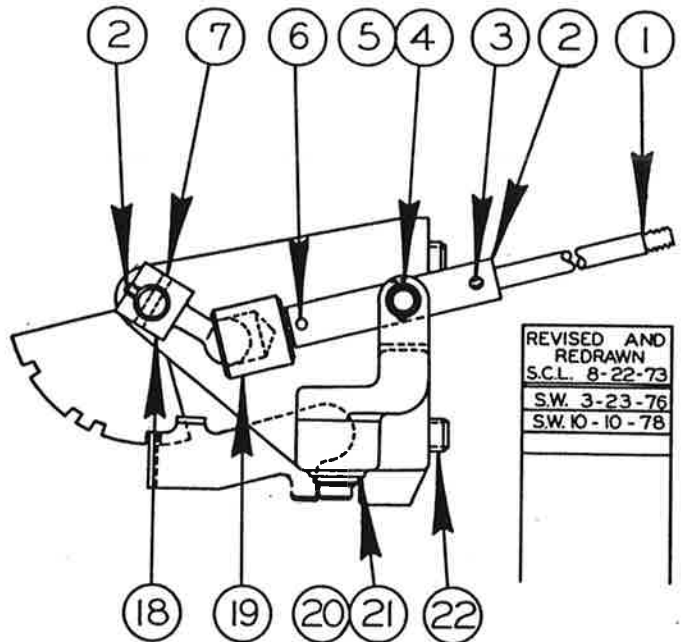
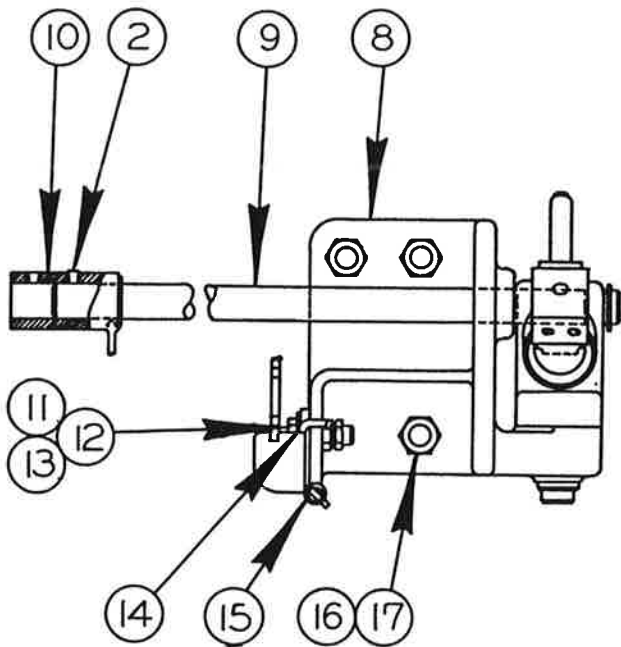
C-3-76 CM-3-72

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CONTOUR FEED ATTACHMENT

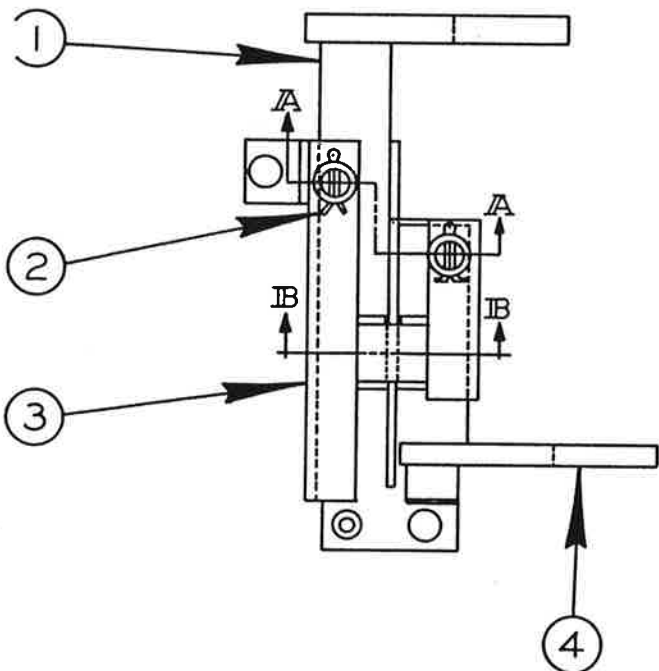
INDEX NO. Ref.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
	47931	Contour Attachment Sub-Assembly	
1	090-333295	. Bracket Weldment	1
*2	090-362385	. Sprocket Shaft Extension	1
*3	090-499187	. Chain Guide	1
4	135-064269	. Snap Ring	1
5	091-085357	. Sprocket Assembly	1
6	091-085332	. . Sprocket	1
7	091-085340	. . Bearing	1
8	090-333055	. Guard	1
9	091-990150	. Scr. Truss Hd. Mach. #10-24NC x 3/8	3
10	091-085274	. Worm	1
11	091-083923	. Bearing	2
12	090-042599	. Roll Pin	2
13	134-055243	. Universal Joint	1
14	090-042573	. Roll Pin	1
15	091-984229	. Scr. Soc. Hd. Set 1/4-20NC x 1/4	3
16	091-085266	. Worm Gear	1
17	090-042631	. Roll Pin	1
18	091-984245	. Scr. Soc. Hd. Set 1/4-20NC x 3/8	1
19	091-081463	. Bearing	2
20	091-087577	. Shaft	1
21	134-054105	. Collar	1
22	091-087296	. Axle	1
23	091-007955	. Oilite Bearing	2
24	091-085365	. Pin	1

*NOTE: Items 2 and 3 are used only on Shaft Extension Assembly #090-499260.

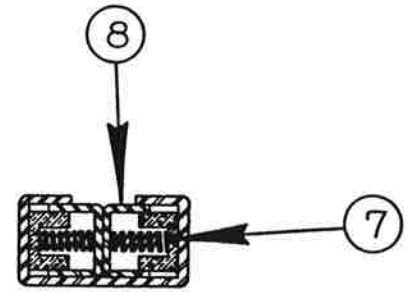


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S.C.L. 8-22-73
S.W. 3-23-76
S.W. 10-10-78

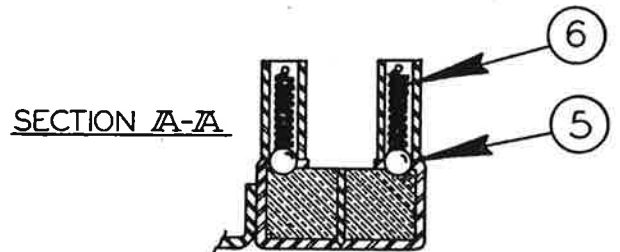
GEAR SHIFT ASSEMBLY



SHIFTER
ASSEMBLY



SECTION B-B



SECTION A-A

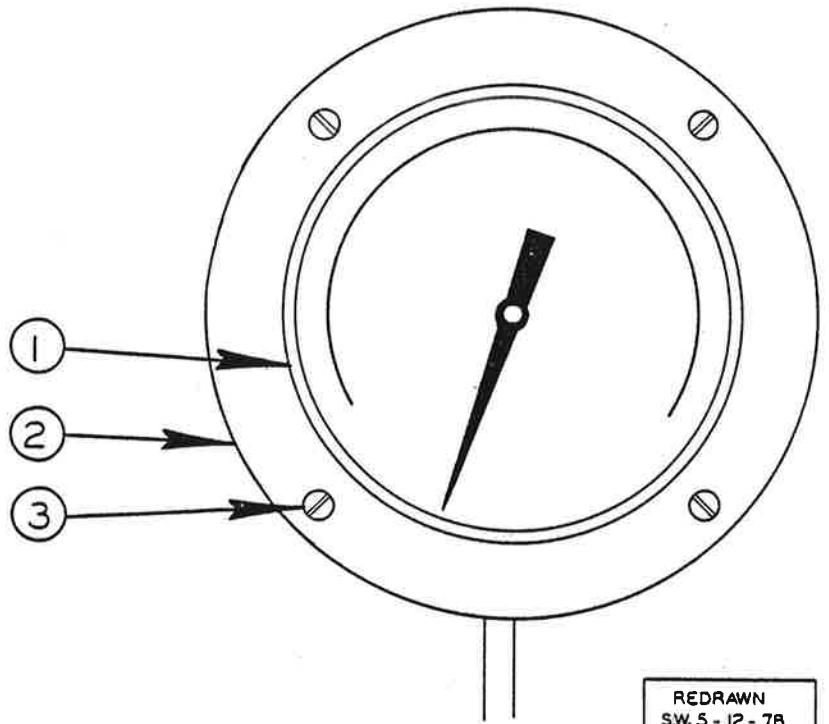
MODEL	FIRST MACH.	LAST MACH.
2612-1H	240-65101	240-68145
2612-H	284-68101	284-76223
2612-H	269-68101	269-68102
2613-2	127-60139	127-72297
6013-2	129-60105	129-70118
3612-1H3	358-76101	358-78145
2612-2H	206-62101	206-73347
1612-3	152-59101	152-751144
3612-3	153-59101	153-761249
1613-2	150-59101	150-75655
3613-2	151-59101	151-756083
2012-1H3	354-76101	354-78156

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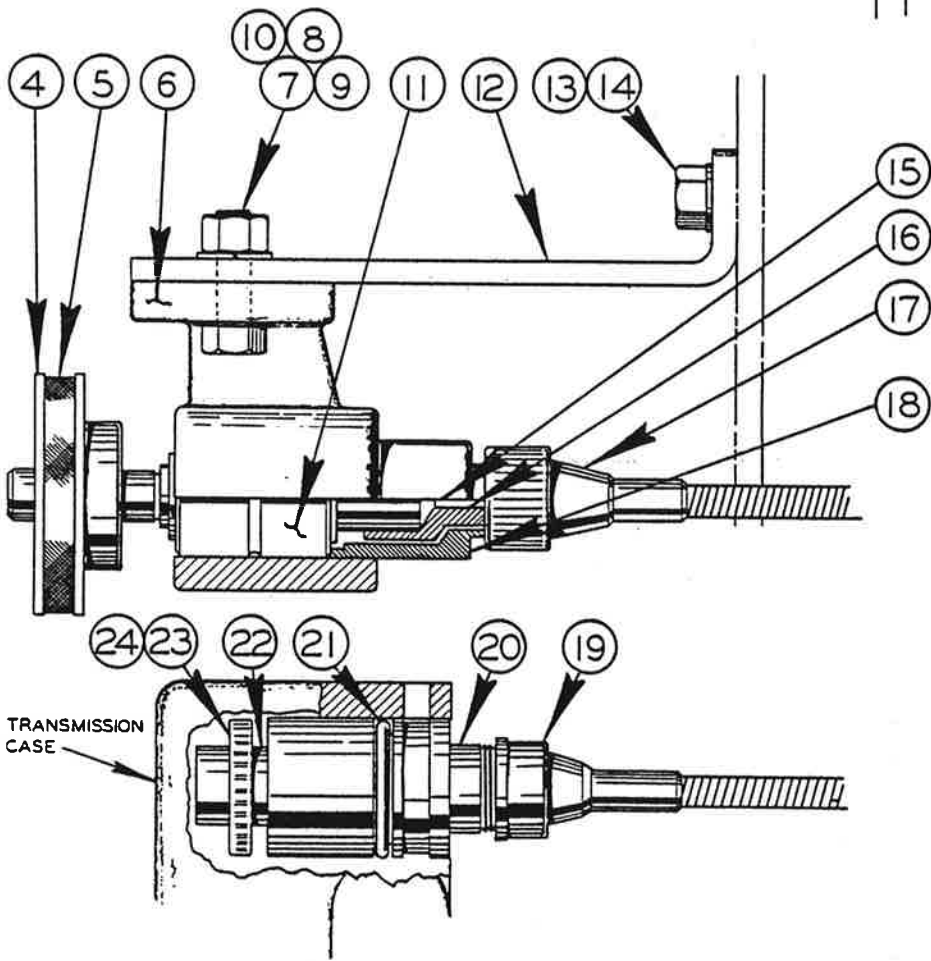
C-4-39 CM-4-12

GEAR SHIFT & SHIFTER ASSEMBLIES

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	090-236449	Gear Shift Sub-Assembly (3613-2, 3612-3, 1613-2, 3612-1H3)	
Ref.	090-278540	Gear Shift Sub-Assembly (6013-2)	
Ref.	090-410804	Gear Shift Sub-Assembly (1612-3)	
Ref.	090-449075	Gear Shift Sub-Assembly (2613-2, 2612-2H)	
1	090-039256	. Shifter Rod	1
2	090-052168	. Pivot Arm	1
3	091-984229	. Scr. Soc. Hd. Set 1/4-20NC x 1/4	3
4	090-040767	. Pin	1
5	135-096139	. Retaining Ring	2
6	090-042557	. Roll Pin	1
7	090-042599	. Roll Pin	2
8	090-410796	. Bracket	1
9	090-085267	. Shaft (3613-2, 3612-3, 3612-1H3, 1613-2)	USE
	090-052218	. Shaft (2613-2, 2612-2H, 1613-3)	
	090-172974	. Shaft (6013-2)	ONE
10	090-216516	. Shift Lock Selector Sub-Assembly	1
11	091-981001	. Scr. Hex. Hd. Cap 5/16-18NC x 1	1
12	091-991232	. Nut, Hex. Jam 5/16-18NC	2
13	091-993014	. Washer, Flat 5/16	1
14	090-219502	. Lock Lever	1
15	090-052176	. Spring	1
16	135-078152	. Adjustable Screw	3
17	091-993055	. Nut, Hex. Jam 5/8-18NF	3
18	090-052200	. Ball Crank	1
19	135-087013	. Socket	1
20	135-064269	. Retaining Ring	1
21	090-052226	. Washer	1
22	090-210287	. Swivel Block Sub-Assembly	1
Ref.	090-402801	Shifter Assembly	
1	090-204280	. Shifter Rod Assembly	1
2	091-995118	. Cotter Pin	2
3	090-203886	. Shifter Rod Cage	1
4	090-204272	. Shifter Rod	1
5	105-035026	. Steel Ball	2
6	090-023292	. Spring	2
7	090-110008	. Spring	2
8	090-025883	. Latch	2



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REVISIONS



SPEED INDICATOR ASSEMBLY

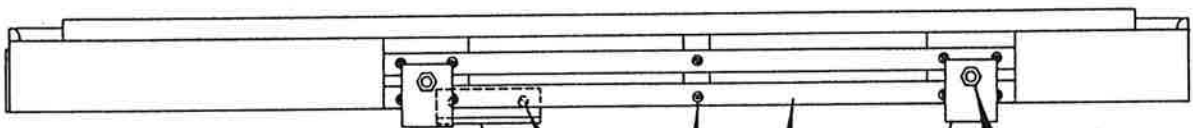
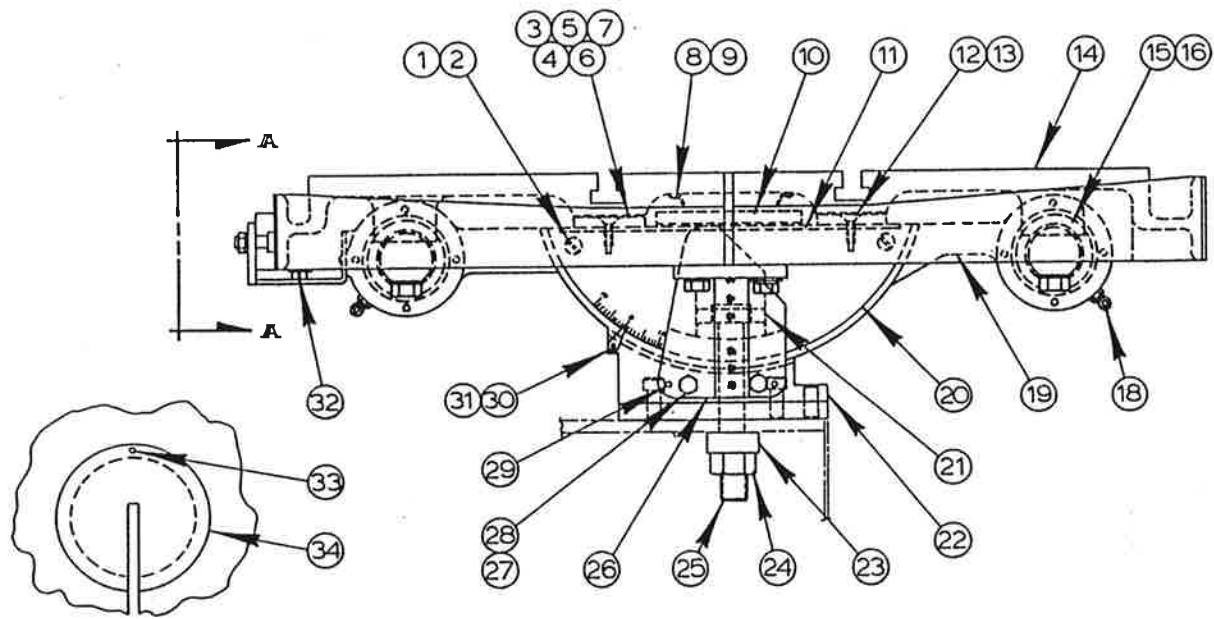
C-5-105 CM-5-53

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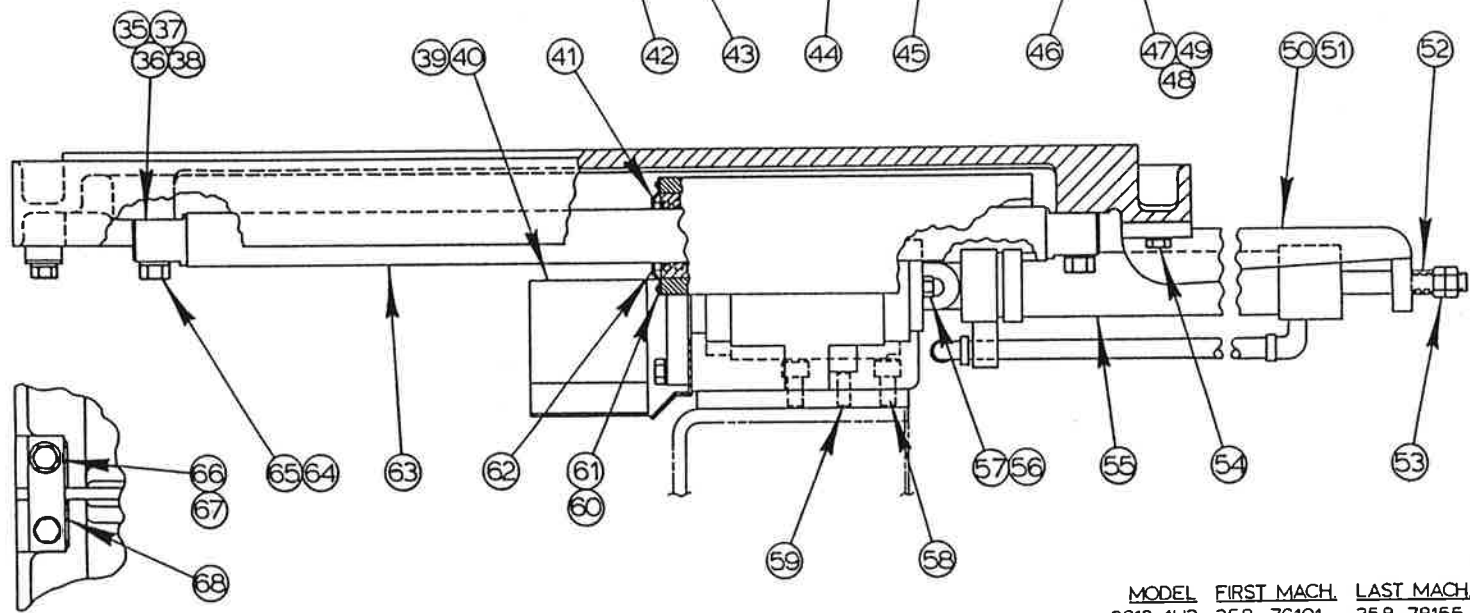
SPEED INDICATOR ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.		Speed Indicator Assembly	
1	090-275199	. Speed Indicator Head (3 Speed Trans.)(2613-2, 6013-2, 2612-1H, 2612-2H, 2612-H, 2613-1H, 2612-1H3, 2614-1)	
	090-447897	. Speed Indicator Head (1Speed Trans.)(2613-2, 6013-2)	
	090-454257	. Speed Indicator Head (1612-1, 3613-1, 1612-0, 3613-0, 1611-H, 1612-H, 3612-H, 3613-10, 3612-1H)	
	090-210956	. Speed Indicator Head (1612-3, 3612-3, 1613-2, 3613-2, 3612-1H3)	
	090-419680	. Speed Indicator Head (2613-3, 6013-3, 6013-H3)	
	090-448770	. Speed Indicator Head (Used on all 6013-3 Before Ser.#199-70130)	
	090-449646	. Speed Indicator Head (2612-1)	
2	090-174780	. Speed Indicator Bezel(1612-0,3613-0,1612-1,3613-1,1613-2,3613-2,2612-1,2613-2,2614-1,3613-10,6013-2,1612-3,3612-3,1611-H,1612-H,3612-H,2612-H,2612-2H,2613-1H,2612-1H3,3612-1H3,3612-1H,6013-3,6013-H3)	1
	106-054026	. Speed Indicator Bezel(2613-3,2612-1H,(used with #090-448770 on old 6013-3))	1
3	091-988717	. Screw, Rd. Hd. Mach. #10-24NC x 5/8	4
4	106-055056	. Pulley	1
	091-984377	. Screw, Soc. Set 5/16-18NC x 1/2	1
5	135-076321	. Belt (1612-1, 1612-0)	1
	090-072778	. Belt (1611-H, 1612-H)	1
	111-055083	. Belt (3613-1,3613-0,3613-10,3612-H,3612-1H)	1
6	134-051085	. Bracket	1
7	091-980300	. Screw, Hex. Hd. Cap 5/16-18NC x 1 1/4	2
8	091-991224	. Nut, Hex. 5/16-18NC	2
9	091-993238	. Washer, Lock 5/16" Std.	1
10	091-993014	. Washer 5/16" Std.	2
11	106-054067	. Shaft & Bearing	1
12	090-374885	. Bracket	1
13	091-980441	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	2
14	091-993329	. Washer, Lock 3/8 Std.	2
15	090-078320	. Cable Key	1
16	106-054042	. Bearing Coupling	1
17	134-055086	. Speed Indicator Cable (1612-1)	1
	090-102104	. Speed Indicator Cable (3613-1,1613-2,3613-2,3612-3,3612-1H3)	1
	091-186932	. Speed Indicator Cable (1612-0,3613-0,1611-H,1612-H,3612-H)	1
	091-433292	. Speed Indicator Cable (3613-10,3612-1H)	1
18	106-054059	. Coupling Housing	1
19	090-094970	. Speed Indicator Cable (3 Speed Trans.)(6013-2,6013-3,6013-H3)	1
	090-220401	. Speed Indicator Cable (1 Speed Trans.)(6013-2)	1
	090-298126	. Speed Indicator Cable (2613-2)	1
	135-008928	. Speed Indicator Cable (1612-0,3613-0,1613-2,2613-2,1612-3,2612-1H,2612-2H,2612-1,2612-H,2614-1,2613-1H,2612-1H3)	1
	090-102112	. Speed Indicator Cable (2613-3)	1
20	090-112731	Tachometer Drive Assembly (See Transmission Page)	
21	090-022781	. "O"-Ring	1
22	090-022716	. Spacer	1
23	090-105404	. Helical Gear	1
24	090-042292	. Roll Pin	1

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 SCL 6-26-87
 SCL 3-2-92



VIEW A-A



MODEL	FIRST MACH.	LAST MACH.
3612-1H3	358-76101	358-78155
3612-2H3	401-78101	401-92232

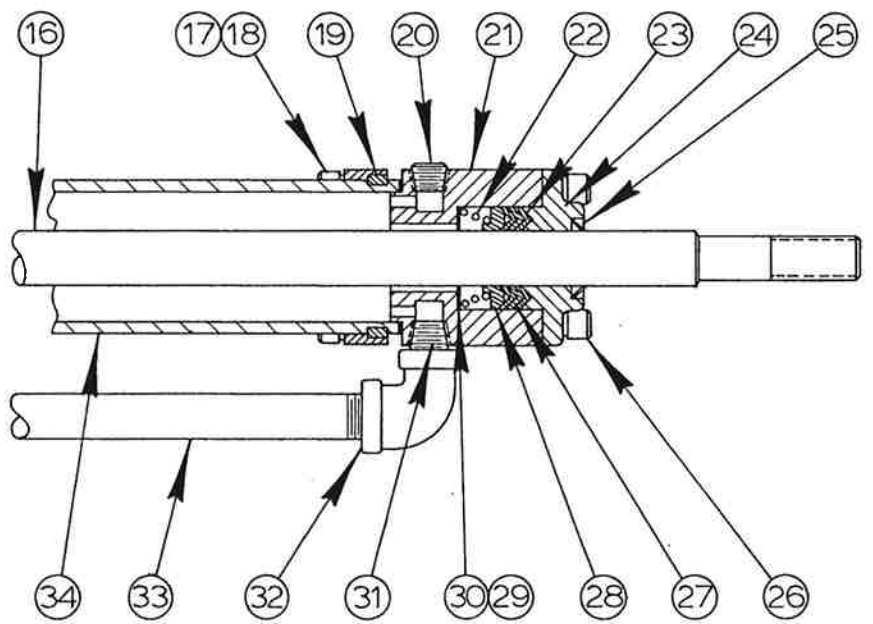
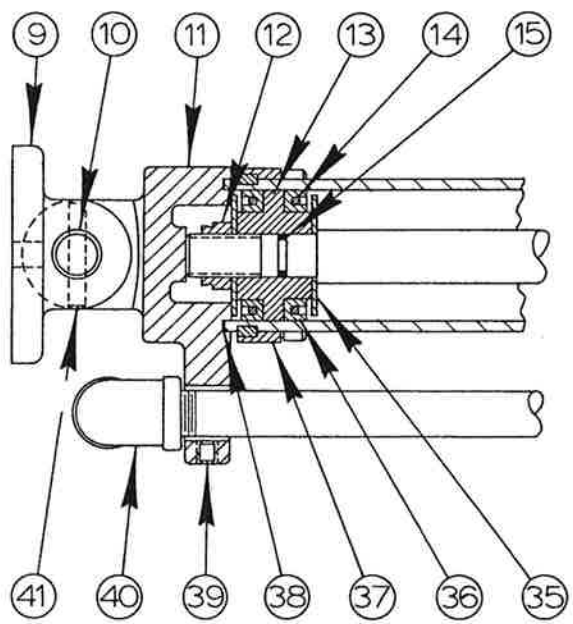
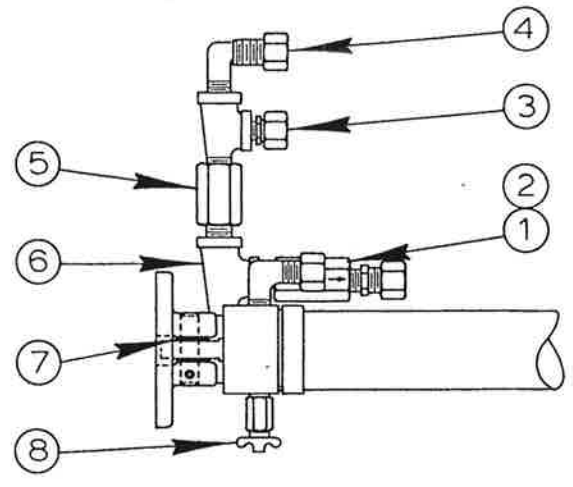
HYDRAULIC TABLE ASSEMBLY

HYDRAULIC TABLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	090-507757	Hydraulic Table Assembly	
1	091-988931	. Screw, Rd. Hd. Mach. 1/4-20NC x 3/8.....	2
2	091-993568	. Washer, Lock 1/4 Shakeproof Int.	2
3	091-115527	. Shim (.003).....	A.R.
4	091-115535	. Shim (.005).....	A.R.
5	091-115543	. Shim (.008).....	A.R.
6	091-115550	. Shim (.0149).....	A.R.
7	091-115568	. Shim (.002).....	A.R.
8	090-202797	. Drip Strip	2
9	091-993998	. Screw, Rd. Hd. Drive #4 x 1/4.....	10
10	090-410721	. Pan.....	1
11	090-342122	. Cover.....	1
12	090-342296	. Way Bar.....	4
13	091-983205	. Screw, Flat Hd. Soc. 1/4-20NC x 3/4.....	4
14	095-013801	. Table.....	1
15	090-036476	. Ball Bushing	4
16	091-782714	. Spacer.....	2
17	135-065803	. Pipe Plug (If Supplied).....	1
18	090-087909	. 90° Lube Fitting	2
19	090-507914	. Trunnion	1
20	090-216219	. Trunnion Plate.....	1
21	090-394644	. Head.....	1
22	090-409038	. Cradle	1
23	090-105016	. Spacer.....	1
24	091-991414	. Nut, Hex. 3/4-16NF.....	1
25	091-981068	. Screw, Hex. Hd. Cap 3/4-16NF x 5.....	1
26	090-242413	. Keeper Block.....	1
27	091-980474	. Screw, Hex. Hd. Cap 3/8-16NC x 1-1/4.....	2
28	091-993329	. Washer, Lock 3/8 Std.....	9
29	091-338756	. Dowel Pin.....	2
30	134-033158	. Pointer.....	1
31	091-988386	. Screw, Rd. Hd. Mach. #6-32NC x 1/4.....	1
32	106-335185	. Pipe Plug.....	1
33	090-042094	. Roll Pin.....	1
34	090-104902	. Center Plate	1
35	091-333104	. Shim (.035).....	A.R.
36	091-333112	. Shim (.0149).....	A.R.
37	091-333120	. Shim (.005).....	A.R.
38	091-333138	. Shim (.003).....	A.R.
39	090-410937	. Chip Guard Assembly	1
40	090-450800	. Chip Guard Assembly (w/Handle)	1
41	091-655076	. Rod Wiper	4
42	090-095035	. Stop.....	1
43	091-988956	. Screw, Rd. Hd. Mach. 1/4-20NC x 1/2.....	2
44	091-982219	. Screw, Soc. Hd. Cap #10-24NC x 5/8.....	10
45	090-239674	. Slide Bar.....	2
46	090-095043	. Dog.....	2
47	090-093923	. T-Bolt 5/16-18NC.....	2
48	091-993238	. Washer, Lock 5/16 Std.....	2
49	091-991224	. Nut, Hex. 5/16-18NC.....	2
50	090-410614	. Cylinder Bracket.....	1
51	090-062910	. Plug Button.....	1
52	090-119520	. Spacer	1
53	091-991349	. Nut, Hex. Jam 1/2-20NF	2
54	091-980441	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4.....	4
55*	094-132503	. Table Feed Cylinder Assembly (See Detail).....	1
56	091-980276	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4.....	2
57	091-993238	. Washer, Lock 5/16 Std.....	1
58	091-982918	. Screw, Soc. Hd. Cap 1/2-13NC x 3/4.....	4
59	134-134071	. Dowel Pin.....	1
60	091-988675	. Screw, Rd. Hd. Mach. #10-24NC x 3/8.....	20
61	091-993196	. Washer, Lock #10 Std.....	16
62	090-051764	. Retainer	4
63	090-216128	. Guide Rod.....	2
64	091-980698	. Screw, Hex. Hd. Cap 1/2-13NC x 2.....	4
65	091-993279	. Washer, Lock 1/2 Std.....	4
66	091-980466	. Screw, Hex. Hd. Cap 3/8-16NC x 1.....	2
67	091-992644	. Washer, Flat 3/8 S.A.E. Std.....	1
68	090-045998	. Clamp.....	1

*NOTE: #55 was #090-410606 Before Serial #400-85216 On 3612-2H And All Other Models Listed.

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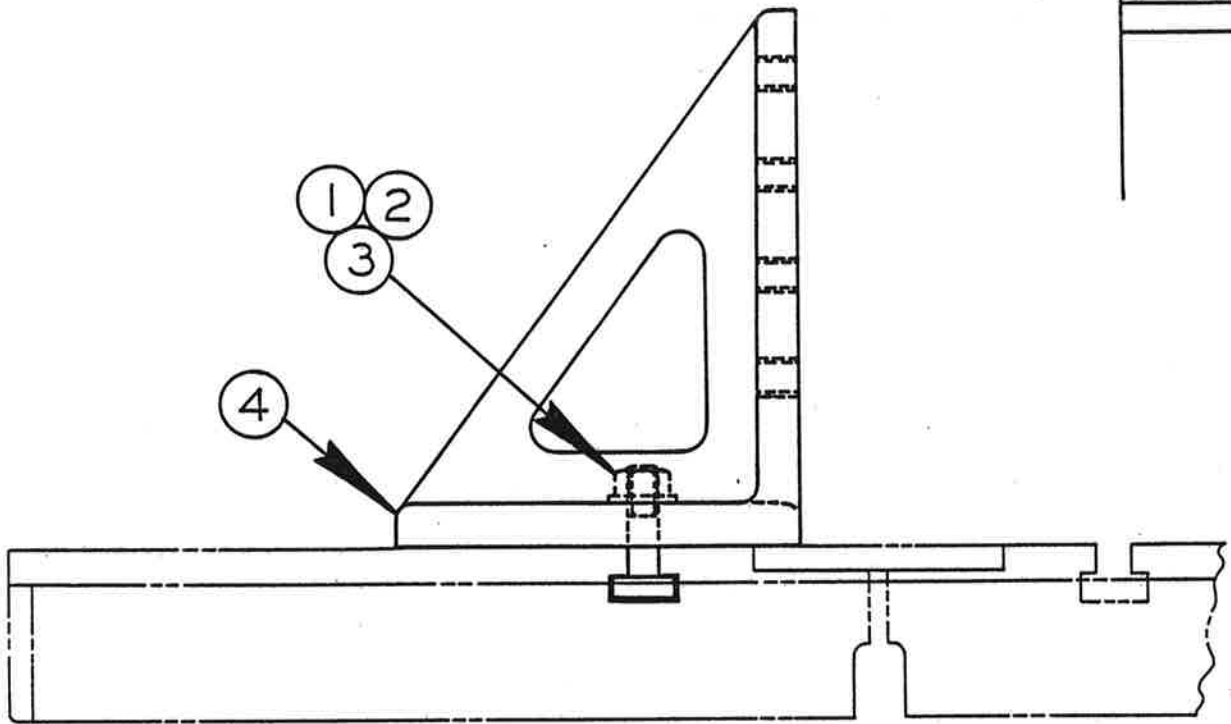
MODEL	FIRST MACH.	LAST MACH.
1612-3	152-68956	152-751144
3612-3	153-68972	153-761249
2612-2H	206-68260	206-73347
2612-D	236-69110	236-77121
3612-H	272-68101	272-77373
2612-H	284-68101	284-76223
1612-H	288-69101	288-75436
2012-1H	348-75101	348-78170
2012-1H3	354-76101	354-78156
3612-1H3	358-76101	358-78155
2613-1H	361-76101	361-85175
3612-1H	382-77101	382-78130
2012-2H	383-78101	383-85252
2012-2H3	397-78101	397-85203
3612-2H	400-78101	400-85215
3612-2H3	401-78101	401-85199

TABLE FEED CYLINDER ASSEMBLY

TABLE FEED CYLINDER ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PE ASS'Y
Ref.	090-410606	Table Feed Cylinder Assembly (Standard)	
Ref.	090-481391	Table Feed Cylinder Assembly (Servo-contour Feed)	
Ref.	090-485178	Table Feed Cylinder Assembly (2612-D Only)	
1	091-022459	. Check Valve (Servo-contour Feed Only).....	1
2	114-035074	. Close Nipple (Servo-contour Feed Only).....	2
3	093-090108	. Male Connector (Servo-contour Feed Only).....	2
4	093-090579	. 90° Male Elbow (Servo-contour Feed Only).....	2
5	093-034106	. Orifice (.033 Dia.)(Servo-contour Feed Only).....	1
6	135-008472	. Service Tee (Servo-contour Feed Only).....	2
7	135-008910	. Shim (1/32).....	2
8	091-100636	. Drain Valve.....	1
9	090-215948	. Swivel Base.....	1
10	090-051301	. Swivel Pin.....	1
11	090-256553	. Rear Cylinder Cap.....	1
12	090-127762	. Self-locknut.....	1
13	091-076463	. Piston.....	1
14	090-104357	. O-Ring.....	2
15	135-091767	. O-Ring.....	1
16	090-127721	. Piston Rod.....	
17	091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1.....	3
18	090-035593	. Washer, Lock 1/4 Hi-collar.....	12
19	135-004661	. Snap Ring Segment.....	4
20	091-203695	. Pipe Plug.....	1
21	090-256561	. Front Block.....	1
	090-340753	. Front Block (2612-D Only).....	1
22	091-031732	. Spring.....	1
23	091-098848	. Homo. Chevron Packing Ring.....	2
24	091-031757	. End Cap.....	1
25	090-070699	. Scraper Ring.....	1
26	091-982397	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4.....	4
27	091-098830	. Fab. Chevron Packing Ring.....	1
28	090-174541	. Back-up Washer.....	1
29	091-333328	. Shim (1/64).....	A.R.
30	091-333336	. Shim (1/32).....	A.R.
31	114-145287	. Close Nipple.....	1
	091-203695	. Pipe Plug (2612-D Only).....	1
*32	090-152224	. 90° Reducing Elbow.....	1
*33	091-165548	. Pipe.....	1
34	091-076513	. Cylinder.....	1
35	091-025247	. Washer.....	2
36	091-101238	. U-Cup.....	2
37	135-004653	. Cylinder Collar.....	2
38	135-004638	. Gasket.....	2
*39	091-984245	. Screw, Soc. Set 1/4-20NC x 3/8.....	1
*40	135-005197	. 90° Elbow.....	1
41	090-042615	. Roll Pin.....	1

*Note: These Items Do Not Apply To Model 2612-D.



ANGLE PLATE ASSEMBLY

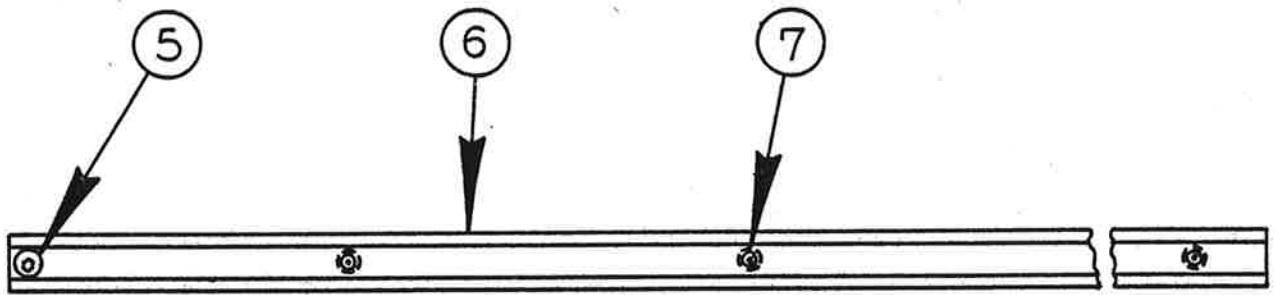
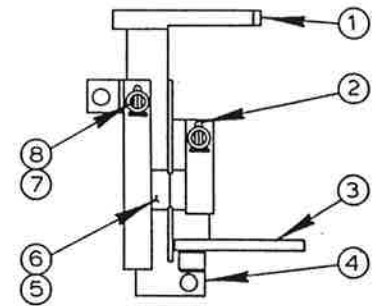
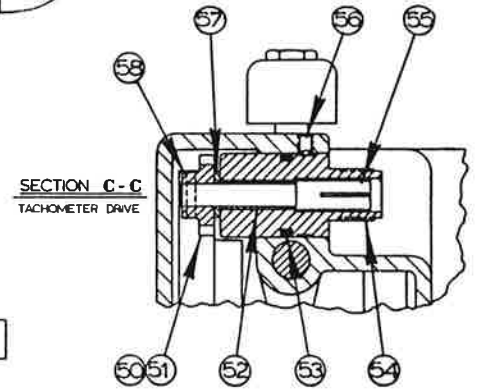
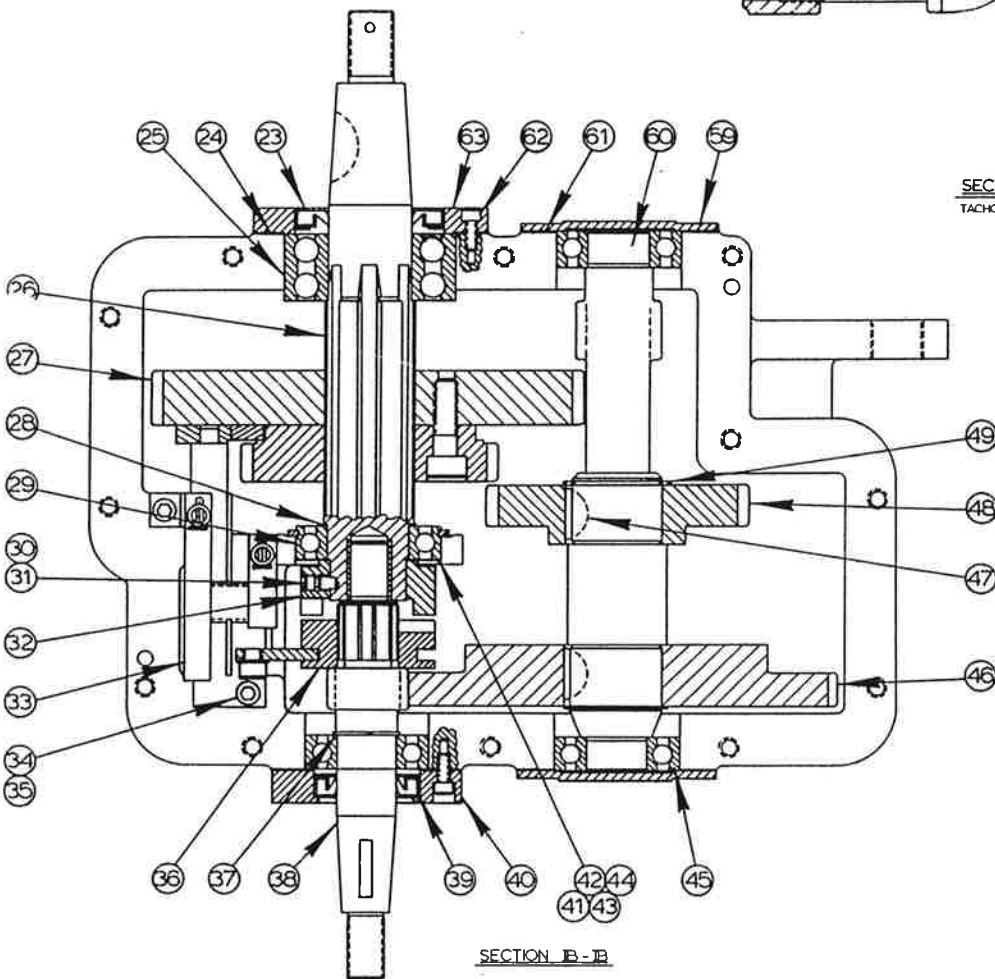
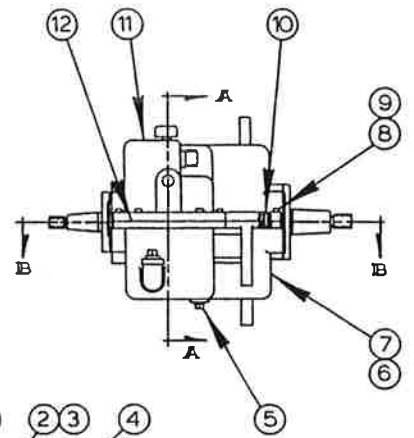
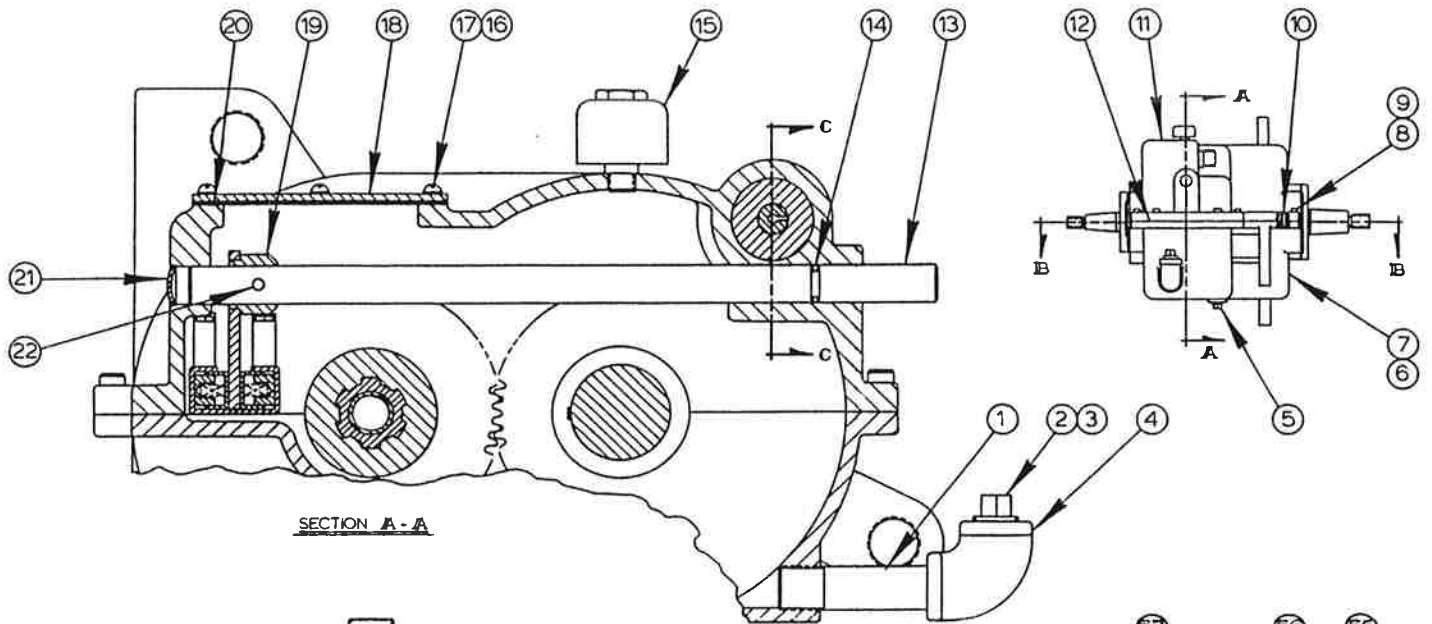


TABLE EXTENSION ASSEMBLY

ANGLE PLATE & TABLE EXTENSION ASSEMBLIES

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	090-531237	Angle Plate Assembly (1612-3, 2612-2H, 2612-D, 3612-3)	
Ref.	090-528647	Angle Plate Assembly (2613-3, 2618-4, 6013-3, 2612-1H3, 6013-H3)	
1	090-057126	. T-Slot Bolt 1/2-13NC x 2	2
2	091-992669	. Washer 1/2 Std.	2
3	090-033671	. Nut, Hex. 1/2-13NC	2
4	090-439019	. Angle Plate (Ass'y #090-531237)	Use
	090-419227	. Angle Plate (Ass'y #090-528647)	One
Ref.	090-261900	Table Extension Assembly (1612-H, 1612-3, 2013-1, 2013-10, 2012-1A, 2012-1AT, 2012-A, 2012-AT, 2612-H, 2613-3, 2612-2H, 2618-4, 3612-H, 6013-3, 2012-1H3, 2612-1H3, 3612-1H3, 6013-H3)	
5	091-982561	. Screw, Soc. Hd. Mach. 5/16-18NC x 1/2	1
6	090-261892	. Table Extension Bar	1
7	091-985762	. Screw, Soc. Set 5/16-18NC x 3/4 (Flat Pt.)	4



SHIFTER ASSEMBLY

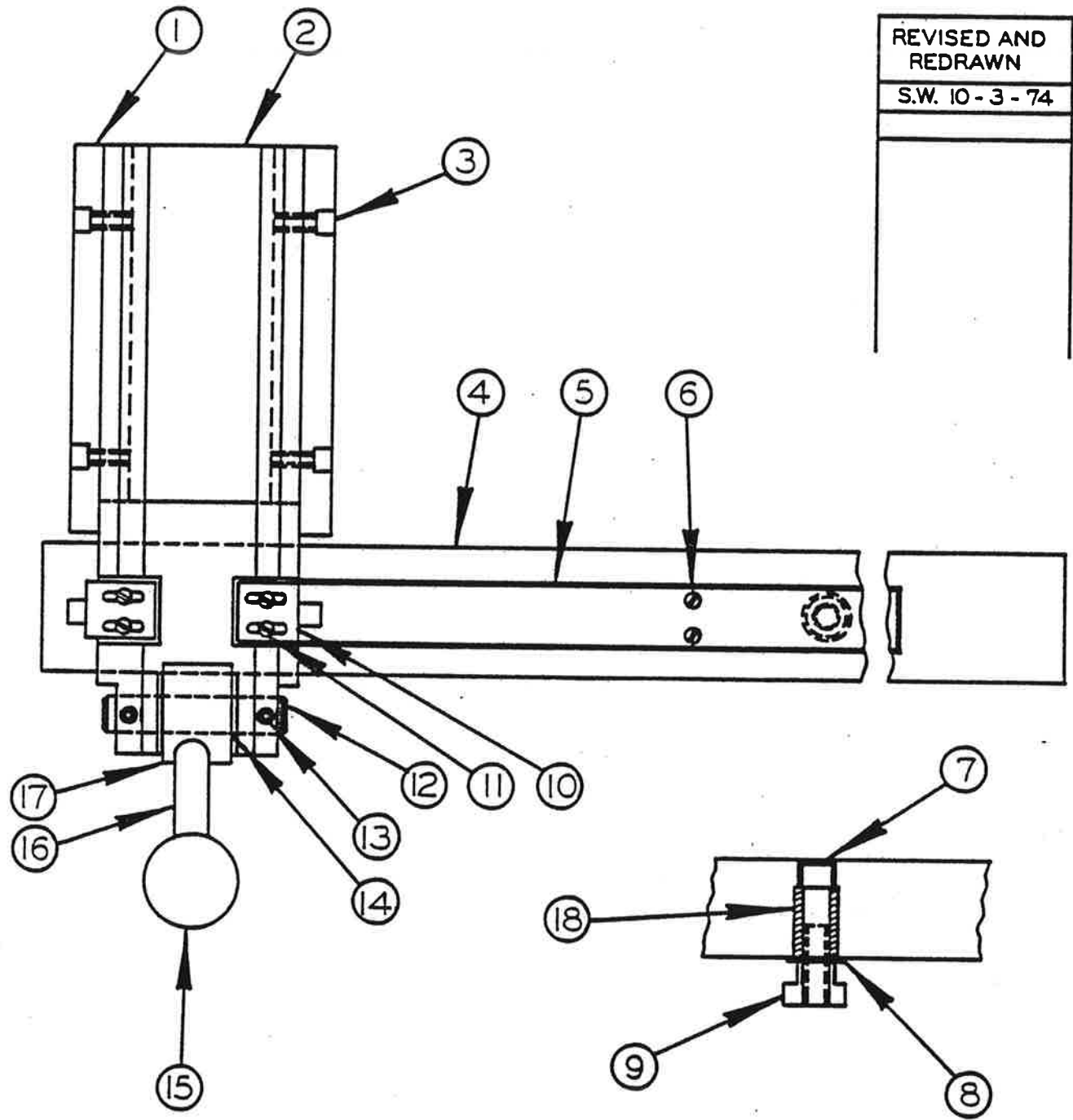
MODEL	FIRST MACH	LAST MACH
1613-2	150-59101	150-75655
1612-3	152-59101	152-751144
3613-2	151-59101	151-756083
3612-3	153-59101	153-761249
2613-2	127-60139	127-72297
6013-2	129-60105	129-70118
2612-2H	206-62101	206-73347
2612-1H	240-65101	240-68145
2612-H	269-68101	269-68102
2612-H	284-68101	284-76223
2012-1H3	354-76101	354-78156
3612-1H3	358-76101	358-78145

TRANSMISSION ASSEMBLY
(MX-2)

TRANSMISSION ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
1	090-501867	Transmission Assembly (MX-2)		50	090-112731	Tachometer Drive Assembly	1
2	090-029893	• Pipe Nipple	1	51	090-105404	• Gear	1
3	090-012766	• Sq. Hd. Pipe Plug	1	52	114-065535	• Oilite Bushing	1
4	091-384420	• Gear Oil	A.R.	53	090-022781	• O-Ring	1
5	114-003486	• 90° Elbow	1	54	090-022799	• Body	1
6	105-046122	• Sq. Hd. Pipe Plug	1	55	090-022807	• Spindle	1
7	090-501933	• Housing Assembly	1	56	091-984237	• Screw, Soc. Set 1/4-20NC x 5/16	1
8	090-501941	• Lower Housing	1	57	090-022716	• Spacer	1
	091-982595	• Screw, Soc. Hd. Cap 5/16-18 NC x 7/8	12	58	090-042292	• Roll Pin	1
9	090-019936	• Washer, Lock 5/16 Hi-Collar	12	59	090-022641	• Bearing Cap	2
10	105-044127	• Dowel Pin	1	60	090-246984	• Countershaft	1
11	090-501958	• Upper Housing	1	61	090-022633	• Gasket	3
12	090-203993	• Gasket	1	62	091-982203	• Screw, Soc. Hd. Cap #10-24NC x 1/2	10
13	090-022666	• Shifter Rod	1	63	090-050261	• Bearing Retainer	1
14	090-041229	• O-Ring	1				
15	091-443549	• Breather	1	Ref.	090-402801	Shifter Assembly	
16	091-988691	• Screw, Rd. Hd. Mach. #10-24NC x 1/2	14	1	090-204280	• Shifter Rod Assembly	1
17	091-993196	• Washer, Lock #10 Std.	14		090-022856	• Shifter Fork	1
18	090-025958	• Cover	1		090-021684	• Shifter Rod	1
19	090-204256	• Shifter Arm Assembly	1	2	091-995084	• Cotter Pin (1/16 x 5/8)	2
	090-022674	• Hub	1	3	090-204272	• Shifter Rod Assembly	1
	090-022682	• Arm	1		090-022849	• Shifter Fork	1
20	090-025966	• Gasket	1		090-021650	• Shifter Rod	1
21	135-034197	• Expansion Plug	1		091-982702	• Screw, Soc. Hd. Cap 5/16-24NF x 1/2	1
22	090-132820	• Dowel Pin	1		091-993576	• Washer, Lock 5/16 Shakeproof Int.	1
23	090-026899	• Oil Seal	1				
24	090-038720	• Gasket	1	4	090-203886	• Shifter Rod Cage Assembly	1
25	090-050279	• Ball Bearing	1		090-203894	• Cage	1
26	090-212903	• Output Shaft Assembly	1		090-021676	• Spring Holder	2
	090-045758	• Bearing	1		090-021668	• Separator	2
	090-209479	• Output Shaft	1		090-022864	• Lug	1
27	090-429747	• Cluster Gear Sub-Assembly	1	5	090-025883	• Latch	2
	090-429754	• Gear (Small)	1	6	090-110008	• Spring	2
	090-429739	• Gear (Large)	1	7	090-023292	• Spring	2
	091-982801	• Screw, Soc. Hd. Cap 3/8-16NC x 1 1/4	3	8	105-035026	• Steel Ball	2
	135-004455	• Dowel Pin	2				
28	113-013049	• Spacer (.010)	1				
29	090-045816	• Ball Bearing	1				
30	091-984229	• Screw, Soc. Set 1/4-20NC x 1/4	1				
31	090-039082	• Screw, Soc. Set 1/4-20NC x 5/16 (Dog PT)	1				
32	090-036880	• Clutch Jaw	1				
33	090-402801	• Shifter Assembly (See Detail)	1				
34	091-982355	• Screw, Soc. Hd. Cap 1/4-20NC x 3/8	2				
35	091-993568	• Washer, Lock 1/4 Shakeproof Int.	2				
36	090-034653	• Clutch Jaw	1				
37	090-136110	• Retaining Ring	1				
38	090-259987	• Input Shaft	1				
39	090-026907	• Oil Seal	1				
40	090-022658	• Bearing Retainer	1				
41	091-333385	• Spacer (.005)	A.R.				
42	091-333393	• Spacer (.010)	A.R.				
43	091-333401	• Spacer (.029)	A.R.				
44	091-333419	• Spacer (.125)	A.R.				
45	090-022765	• Ball Bearing	3				
46	090-429762	• Countershaft Gear	1				
47	135-071926	• Woodruff Key	2				
48	090-251232	• Intermediate Gear	1				
49	090-022773	• Retaining Ring	2				

REVISED AND REDRAWN
S.W. 10-3-74



UNIVERSAL CAL. WORK FIXTURE
(USE WITH T-SLOT TABLE ONLY)

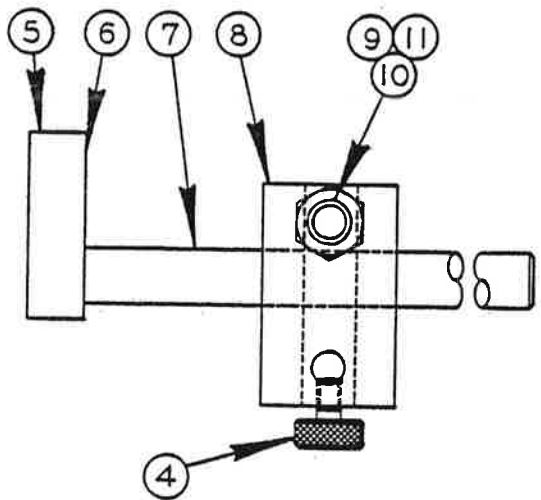
FITS ALL CONTOUR-
MATIC MACHINES

CM-10-9
F-9

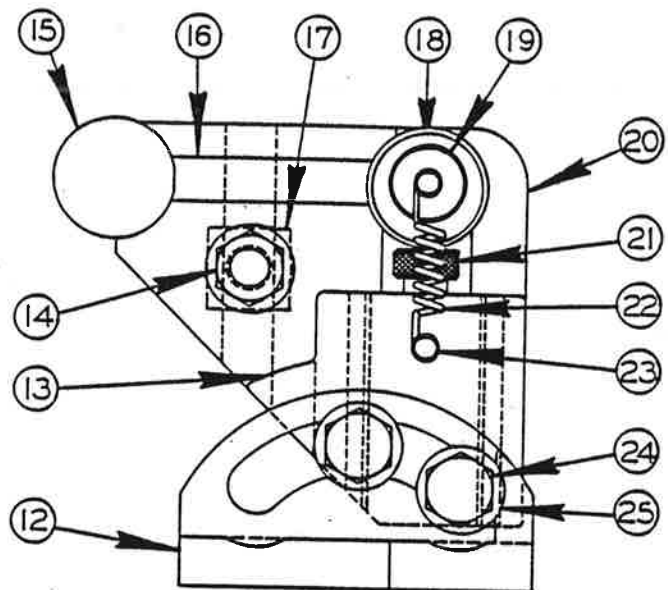
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UNIVERSAL CALIBRATED WORK FIXTURE

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
REF.	090-450842	Universal Calibrated Work Fixture (English) 26-3, 60-3, 2612-H, 2613-3, 2618-4, 6013-3, 6013-H3	
REF.	090-450834	Universal Calibrated Work Fixture (English) 16-2, 36-3, 1612-H, 1612-3, 2012-A, 2012-AT, 2012-1AT, 3612-H, 3612-3, 3612-1H, 3612-1, 3613-10	
REF.	094-049079	Universal Calibrated Work Fixture (Metric) 2012-A, 2012-AT, 2012-1A, 2012-1AT, 3612-1H, 3612-1, 3613-10	
REF.	094-048170	Universal Calibrated Work Fixture (Metric) 2612-H	
1	090-183906	. Wear Strip	2
2	090-450859	. Head	1
3	091-982363	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2	4
4	090-450875	. Bar (Used on Ass'y #094-048170 & #090-450842)	1
	090-450867	. Bar (Used on Ass'y #094-049079 & #090-450834)	1
5	090-450891	. Scale (Used on Ass'y #090-450842)	USE
	090-450883	. Scale (Used on Ass'y #090-450834)	
	090-475005	. Scale (Used on Ass'y #094-049079)	
	090-474990	. Scale (Used on Ass'y #094-048170)	ONE
6	091-988337	. Screw, Rd. Hd. Mach. #5-40NC x 1/8	10
7	091-982819	. Screw, Soc. Hd. Cap 3/8-16NC x 11/2	USE
	091-982827	. Screw, Soc. Hd. Cap 3/8-16NC x 13/4	TWO
8	091-992644	. Washer, Flat 3/8 S.A.E.	2
9	090-038555	. T-Nut	2
10	090-183922	. Pointer	2
11	091-990051	. Screw, Truss Hd. Mach. #6-32NC x 1/4 Plated	4
12	090-183914	. Pin	1
13	091-984179	. Screw, Soc. Set #10-32NF x 1/4	2
14	090-288929	. Cam Assembly	1
15	134-135086	. Ball	1
16	090-025792	. Handle	1
17	091-007021	. Cam	1
18	091-011171	. Collar	1

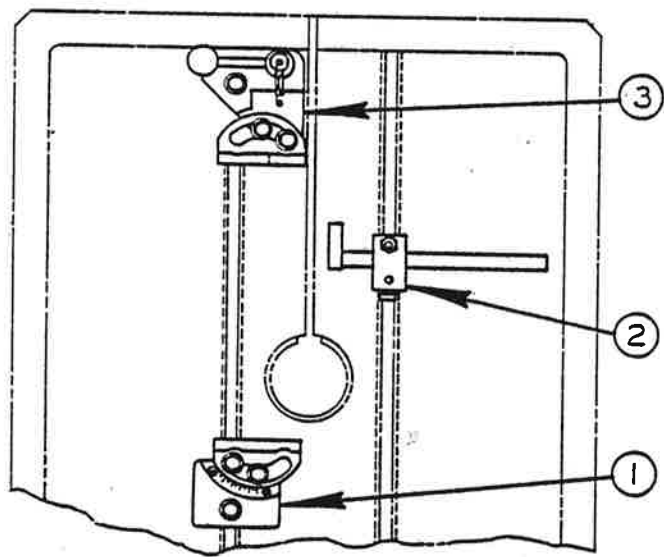


#20453
CUTOFF GAUGE ASSEMBLY

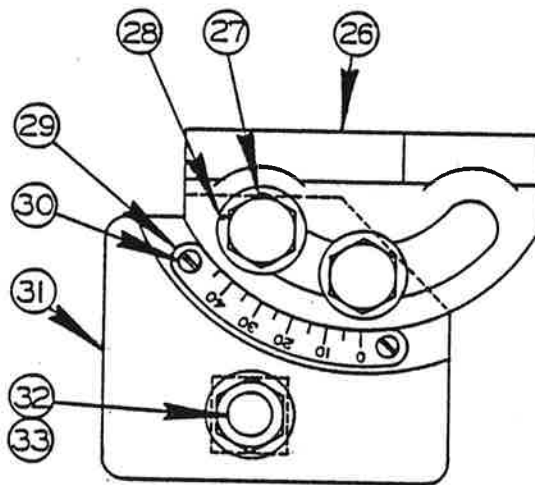


#40364
FRONT VISE ASSEMBLY

REVISED AND
REDRAWN
SCL 11-21-74



UNIVERSAL VISE ASSEMBLY



#40365
REAR VISE ASSEMBLY

UNIVERSAL VISE ASSEMBLY

INDEX NO. REF.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
	090-403635	Universal Vise Assembly	
1	090-403650	. Rear Vise Assembly (See Below)	1
2	090-204538	. Cut Off Gauge Assembly (See Below)	1
3	090-403643	. Front Vise Assembly (See Below)	1
	090-025818	. Offset Socket Wrench (Not Shown)	1
REF.	090-204538	Cutoff Gauge Assembly	
4	135-005544	. Thumb Nut	1
5	090-204544	. Gauge Bar Assembly	1
6	090-023359	. . Head	1
7	090-023342	. . Pin	1
8	090-023367	. Body	1
9	090-025800	. T-Slot Bolt	1
10	090-033671	. Nut, Hex. 1/2-13NC	1
11	091-992669	. Washer 1/2 S.A.E. Std.	1
REF.	090-403643	Front Vise Assembly	
12	090-205618	. Jaw	1
13	090-205634	. Jaw Support	1
14	090-033671	. Nut, Hex. 1/2-13NC	1
15	134-135086	. Knob	1
16	090-205600	. Cam Assembly	1
17	090-025842	. T-Slot Bolt	1
18	091-984229	. Screw, Soc. Hd. Set 1/4-20NC x 1/4 Cup Pt.	1
19	090-025834	. Pivot Pin	1
20	090-205626	. Body	1
21	090-023227	. Adjusting Screw	1
22	090-025826	. Spring	1
23	090-023201	. Spring Stud	2
24	091-980664	. Screw, Hex. Hd. Cap 1/2-13NC x 1-1/4	2
25	091-992669	. Washer 1/2 S.A.E. Std.	3
REF.	090-403650	Rear Vise Assembly	
26	090-205592	. Jaw	1
27	091-980664	. Screw, Hex. Hd. Cap 1/2-13NC x 11/4	2
28	091-992669	. Washer 1/2 S.A.E. Std.	3
29	090-025768	. Escutcheon	1
30	091-988386	. Screw, Rd. Hd. Mach. #6-32NC x 1/4	2
31	090-205584	. Jaw and Body	1
32	090-093675	. T-Slot Bolt	1
33	090-033671	. Nut, Hex. 1/2-13NC	1

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AND
REDRAWN
S.W. 2-12-70

REVISIONS

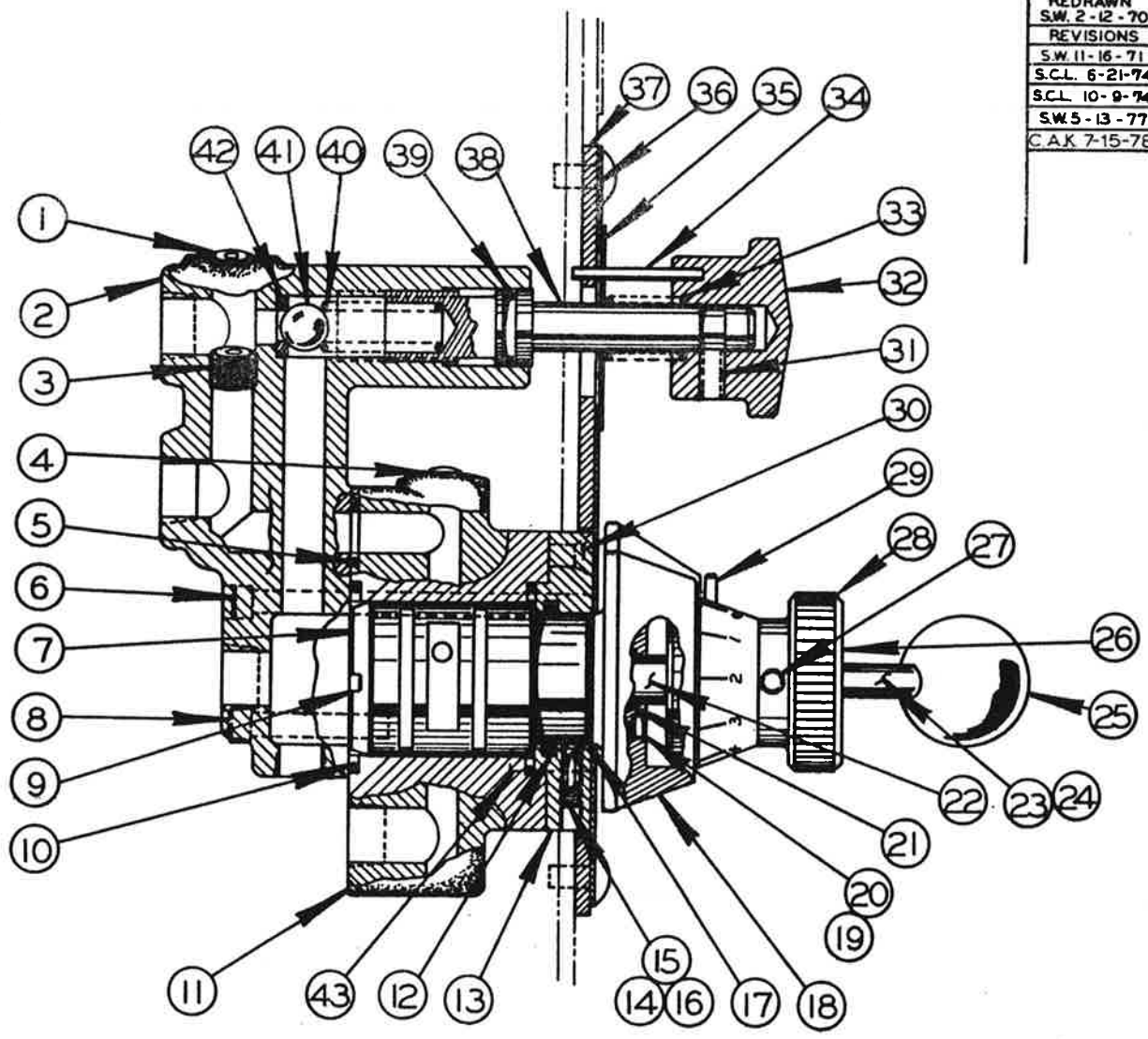
S.W. 11-16-71

S.C.L. 6-21-74

S.C.L. 10-9-74

S.W. 5-13-77

C.A.K. 7-15-78



VALVE ASSEMBLY

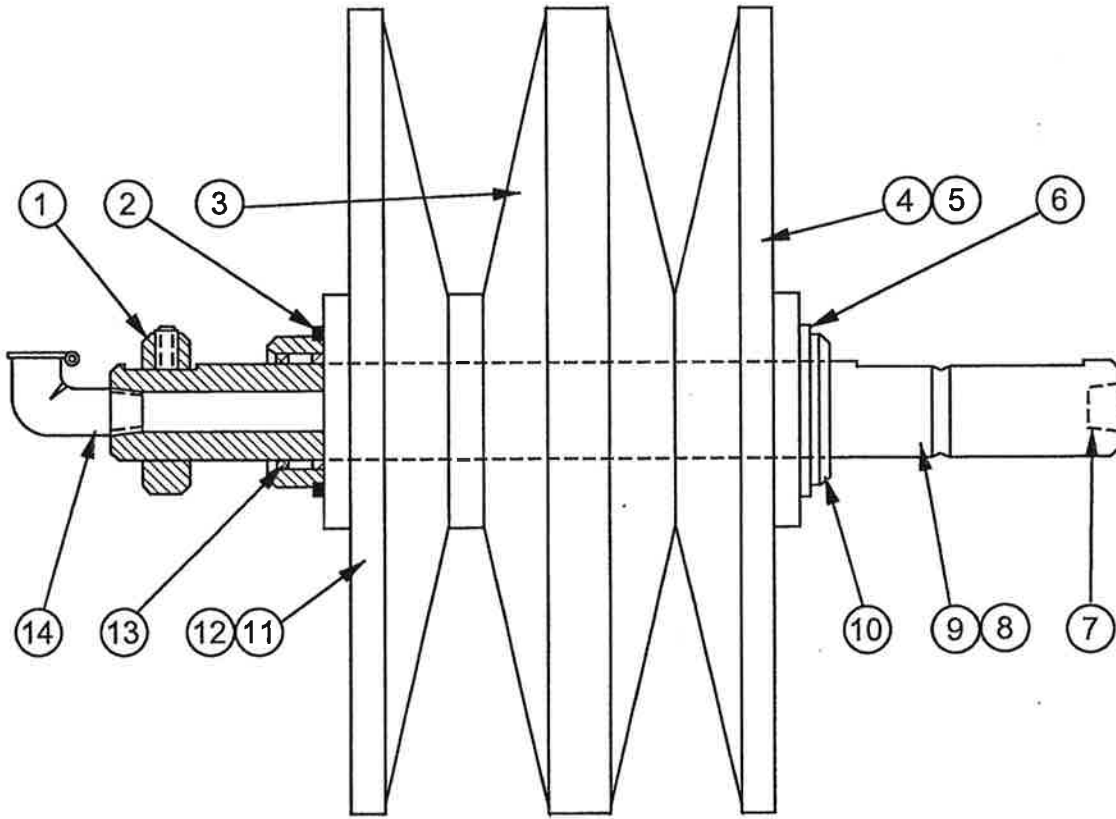
MODEL	FIRST MACH	LAST MACH
3612-IH	382-77101	
1612-XI	170-60101	170-64106
1612-3	152-59101	152-751144
3612-3	153-59101	153-761249
2612-IH	240-65101	240-68145
2612-H	284-68101	284-76223
2612-2H	206-62101	206-73347
3612-H	272-68101	272-77373
2613-3	198-61101	198-76431
6013-3	199-61101	199-76138
2612-D	236-64101	236-84141
3612-IH3	358-76101	358-78155

VALVE SUB-ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	090-433228	Valve Sub-Assembly (For Standard Hydraulics)	
Ref.	090-455692	Valve Sub-Assembly (For Servo Contour Feed)	
Ref.	090-455700	Valve Sub-Assembly (For Servo Contour Feed) (2613-3, 6013-3 & 6013-H3 only)	
Ref.	090-467838	Valve Sub-Assembly (For Standard Hydraulics) (6013-3) (6013-H3)	
1	091-227488	. Soc. Hd. Pipe Plug (Used on #43322, #46783)	2
	091-233288	. Soc. Hd. Pipe Plug (Used on #45569, #45570)	1
2	090-523044	. Pressure Valve Housing (Used on #43322, #46783)	1
	090-566795	. Pressure Valve Housing (Used on #45569, #45570)	1
3	091-227488	. Soc. Hd. Pipe Plug (Used Here on #45569, #45570)	2
4	091-203695	. Soc. Hd. Pipe Plug	4
5	090-033705	. O-Ring	1
6	091-982504	. Screw, Soc. Hd. Cap 1/4-20NC x 2 3/4	3
*7	090-247552	. Valve Spool	1
8	091-982397	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4	1
9	090-042516	. Roll Pin	1
10	090-015082	. O-Ring	2
11	090-433095	. Control Valve Housing	1
12	135-098598	. O-Ring	1
13	090-251794	. Valve Cap	1
14	091-144659	. Nyloc Set Screw	1
15	114-002504	. Spring	1
16	134-015189	. Steel Ball	1
17	090-103755	. Gasket	1
18	090-213125	. Knob	1
19	091-982140	. Screw, Soc. Hd. Cap #8-32NC x 3/4	3
20	090-022385	. Washer, Lock	3
21	135-091767	. O-Ring	1
*22	090-247511	. Vernier Spool	1
23	090-113788	. Lever Rod	1
24	090-042292	. Roll Pin	1
25	134-135086	. Shift Lever Knob	1
26	090-106626	. Knob Escutcheon (Used on #43322, #46783)	1
	091-090290	. Knob Escutcheon (Used on #45569, #45570)	1
27	091-984245	. Screw, Soc. Hd. Set 1/4-20NC x 3/8	2
28	090-106527	. Knob	1
29	105-115091	. Dowel Pin	1
30	091-987586	. Screw, Fl. Hd. Mach. 1/4-20NC x 3/8 (Used on #43322, #45569) ..	4
31	091-984252	. Screw, Soc. Hd. Set 1/4-20NC x 1/2	1
32	090-071549	. Knob	1
33	090-051939	. Spring	1
34	090-042367	. Roll Pin	1
35	090-051913	. Pointer	1
36	090-251679	. Dial Plate (Used on #43322)	1
	090-336645	. Dial Plate (Used on #45569)	1
37	090-251786	. Valve Panel (Used on #43322, #45569)	1
38	090-098849	. Valve Screw	1
39	135-085413	. O-Ring	1
40	135-091734	. Spring	1
41	135-056570	. Steel Ball	1
42	091-147470	. Ball Seat	1
43	091-982363	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2	1

* NOTE: Replace valve spool and vernier spool, items 7 and 22 as a unit.

NEW DRG. S.C.L. 8-28-97
REVISIONS



VARIABLE PULLEY ASSEMBLY
(8.5")

C - 5 - 34 CM - 5 - 12 Z - 5 - 33 PS - 4 - 35

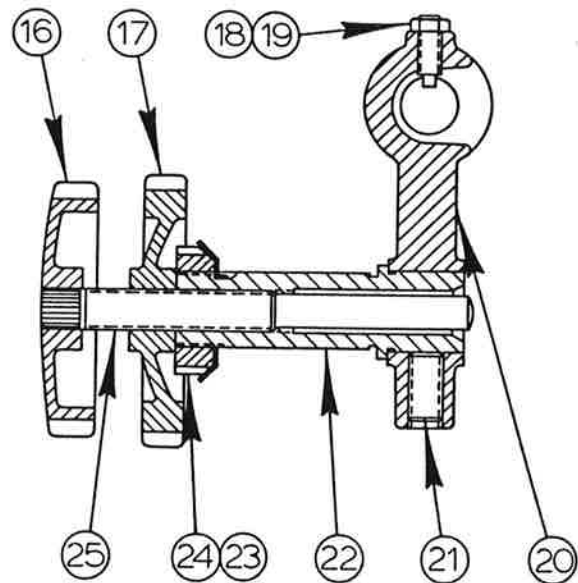
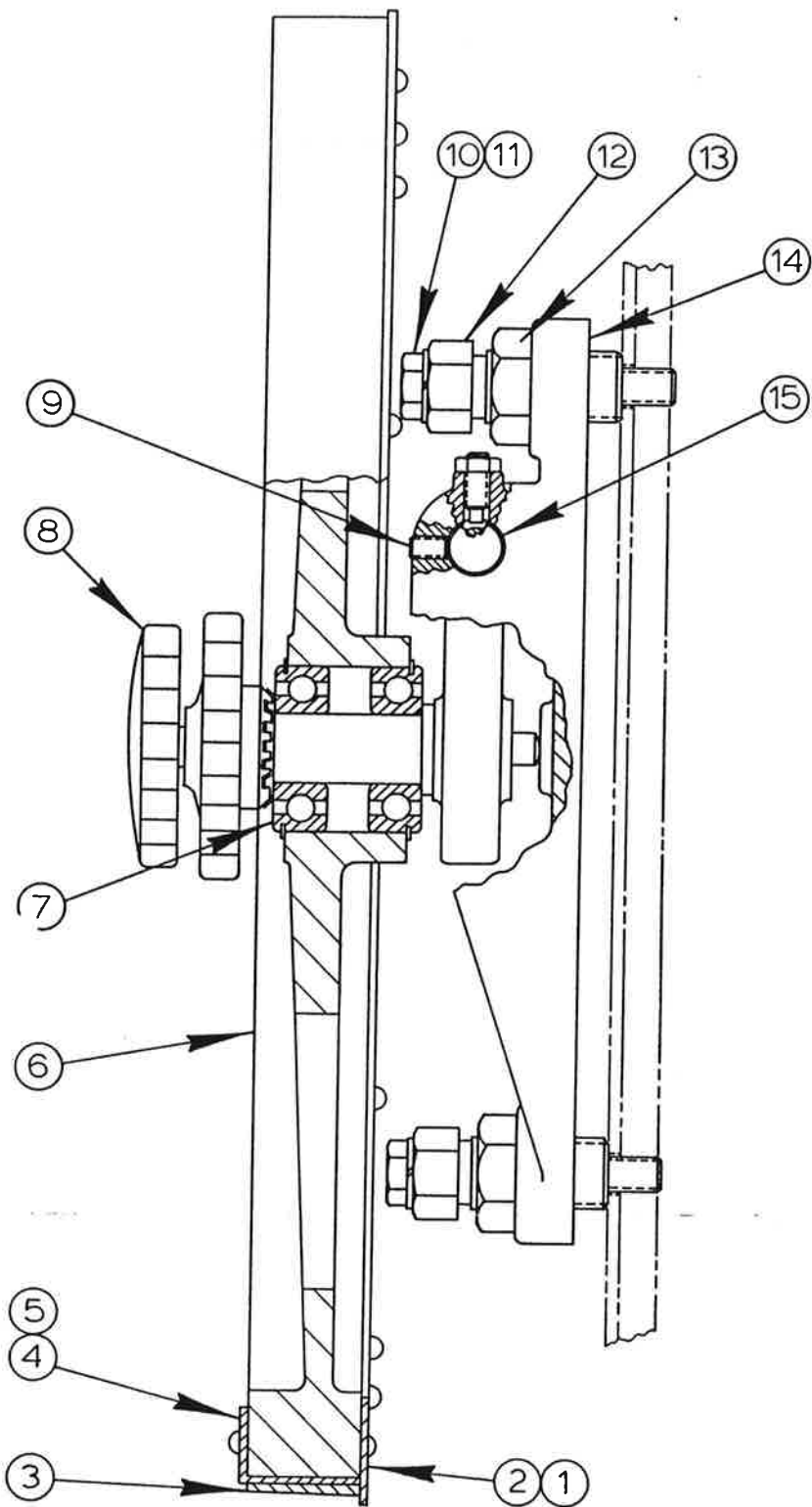
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CODE NO. C-5-34
 CM-5-12
 Z-5-33
 PS-4-35

VARIABLE PULLEY ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
	135-093359	Variable Pulley Assembly (8.5")	
1	090-061839	. Set Screw Collar	1
2	135-003275	. Snap Ring	1
3	090-202466	. Center Sheave Assembly	1
4	135-093375	. End Sheave	1
5	105-046023	. Woodruff Key	1
6	135-003275	. Snap Ring	1
7	091-227488	. Pipe Plug	1
8	135-093367	. Shaft	1
9	091-007013	. Wick	A.R.
10	135-093391	. Variable Sleeve Assembly	1
11	135-093375	. End Sheave	1
12	105-046023	. Woodruff Key	1
13	135-008985	. Washer (Both Ends)	2
14	111-055125	. Variable Oilder	1
Following Not Shown:			
	091-420455	. Cloth Bag	1

REVISED AND REDRAWN
S.C.L. 7-30-81



WHEEL HINGE ASSEMBLY

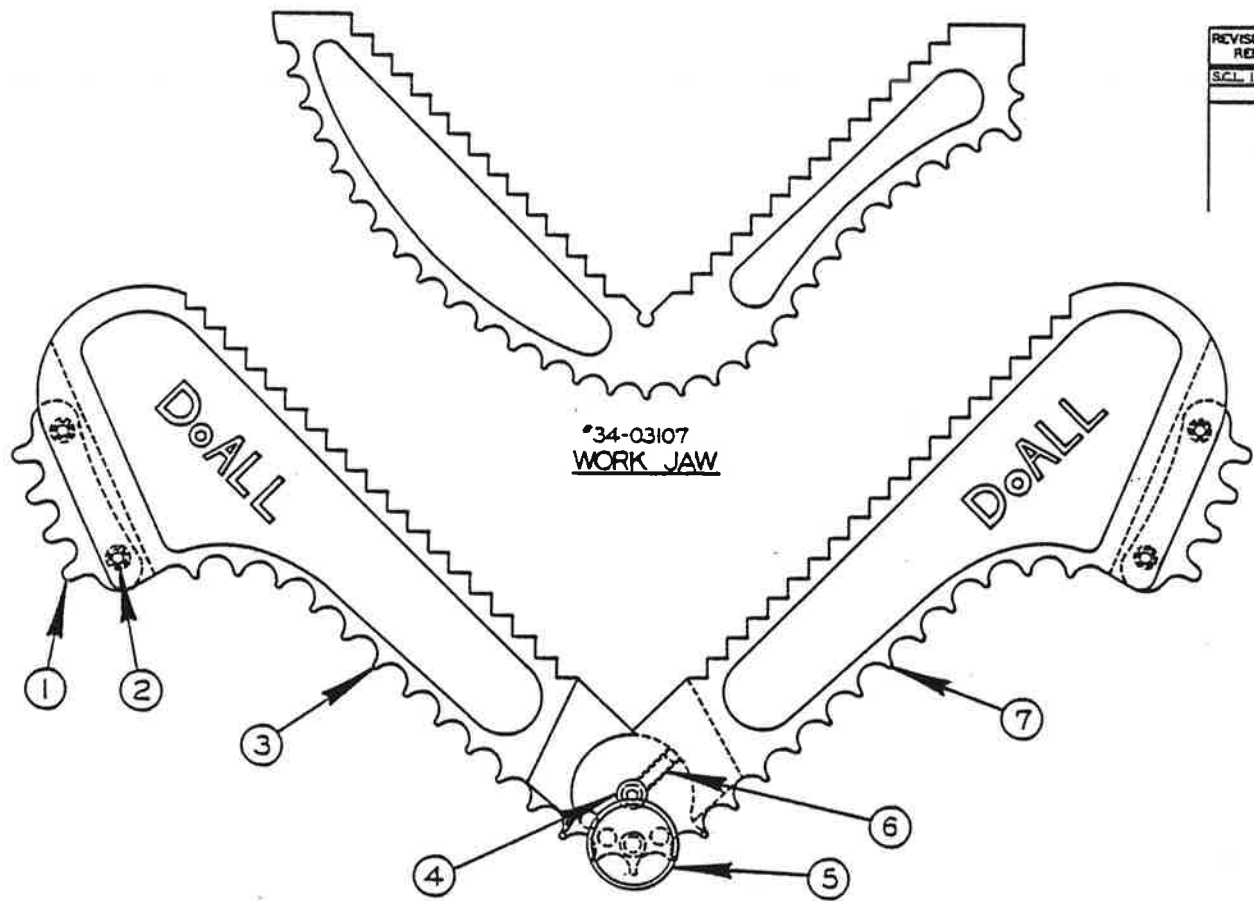
MODEL	FIRST MACH.	LAST MACH.
3612-1H3	358-76101	358-78155

THIRD WHEEL AND HINGE ASSEMBLY

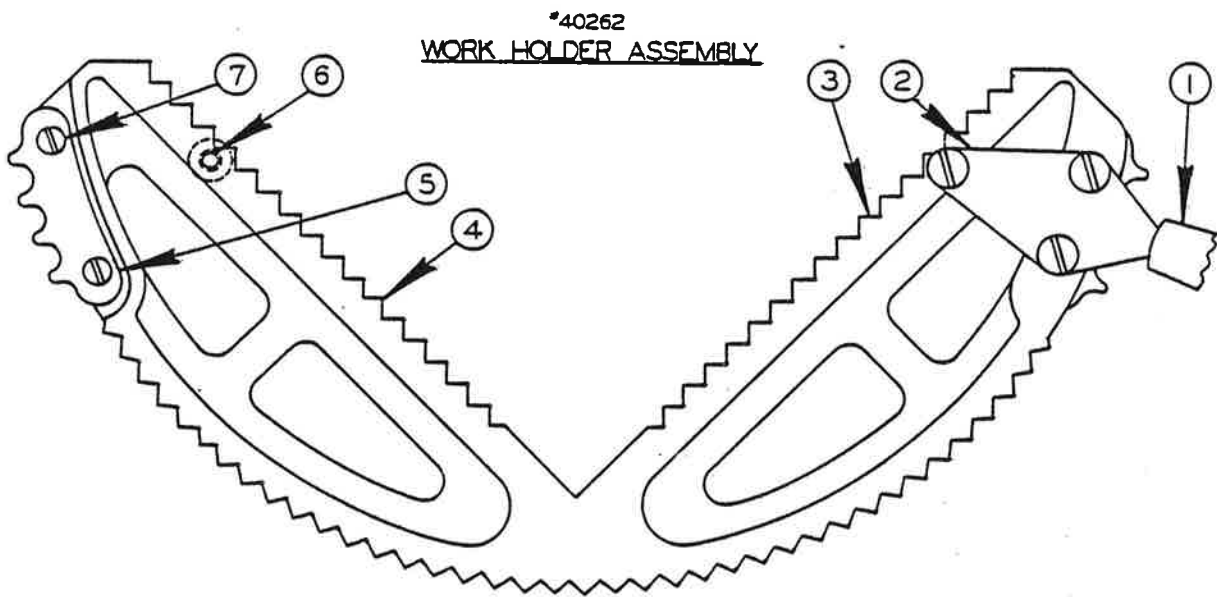
THIRD WHEEL AND HINGE ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	094-068145	Third Wheel and Hinge Assembly	
1	094-068137	. Wheel Assembly (Standard)	1
	094-083896	. Wheel Assembly (3/4" Metal Faced)	1
	094-083870	. Wheel Assembly (1" Metal Faced)	1
*2	090-314527	. . Back-Up Plate	6
*3	093-047447	. . Wheel Tire Assembly	1
*4	090-046756	. . Retainer	4
*5	091-988675	. . Screw, Rd. Hd. Mach. #10-24NC x 3/8	26
6	094-068129	. . Wheel (Standard)	1
	094-068434	. . Wheel (3/4" Metal Faced)	1
	094-068442	. . Wheel (1" Metal Faced)	1
7	105-015085	. . Ball Bearing	2
8	090-215476	. Wheel Hinge Assembly (See Detail)	1
9	091-984286	. Screw, Soc. Set 1/4-20NC x 1	2
10	091-980532	. Screw, Hex. Hd. Cap 3/8-16NC x 2-3/4	3
11	091-993329	. Washer, Lock 3/8 Std.	3
12	090-059569	. Adjustable Screw	3
13	091-991422	. Nut, Hex. Jam 3/4-16NF	3
14	090-412644	. Bracket	1
15	135-086106	. Hinge Pin	1
Ref.	090-215476	Wheel Hinge Assembly	
16	105-011084	. Tilting Screw Knob	1
17	105-011092	. Tilting Locknut	1
18	091-991141	. Nut, Hex. Jam 1/4-20NC	1
19	090-038621	. Screw, Soc. Set 1/4-20NC x 3/4 (Dog Pt.)	1
20	090-215468	. Wheel Hinge	1
21	091-984518	. Screw, Soc. Set 3/8-16NC x 3/4	1
22	105-014245	. Wheel Axis Stud	1
23	105-015069	. Bearing Locknut	1
24	105-015077	. Bearing Lockwasher	1
25	105-014252	. Wheel Tilting Screw	1

*NOTE: Starred Items Used On Standard Wheel Assembly Only.



*34-03107
WORK JAW



*40262
WORK HOLDER ASSEMBLY

*5-13007
WORK HOLDING JAW ASSEMBLY

CODE NO. C-10-16

CM-9-5

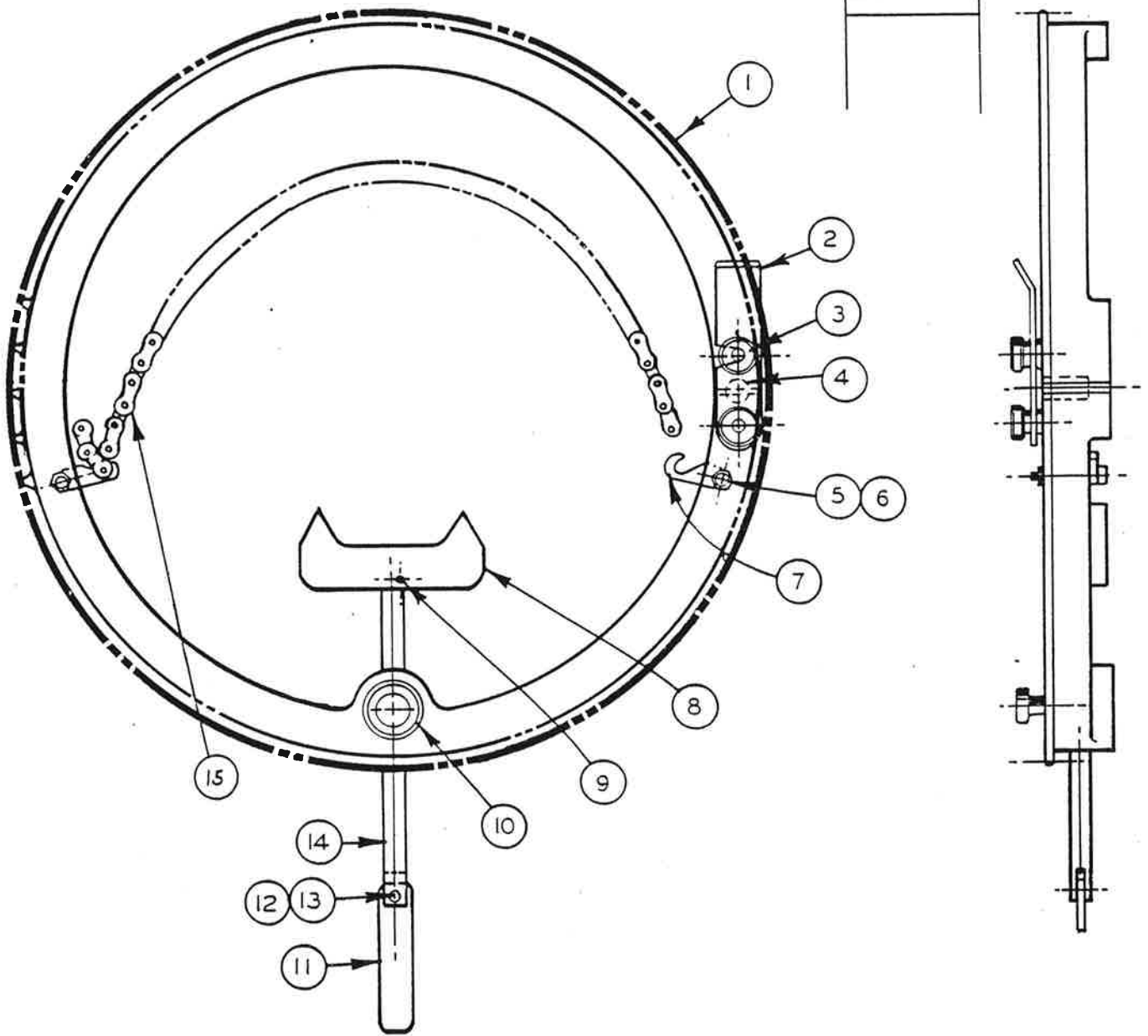
Z-9-9

WORK HOLDING JAW

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
REF.	134-031079	Work Jaw	
REF.	090-402629	Work Holder Assembly	
*1	105-133136	. Sprocket	2
2	091-986984	. Screw, Fil. Hd. Mach. #10-24NC x 1/2	4
3	090-203860	. Left Arm	1
4	091-982355	. Screw, Soc. Hd. Cap 1/4-20NC x 3/8	1
5	090-021627	. Knurled Screw	1
6	091-984104	. Screw, Soc. Hd. Set #10-24NC x 1/4	2
7	090-203852	. Right Arm	1
REF.	105-130074	Work Holding Jaw Assembly	
1	105-135123	. Handle	2
2	105-133185	. Handle Bracket	2
3	090-406786	. Work Holding Jaw Sub-Assembly	1
4	105-131106	. . Work Holding Jaw	1
*5	105-133136	. . Sprocket	2
6	091-988923	. . Screw, Rd. Hd. Mach. 1/4-20NC x 5/16	6
7	091-990150	. . Screw, Truss Hd. Mach. #10-24NC x 3/8	4

*NOTE: Before 2/12/44 On Hydraulic Machines Use #106-233372 Sprocket With 3/16" Pitch, Specify Pitch Of Chain When Ordering.

NEW DRG
S.W. 4-17-72
REVISIONS
SCL. 11-14-74
SW.5 - 13 - 77
SW.5-30-78



#403310
 CONTOUR FEED
 WORK HOLDING FIXTURE

C-3-77 CM-3-75
 G-7

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CONTOUR FEED WORK HOLDING FIXTURE

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	094-033107	Contour Feed Work Holding Fixture	
1	095-015160	. Clamping Ring	1
2	091-253328	. Clamp	1
3	091-339705	. Clamp Screw	2
4	090-130428	. Dowel	1
5	091-991117	. Nut, Hex. #10-24NC	2
6	091-982272	. Screw, Soc. Hd. Cap #10-24NC x 11/2	2
7	135-003291	. Chain Connector	2
8	091-253351	. Jaw	1
9	090-042557	. Roll Pin	1
10	091-253377	. Screw Feed Sub-Assembly	1
11	091-253385	. Handle	1
12	091-052639	. Belleville Washer	1
13	090-042516	. Roll Pin	1
14	091-253344	. Screw	1
15	091-253336	. Chain	1
	091-253401	. Chain Assembly (Not Shown)	1

