



SERVICE
COPIES

ILLUSTRATED PARTS LIST

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<p>IMPORTANT: WHEN ORDERING SPARES ALWAYS QUOTE MODEL AND MACHINE NUMBER</p>

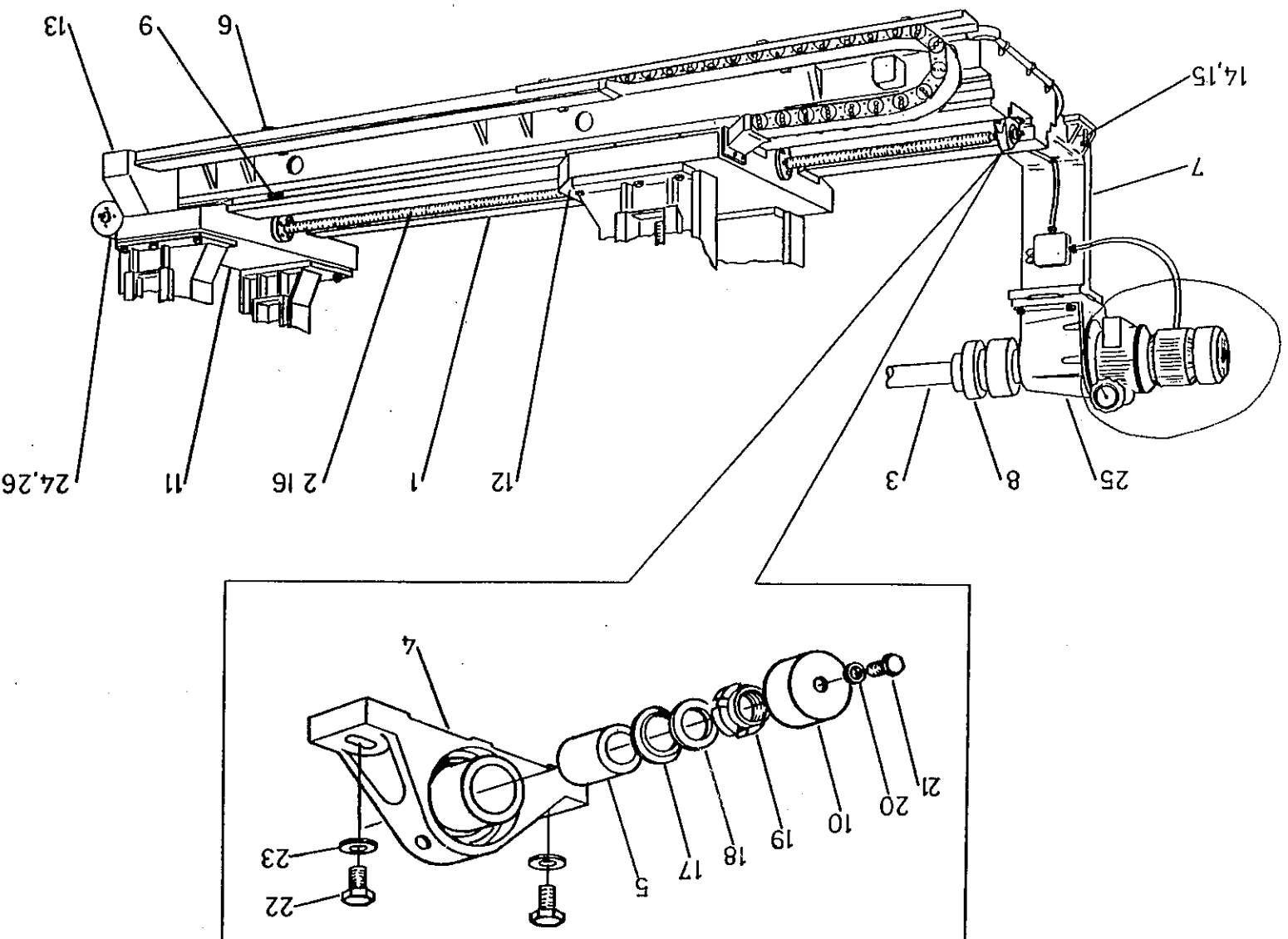


FIG 1 MACHINE BED



Ref	Description	No. off
1	MACHINE BED	
1	1.9 Metre Bed	1
	or	
	3.0 Metre Bed	1
	or	
	4.1 Metre Bed	1
2	1.9 Metre Traverse Screw	1
	or	
	3.0 Metre Traverse Screw	1
	or	
	4.1 Metre Traverse Screw	1
3	1.9 Metre Backshaft	1
	or	
	3.0 Metre Backshaft	1
	or	
	4.1 Metre Backshaft	1
4	Pillow Block Bearing 'RHP' NP35	1
5	Bush	1
6	Cable Runway Support	4
7	Feed Drive Plinth	1
8	Torque Limiter	1
9	Cam Plate	2
10	Cover for Traverse Screw	1
11	Fixed Carriage	1
12	Adjustable Carriage	1
13	Cable Connection Box	1
14	Hexagon Head Setscrew M16 x 80mm long	8
15	Lock Nut M16	8
16	Key 8mm x 7mm x 80mm (Traverse Screw Drive)	1
17	Disc Washer 40mm O/D x 20mm I/D x 2.5mm	1
18	Thrust Washer 'INA' WS 81104	1
19	Self Locking Nut M20 x 1.0p	1
20	Plain Washer M6	1
21	Hexagon Head Setscrew M6 x 25mm long	1
22	Hexagon Head Setscrew M12 x 45mm long	2
23	Large Plain Washer M12	2
24	Lenze Gearbox Type 05 / 80 52.114 (rear of bed)	1
25	'Simplatrol' Disco Feed Drive Unit	1
26	Traverse Motor 'Brook' DNV9OLD.1.1/0	1

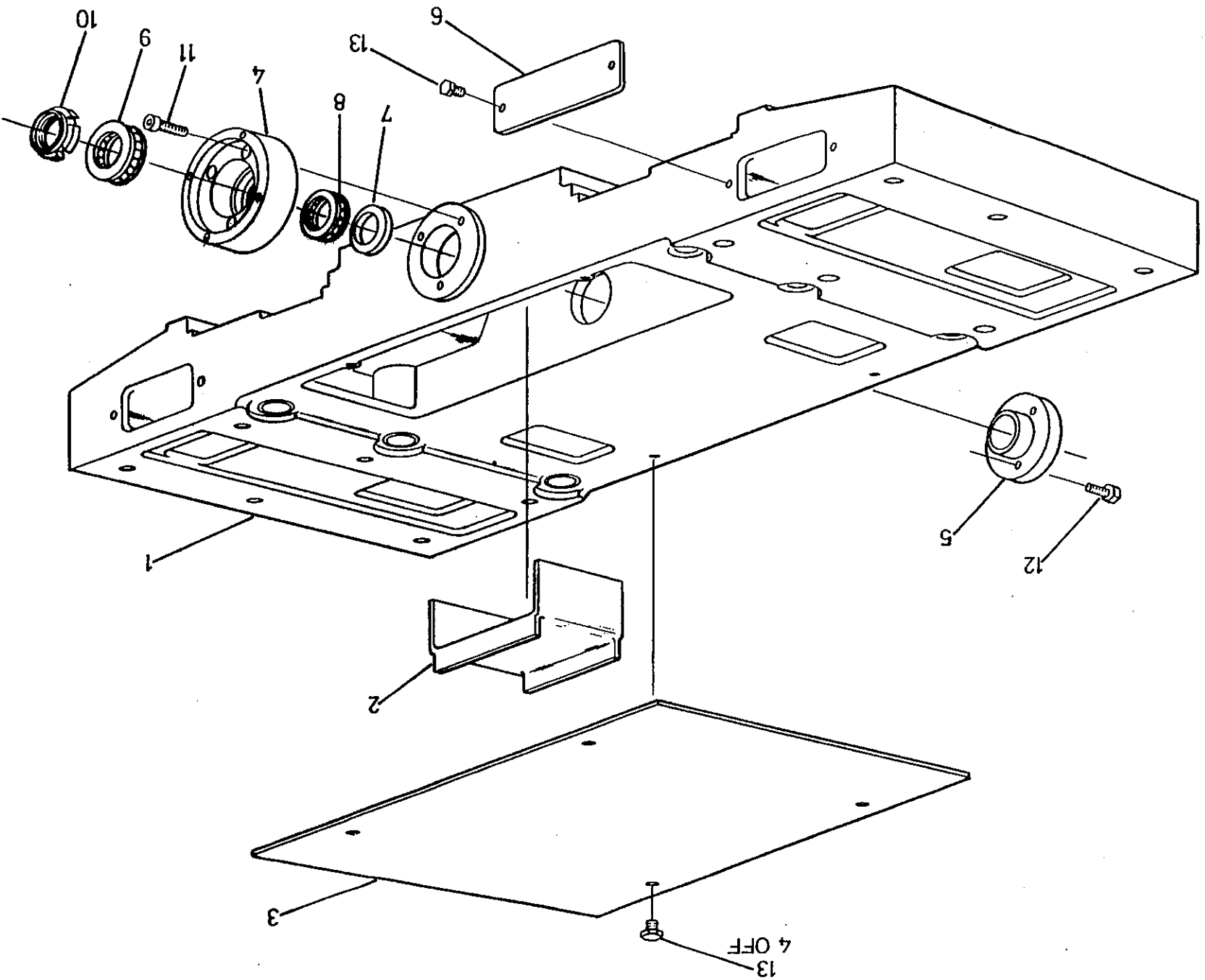


FIG 2 MIXED CARRIAGE

**2 FIXED CARRIAGE**

Ref	Description	No. Off
1	Fixed Carriage	1
2	Traverse Screw Cover	1
3	Cover	1
4	Gearbox Mounting Flange	1
5	Leadcrew Support	1
6	Cover	2
7	Bearing Bracket Ring	1
8	Thrust Bearing SKF 511106	1
9	Thrust Bearing SKF 51206	1
10	Self Locking Nut M30 x 1.5	1
11	Hexagon Socket Capscrew M10 x 30mm long	3
12	Hexagon Head Setscrew M10 x 30mm long	3
13	Hexagon Head Setscrew M6 x 12mm long	8

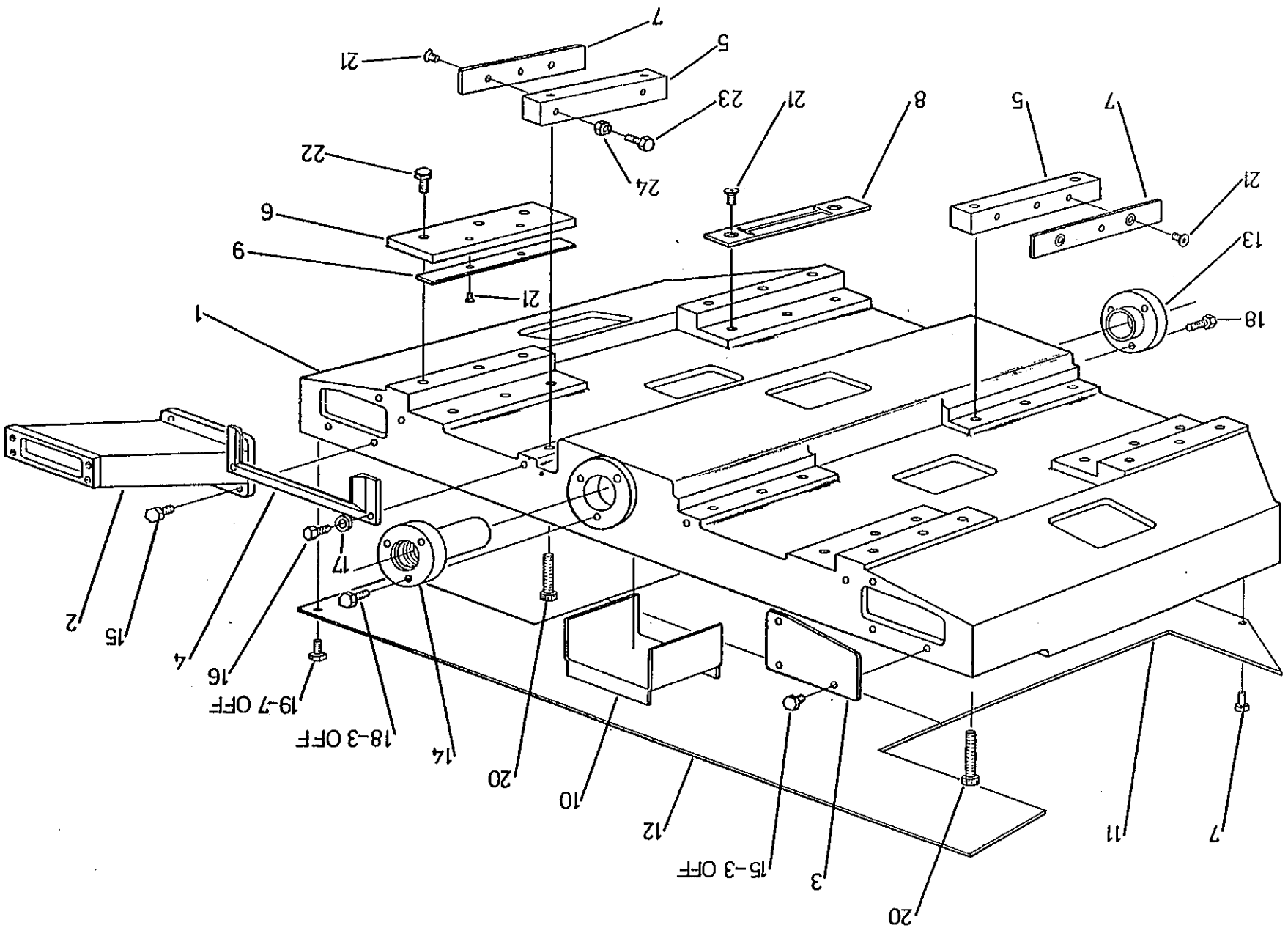


FIG 3 ADJUSTABLE CARRIAGE



3 ADJUSTABLE CARRIAGE

Ref	Description	No. Off
1	Adjustable Carriage	1
2	Cable Runaway Connector	1
3	Cover Plate	1
4	Slideway Wiper	4
5	Side Guide Block	4
6	Keep Plate	4
7	Side Guide Bearing	4
8	Bearing Plate	4
9	Keep Plate Bearing	4
10	Traverse Screw Cover	1
11	Cover	1
12	Cover	1
13	Leadscrew Support	1
14	Traverse Nut UVA 337	1
15	Hexagon Head Setscrew M8 x 16mm long	6
16	Hexagon head Setscrew M6 x 16mm long	8
17	Large Plain Washer M6	8
18	Hexagon Head Setscrew M10 x 30mm long	6
19	Hexagon Head Setscrew M6 x 12mm long	14
20	Hexagon Socket Capscrew M10 x 35mm long	8
21	Hexagon Socket Countersunk Capscrew M4 x 8mm long	24
22	Hexagon Head Setscrew M12 x 25mm long	12
23	Hexagon Head Setscrew M10 x 35mm long	4
24	Nut M10	4

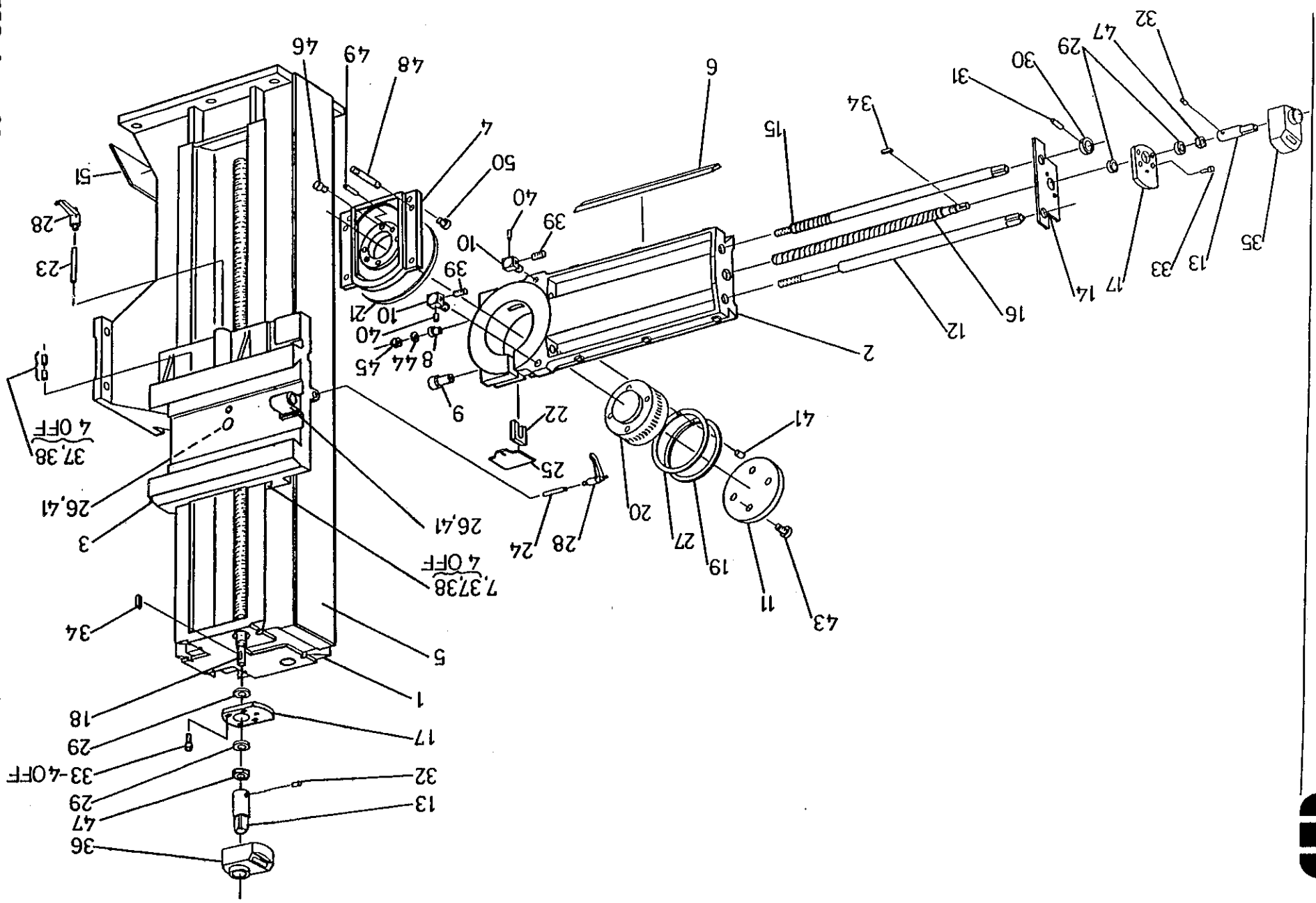


FIG 4 COLUMN AND HEAD



Ref	Description	No. Off
4	COLUMN AND HEAD	
1	Column	1
2	Head Slide L.H. (Shown)	1
	or	
	Head Slide R.H.	1
3	Back Slide L.H. (Shown)	1
	or	
	Back Slide R.H.	1
4	Motor Mounting Plate (standard shown)	1
	or	
	Motor Mounting Plate for use with head mounted scorer	1
5	Column Cover	1
6	Horizontal Gib for Head Slide	1
7	Vertical Gib for Head Slide	1
8	Bush	1
9	Locking Screw Nut <small>6.000 151</small>	1
10	Adjustable Stop	2
11	Hub Clamp Plate	1
12	Locking Screw <small>6.000 156</small>	1
13	Adaptor	2
14	Traverse and Lock Scale L.H. (Shown)	1
15	traverse and Lock Scale R.H.	1
16	Worm Shaft	1
17	Horizontal Leadscrew	1
18	Thrust Plate	2
19	Vertical Leadscrew	1
20	Hub Thrust Bearing	1
21	Hub/Worm Wheel <small>6.000 152</small>	1
22	Cant Scale	1
23	Rubber Insert	1
24	Clamping Slug	1
25	Clamping slug	1
26	Canting Scale Marker	1
27	Back Slide Nut	2
	Shims	
28	Bristol Handle M10	2
29	Thrust Bearing 'SKF' 51102	4
30	Collar 20mm I/D x 32mm O/D x 14mm	1
31	Tension Pin dia 6mm x 32mm long	1
32	Socket Head Grubscrew M6 x 6mm long	2

As required

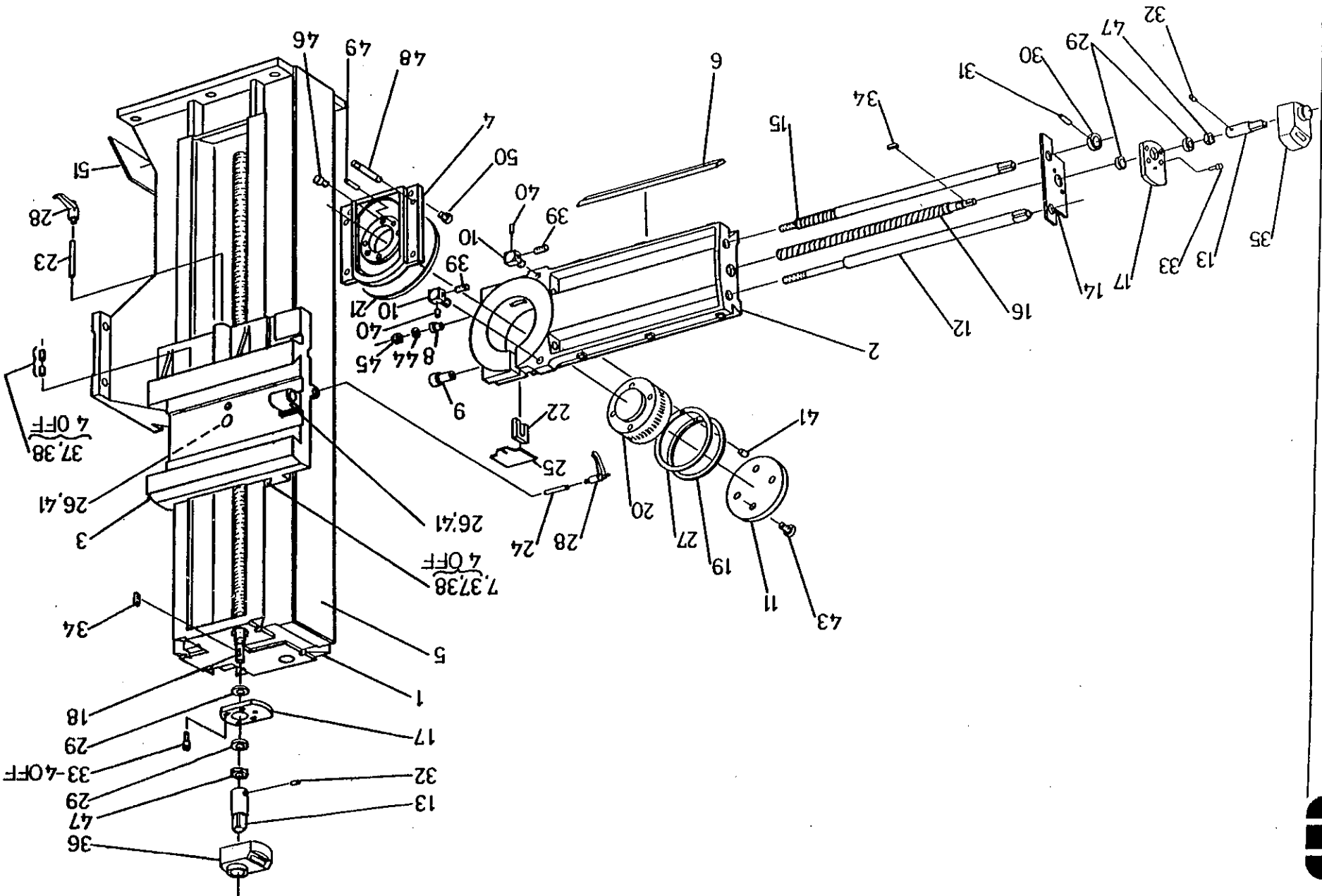


FIG 4 COLUMN AND HEAD



4 COLUMN AND HEAD - CONT.....

Ref	Description	No. Off
33	Hexagon Socket Capscrew M6 x 16mm long	6
34	Key 4mm x 4mm x 20mm	2
35	'SIKO' Dial Indicator 0902E 4mm	1
36	'SIKO' Dial Indicator 0904I 4mm (when used as a top head)	1
	or	
	'SIKO' Dial Indicator 0902E 4mm (When used on bottom head)	1
37	Hexagon Socket Nyloc Grubscrew M10 x 20mm long	8
38	Clamping Slug	8
39	Hexagon Socket Grubscrew M6 x 25mm long	2
40	Hexagon Socket Grubscrew M6 x 6mm long	2
41	Hexagon Socket Butt Screw M8 x 20 long	2
42	Locating Pin dia 6mm	1
43	Hexagon Socket Capscrew M8 x 20mm long	4
44	Plain Washer M12	1
45	Locknut M12 x 1.0 pitch	1
46	Hexagon Socket Capscrew M8 x 25mm long	4
47	Locknut M15 x 1.0 pitch	1
48	Special Stud for Motor Fixing	4
49	Tension Pin dia 8mm x 24mm long	2
50	Hexagon Socket Capscrew M10 x 12mm long	2
51	Cover	1

Note: Except for items 1, 5 and 51 quantities are per head

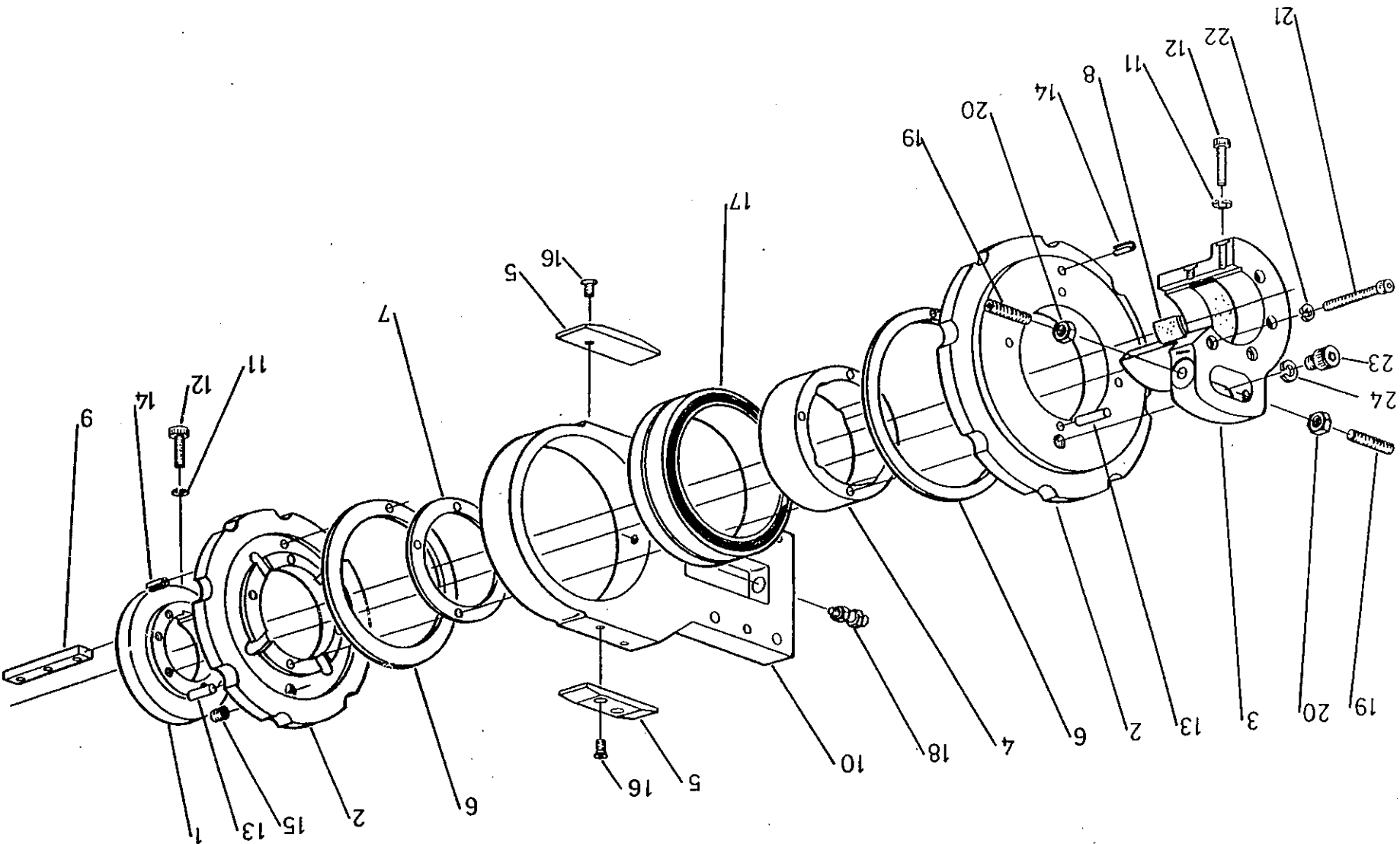


FIG 5 DRIVEN SPROCKET



5 DRIVEN SPROCKET

Ref	Description	No. Off
1 WAA 118	Feed Chain Sprocket Clamp Plate 2	1
- 2	Feed Chain Sprocket	2
3 WAA 107	Feed Chain Drive Hub 2	1
- 4	Feed Chain Sprocket Hub	1
X5 WAA 208	Chordal Action Guides 8	2 WAA 208
- 6	Sprocket Thrust Ring	2 WAA 231
- 7	Feed Chain Sprocket Shims	As required X
8 WAA 283	Strip Bearing 2	1
9 WAA 123	Feed Chain Sprocket Key WAA 123 2	1
10 WAA 113	Feed Chain Sprocket Mounting Plate	1
11 KOS28153	Spring Washer M6 4	2
12 KOS25170	Hexagon Socket Capscrew M6 x 40mm long 4	2
13 KOS28129	Dowel dia 6mm x 20mm long 8	8
14 KOS20474	Tension Pin dia 4mm x 10mm long 4	2
15 KOS26130	Hexagon Socket Grubscrew M10 x 10mm long 2	1
X16 KOS25321	Hexagon Socket Countersunk Screw M6 x 12mm long 16	4
17 KDL13120	Roller Bearing 'INA' NA-4828	1
18 K2002633	Non Return Oil Flow Unit 2	1
19 KOS26174	Hexagon Socket Grubscrew M8 x 30mm long 4	2
20 KOS27109	Locknut M8 4	2
21 KOS25199	Hexagon Socket Capscrew M8 x 80mm long 12	6
22 KOS28154	Spring Washer M8 12	6
23 KOS25206	Hexagon Socket Capscrew M10 x 12mm long 2	1
24 KOS28155	Spring Washer M10 2	1

NOTE: Quantities are per assembly

~~X~~ WAA 209 0.001"
WAA 210 0.002"
WAA 211 0.003"
WAA 212 0.005"
WAA 213 0.010"

} for item 5.

- ITEM 7
- WAA 274
 - 275
 - 276
 - 277
 - 278

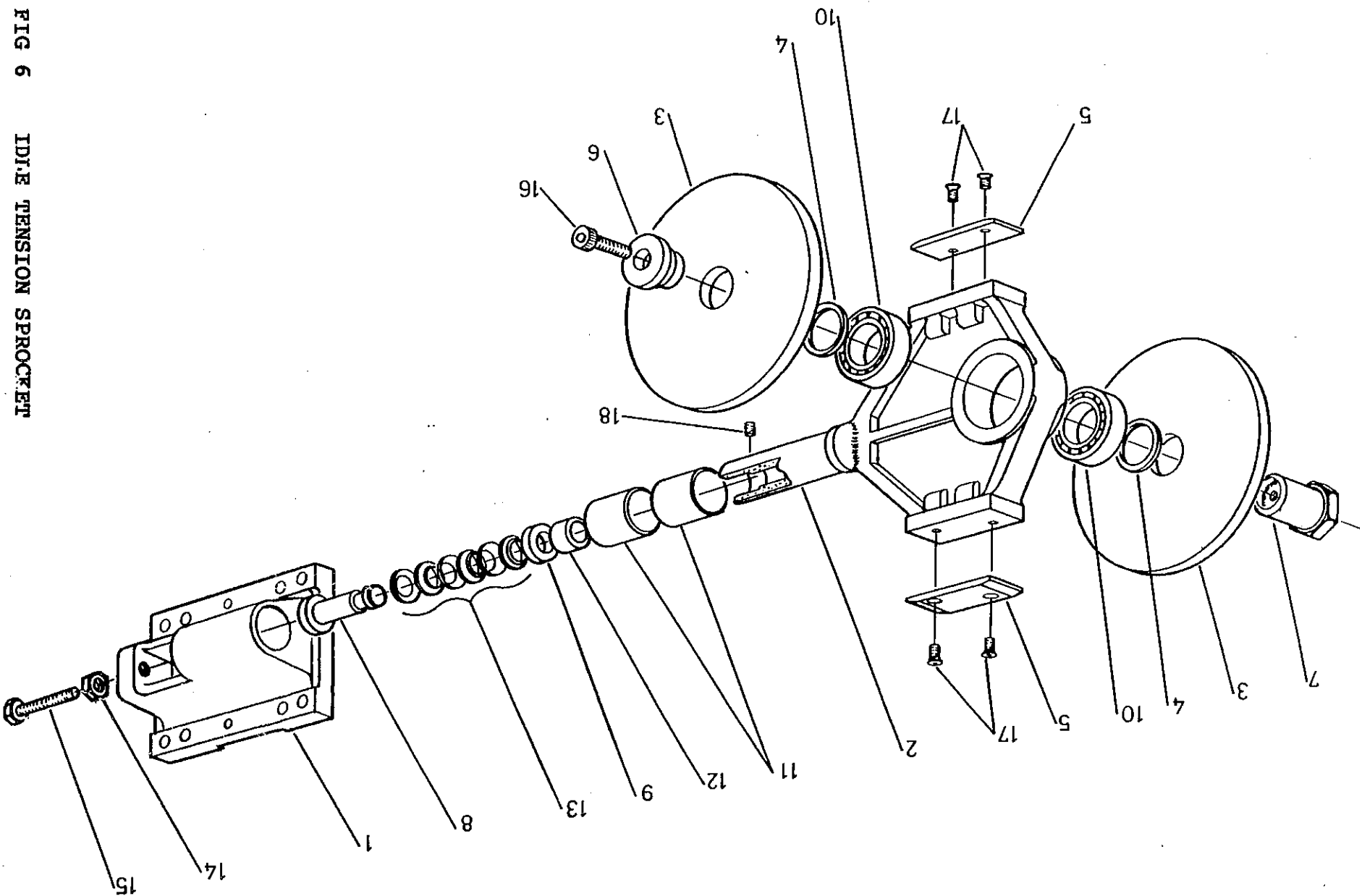


FIG 6 IDLER TENSION SPROCKET



6 IDLE TENSION SPROCKET

Ref	Description	No. Off
1 WJMA 114	Feed Chain Tension Bracket 2	1
2 WJMA 115	Feed Chain Front Sprocket Bracket 2	1
3 WJMA 117	Front Idler Sprocket	2
-4 WJMA 122	Idler Sprocket Spacer	2
X 5 WJMA 208	Chordal Action Guides	2
6 WJMA 121	Idler Sprocket Spindle Clamp 2	1
7 WJMA 120	Idler Sprocket Spindle 2	1
8 WJMA 336	Feed Chain Tension Spindle 2	1
9 WJMA 206	Feed Chain Tension Spindle Washer 2	1
-10 -	Ball Bearing 'SKF' 6008 2RS	2
11 KOS 31640	Bush 46mm O/D x 40mm I/D x 50mm long 4	2
12 KOS 31576	Bush 25mm O/D x 20mm I/D x 25mm long 2	1
13 K3073484	Disc Spring (Stacked in Series) 1 2	6
14 KOS 27104	Nut M12 2	1
15 KOS 25235	Hexagon Head Setscrew M12 x 50mm long 12	1
16 KOS 25232	Hexagon Socket Capscrew M12 x 35mm long 2	1
X 17 KOS 25164	Hexagon Socket Countersunk Screw M6 x 12mm long	4
18 KOS 26161	Socket Head GrubscREW M6 x 10mm long 2	1

NOTE: Quantities are per assembly

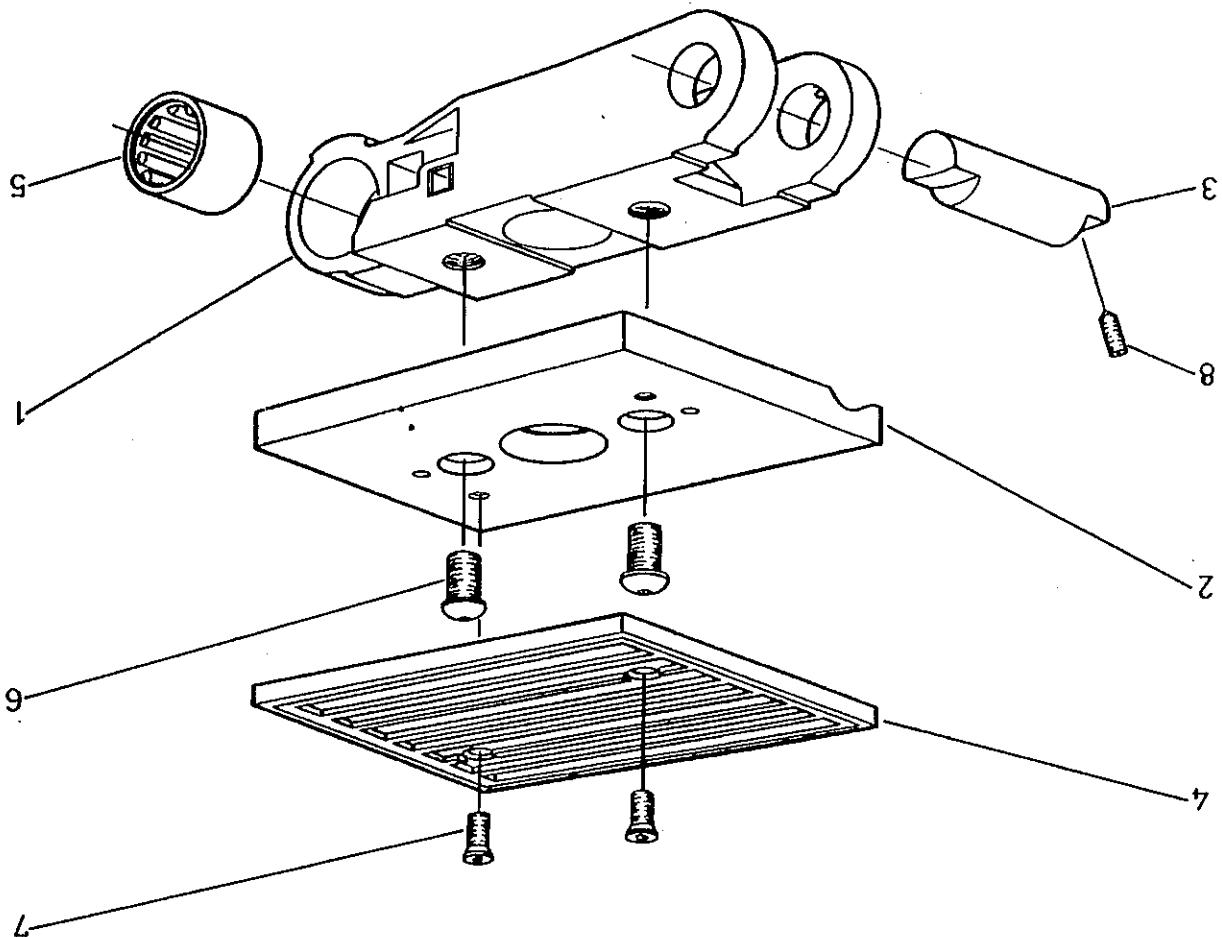


FIG 7 PLAIN CHAIN LINK



ILLUSTRATED PARTS LIST

SECTION 5

7 PLAIN CHAIN LINK

Ref	Description	No. Off
1	Chain Link	1
2	Guide Pad WAA 178.	1
3	Chain Axle	1
4	Top Guide Pad (Rubber) WAA 158/159 <i>without hole</i>	1
	Top Guide Pad (Steel) <i>with hole</i>	1
5	Needle Roller Bearing 'INA' HK2016 2RS	1
6	Hexagon Socket Button Head Screw M8 x 20mm long	2
7	Hexagon Socket Countersunk Screw M6 x 12mm long	2
8	Hexagon Socket Nyloc Dog Point Grubscrew M6 x 12mm long	1

1K 3072836

NOTE: Quantities are per link

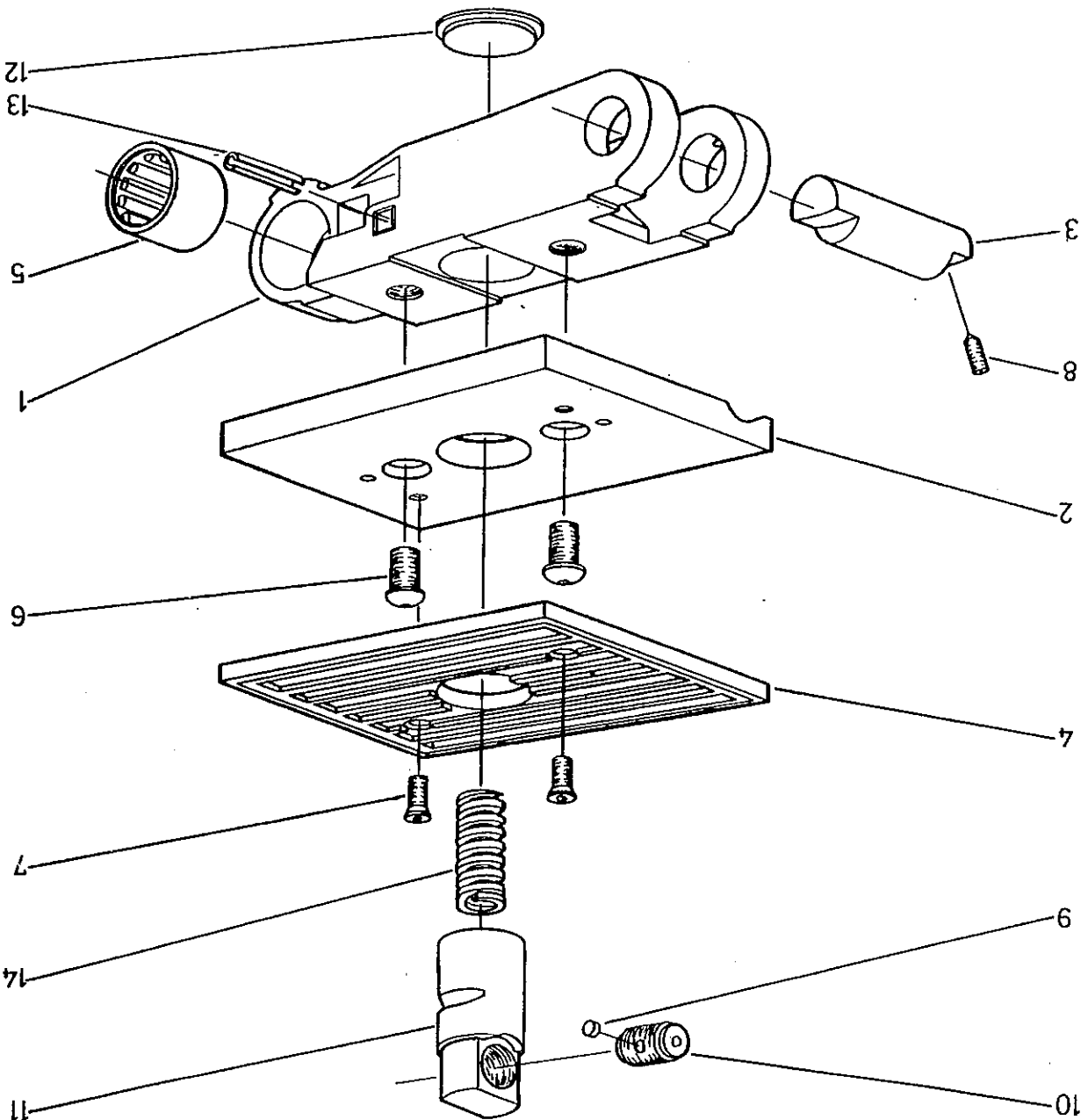


FIG 8 DISAPPEARING DOG CHAIN LINK



8 DISAPPEARING DOG CHAIN LINK *CHAIN*

Ref	Description	No. Off
1✓	Chain Link <i>WAA 178</i> WAA 178 530	1
2✓	Guide Pad <i>WAA 178</i>	1
3✓	Chain axle <i>WAA 341</i>	1
4	Top Guide Pad (Rubber) <i>WA 159</i>	1
5✓	✓ Top Guide Pad (Steel) <i>WA, 161</i>	1
6✓	Needle Roller Bearing 'INA' HK2016 2RS <i>W06.15.140</i>	1
7✓	Hexagon Socket Button Head Screw M8 x 20mm long	2 <i>K3072971</i>
8✓	Hexagon Socket Countersunk Screw M6 x 12mm long	2 <i>K052532+</i>
	Hexagon Socket Nyloc Dog Point Grubscrew <i>K3072886</i>	1
	M6 x 12mm long	1
	Nyloc Insert <i>WAA 518</i>	1
* 9	Adjusting Screw <i>WAA 178</i>	1
* 10✓	Disappearing Dog <i>WAA 570</i>	1
11✓	Washer <i>WASHER DP 18+</i> * <i>WAA 541</i>	1
12✓	Tension Pin dia 6mm x 32mm long <i>K0520526</i>	1
13✓	Compression Spring 'Entex' ETS 93 <i>K7077964</i>	1
14✓		1

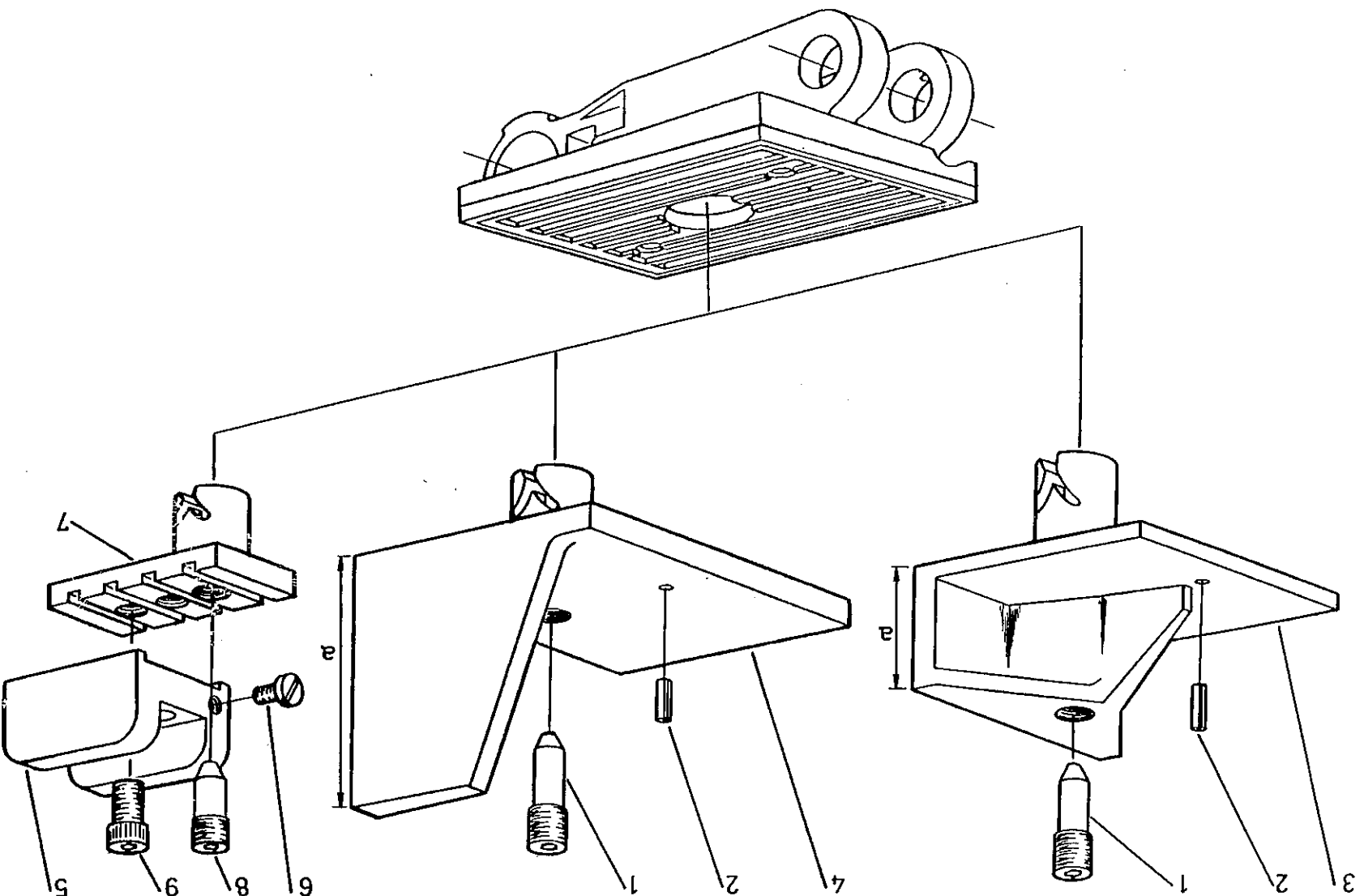


FIG 9 FLAT BACK, FINGER AND TRAPPING DOGS

**9 FLAT BACK, FINGER AND TRAPPING DOGS**

Ref	Description	No. Off
1	Clamp Screw	
2	Tension Pin dia 6mm x 12mm long	
3	Flat Back Dog	
4	Finger Dog	
5	Trapping Dog Adjuster	
6	Adjusting Screw for Trapping Dog	
7	Trapping Dog Body	
8	Clamp Screw	
9	Hexagon Socket Capscrew M12 x 25mm long	

NOTE: When ordering 'Flat Back or 'Finger Dogs' quote height 'a' of dog

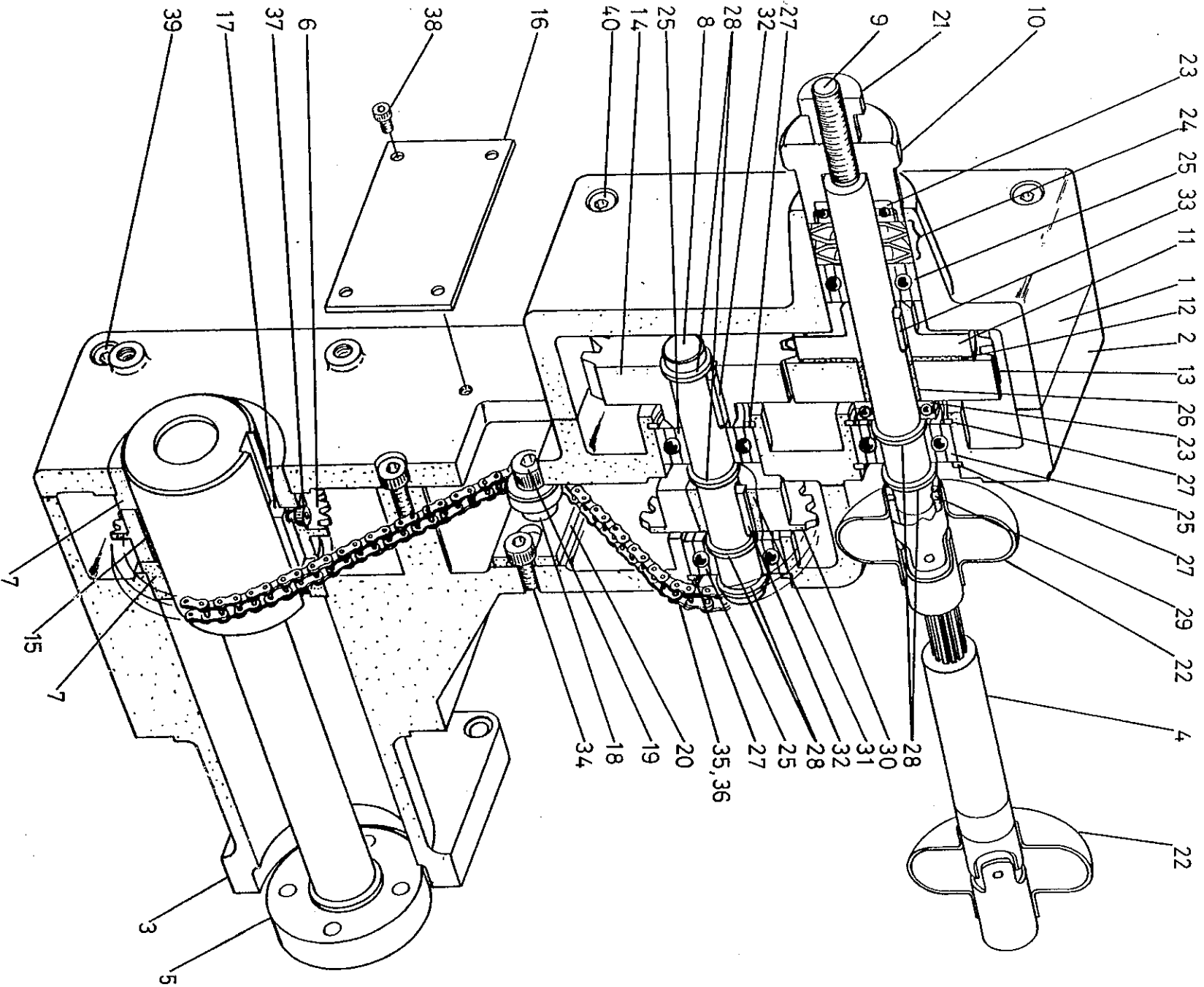


FIG 10 TOP PRESSURE DRIVE UNIT ASSEMBLY



10 TOP PRESSURE DRIVE UNIT ASSEMBLY

Ref	Description	No. Off
1	Front Drive Housing	1
2	Intermediate Housing	1
3	Drive Housing	1
4	Telescopic Drive Shaft WAA410	1
5	Backshaft Extension	1
6	Chain Wheel	1
7	Backshaft Bush	2
8	Gear Shaft	1
9	Clutch Shaft (with left or right hand thread)	1
10	Top Pressure Drive Adjusting Nut (left or right hand thread)	1
11	Clutch Plate	1
12	Clutch Pad	1
13	Driven Gear	1
14	Drive Gear	1
15	Strip Bearing	1
16	Cover for Tensioner Access	1
17	Drive Key	1
18	Tensioner Wheel	1
19	Pivot Pin WAA 405	1
20	Chain Tensioner WAA 408	1
21	Top Pressure Drive Lock Nut (left or right hand thread)	1
22	'HUCO' Gaiter Type T Size 32 K303214	2
23	Thrust Bearing 'RHP' 51105	2
24	Disc Spring 50mm O/D x 25.4mm I/D x 15mm	4
25	Ball Bearing 'RHP' 6205-2RS	4
26	Bush 30mm O/D x 25mm I/D x 20mm long	1
27	Internal Circlip dia 52mm	4
28	External Circlip dia 25mm	6
29	Taper Pin	1
30	Sprocket 'Fenner' 41-21	1
31	Taper Lock Bush 1610 25mm	1
32	Key 8mm x 7mm x 25mm	2
33	Key 8mm x 7mm x 20mm	1
34	Hexagon Socket Capscrew M8 x 16mm long	1
35	Connection link No. 26 110046 CHN	1

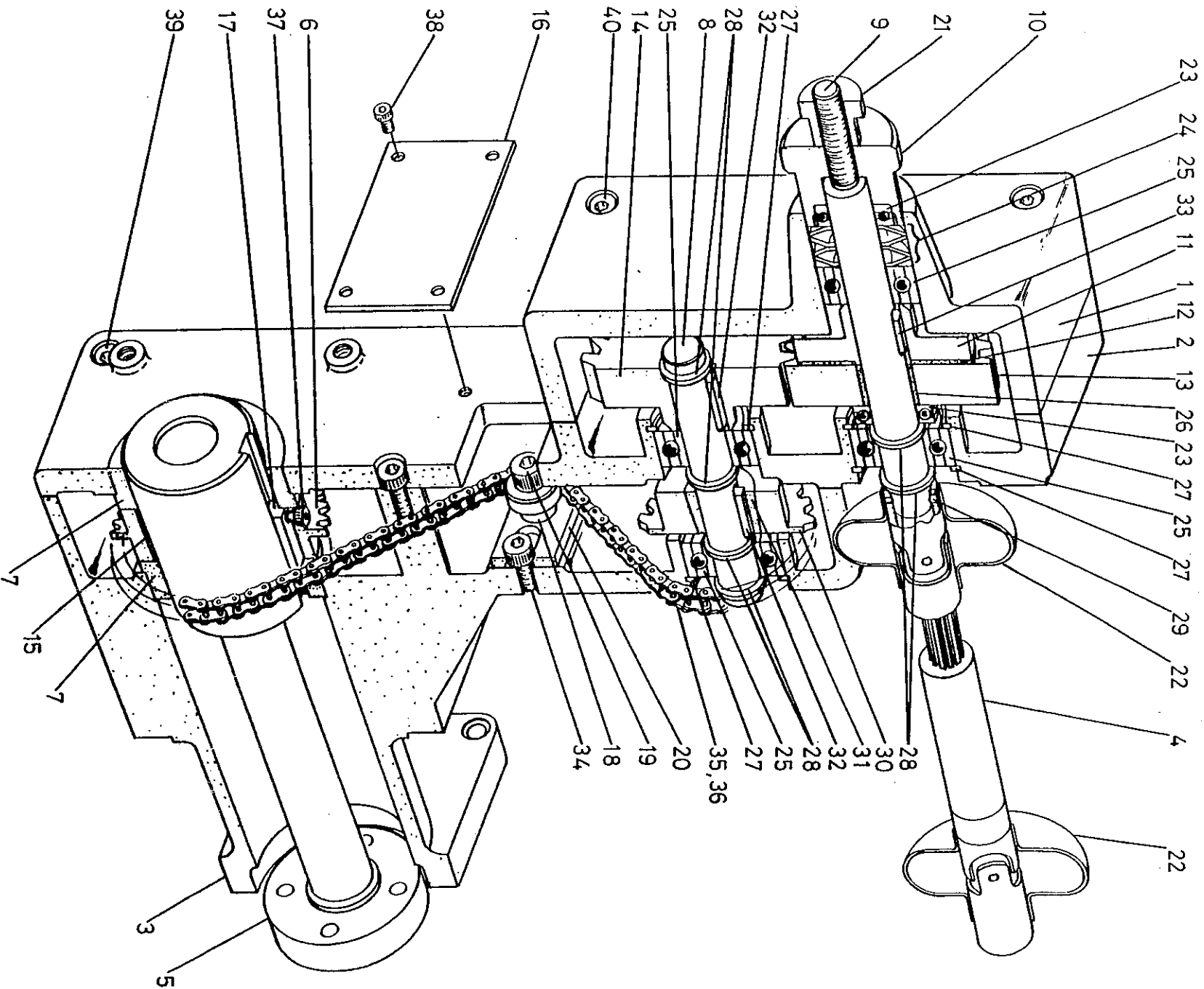


FIG 10 TOP PRESSURE DRIVE UNIT ASSEMBLY



ILLUSTRATED PARTS LIST

SECTION 5

10 TOP PRESSURE DRIVE UNIT ASSEMBLY Cont

Ref	Description	No. Off
36	Chain 1/2" pitch 68 links	1 1 301044
37	Hexagon Socket Capscrew M5 x 16mm long	1
38	Hexagon Socket Capscrew M4 x 8mm long	4
39	Hexagon Socket Capscrew M8 x 20mm long	3
40	Hexagon Socket Capscrew M8 x 60mm long	4

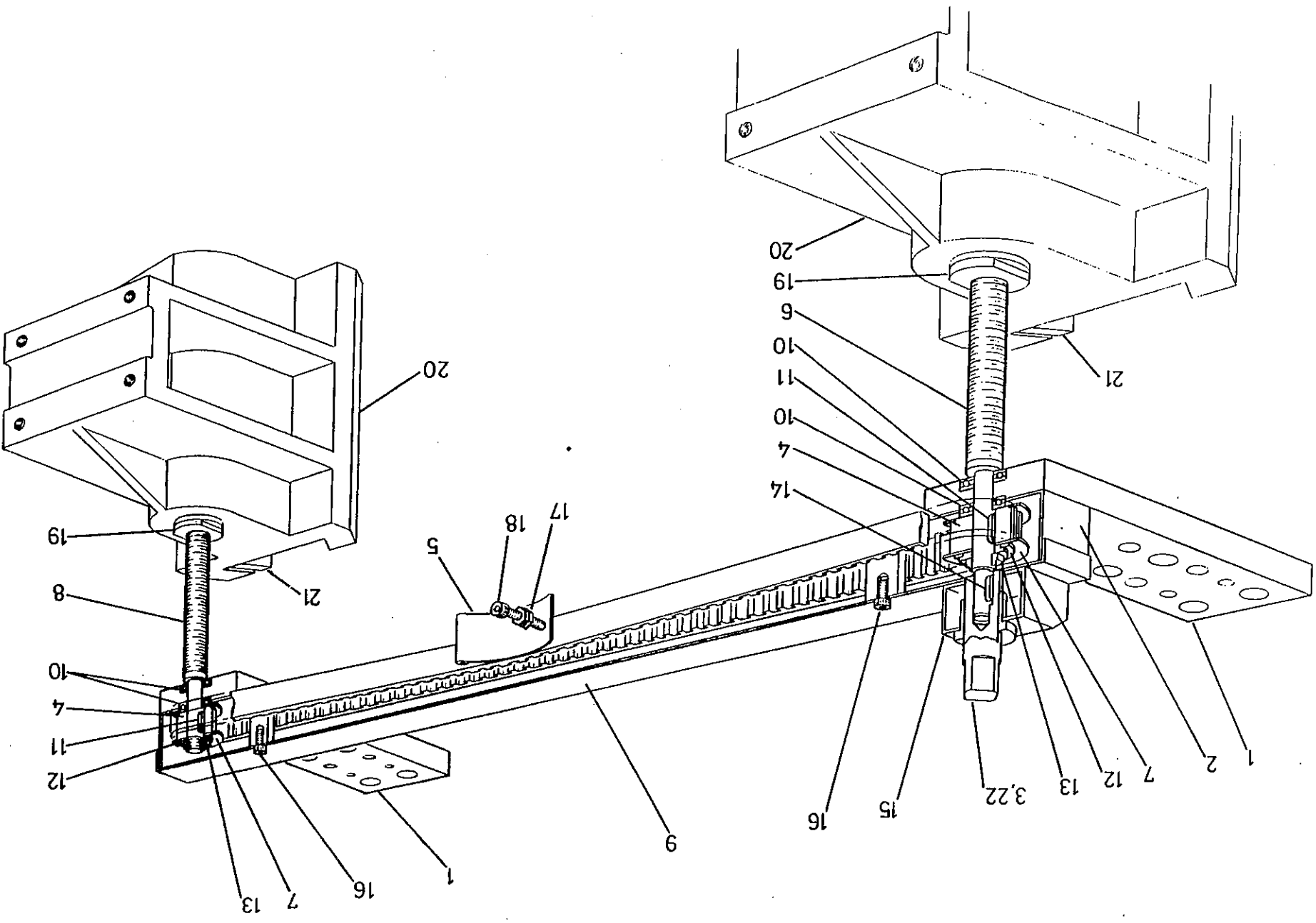


FIG 11 TOP PRESSURE ADJUSTMENT - DOUBLE COLUMN



11 TOP PRESSURE ADJUSTMENT - DOUBLE COLUMN

Ref	Description	No. Off
1	Top Pressure Anchor Plate	2
2	Dual drive Box	1
3	Handle Adaptor	1
4	Timing Pulley	2
5	Top Pressure Belt Adjuster	1
6	Top Pressure Leadscrew	1
7	Timing Pulley Flange	2
8	Top Pressure Leadscrew	1
9	Dual Drive Box Cover	1
10	Thrust Bearing 'SKF' 51102	4
11	Key 5mm x 5mm x 20mm	2
12	External Circlip dia 30mm	2
13	Special Locking Nut M15 x 1.0p	2
14	Key 4mm x 4mm x 20mm	1
15	'SIKO' Digital Readout 0904:1 (Imperial or Metric)	1
16	Hexagon Socket Capscrew M6 x 12mm long	2
17	Lock Nut M6	1
18	Hexagon Socket Capscrew M6 x 50mm long	1
19	Nut Insert	2
20	Top Pressure Slide (Fixed side movement - See No. 13 for Adjustable side movement)	2
21	Gib Strip for slide	2
22	Hexagon Socket Grubscrew M6 x 6mm long	1

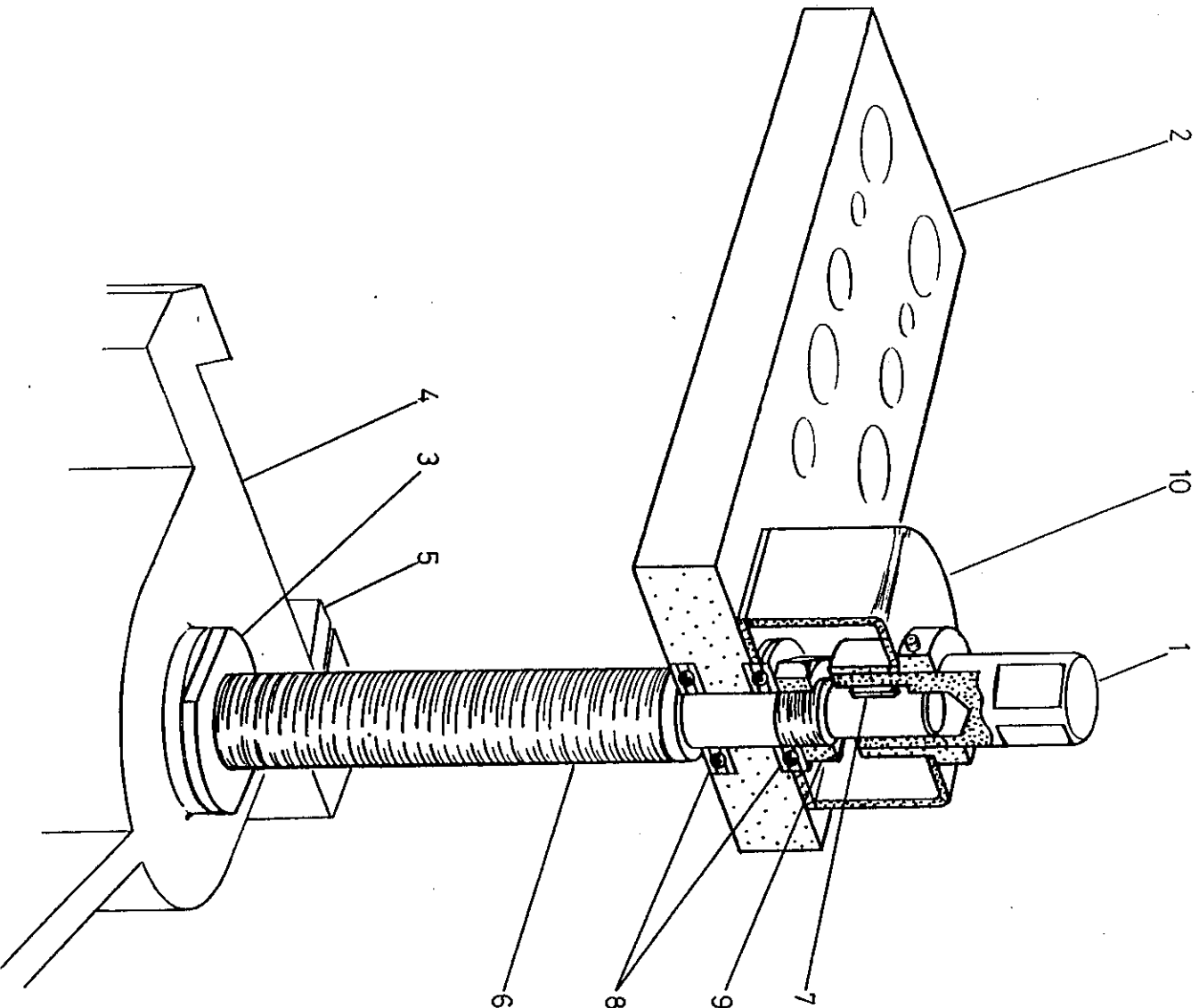


FIG 12 TOP PRESSURE ADJUSTMENT - SINGLE COLUMN



12 TOP PRESSURE ADJUSTMENT - SINGLE COLUMN

Ref	Description	No. Off
1	Square Adaptor	1
2	Top Pressure Anchor Plate	1
3	Rise and Fall Nut Insert	1
4	Top Pressure Slide (Fixed side movement - See No. 13 for Adjustable Side Movement)	1
5	Gib Strip for Slide	1
6	Top Pressure Lead Screw	1
7	Key 4mm x 4mm x 20mm	1
8	Thrust Bearing 'SKF' 51102	2
9	Special Locking Nut M15 x 1.0p	1
10	'SIKO' Digital Readout 0904:1 (Imperial or Metric)	1

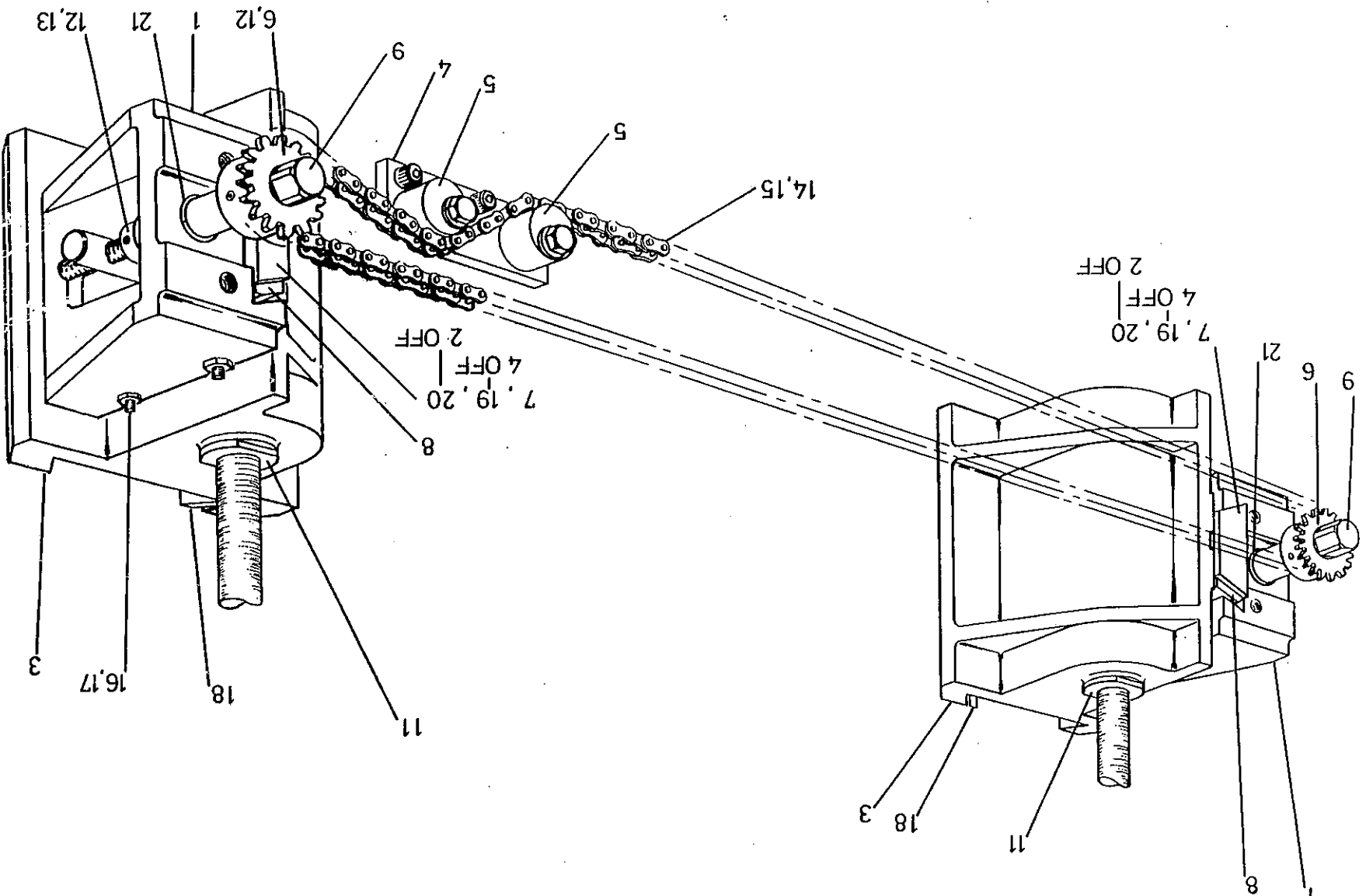


FIG 13 SIDE ADJUSTMENT - NCP PRESSURES



13 SIDE ADJUSTMENT - TOP PRESSURES

Ref	Description	No. Off
1	Top Pressure Adjustment Slide R.H.	1
2	Top Pressure Adjustment Slide L.H.	1
3	Top Pressure Slide	2
4	Tensioner Plate	1
5	Chain Tensioner	2
6	Sprocket	2
7	Top Pressure Adjustment Slideway	2
8	Gib Strip	2
9	Screw	2
10	Slide Nut	2
11	Rise and Fall Nut Insert	2
12	Collar 25mm O/D, 12mm I/D	2
13	Hexagon Socket Grubscrew M6 x 6mm long	4
14	Chain 3/8" pitch 197 pitches	1
15	Chain Connecting Link	1
16	Hexagon Socket Grubscrew M10 x 35mm long	4
17	Locknut M10	4
18	Gib Strip	2
19	Hexagon Socket Capscrew M10 x 30mm long	8
20	Tension Pin dia 8mm x 40mm long	4
21	Plain Washer M12	2

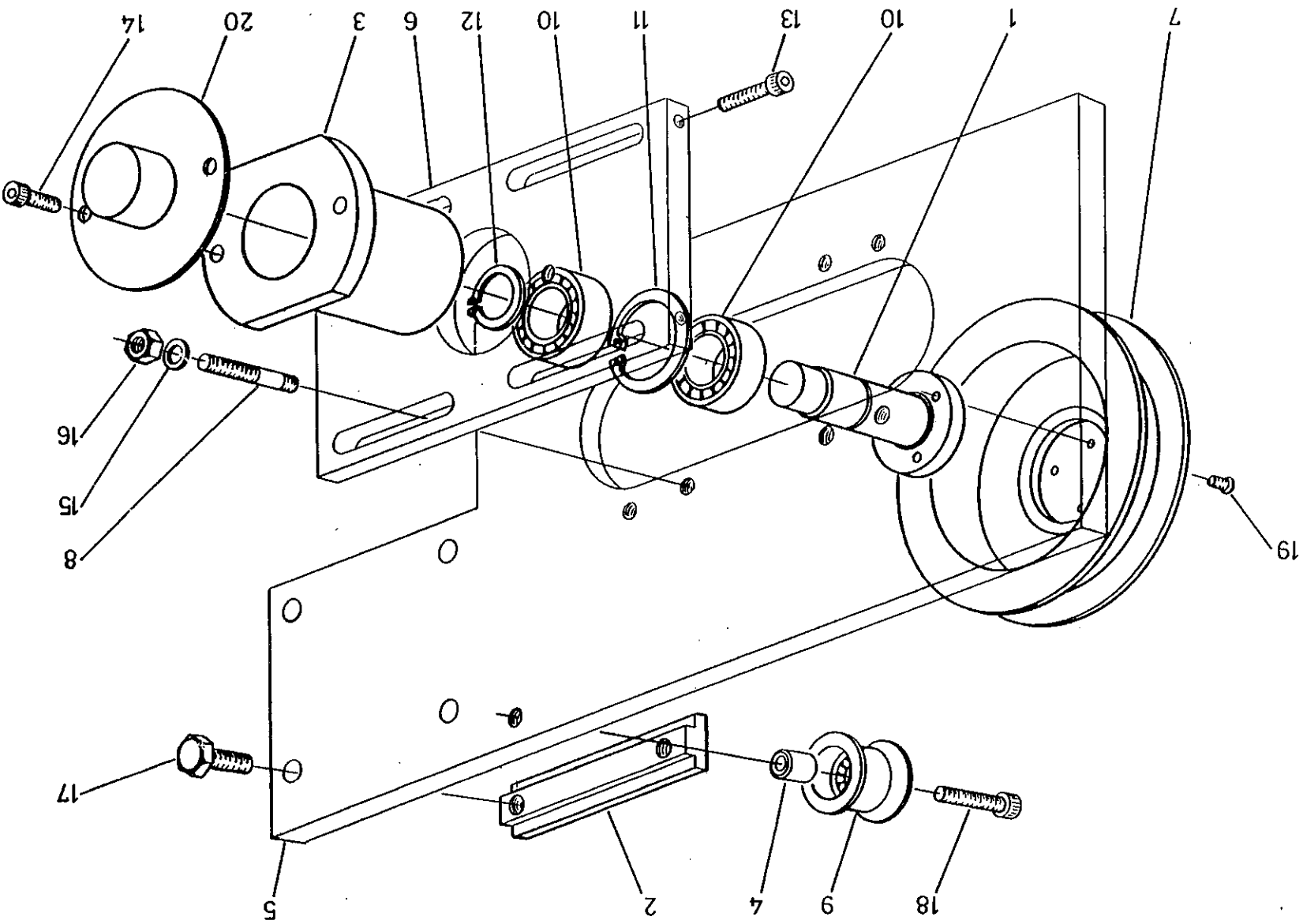


FIG 14 REAR PULLEY - 'V' BELT TOP PRESSURE

14 REAR PULLEY - 'V' BELT TOP PRESSURE

Ref	Description	No. Off
1	Spindle	1
2	Tee Bar	2
3	Spindle Housing	1
4	Idle Roller Spacer	1
5	Rear Plate	1
6	Tension Plate	1
7	Pulley	1
8	Special Stud M10 x 50mm long	4
9	Top Pressure Roller (only available complete with bearing)	1
10	Ball Bearing 'SKF' 6205 - 2RS	2
11	Internal Circlip dia 52mm	1
12	External Circlip dia 25mm	1
13	Hexagon Socket Capscrew M6 x 50mm long	2
14	Hexagon Socket Capscrew M8 x 20mm long	2
15	Plain Washer M10	4
16	Nut M10	4
17	Hexagon Head Setscrew M10 x 25mm long	4
18	Hexagon Socket Capscrew M10 x 45mm long	1
19	Hexagon Socket Countersunk Screw M6 x 10mm long	3
20	Drive Shaft Cover (Not fitted if top pressure are driven)	1

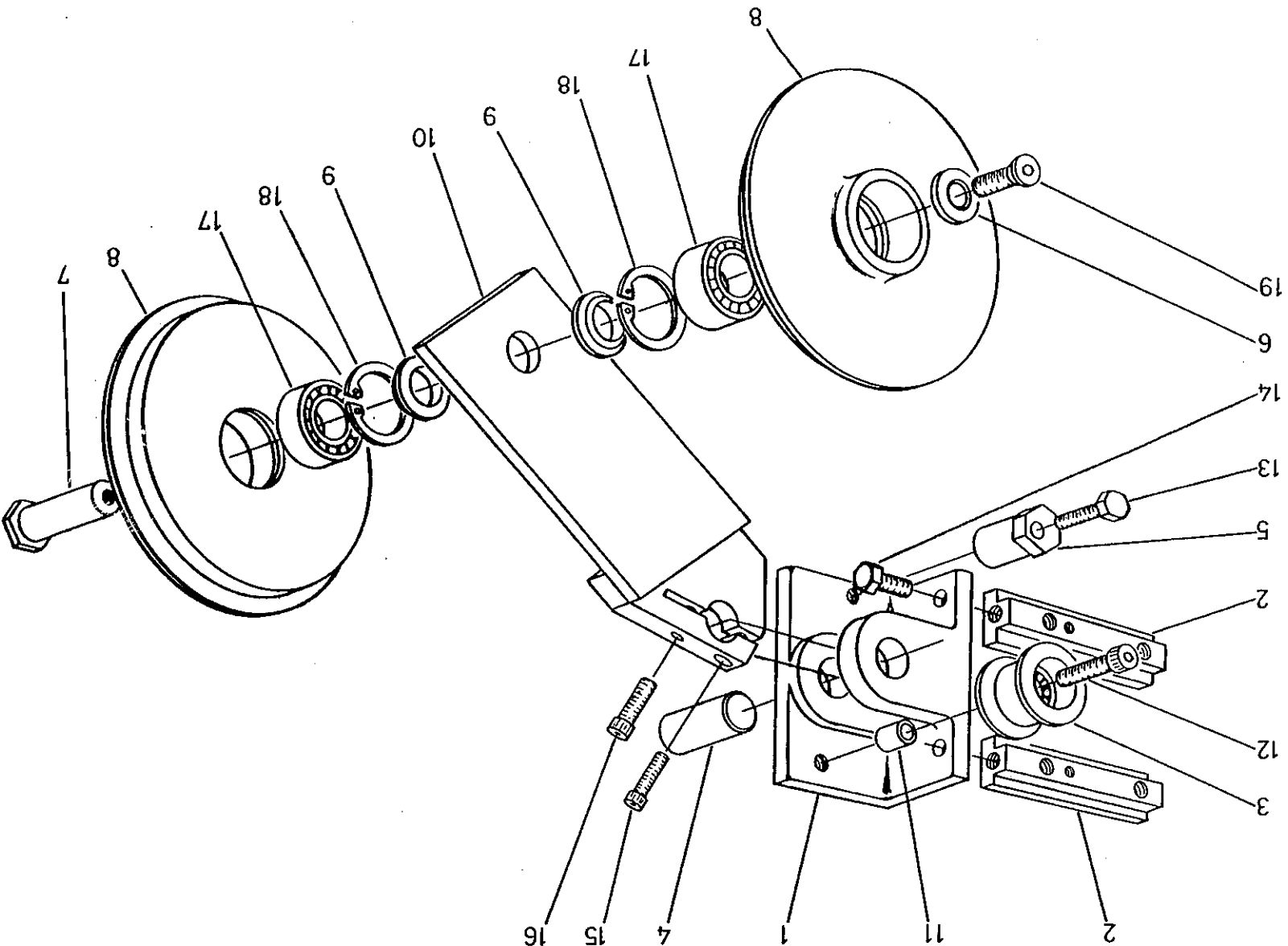


FIG 15 FRONT PULLEY - 'V' BELT TOP PRESSURE



15 FRONT PULLEY - 'V' BELT TOP PRESSURE

Ref	Description	No. Off
1	Pivot Bracket (left hand as shown or right hand)	1
2	Tee Bar	2
3	Top Pressure Roller (complete with bearing)	1
4	Pivot Pin	1
5	Stop Bar	1
6	Bearing Retaining Washer	1
7	Bearing Pin	1
8	Front Pulley Half	2
9	Bearing Spacer	2
10	Pivot Arm (left hand as shown or right hand))	1
11	Idle Roller Spacer	1
12	Hexagon Socket Capscrew M10 x 35mm long	1
13	Hexagon Head Setscrew M8 x 40mm long	1
14	Hexagon Head Setscrew M8 x 20mm long	2
15	Hexagon Socket Capscrew M6 x 25mm long	1
16	Hexagon Socket Capscrew M8 x 40mm long	1
17	Ball Bearing 'SKF', 6004 - 2RS	2
18	Internal Circlip dia 42mm	2
19	Hexagon Socket Head Countersunk Screw M8 x 20mm long	1



LH K30739160
RH ~~K30739161~~

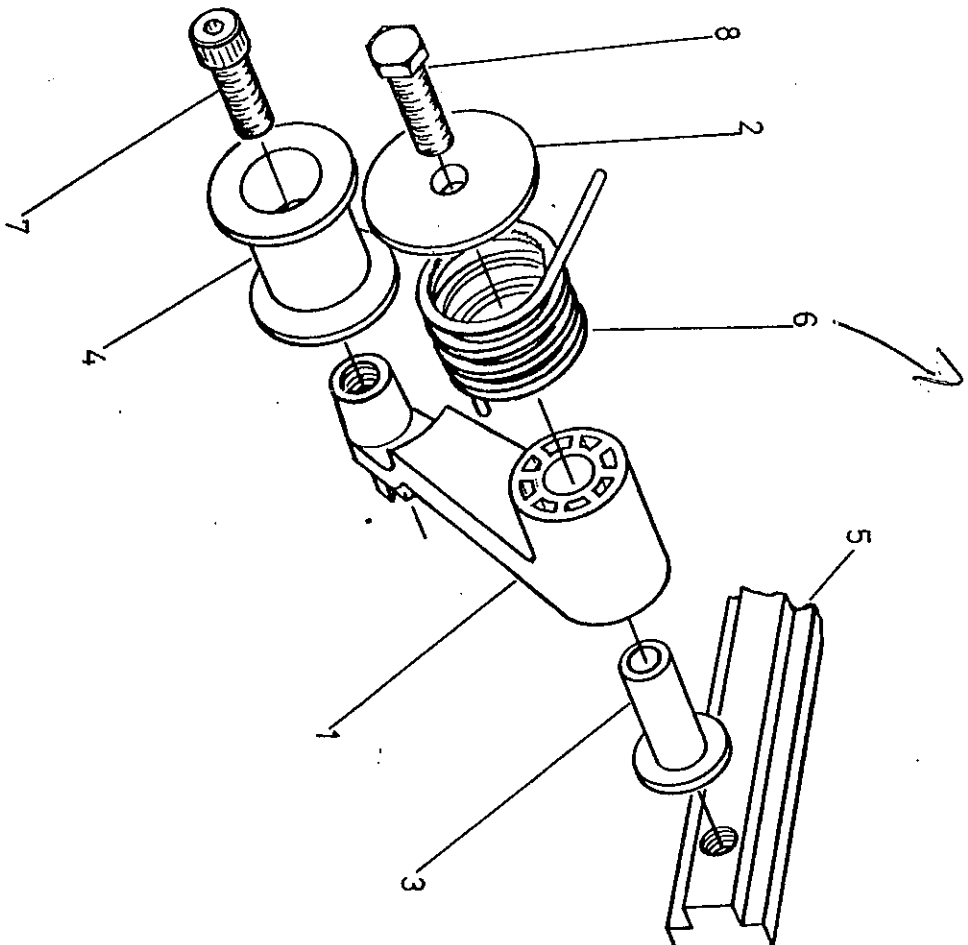


FIG 16 PRESSURE ARM - 'V' BEIN' TOP PRESSURE



16 PRESSURE ARM - 'V' BELT TOP PRESSRU

Ref	Description	No. Off
1	Top Pressure Arm DA 106	1
2	Retaining Washer DA 45	1
3	Pressure arm Support DA 43	1
4	Top Pressure Roller (complete with bearing only) DA 20	1
5	Tee Bar	1
6	Compression Spring 'Entex' ETS 59 K30-73-454	1
7	Hexagon Socket Capscrew M10 x 35mm long	1
8	Hexagon Head Setscrew M10 x 40mm long	1

NOTE: Quantities are per pressure arm assembly

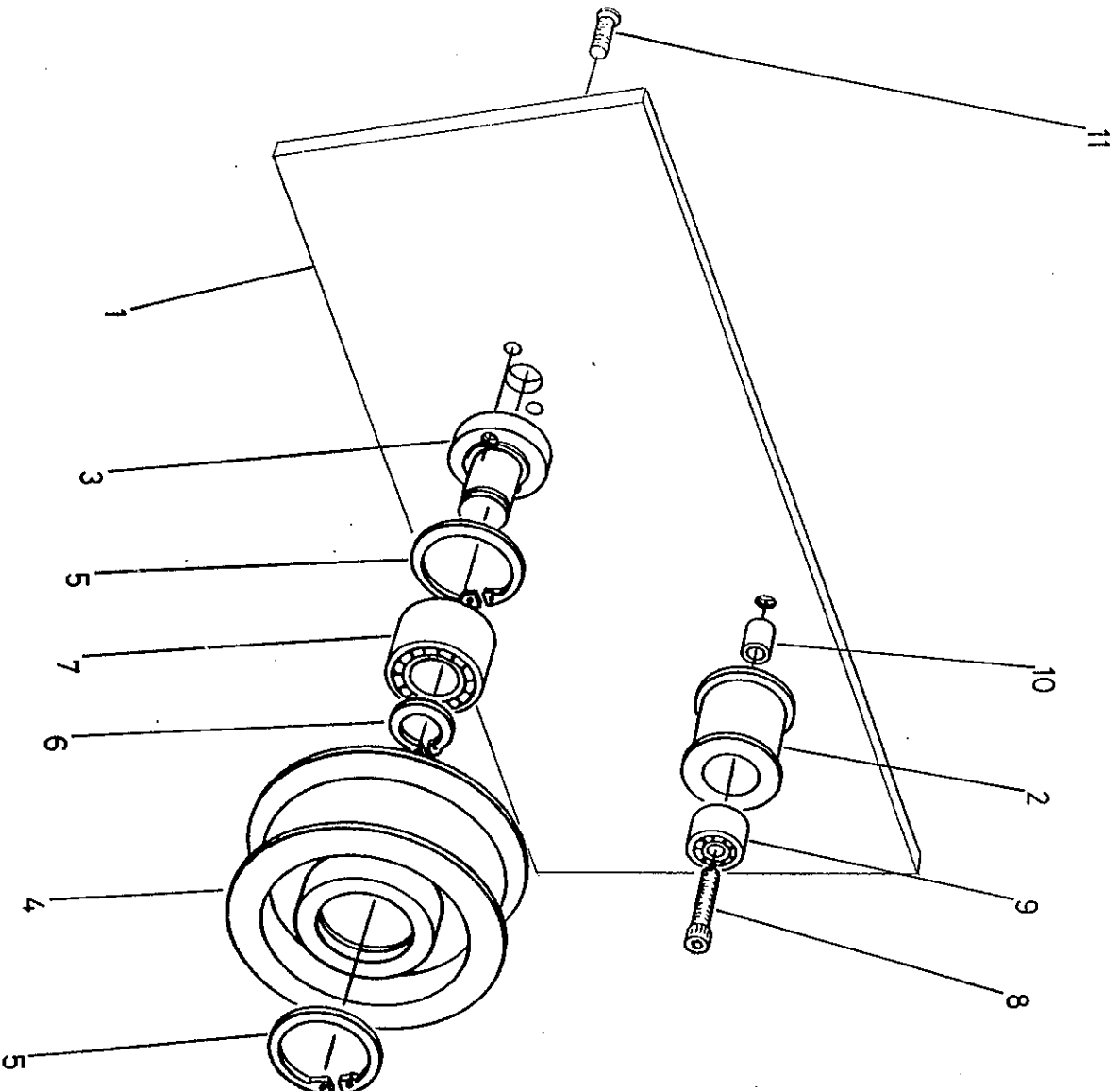


FIG 17. FRONT PULLEY-CAMSHAFT TOP PRESSURE



17 FRONT PULLEY - CATERPILLAR TOP PRESSURE

Ref	Description	No. Off
1	Front Plate (left hand as shown or right hand)	1
2	Idler Pulley	1
3	Spindle	1
4	Pressure Chain Wheel	1
5	Internal Circlip dia 62mm	2
6	External Circlip dia 30mm	1
7	Ball Bearing 'SKF' 6300 2RS	1
8	Hexagon Socket Capscrew M10 x 35m long	1
9	Ball Bearing 'RHP' 6206 - 24W	1
10	Spacer	1
11	Hexagon Socket Countersunk Screw M8 x 20mm long	2

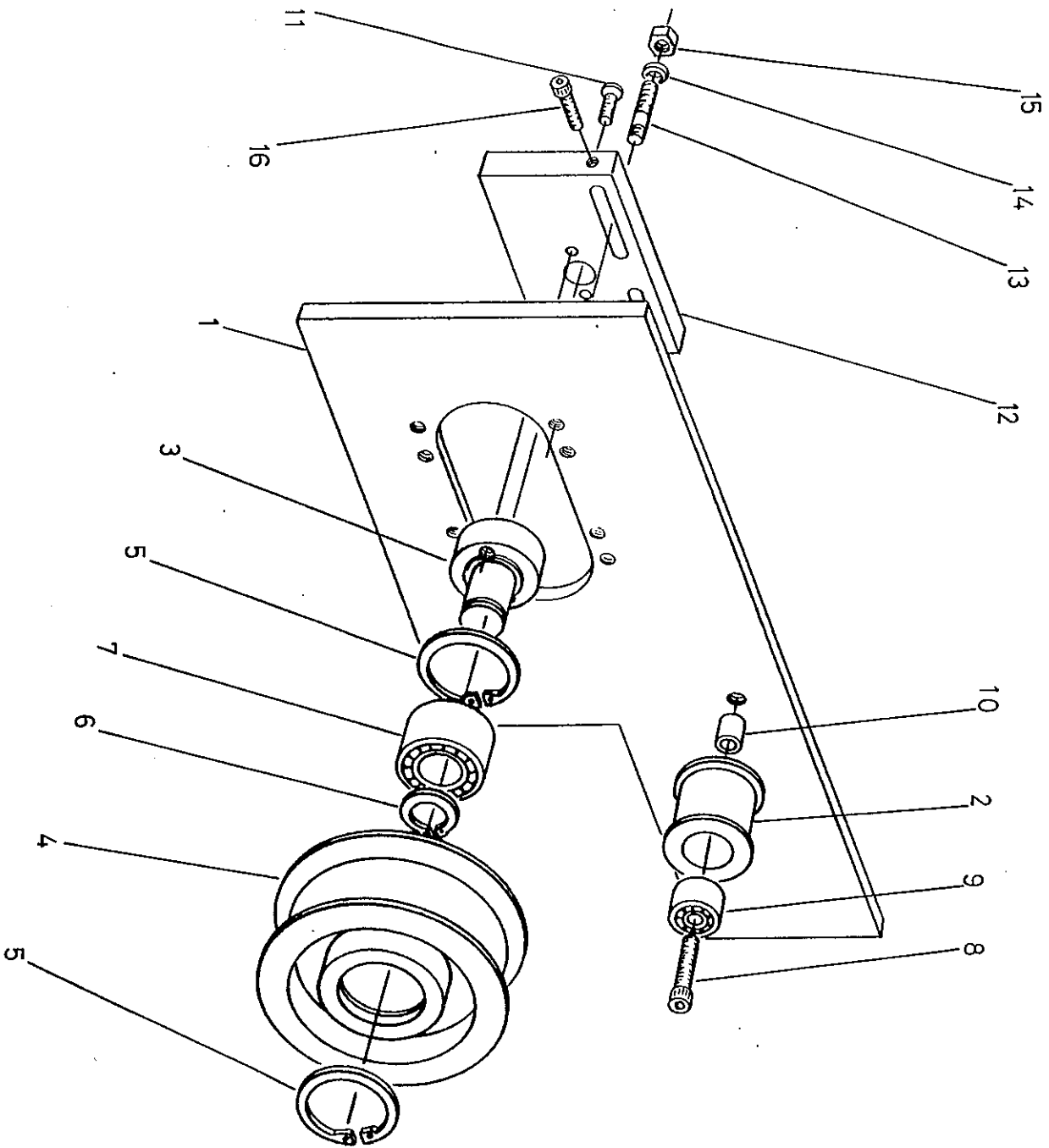


FIG 18 REAR PULLEY-CATERPILLAR TOP PRESSURE



18 REAR PULLEY - CATERPILLAR TOP PRESSURE

Ref	Description	No. Off
1	Rear Plate	1
2	Idler Pulley	1
3	Spindle	1
4	Pressure Chain Wheel	1
5	Internal Circlip dia 62mm	2
6	External Circlip dia 30mm	1
7	Ball Bearing 'SKF' 6300 2RS	1
8	Hexagon Socket Capscrew M10 x 35mm long	1
9	Ball Bearing 'RHP' 6206 - 24W	1
10	Spacer	1
11	Hexagon Socket Countersunk Screw M8 x 20mm long	2
12	Tension Bracket	1
13	Special Stud M10 x 50mm long	2
14	Plain Washer M10	2
15	Nut M10	2
16	Hexagon Socket Capscrew M6 x 50mm long	1

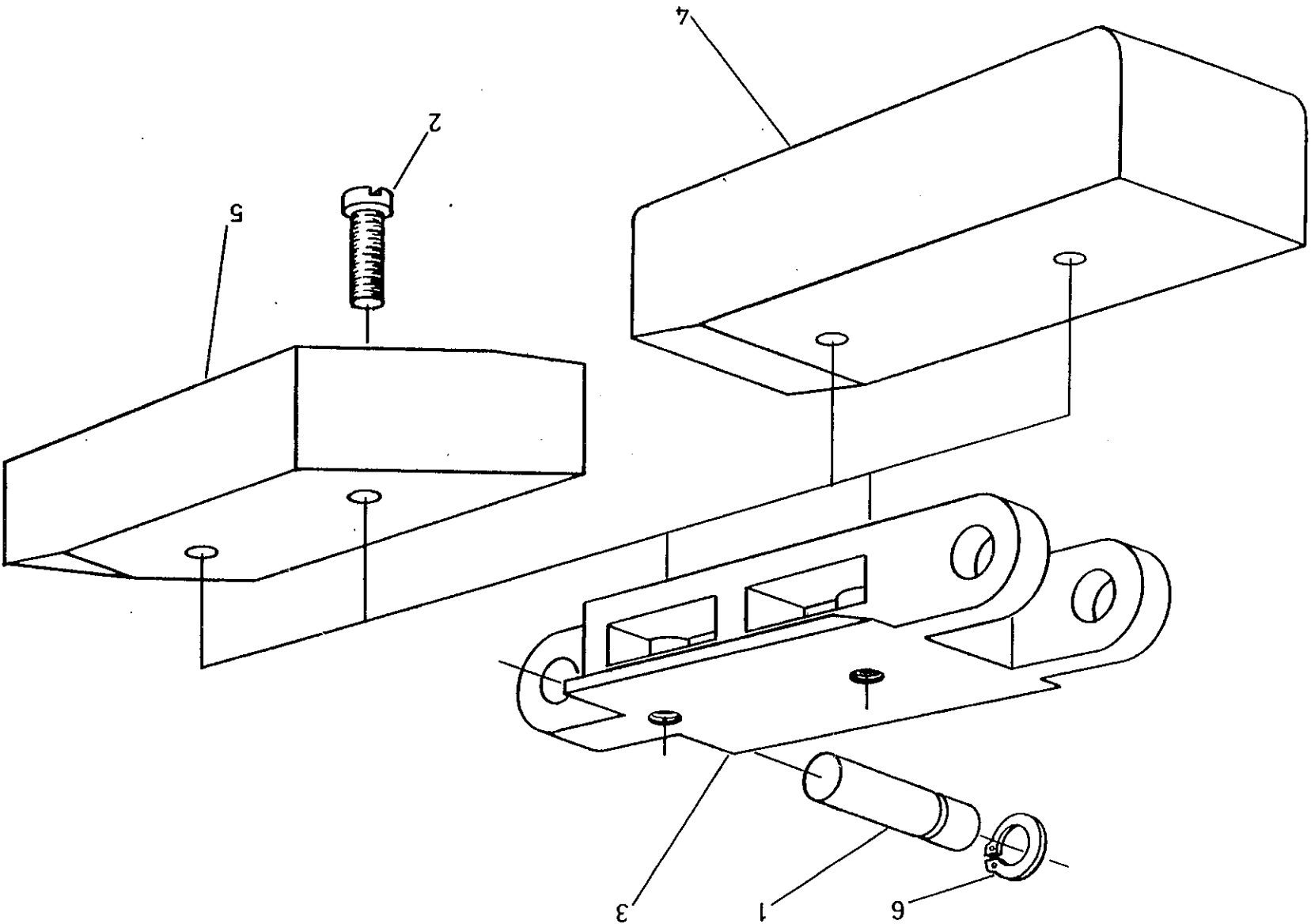


FIG 19 CAPILLAR PRESSURE PADS



19 CATERPILLAR PRESSURE PADS

Ref	Description	No. Off
1	Chain Pin. <i>DP 2242.</i>	1
2	Screw for Pressure Pad	2
3	Link for Pressure Chain <i>DP 2240,</i>	1
4	Pressure Pad Standard	1
5	Pressure Pad Rhomboidal (left or right hand)	1
6	External Circlip	1

*Part which links go on in
CDA 491.*

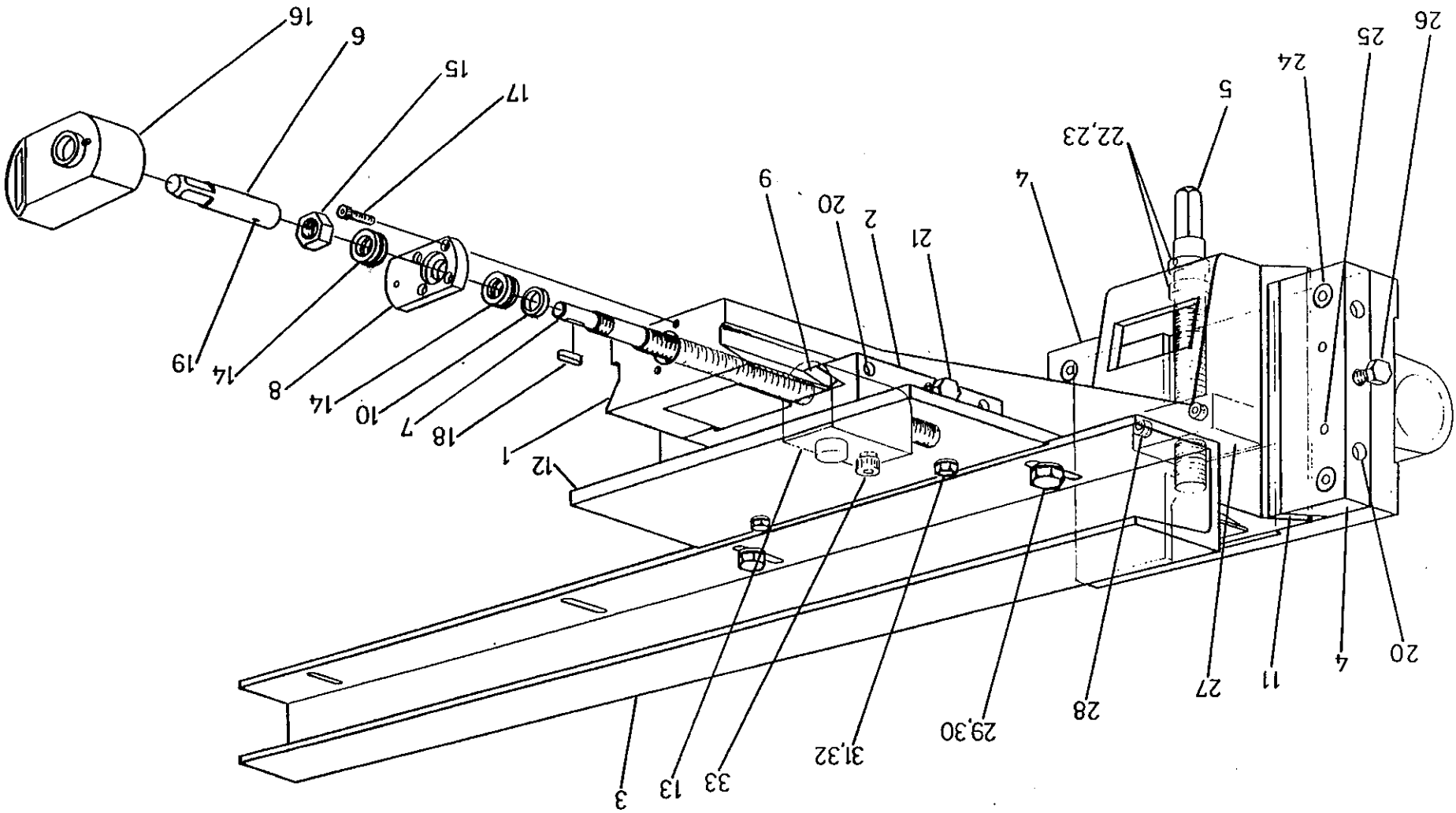
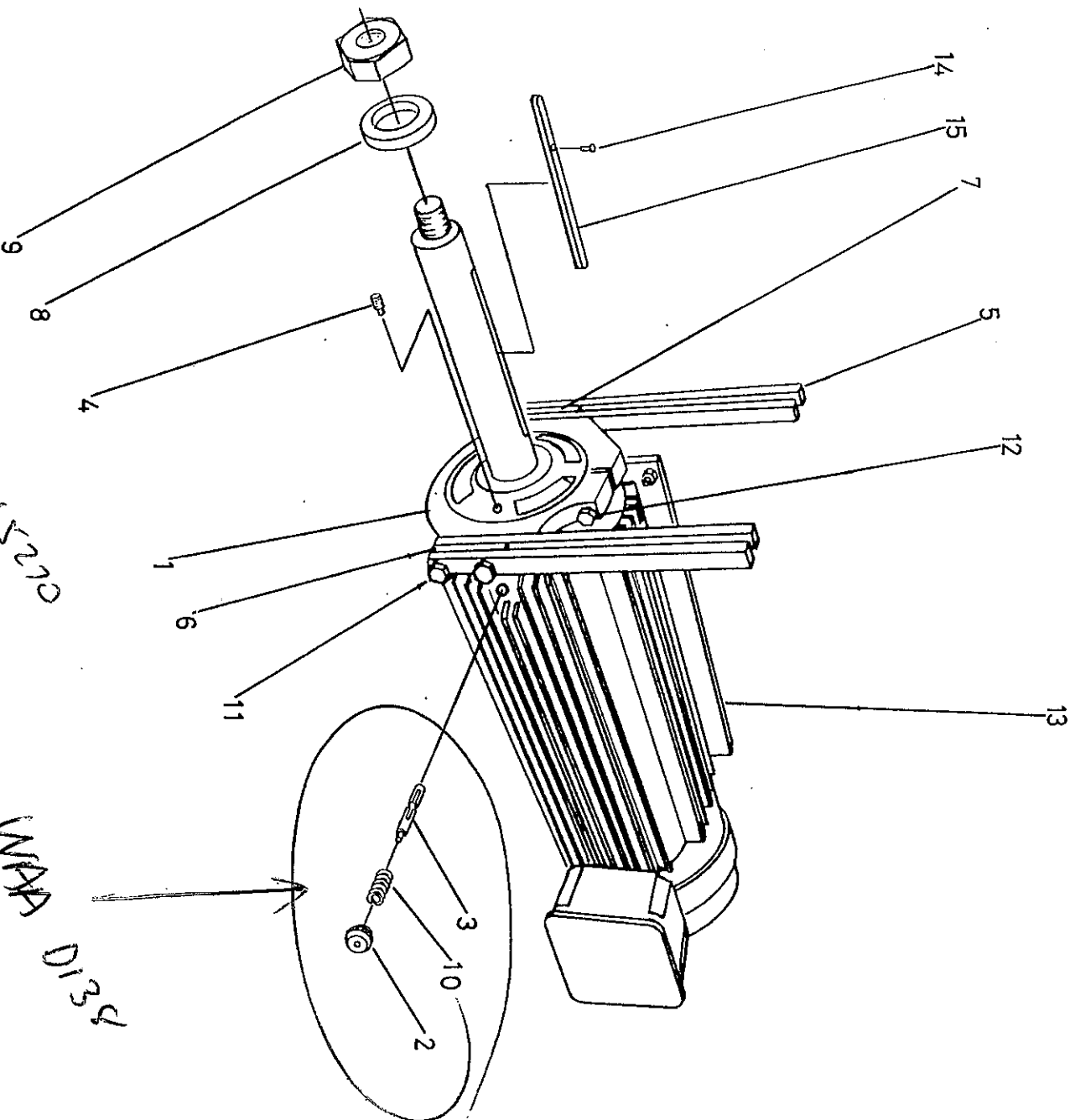


FIG. 20 STANDARD 1.5M INFEED FENCE



20 STANDARD 1.5M INFEED FENCE

Ref	Description	No.Off
1	Fence Adjustment Bracket	1
2	Slide for Fence Adjustment Bracket	1
3	Standard Fence	1
4	Vee Slide	2
5	Fence Screw	1
6	Adaptor	1
7	Top Pressure Leadscrew	1
8	Thrust Plate	1
9	Gib Strip	1
10	Spacer	1
11	Gib Strip	1
12	Fence Plate	1
13	Back Slide Nut	1
14	Thrust Bearing 'SKF' 51102	2
15	Self Locking Nut M15 x 10P	1
16	'SIKO' Digital Readout 09021 (Metric or imperial)	1
17	Hexagon Capscrew M6 x 16mm long	2
18	Key 20mm x 4mm x 4mm	1
19	Hexagon Socket Grubscrew M4 x 6mm long	1
20	Hexagon Socket Grubscrew M10 x 25mm long	1
21	Hexagon Head Setscrew M10 x 35mm long	1
22	Plain Collar 20mm I/D x 32mm O/D x 14mm	2
23	Tension dia 6mm x 30mm long	2
24	Hexagon Socket Capscrew M12 x 55mm long	4
25	Dowel dia 6mm x 30mm long	4
26	Hexagon Head Setscrew M10 x 50mm long	1
27	Nut	1
28	Hexagon Socket Capscrew M8 x 50mm long	1
29	Hexagon Head Capscrew M10 x 16mm long	1
30	Plain Washer M10	2
31	Hexagon Head Setscrew M8 x 25mm long	2
32	Plain Washer M8	2
33	Hexagon Socket Capscrew M8 x 20mm long	1



Wm 5270

DP 226#

W 5270

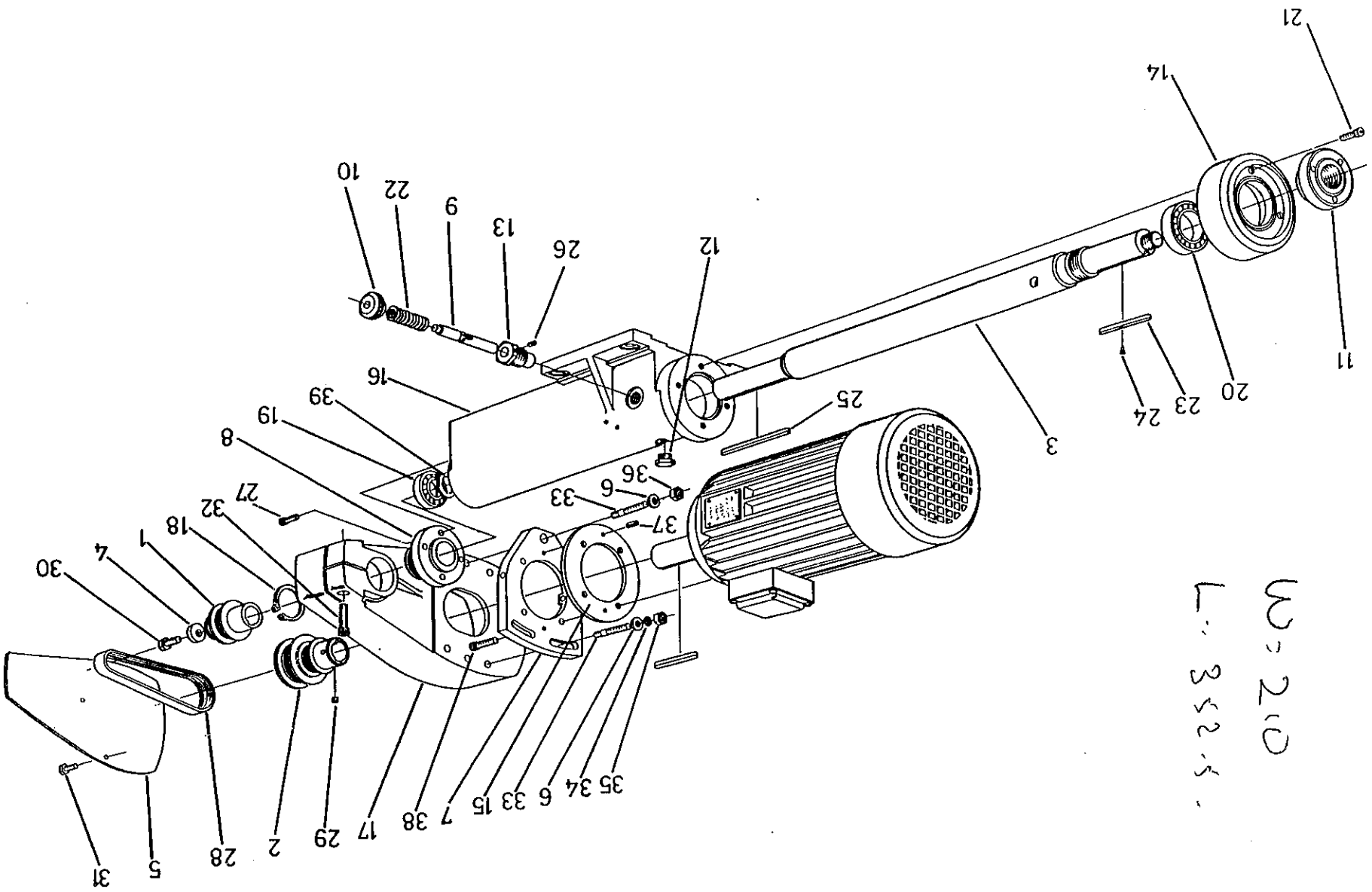
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FIG 21 'A' TYPE HEAD



21 'A' TYPE HEAD

Ref	Description	No. Off
1	Support Ring for Guard	1
2	Knob for plunger	1
3	Plunger Barrel	1
4	Half Dog Point Grubscrew 1/4" B.S.W. x 19mm long	1
5	Cutter Guard Support Bar	4
6	Cutter Guard Support Bar Packer (10mm thick)	1
7	Cutter Guard Support Bar Packer (12mm thick)	1
8	Spacer (Various widths and bore sizes)	A/R
9	Spindle Nut (to suit spindle diameter)	1
10	Compression Spring 'Entex' ETS 96	1
11	Hexagon Socket Capscrew M10 x 60mm long	4
12	Hexagon Socket Capscrew M10 x 70mm long	1
13	Motor	1
14	Hexagon Socket Countersunk Screw M5 x 16mm long	1
15	Drive key (To suit spindle)	1



W-210
L-352-3

FIG 22 'B' TYPE HEAD



Ref	Description	No. Off
22	'B' TYPE HEAD	
1	* Spindle Pulley	1
2	* Motor Pulley	1
3	* Spindle	1
4	Retaining Washer	1
5	Cover	1
6	Special Washer	3
7	Head Motor Adjustment Plate DP 258	1
8	Pivot Boss	1
9	Spindle Lock Plunger	1
10	Knob for Plunger	1
11	Spindle Locknut	1
12	Plug	2
13	Spindle Lock Body	1
14	Top Bearing Cap	1
15	Distance Plate	1
16	Spindle Housing W/A 374	1
17	Head Mounting Support Bracket DP 259	1
18	External Circlip dia 70mm	1
19	Ball Bearing 'SKF' 6207 - 2Z	1
20	Ball Bearing 'SKF' 6209 - Z	1
21	Hexagon Socket Capscrew M6 x 30mm long	4
22	Compression Spring 12.7mm O/D, 50.8mm long 1.25mm gauge	1
23	Key 10mm x 8mm x 65mm	1
24	Hexagon Socket Countersunk Screw M5 x 16mm long	1
25	Key 10mm x 8mm x 90mm	1
26	Hexagon Socket GrubscREW M4 x 8mm long	1
27	Hexagon Socket Capscrew M8 x 25mm long	4
28	'Poly V' Drive Belt 260 - J10	1
29	Hexagon Socket GrubscREW M10 x 10mm long	2
30	Hexagon Head Setscrew M12 x 30mm long	1
31	Hexagon Head Setscrew M8 x 30mm long	3
32	Hexagon Socket Capscrew M12 x 75mm long	1
33	Stud M10 x 60mm long	3
34	Spring Washer M10	2
35	Plain Nut M10	2

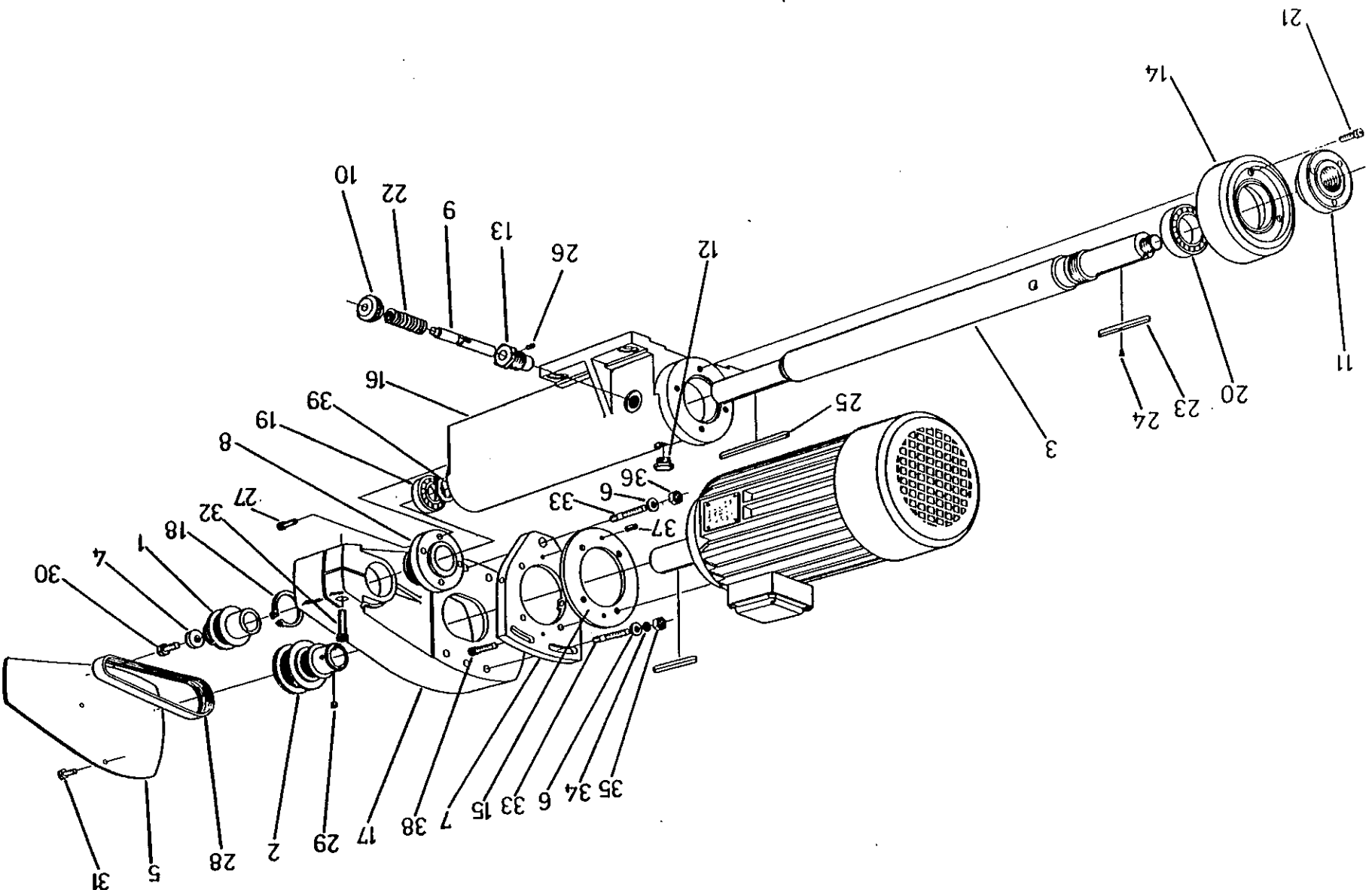


FIG 22 'B' TYPE HEAD



22 'B' TYPE HEAD - CONT.....

Ref	Description	No. Off
36	Self Locking Nut M10	1
37	Tension Pin dia 6mm	2
38	Hexagon Socket Capscrew M8 x 30mm long	4
39	Pre Load Wavey Washer	1

* Specify Spindle Speed and Diameter

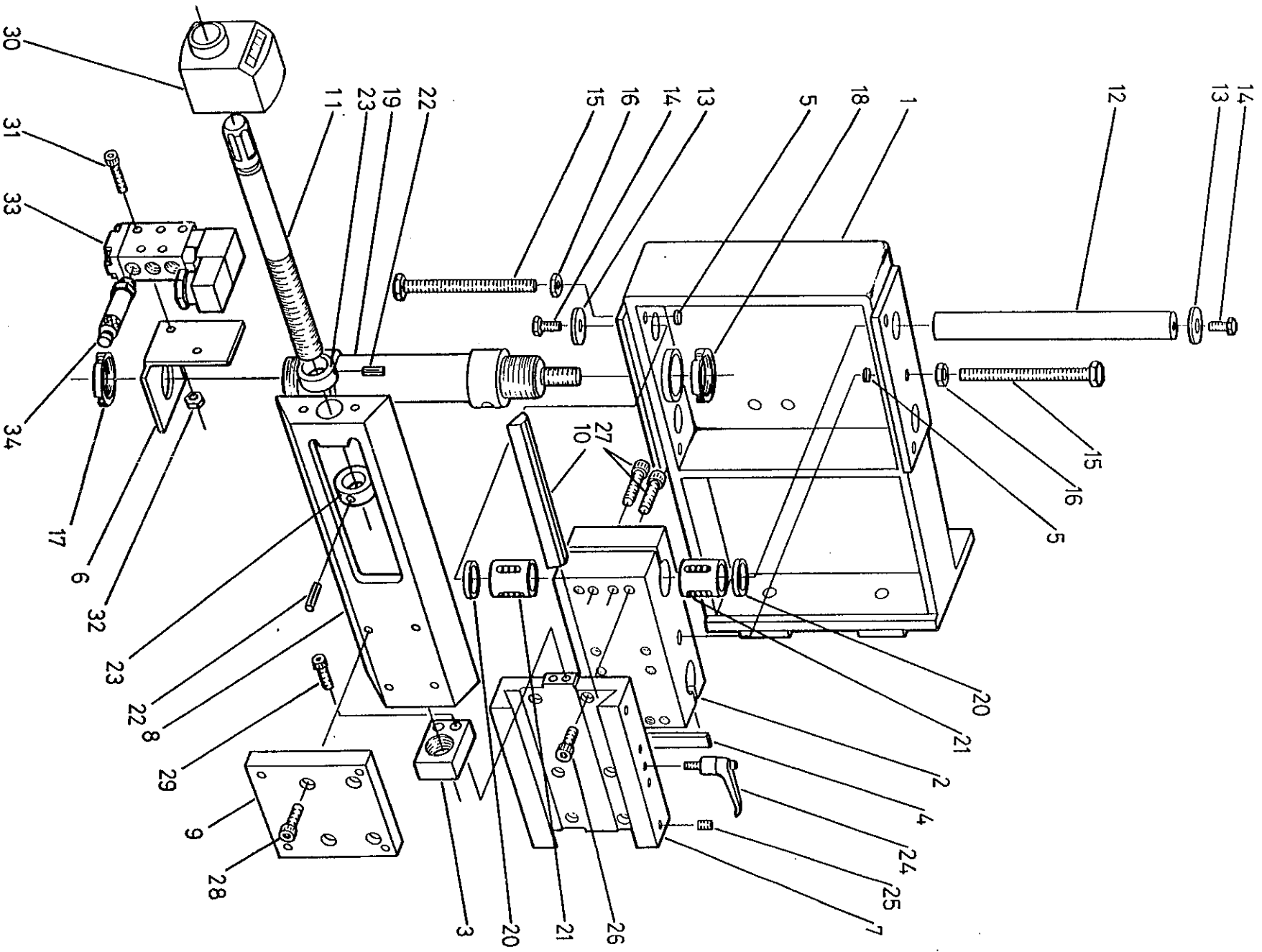


FIG 23 BEAM MOUNTED SCORER BODY



23 BEAM MOUNTED SCORER BODY

Ref	Description	No. Off
1	Scorer Bracket R.H. (Shown)	1
	or	
2	Scorer Bracket L.H.	1
3	Scorer Carriage	1
4	Nut for Leadscrew	1
5	Bearing Seal	2
6	Stop Pad	2
7	Mounting Pad for Solenoid Valve	1
8	Slide Base	1
9	Slide	1
	Motor Mounting Plate for 0.55KW motor (shown)	1
	or	
10	Motor Mounting Plate for 1.1 kW motor	1
11	Gib Strip	1
12	Leadscrew	1
13	Precision Ground Shaft dia 25mm x 266mm long	2
14	Large Plain Washer M10	4
15	Hexagon Head Setscrew M10 x 20mm long	4
16	Hexagon Head Setscrew M12 x 130mm long	2
17	Locknut M12	2
18	Notch Nut M45 x 1.5mm	1
19	Notch Nut M45 x 1.5mm Supplied with Cylinder	
20	'Festo' Double Acting Cylinder DSW - 50 - 80p	1
21	'INA' Sealing Ring G25x 35 x 4	4
22	'INA' Linear Ball Bearing KH 2540	4
23	Tension Pin dia 6mm x 32mm long	2
24	Plain Collar dia 32mm x 20mm bore	2
25	Bristol Type Locking Handle with Stud M10 x 25mm	1
26	Hexagon Socket Nylon Grubscrew M10 x 20mm long	1
27	Hexagon Socket CapscREW M8 x 25mm long	4
28	Hexagon Socket CapscREW M8 x 30mm long	4
29	Hexagon Socket CapscREW M8 x 20mm long	4
30	Hexagon Socket CapscREW M8 x 16mm long	2
31	Siko Dial Indicator	1
32	Hexagon Socket CapscREW M4 x 35mm long	1
33	Plain Nut M4	2
34	'Schrader Bellows' 1/4 " BSP Solenoid Valve B53414SM	1
	'Maxam' Throttle Valve 705013720E	2

SECTION 5

ILLUSTRATED PARTS LIST

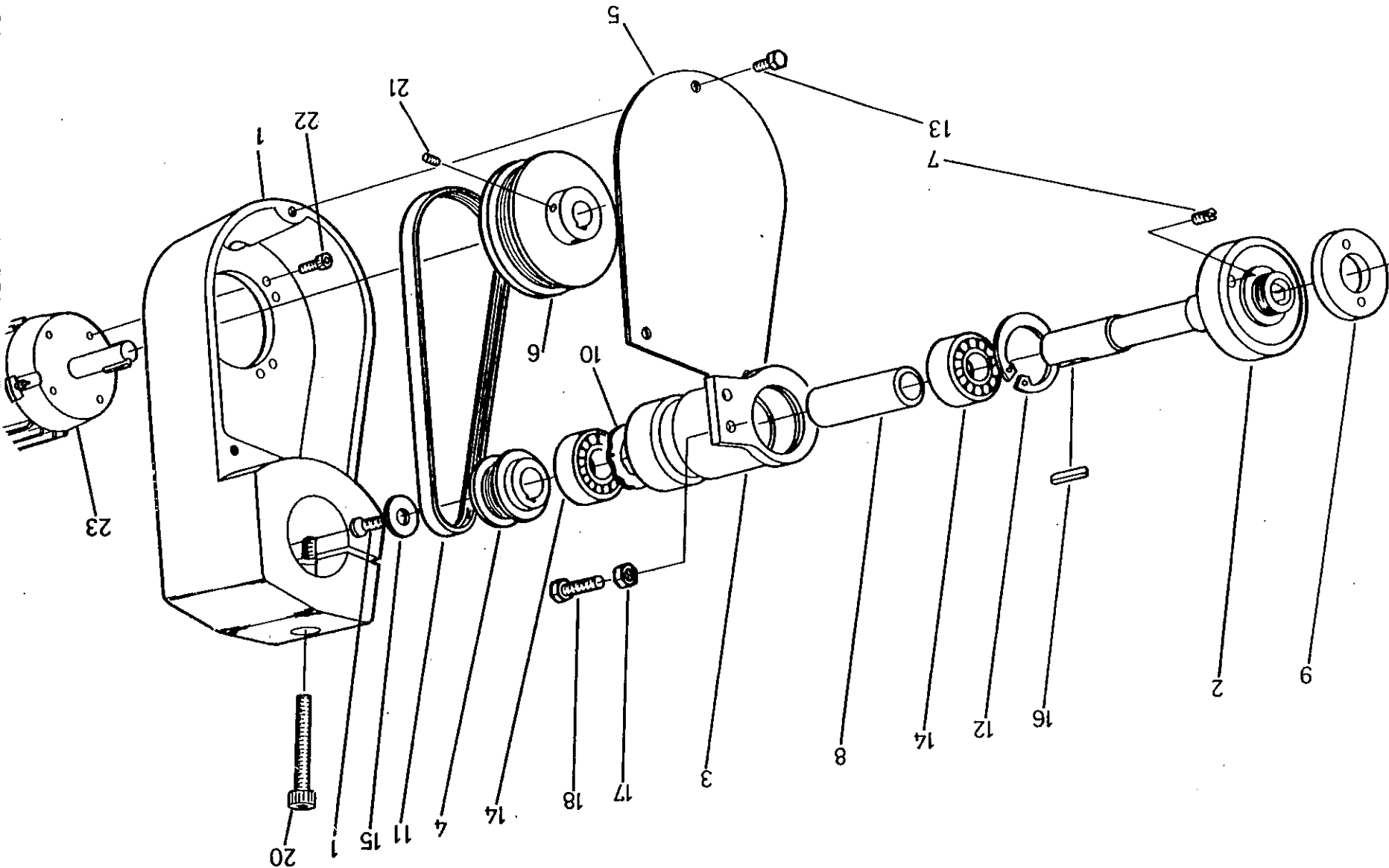


FIG 24 BELT DRIVEN SCORER HEAD



24 BELT DRIVEN SCORER HEAD

Ref	Description	No. off
1	Scorer Housing	1
2	Scorer Spindle	1
3	Rise and Fall Quill	1
4	Scorer Spindle Pulley	1
5	Cover	1
6	Scorer Motor Pulley	1
7	Peg for Scorer Saw	1
8	Bearing Spacer	1
9	Retaining Collar	1
10	Preload Wavey Washer	1
11	'Poly V' Drive Belt 180 - J4 <u>K 3078391</u>	1
12	Internal Circlip dia 35mm	1
13	Hexagon Head Setscrew M5 x 10mm long	3
14	'SKF' Ball Bearing 6003 - 2RS	2
15	Washer for Spindle Pulley	1
16	Key 5mm x 5mm x 15mm	1
17	Locknut M5	2
18	Hexagon Head Setscrew M5 x 25mm long	2
19	Hexagon Socket Countersunk Screw M8 x 20mm long	1
20	Hexagon Socket Capscrew M8 x 55mm long	1
21	Hexagon Socket Grubscrew M6 x 8mm long	2
22	Hexagon Socket Capscrew M6 x 20mm long	4
23	'Brook' Motor D71 BH 0.55kW, 3PH, 50HZ	1

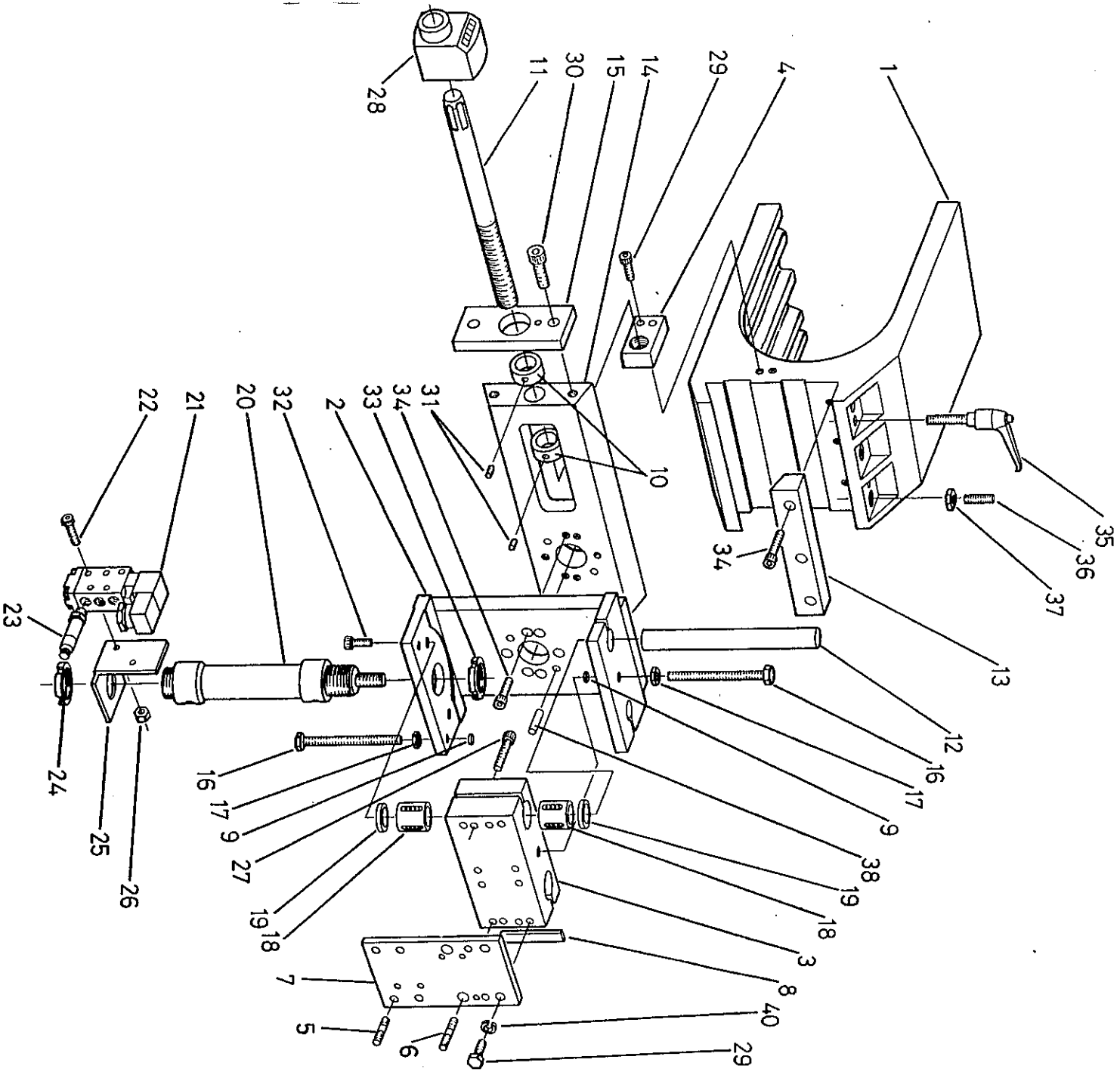


FIG 25 HEAD MOUNTED SCORER BODY



25 HEAD MOUNTED SCORER BODY

Ref	Description	No off
1	Jump scorer tie bracket	1
2	Scorer body	1
3	Scorer carriage	1
4	Nut for lead screw	1
5	Stud for motor carriage	2
6	Stud for motor plate	2
7	Scorer motor plate	1
8	Bearing seal for scorer	2
9	Stop pad	2
10	Collar	2
11	Lateral adjusting screw	1
12	Scorer slide bars	2
13	Gib	1
14	Cross slide	1
15	Scorer adjusting tie plate	1
16	Hexagon head setscrew M12 x 130mm long	2
17	Lock nut M12	2
18	'INA' linear ball bearing KH2540	4K0607143
19	'INA' sealing ring G25 x 35 x 4	4K3074358
20	'Festo' double acting cylinder DSW - 50 - 80P	1
21	'Schrader bellows' 1/4" BSP solenoid valve B53414SM	1
22	Hexagon socket capscrew M4 x 35mm long	2
23	'Maxam' throttle valve 705013720E	2
24	Notch nut M45 x 1.5mm pitch	1
25	Mounting pad for solenoid valve	1
26	Plain nut M4	2
27	Hexagon socket capscrew M8 x 30mm long	4
28	'Siko' dial indicator	1
29	Hexagon socket capscrew M8 x 16mm long	2
30	Hexagon socket capscrew M8 x 25mm long	2
31	Tension pin dia 6mm x 32mm long	2
32	Hexagon socket capscrew M10 x 25mm long	2
33	Notch nut M45 x 1.5mm pitch (supplied with cylinder)	1
34	Hexagon socket capscrew M8 x 30mm long	9
35	Bristol locking handle M10	2
36	Hexagon socket grubscREW M8 x 25mm long	3
37	Locknut M8	3

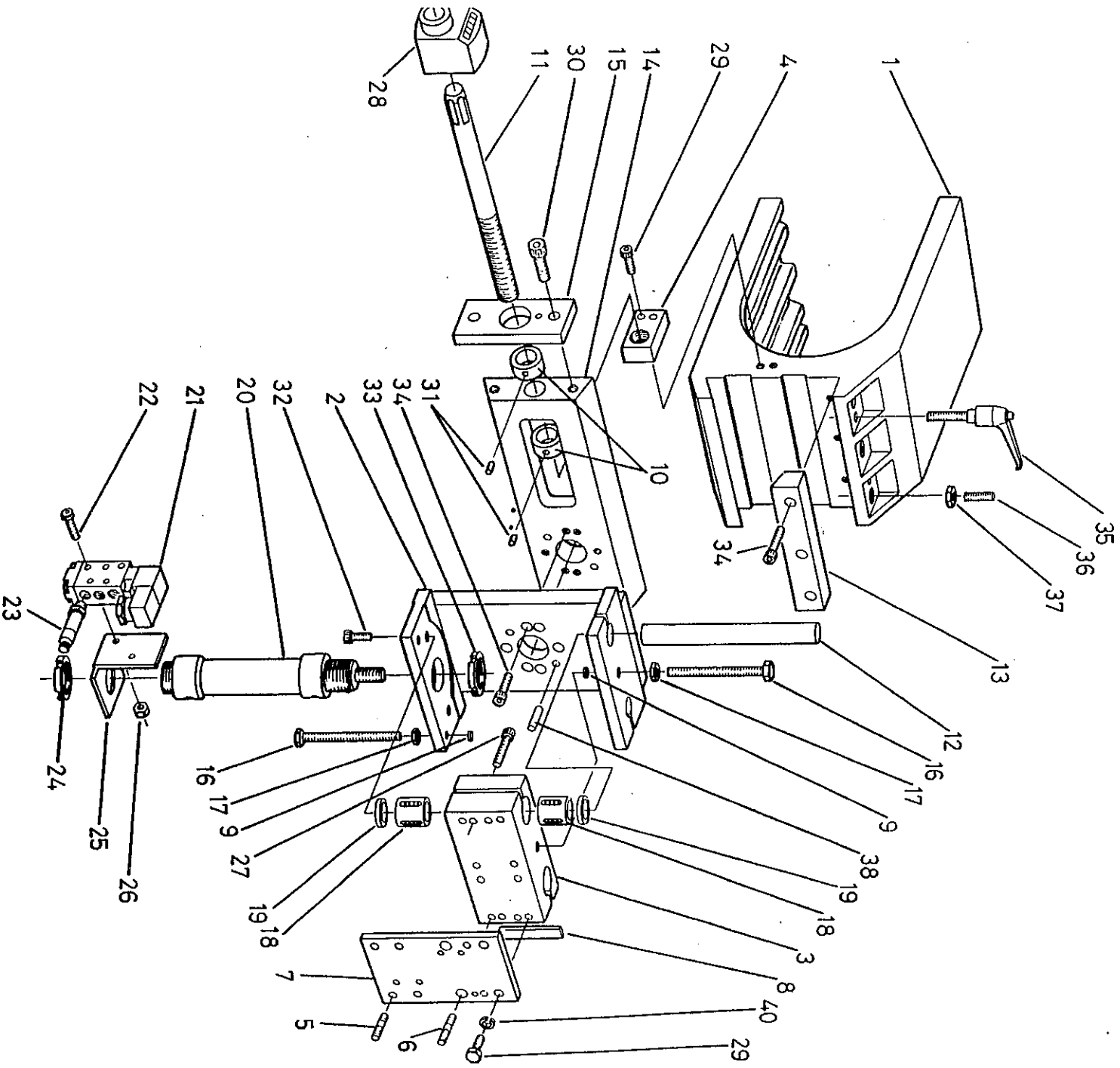


FIG 25 HEAD MOUNTED SCORER BODY



25 HEAD MOUNTED SCORER BODY CONT.....

Ref	Description	No off
38	Dowel diameter 8mm x 35mm long	2
39	Hexagon head setscrew M8 x 25mm long	2
40	Spring washer M8	2

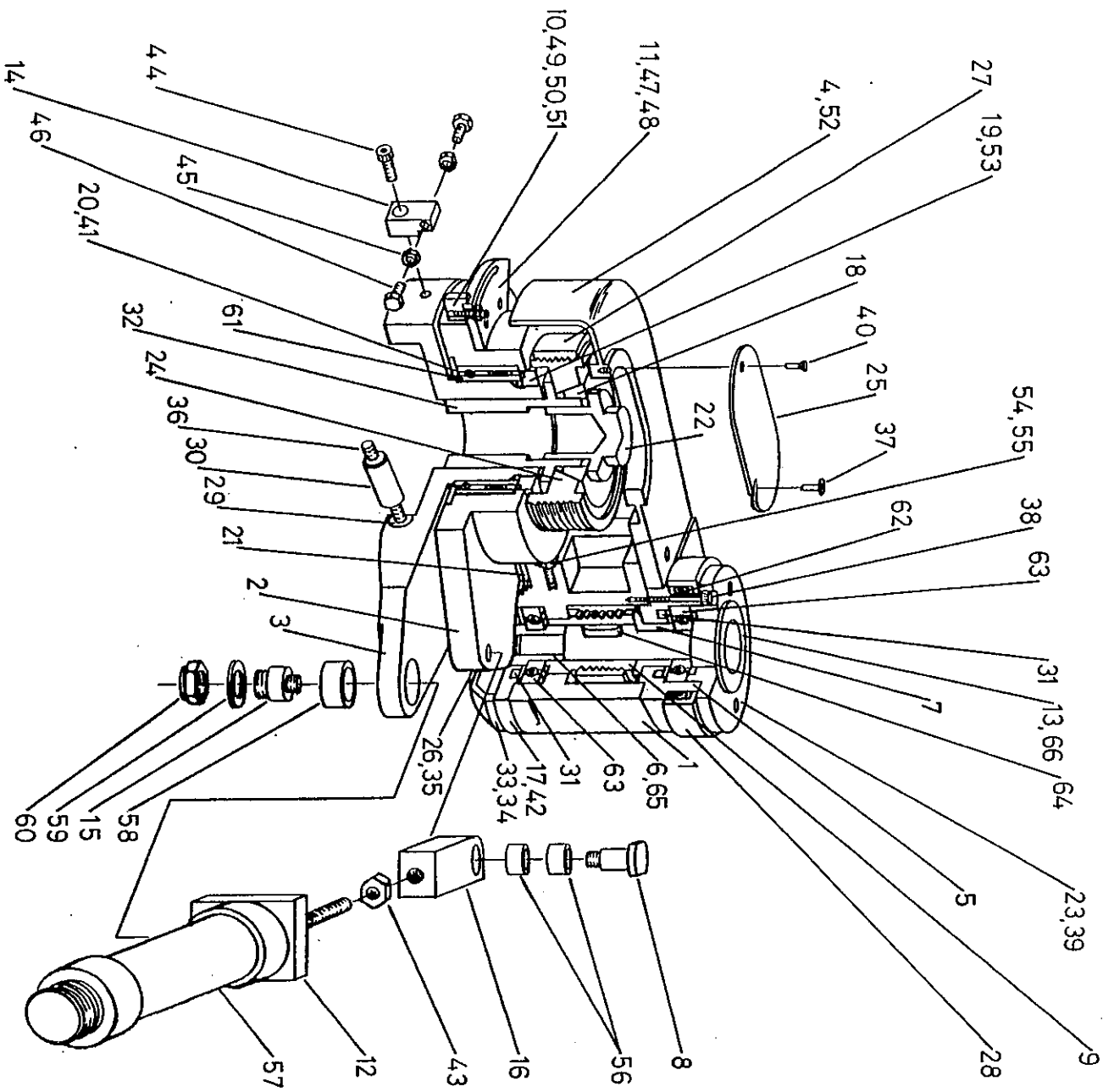


FIG 26 RELISHING HEAD



26	RELISHING HEAD		
Ref	Description	No off	
1	Spindle body	1	
2	Arm for head	1	
3	Base plate for head	1	
4	Guard for drive	1	
5	Top bearing housing	1	
6	Sleeve for bottom bearing	1	
7	Spacer for top bearing	1	
8	Pivot pin for connecting link	1	
9	Driven pulley	1	
10	Stop	2	
11	Quaderant plate	1	
12	Cylinder adaptor	1	
13	Relish spindle	1	
14	Base plate stop	1	
15	Pivot pin	1	
16	Connecting link	1	
17	Bottom bearing end cap	1	
18	Cone for driving pulley	1	
19	Locknut for bearing	1	
20	Clamp ring for bearing	1	
21	Key	1	
22	Nut for motor	1	
23	End cap,top bearing	1	
24	Driving pulley	1	
25	Cover for drive guard	1	
26	Cover	1	
27	'Poly - V' belt - 220j13	1	
28	Cam follower	1	
29	Plain locking pad	1	
30	Threaded locking pad	1	
31	Felt ring	2	
32	Spindle sleeve (specify spindle diameter).	1	
33	Cover	1	
34	Hexagon socket capscrew $\frac{3}{16}$ BSW x 1 $\frac{1}{4}$ long	3	
35	Round head screw $\frac{3}{16}$ BSW x $\frac{3}{8}$ long	1	
36	Hexagon socket capscrew M10 x 120mm long	1	
37	Round head screw $\frac{1}{4}$ BSW x $\frac{1}{2}$ long	1	

SECTION 5
ILLUSTRATED PARTS LIST

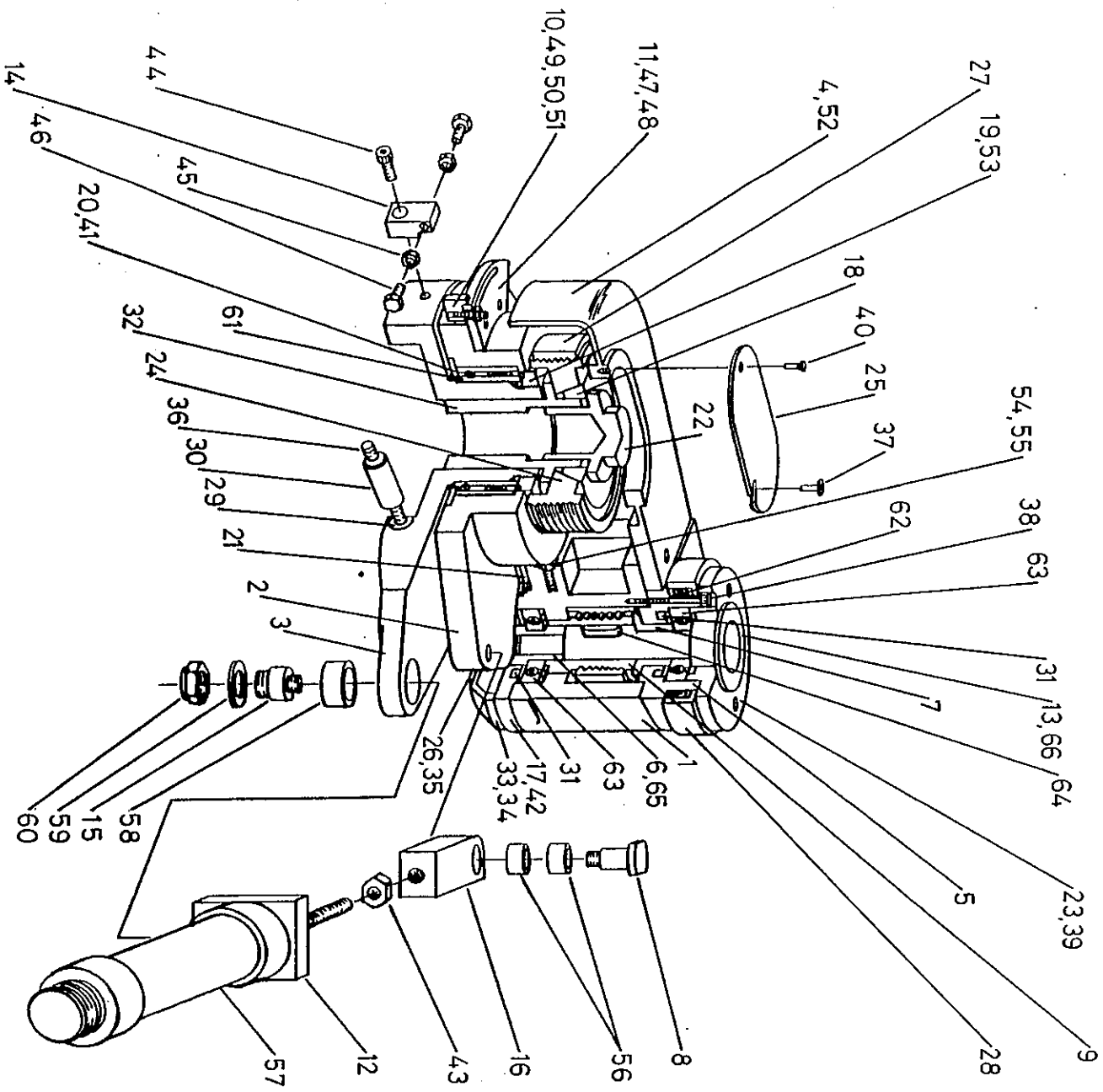


FIG 26 RELISHING HEAD



26 RELISHING HEAD CONT.....

Ref	Description	No off
38	Hexagon socket capscrew M5 x 50mm long	3
39	Hexagon socket capscrew $\frac{3}{16}$ BSW x $\frac{1}{2}$ long	3
40	Counter sunk hexagon socket screw $\frac{1}{4}$ BSW x $\frac{1}{2}$ long	1
41	Counter sunk hexagon socket screw $\frac{3}{16}$ BSW x $\frac{1}{2}$ long	3
42	Hexagon socket capscrew M5 x 25mm long	4
43	Locking nut M16 x 2P	1
44	Hexagon socket capscrew $\frac{5}{16}$ BSW x $\frac{5}{8}$ long	2
45	Locking nut $\frac{1}{4}$ BSW	2
46	Hexagon head setscrew $\frac{1}{4}$ BSW x $\frac{1}{2}$ long	2
47	Hexagon socket capscrew $\frac{5}{16}$ BSW x $\frac{3}{4}$ long	2
48	Dowel $\frac{5}{16}$ dia x 1" long	2
49	Stud $\frac{3}{16}$ BSW x 1 $\frac{1}{2}$ long	2
50	Nut $\frac{3}{8}$ BSW	2
51	Plain washer $\frac{3}{8}$ BSW	2
52	Hexagon socket capscrew M6 x 12mm long	2
53	Counter sunk hexagon socket screw $\frac{3}{16}$ BSW x $1 \frac{1}{2}$ long	1
54	Hexagon head setscrew M6 x 40mm long	1
55	Locking nut M6	1
56	'Compo' bush SN 066 x .625"	2
57	'Festo' DSW - 50 - 89p cylinder	1
58	Bush 25mm O/Dx 20mm I/Dx 25mm long	1
59	Plain washer M16	1
60	Self locking nut M16	1
61	'INA' needle roller / angular contact ball bearing NKIB - 5914	1
62	'INA' needle roller bearing K80 x 86 x 20	1
63	'RHP' ball bearing IP ₁ /6206	2
64	Key $\frac{3}{16}$ square x 1 $\frac{1}{2}$ long	1
65	Key $\frac{3}{16}$ sq x $\frac{1}{2}$ long	1
66	Locknut for spindle	1

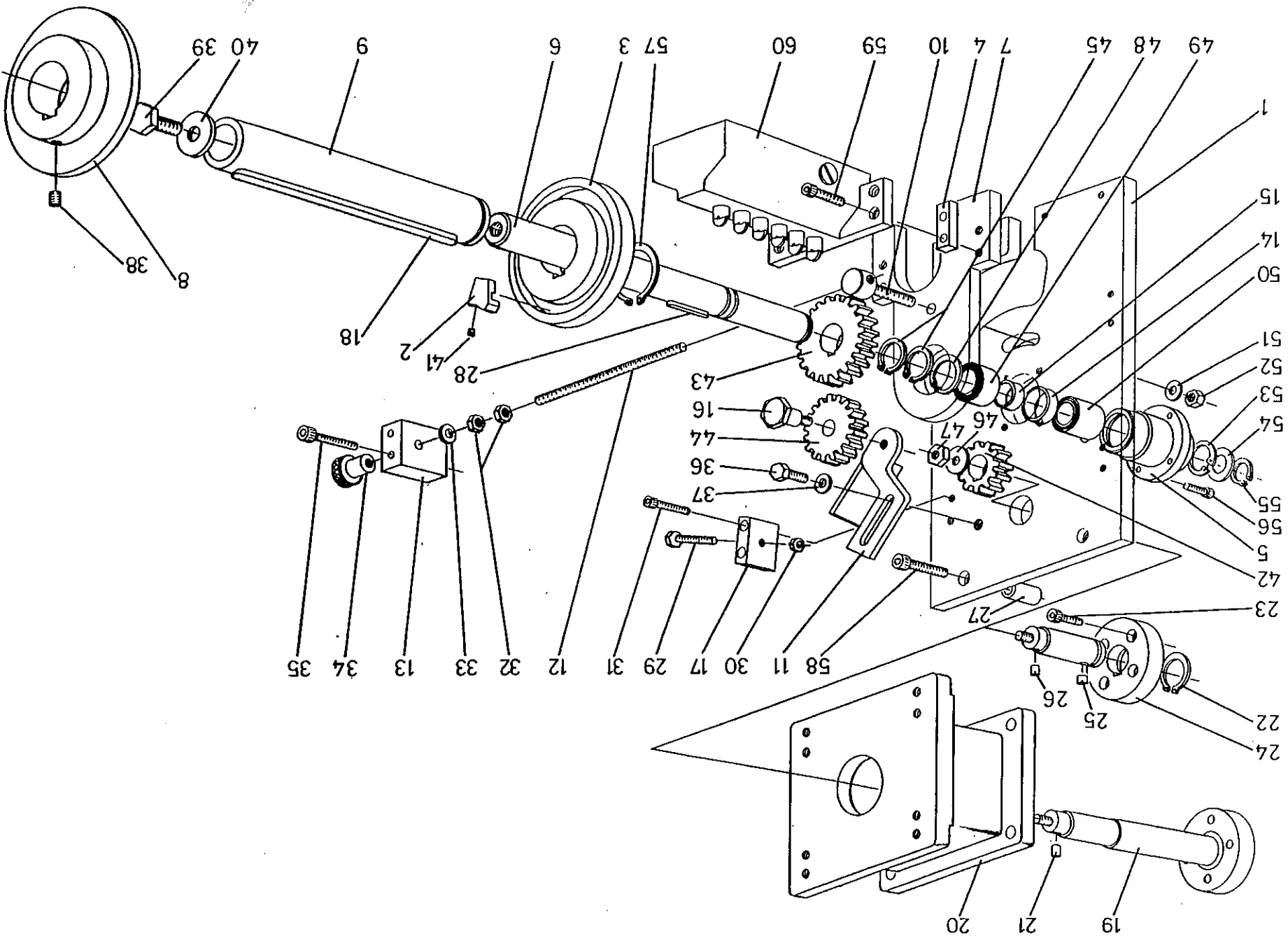


FIG. 27 TIMING DRUM



27	TIMING DRUM	
Ref	Description	No off
1	Timing drum backplate	1
2	Trip dog	2 per cam disc
3	Cam disc	as required
4	Packing block	2
5	Cam shaft housing	1
6	Cam shaft	1
7	Pivot plate	1
8	Cam disc clamp	1
9	Cam shaft sleeve	1
10	Clamp screw	1
11	Intermediate gear arm	1
12	Leadscrew	1
13	Leadscrew housing	1
14	Bearing spacer (outer)	1
15	Bearing spacer (inner)	1
16	Pivot pin	1
17	Jacking plate	1
18	Key 12mm x 8mm x 155mm long	1
19	Drive shaft	1
20	Support for timing drum	1
21	Plain dowel dia 6mm x 12mm long	1
22	'INA' external circlip WR25	1
23	Hexagon socket capscREW M8 x 20mm long	4
24	Drive adaptor plate	1
25	Plain dowel dia 8mm x 16mm long	1
26	Plain dowel dia 6mm x 12mm long	1
27	Spacer	4
28	Key 6mm x 6mm x 40mm long	1
29	Hexagon head setscrew M6 x 35mm long	1
30	Nut M6	1
31	Hexagon socket capscREW M6 x 45mm long	2
32	Lock nut M8	2
33	Large plain washer M8	1
34	Thumb nut 'WDS' 520-204	1
35	Hexagon socket capscREW M6 x 45mm long	2
36	Hexagon head setscrew M10 x 20mm long	1
37	Large plain washer M10	1

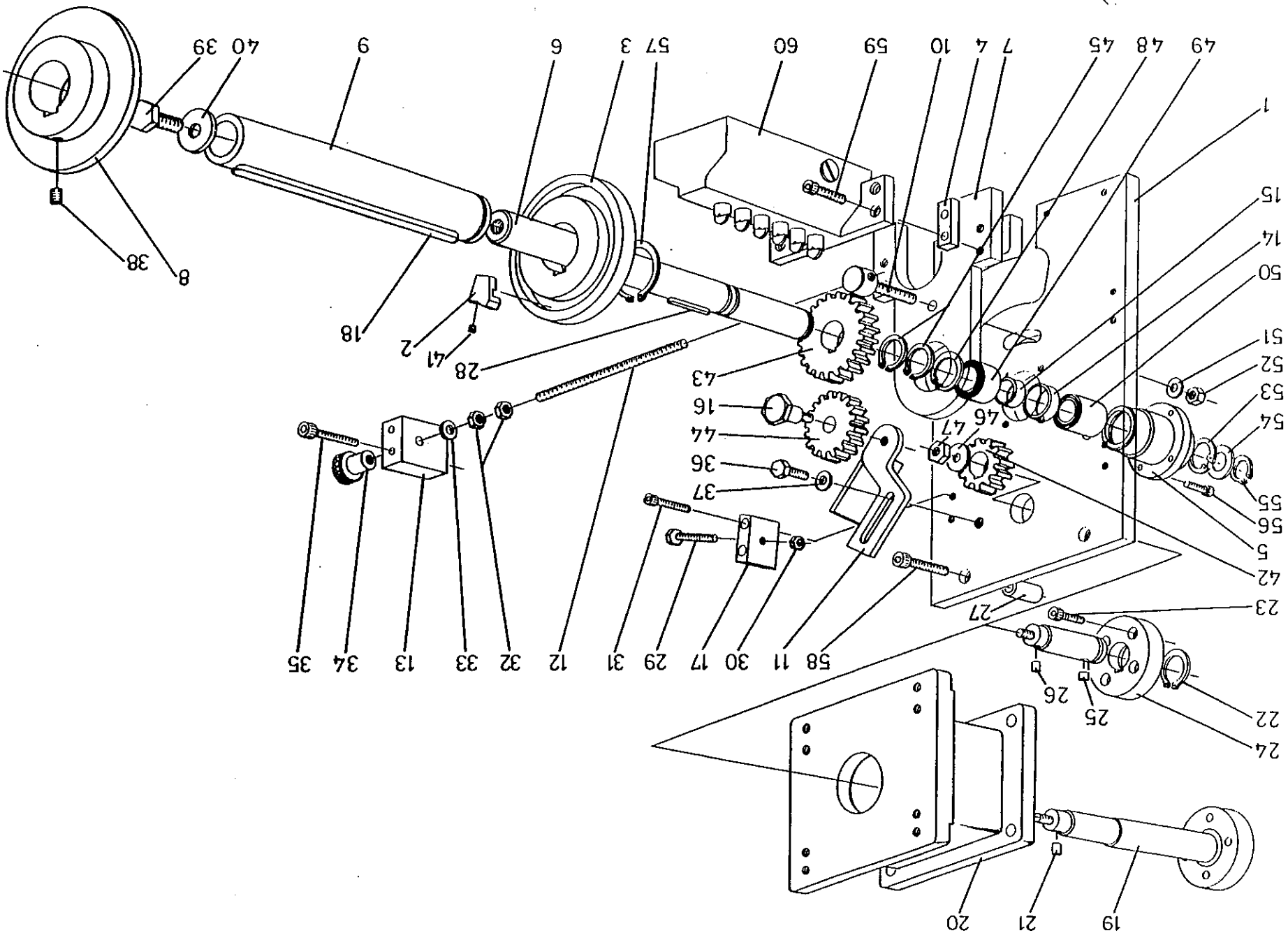


FIG 27 TIMING DRUM



27 TIMING DRUM CONT....

Ref	Description	No off
38	Hexagon socket grubscREW M6 x 20mm long	1
39	Hexagon head setscrew M10 x 20mm long	1
40	Large plain washer M10	1
41	Hexagon socket grubscREW M5 x 6mm long	1 per trip dog
42	'HPC' tuflnol gear to suit required speed	1
43	'HPC' tuflnol gear to suit required speed	1
44	'HPC' tuflnol gear	1
45	External circlip dia 20mm	2
46	Large plain washer M10	1
47	Nut M10	1
48	Internal circlip dia 37mm	1
49	'INA' needle roller bearing NA 4904RS	1
50	'INA' needle roller / angular contact bearing NKIB 5904	1 KOE14223
51	Large plain wahser M12	1
52	Nut M12	1
53	Internal circlip dia 37mm	1
54	Plain washer M20	1
55	External circlip dia 20mm	1
56	Hexagon socket capscrew M6 x 20mm long	4
57	External circlip dia 40mm	1
58	Hexagon socket capscrew M8 x 50mm long	4
59	Hexagon socket capscrew M6 x 30mm long	4
60	'Euchner' 12 way limit switch GSBF 12R12 - 502	1
	or	
	'Euchner' 6 way limit switch RGBF 06R12 - 502	1