

REPAIR PARTS
for
BROWN & SHARPE
No. 00G AUTOMATIC SCREW
and
No. 00G AUTOMATIC CUTTING-OFF
MACHINES
HIGH SPEED
and
ATTACHMENTS



542-00-851

TO

542-00-3299

For Machines Beginning Serial No. 542-00-851

THE parts are arranged in the illustrations so far as possible in the same relative positions as in the machines. This is to facilitate stripping and assembling as well as identifying the parts.

The parts are shown separated to make the construction of the machines more readily understood and to show each part to best advantage. In some cases, when a particular part is ordered, not only that part but one or more supplementary parts also may be sent when, from our experience, this is known to be advisable for a more satisfactory repair job.

Repair parts, in some cases, will require fitting and therefore may need holes to be drilled, shoulders to be squared or similar machining in order to make them fit properly.

A scale of inches is located at the lower part of each Repair Parts illustration. This scale will be useful in determining the approximate size of the parts illustrated on that particular page.

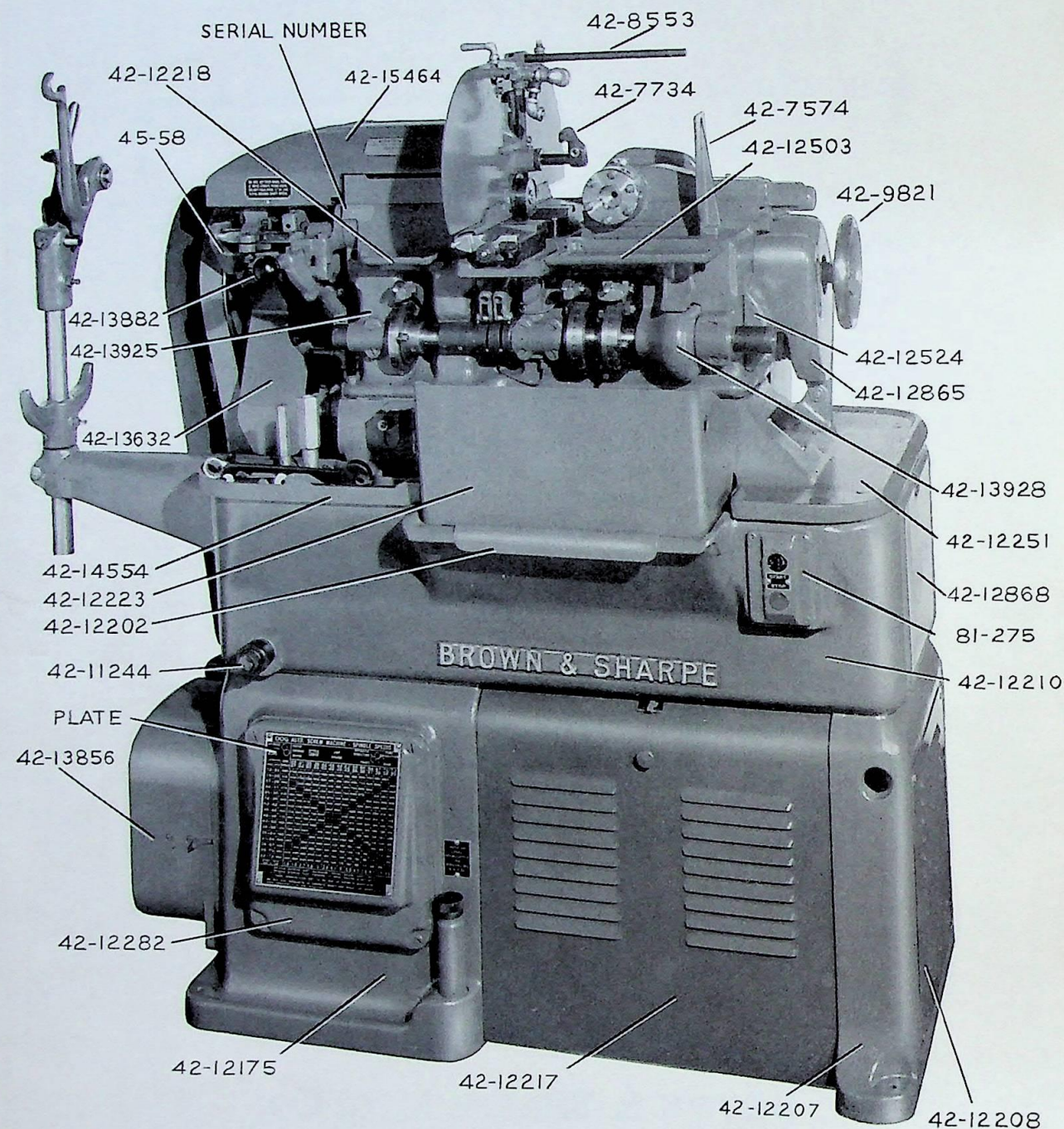
HOW TO ORDER REPAIR PARTS

This information is essential:

- 1 — Quantity, Part Number and Name**
- 2 — Size and Style of Machine**
**This will be found on the front
or side of the machine.**
- 3 — Serial Number of Machine or Attachment**
(Give both when ordering attachment parts)
**This number will be found stamped on parts
as designated in Repair Parts Book.**

BROWN & SHARPE MFG. CO.
PROVIDENCE 1, R. I., U. S. A.

**ORDER BY PART NUMBER AND NAME ALSO GIVE
SIZE, STYLE AND SERIAL NUMBER OF MACHINE.
(See instructions "How to order Repair Parts" in this book.)**



Front View

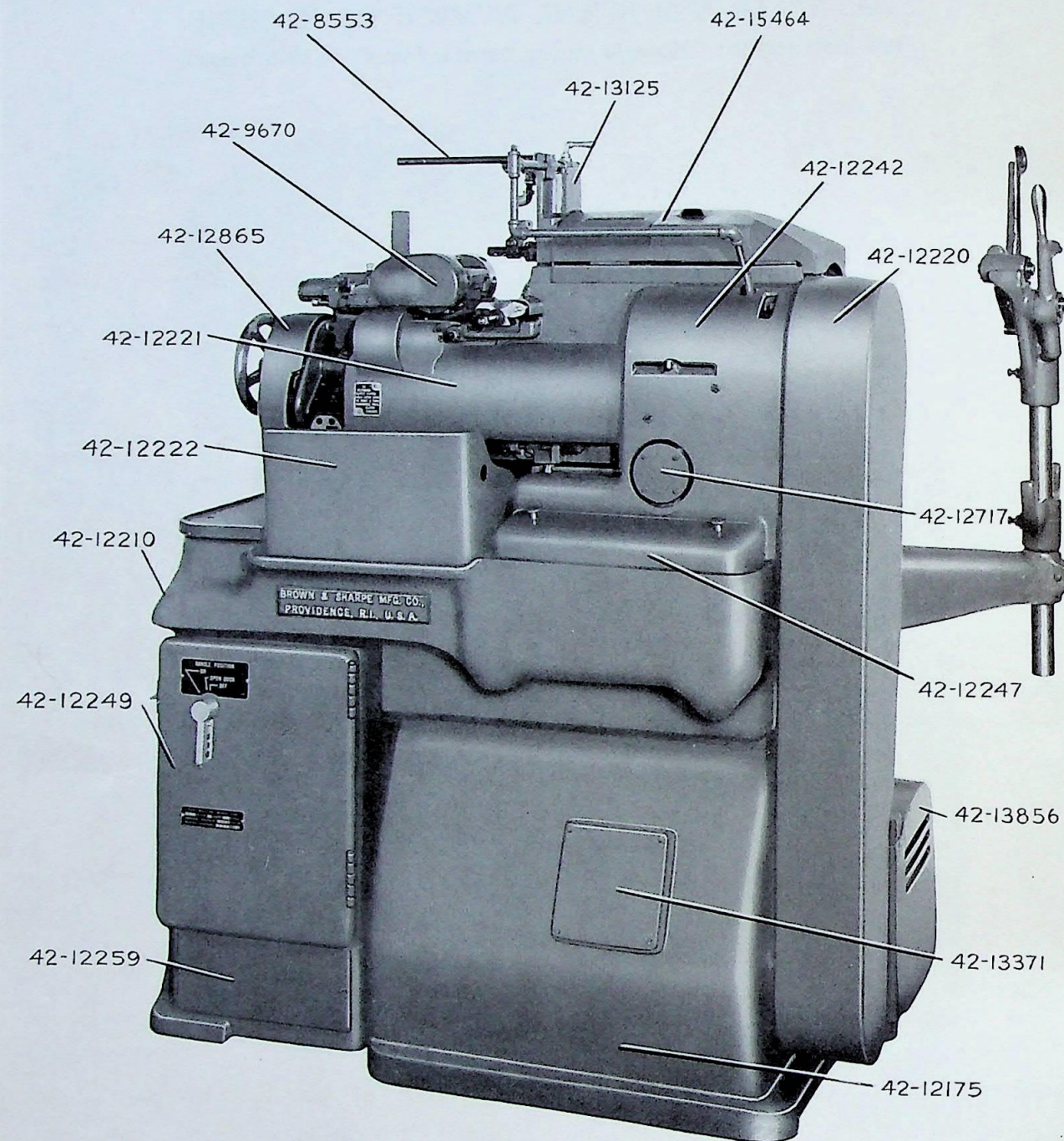
Front View

- 42-7574 Turret Tool Oil Guard
- 42-7734 Swing Stock Stop
- 42-8553 Oil Guard Support
- 42-9821 Handwheel
- 42-11244 Tank Table Drain Plug
- 42-12175 Base
- 42-12202 Work Pan
- 42-12207 Tank Table Leg
- 42-12208 Tank Table Leg Cover
- 42-12210 Tank Table
- 42-12217 Motor Cover, Front
- 42-12218 Tool Pan, Left
- 42-12223 Oil Shield, Front
- 42-12251 Bed Leg, Right
- 42-12282 Base Cover
- 42-12503 Tool Pan, Right
- 42-12524 Lead Cam Shaft Gear Guard
- 42-12865 Feed Change Gear Guard
- 42-12868 Change Gear Box Cover
- 42-13632 Pump Chain Guard
- 42-13856 Spindle Change Gear Cover
- 42-13882 Feed Starting Lever
- 42-13925 Bed
- 42-13928 Bevel Gear Guard
- 42-14554 Wrench Rack
- 42-15464 Spindle Cover
- 45-58 Feed Slide Bracket
- 81-275 Push Button, Complete
- Plate, Spindle Speed
 - 42-12206 (Screw Machines)
 - 44-9 (Cutting-Off Machines)

**ORDER BY PART NUMBER AND NAME ALSO GIVE
SIZE, STYLE AND SERIAL NUMBER OF MACHINE.
(See instructions "How to order Repair Parts" in this book.)**

Rear View

- | | |
|----------|---------------------------|
| 42-8553 | Oil Guard Support |
| 42-9670 | Turret Disk Guard |
| 42-12175 | Base |
| 42-12210 | Tank Table |
| 42-12220 | Driving Pulley Belt Guard |
| 42-12221 | Back Guard |
| 42-12222 | Oil Shield, Rear |
| 42-12242 | Driving Clutch Guard |
| 42-12247 | Lubricator Tubing Guard |
| 42-12249 | Switch Compartment Door |
| 42-12259 | Tank Table Leg Core Cover |
| 42-12717 | Receptacle Box Plate |
| 42-12865 | Feed Change Gear Guard |
| 42-13125 | Oil Pipe Support |
| 42-13371 | Base Hand Hole Cover |
| 42-13856 | Spindle Change Gear Cover |
| 42-15464 | Spindle Cover |

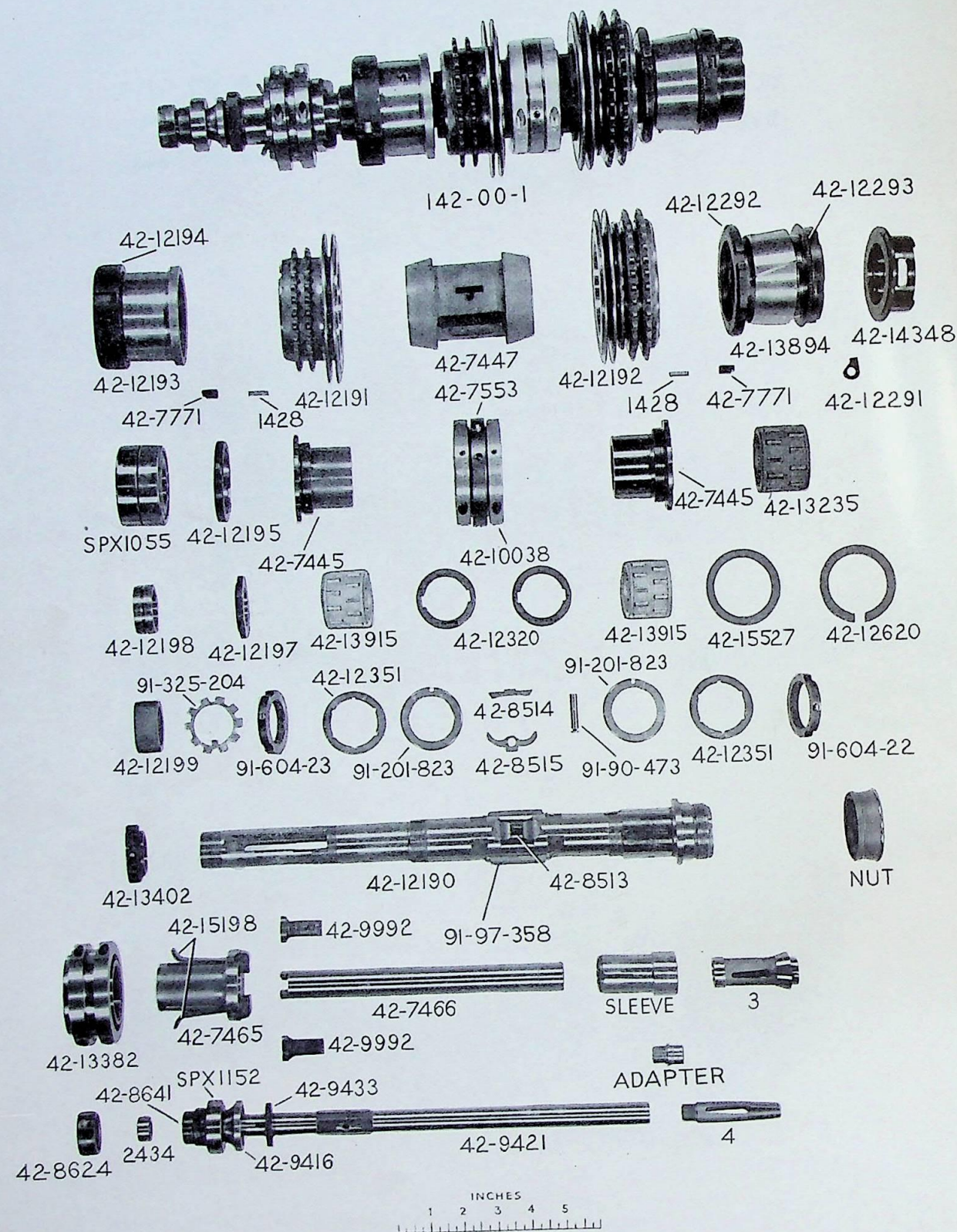


Rear View

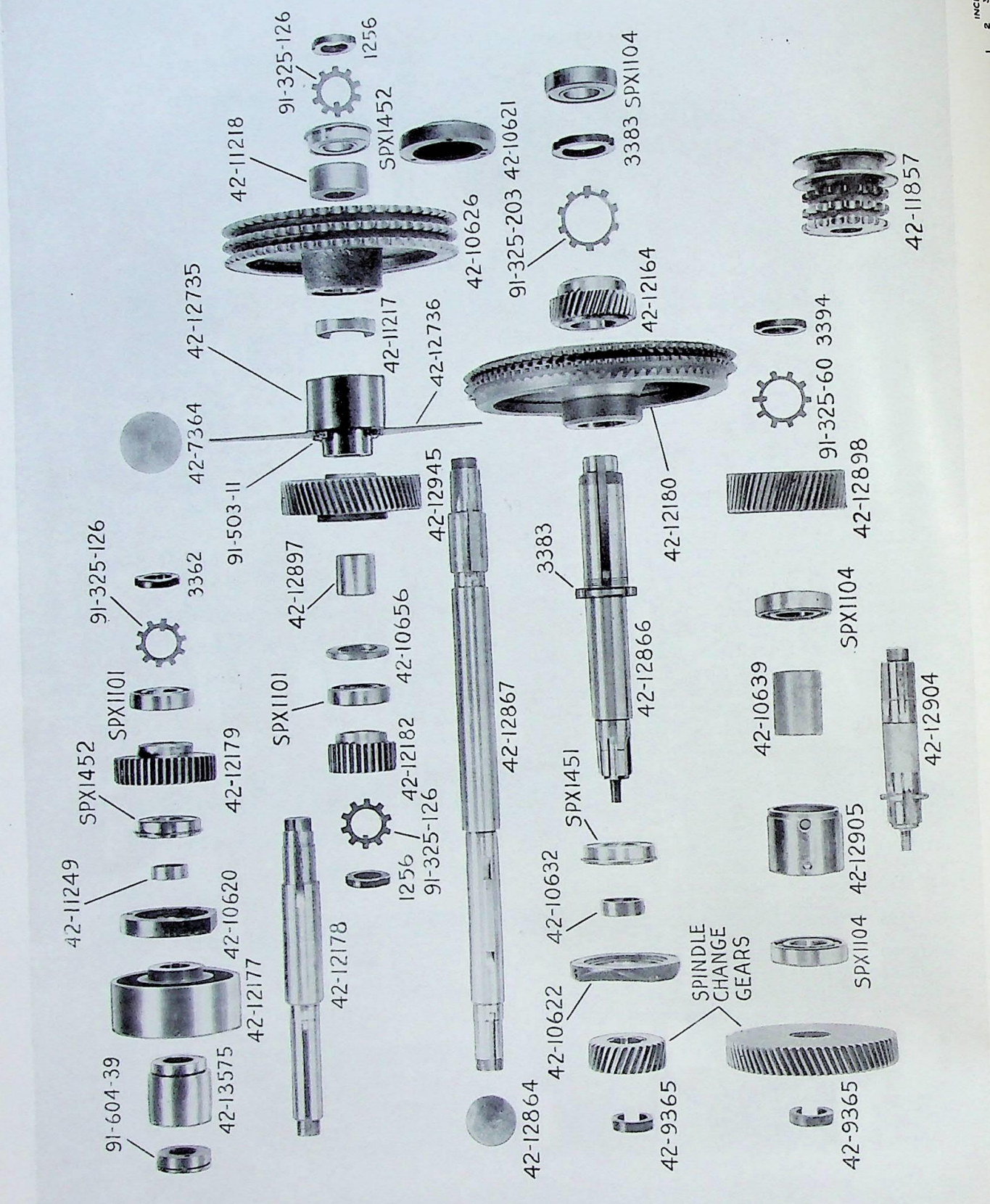
ORDER BY PART NUMBER AND NAME ALSO GIVE
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(See instructions "How to order Repair Parts" in this book.)

Spindle Assembly and Parts

- | | | | |
|----------|---|------------|--|
| 3 | Spring Collet (See Brown & Sharpe Catalog) | 42-12199 | Spindle Nut |
| 4 | Feeding Finger (See Brown & Sharpe Catalog) | 42-12291 | Spindle Front Box Nut Lock |
| | | 42-12292 | Spindle Front Box Nut, Left |
| | | 42-12293 | Spindle Front Box Nut, Right |
| 1428 | Spindle Sprocket Plunger Spring | 42-12320 | Clutch Body Washer |
| 2434 | Feed Tube Bushing (See Brown & Sharpe Catalog) | 42-12351 | Spindle Sprocket Thrust Washer, Bronze |
| | | 42-12620 | Spindle Labyrinth Washer Spring |
| | | 42-13235 | Spindle Front Box Roller Bearing |
| | | 42-13382 | Chuck Fork Sleeve, Complete |
| | | 42-13402 | Chuck Adjusting Nut |
| | | 42-13894 | Spindle Front Box (Includes 42-12292 and 42-12293) |
| 42-7445 | Spindle Sprocket Bushing | 42-13915 | Spindle Sprocket Roller Bearing |
| 42-7447 | Clutch Body | 42-14348 | Spindle Nose Oil Guard |
| 42-7465 | Chuck Lever Fulcrum | 42-15198 | Chuck Lever |
| 42-7466 | Chuck Closing Tube | 42-15527 | Spindle Labyrinth Washer |
| 42-7553 | Clutch Sleeve Ring | 91-90-473 | Clutch Lever Fulcrum |
| 42-7771 | Spindle Sprocket Plunger | 91-97-358 | Spindle Key |
| 42-8513 | Clutch Lever Spindle Insert | 91-201-823 | Spindle Sprocket Thrust Washer, Steel |
| 42-8514 | Clutch Shoe | 91-325-204 | Spindle Nut Lockwasher |
| 42-8515 | Clutch Lever | 91-604-22 | Spindle Pulley Thrust Nut, Right |
| 42-8624 | Feed Tube Adjusting Nut | 91-604-23 | Spindle Pulley Thrust Nut, Left |
| 42-8641 | Feed Tube Nut | | |
| 42-9416 | Feed Tube Collar | 142-00-1 | Spindle Assembly, Complete |
| 42-9421 | Feed Tube, Complete (Includes 2434, 42-8624, 42-8641, 42-9416, 42-9433 and SPX1152) | SPX1055 | Spindle Rear Box Ball Bearing (Matched Pair) |
| 42-9433 | Feed Tube Thrust Washer | SPX1152 | Feed Tube Ball Bearing |
| 42-9992 | Chuck Lever Fulcrum Shoe | | Adapter, Feeding Finger (See Brown & Sharpe Catalog) |
| 42-10038 | Clutch Sleeve, Complete (Includes 42-7553) | | |
| 42-12190 | Spindle (Includes 42-8513, 42-13619 and 91-97-358) | | Nut, Chuck |
| 42-12191 | Spindle Sprocket, Left (Includes 1428, 42-7445 and 42-7771) | | 42-11496 (For No. 10 Collet) |
| 42-12192 | Spindle Sprocket, Right (Includes 1428, 42-7445 and 42-7771) | | 42-11497 (For No. 00 Collet) |
| 42-12193 | Spindle Rear Box (Includes 42-12194 and 42-12195) | | |
| 42-12194 | Spindle Rear Box Nut | | Sleeve, Chuck |
| 42-12195 | Spindle Rear Bearing Retainer Nut | | 42-13618 (For No. 00 Collet) |
| 42-12197 | Spindle Rear Bearing Spacer, Right | | 42-13619 (For No. 10 Collet) |
| 42-12198 | Spindle Rear Bearing Spacer, Left | | |



Spindle Assembly and Parts



Spindle Drive

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(See instructions "How to order Repair Parts" in this book.)**

Spindle Drive

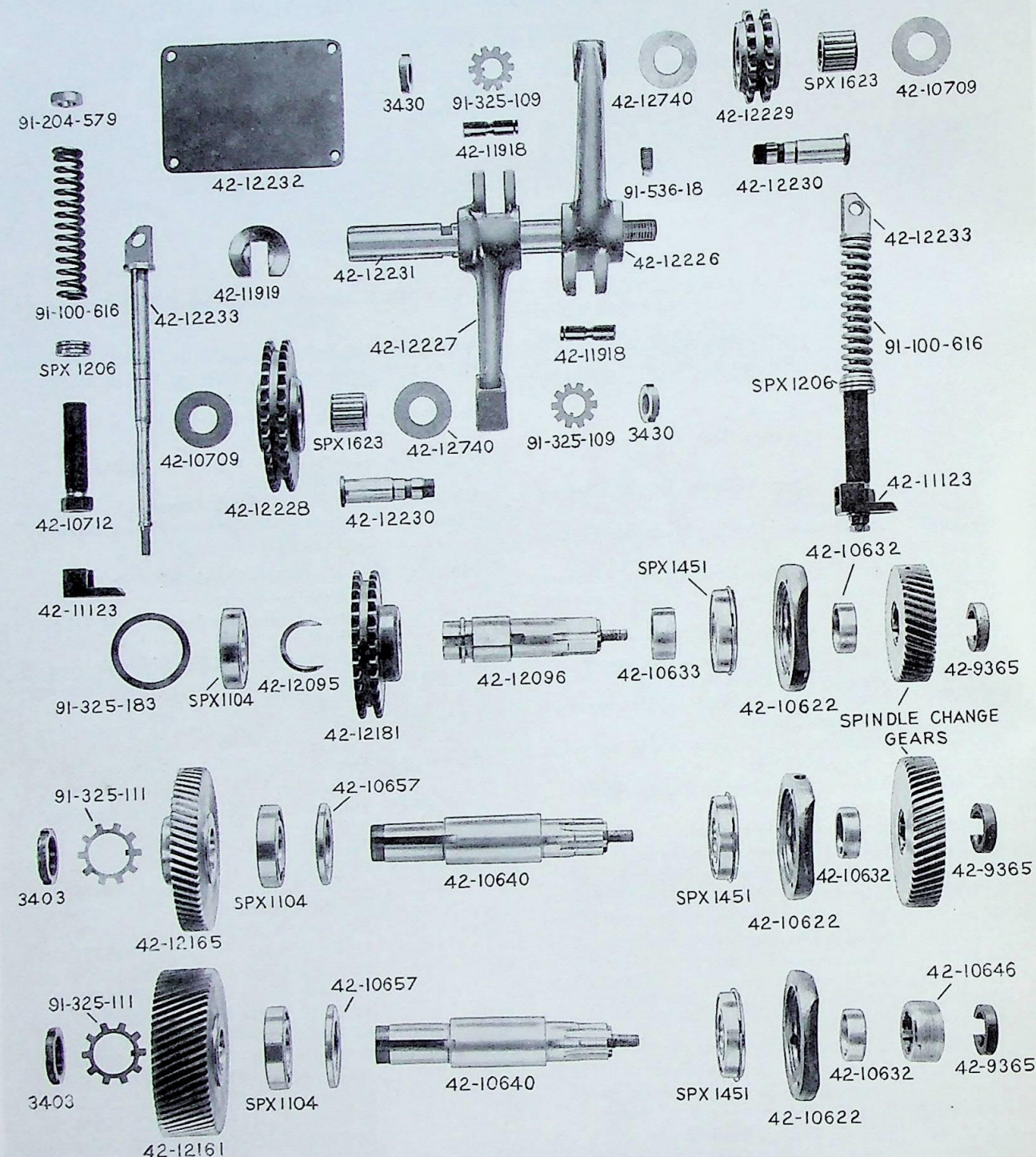
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SIZE, STYLE AND SERIAL NUMBER OF MACHINE.
(See instructions "How to order Repair Parts" in this book.)

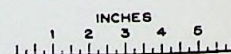
Spindle Drive (cont'd)

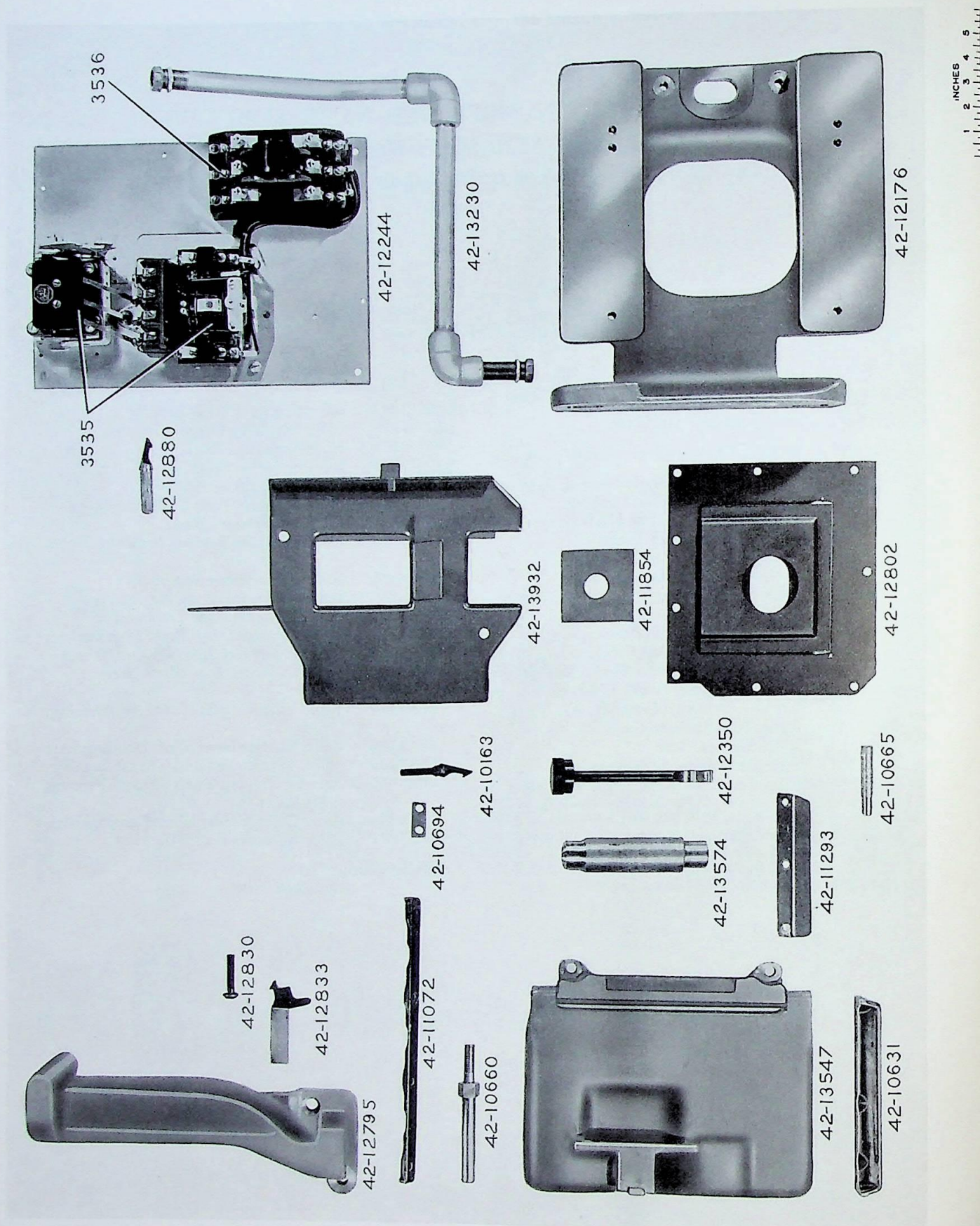
3403	Ratio Change Gear Shaft Nut	42-12227	Idler Sprocket Arm, Left
3430	Idler Sprocket Stud Nut	42-12228	Idler Sprocket, Large
42-9365	Spindle Change Gear Washer	42-12229	Idler Sprocket, Small
42-10622	Spindle Driving Shaft Bearing Retainer	42-12230	Idler Sprocket Stud
42-10632	Spindle Driving Shaft Spacer	42-12231	Idler Sprocket Arm Shaft
42-10633	Slow Spindle Driving Shaft Spacer	42-12232	Idler Sprocket Arm Shaft Cover
42-10640	Ratio Change Gear Shaft	42-12233	Idler Adjustment Rod
42-10646	Ratio Change Gear Collar	42-12740	Idler Sprocket Bearing Retainer, Inner
42-10657	Ratio Gear Shaft Bearing Plate	91-100-616	Idler Adjustment Spring
42-10709	Idler Sprocket Bearing Retainer, Outer	91-204-579	Idler Adjustment Spring Spacer
42-10712	Idler Adjusting Rod Screw	91-325-109	Idler Sprocket Stud Lockwasher
42-11123	Idler Adjusting Rod Lock	91-325-111	Ratio Change Gear Shaft Lockwasher
42-11918	Idler Adjusting Rod Fulcrum	91-325-183	Spindle Driving Shaft Spring Washer
42-11919	Idler Adjusting Arm Shaft Washer	91-536-18	Idler Sprocket Arm Shaft Screw
42-12095	Spindle Driving Shaft Washer		
42-12096	Spindle Driving Shaft (Slow)	SPX1104	Spindle Driving Shaft (Slow) Bearing, Left
42-12161	Ratio Intermediate Gear	SPX1104	Ratio Change Gear Shaft Bearing, Left
42-12165	Ratio Driven Gear	SPX1206	Idler Adjustment Rod Thrust Bearing
42-12181	Spindle Driving Sprocket, Small	SPX1451	Spindle Driving Shaft (Slow) Bearing, Right
42-12224	Idler Sprocket Arm, Right Complete (Includes 3430, 42-10709, 42-12226, 42-12229, 42-12230, 42-12740, 91-325-109 and SPX1623)	SPX1451	Ratio Change Gear Shaft Bearing, Right
42-12225	Idler Sprocket Arm, Left Complete (Includes 3430, 42-10709, 42-12227, 42-12228, 42-12230, 42-12740, 91-325-109 and SPX1623)	SPX1623	Idler Sprocket Roller Bearing
42-12226	Idler Sprocket Arm, Right		

Spindle Change Gears
See Page 9



Spindle Drive (cont'd)





Base Parts

ORDER BY PART NUMBER AND NAME ALSO GIVE
SIZE, STYLE AND SERIAL NUMBER OF MACHINE.
(See instructions "How to order Repair Parts" in this book.)

Base Parts

- *3535 Combination Switch (Disconnect Switch and Magnetic Starter)
- *3536 Reversing Switch

- 42-10163 Motor Cover Catch
- 42-10631 Ratio Change Gear Cover Oil Collector
- 42-10660 Change Gear Cover Bracket Stud
- 42-10665 Motor Cover Fulcrum Pin
- 42-10694 Motor Cover Catch Block
- 42-11072 Spindle Change Gear Cover Oil Collector
- 42-11293 Cover Oil Deflector
- 42-11854 Labyrinth Oil Seal
- 42-12176 Motor Bracket
- 42-12244 Control Panel Base
- 42-12350 Oil Gage Cap
- 42-12795 Change Gear Cover Bracket
- 42-12802 Motor Shaft Oil Labyrinth
- 42-12830 Catch Adjusting Screw
- 42-12833 Change Gear Cover Catch
- 42-12880 Switch Compartment Cover Catch
- 42-13230 Push Button Conduit
- 42-13547 Ratio Change Gear Cover (Includes 42-11293)
- 42-13574 Oil Gage Sleeve
- 42-13932 Base Gear Guard

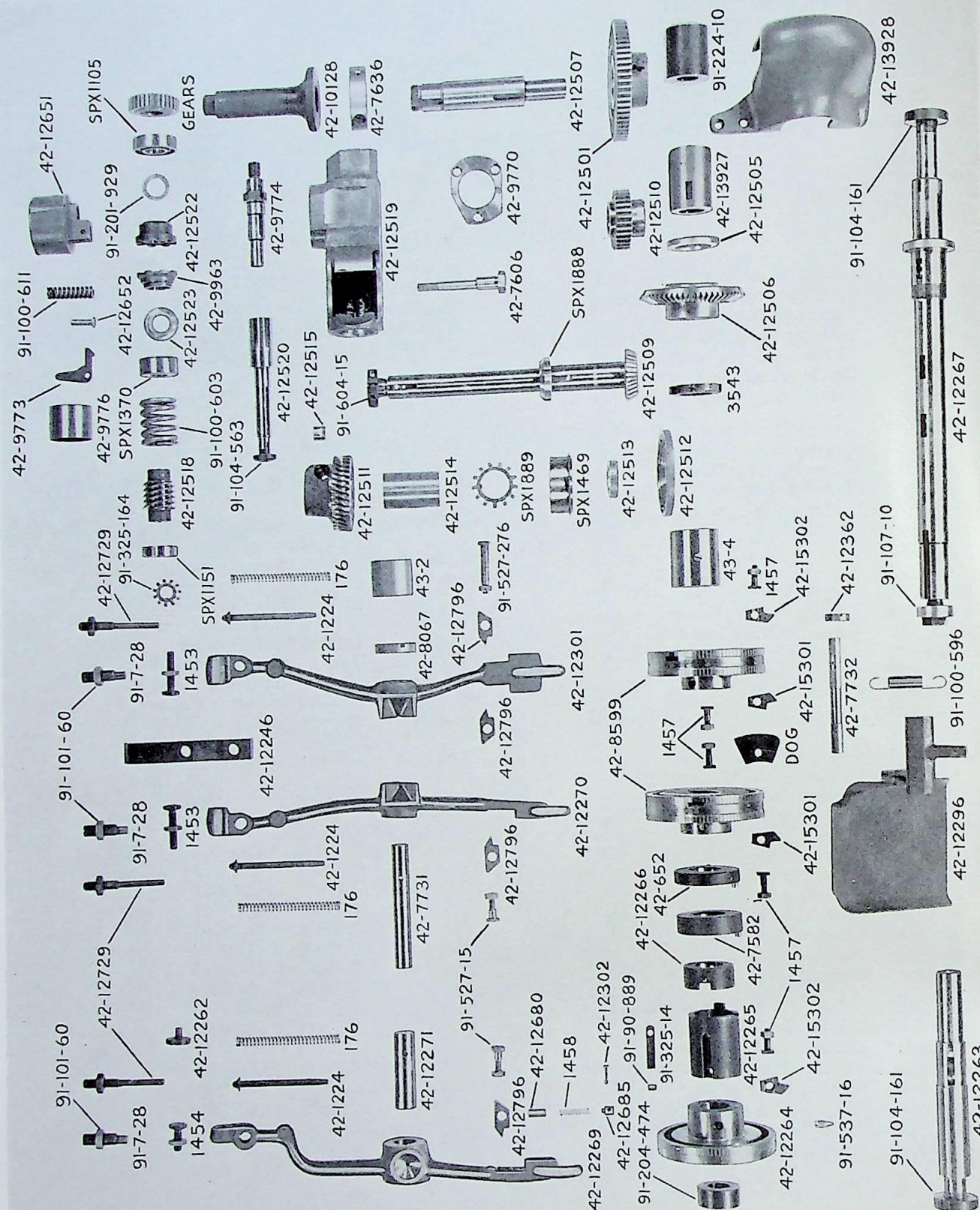
NOT SHOWN
†3773 Motor

*Specify Volts, Cycles and Phase

†Give Complete Motor Name Plate Data

— 14 —

— 15 —

INCHES
1 2 3 4 5 6

Clutch Trip Levers and Operating Parts

ORDER BY PART NUMBER AND NAME ALSO GIVE
SIZE, STYLE AND SERIAL NUMBER OF MACHINE.
(See instructions "How to order Repair Parts" in this book.)

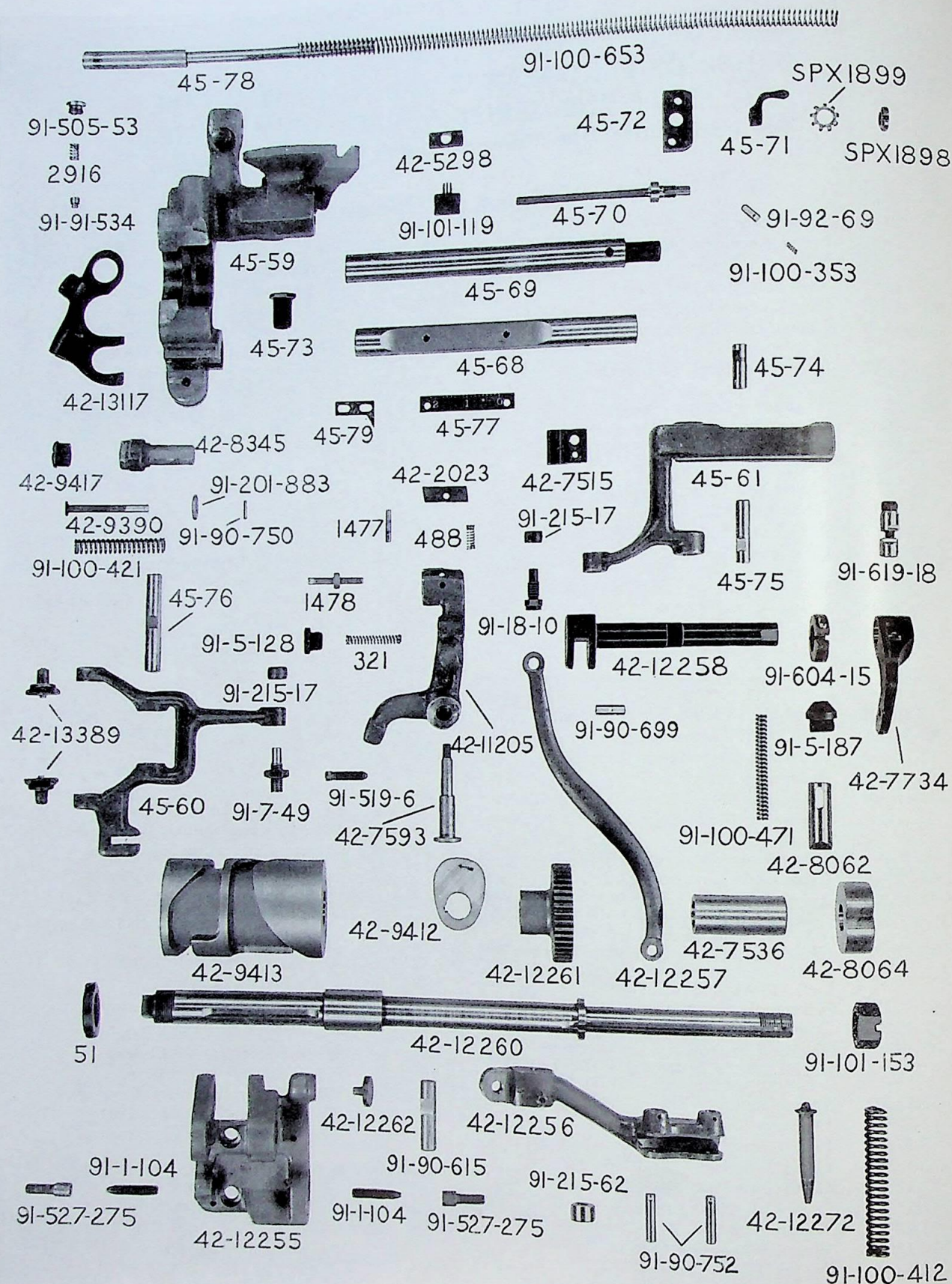
Clutch Trip Levers and Operating Parts

176	Trip Lever Plunger Spring	42-12518	Worm
1453	Lever Abutment Adjusting Screw, Long	42-12519	Worm Case
1454	Lever Abutment Adjusting Screw, Short	42-12520	Worm Shaft
1457	Trip Dog Bolt and Nut	42-12522	Worm Safety Clutch Driver
1458	Trip Lever Dog Spring	42-12523	Worm Shaft Thrust Washer
3543	Cross Slide Cam Shaft Thrust Nut	42-12651	Worm Safety Latch Carrier
		42-12652	Worm Safety Latch Plunger
42-652	Cross Slide Cam Holder, Front	42-12680	Trip Lever Dog Spring Plunger
42-1224	Trip Lever Spring Plunger	42-12685	Trip Lever Dog Spring Retainer
42-7582	Cross Slide Cam Holder, Back	42-12729	Lever Stop and Nut
42-7606	Worm Shaft Bearing Eccentric Stud	42-12796	Trip Lever Dog
42-7636	Lead Cam Holder	42-13927	Cross Slide Cam Shaft Cap Bushing
42-7731	Turret and Chuck Trip Lever Fulcrum	42-13928	Bevel Gear Guard
42-7732	Deflector Fulcrum	42-15301	Trip Dog, Left (Includes 1457)
42-8067	Trip Lever Fulcrum Collar	42-15302	Trip Dog, Right (Includes 1457)
42-8599	Chuck or Turret Dog Carrier (Includes 91-537-16)	43-2	Clutch Trip Lever Fulcrum Collar (Cutting- Off Machines)
42-9770	Worm Case Cap	43-4	Dog Carrier Collar (Cutting-Off Machines)
42-9773	Worm Safety Latch		
42-9774	Worm Shaft Extension	91-7-28	Clutch Operating Screw
42-9776	Worm Safety Clutch Sleeve	91-90-889	Reverse Coupling Screw Pin
42-9963	Worm Safety Clutch, Driven	91-100-596	Deflector Spring
		91-100-603	Worm Safety Clutch Spring
		91-100-611	Worm Safety Latch Spring
42-10128	Lead Cam Clamp Nut, Complete	91-101-60	Clutch Operating Screw Nut
42-12246	Trip Lever Abutment	91-104-161	Reverse Shaft Nut
42-12262	Reversing Trip Lever Abutment	91-104-161	Slotting Extension Sleeve Nut
42-12263	Reversing Shaft	91-104-563	Worm Shaft Nut
42-12264	Reversing Dog Carrier (Includes 91-537-16)	91-107-10	Cross Slide Cam Shaft Nut
42-12265	Reversing Shaft Coupling (Includes 91-325-14)	91-201-929	Worm Shaft Extension Washer
		91-204-474	Vertical Slide Extension Sleeve
42-12266	Cross Slide Cam Shaft Collar		
42-12267	Cross Slide Cam Shaft	91-224-10	Slotting Extension Sleeve
42-12269	Reverse Clutch Trip Lever (Includes 1454, 1458, 42-12302, 42-12680, 42-12685, 42-12796, 91-7-28, 91-101-60 and 91-527-15)	91-325-14	Reversing Shaft Coupling Spring
42-12270	Chuck Clutch Trip Lever (Includes 1453, 1458, 42-12302, 42-12680, 42-12685, 42-12796, 91-7-28, 91-101-60 and 91-527-15)	91-325-164	Worm Shaft Nut Lockwasher
42-12271	Reverse Trip Lever Fulcrum	91-527-15	Trip Lever Dog Bolt, Short
42-12296	Deflector	91-527-276	Trip Lever Dog Bolt, Long
42-12301	Turret Clutch Trip Lever (Includes 1453, 1458, 42-12302, 42-12680, 42-12685, 42-12796, 91-7-28, 91-101-60 and 91-527-276)	91-537-16	Dog Carrier Set Screw
		91-604-15	Worm Wheel Shaft Nut
42-12302	Spring Retainer Pin	SPX1105	Worm Shaft Extension Bearing
42-12362	Deflector Fulcrum Collar	SPX1151	Worm Shaft Bearing, Outer
42-12501	Lead Cam Shaft Gear	SPX1370	Worm Shaft Bearing, Inner
42-12505	Cross Slide Cam Shaft Spacer	SPX1469	Worm Wheel Shaft Ball Bearing
42-12506	Cross Slide Cam Shaft Gear	SPX1888	Worm Wheel Shaft Lock Nut
42-12507	Lead Cam Shaft	SPX1889	Worm Wheel Shaft Lockwasher
42-12509	Worm Wheel Shaft (Includes SPX1888)		
42-12510	Worm Wheel Shaft Gear, Driver		
42-12511	Worm Wheel (Includes 42-12515)		
42-12512	Worm Wheel Shaft Bearing Retainer		
42-12513	Worm Wheel Shaft Spacer		
42-12514	Worm Wheel Shaft Bearing Bushing		
42-12515	Worm Wheel Clamp Bushing		
		Dog, Deflector	
		42-15458	(30° Angle of Arc)
		42-15459	(45° Angle of Arc)
		42-15460	(72° Angle of Arc)
		Gears, Feed Change	
		See Page 15	
		NOT SHOWN	
		42-15875	Lead Cam Shaft Bushing (On Bed)

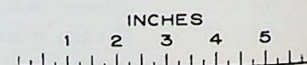
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(See instructions "How to order Repair Parts" in this book.)**

Chuck and Feed Operating Parts

51	Chuck Cam Shaft Nut, Left	45-71	Feed Adjusting Crank
321	Stopping Lever Spring	45-72	Feed Adjusting Screw Cap (Includes 91-92-69 and 91-100-353)
488	Stopping Lever Latch Spring	45-73	Feed Slide Bearing Adjusting Sleeve
1477	Stopping Lever Latch Fulcrum	45-74	Feed Lever Fulcrum, Short
1478	Stopping Lever Adjusting Screw	45-75	Feed Lever Fulcrum, Long
2916	Feed Tube Bearing Plunger Spring	45-76	Chuck Fork Fulcrum
		45-77	Feed Scale
		45-78	Stopping Spring Plunger
		45-79	Feed Pointer
42-2023	Stopping Lever Latch	91-1-104	Back Guard Hinge Screw
42-5298	Feed Lever Block	91-5-128	Stopping Lever Spring Screw
42-7515	Starting Lever Plunger Plate	91-5-187	Stopping Disk Plunger Spring Screw
42-7536	Chuck Cam Shaft Sleeve	91-7-49	Chuck Cam Roll Stud
42-7593	Stopping Lever Stud	91-18-10	Feed Cam Roll Stud
42-7734	Swing Stock Stop (Includes 91-619-18)	91-90-615	Stock Stop Lever Fulcrum
42-8062	Stopping Disk Plunger	91-90-699	Stock Stop Shaft Fulcrum
42-8064	Chuck Cam Shaft Stop Disk	91-90-750	Feed Latch Shearing Pin
42-8345	Feed Latch Plunger Sleeve	91-90-752	Stock Stop Cam Lever Pin
42-9390	Feed Latch Plunger	91-91-534	Feed Tube Bearing Plunger
42-9412	Stock Stop Cam	91-92-69	Feed Adjusting Screw Locking Plunger
42-9413	Chuck and Feed Cam		
42-9417	Feed Latch Plunger Sleeve Nut	91-100-353	Feed Adjusting Screw Locking Spring
42-11205	Stopping Lever (Includes 488, 1477, 1478, 42-2023 and 91-519-6)	91-100-412	Stock Stop Cam Lever Spring
42-12255	Stock Stop Cam Lever Bracket (Includes 42-12262)	91-100-421	Feed Latch Plunger Spring
42-12256	Stock Stop Cam Lever (Includes 91-90-752 and 91-215-62)	91-100-471	Stop Disk Plunger Spring
42-12257	Stock Stop Connecting Link	91-100-653	Stopping Spring
42-12258	Stock Stop Shaft	91-101-119	Feed Adjusting Screw Nut
42-12260	Chuck Cam Shaft	91-101-153	Chuck Cam Shaft Nut, Right
42-12261	Chuck Cam Shaft Gear	91-201-883	Feed Latch Plunger Washer
42-12262	Reverse Trip Lever Abutment		
42-12272	Cam Lever Spring Plunger	91-215-17	Chuck Cam Roll
42-13117	Feed Latch (Includes 2916, 91-91-534 and 91-505-53)	91-215-17	Feed Cam Roll
42-13389	Chuck Fork Sleeve Shoe	91-215-62	Stock Stop Cam Roll
45-59	Feed Slide	91-505-53	Feed Tube Bearing Plunger Spring
45-60	Chuck Fork (Includes 91-7-49)	91-519-6	Starting Lever Adjusting Screw
45-61	Feed Lever (Includes 91-18-10)	91-527-275	Back Guard Pivot Eccentric
45-68	Feed Slide Guide	91-604-15	Stock Stop Shaft Nut
45-69	Feed Slide Round Bar Way	91-619-18	Stock Stop Clamp Bushing, Complete
45-70	Feed Adjusting Screw	SPX1898	Feed Adjusting Screw Nut
		SPX1899	Feed Adjusting Screw Lockwasher



Chuck and Feed Operating Parts



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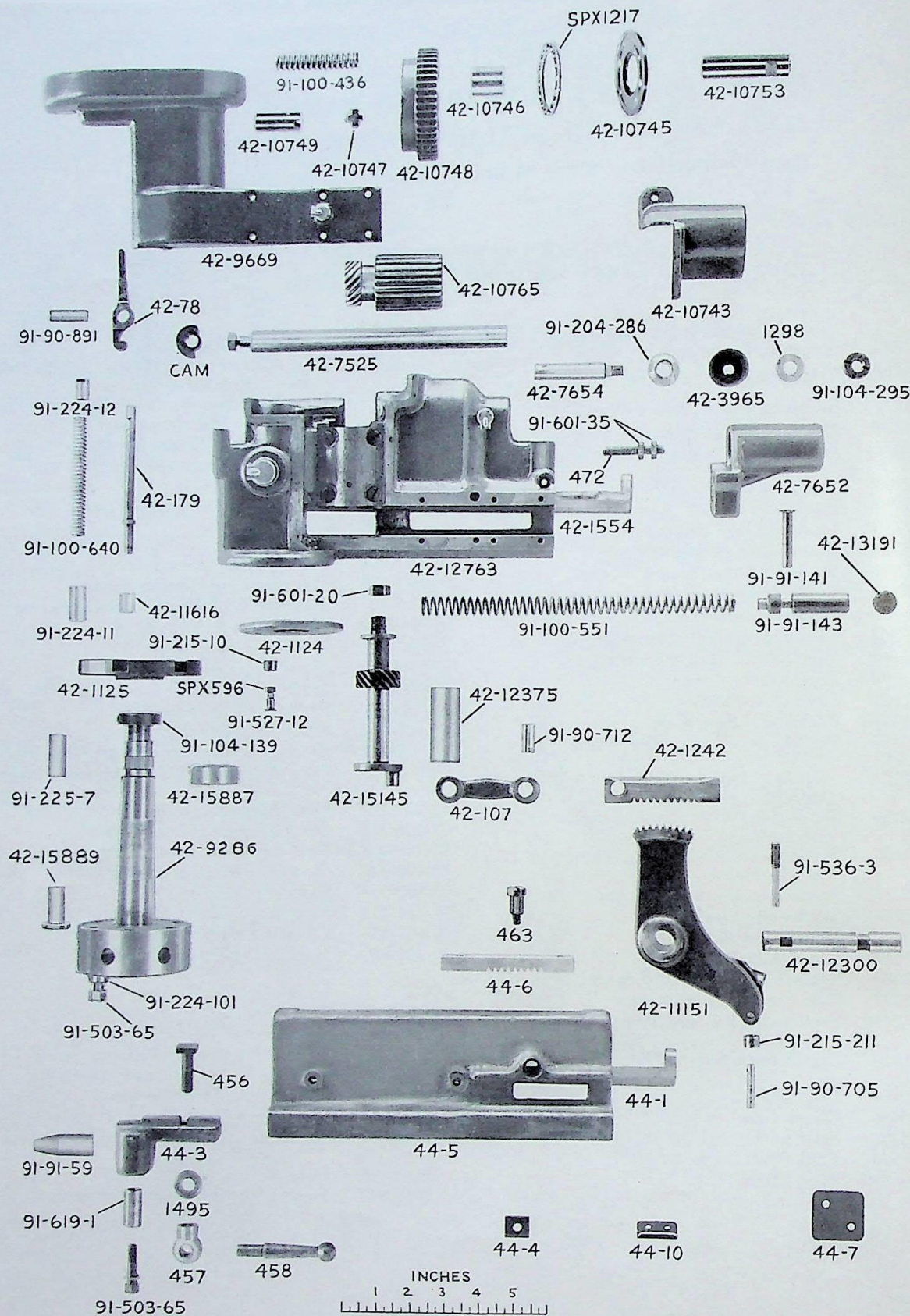
Turret and Stop Holder Slide Parts

Automatic Screw Machines

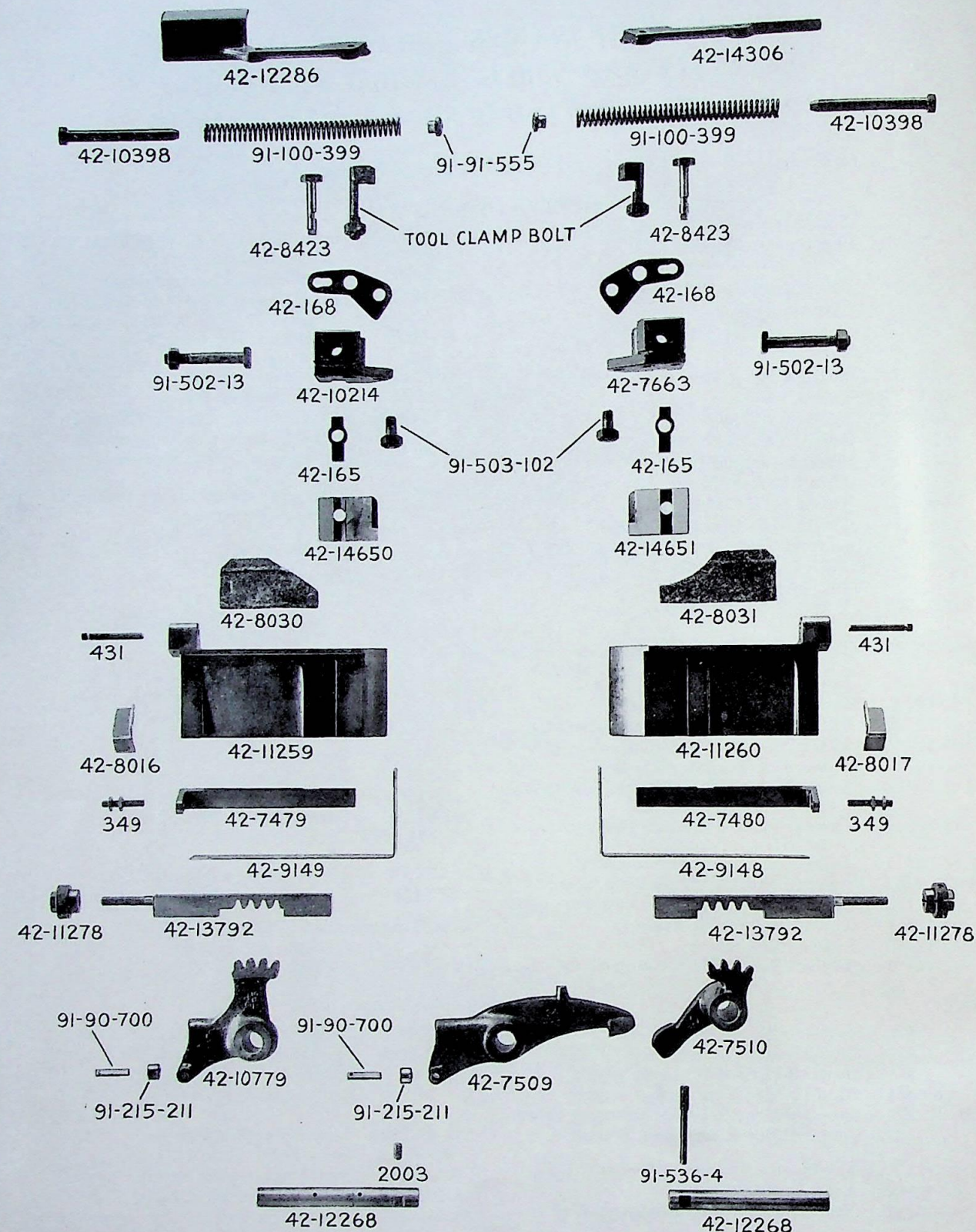
472	Turret Slide Gib Adjusting Screw	42-12763	Turret Slide (Includes 42-9669, 42-12375 and 42-9670 on page 5)
1298	Plunger Nut Washer	42-13191	Turret Spring Plunger Buffer
42-78	Turret Locking Pin Lever	42-15145	Turret Change Shaft (Includes 42-1124, 91-215-10, 91-527-12, 91-601-20 and SPX596)
42-107	Connecting Rod	42-15887	Turret Disk Driving Sleeve
42-179	Turret Locking Pin (Includes 91-224-11)	91-90-705	Lead Lever Roll Pin
42-1124	Turret Change Roll Disk	91-90-712	Connecting Rod Pin
42-1125	Turret Disk	91-90-891	Turret Locking Pin Lever Fulcrum
42-1242	Turret Slide Rack	91-91-141	Turret Slide Spring Plunger Pin
42-1554	Turret Slide Gib	91-91-143	Turret Slide Spring Plunger
42-3965	Plunger Cupped Washer	91-100-436	Turret Intermediate Gear Spring
42-7525	Turret Return Shaft	91-100-551	Turret Slide Spring
42-7652	Turret Slide Cushion Case	91-100-640	Turret Locking Pin Spring
42-7654	Turret Slide Cushion Plunger	91-104-139	Turret Disk Nut
42-9286	Turret (Includes 42-1125, 42-11616, 42-15887, 42-15889, 91-104-139, 91-224-101, 91-225-7 and 91-503-65)	91-104-295	Plunger Nut
42-9669	Turret Slide Guard	91-204-286	Plunger Collar
42-10742	Turret Slide Cushion, Complete (Includes 1298, 42-3965, 42-7652, 42-7654, 42-10743, 91-104-295 and 91-204-286)	91-215-10	Turret Change Roll
42-10743	Turret Slide Cushion Guard	91-215-211	Lead Lever Roll
42-10745	Intermediate Gear Thrust Washer	91-224-11	Turret Locking Pin Sleeve, Front
42-10746	Turret Intermediate Gear Bushing	91-224-12	Turret Locking Pin Sleeve, Back
42-10747	Turret Intermediate Gear Roll	91-224-101	Turret Tool Clamp Bushing
42-10748	Turret Intermediate Gear (Includes 42-10745, 42-10746 and SPX1217)	91-225-7	Turret Bushing
42-10749	Turret Intermediate Gear Plunger (Includes 42-10747)	91-503-65	Turret Tool Clamp Bolt
42-10753	Turret Intermediate Gear Shaft	91-527-12	Turret Change Roll Stud
42-10765	Turret Change Shaft Driving Gear	91-536-3	Lead Lever Fulcrum Screw
42-11151	Lead Lever (Includes 91-90-705 and 91-215-211)	91-601-20	Turret Change Shaft Nut
42-11616	Turret Locking Pin Bushing	91-601-35	Turret Slide Gib Nut
42-12300	Lead Lever Fulcrum	SPX 596	Turret Change Roll Stud Nut
42-12375	Turret Change Shaft Bushing	SPX 1217	Turret Intermediate Gear Thrust Bearing
		Cam, Turret Locking Pin	
		42-7848 (Single Throw)	
		42-7849 (Double Throw)	

Automatic Cutting-Off Machines

456	Stop Holder Clamp Bolt	44-5	Stop Holder Slide (Includes 44-6)
457	Stop Holder Clamp Nut	44-6	Stop Holder Slide Rack
458	Stop Holder Clamp Lever	44-7	Turret Buffer Plate
463	Stop Holder Slide Spring Plunger	44-10	Lead Lever Slot Cover
472	Stop Holder Slide Gib Adjusting Screw		
1495	Stop Holder Clamp Bolt Washer	91-90-705	Lead Lever Roll Pin
		91-91-59	Stock Stop
42-11151	Lead Lever (Includes 91-90-705 and 91-215-11)	91-91-143	Stop Holder Slide Spring Plunger
42-12300	Lead Lever Fulcrum	91-100-551	Stop Holder Slide Spring
42-13191	Stop Holder Spring Plunger Buffer	91-215-211	Lead Lever Roll
		91-503-65	Stop Clamp Bolt
44-1	Stop Holder Slide Gib	91-536-3	Lead Lever Fulcrum Screw
44-3	Stop Holder (Includes 456, 457, 458, 1495, 91-503-65 and 91-619-1)	91-601-35	Stop Holder Slide Gib Nut
44-4	Stop Holder Stop	91-619-1	Stop Clamp Bushing



Turret and Stop Holder Slide Parts

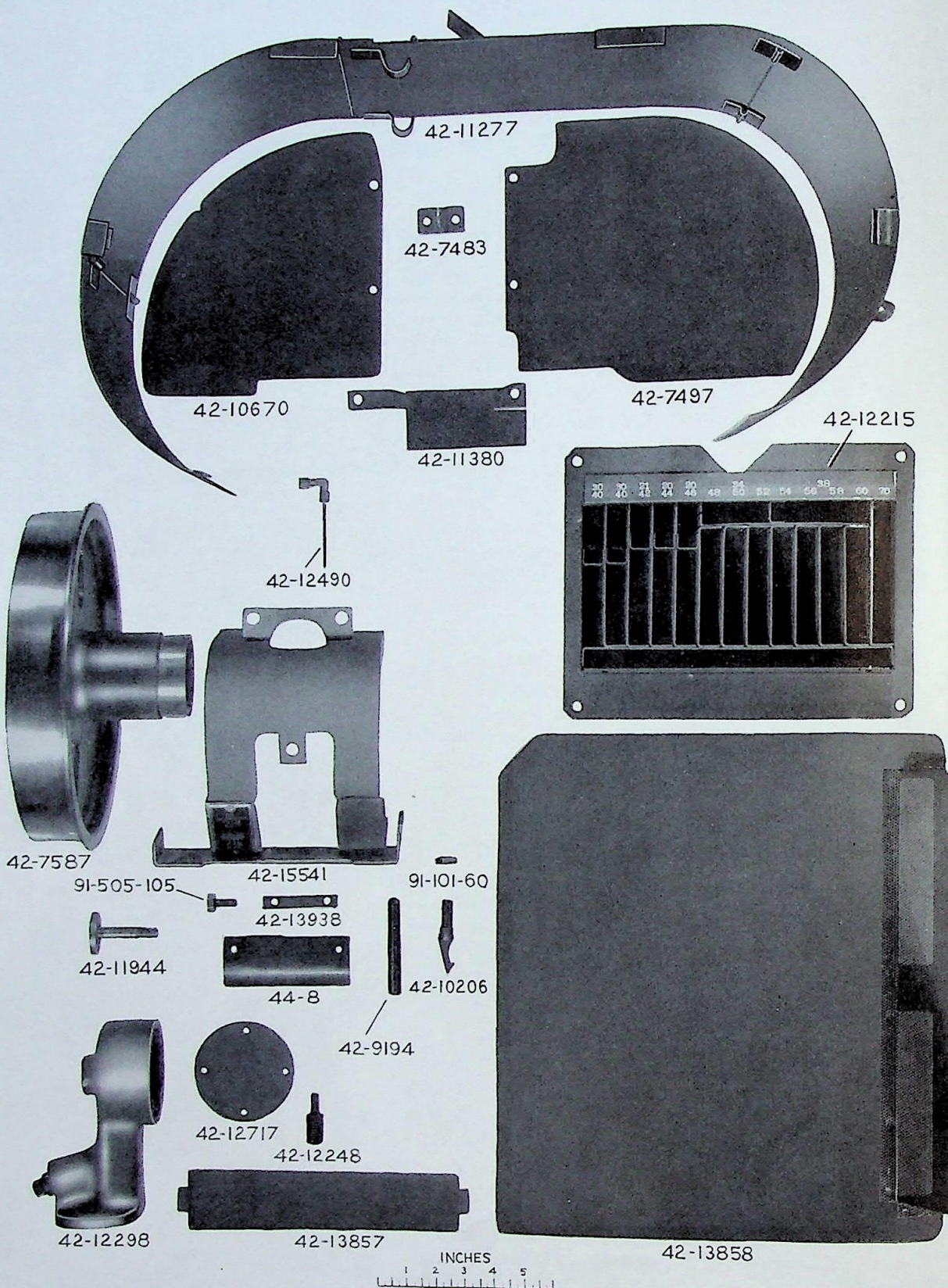


Cross Slides and Tool Posts

ORDER BY PART NUMBER AND NAME ALSO GIVE
 SIZE, STYLE AND SERIAL NUMBER OF MACHINE.
 (See instructions "How to order Repair Parts" in this book.)

Cross Slides and Tool Posts

349	Cross Slide Gib Adjusting Screw and Nuts
431	Cross Slide Stop Adjusting Screw
2003	Cross Slide Lever Fulcrum Screw
42-165	Tool Post Swivel
42-168	Tool Adjusting Block
42-7479	Cross Slide Gib, Front
42-7480	Cross Slide Gib, Back
42-7509	Cross Slide Lever, Back (Includes 91-90-700 and 91-215-211)
42-7510	Cross Slide Segment
42-7663	Tool Post, Back
42-8016	Cross Slide Gib Screw Guard, Front
42-8017	Cross Slide Gib Screw Guard, Back
42-8030	Cross Slide Felt, Front
42-8031	Cross Slide Felt, Back
42-8423	Tool Post Eccentric
42-9148	Cross Slide Guard, Back
42-9149	Cross Slide Guard, Front
42-10214	Tool Post, Front
42-10398	Cross Slide Spring Plunger
42-10779	Cross Slide Lever, Front (Includes 91-90-700 and 91-215-211)
42-11259	Cross Slide, Front
42-11260	Cross Slide, Back
42-11278	Cross Slide Dial, Front
42-12268	Cross Slide Lever Fulcrum
42-12286	Cross Slide Chip Guard, Front
42-13792	Cross Slide Rack
42-14306	Cross Slide Chip Guard, Back
42-14650	Tool Post Raising Block, Front
42-14651	Tool Post Raising Block, Back
91-90-700	Cross Slide Lever Pin
91-91-555	Cross Slide Spring Holder
91-100-399	Cross Slide Spring
91-215-211	Cross Slide Cam Roll
91-502-13	Tool Post Clamp Bolt
91-503-102	Tool Post Tool Clamp Screw
91-536-4	Cross Slide Segment Set Screw
142-00-10	Back Tool Post, Complete
142-00-12	Front Tool Post, Complete
Tool Clamp Bolt	
42-15148	Back 1 1/8" Long
42-15149	Back 1 3/8" Long
42-15158	Front 1 1/8" Long
42-15159	Front 2 1/4" Long
42-15160	Front 1 1/8" Long



Guards, etc.

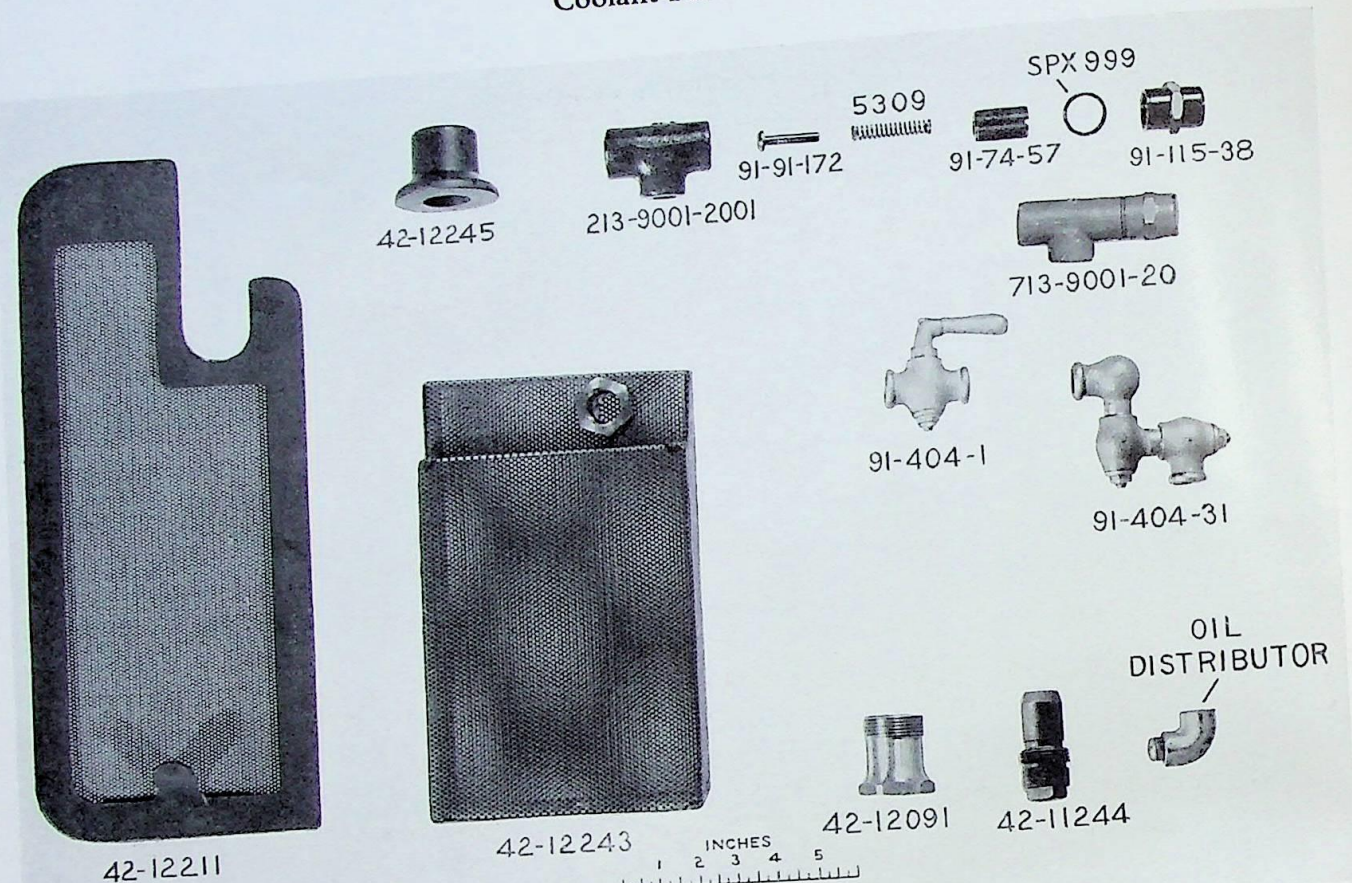
ORDER BY PART NUMBER AND NAME ALSO GIVE
SIZE, STYLE AND SERIAL NUMBER OF MACHINE.
(See instructions "How to order Repair Parts" in this book.)

Guards, etc.

- 42-7483 Oil Pipe Support Cap
- 42-7497 Forward Oil Guard Side
- 42-7587 Driving Pulley (Includes 42-7331 on page 15)
- 42-9194 Oil Shield Pin
- 42-10206 Back Guard Catch
- 42-10670 Rear Oil Guard Side
- 42-11277 Oil Guard
- 42-11380 Oil Pipe Support Splash Guard
- 42-11944 Driving Clutch Guard Screw
- 42-12215 Feed Change Gear Box
- 42-12248 Lubricator Adjusting Screw
- 42-12298 Receptacle Box (Includes 42-12717)
- 42-12490 Spindle Clutch Oil Tube
- 42-12717 Receptacle Box Plate
- 42-13857 Tank Plate, Front
- 42-13858 Tank Plate, Right
- 42-13938 Spindle Sprocket Guard Support Strap
- 42-15541 Spindle Sprocket Guard, Front
- 44-8 Turret Gear Opening Cover (Cutting-Off Machines)
- 91-101-60 Back Guard Catch Locknut
- 91-505-105 Spindle Sprocket Guard Strap Screw

ORDER BY PART NUMBER AND NAME ALSO GIVE
SIZE, STYLE AND SERIAL NUMBER OF MACHINE.
(See instructions "How to order Repair Parts" in this book.)

Coolant Parts

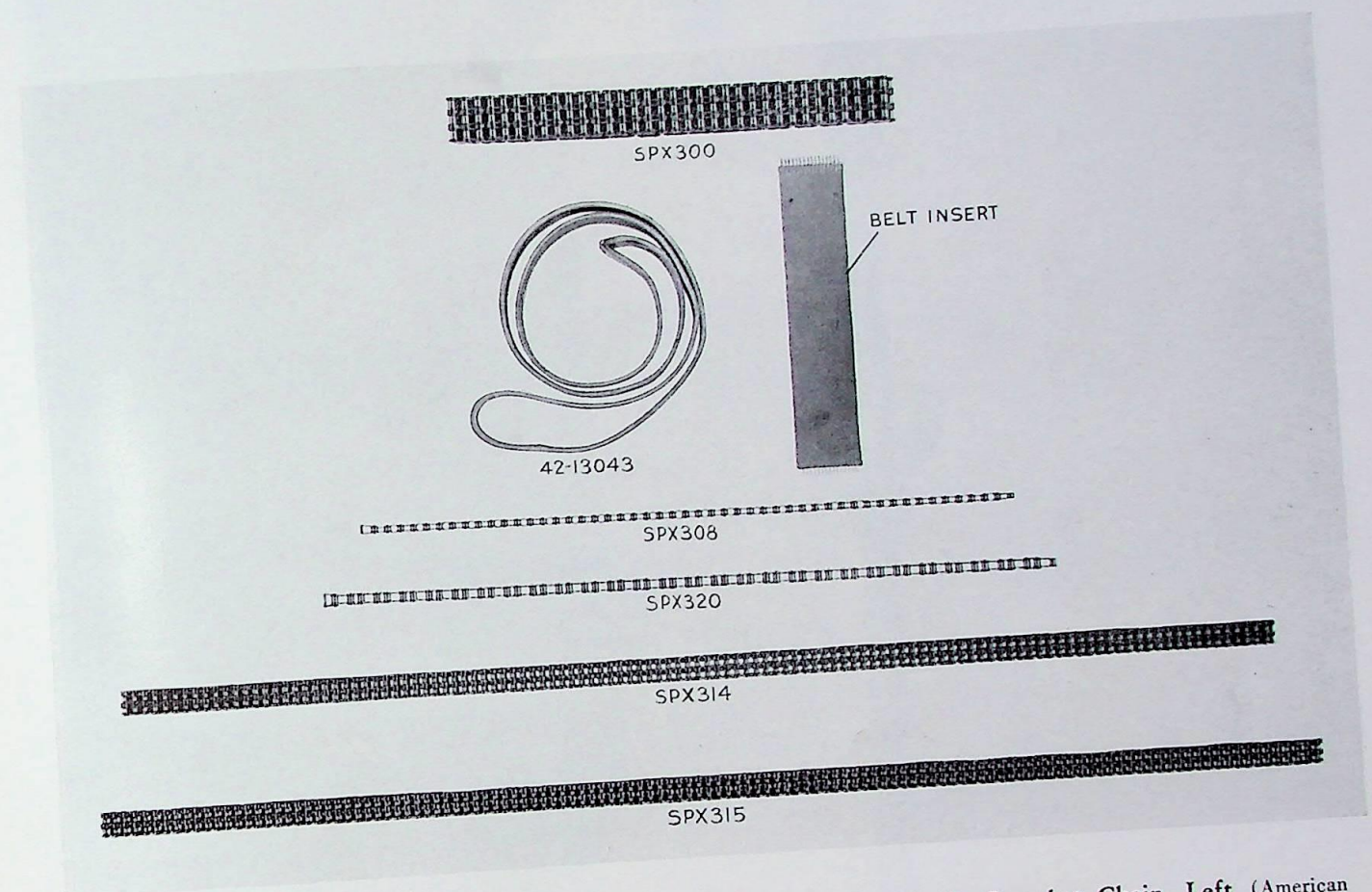


5309	Relief Valve Plunger Spring	213-9001-2001	Relief Valve Body
42-11244	Tank Table Drain Plug	713-9001-20	Relief Valve, Complete
42-12091	Tank Table Drain Plug Bushing	SPX999	Adjusting Screw Cap Gasket
42-12211	Tank Strainer		
42-12243	Oil Strainer		
42-12245	Strainer Oil Pipe Sleeve		
91-74-57	Relief Valve Adjustment Screw		
91-91-172	Relief Valve Plunger		
91-115-38	Adjusting Screw Cap		
91-404-1	Straight Cock, Lever Handle		
91-404-31	Universal Swing Joint		

Oil Distributor
42-7641 (Slotted)
42-8512 (Plain)
Coolant Pump, Complete
See Page 15

ORDER BY PART NUMBER AND NAME ALSO GIVE
SIZE, STYLE AND SERIAL NUMBER OF MACHINE.
(See instructions "How to order Repair Parts" in this book.)

Belt and Chains



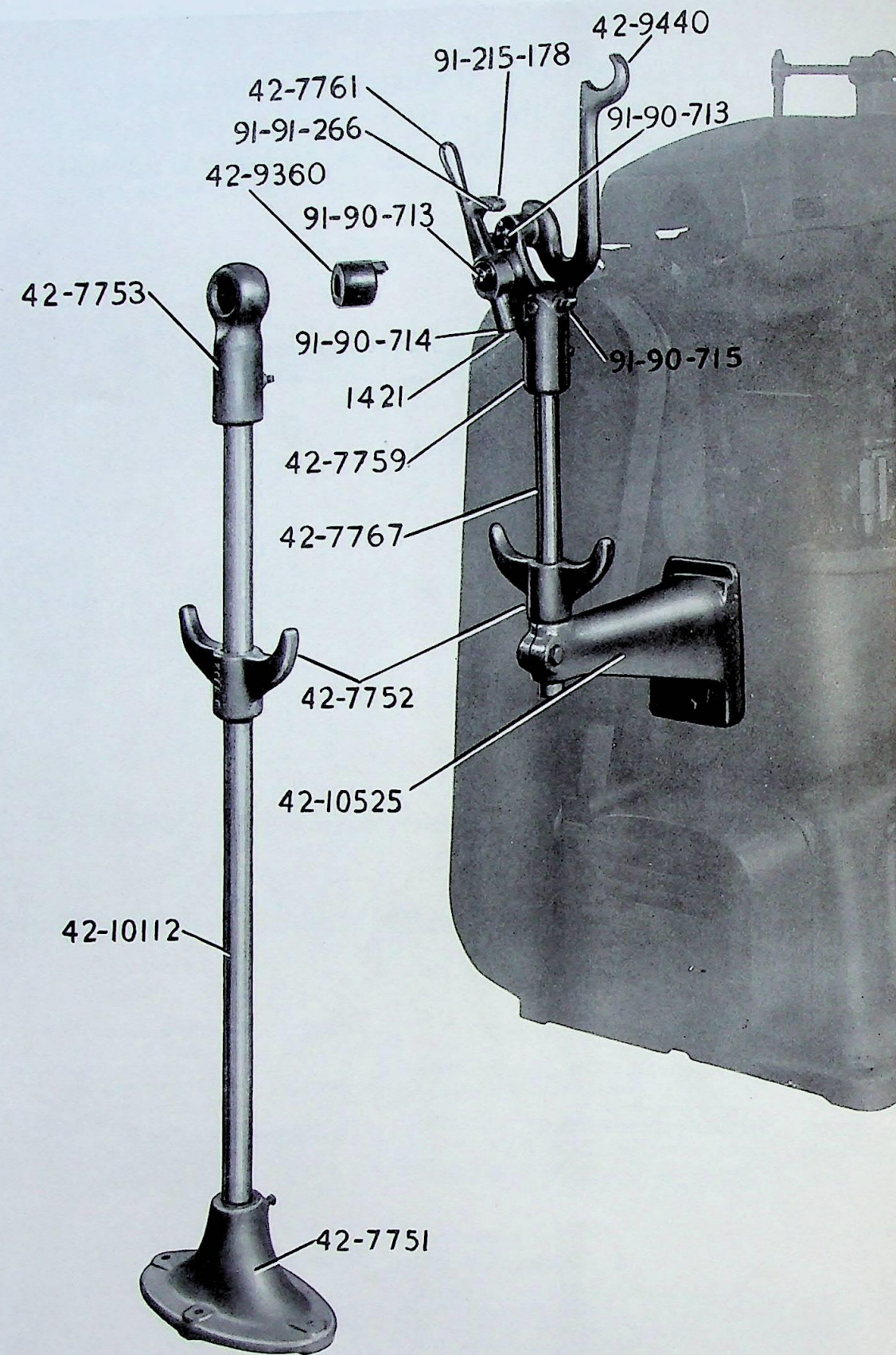
42-13043	Driving Pulley Belt	SPX315	Spindle Sprocket Chain, Left (American Standard D. 35 Roller Chain with 242 links including connecting link, run in.)
SPX300	Motor Sprocket Chain (American Standard E. 40 Roller Chain with 68 links including connecting link, run in.)	SPX320	Pump Sprocket Chain
SPX308	Lubricator Sprocket Chain		
SPX314	Spindle Sprocket Chain, Right (American Standard D. 35 Roller Chain with 226 links including connecting link, run in.)		

Belt Insert, Driving Pulley
42-13846 (For open belt)
42-13847 (For crossed belt)

Notes On Main Driving Chains

The main driving chains are specified in general terms, being identified by American Standard Roller Chain standards. Notice that all these chains are *run in*. The stretch in a regular commercial chain (not *run in*) develops rapidly during the first hours of operation and adjustment must be made almost hourly. In addition it will probably be necessary to remove chain links during the first days of operation.

A chain which stretches and operates without proper tension will ride out on its sprocket and will permit the rollers to strike the tips of the sprocket teeth. When running in this manner a chain can be ruined during its first day of operation. Even with "Run-In" chains regular checks on chain tension should be made, for maximum chain life cannot be obtained unless proper tension is maintained.



Stock Supports

ORDER BY PART NUMBER AND NAME ALSO GIVE
 SIZE, STYLE AND SERIAL NUMBER OF MACHINE.
 (See instructions "How to order Repair Parts" in this book.)

Stock Supports

1421	Locking Handle Spring
42-7751	Stock Stand Base
42-7752	Stock Hook
42-7753	Rear Stock Pipe Support
42-7759	Front Stock Pipe Support
42-7761	Stock Pipe Locking Handle (Includes 1421, 91-90-714, 91-91-266 and 91-215-178)
42-7767	Stock Support Bar
42-9360	Pipe Collar
42-9440	Stock Pipe Holder
42-10112	Stock Stand Bar
42-10525	Stock Support Bracket
91-90-713	Stock Pipe Handle or Holder Fulcrum
91-90-714	Locking Handle Spring Plunger
91-90-715	Stock Pipe Holder Stop Pin
91-91-266	Locking Handle Roll Pin
91-215-178	Locking Handle Roll

**ORDER BY PART NUMBER AND NAME ALSO GIVE *SIZE, STYLE*
AND *SERIAL NUMBER* OF BOTH MACHINE AND ATTACHMENT.**

(See instructions "How to order Repair Parts" in this book.)

Screw Slotting Attachment

Parts common to Motor and Belt Driven Attachments

42-716	Slotting Cam	91-201-479	Saw Arbor Washer ($\frac{1}{8}$ " Thick)
42-1234	Saw Arbor Collar	91-201-480	Saw Arbor Washer ($\frac{3}{32}$ " Thick)
42-1560	Saw Guard	91-201-481	Saw Arbor Washer ($\frac{1}{8}$ " Thick)
42-4078	Screw Holder Arm Stop	91-601-54	Saw Arbor Nut
42-6640	Slotting Bushing Blank	Arbor, Saw	
42-6808	Screw Holder		42-8601 (Motor Driven)
42-6826	Rotating Cam		42-11693 (Belt Driven)
42-7688	Screw Chute	Bushing, Saw Arbor	
42-9515	Screw Holder Support		42-2608 (Motor Driven)
			42-2613 (Belt Driven)
42-11695	Saw Slide Bracket	Cutter	
42-12525	Ejector		705-450-559 (High Speed Steel)
42-12544	Screw Holder Arm		705-456-559 (Carbon Steel)
42-12837	Screw Chute Guard	Saw Slide	
42-14558	Screw Chute Extension		42-11694 (Belt Driven, Includes 42-1560 and 42-11697)
42-15180	Oil Distributor		42-13865 (Motor Driven, Includes 42-1560, 42-2608, 42-13866, 42-13867, and 42-14324)
46-110	Swing Pendant	NOT SHOWN	
91-1-103	Saw Slide Adjusting Screw	Forward Oil Guard Side	
			42-8531 (Belt Driven)
			42-8532 (Motor Driven)

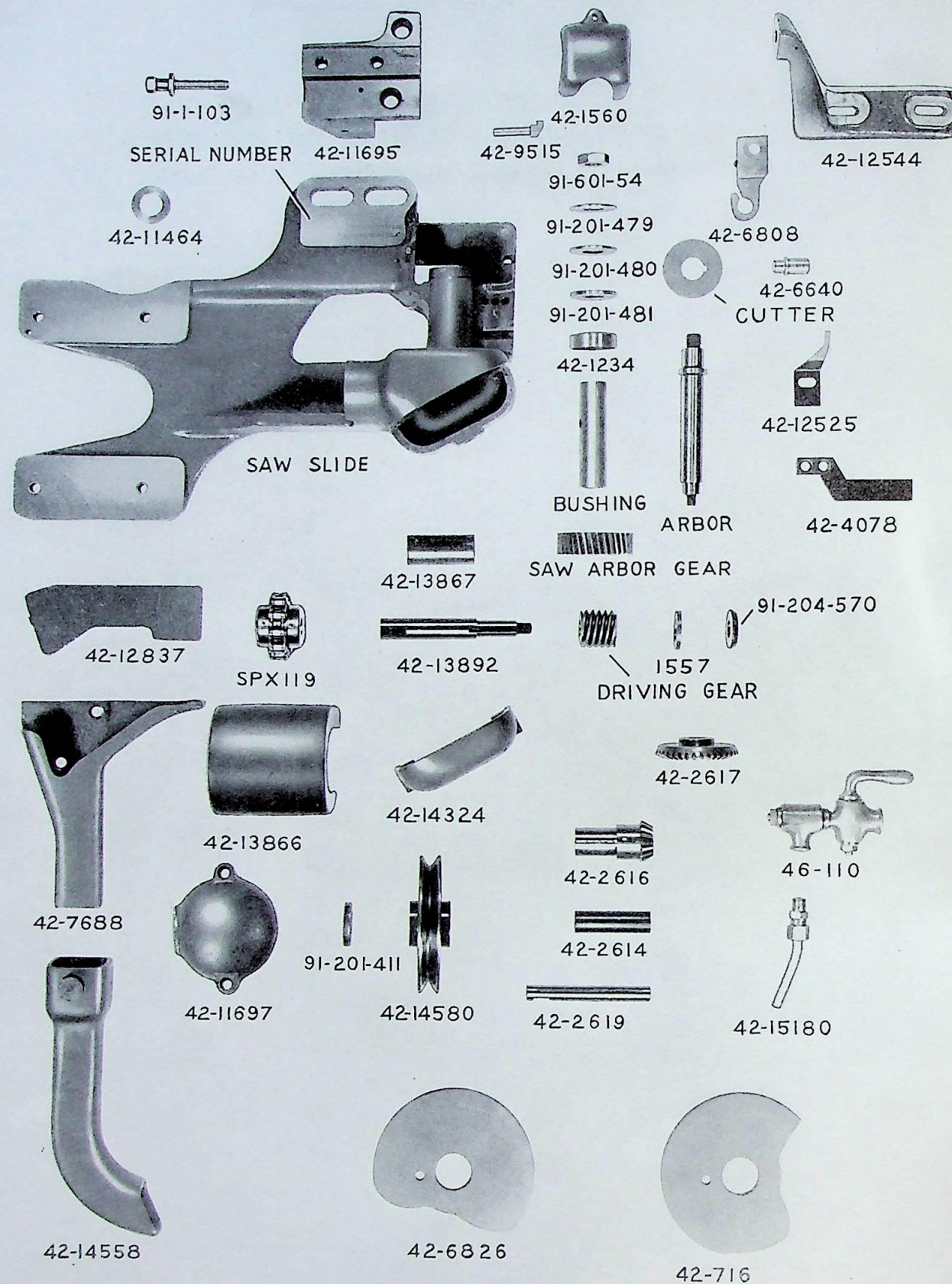
Parts for Motor Driven Attachment Only

1557	Saw Arbor Driving Shaft Washer, Bronze	SPX119	Motor Shaft Coupling
42-11464	Motor Washer	Driving Gear	
42-13866	Motor Shaft Coupling Guard		42-8612 (3 Teeth)
42-13867	Saw Arbor Driving Shaft Bushing		42-8614 (8 Teeth)
42-13892	Saw Arbor Driving Shaft	Saw Arbor Gear	
42-14324	Saw Slide Cover		42-8613 (36 Teeth)
			42-8615 (32 Teeth)
91-204-570	Saw Arbor Drive Shaft Washer		

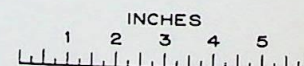
Parts for Belt Driven Attachment Only

42-2614	Driving Gear Bushing	42-11697	Gear Guard
42-2616	Driving Gear (Includes 42-2614)	42-14580	Driving Pulley
42-2617	Saw Arbor Gear		
42-2619	Driving Gear Stud	91-201-411	Driving Pulley Washer

For Transferring Mechanism parts see pages 40-41.



Screw Slotting Attachment



ORDER BY PART NUMBER AND NAME ALSO GIVE *SIZE, STYLE*
AND *SERIAL NUMBER* OF BOTH MACHINE AND ATTACHMENT.

(See instructions "How to order Repair Parts" in this book.)

Burring Attachment

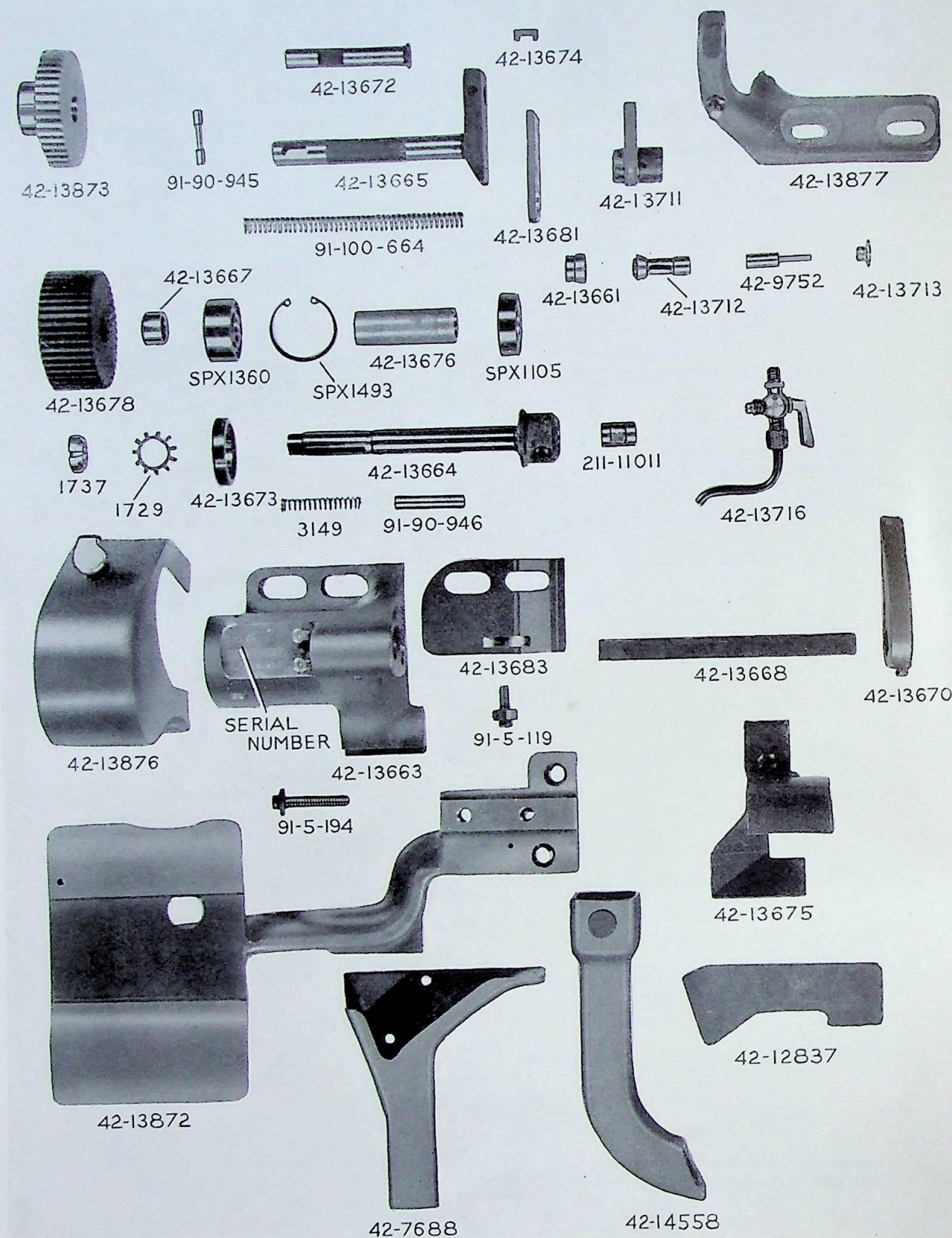
1729	Spindle Lockwasher	42-13716	Oil Piping
1737	Spindle Locknut	42-13872	Motor Bracket
3149	Spindle Plunger Spring	42-13873	Motor Gear (45 Teeth)
		42-13876	Motor Gear Guard
		42-13877	Work Holder Arm
		42-14558	Screw Chute Extension
42-7688	Screw Chute	91-5-119	Spindle Slide Adjusting Screw
*42-9752	Ejector Plunger Blank	91-5-194	Adjusting Plate Adjusting Screw
		91-90-945	Spring Retainer Pin
		91-90-946	Spindle Plunger
		91-100-664	Work Bushing Holder Spring
42-12837	Screw Chute Guard	211-11011	Bushing Blank
*42-13661	Work Bushing Blank		
42-13663	Spindle Slide	SPX1105	Spindle Ball Bearing, Front
42-13664	Spindle	SPX1360	Spindle Ball Bearing, Rear
42-13665	Work Bushing Holder	SPX1493	Spindle Bearing Retaining Ring
42-13667	Spindle Gear Spacer		
42-13668	Work Holder Arm Stop		
42-13670	Ejector		
42-13672	Work Bushing Holder Guide		
42-13673	Bearing Retainer		
42-13674	Work Bushing Holder Guide Key		
42-13675	Work Chute, Upper		
42-13676	Spindle Bearing Spacer		
42-13678	Spindle Gear (45 Teeth)		
42-13681	Work Bushing Plate		
42-13683	Adjusting Plate		
42-13711	Chuck Holder		
*42-13712	Collet Blank		
42-13713	Collet Nut		

NOT SHOWN

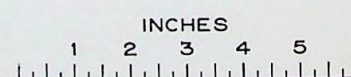
42-11695	Saw Slide Bracket (Belt Driven)
42-13685	Forward Oil Guard Side
42-13718	Spindle Pulley (Belt Driven from Countershaft)
42-14347	Spindle Pulley (Belt Driven from Attachment Driving Stand)
42-14697	Attachment Driving Pulley (Belt Driven)
*711-350-100	Cam Blanks

*Parts Finished to Order Upon Receipt of Drawing of Work.

For Transferring Mechanism parts see pages 40-41.



Burring Attachment



ORDER BY PART NUMBER AND NAME ALSO GIVE *SIZE, STYLE*
AND *SERIAL NUMBER* OF BOTH MACHINE AND ATTACHMENT.

(See instructions "How to order Repair Parts" in this book.)

Nut Tapping Attachment

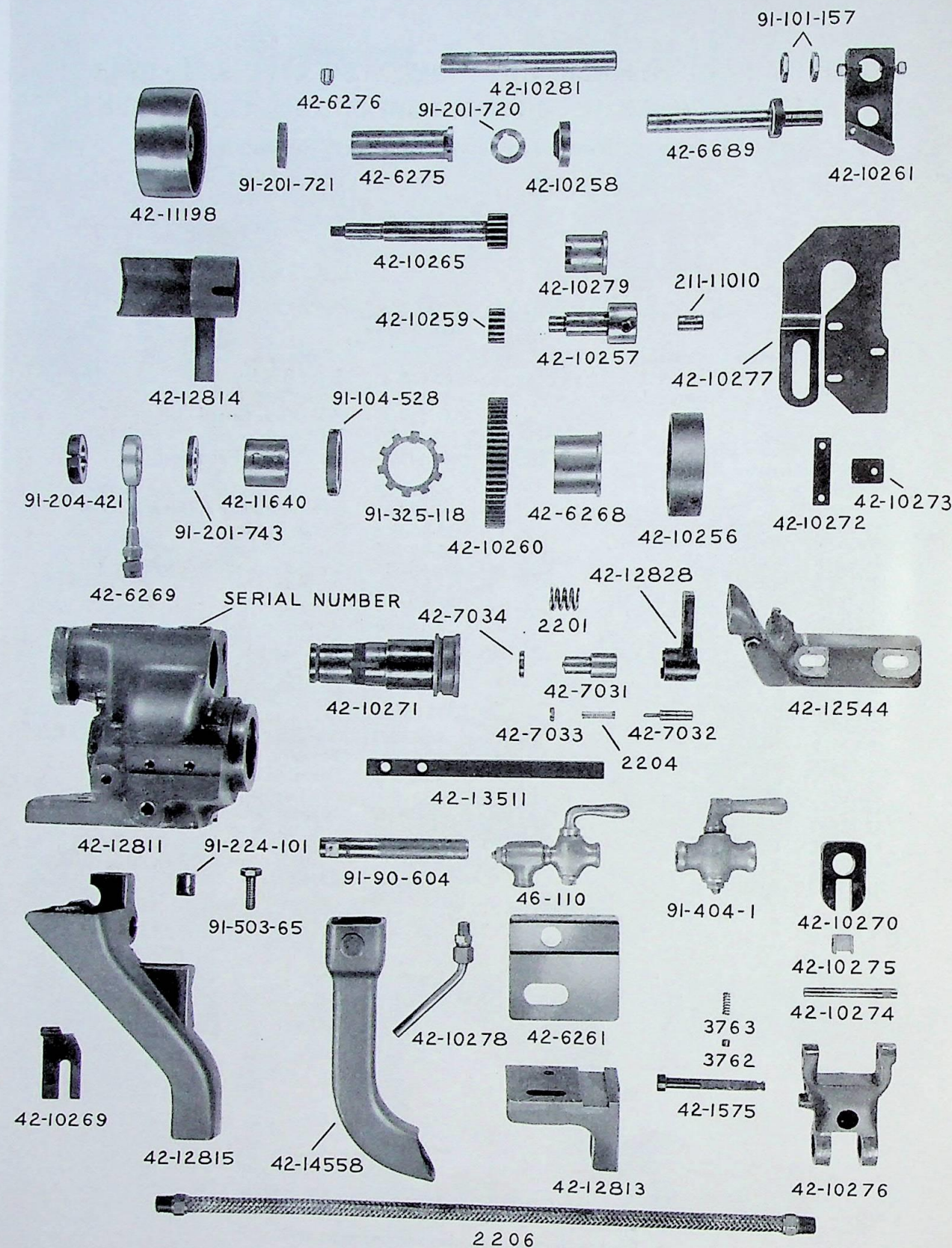
2201	Work Holder Spring, Large	42-10277	Nut Guide Plate
2204	Work Holder Plunger Spring	42-10278	Oil Distributor
2206	Flexible Tube	42-10279	Countersinking Spindle Bushing
3762	Rotating Lever Stop Clamp	42-10281	Countersinking Guide Fulcrum
3763	Rotating Lever Stop Clamp Spring	42-11198	Driving Pulley
		42-11640	Spindle Bushing, Rear
42-1575	Rotating Lever Stop	42-12544	Work Holder Arm
42-6261	Nut Tapping Bracket Slide	42-12811	Nut Tapping Case
42-6268	Spindle Bushing, Front	42-12813	Nut Tapping Bracket
42-6269	Guide Collar	42-12814	Oil Guard
42-6275	Driving Shaft Bushing	42-12815	Chute (Includes 91-224-101 and 91-503-65)
42-6276	Oil Wiper, Top	42-12828	Work Holder
42-6689	Nut Guide Holder	42-13511	Work Holder Arm Stop
*42-7031	Work Holder Bushing Blank	42-14558	Chute Extension
*42-7032	Work Holder Plunger Blank		
42-7033	Spring Retainer, Small	46-110	Swing Pendant
42-7034	Spring Retainer, Large	91-90-604	Chute Holder
		91-101-157	Nut Guide Holder Nut
42-10256	Spindle Oil Guard	91-104-528	Spindle Gear Nut
42-10257	Countersinking Spindle	91-201-720	Drive Shaft Washer
42-10258	Oil Wiper, Side	91-201-721	Oil Retainer
42-10259	Countersinking Spindle Gear	91-201-743	Nut Driving Sleeve Washer
42-10260	Spindle Gear	91-204-421	Nut Driving Sleeve Collar
42-10261	Countersinking Guide	91-224-101	Tap Guide Clamp Bushing
42-10265	Driving Shaft	91-325-118	Spindle Gear Nut Lockwasher
42-10269	Nut Retainer Spring	91-404-1	Straight Cock, Lever Handle
42-10270	Slotting Shaft Lever	91-503-65	Tap Guide Clamp Bolt
42-10271	Spindle		
42-10272	Nut Guide, Upper	211-11010	Bushing Blank
42-10273	Nut Guide, Lower		
42-10274	Rotating Lever Rod		
42-10275	Rotating Lever Shoe		
42-10276	Rotating Lever (Includes 3762, 3763, 42-1575, 42-10274 and 42-10275)		

NOT SHOWN

*42-14604	Rotating Cam Blank
*42-14604	Slotting Cam Blank

*Parts Finished to Order Upon Receipt of Drawing of Work.

For Transferring Mechanism parts see pages 40-41.



Nut Tapping Attachment

ORDER BY PART NUMBER AND NAME ALSO GIVE SIZE, STYLE AND SERIAL NUMBER OF BOTH MACHINE AND ATTACHMENT.

(See instructions "How to order Repair Parts" in this book.)

Index Drilling Attachment

1737	Drill Spindle Nut	42-13953	Motor Sheave (Motor Driven)
1729	Drill Spindle Lockwasher	42-13955	Pulley Shaft Bearing Spacer, Small
1753	Work Spindle Nut	42-13956	Pulley Shaft Bearing Spacer, Large
1769	Chuck Adjusting Nut	42-13957	Pulley Shaft Bearing Nut Spacer
1778	Index Pawl Spring Stud	42-13958	Spindle Pulley Bearing Retainer
1818	Shearing Pin	42-13959	Drill Spindle Pulley Shaft
3764	Drill Spindle Pulley Shaft Nut	42-13960	Drill Spindle Sheave
		42-13961	Drill Spindle Pulley Bearing Sleeve
42-699	Collet Blank	91-90-700	Feed or Index Lever Roll Pin
42-1230	Chuck Lever	91-90-928	Ejector Operating Sleeve Pin
42-3555	Lever Plunger	91-90-929	Index Plunger Pin
42-3575	Index Pawl	91-90-930	Index Lever Fulcrum
		91-90-962	Ejector Lever Pin
42-13469	Work Spindle Plug	91-91-609	Index Pawl Fulcrum
42-13470	Work Spindle (Includes 1753, 1769 and 42-13469)	91-91-610	Chuck Cam or Ejector Lever Roll Pin
42-13471	Work Spindle Sleeve	91-97-487	Drill Spindle Key
42-13472	Chuck Sleeve		
42-13473	Chuck Lever Fulcrum	91-100-18	Index Pawl Spring
42-13474	Chuck Closing Tube	91-100-188	Feed Lever Spring
42-13475	Chuck Operating Sleeve	91-100-268	Index Plunger Spring
42-13478	Index Plate	91-100-658	Ejector Spring
42-13480	Index Pawl Disk	91-215-126	Shearing Pin Bushing
42-13481	Index Ratchet	91-215-211	Feed or Index Lever Roll
42-13482	Index Lever (Includes 91-90-700 and 91-215-211)	91-215-226	Chuck Cam or Ejector Lever Roll
42-13483	Ejector Sleeve Nut	91-224-144	Ejector Bushing
42-13484	Ejector	91-325-109	Drill Spindle Pulley Shaft Lockwasher
42-13485	Ejector Operating Sleeve		
42-13486	Ejector Tube	211-11016	Bushing Blank
42-13487	Ejector Sleeve		
42-13488	Ejector Lever (Includes 91-90-962, 91-91-610 and 91-215-226)	‡SPX229	Motor Belt (Motor Driven)
42-13497	Feed Lever (Includes 1818, 91-90-700, 91-215-126 and 91-215-211)	SPX807	Drill Spindle Bearing Sleeve Bushing
42-13499	Feed Lever Stud	SPX1040	Drill Spindle Pulley Shaft Bearing
42-13500	Drill Spindle (Includes SPX1894)	SPX1410	Drill Spindle Bearing
42-13503	Drill Spindle Bearing Sleeve	SPX3908	Drill Spindle Bearing Oiler
42-13504	Drill Spindle Bearing Retainer		
42-13529	Chuck Cam Lever (Includes 91-91-610 and 91-215-226)		
42-13530	Chuck Cam or Ejector Lever Fulcrum		
42-13531	Chuck Cam or Feed Lever Shoe		
42-13532	Index Plunger		

Collet Wrench

42-570 (2¾" Long)
42-571 (3½" Long)

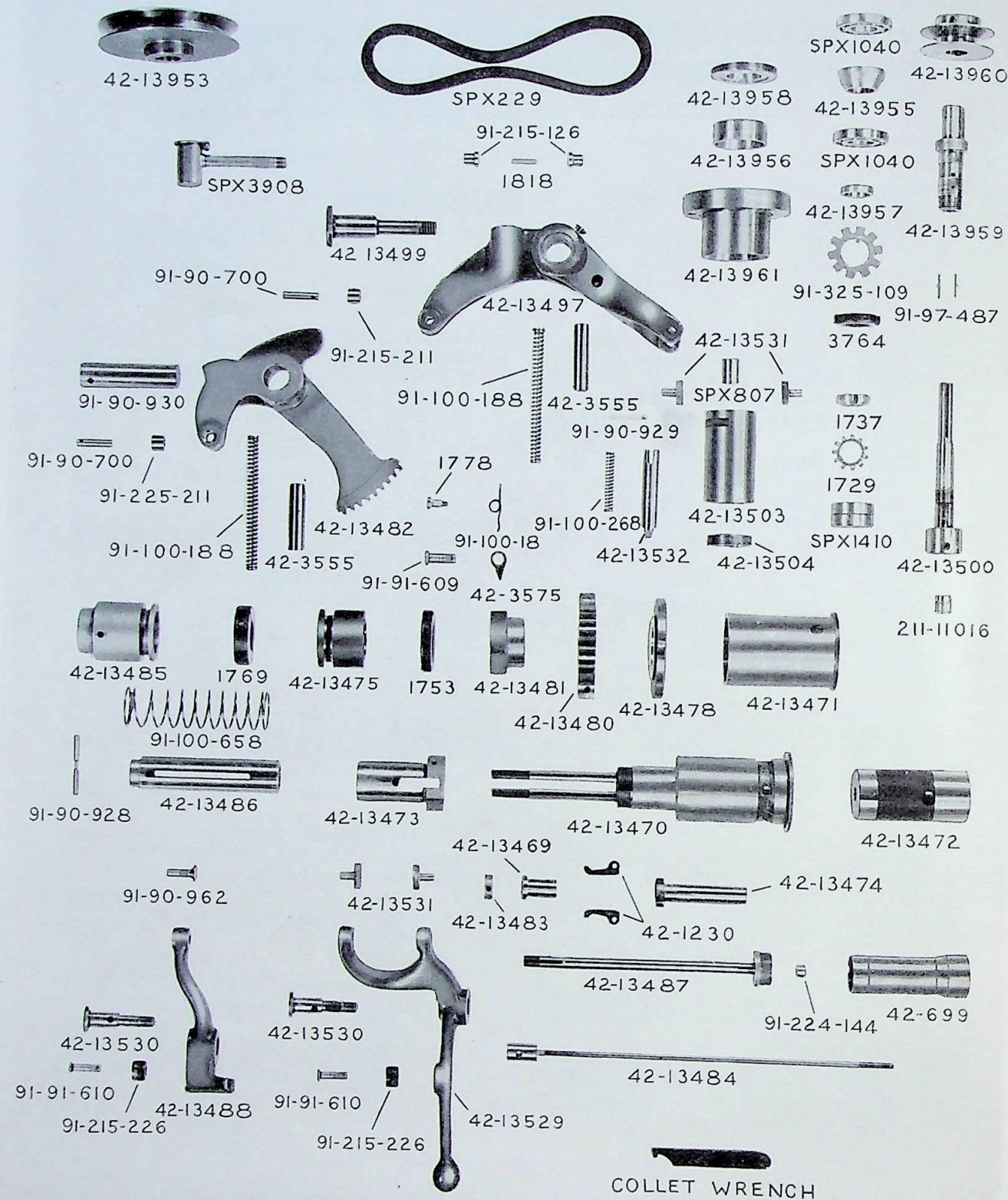
NOT SHOWN

42-13459 Frame

‡Oil Resistant V-Belt; Cross Section ½" Wide x 1½" thick, inside circumference 18"

For Transferring Mechanism parts see pages 40-41.

(Continued on next page)



Index Drilling Attachment

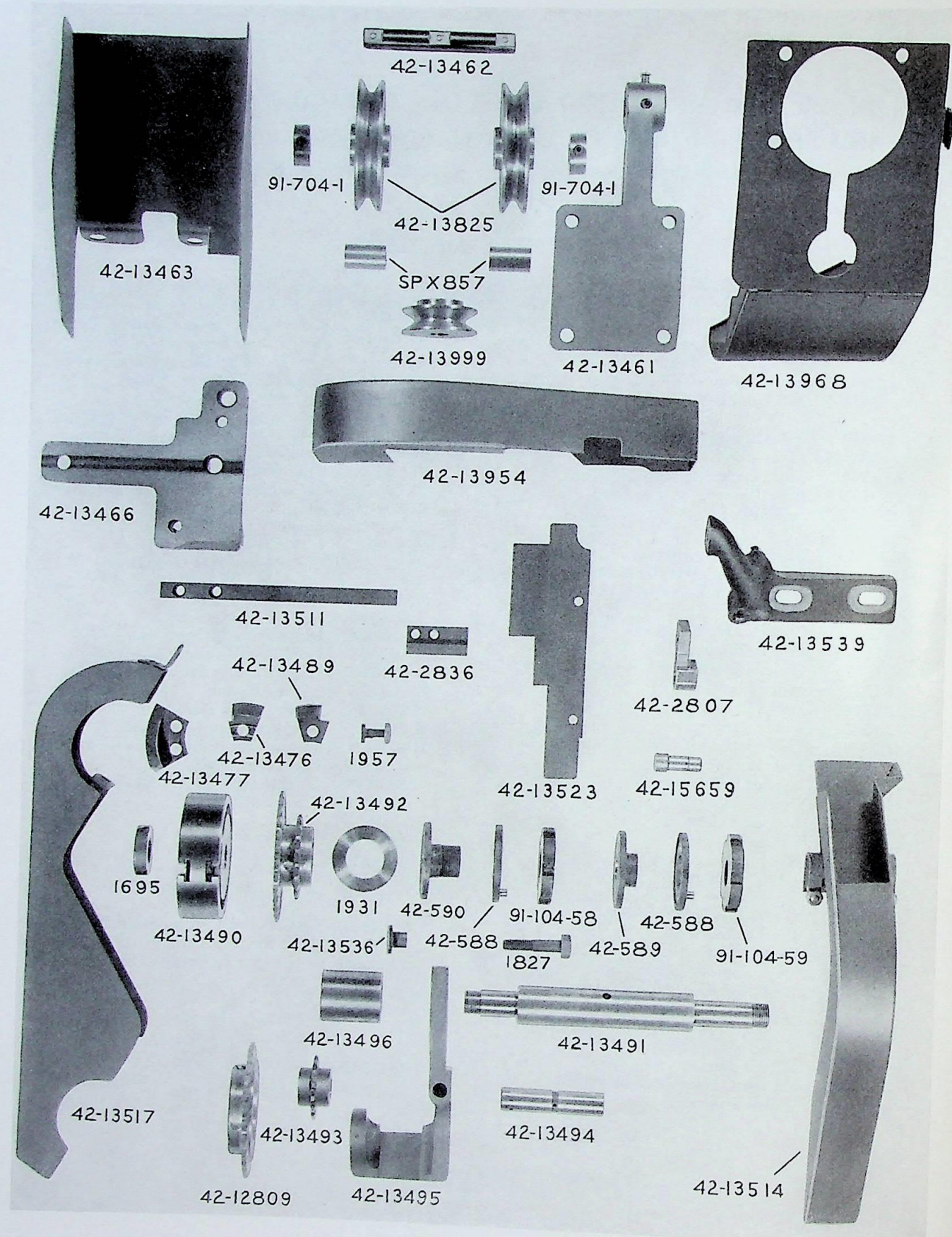
ORDER BY PART NUMBER AND NAME ALSO GIVE *SIZE, STYLE*
AND *SERIAL NUMBER* OF BOTH MACHINE AND ATTACHMENT.
(See instructions "How to order Repair Parts" in this book.)

Index Drilling Attachment (cont'd)

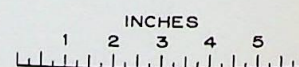
1695	Cam Shaft Nut	42-13511	Work Holder Arm Stop
1827	Idler Sprocket Arm Clamp Stud	42-13514	Chute
1931	Cam Shaft Washer	42-13517	Chain Guard
1957	Closing, Opening and Ejector Cam Bolt and Nut	42-13523	Forward Oil Guard, Side
		42-13536	Idler Sprocket Arm Clamp Nut
		42-13537	Idler Pulley Bracket, Complete Belt Driven (Includes 42-13461, 42-13462, 42-13463, 42-13825, 91-704-1 and SPX857)
42-588	Cam Driving Disk	42-13539	Work Holder Arm
42-589	Feed Cam Holder	42-13825	Idler Pulley (Belt Driven)
42-590	Index Cam Holder	42-13954	Motor Pulley Guard (Motor Driven)
		42-13968	Attachment Oil Guard
42-2807	Work Holder	42-13999	Drill Spindle Pulley (Belt Driven)
42-2836	Work Holder Arm Rest	42-15659	Work Bushing Blank
		91-104-58	Index Cam Holder Nut
		91-104-59	Feed Cam Holder Nut
42-12809	Driving Sprocket	91-704-1	Idler Pulley Stud Collar (Belt Driven)
42-13461	Idler Pulley Bracket (Belt Driven)	SPX857	Idler Pulley Bushing (Belt Driven)
42-13462	Idler Pulley Stud (Belt Driven)		
42-13463	Idler Pulley Guard (Belt Driven)	NOT SHOWN	
42-13466	Adapter Bracket	42-6614	Counter Shaft Pulley (Belt Driven)
42-13476	Chuck Closing Cam	42-13952	Motor Bracket (Motor Driven)
42-13477	Chuck Opening Cam		
42-13489	Ejector Cam	*711-350-100	Cam Blanks
42-13490	Ejector and Chuck Cam Disk	SPX317	Chain
42-13491	Cam Shaft		
42-13492	Cam Shaft Sprocket		
42-13493	Idler Sprocket		
42-13494	Idler Sprocket Stud		
42-13495	Idler Sprocket Arm		
42-13496	Frame Bushing		

*Parts Finished to Order Upon Receipt of Drawing of Work.

For Transferring Mechanism parts see pages 40-41.



Index Drilling Attachment (continued)



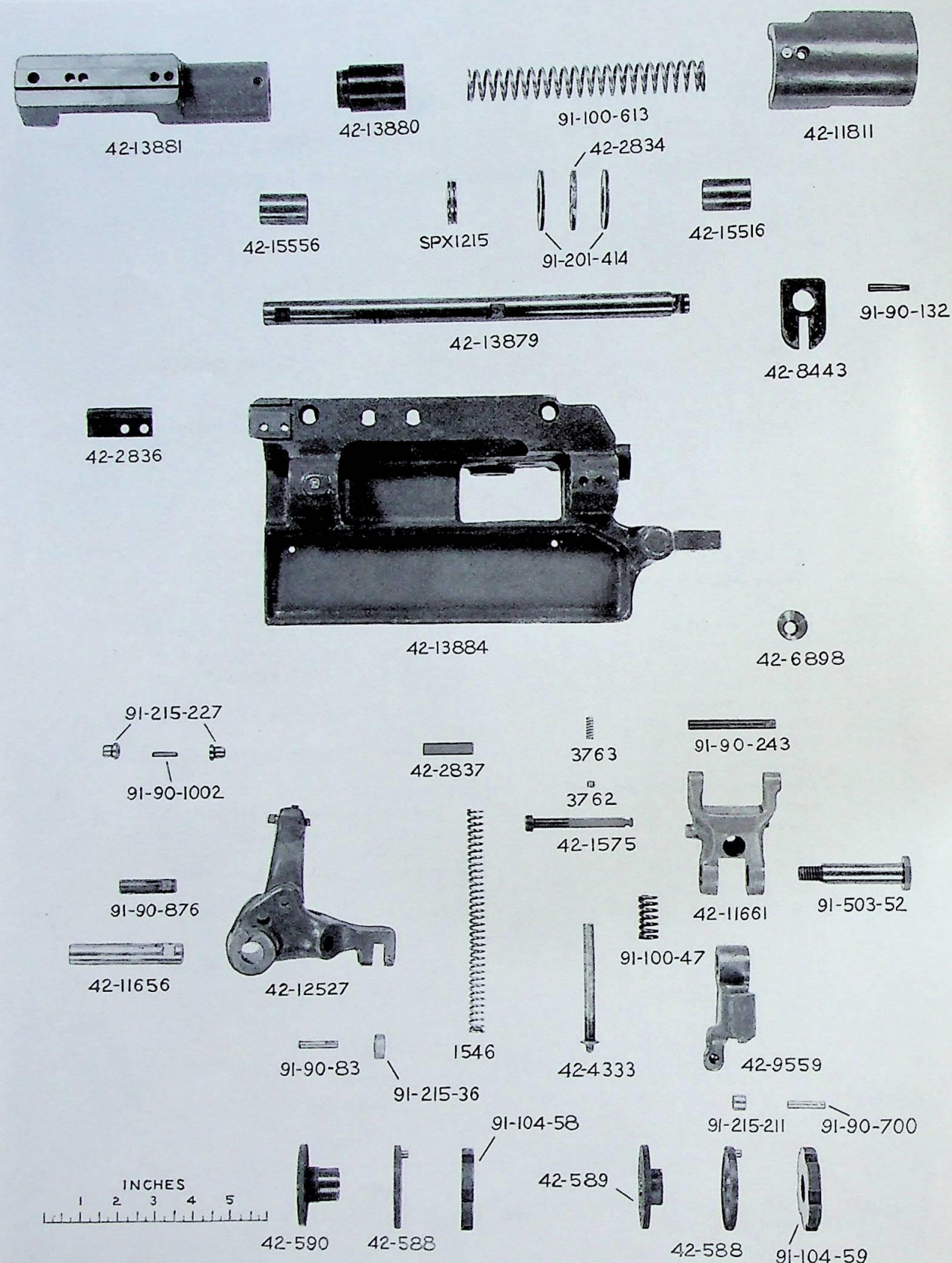
ORDER BY PART NUMBER AND NAME ALSO GIVE *SIZE, STYLE*
AND *SERIAL NUMBER* OF BOTH MACHINE AND ATTACHMENT.

(See instructions "How to order Repair Parts" in this book.)

Transferring Mechanism

Used with Screw Slotting, Burring, Nut Tapping, and Index Drilling Attachments

1546	Rotating Cam Lever Spring	42-13879	Slotting Shaft
3762	Rotating Lever Stop Clamp	42-13880	Slotting Shaft Spring Guard
3763	Rotating Lever Stop Clamp Spring	42-13881	Work Holder Arm Base
		42-13884	Slotting Shaft Bracket (Includes 42-15516 and 42-15556)
42-588	Cam Driving Disk	42-15516	Slotting Shaft Bracket Bushing, Right
42-589	Rotating Cam Holder	42-15556	Slotting Shaft Bracket Bushing, Left
42-590	Slotting Cam Holder		
42-1575	Rotating Lever Stop	91-90-83	Slotting Cam Lever Roll Pin
42-2834	Slotting Shaft Ball Retainer	91-90-132	Slotting Shaft Lever Pin
42-2836	Screw Holder Arm Rest	91-90-243	Rotating Lever Rod
42-2837	Slotting Lever Stop	91-90-700	Rotating Cam Lever Roll Pin
42-4333	Rotating Cam Lever Spring Plunger	91-90-876	Slotting Lever Pin
42-6898	Eccentric Stop Block	91-90-1002	Shearing Pin
42-8443	Slotting Shaft Lever	91-100-47	Rotating Lever Spring
42-9559	Rotating Cam Lever (Includes 91-90-700 and 91-215-211)	91-100-613	Slotting Shaft Spring
		91-104-58	Slotting Cam Nut
		91-104-59	Rotating Cam Nut
42-11656	Slotting Lever Fulcrum	91-201-414	Slotting Shaft Ball Retainer Washer
42-11661	Rotating Lever (Includes 3762, 3763, 42-1575 and 91-90-243)	91-215-36	Slotting Cam Lever Roll
42-11811	Rotating Lever Guard	91-215-211	Rotating Cam Lever Roll
42-12527	Slotting Lever, Complete (Includes 91-90-83, 91-90-876, 91-90-1002, 91-215-36 and 91-215-227)	91-215-227	Shearing Pin Bushing
		91-503-52	Rotating Lever Stud
		SPX1215	Slotting Shaft Spring Thrust Bearing



Transferring Mechanism

Used with Screw Slotting, Burring, Nut Tapping, and Index Drilling Attachments

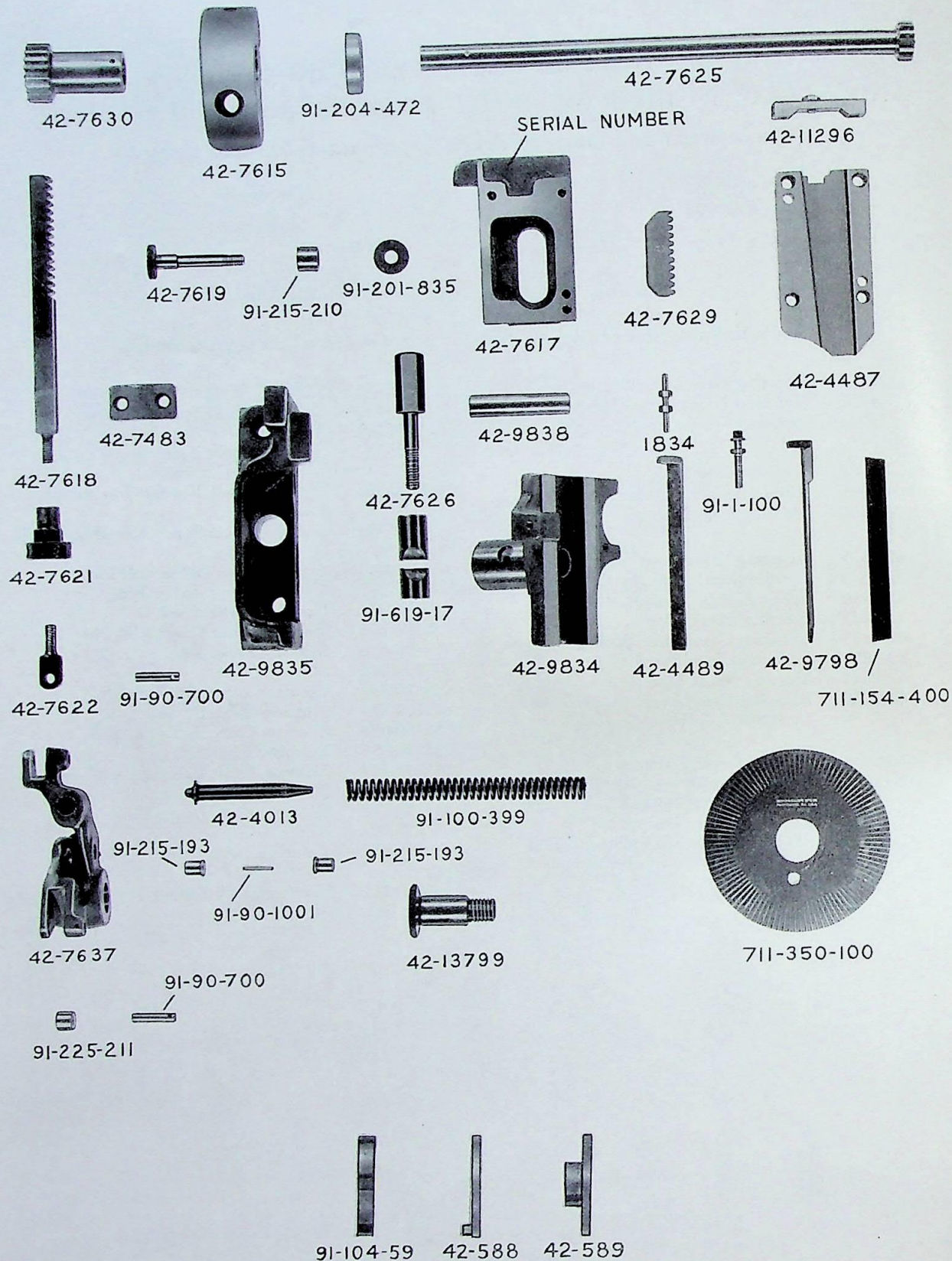
ORDER BY PART NUMBER AND NAME ALSO GIVE *SIZE, STYLE*
AND *SERIAL NUMBER* OF BOTH MACHINE AND ATTACHMENT.

(See instructions "How to order Repair Parts" in this book.)

Vertical Slide Attachment

1834	Vertical Slide Way Gib Adjusting Screw and Nuts	42-9834	Vertical Slide Way
		42-9835	Vertical Slide Bracket (Includes 42-7483 and 91-619-17)
42-588	Cam Driving Disk	42-9838	Vertical Slide Swivel Stop
42-589	Vertical Slide Cam Holder	42-11296	Tool Wedge Support
42-4013	Cam Lever Spring Plunger	42-13799	Cam Lever Stud
42-4487	Vertical Tool Holder		
42-4489	Vertical Slide Way Gib	91-1-100	Vertical Tool Holder Screw
42-7483	Oil Pipe Support Cap	91-90-700	Operating Rack Lever Pin
42-7615	Operating Rack Support	91-90-700	Vertical Slide Cam Lever Roll Pin
42-7617	Vertical Slide	91-90-1001	Shearing Pin
42-7618	Driving Gear Operating Rack	91-100-399	Operating Rack Lever Spring
42-7619	Operating Rack Support Stud	91-104-59	Vertical Slide Cam Holder Nut
42-7621	Operating Rack Adjusting Nut	91-201-835	Operating Rack Support Stud
42-7622	Operating Rack Adjusting Screw		Washer
42-7625	Vertical Slide Pinion Shaft	91-204-472	Pinion Shaft Driving Gear Collar
42-7626	Vertical Slide Way Clamp Screw	91-215-193	Shearing Pin Bushing
42-7629	Vertical Slide Rack	91-215-211	Vertical Slide Cam Lever Roll
42-7630	Pinion Shaft Driving Gear	91-215-210	Operating Rack Support Roll
42-7637	Vertical Slide Cam Lever (Includes 91-90-700, 91-90-1001, 91-215-193 and 91-215-211)	91-619-17	Vertical Slide Way Clamp
42-9798	Tool Wedge	711-154-400	Cutting-Off Blade
		*711-350-100	Cam Blank

*Parts Finished to Order Upon Receipt of Drawing of Work.



Vertical Slide Attachment

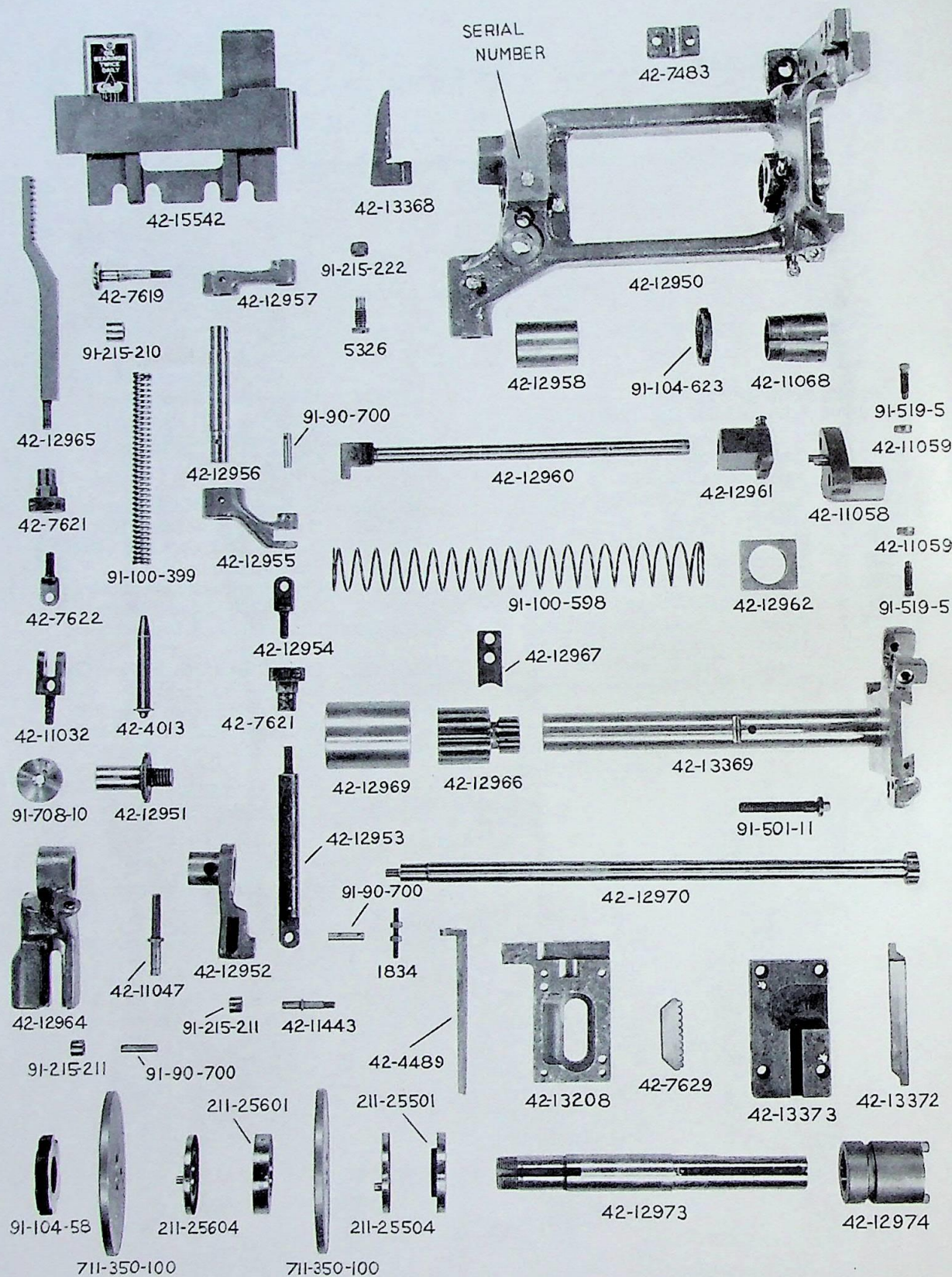
ORDER BY PART NUMBER AND NAME ALSO GIVE SIZE, STYLE AND SERIAL NUMBER OF BOTH MACHINE AND ATTACHMENT.

(See instructions "How to order Repair Parts" in this book.)

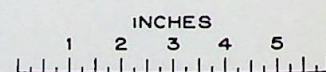
Longitudinal Turning Attachment

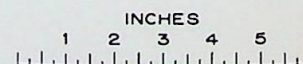
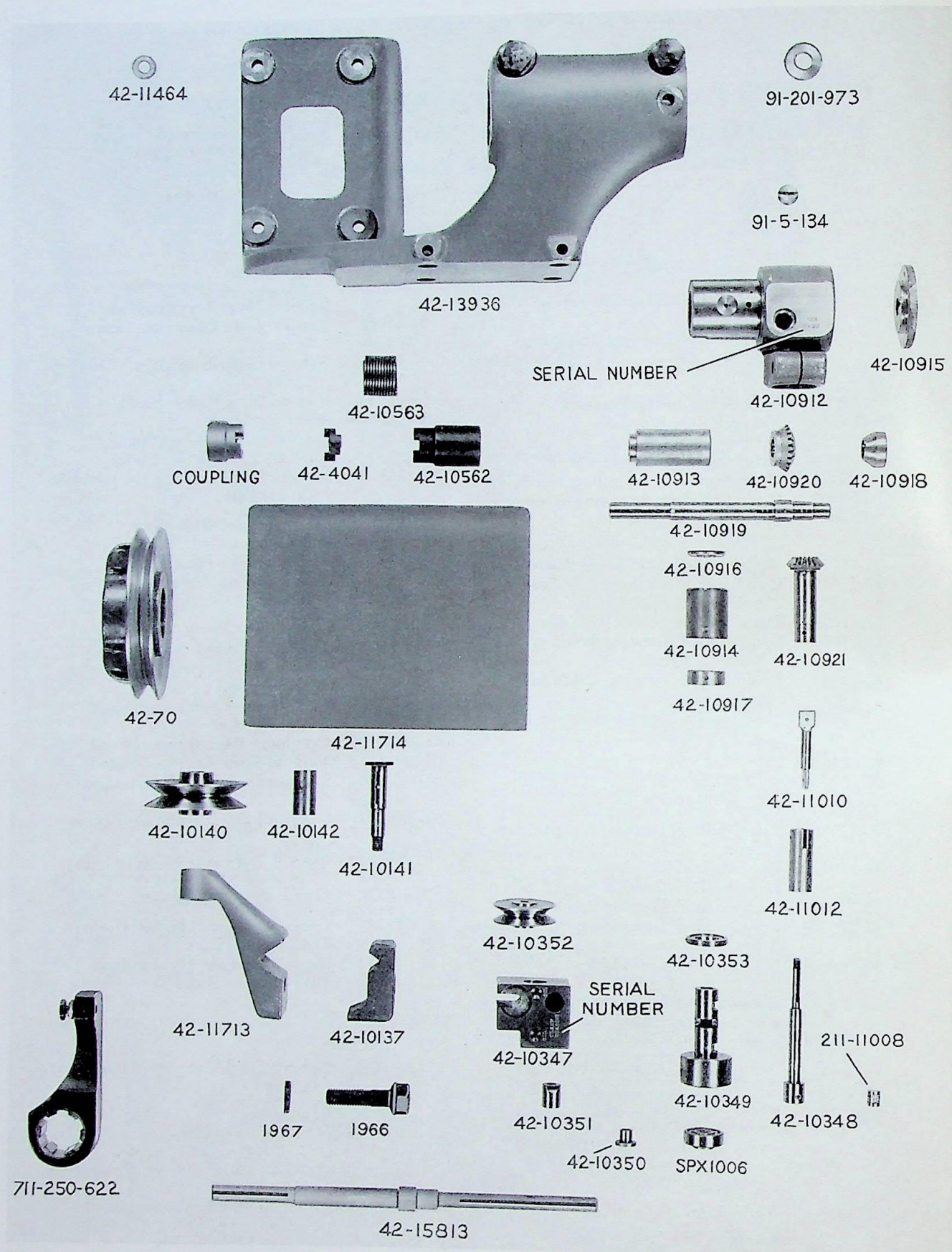
1834	Vertical Slide Way Gib Screw	42-12966	Vertical Slide Operating Gear
	and Nuts	42-12967	Vertical Slide Operating Gear Retainer
5326	Longitudinal Turning Rod Lever Screw	42-12969	Vertical Slide Pinion Shaft Driving Collar
		42-12970	Vertical Slide Pinion Shaft
42-4013	Cam Lever Spring Plunger	42-12973	Reversing Shaft
42-4489	Vertical Slide Way Gib	42-12974	Reversing Shaft Coupling
42-7483	Oil Pipe Support Cap	42-13208	Turning Tool Holder Slide
42-7619	Operating Rack Support Stud	42-13368	Longitudinal Turning Attachment Cover Plate
42-7621	Operating Rack Adjusting Nut		
42-7622	Operating Rack Adjusting Screw		
42-7629	Vertical Slide Rack	42-13369	Turning Tool Slide Way (Includes 42-12962)
		42-11032	Vertical Slide Cam Lever Block
42-11032	Vertical Slide Cam Lever Block	42-11047	Cam Lever Block Adjusting Screw
42-11047	Cam Lever Block Adjusting Screw	42-11058	Turning Tool Slide Guide
42-11058	Turning Tool Slide Guide	42-11059	Turning Tool Slide Guide Shoe
42-11059	Turning Tool Slide Guide Shoe	42-11068	Longitudinal Turning Bracket Bushing, Front
42-11068	Longitudinal Turning Bracket Bushing, Front	42-11443	Longitudinal Turning Lever Roll Stud
42-11443	Longitudinal Turning Lever Roll Stud	42-12950	Longitudinal Turning Bracket (Includes 42-7483)
42-12950	Longitudinal Turning Bracket (Includes 42-7483)	42-12951	Cam Lever Stud
42-12951	Cam Lever Stud	42-12952	Longitudinal Turning Cam Lever (Includes 42-11443 and 91-215-211)
42-12952	Longitudinal Turning Cam Lever (Includes 42-11443 and 91-215-211)	42-12953	Longitudinal Turning Link
42-12953	Longitudinal Turning Link	42-12954	Longitudinal Turning Adjusting Screw
42-12954	Longitudinal Turning Adjusting Screw	42-12955	Longitudinal Turning Lever
42-12955	Longitudinal Turning Lever	42-12956	Longitudinal Turning Lever Stud
42-12956	Longitudinal Turning Lever Stud	42-12957	Longitudinal Turning Rod Lever
42-12957	Longitudinal Turning Rod Lever	42-12958	Longitudinal Turning Bracket Bushing, Rear
42-12958	Longitudinal Turning Bracket Bushing, Rear	42-12960	Longitudinal Turning Rod (Includes 42-12961)
42-12960	Longitudinal Turning Rod (Includes 42-12961)	42-12961	Longitudinal Turning Rod Shoe
42-12961	Longitudinal Turning Rod Shoe	42-12962	Turning Tool Slide Way Collar
42-12962	Turning Tool Slide Way Collar	42-12964	Vertical Slide Cam Lever (Includes 42-11032, 42-11047, 91-90-700 and 91-215-211)
42-12964	Vertical Slide Cam Lever (Includes 42-11032, 42-11047, 91-90-700 and 91-215-211)	42-12965	Vertical Slide Operating Rack
42-12965	Vertical Slide Operating Rack		
		711-350-100	Cam Blank
			NOT SHOWN
		42-13366	Longitudinal Turning Attachment Cover

*Parts Finished to Order Upon Receipt of Drawing of Work.



Longitudinal Turning Attachment





**ORDER BY PART NUMBER AND NAME ALSO GIVE *SIZE, STYLE*
AND SERIAL NUMBER OF BOTH MACHINE AND ATTACHMENT.**

(See instructions "How to order Repair Parts" in this book.)

Cross Drilling Attachment

Parts Common to Motor and Belt Driven Attachments

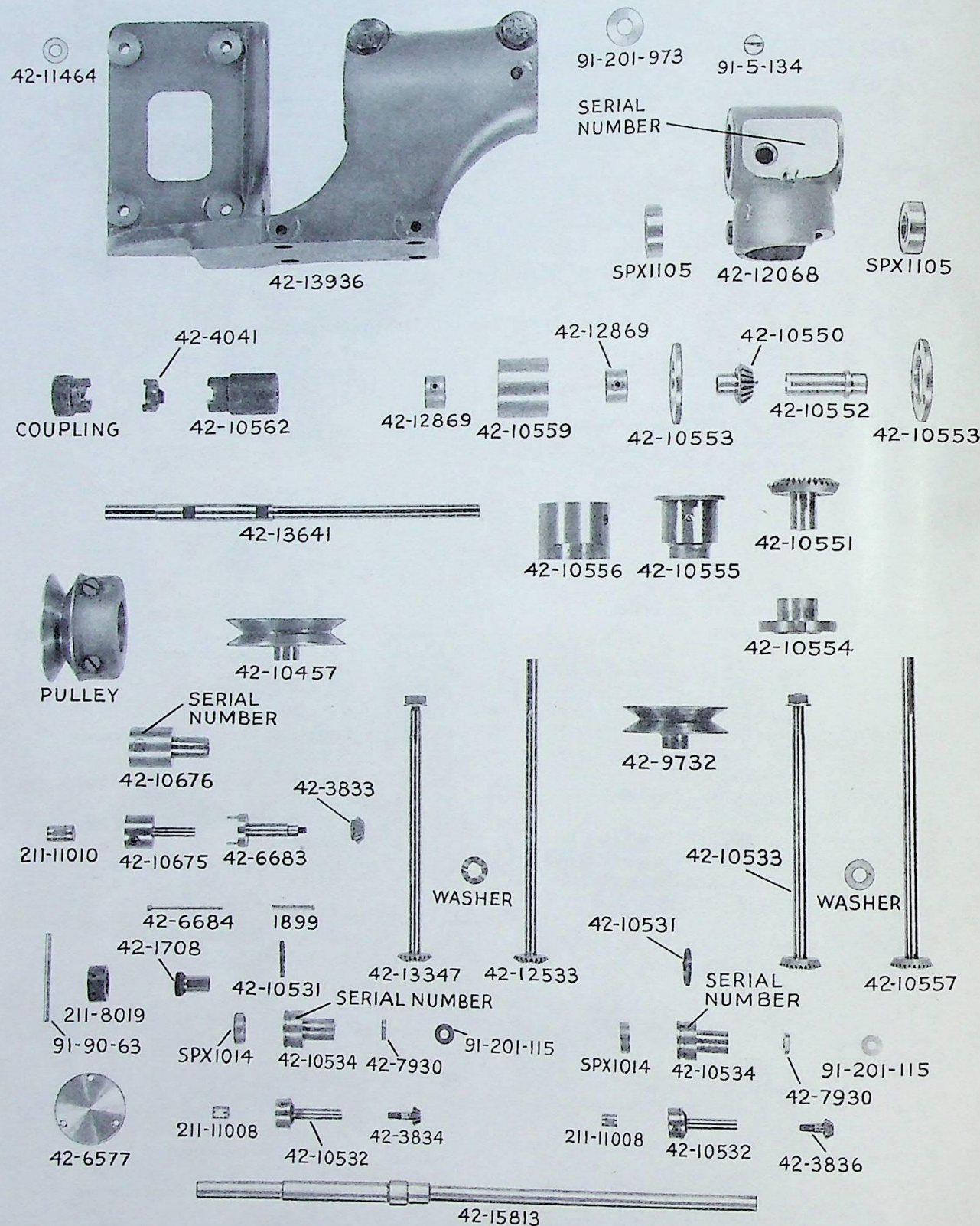
42-10347	Spindle Post (Includes 42-10351)	*211-11008	Bushing Blank
42-10348	Drill Spindle		
42-10349	Drill Spindle Bushing		
42-10350	Drill Spindle Bearing Sleeve	711-250-622	Spindle Brake
42-10351	Spindle Bushing Clamp Bushing		
42-10353	Drill Spindle Bearing Retainer		
142-00-26	Spindle Post, Complete	SPX1006	Ball Bearing

Parts for Motor Driven Attachment Only

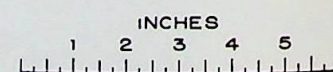
42-4041	Motor Shaft Intermediate Coupling	42-10921	Cross Drilling Driven Gear
		42-11010	Cross Drilling Adapter Shaft
		42-11012	Cross Drilling Adapter Shaft Extension
42-10562	Turret Driving Shaft Coupling	42-11464	Motor Spacing Washer
42-10563	Turret Driving Shaft Coupling Spring	42-13936	Motor Stand Bracket
42-10912	Cross Drilling Motor Gear Case	42-15813	Turret and Cross Drilling Driving Shaft (For Combination Turret and Cross Drilling Attachments)
42-10913	Cross Drilling Driving Gear Bushing		
42-10914	Cross Drilling Driven Gear Bushing	91-5-134	Cross Drilling Motor Gear Case Screw
42-10915	Cross Drilling Gear Case Cap	91-201-973	Motor Stand Bracket Washer
42-10916	Cross Drilling Driven Gear Washer		
42-10917	Cross Drilling Driven Gear Collar		
42-10918	Cross Drilling Driving Shaft Spacer	Coupling, Motor Shaft	
42-10919	Cross Drilling Driving Shaft	42-10561	($\frac{1}{2}$ " Motor Shaft)
42-10920	Cross Drilling Driving Gear	42-11493	($\frac{5}{8}$ " Motor Shaft)

Parts for Belt Driven Attachment Only

1966	Idler Pulley Bracket Clamp Screw (For use with Attachment Driving Stand)	42-10141	Idler Pulley Stud (For use with Attachment Driving Stand)
		42-10142	Idler Pulley Bushing (For use with Attachment Driving Stand)
1967	Idler Pulley Bracket Clamp Screw Washer (For use with Attachment Driving Stand)	42-10352	Spindle Driving Pulley
		42-11712	Idler Pulley Bracket, Complete (For use with Attachment Driving Stand)
42-70	Countershaft Pulley		
42-10137	Idler Pulley Bracket Clamp (For use with Attachment Driving Stand)	42-11713	Idler Pulley Bracket (For use with Attachment Driving Stand)
42-10140	Idler Pulley (For use with Attachment Driving Stand)	42-11714	Attachment Belt Oil Guard



Turret Attachments



Turret Attachments

Motor Drive for Turret Attachments

42-4041	Motor Shaft Intermediate Coupling	42-13641	Turret Driving Shaft (Includes (1) 42-12869)
42-6577	Turret Bevel Gear Guard	42-13936	Motor Stand Bracket
42-10550	Turret Driving Gear	42-15813	Turret and Cross Drilling Driving Shaft
42-10551	Turret Driven Gear	91-5-134	Turret Gear Case Screw
42-10552	Turret Gear Case Bearing Sleeve	91-201-973	Motor Bracket Washer
42-10553	Turret Gear Case Bearing Retainer	SPX1105	Turret Gear Case Ball Bearing
42-10554	Turret Gear Case Bushing		
42-10555	Turret Gear Case Support		
42-10556	Turret Gear Case Sleeve		
42-10559	Turret Driving Shaft Bushing		
42-10562	Turret Driving Shaft Coupling		
42-11464	Motor Adjustment Washer		
42-12068	Turret Gear Case		
42-12869	Motor Driving Shaft Collar		

Turret Drilling Attachment

42-3836	Pinion (12 Teeth)	91-201-115	Pinion Washer
42-6577	Turret Bevel Gear Guard	142-00-23	Drill Spindle, Complete (Includes 42-3836, 42-7930, 42-10532, 42-10534, 91-201-115, 211-11008 and SPX1014)
42-7930	Drill Spindle Pin Washer	211-11008	Drill Bushing Blank
42-9732	Driving Pulley (3" Diameter, Belt Driven)	SPX1014	Ball Bearing
42-10390	Attachment Belt Oil Guard (Not Shown, Belt Driven)		
42-10531	Oil Hole Cover		
42-10532	Drill Spindle		
42-10533	Driving Shaft (27 Teeth, Belt Driven, Includes 91-235-11)		
42-10534	Drill Spindle Holder (Includes 42-10531)		
42-10557	Turret Driven Shaft (27 Teeth, Motor Driven)		

Combination Drilling and Tapping Attachment

1899	Tap Spindle Spring	42-13347	Driving Shaft (20 Teeth, Belt Driven)
42-3833	Bevel Gear (15 Teeth)	91-201-115	Pinion Washer
42-3834	Pinion (10 Teeth)	142-00-24	Drill Spindle, Complete (Includes 42-3834, 42-7930, 42-10532, 42-10534, 91-201-115, 211-11008 and SPX1014)
42-6577	Turret Bevel Gear Guard	142-00-25	Tap Spindle, Complete (Includes 1899, 42-3833, 42-6683, 42-6684, 42-10675, 42-10676 and 211-11010)
42-6683	Tap Spindle Driving Bushing	211-11008	Drill Bushing Blank
42-6684	Tap Spindle Pin	211-11010	Tap Bushing Blank
42-7930	Drill Spindle Pin Washer	SPX1014	Ball Bearing
42-10390	Attachment Belt Oil Guard (Not Shown, Belt Driven)		
42-10457	Driving Pulley (3 1/2" Diameter, Belt Driven)		
42-10531	Oil Hole Cover		
42-10532	Drill Spindle		
42-10534	Spindle Holder (Includes 42-10531)		
42-10675	Tap Spindle		
42-10676	Tap Spindle Holder		
42-12533	Tap Driving Shaft (20 Teeth, Motor Driven)		

Tap or Die Revolving Attachment

1899	Tap Spindle Spring	42-12533	Tap Driving Shaft (20 Teeth, Motor Driven)
42-1708	Die Adapter	42-13347	Driving Shaft (20 Teeth, Belt Driven)
42-3833	Bevel Gear (15 Teeth)	91-90-63	Pin Wrench
42-6577	Turret Bevel Gear Guard	142-00-25	Tap Spindle, Complete (See Above)
42-6683	Tap Spindle Driving Bushing	211-8019	5/8" Die Cap
42-6684	Tap Spindle Pin	211-11010	Tap Bushing Blank
42-10390	Attachment Belt Oil Guard (Not Shown, Belt Driven)		
42-10457	Driving Pulley (3 1/2" Diameter, Belt Driven)		
42-10675	Tap Spindle		
42-10676	Tap Spindle Holder		

ORDER BY PART NUMBER AND NAME ALSO GIVE *SIZE, STYLE*
AND *SERIAL NUMBER* OF BOTH MACHINE AND ATTACHMENT.

(See instructions "How to order Repair Parts" in this book.)

Turret Milling Attachment

Parts Common to Motor and Belt Driven Attachments

3765	Cutter Arbor Nut	42-15662	Cover
		42-15663	Turret Milling Bevel Gear Guard
42-3833	Bevel Gear		
*42-6577	Turret Bevel Gear Guard	91-235-227	Bevel Gear Thrust Washer
42-15653	Shank	SPX842	Driven Shaft Bearing
42-15654	Driven Shaft	SPX1504	Cutter Arbor Support Bearing
42-15655	Shaft Housing	SPX1505	Cutter Arbor or Shank Bearing
42-15656	Cutter Arbor Support	SPX1506	Cutter Arbor Driving Shaft Bearing
42-15657	Cutter Arbor Driving Shaft		
42-15658	Cutter Arbor Driving Shaft Gear		
42-15660	Cutter Arbor Gear		
42-15661	Cutter Arbor		
			Washer, Thrust
			91-235-206 (Thin Washer)
			91-235-225 (Thick Washer)

Parts for Motor Driven Attachment Only

*42-10550	Turret Driving Gear	*42-12068	Turret Gear Case
*42-10551	Turret Driven Gear	*42-12531	Driving Shaft (Includes 91-235-225)
*42-10552	Turret Gear Case Bearing Sleeve	*42-13690	Motor Stand Bracket
*42-10553	Turret Gear Case Bearing Retainer		
*42-10554	Turret Gear Case Bushing	*91-5-134	Turret Gear Case Screw
*42-10565	Turret Gear Case Support		
*42-10566	Turret Gear Case Sleeve	*SPX1105	Turret Gear Case Ball Bearing

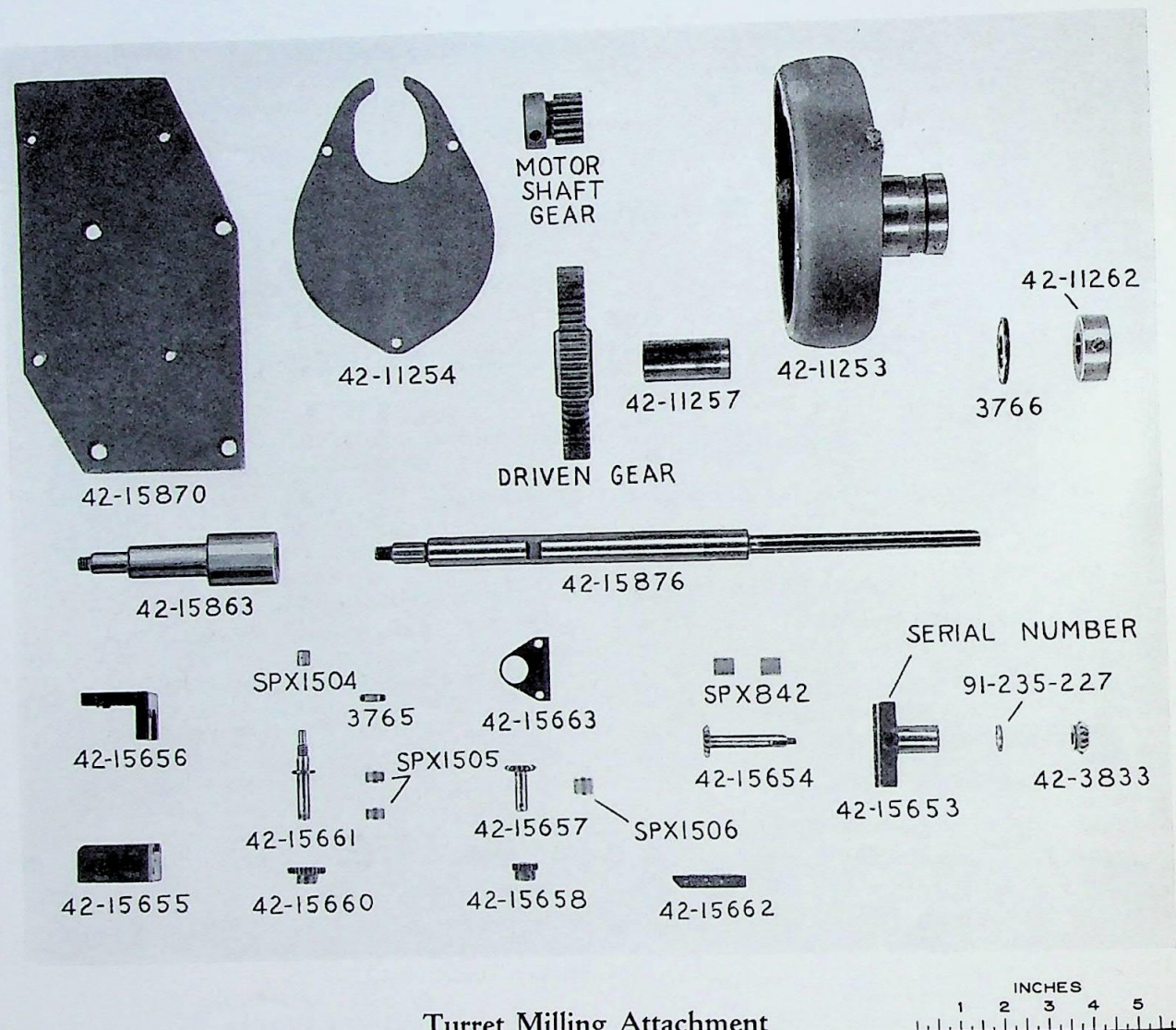
Parts for Belt Driven Attachment Only

*42-556	Driving Pulley	*Pulley, Countershaft	
42-13238	Attachment Belt Oil Guard (Not Shown)	42-215	(3 $\frac{3}{4}$ " Diameter)
*42-13310	Driving Shaft		

Gear Reduction Unit

3766	Attachment Driving Shaft Washer	Driven Gear	
42-11253	Motor Gear Guard	42-15865	32 Teeth
42-11254	Motor Gear Guard Cover	42-15867	48 Teeth
42-11257	Motor Gear Guard Bushing	42-15869	64 Teeth
42-11262	Attachment Driving Shaft Collar		
42-15863	Attachment Driving Shaft Adapter (For combination Cross Drilling and Turret Drilling Attachments)	Motor Shaft Gear	
		42-15868	16 Teeth
42-15870	Motor Plate	42-15866	24 Teeth
42-15876	Attachment Driving Shaft	42-15864	32 Teeth

*Parts shown on page 48.

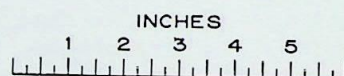
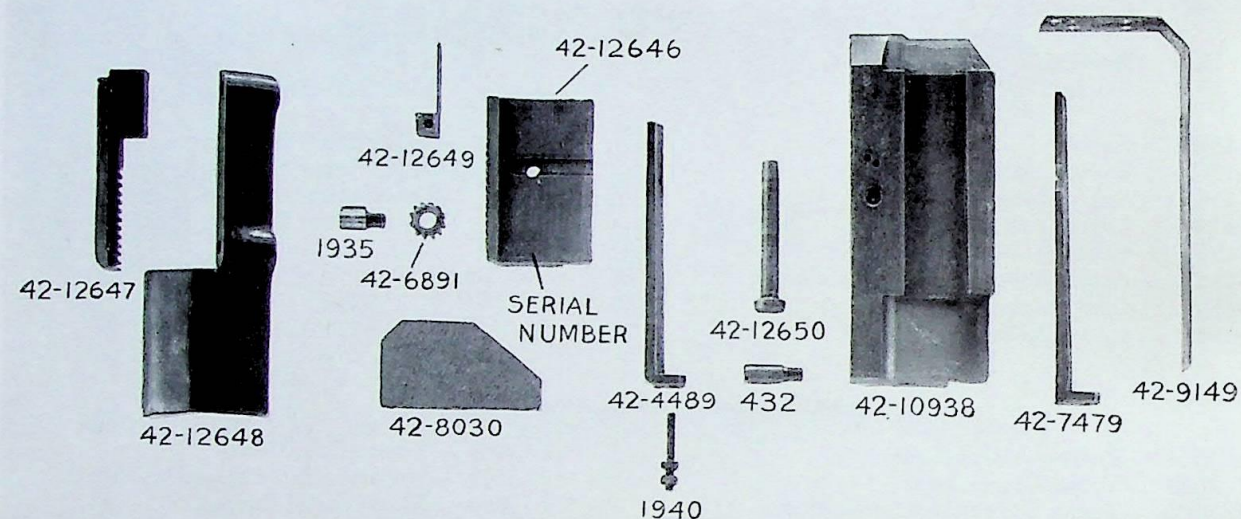


Turret Milling Attachment

ORDER BY PART NUMBER AND NAME ALSO GIVE *SIZE, STYLE*
AND *SERIAL NUMBER* OF BOTH MACHINE AND ATTACHMENT.

(See instructions "How to order Repair Parts" in this book.)

Double Movement Cross Slide

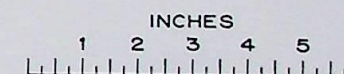
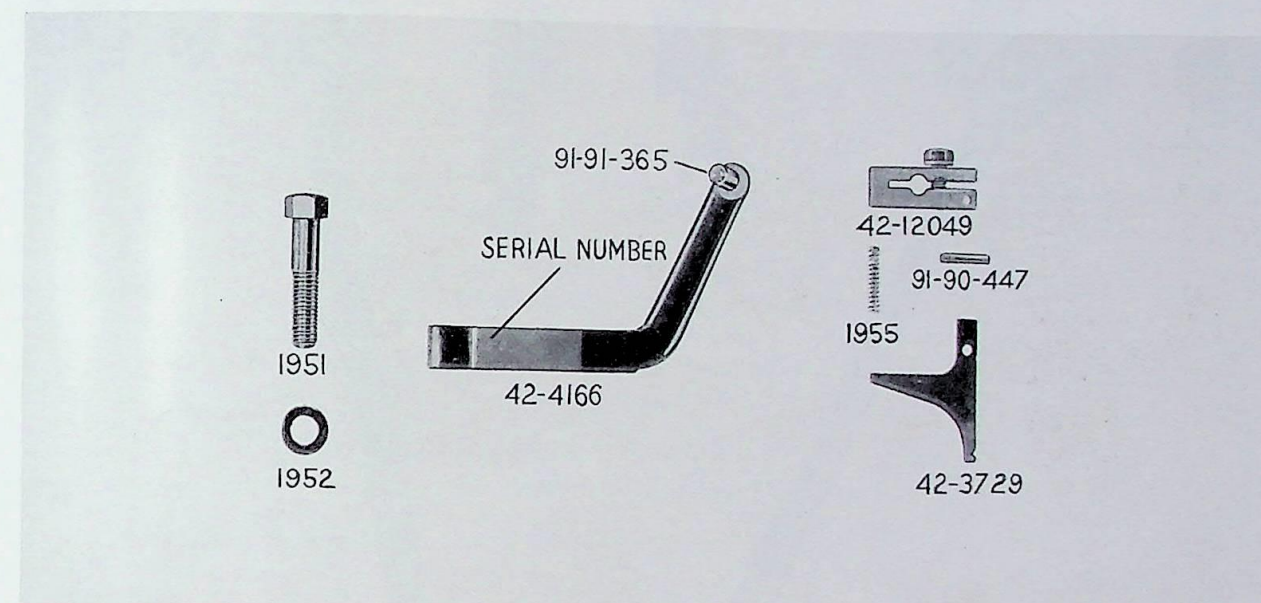


432	Cross Slide Spring Plunger Screw	42-9149	Cross Slide Guard, Front
1935	Pinion Stud	42-10938	Bottom Cross Slide, Front
1940	Top Gib Adjusting Screw and Nuts	42-12646	Top Cross Slide, Front
42-4489	Top Gib	42-12647	Ledge Rack
42-6891	Pinion	42-12648	Rack and Pinion Guard
42-7479	Cross Slide Gib, Front	42-12649	Pinion Guard, Lower
42-8030	Cross Slide Felt, Front	42-12650	Cross Slide Spring Plunger

ORDER BY PART NUMBER AND NAME ALSO GIVE *SIZE, STYLE*
AND *SERIAL NUMBER* OF BOTH MACHINE AND ATTACHMENT.

(See instructions "How to order Repair Parts" in this book.)

Slabbing Holder

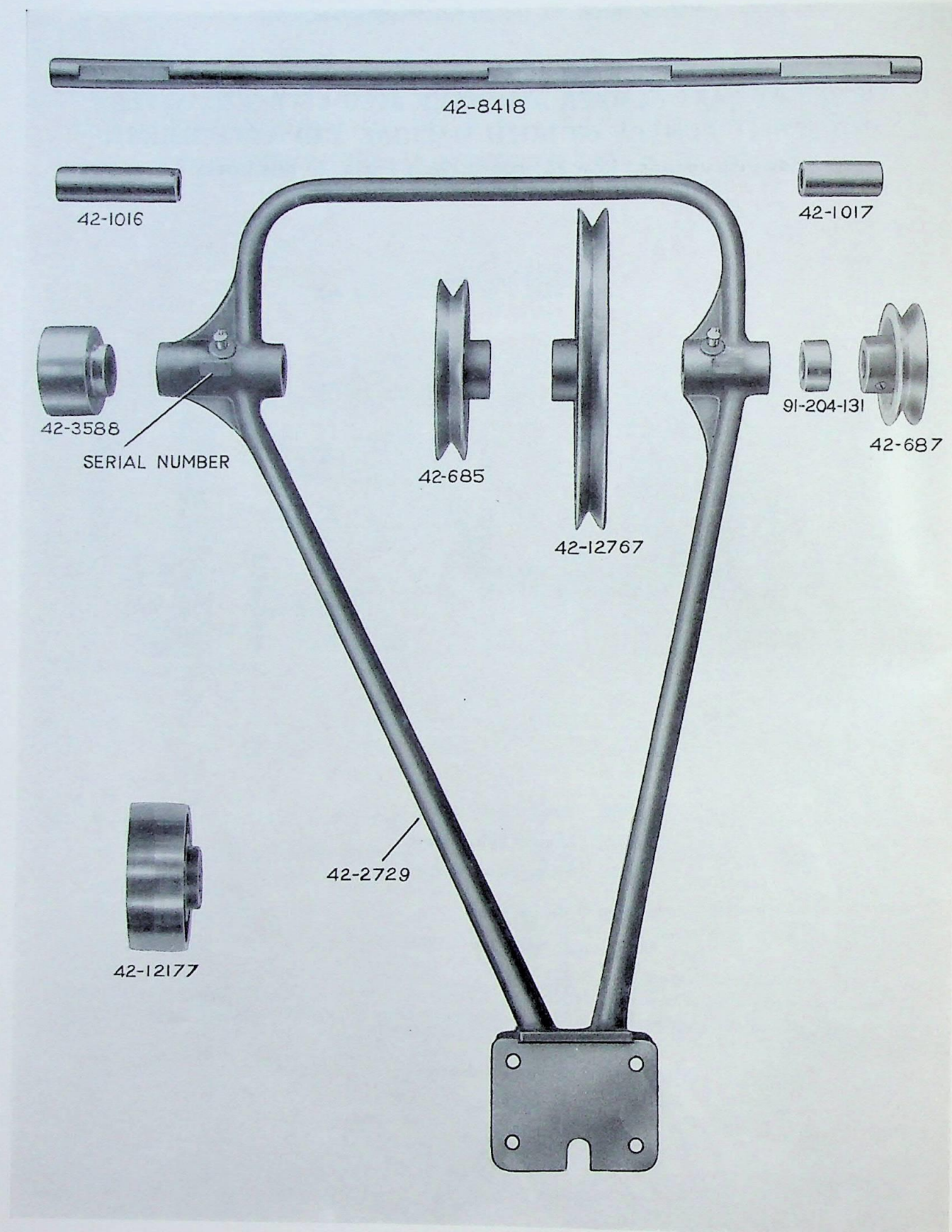


1951	Bracket Bolt
1952	Bracket Bolt Washer
1955	Finger Blank Spring
42-3729	Finger Blank
42-4166	Bracket (Includes 91-91-365)
42-12049	Head
42-12050	Head, Complete (Includes 1955, 42-3729, 42-12049 and 91-90-447)
91-90-447	Finger Blank Pivot
91-91-365	Head Pivot

ORDER BY PART NUMBER AND NAME ALSO GIVE *SIZE, STYLE*
AND *SERIAL NUMBER* OF BOTH MACHINE AND ATTACHMENT.
(See instructions "How to order Repair Parts" in this book.)

Attachment Driving Stand

- 42-685 Attachment Driving Pulley 6" Diameter
- 42-687 Attachment Driving Pulley 4" Diameter
- 42-1016 Attachment Driving Bracket Bushing, Long
- 42-1017 Attachment Driving Bracket Bushing, Short
- 42-2729 Attachment Driving Bracket
- 42-3588 Attachment Driving Shaft Pulley
- 42-8418 Attachment Driving Shaft
- 42-12177 Intermediate Driving Pulley
- 42-12767 Attachment Driving Pulley 10" Diameter
- 91-204-131 Attachment Driving Shaft Collar



Attachment Driving Stand