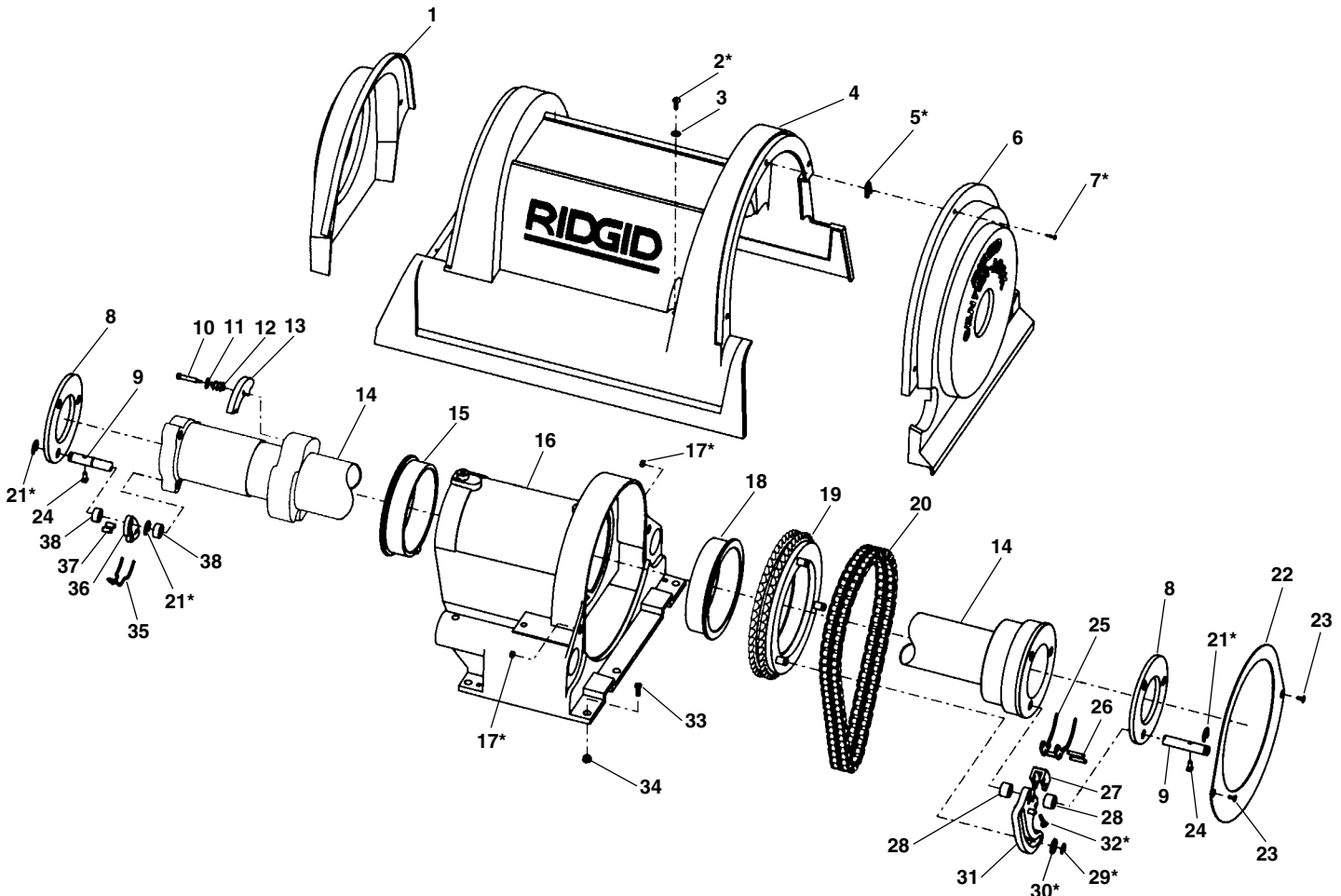


Spindle Assembly

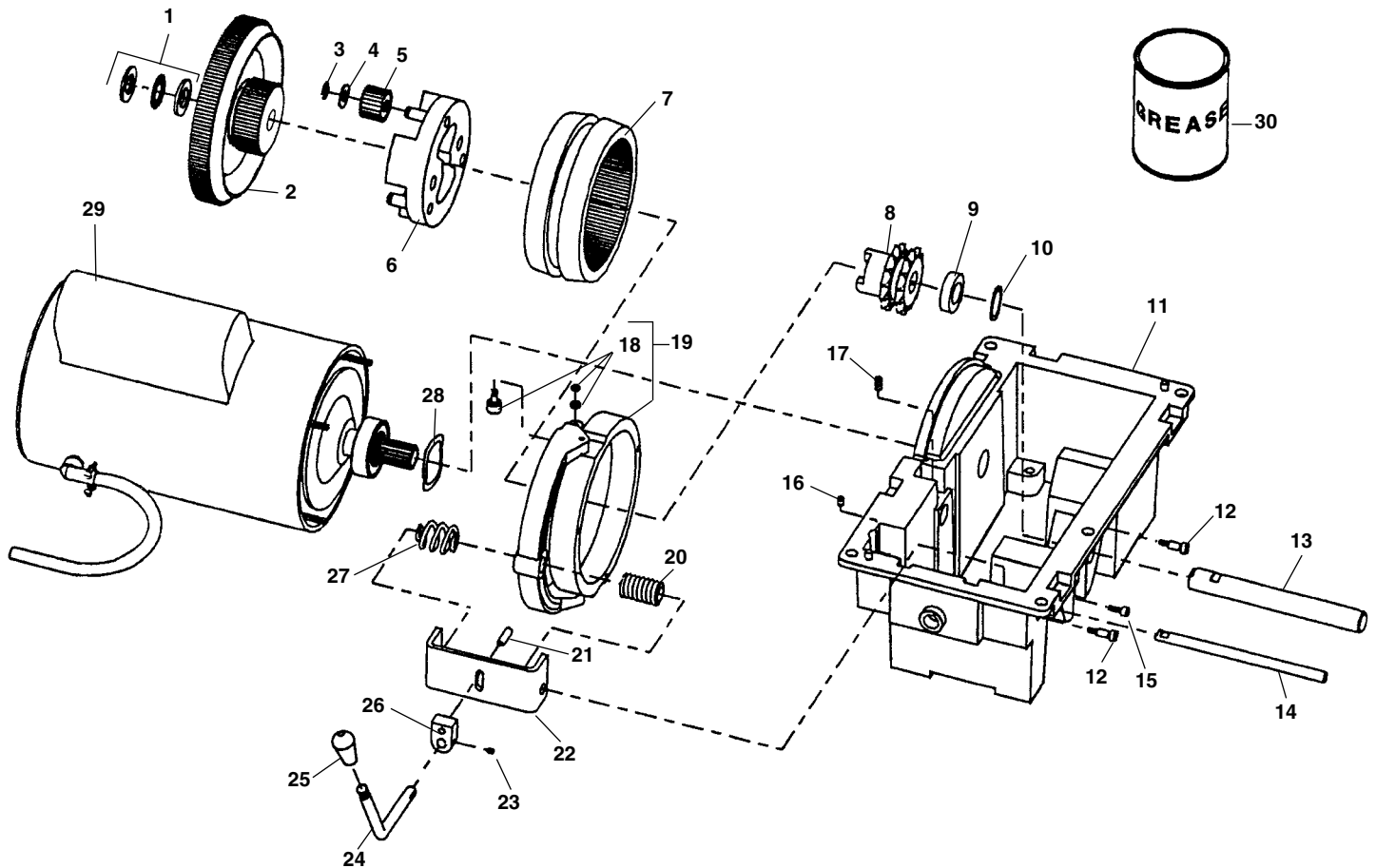


NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	34652	Rear Cover	21*	26937	Retaining Ring (9)
2*	43352	Screw (3)	22	34757	Splash Guard
3*	43357	Washer (3)	23*	46785	Screw 10-32 x 3/8" (2)
4	34657	Top Cover w/Clips (Includes 4, 5, 7)	24	34762	Pivot Rod Pin (6)
5*	43362	"J" Clip (6)	25	34772	Front Pick-up Springs (3)
6	34662	Front Cover	26	34777	Roll Pin (6)
7*	43367	Screw (6)	27	34782	Jaw Insert (3) (Includes Ref.# 25, 26)
8	47497	Pivot Rod Support (2)	28	34787	Front Jaw Spacer (6)
9	34767	Pivot Rod (3)	29*	34245	Retaining Ring (3)
10	39567	Shoulder Screw 1/4" -20 x 1 1/2" (3)	30*	34792	Washer (3)
11	54290	Flat Washer (3)	31	40847	Front Jaw (Includes Ref.# 25, 26, 27, 32)
12	35362	Spring (3)	32*	44557	Jaw Insert Screw (3)
13	34702	Brake Shoe (3)	33	45470	Bolt 3/8" - 16 x 1" (5)
14	44552	Spindle Tube	34	44225	Nut 3/8" - 16 (5)
15	34712	Rear Bearing	35	34807	Rear Pick-up Spring (3)
16	34717	Spindle Housing	36	41347	Rear Jaw Set (Includes Ref.# 35, 37)
17*	34722	Nut #10 (2)	37	34817	Pick-up Spring Pin (6)
18	34727	Front Bearing	38	34802	Rear Jaw Spacer (6)
19	34732	Drive Sprocket w/Pins	—	46727	Hardware package (Includes items marked with *)
20	34742	Drive Chain w/Master Link			
	34747	Master Link			

†See Service Notes

Transmission and Motor – Induction



**NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.**

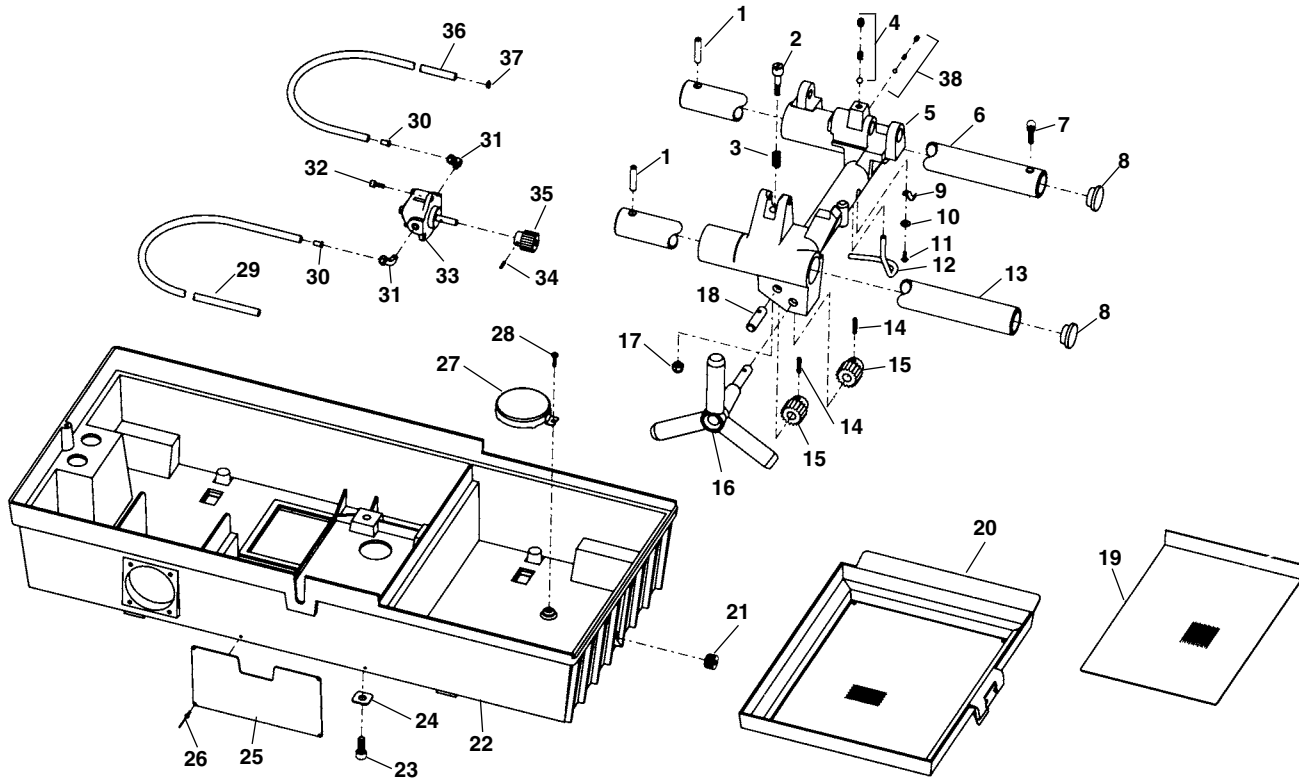
Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	41425	Thrust Bearing w/Washer	11	34872	Transmission Housing	21	44640	Dowel Pin
2	44537	Input Gear 60 Hz	12	34877	Shoulder Screw 1/4" - 20 x 1/2" (2)	22	34912	Yoke Slide
3	34245	Retaining Ring (3)	13	34882	Transmission Shaft	23	34917	Set Screw 10 - 32 x 1/4"
4	34792	Washer (3)	14	34887	Shifter Shaft	24	34927	Shifter Lever
5	34837	Planet Gear (3)	15	40260	Screw 10 - 24 x 1/2"	25	34932	Knob
6	56822	Planet Gear Spider w/Pins	16	34897	Set Screw 10 - 32 x 1/4"	26	34922	Pivot Block
7	44527	Internal Ring Gear	17	34892	Set Screw 1/4" - 20 x 1/2"	27	35362	Barrel Spring
8	34862	Output Sprocket	18	44547	5/8" Cam Roller (2)	28	34942	Wave Washer
9	34867	Thrust Spacer	19	44542	Stationary Cup Assembly	29	34947	Motor 120V 60 Hz
10	68037	Wave Washer	20	34907	Large Spring	30	26707	Transmission Grease 1 lb. (2)

1822-I Motor Parts

Description	120V 60Hz
Dual Contact Start Switch	46772
Start Capacitor	46782
Run Capacitor	46802
Motor Bolts	46812

See 1822 Service Notes

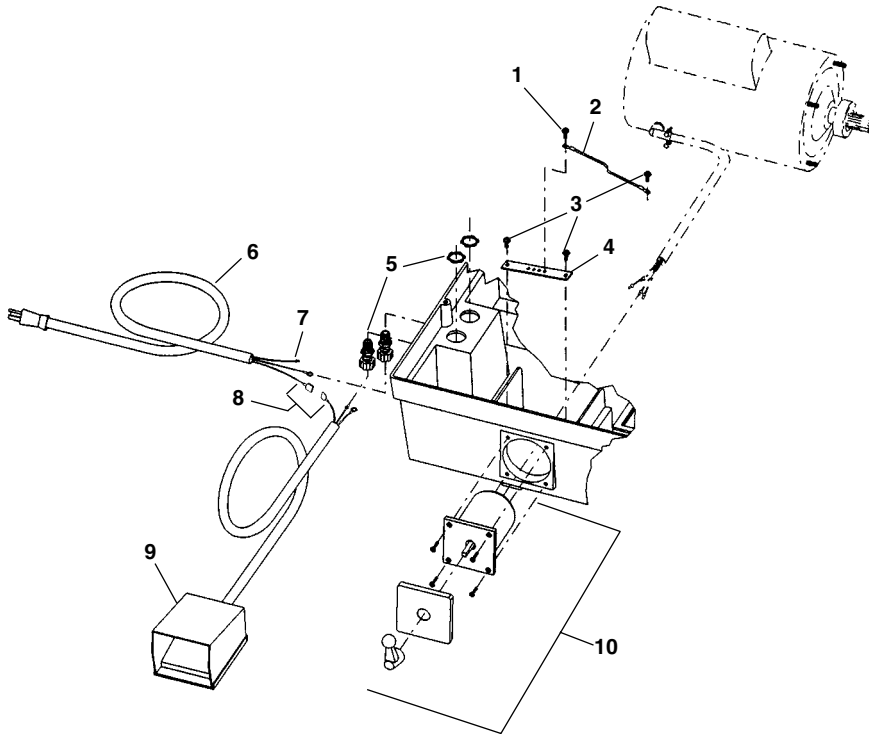
Carriage and Oil System - Induction



**NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	34375	Rail Pin (2)	21	48337	Drain Plug 3/4" NPT
2	35042	Stop Bolt	22	26842	Drain Plug (Rubber-Early Style)
3	35047	Stop Bolt Spring	22	59747	Base
4	46810	Detente Assembly	22	59752	Base (1822-IC)
5	35147	Carriage (Includes 2, 3, 4, 5, 38)	23	46755	Bolt 3/8" -16 x 7/8" (4)
6	35057	Rear Rail	24	35107	Square Washer (4)
7	34425	Screw 5/16" -18 x 3/8"	25	36612	Warning Plate 60Hz
8	35162	Rail Plug (2)	26	35222	Pop Rivet (2)
9	35062	Oil Line Clamp	27	58467	Oil Screen Assembly
10	45365	Washer #10	28	26797	Oil Screen Screw 10-32 x 5/16"
11	79965	Screw 10-32 x 1/2	29	35112	Oil Intake Line 30"
12	35067	Oil Tube	30	35117	Oil Line Insert (2)
13	35167	Front Rail	31	35122	90 Degree Fitting (2)
14	34342	Roll Pin 3/16" x 15/16" (2)	32	32145	Bolt 1/4" - 20 x 1/2" (3)
15	35177	Carriage Pinion (2)	33	39162	Oil Pump
16	35182	Handwheel	34	39820	Pin
17	75110	Stop Nut 5/16" -18	35	35197	24 T Pump Gear - 60 Hz
18	35187	Pinion Idler Shaft	36	35137	Oil Supply Line 40"
19	35192	Lower Screen	37	35142	Hose Clamp
20	35097	Draw Tray Assembly	38	35307	Oil Pressure Relief

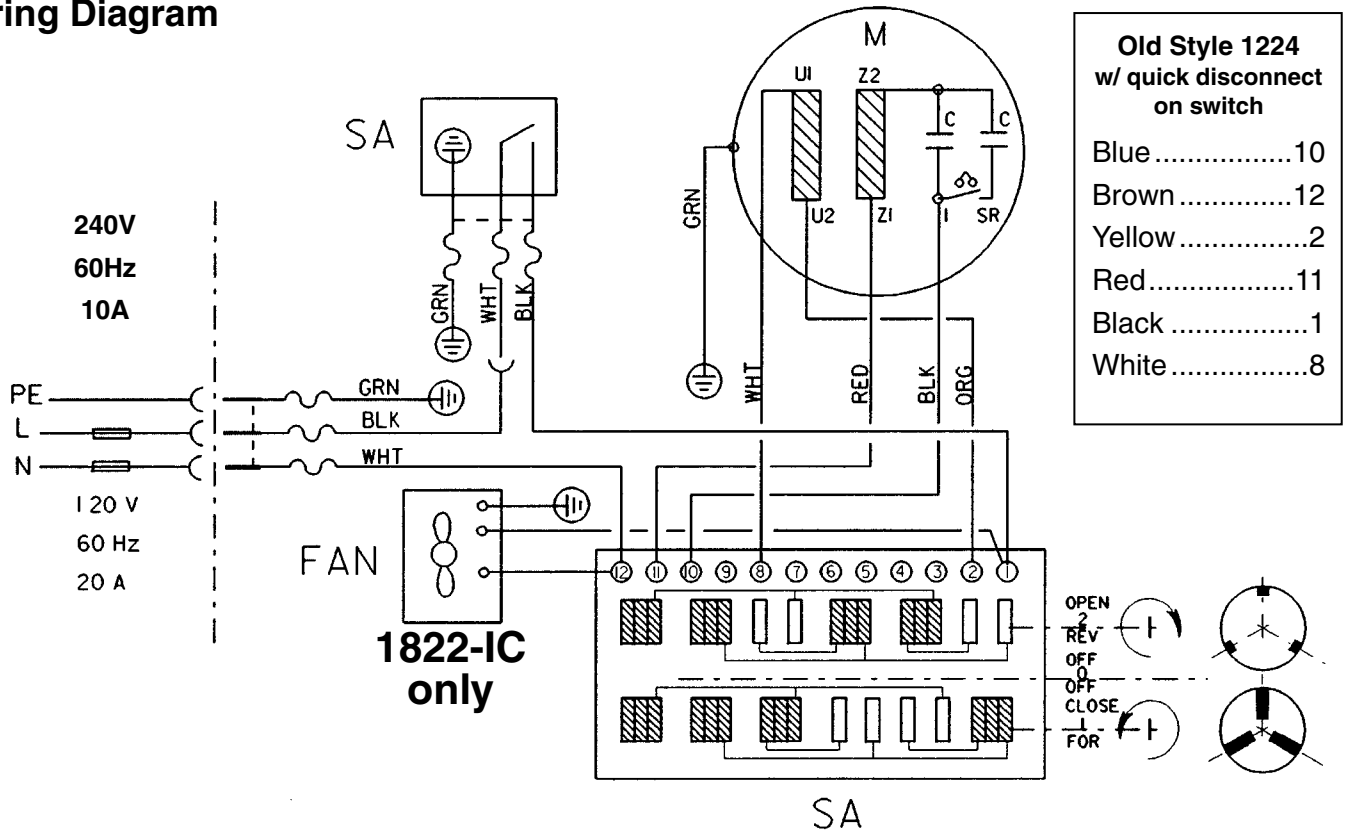
60 Hz Electrical Components



NOTE: Order parts by Catalog Number only. DO NOT order by Reference Number.

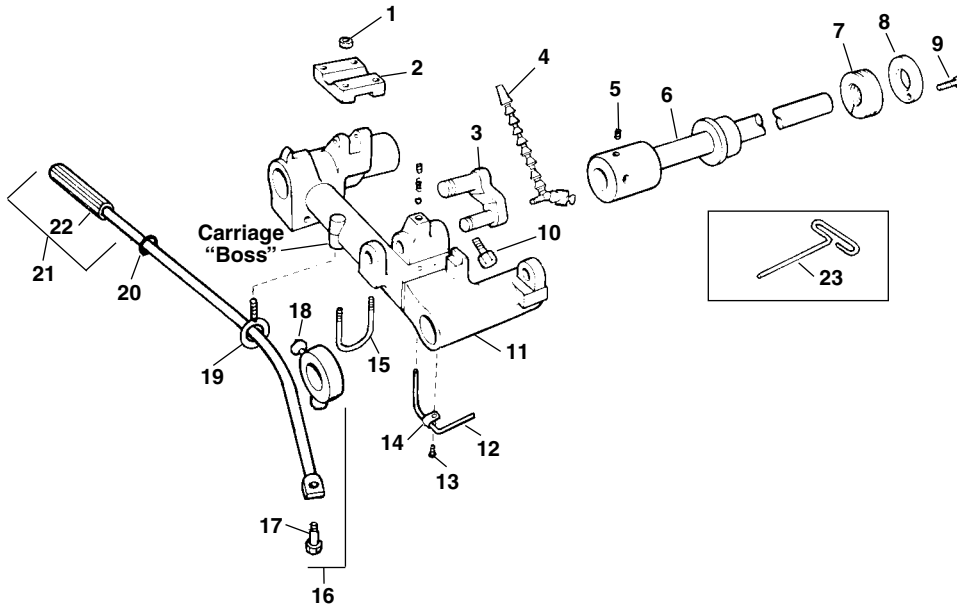
Ref. No.	Catalog No.	Description
1	34715	Screw 10-32 x 3/8" (3)
2	33607	Ground Wire
3	45420	Screw 10-24 (4)
4	59732	Ground Strap
5	68885	Strain Relief (2)
6	46740	Power Cord 120V
	46410	Power Cord 240V
7	36222	Wire Terminal
8	56407	Quick Disconnect Set
9	36642	B-294 Foot Switch
10	20133	Switch Assembly

1224 & 1822-I Replacement Switch Wiring Diagram



No. 241 Carriage Mount Kit Parts

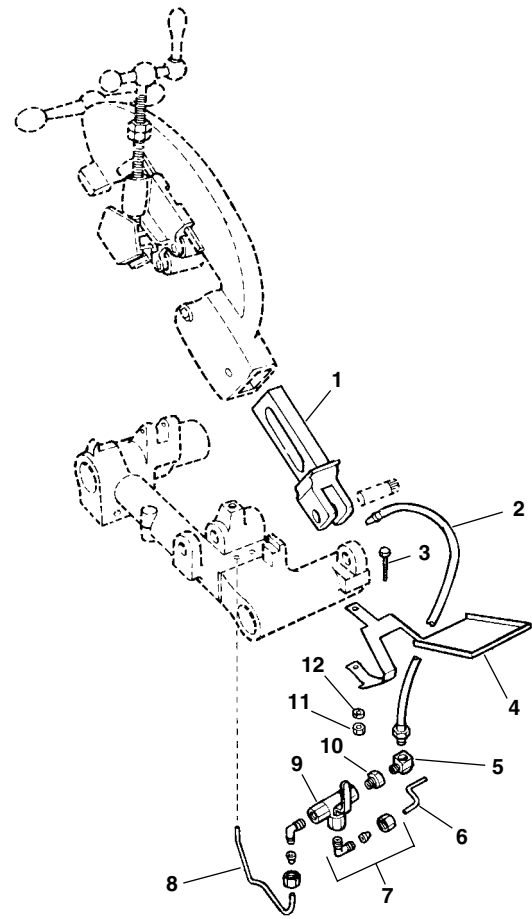
NOTE: Order parts by Catalog Number only. DO NOT order by Reference Number.



Ref. No.	Catalog No.	Description
—	35877	241 Carriage Mount Kit
1	96730	Hex Nut, 3/16" - 18
2	36177	Saddle
3	36182	Connecting Link
4	35277	Coolant Nozzle
5	39775	Set Screw, 3/8" - 11
6	36187	Drive Bar
7	36192	Spring
8	36197	End Cap
9	27357	Cap Screw, 1/4" - 20 x 3/4"
10	35202	Sq. Hd. Set Screw, 1/2" - 13
11	35052	Carriage
12	35067	Oil Supply Line
13	79965	Screw, 10-32 x 1/2"
14	35062	Oil Line Clamp
15	35207	U-Bolt
16	35282	Collar Assembly
17	46210	Shoulder Bolt
18	46220	Thumb Screw
19	35082	Eye Bolt
20	35092	O-Ring
21	43400	Lever Arm Assembly
22	46235	Hand Grip
23	35212	Hex Wrench
24	46810	Detente Assembly

No. 822 Blade Cutter Adapter Kit Parts
307 Oil Spout Assembly

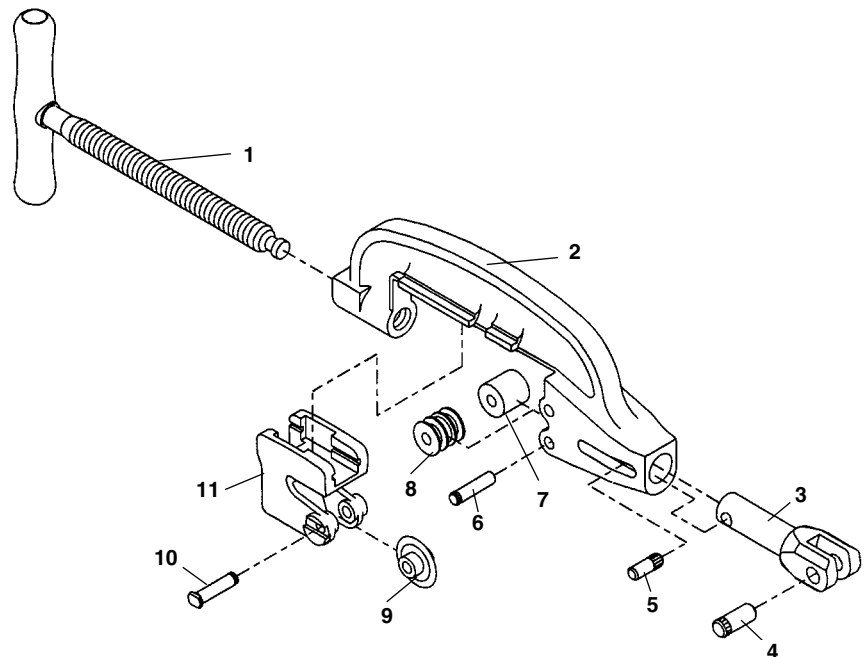
Ref. No.	Catalog No.	Description
—	35872	822 Adapter Kit
—	36602	307 Manifold Kit
1	36137	Cutter Arm (822 Kit Only) (1)
2	39845	Coolant Nozzle (1)
3	44510	Cap Screw 1/4" - 20 x 2" (1)
4	36142	Drip Guard (1)
5	36147	90° Street Elbow (1)
6	36152	Oil Line (3.3 in.) (1)
7	36157	90° Comp. Fitting (2)
8	36162	Oil Line (7.4 in.) (1)
9	36167	3-Way Valve (1)
10	36172	Reducer Bushing (1)
11	83890	Hex Nut, 1/4" - 20 (1)
12	27097	Flat Washer, 1/4" (1)



No. 364 Cutter

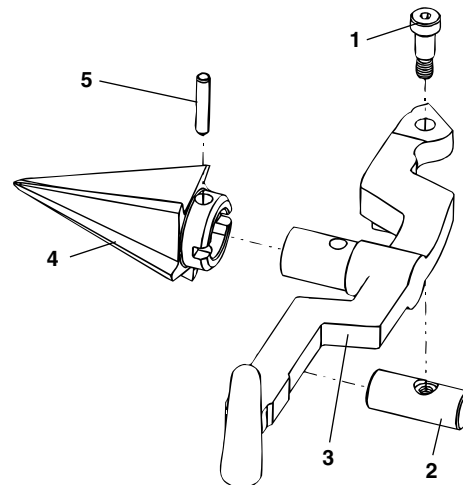
**NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description
—	34617	364 Cutter Complete
1	36287	Feed Screw Handle
2	36292	Cutter Frame
3	45505	Support Arm
4	45520	Hinge Pin
5	35317	Retaining Pin
6	46662	Roll Pin (2)
7	46960	Roll (Steel) (2)
8	43682	Roll Pl. Coated Pipe (2)
9	44185	Cutter Wheel E-1032
10	34780	Wheel Pin
11	36282	Wheel Housing



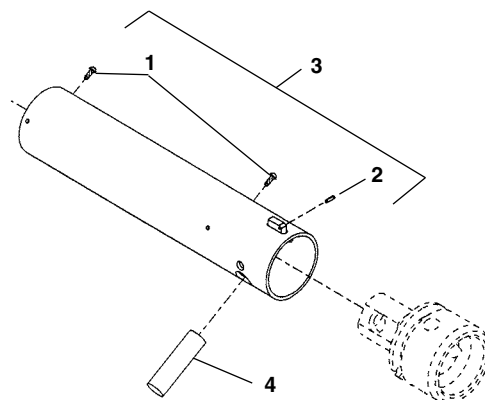
No. 344 Reamer

Ref. No.	Catalog No.	Description
—	34612	344 Reamer Complete
1	36262	Shoulder Screw
2	36267	Pivot Pin
3	36272	Reamer Arm
4	36277	Reamer Cone (R.H.)
	46660	Reamer Cone (L.H. & R.H.)
5	35355	Split Roll Pin

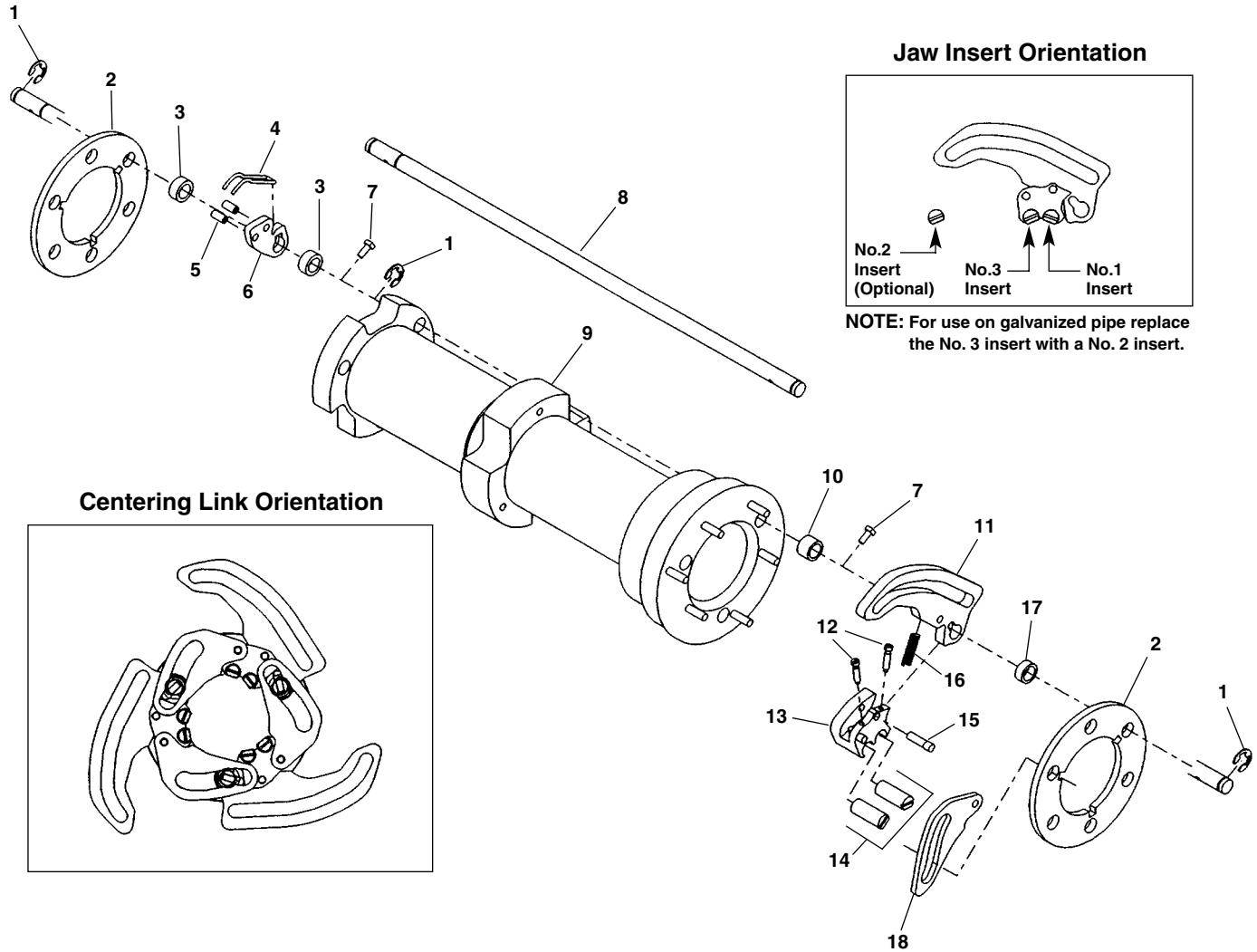


No. 839 Nipple Chuck

Ref. No.	Catalog No.	Description
—	35867	No. 839 Adapter Kit
1	54307	Drive Screw (6)
2	47502	Roll Pin
3	47507	Tube Assembly
4	47512	Pin, 3/4" x 2 3/4"



Spindle Assembly For Plastic Coated Pipe



Jaw Insert Orientation

No.2 Insert (Optional) No.3 Insert No.1 Insert

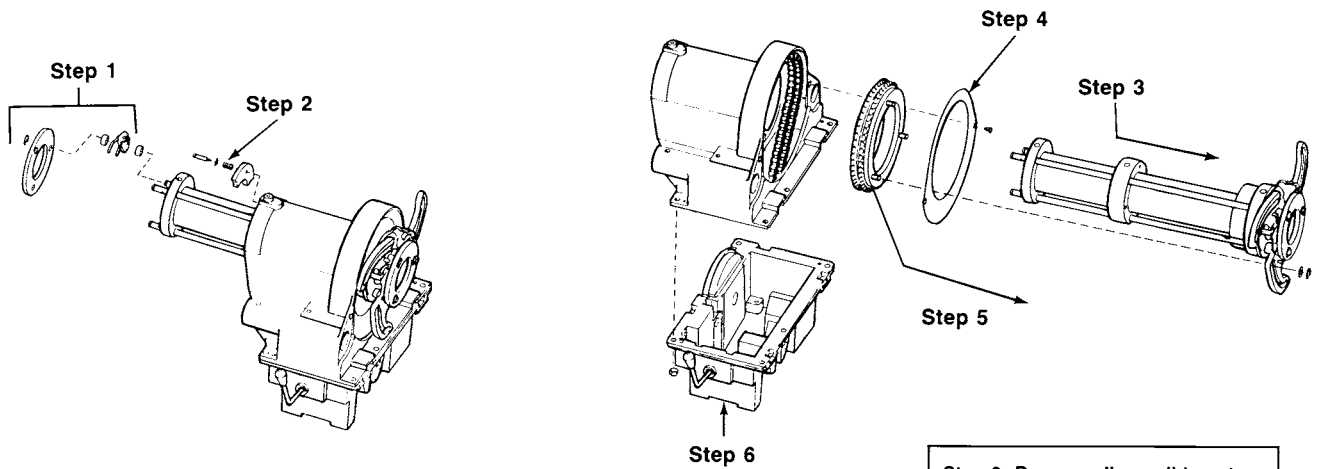
NOTE: For use on galvanized pipe replace the No. 3 insert with a No. 2 insert.

Centering Link Orientation

NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
—	50107	Plastic Coated Pipe Spindle Assembly	10	34787	Large Front Spacer
1	26937	Retaining Clip (9)	11	52977	Jaw (3) (Includes Ref. No.12-16)
2	47497	Pivot Rod Support (2)	12	46642	Jaw Insert Screw (6)
3	34802	Rear Spacer (6)	13	52982	Insert Holder (3)
4	43407	Rear Pick-up Spring (3)	14	43377	Jaw Insert Set (Includes 3 each No.1 & 3 Inserts)
5	34817	Rear Pick-up Spring Pin (6)		46647	Jaw Insert Set (No. 2 - Optional f/Galv. Pipe)
6	43412	Rear Jaw (3) (Includes Ref. No. 4 & 5)	15	43402	Insert Holder Pin (3)
7	34762	Pivot Rod Pin (6)	16	52987	Insert Holder Spring (3)
8	34767	Pivot Rod (3)	17	43392	Small Front Spacer (3)
9	61127	Spindle Tube f/P.C.P.	18	43387	Centering Link (3)

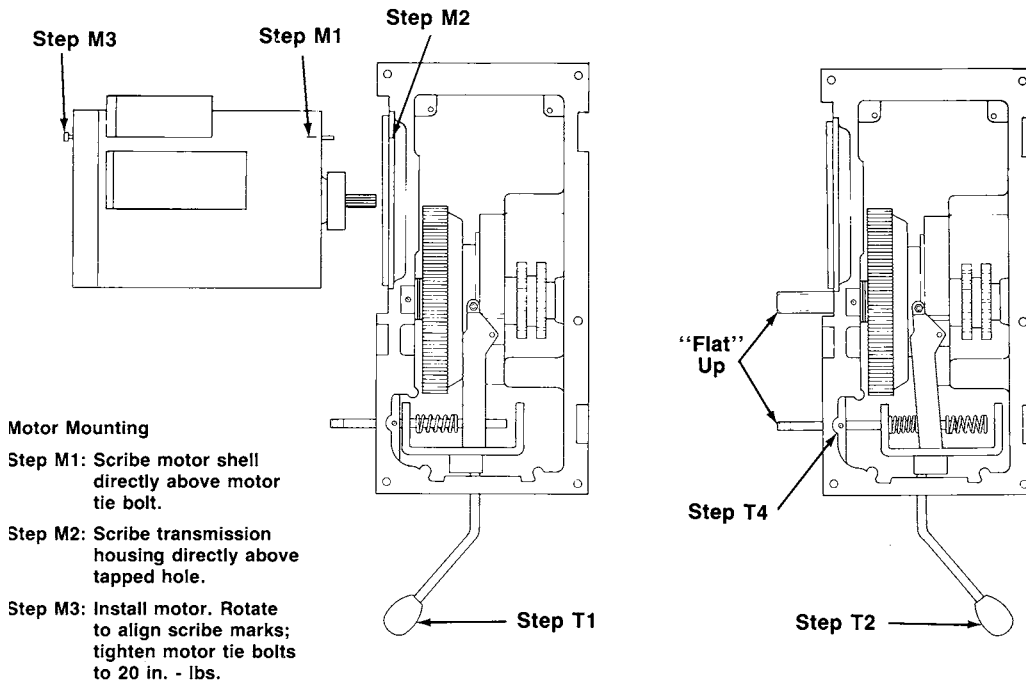
Power Assembly/Drive Assembly Separation Procedure



Step 1: Remove Rear Centering Device.
Step 2: Remove Brake Shoes (3).

Step 3: Remove clips - slide out Spindle Assembly.
Step 4/5: Remove Splash Guard and Sprocket.
Step 6: Separate housings.

Motor Mounting and Transmission Shifter Assembly (Induction Only)



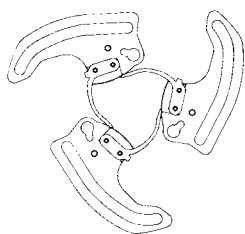
Motor Mounting
Step M1: Scribe motor shell directly above motor tie bolt.
Step M2: Scribe transmission housing directly above tapped hole.
Step M3: Install motor. Rotate to align scribe marks; tighten motor tie bolts to 20 in. - lbs.

Transmission Shifter Assembly
Step T1: Rotate shift lever to left and install small (short) spring over shifting shaft.
Step T2: Rotate shift lever to right and install large (long) spring.
Step T3: (Not shown) Rotate shift lever to center (upright) position and finish installing shaft.
Step T4: Tighten set screw.
Note: Install "flat" on shafts UP.

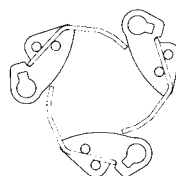
Right Hand

Jaw Orientation

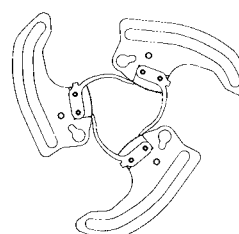
Left Hand



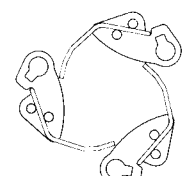
Front



Rear



Front



Rear