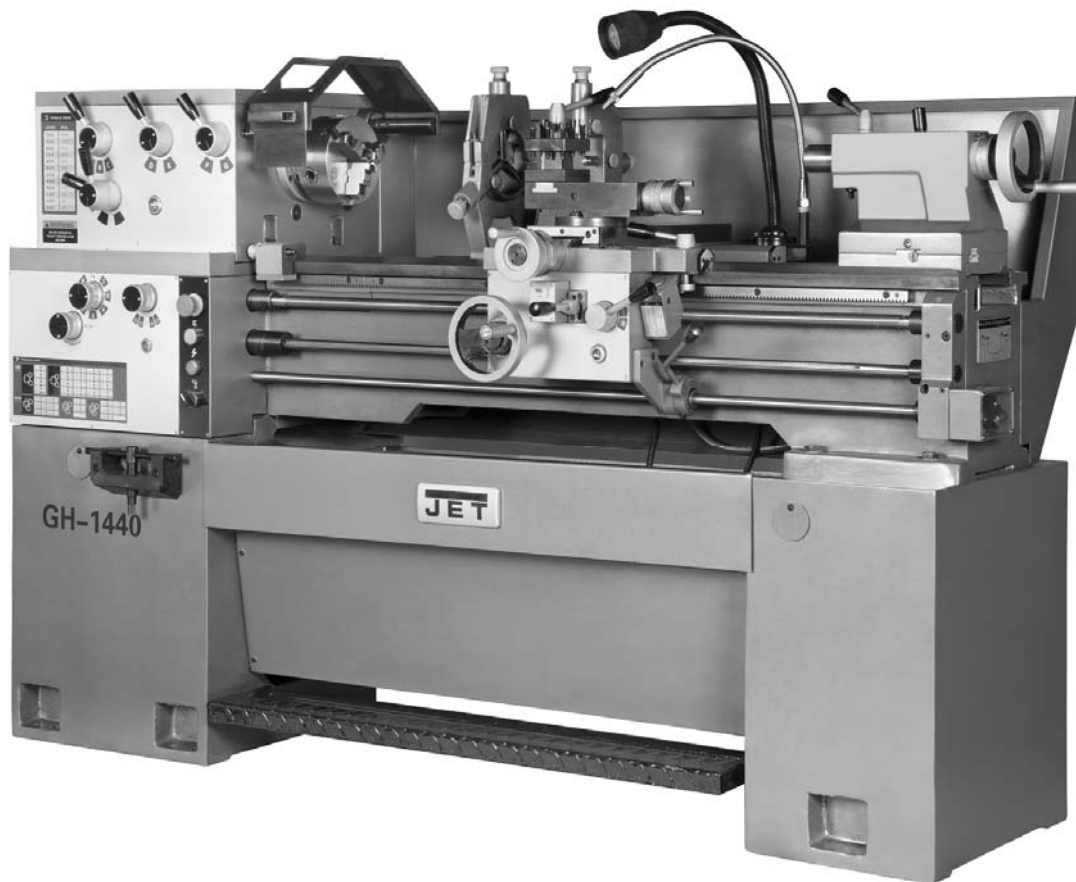




# Operating Instructions and Parts Manual

## Geared Head Lathe 14x40 inch

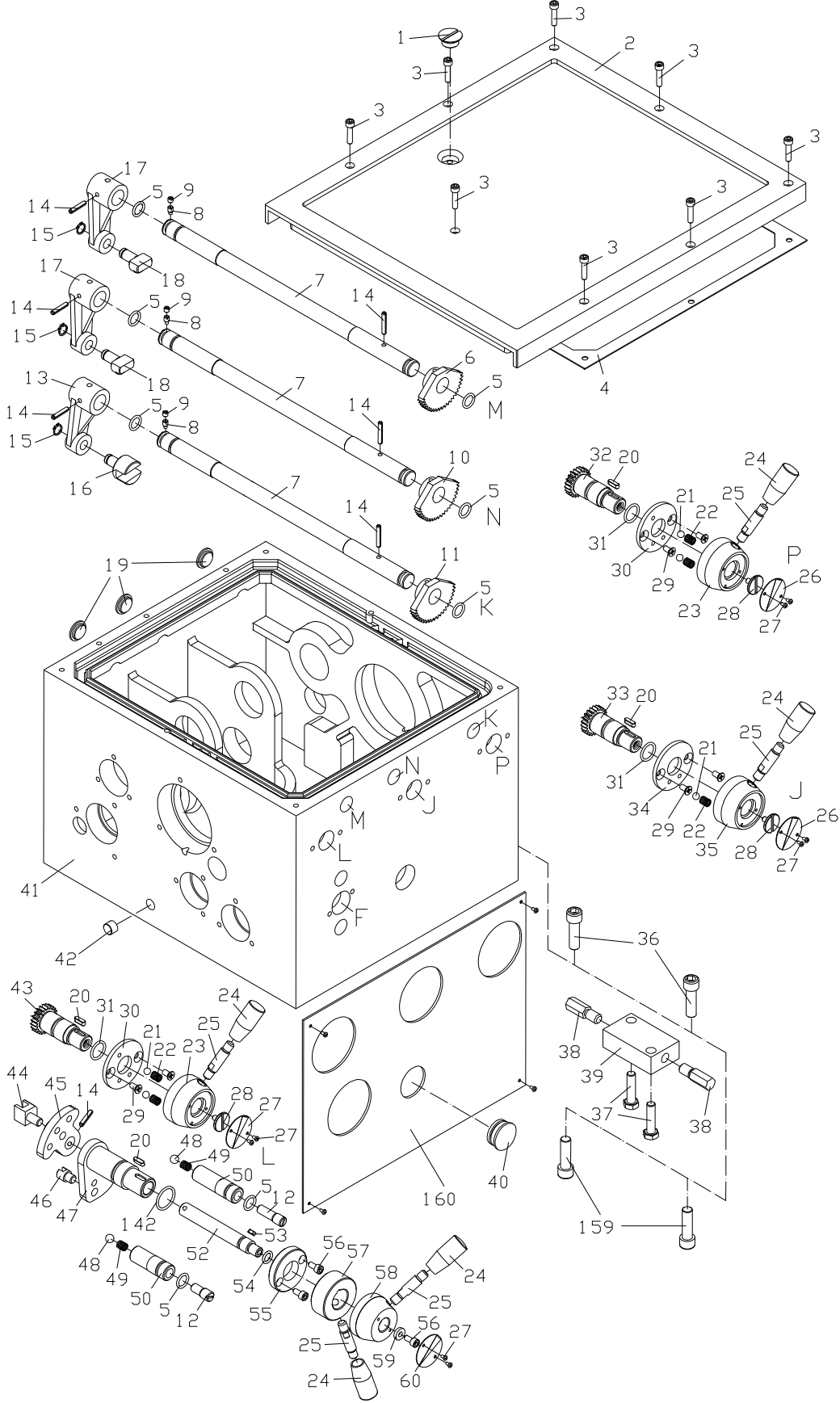
Model GH-1440



**JET**  
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**Part No. M-322830**  
Edition 3 08/2018  
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### 14.1.1 Headstock Assembly I – Exploded View

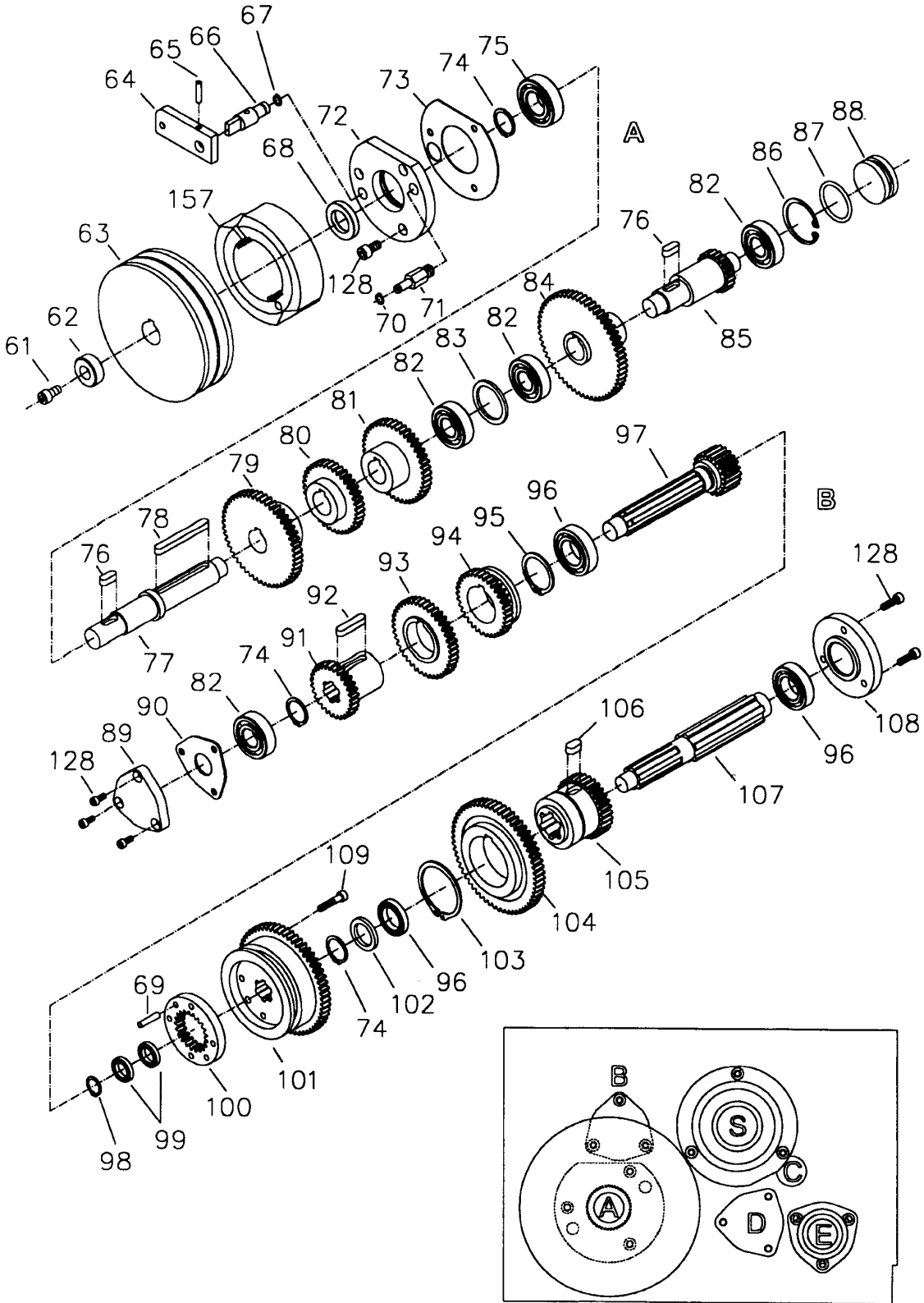


## 14.1.2 Headstock Assembly I – Parts List

Index No.	Part No.	Description	Size	Qty
1	C6136-02755	Plug		1
2	GH1440K-02119	Headstock Cover		1
3	TS-1503061	Hex Socket Hd Cap Screw	M6x25	6
4	GH1440K-02509	Gasket		1
5	GH1440K-005	O-Ring	14x2.65 mm	8
6	GH1440-04-38	Gear	38T	1
7	GH1440K-02749	Shaft		3
8	TS-1523031	Socket Set Screw	M6x10	3
9	F010445	Socket Set Screw FP	M6x6	3
10	GH1440-04-37	Gear	48T	1
11	GH1440-04-36	Gear	43T	1
12	GH1440K-02754	Set Screw		1
13	GH1440-04-43	Shift Arm		1
14	ZX-S48	Spring Pin	5x30 mm	7
15	F006041	C-Retaining Ring, Ext	12 mm	3
16	GH1440-04-45	Shift Fork		1
17	GH1440-04-35	Shift Arm		2
18	GH1440-04-44	Gear Shifter		2
19	GH1440K-02748	Plug		3
20	5510677	Key, Dbl Rd Hd	5x16 mm	4
21	SB-8MM	Steel Ball	8 mm	5
22	C6240-20018	Spring		5
23	GH1440-04-49	Lever Hub		2
24	GB4141.14-BM10x50	Knob		5
25	GH1440-04-34	Handle Lever		5
26	GH1440K-02303	Lever Indicator Plate		4
27	TS-1531012	Pan Hd Screw	M3x6	14
28	GH1440-04-59	Screw		3
29	TS-1514011	Socket Hd Flat Screw	M6x12	6
30	GH1440-04-50	Position Plate		2
31	GH1440K-031	O-Ring	19x2.65 mm	3
32	GH1440-04-40	Gear Shaft	22T	1
33	GH1440-04-42	Gear Shaft	17T	1
34	GH1440-04-51	Position Plate		1
35	GH1440-04-58	Lever Hub		1
36	TS-1506051	Hex Socket Hd Cap Screw	M12x40	2
37	GB5782-86	Alignment Bolt	M10x40	2
38	GH1440-04-62	Alignment Bolt		2
39	GH1440-04-63	Alignment Block		1
40	GB1160.1-89	Oil Sight Glass	20 mm	1
41	GH1440K-02101	Headstock Casting		1
42	05-75	Drain Plug		1
43	GH1440-04-39	Gear Shaft	27T	1
44	GH1440-04-47	Shaft Fork		1
45	GH1440-04-36	Shifting Crank		1
46	GH1440-04-71	Shaft Fork		1
47	GH1440K-02117	Shifting Crank		1
48	SB-10MM	Steel Ball	10 mm	2
49	GB2089	Spring	0.9×9×40 mm	2
50	GH1440K-02753	Shaft		1
51	GH1440K-02755	Shaft		1
52	GH1440K-02747	Shaft		1
53	GB1096-4X10	Key, Dbl Rd Hd	4x10 mm	1
54	GH1440K-054	O-Ring	10.6x2.65 mm	1
55	GH1440-04-55	Collar		1
56	TS-150303	Hex Socket Hd Cap Screw	M6x12	3
57	GH1440-04-57	Collar		1
58	GH1440-04-58	Lever Hub		1
59	TS-1550041	Flat Washer	6mm	1
60	GH1440K-02756	Lever Indicator Plate		1

<b>Index No.</b>	<b>Part No.</b>	<b>Description</b>	<b>Size</b>	<b>Qty</b>
142	GH1440K-142	O-Ring	25x2.65 mm	3
159	TS-1506041	Hex Socket Hd Cap Screw	M12x35	2
160	GH1440K-02304-24	Name Plate		1

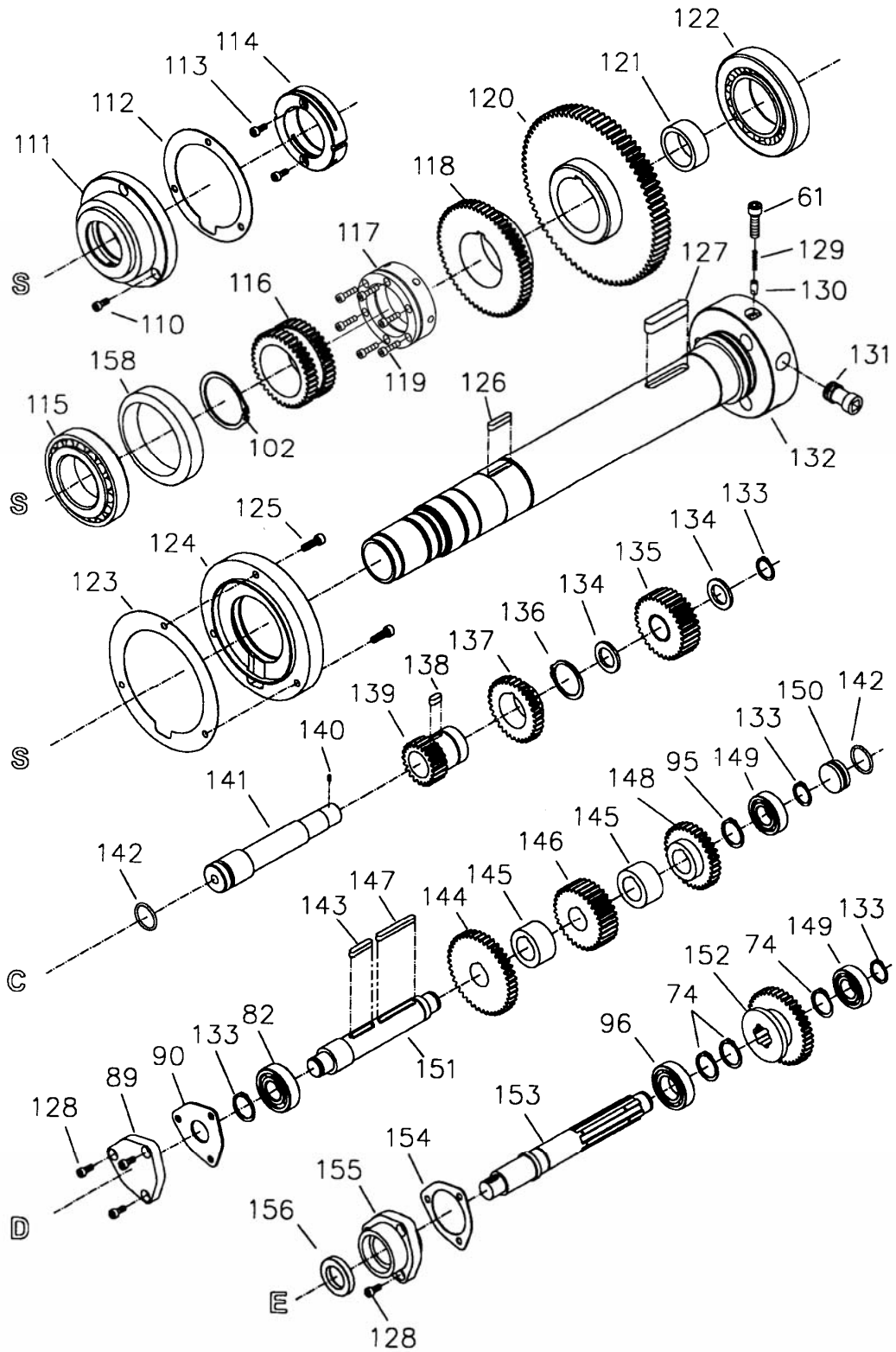
14.2.1 Headstock Assembly II – Exploded View



## 14.2.2 Headstock Assembly II – Parts List

Index No.	Part No.	Description	Size	Qty
61	TS-1504031	Hex Socket Hd Cap Screw	M8x16	1
62	04-12	Washer		1
63	04-11	Pulley		1
64	GH1440K-02722	Brake Block		1
65	5625391	Spring Pin	5x16 mm	1
66	11-09	Brake Actuator Shaft		1
67	F006041	C-Retaining Ring, Ext	12 mm	1
68	GB9877.1-88	Spacer	SD25x45x7	1
69	GHW-H69	Taper Pin	A6x26 mm	2
70	F006039	C-Retaining Ring, Ext	8 mm	1
71	11-11	Brake Retaining Stud		1
72	04-13	Cover		1
73	04-14	Gasket		1
74	F006050	C-Retaining Ring, Ext	25 mm	6
75	BB-6205	Ball Bearing	6205/p5	1
76	AK052	Key, Dbl Rd Hd	8x20 mm	2
77	GH1440K-02718	Shaft		1
78	GHW-H78	Key	8x72 mm	1
79	GH1440-04-04	Gear	50T	1
80	GH1440-04-05	Gear	37T	1
81	GH1440-04-06	Gear	43T	1
82	BB-6204	Ball Bearing	6204/p5	5
83	GH1440-04-17	Washer		1
84	GH1440-04-12	Gear	57T	1
85	GH1440-04-11	Gear Shaft	20T	1
86	F006075	C-Retaining Ring, Int	47 mm	1
87	GH1440K-287	O-Ring	40x2.65	1
88	GH1440K-02106	Plug		1
89	04-53	Bearing Cap		2
90	04-52	Gasket		2
91	GH1440-04-08	Gear	28T	1
92	GHW-H92	Key, Dbl Rd Hd	8x38 mm	1
93	GH1440-04-09	Gear	41T	1
94	GH1440-04-10	Gear	34T	1
95	F006055	C-Retaining Ring, Ext	40 mm	1
96	BB-6005	Ball Bearing	6005/p5	4
97	GH1440K-02724	Gear Shaft	21T	1
98	F006045	C-Retaining Ring, Ext	17 mm	1
99	BB-61803	Ball Bearing	61803/p5	2
100	GH1440-04-15	Gear	21T	1
101	GH1440-04-14	Gear	58T	1
102	GH1440K-02709	Washer		1
103	F006082	C-Retaining Ring, Ext	55 mm	1
104	GH1440-04-19	Gear	59T	1
105	GH1440-04-18	Gear	31T	1
106	GB1096-10X18	Key, Dbl Rd Hd	10x18 mm	1
107	GH1440-04-13	Spline Shaft		1
108	GH1440-04-24	Cover		1
109	TS-1503081	Hex Socket Hd Cap Screw	M6x35	4
128	JHM610-22	Hex Socket Hd Cap Screw	M6x14	9
157	11-15	Brake Shoe Assembly		1

14.3.1 Headstock Assembly III – Exploded View

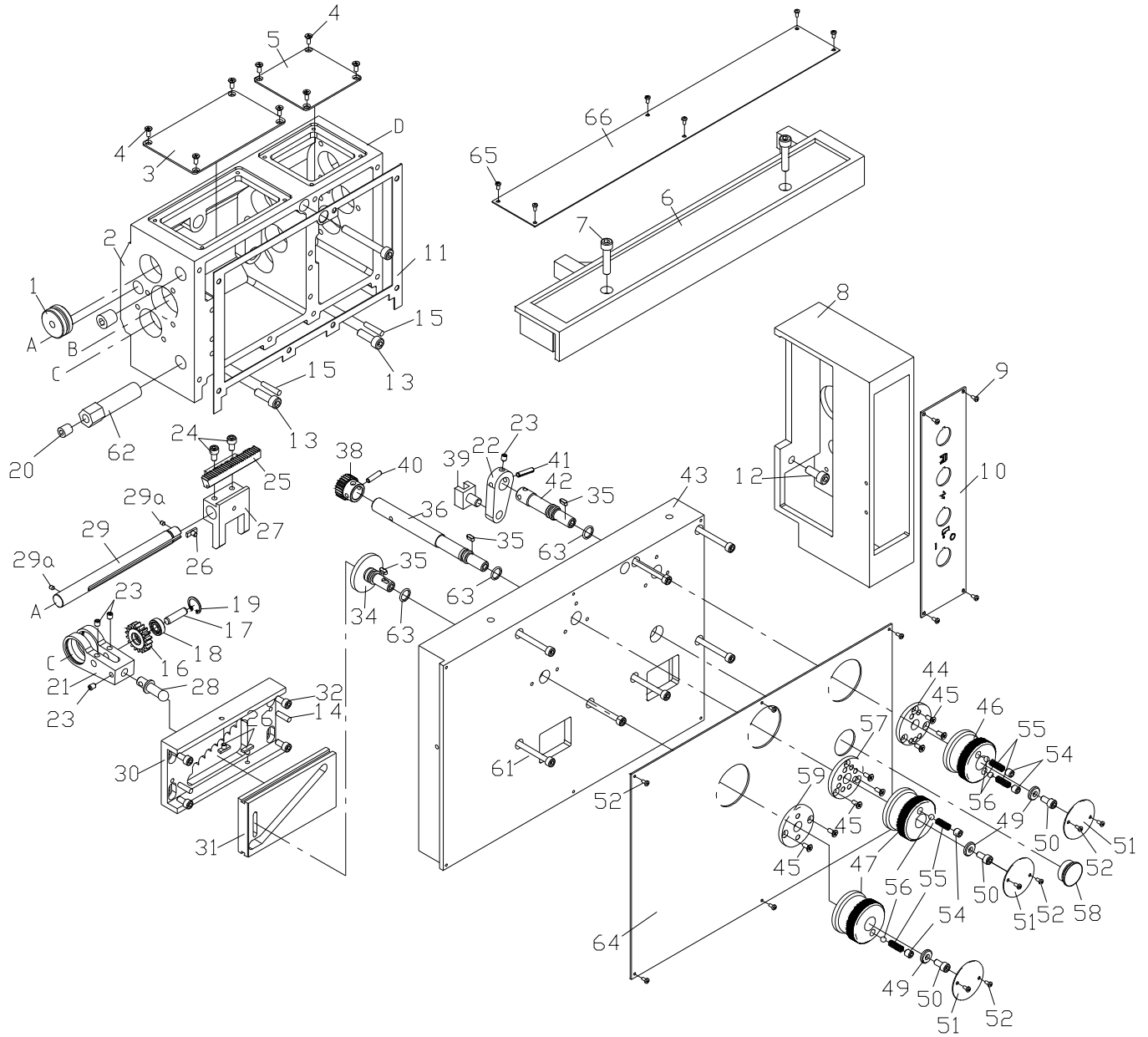


### 14.3.2 Headstock Assembly III – Parts List

Index No.	Part No.	Description	Size	Qty
56	TS-150303	Hex Socket Hd Cap Screw	M6x12	18
61	TS-1504031	Hex Socket Hd Cap Screw	M8x16	3
74	F006050	C-Retaining Ring, Ext	25 mm	6
82	BB-6204	Ball Bearing	6204/p5	5
89	04-53	Bearing Cap		2
90	04-52	Bearing Cap Gasket		2
95	F006055	C-Retaining Ring, Ext	40 mm	1
96	BB-6005	Ball Bearing	6005/p5	4
102	F006082	C-Retaining Ring, Ext	55 mm	1
110	TS-1503041	Hex Socket Hd Cap Screw	M6x16	3
111	GH1440-04-29	Cover		1
112	04-60	Gasket		1
113	TS-1502031	Hex Socket Hd Cap Screw	M5x12	2
114	GH1440-04-31	Nut		1
115	BB-32011	Tapered Roller Bearing	32011/p5	1
116	GH1440-04-30	Gear	38T	1
117	CK6125-02713	Lock Collar		1
118	GH1440-04-21	Gear	59T	1
119	TS-1502051	Hex Socket Hd Cap Screw	M5x20	6
120	GH1440-04-23	Gear	87T	1
121	GH1440-04-25	Collar		1
122	BB-30212	Tapered Roller Bearing	30212/p5	1
123	GH1440-04-32	Gasket		1
124	GH1440-04-28	Cover		1
125	TS-1503061	Hex Socket Hd Cap Screw	M6x25	3
126	5509094	Key, Dbl Rd Hd	6x30 mm	1
127	GHW-H127	Key, Dbl Rd Hd	10x55 mm	1
128	JHM610-22	Hex Socket Hd Cap Screw	M6x14	6
129	04-31/1	Spring		3
130	04-86	Camlock Set Pin		3
131	04-85	Camlock		3
132	GH1440K-02701	Spindle		1
133	F006047	C-Retaining Ring, Ext	20 mm	4
134	04-36	Washer		2
135	04-35	Gear Assembly	32T	1
136	F006083	C-Retaining Ring, Ext	37 mm	1
137	04-54	Gear	32T	1
138	KF2R5516	Key, Dbl Rd Hd	5x16 mm	1
139	04-55	Gear Assembly	32T	1
140	TS-1523041	Socket Set Screw	M6x12	1
141	04-37	Shaft		1
142	GH1440K-342	O-Ring	25x2.65	3
143	GHW-H126	Key	6x30 mm	1
144	GH1440K-02733	Gear	42T	1
145	GH1440K-02111	Collar		2
146	04-44	Gear	32T	1
147	GHB1340-108	Key, Dbl Rd Hd	6x55 mm	1
148	GH1440K-02736	Gear	32T	1
149	BB-6004	Ball Bearing	6004/p5	2
150	GH1440K-02102	Plug		1
151	GH1440K-02732	Shaft		1
152	04-43	Gear	38T	1
153	04-42	Spline Shaft		1
154	04-48	Gasket		1
155	04-49	Cover		1
156	GB9877.1-88	Spacer	SD25x40x7	1
158	GH1440-04-65	Collar		1



### 14.4.1 Gearbox Assembly I – Exploded View

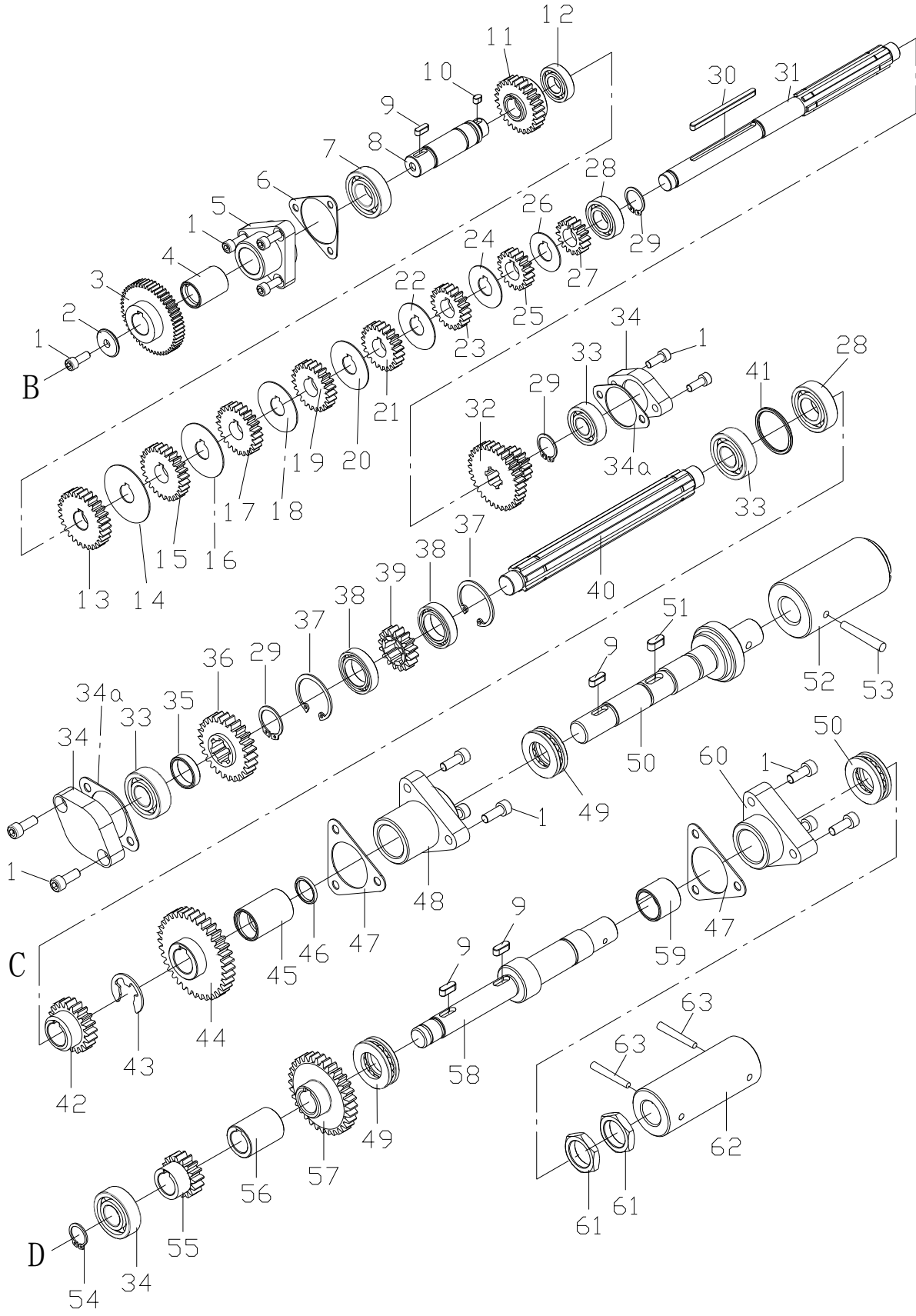


## 14.4.2 Gearbox Assembly I – Parts List

Index No.	Part No.	Description	Size	Qty
1	05-73	Plug		1
2	GH1440K-05101	Gearbox Casting		1
3	05-07	Front Cover		1
4	TS-1512011	Socket Flat Head Screw	M4x10	8
5	GH1440A-05719	Oil Cover		1
6	GH1440K-05501	Cover		1
7	TS-1504071	Hex Socket Hd Cap Screw	M8x35	2
8	GH1440-05-09	Bracket		1
9	GB2672	Screw	M3x6	4
10	GH1440K-18301-2	Electrical Plate		1
11	05-61	Gasket		1
12	TS-1504081	Hex Socket Hd Cap Screw	M8x40	2
13	TS-1504051	Hex Socket Hd Cap Screw	M8x25	3
14	ZX-S75	Taper Pin	5x20 mm	2
15	GH1440K-415	Taper Pin	5x28 mm	2
16	05-50	Gear	18T	1
17	05-51	Shaft	8x30 mm	1
18	GB/T276-94	Bearing	619/8/p5	1
19	F006084	C-Retaining Ring, Int	19 mm	1
20	05-75	Plug		2
21	05-03	Shifter		1
22	GH1440A-5107	Shift Arm		1
23	TS-2276081	Socket Set Screw	M6x8	4
24	TS-1503021	Hex Socket Hd Cap Screw	M6x10	2
25	05-13	Rack		1
26	05-01	Shift Key		3
27	05-12	Shift Fork		1
28	GH1440-0128	Shaft		1
29	05-15	Shaft		1
29a	TS-2276081	Socket Set Screw	M6x8	2
30	05-05	Locating Plate		1
31	05-04	Control Plate		1
32	TS-150303	Hex Socket Hd Cap Screw	M6x12	4
34	GH1440K-05701	Shift Hub		1
35	6293384	Key, Dbl Rd Hd	4x10 mm	3
36	GH1440K-05702	Shaft		1
38	05-14	Gear	26T	1
39	05-55	Shift Fork		1
40	GA7X-122	Spring Pin	5x20 mm	1
41	GHB1340-A82	Spring Pin	5x25 mm	1
42	GH1440K-05703	Shaft		1
43	GH1440K-05102	Cover		1
44	05-58	Locating Disc		1
45	TS-1512011	Socket Flat Hd Screw	M4x10	8
46	GH14440K-05724	Shift Hub		1
47	GH1440-05-13	Shift Hub		2
49	05-08	Washer		3
50	TS-1503041	Hex Socket Hd Cap Screw	M6x16	3
51	GH1440K-05302	Shift Hub Indicator Plate		3
52	TS-1531012	Pan Head Screw	M3x6	6
54	TS-1524011	Socket Set Screw	M8x8	4
55	GH1440K-455	Spring	0.8x5x25 mm	4
56	SB-6.5MM	Steel Ball	6.5 mm	4
57	05-10	Locating Disc		1
58	GH1440-05-27	Oil Sight Glass		1
59	05-59	Locating Disc		1
61	TS-1503111	Hex Socket Hd Cap Screw	M6x50	7
62	GHB1340A-05724	Oil Drain Pipe		1
63	G51-2A	O-Ring		3

<b>Index No.</b>	<b>Part No.</b>	<b>Description</b>	<b>Size</b>	<b>Qty</b>
64	GH1440K-05301-19	Name Plate		1
65	GB2672	Screw	M3x6	6
66	GH1440K-05303	Graphic Plate - Speed Chart		1

14.5.1 Gearbox Assembly II – Exploded View

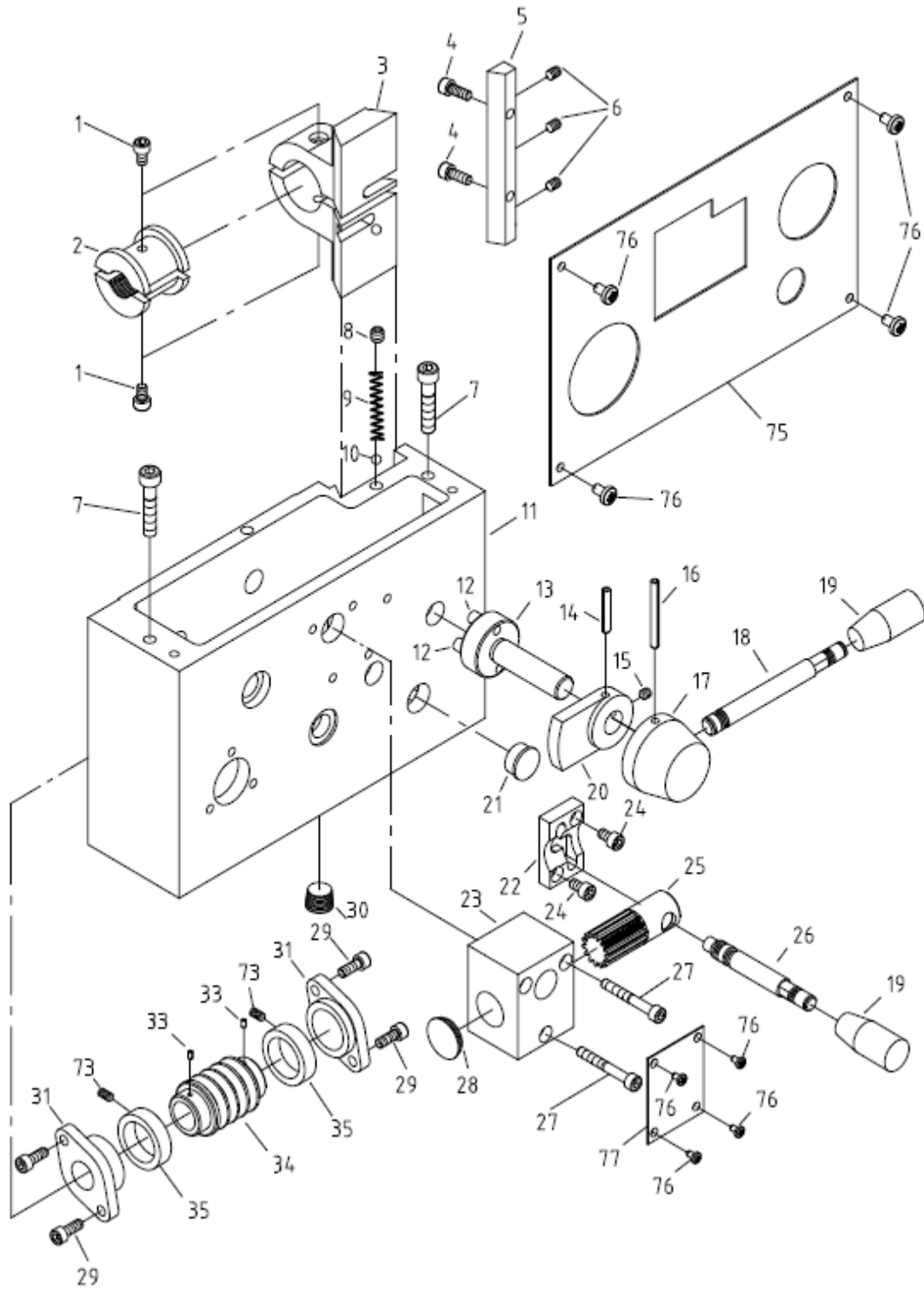


## 14.5.2 Gearbox Assembly II – Parts List

Index No.	Part No.	Description	Size	Qty
1	TS-1503041	Hex Socket Cap Screw	M6x16	1
2	05-42	Washer		1
3	05-41	Gear	52T	1
4	GH1440A-05305	Shaft Collar		1
5	05-39	Flange		1
6	05-38	Gasket		1
7	BB-6004	Ball Bearing	6004/P5	1
8	GH1440A-05725	Shaft (Inch)		1
9	GB1096-5x14	Key, Dbl Rd Hd	5x14 mm	4
10	KF2R5508	Key, Dbl Rd Hd	5x8 mm	1
11	GH1440A-05722	Gear		1
12	GB/T276-94	Ball Bearing	16002/p5	1
13	05-35	Gear	28T	1
14	GH1440K-05719	Key Slot Washer		1
15	GH1440K-05712	Gear	26T	1
16	GH1440K-05718	Key Slot Washer		1
17	GH1440K-05711	Gear	24T	1
18	GH1440K-05717	Key Slot Washer		1
19	GH1440K-05710	Gear	23T	1
20	GH1440K-05716	Key Slot Washer		1
21	GH1440K-05709	Gear	22T	1
22	GH1440K-05715	Key Slot Washer		1
23	GH1440K-05708	Gear	20T	1
24	GH1440K-05714	Key Slot Washer		1
25	GH1440K-05707	Gear	18T	1
26	GH1440K-05713	Key Slot Washer		1
27	GH1440K-05706	Gear	16T	1
28	BB-6003	Ball Bearing	6003/P5	2
29	F006047	C-Retaining Ring, Ext	20 mm	3
30	F014005	Key, Dbl Rd Hd	5x5x75 mm	1
31	GH1440A-05733A	Shaft (Inch)		1
32	GH1440A-05721	Gear	16T/32T	1
33	BB-6202	Ball Bearing	6202/p5	3
34	05-47	Flange		2
34a	05-48	Flange		2
35	GH1440A-05118	Shaft Collar		1
36	05-37	Gear	26T	1
37	F006031	C-Retaining Ring, Int	32 mm	2
38	BB-61804	Ball Bearing	61804/p5	2
39	05-49	Gear	16T	1
40	05-52	Shaft		1
41	GH1440A-05729	Shaft Collar		1
42	05-25	Gear	20T	1
43	PT2748A-032	E-Ring	15 mm	1
44	05-19	Gear	32T	1
45	GH1440A-05306	Shaft Collar		1
46	G51-2A	O-Ring	20X2.4 mm	1
47	05-53	Gasket		2
48	05-17	Flange		1
49	BB-51104	Ball Bearing	51104	2
50	GH1440K-05704	Shaft		1
51	5217851	Key, Dbl Rd Hd	6x6x14 mm	1
52	GH1440K-05727	Collar		1
53	GB117-5x40	Taper Pin	5x40 mm	1
54	F006043	C-Retaining Ring, Ext	15 mm	1
55	05-26	Gear	16T	1
56	05-24	Shaft Collar		1
57	05-22	Gear	32T	1

<b>Index No.</b>	<b>Part No.</b>	<b>Description</b>	<b>Size</b>	<b>Qty</b>
58	GH1440K-05705	Shaft		1
59	GH1440A-05307	Shaft Collar		1
60	05-18	Flange		1
61	05-20	Nut		2
62	GH1440K-05726	Collar		1
63	GB117-4x35	Taper Pin	4x35 mm	2

### 14.6.1 Apron Assembly I – Exploded View

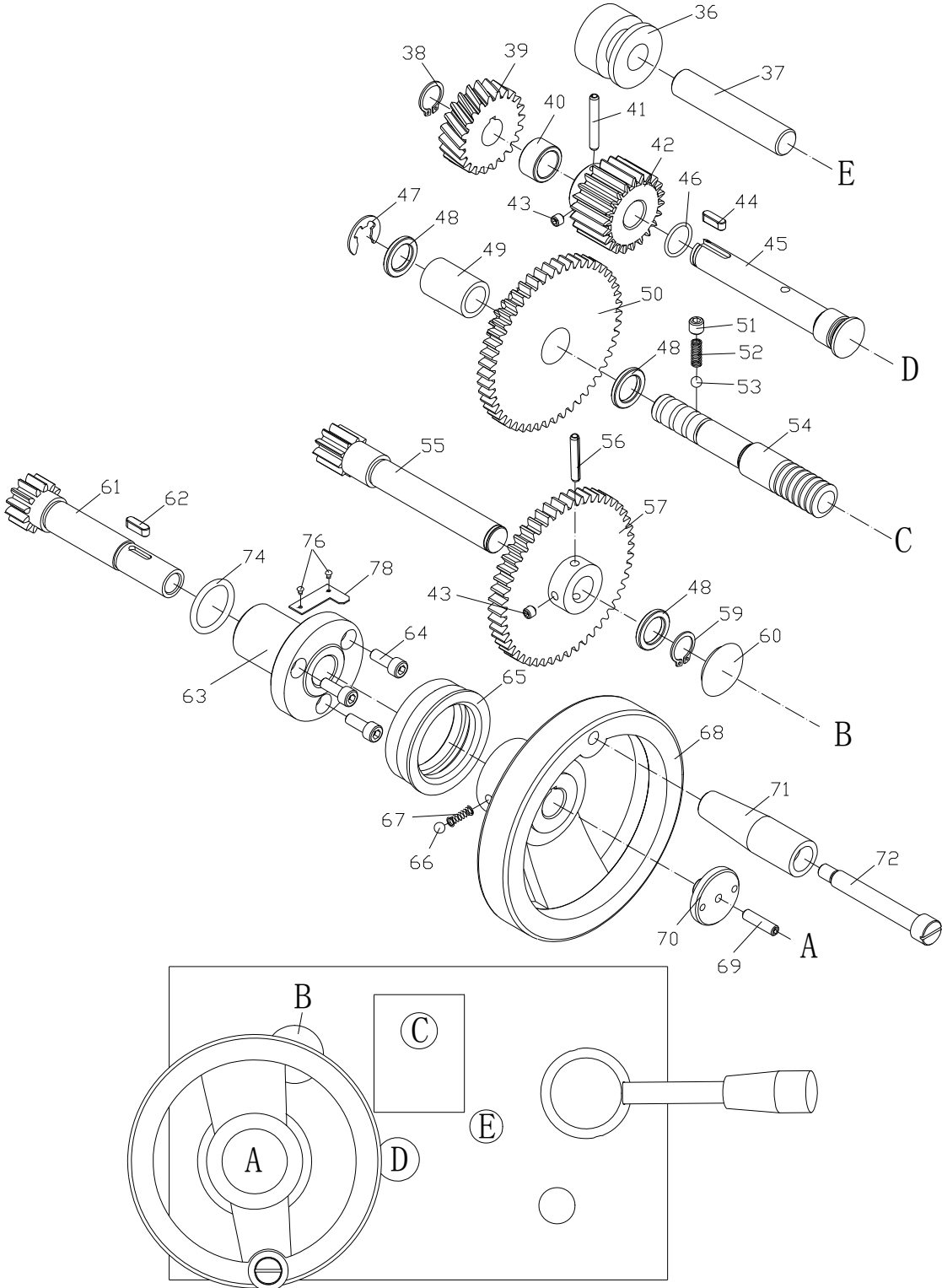


## 14.6.2 Apron Assembly I – Parts List

Index No.	Part No.	Description	Size	Qty
1	TS-1503021	Hex Socket Hd Cap Screw	M6x10	2
2	06-37	Half Nut		1
3	06-36	Bracket		1
4	TS-1503041	Hex Socket Hd Cap Screw	M6x16	2
5	06-33	Gib		1
6	TS-1523031	Socket Set Screw	M6x10	3
7	TS-1504081	Hex Socket Hd Cap Screw	M8x40	2
8	TS-1524011	Socket Set Screw	M8x8	1
9	06-39	Spring		1
10	SB-6MM	Steel Ball	6 mm	1
11	06-01	Apron Casting		1
12	06-42-1	Pin		2
13	06-42	Half Nut Cam		1
14	GB879-5X35	Spring Pin	5x35 mm	1
15	TS-1523011	Socket Set Screw	M6x6	1
16	JRD1000-J39	Spring Pin	5x50 mm	1
17	GH1440-06-09	Hub		1
18	GH1440-06-04	Handle Shaft		1
19	GB4141.14-BM10x50	Knob		2
20	06-40	Safety Catch		1
21	GB1160-12	Sight Glass	12 mm	1
22	06-04	Bracket		1
23	06-16	Block		1
24	TS-1503031	Hex Socket Hd Cap Screw	M6x12	2
25	GH1440-06-07	Spline Shaft		1
26	GH1440-06-08	Handle Shaft		1
27	TS-1503101	Hex Socket Hd Cap Screw	M6x45	3
28	06-02	Plug		1
29	TS-1503041	Hex Socket Hd Cap Screw	M6x16	4
30	06-35	Drain Plug		1
31	06-34	Flange		2
33	GB879-3X5	Spring Pin	3x5 mm	2
34	06-27	Worm		1
35	06-50	Collar		2
73	TS-1522031	Set Screw	M5x10	2
75	GH1440K06301-6	Apron Label		1
76	TS-1531012	Screw	M3x6	8
77	GH1440K06302-2	Graphic Plate - Thread Dial		1



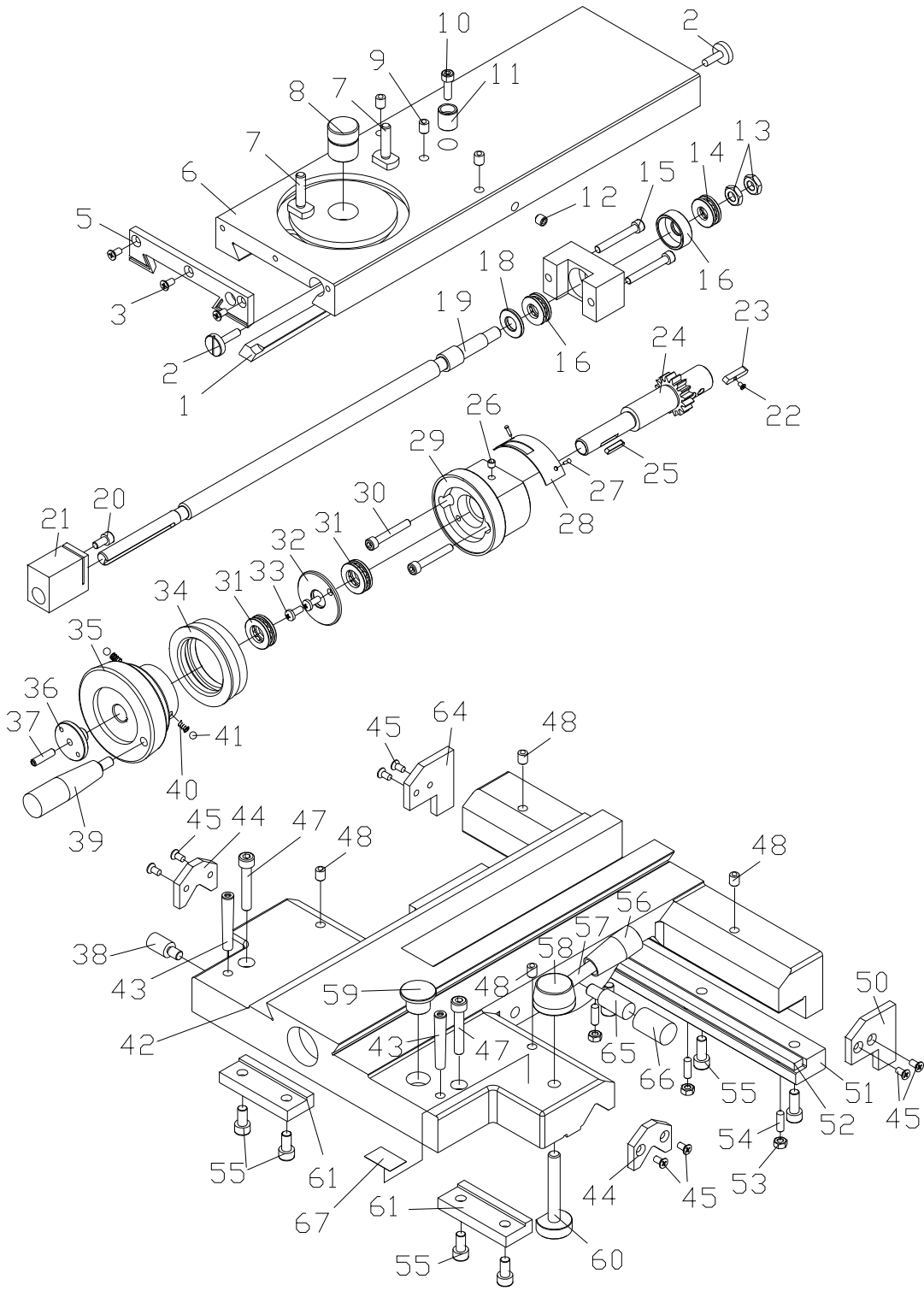
### 14.7.1 Apron Assembly II – Exploded View



## 14.7.2 Apron Assembly II – Parts List

Index No.	Part No.	Description	Size	Qty
36	06-44	Bushing		1
37	06-43	Shaft		1
38	F006044	C-Retaining Ring, Ext	16 mm	1
39	06-28	Gear	22T	1
40	06-26	Collar		1
41	GB879-86	Pin	5x35 mm	1
42	06-20	Gear	24T	1
43	TS-152301	Set Screw	M6x6	1
44	GB1096-79	Key	5x15 mm	1
45	06-19	Shaft		1
46	GB3452.1-82	O-Ring	17x1.8 mm	1
47	6012062	E-Retaining Ring, Ext	12 mm	1
48	06-10	Bushing		2
49	06-15-1	Collar		1
50	06-15	Cluster Gear	50T/20T	1
51	TS-152401	Set Screw	M8x8	1
52	06-14	Spring		1
53	SB-6MM	Steel Ball	6 mm	1
54	06-13	Shaft		1
55	06-06	Shaft		1
56	ZX-S48	Spring Pin	5x30 mm	1
57	06-08	Gear	50T	1
58	06-10	Bushing		1
59	F006044	C-Retaining Ring, Ext	16 mm	1
60	06-11	Plug		1
61	06-07	Shaft		1
62	GB1096-79	Key, Dbl Rd Hd	5x15	1
63	GH1440-06-05	Handwheel Flange		1
64	TS-150304	Hex Socket Hd Cap Screw	M6x16	3
65	06-31	Indicator Ring		1
66	SB-6MM	Steel Ball	6 mm	2
67	06-32	Spring		2
68	GH1440-06-06	Handwheel		1
69	TS-152307	Set Screw	M6x25	1
70	06-30	Wheel Stud		1
71	GH1440-06-11	Handle Sleeve		1
72	GH1440-06-10	Handle Screw		1
74	GH1440K-774	O-Ring	25.8x3.55 mm	1
76	TS-1531012	Screw	M3x6	2
78	GH1440-06304A	Indicator Label		1

14.8.1 Saddle and Cross Slide Assembly – Exploded View

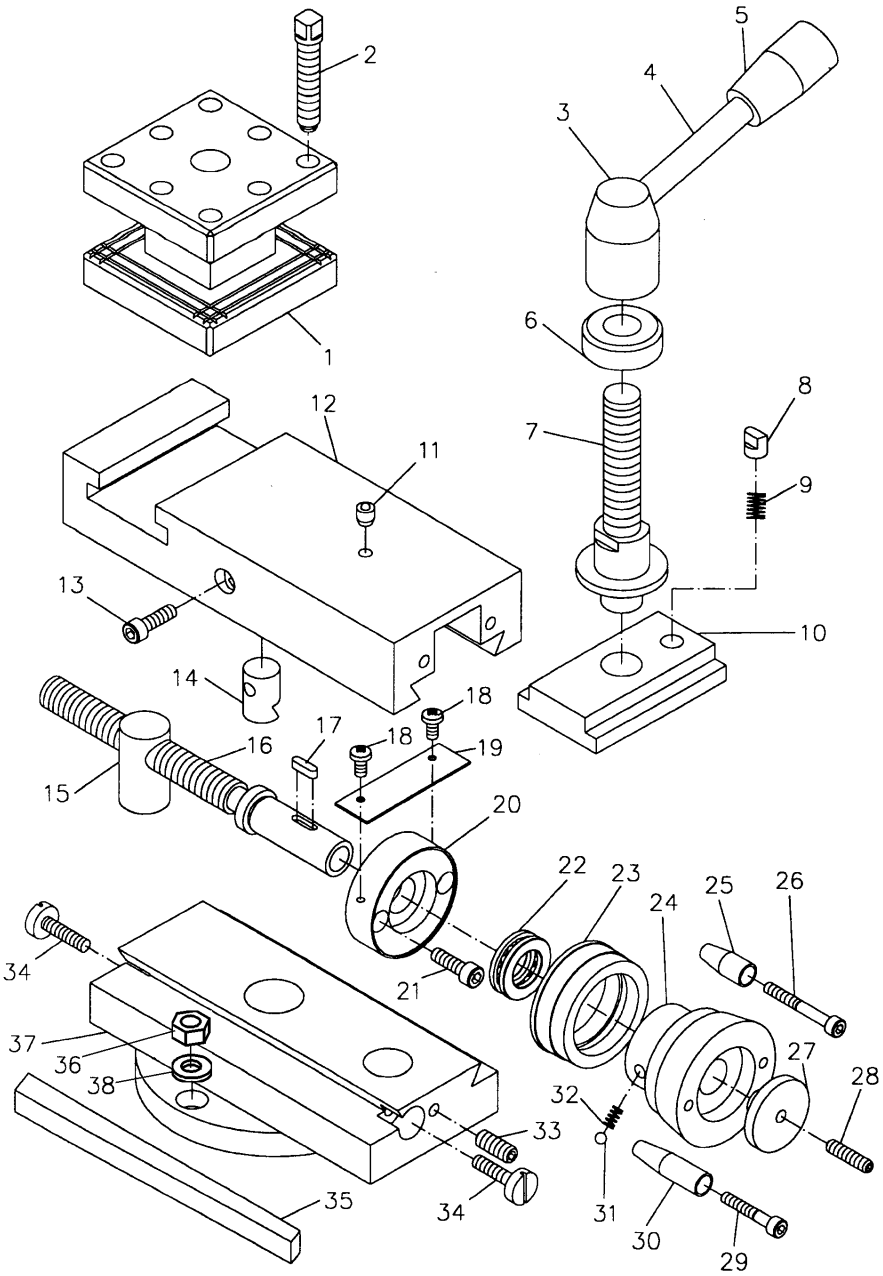


## 14.8.2 Saddle and Cross Slide Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	GH1440K-04702	Gib		1
2	GH1440A-04728	Gib Adjusting Screw		2
3	TS-1533032	Pan Head Machine Screw	M5x10	5
5	GH1440K-04504	Plate Wiper		1
6	GH1440K-04102	Cross Slide Body		1
7	GH1440K-04704	Clamp Nut		2
8	GH1440A-04726	Hub		1
9	GH1440K-809	Ball Oiler	8 mm	3
10	TS-1503051	Hex Socket Hd Cap Screw	M6x20	3
11	GH1440K-04705	Sleeve		1
12	TS-1524011	Socket Set Screw	M8x8	1
13	TS-1540071	Hex Nut	M10	2
14	GH1440A-04701	Bearing Cap		1
15	TS-1503071	Hex Socket Hd Cap Screw	M6x30	2
16	BB-8101	Thrust Bearing	8101	2
17	GH1440A-04103	Block		1
18	GH1440A-04702	Spacer		1
19	GH1440-07-16	Leadscrew		1
20	TS-1503031	Hex Socket Hd Cap Screw	M6x12	1
21	GH1440K-04301	Crossfeed Nut		1
22	GHB1340A-155	Pan Head Machine Screw	M3x5	1
23	KF2R5525	Key, Dbl Rd Hd	5X25 mm	1
24	GH1440K-04703	Gear Shaft		1
25	GB1096-4X20	Key, Dbl Rd Hd	4x20 mm	2
26	GB1155-89	Oiler	6 mm	1
27	TS-1531012	Pan Head Machine Screw	M3x6	2
28	GH1440K-04713	Indicator Plate		1
29	GH1440K-04103	Housing		1
30	TS-1503091	Hex Socket Hd Cap Screw	M6x40	2
31	BB-8102	Thrust Bearing	8102	2
32	GH1440A-04715	Washer, spcl		1
33	TS-1533032	Pan Head Machine Screw	M5x10	2
34	GH1440A-04716A	Index Ring		1
35	GH1440A-04107	Compound Handle		1
36	GH1440A-04717	Cover Screw		2
37	TS-1523071	Socket Set Screw	M6x25	1
39	GH1440A-06719	Handle Sleeve		1
40	GB2089-79	Spring	0.7x5x9 mm	2
41	SB-6MM	Steel Ball	6 mm	2
42	GH1440K-04101	Saddle		1
43	ZX-A41	Taper Pin	6x40 mm	2
44	GH1440K-04503	Plate Wiper		2
45	TS-1533032	Pan Head Machine Screw	M5x10	11
47	TS-1504091	Hex Socket Hd Cap Screw	M8x45	2
48	GH1440K-809	Oiler	8 mm	4
50	GH1440K-04501	Plate Wiper		1
51	GH1440A-04720	Rear Pressure Plate		1
52	GH1440A-04108	Gib		1
53	TS-1540041	Hex Nut	M6	4
54	TS-1523061	Socket Set Screw	M6x20	4
55	TS-1504041	Hex Socket Hd Cap Screw	M8x20	6
56	GB4141.14-10X50	Knob	M10x50	1
57	GH1440A-04733	Handle Shaft		1
58	GH1440A-04730	Hub		1
59	GH1440A-04502	Oil Cap		1
60	GH1440A-04731	Lock Stud		1
61	GH1440A-04719	Front Pressure Plate		2
64	GH1440K-04502	Plate Wiper		1

<b>Index No.</b>	<b>Part No.</b>	<b>Description</b>	<b>Size</b>	<b>Qty</b>
65 .....	GHB1340A-04788....	Pin.....	.....	1
66 .....	GHB1340A-04507....	Sleeve.....	.....	1
67 .....	GH1440K04303 .....	Plate.....	.....	1

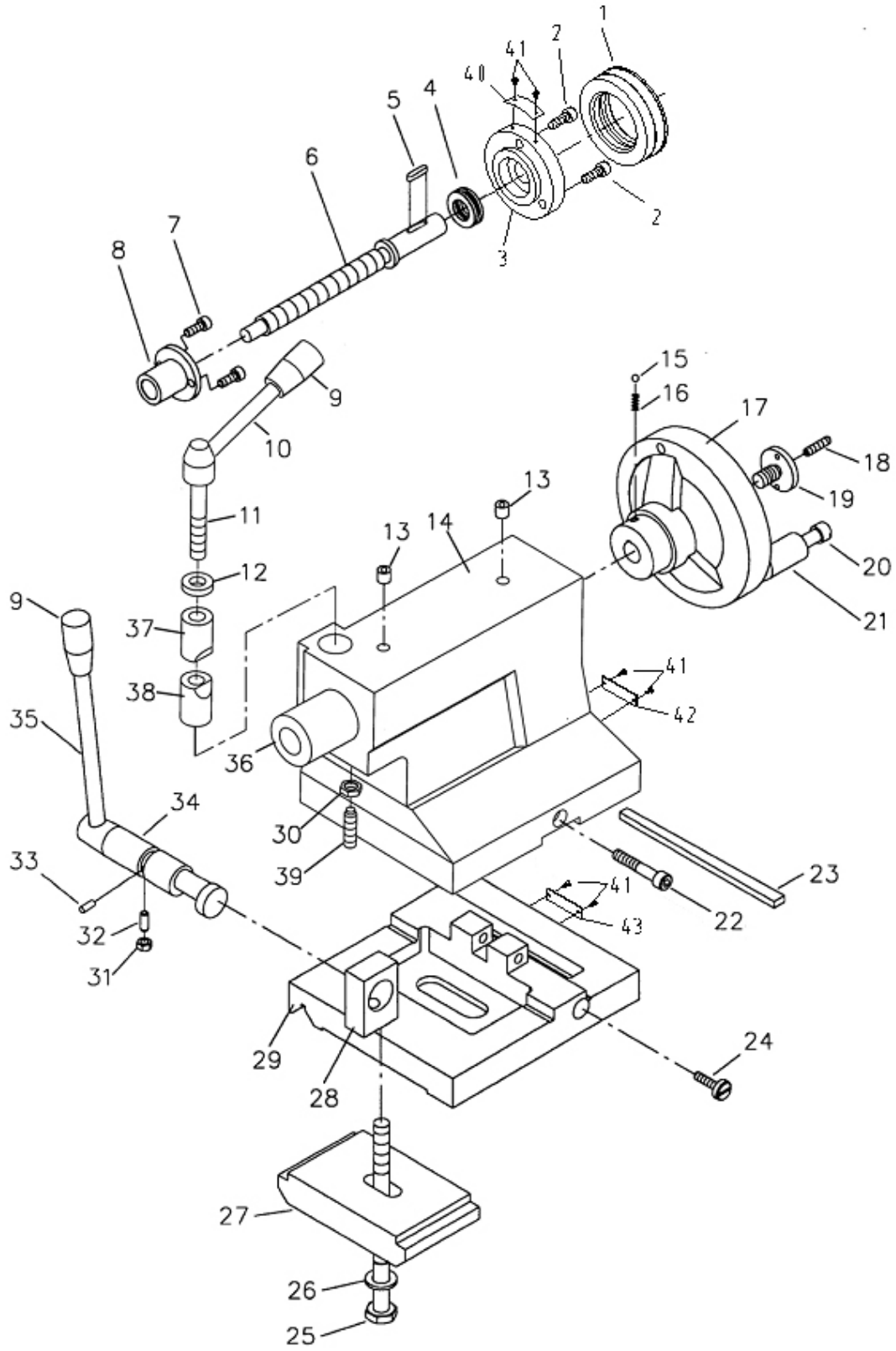
14.9.1 Top Slide and Tool Post – Exploded View



## 14.9.2 Top Slide and Tool Post – Parts List

Index No.	Part No.	Description	Size	Qty
1	GH1440A-04707	Tool Post		1
2	GB83-88	Tool Lock Screw	10x50 mm	8
3	C0632-04704	Handle Hub		1
4	GH1440A-04705	Handle Shaft		1
5	GB4141.14-BM10x50	Knob		1
6	GH1440A-04706	Spacer		1
7	GH1440A-04708	Tool Post Pin		1
8	GH1440A-04709	Tool Post Position Pin		1
9	GB2089-80	Spring	1x8x11 mm	1
10	GH1440A-04725	Clamp Nut		1
11	GH1440K-809	Ball Oiler	8 mm	1
12	GH1440A-04105	Compound Slide		1
13	TS-1503051	Hex Socket Hd Cap Screw	M6x20	1
14	GH1440A-04729	Position Pin		1
15	GH1440A-04302A	Cylindrical Nut		1
16	GH1440A-04724C	Compound Screw		1
17	GB1096-79	Key, Dbl Rd Hd	4x14 mm	1
18	TS-1531012	Screw	M3x6	2
19	GH1440K-04714	Indicator Label		1
20	GH1440A-04110	Screw Bushing		1
21	TS-1503051	Hex Socket Hd Cap Screw	M6x20	2
22	BB-8103	Thrust Bearing	8103	1
23	GH1440A-04723A	Index Ring		1
24	GH1440A-04109	Handwheel		1
25	GH1440A-04722	Handle		1
26	TS-1502061	Hex Socket Hd Cap Screw	M5x25	1
27	GH1440A-04717	Cover Screw		1
28	TS-1523071	Socket Set Screw	M6x25	1
29	TS-1502091	Hex Socket Hd Cap Screw	M5x40	1
30	GH1440A-04721	Handle		1
31	SB-6MM	Steel Ball	6 mm	2
32	GB2089-80	Spring	0.7x5x9 mm	2
33	TS-1523051	Socket Set Screw	M6x16	1
34	GH1440A-04728	Gib Adjusting Screw		2
35	GH1440K-04702	Gib		1
36	TS-1540061	Hex Nut	M8	2
37	GH1440K-04104	Swivel Slide		1
38	TS-1550061	Flat Washer	8 mm	2

### 14.10.1 Tailstock Assembly – Exploded View

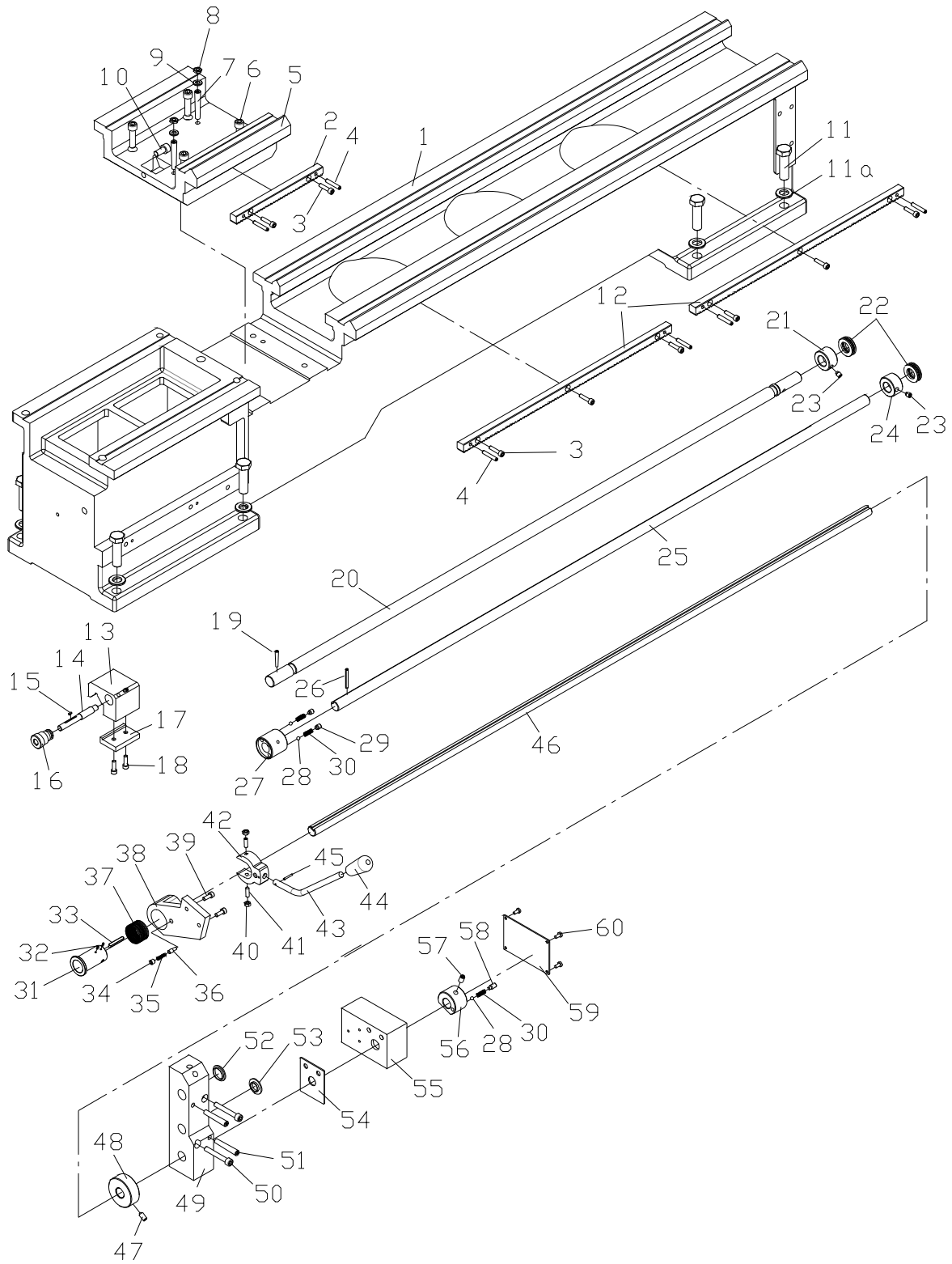




## 14.10.2 Tailstock Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	GH1440A-03703A	Index Ring		1
2	TS-1503051	Hex Socket Hd Cap Screw	M6x20	3
3	GH1440K-03102	Hub		1
4	BB-8103	Thrust Bearing	8103	1
5	KF2R4420	Key, Dbl Rd Hd	4x20 mm	1
6	GH1440K-03702	Leadscrew		1
7	TS-1503041	Hex Socket Hd Cap Screw	M6x16	2
8	GH1440K-03301	Flange		1
9	GB4141. 14	Knob	BM10x50	2
10	GH1440K-03705	Lever Handle		1
11	GH1440K-03704	Lever Support		1
12	GH1440K-03703	Washer		1
13	GB1155-89	Ball Oiler	10 mm	2
14	GH1440K-03101	Tailstock Body		1
15	SB-6MM	Steel Ball	6 mm	2
16	GB2089-80	Spring	0.8x5x8	2
17	GH1440A-06108	Handwheel		1
18	TS-1523081	Socket Set Screw	M6x30	1
19	GH1440A-06721	Cover Screw		1
20	GH1440A-06720	Handle Lever		1
21	GH1440A-06719	Handle Sleeve		1
22	TS-1504131	Hex Socket Hd Cap Screw	M8x70	2
23	GH1440K-03711	Gib		1
24	GH1440K-03712	Gib Adjusting Screw		2
25	TS-1492071	Hex Cap Bolt	M12x70	1
26	TS-155008	Washer	12 mm	1
27	GH1440K-03103	Tailstock Clamp Plate		1
28	GH1440A-03710	Block		1
29	GH1440K-03104	Tailstock Base		1
30	F012319	Hex Jam Nut	M10	1
31	F012316	Hex Jam Nut	M6	1
32	F010438	Socket Set Screw DP	M6x16	1
33	GB879-86	Pin	5x10 mm	1
34	GH1440K-03710	Eccentric Shaft		1
35	GH1440K-03709	Lever Handle		1
36	GH1440K-03701	Quill		1
37	GH1440K-03707	Clamping Block		1
38	GH1440K-03708	Clamping Block		1
39	F010446	Socket Set Screw DP	M10x40	1
40	GH1440K-03714	Indicator Label		1
41	TS-1531012	Screw	M3x6	6
42	GH1440K-03302	Indicator Label		1
43	GH1440K-03303	Indicator Label		1

### 14.11.1 Bed and Shaft Assembly – Exploded View

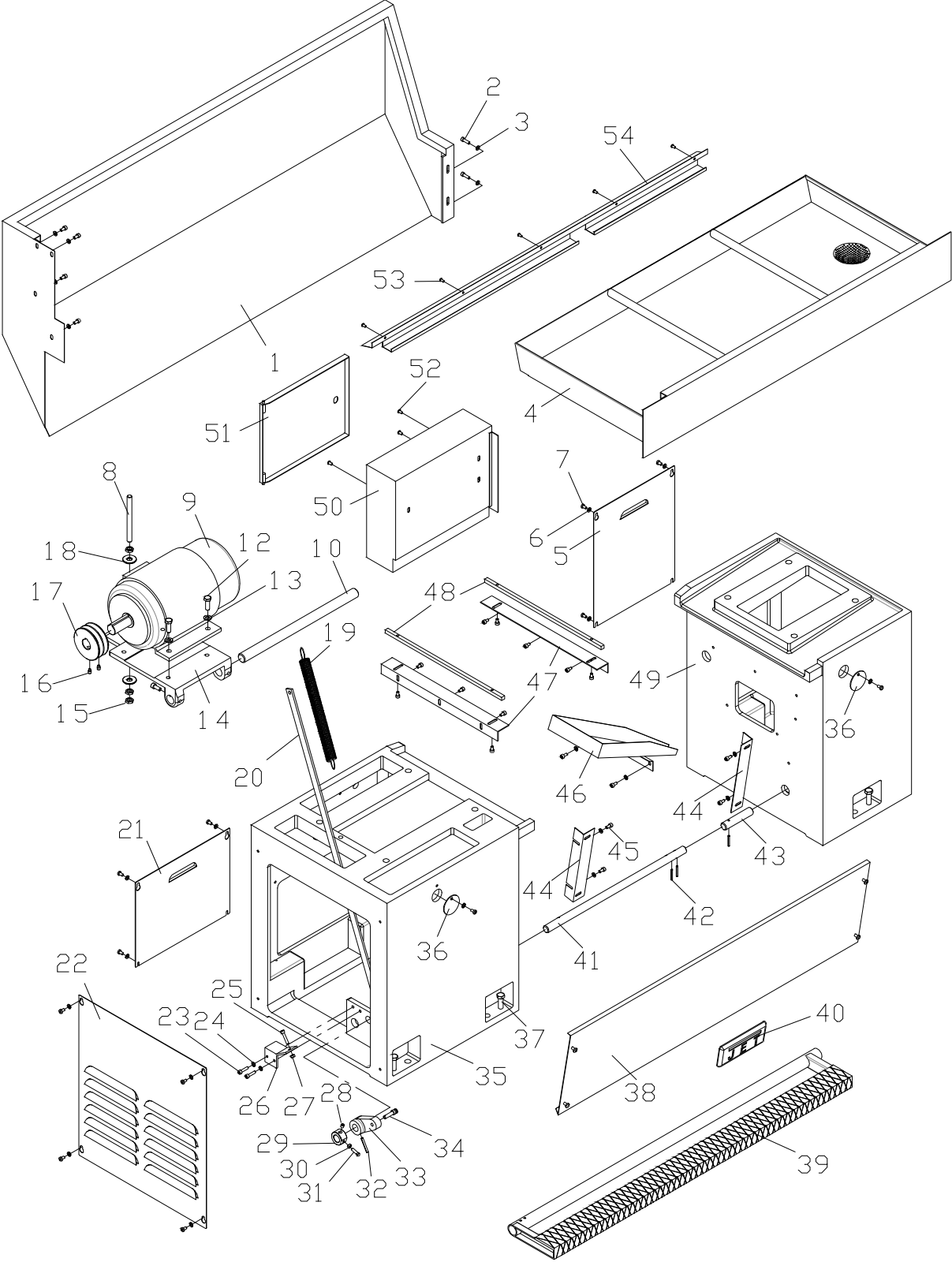


## 14.11.2 Bed and Shaft Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	GH1440K-01101	Bed		1
2	GH1440A-01704	Rack (short)		1
3	TS-150306	Hex Socket Cap Screw	M6x25	8
4	ESR1650-81	Spring Pin	6x35 mm	6
5	GH1440K-01102	Gap Bridge		1
6	TS-1505061	Hex Socket Cap Screw	M10x40	4
7	GH1440K-1109	Taper Pin, Ext. Thread	8x60 mm	2
8	TS-1540061	Hex Nut	M8	2
9	TS-1550061	Flat Washer	M8	2
10	TS-1505021	Hex Socket Cap Screw	M10x20	1
11	CL1640ZX-0204	Hex Cap Bolt	M16x55	8
11a	TS-155010	Flat Washer	M16	8
12	GH1440A-01705	Rack (long)		2
13	GH1440K-01705	Micro Adjust Bracket		1
	GH1440K-MA	Micro Adjust Assembly (#13 thru 18)		1
14	GH1440A-01716	Shaft		1
15	JAT741-21	Spring Pin	3x6 mm	1
16	GH1440A-01717	Index Ring		1
17	GH1440A-01108	Plate		1
18	TS-1503051	Hex Socket Cap Screw	M6x20	2
19	GHB1330-12B	Taper Pin	5x35 mm	1
20	GH1440A-01712/1000	Lead Screw		1
21	GH1440A-01718	Collar		1
22	BB-51104	Bearing	51104	2
23	TS-1524021	Socket Set Screw	M8x10	2
24	GH1440A-01718	Collar		1
25	GH1440K-01701	Control Rod		1
26	ZX-S41	Spring Pin	5x40 mm	1
27	GH1440A-01706	Clutch		1
28	SB-6MM	Steel Ball	6 mm	3
29	TS-152402	Socket Set Screw	M8x10	2
30	01-38	Spring	1.2×6×28 mm	2
31	GH1440A-01711	Sleeve		1
32	SP-36	Spring Pin	3x6 mm	2
33	F014006	Key, Dbl Rd Hd	5x36 mm	1
34	TS-1524011	Socket Set Screw	M8x8	1
35	GB2089-80	Spring	0.8x5x25 mm	1
36	GH1440A-01711	Key		1
37	GB2089-80	Spring	3x35x70 mm	1
38	GH1440A-01105	Control Bracket		1
39	TS-1503041	Hex Socket Cap Screw	M6x16	2
40	TS-1540041	Hex Nut	M6	2
41	TS-1523061	Socket Set Screw	M6x20	2
42	GH1440A-01106	Control Fork		1
43	GH1440A-01715	Control Handle		1
44	GB4141.14	Knob	BM10x50	1
45	6295576	Spring Pin	3x20 mm	1
46	GH1440K-01701A	Control Rod		1
47	TS-1523031	Socket Set Screw	M6x10	1
48	GH1440A-01709	Collar		1
49	GH1440K-01108	End Bracket		1
50	TS-1504111	Hex Socket Cap Screw	M8x55	2
51	GH1440K-151	Taper Pin, Int Thread	8x55 mm	2
52	C0632-01502	Plug		1
53	C0632-01503	Plug		1
54	C0632A-01505	Gasket		1
55	C0632A-01301	Shaft Box		1
56	GH1440A-01708	Shift Collar		1
57	TS-1523051	Socket Set Screw	M6x16	1

<b>Index No.</b>	<b>Part No.</b>	<b>Description</b>	<b>Size</b>	<b>Qty</b>
58	F010448	Socket Set Screw DP	M8x16	1
59	C0632A-01504	Shaft Box Cover		1
60	TS-1502021	Socket Head Cap Screw	M5x10	4

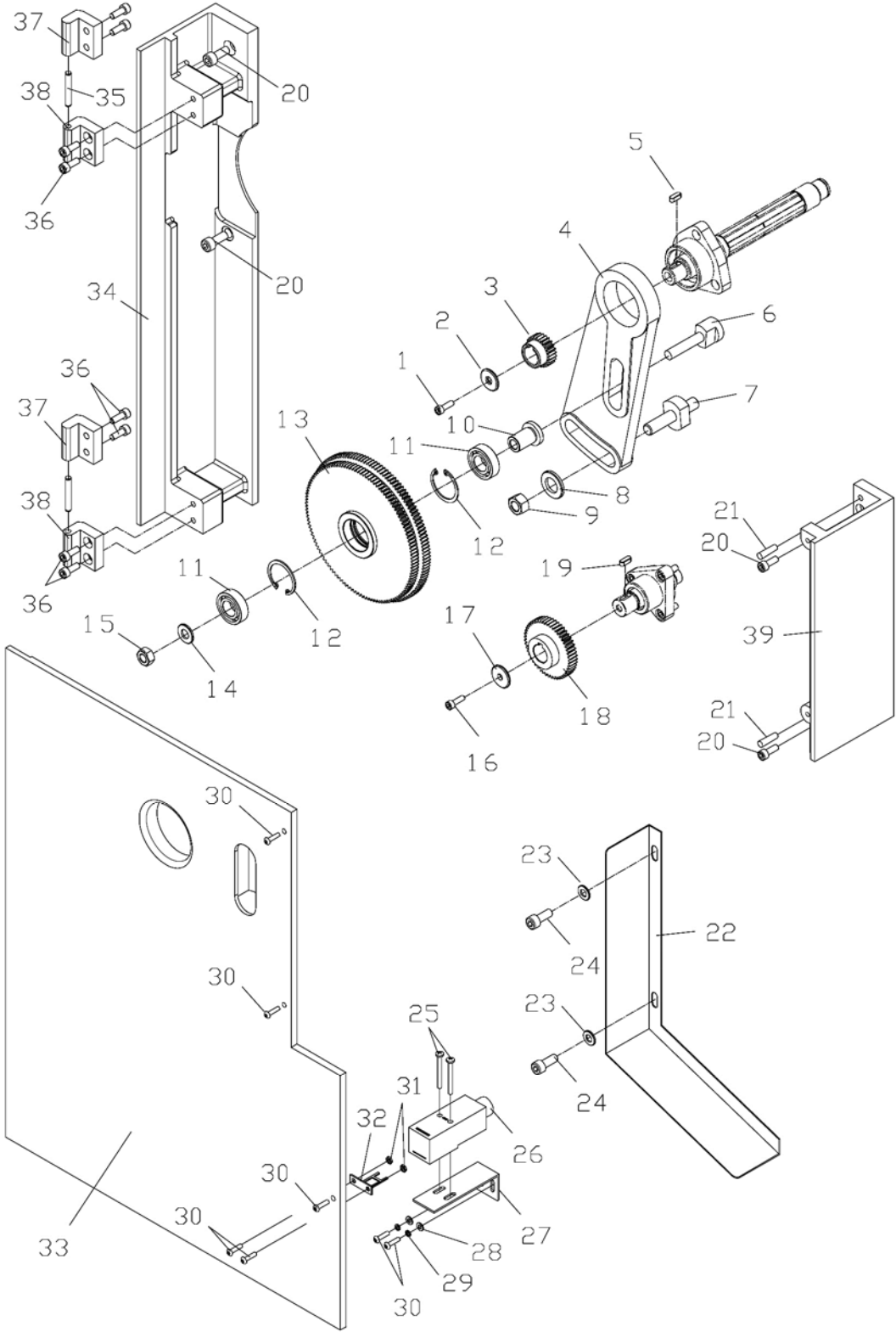
14.12.1 Stand and Brake Assembly – Exploded View



## 14.12.2 Stand and Brake Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	GH1440K-01-707A	Splash Guard	M6x10	1
2	TS-1503021	Hex Socket Hd Cap Screw	M6x10	2
3	TS-1550041	Flat Washer	6 mm	2
4	GH1440K-01705	Chip Tray		1
5	GH1440K-01710	Cover		1
6	TS-1550041	Flat Washer	6 mm	27
7	TS-1534032	Phillips Pan Hd Machine Screw	M6x10	19
8	GH1440A-1730	Screw	M6x10	1
9	GH1440-M1-1	Main Motor (1 Phase)		1
	GH1440-M1-1SC	Start Capacitor	400µF 350V	1
	GH1440-M1-1RC	Run Capacitor	40µF 450V	1
	GH1440-M1-3	Main Motor (3 Phase)		1
10	GH1440K-01704	Shaft	M6x10	1
12	TS-1491041	Hex Cap Bolt	M10x30	4
13	TS-1550071	Flat Washer	10 mm	4
14	GH1440K-01107	Motor Mounting Bracket		1
	TS-1524011	Set Screw	M8x8	3
15	TS-1540081	Hex Nut	M12	3
16	TS-1524031	Socket Set Screw	M8x12	1
17	GH1440K-01106	Pulley		1
18	GH1440A-01731	Washer	12 mm	2
19	11-04	Spring	3.5x25x270	1
20	GH1440K-22702	Connector Bar		1
21	GH1440K01709	Cover		1
22	GH1440K-01708	Cover		1
23	TS-1503061	Hex Socket Hd Cap Screw	M6x25	2
24	TS-1550041	Flat Washer	6 mm	2
25	TS-1503071	Hex Socket Hd Cap Screw	M6x30	1
26	GH1440K-22703	Angle Steel	M12	1
27	TS-2311061	Hex Nut	M6	1
28	TS-1524021	Socket Set Screw	M8x10	1
29	GH1440A-22705	Link Nut		1
30	TS-2311061	Hex Nut	M6	1
31	GH1440A-22713	Screw		1
32	ESR1650-18	Spring Pin	5x40mm	1
33	GH1440A-22101	Link		1
34	GH1440A-22704	Shaft Pin		1
	F003804	Cotter Pin	1/16 x 3/4	1
35	GH1440K-01103	Pedestal (left)		1
36	GH1440A-01723	Round Cover		4
37	TS-1492051	Hex Cap Bolt	M12x50	1
38	GH1440K-01706	Front Plate		1
39	GH1440K-01701	Brake Pedal		1
40	JET-165	JET Logo	165x68mm	1
41	C0632A-22704	Shaft		1
42	2210-108	Spring Pin	M5x30	3
43	GH1440A-22707	Shaft		1
44	GH1440K-01714	Bracket		2
45	TS-1503021	Hex Socket Hd Cap Screw	M6x10	16
46	GH1440K-01713	Tray		1
47	GH1440K-01712	Bracket		2
48	GH1440K-01711	Guide		2
49	GH1440K-01104	Pedestal (right)		1
50	GH1440K-18701	Electric Cabinet		1
51	GH1440K-18702	Electric Cabinet Door		1
52	TS-1503021	Hex Socket Hd Cap Screw	M6x10	3
53	TS-1502021	Hex Socket Hd Cap Screw	M5x10	5
54	GH1440K-18717	Support		1

14.13.1 End Gear Assembly – Exploded View

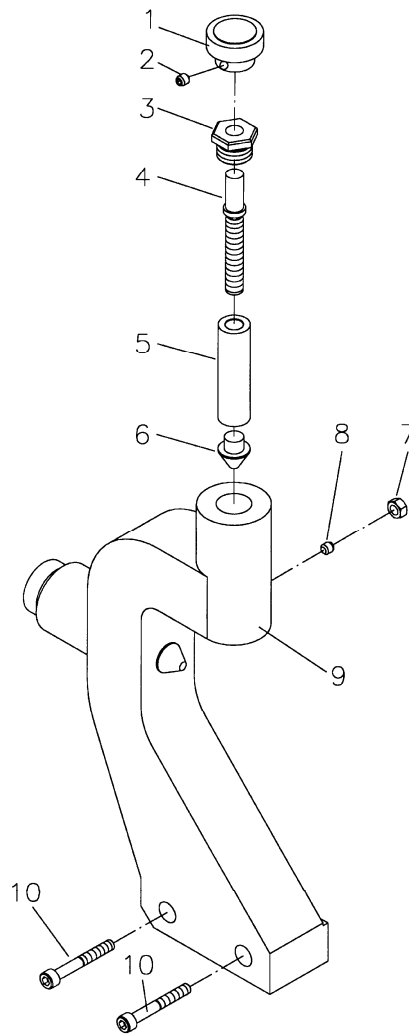


### 14.13.2 End Gear Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	TS-1502041	Hex Socket Hd Cap Screw	M5x16	1
2	GH1440K-1304	Washer, spcl	6 mm	1
3	04-50	Gear	25T	1
4	GH1440K-05104	Quadrant (inch)		1
5	GB1096-5X14	Key, Dbl Rd Hd	5x14 mm	1
6	05-43	Threaded Shaft		1
7	GH1440K-05720	Stud		1
8	TS-2360121	Flat Washer	12 mm	1
9	TS-1540081	Hex Nut	M12	1
10	05-45	Collar		1
11	BB-6103	Ball Bearing	6103	2
12	F006033	C-Retaining Ring, Int	35 mm	2
13	05-65	Gear	120/127	1
14	05-44	Flat Washer		1
15	TS-1540071	Hex Nut	M10	1
16	TS-1503041	Hex Socket Hd Cap Screw	M6x16	1
17	05-42	Washer	6mm	1
18	05-41	Gear	50T	1
19	GB1096-5X14	Key, Dbl Rd Hd	5x14 mm	1
20	TS-1504041	Hex Socket Hd Cap Screw	M8x20	4
21	ZX-H218	Pin	6x25 mm	2
22	GH1440K-05722	Bracket		1
23	TS-1550061	Flat Washer	8mm	2
24	TS-1504041	Hex Socket Hd Cap Screw	M8x20	2
25	PS1652T-105	Phillips Pan Hd Machine Screw	M4x40	2
26	QKS8-1	Door Switch		1
	ZH-SQ1	Door Switch Assembly (includes #26, 32)		1
27	C0632A-18704	Bracket		1
28	TS-1550021	Flat Washer	4 mm	2
29	TS-1551021	Spring Washer	4 mm	2
30	TS-1501051	Hex Socket Hd Cap Screw	M4x16	7
31	TS-1540021	Hex Nut	M4	2
32	QKS8-2	Door Switch		1
33	GH1440K-05502	Back Cover		1
34	GH1440K-05105	Rear side plate		1
35	ZX-H223	Dowel Pin	6h8x40	2
36	TS-1503041	Hex Socket Cap Screw	M6x16	8
37	1440R-08712	Upper Hinge		2
38	1440R-08711	Lower Hinge		2
39	GH1440K-05106	Front Plate		1



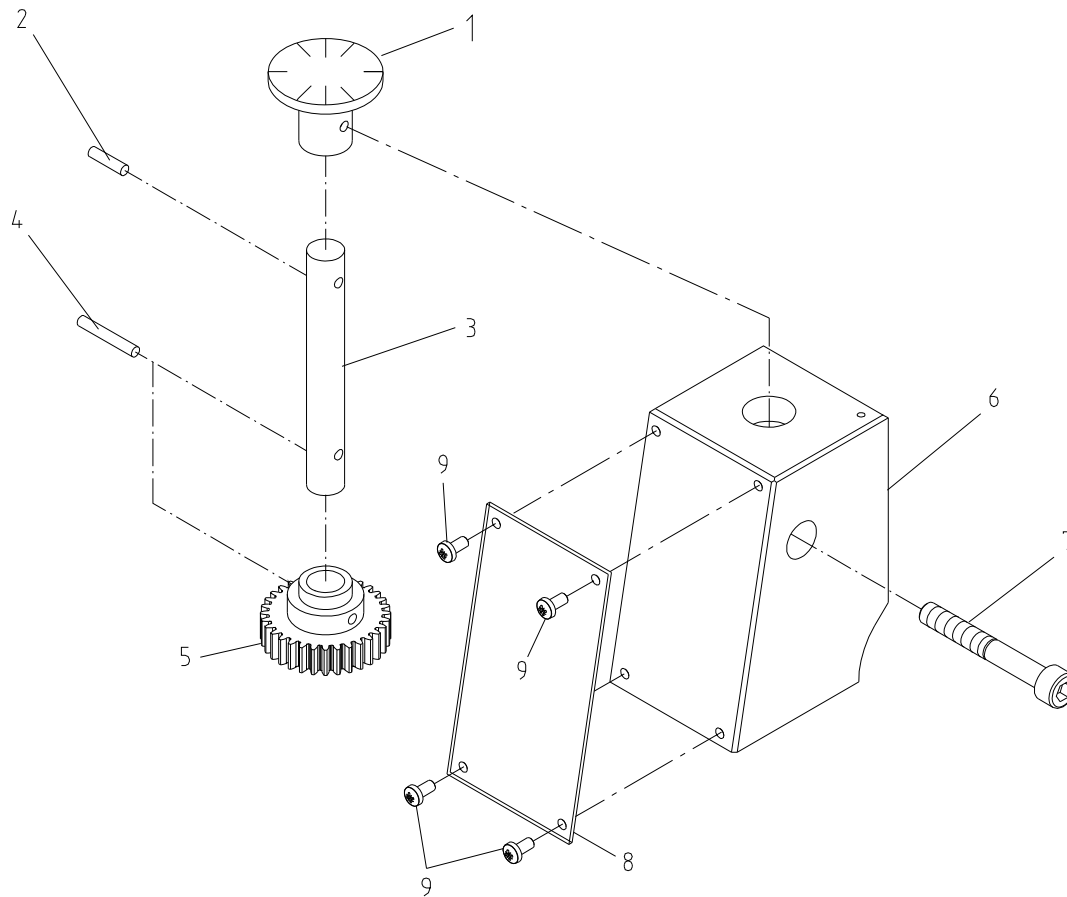
### 14.14.1 Follow Rest – Exploded View



### 14.14.2 Follow Rest – Parts List

Index No.	Part No.	Description	Size	Qty
	GH1440K-FRA	Follow Rest Assembly (#1 thru 10)		
1	GH1440-09-02	Knob		2
2	TS-1523011	Socket Set Screw	M6x6	2
3	10B-04	Bushing		2
4	10B-05	Screw		2
5	10B-02	Sleeve		2
6	10B-06	Brass Finger		1
7	TS-2311061	Hex Nut	M6	2
8	TS-1523011	Socket Set Screw	M6x6	2
9	GH1440-09-01	Follow Rest Body		1
10	TS-1503101	Hex Socket Hd Cap Screw	M6x45	2

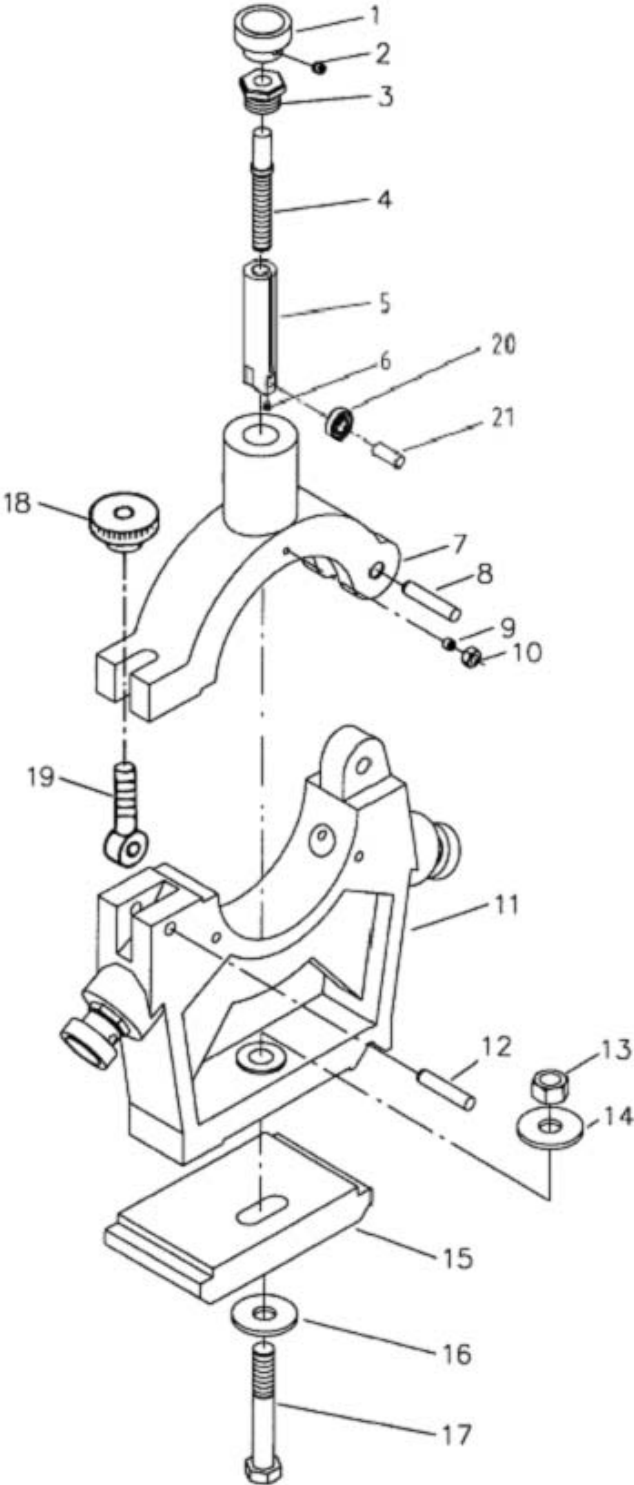
### 14.15.1 Thread Dial Assembly – Exploded View



### 14.15.2 Thread Dial Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
.....	GH1440K-TDA	Thread Dial Assembly (includes #1 thru 9)	.....	.....
1	06-22	Dial	.....	1
2	GB879-3x12	Spring Pin	3x12	1
3	06-23	Shaft	.....	1
4	GB879-3x20	Spring Pin	3x20	1
5	06-25	Gear	32T	1
6	06-24	Body	.....	1
7	TS-1503101	Hex Socket Hd Cap Screw	M6x45	1
8	GH1440K-11305-1	Graphic Plate – Thread Dial	.....	1
9	TS-1531012	Screw	M3x6	4

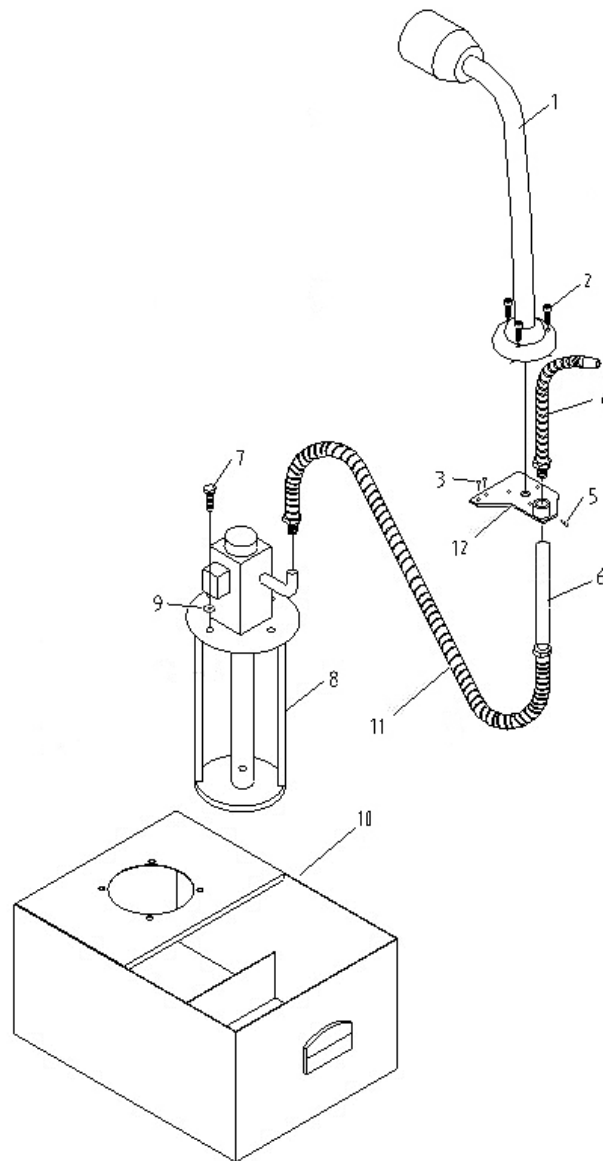
14.16.1 Steady Rest – Parts List



## 14.16.2 Steady Rest – Parts List

Index No.	Part No.	Description	Size	Qty
	GH1440K-SRA	Steady Rest Assembly (#1 thru 21)		1
1	GH1440-09-02	Knob		3
2	TS-1523011	Socket Set Screw	M6x6	3
3	10A-05	Bushing		3
4	10A-06	Screw		3
5	GH1440K-10704	Sleeve		3
6	10A-08	Brass Finger		3
7	10A-03	Steady Rest Upper Body		1
8	F004047	Dowel Pin	8x40 mm	1
9	TS-1523061	Socket Set Screw	M6x20	3
10	TS-1540041	Hex Nut	M6	3
11	GH1440-10-01	Steady Rest Lower Body		1
12	10A-02	Lock Pin		1
13	TS-1540081	Hex Nut	M12	1
14	TS-1550081	Washer	12 mm	1
15	GH1440-10-02	Clamp Plate		1
16	TS-1550081	Flat Washer	12 mm	1
17	TS-1492081	Hex Cap Bolt	M12x80	1
18	GH1440K-1618	Knurled Thumb Knob		1
19	GH1440K-1619	Pivot Stud		1
20	BB-606	Ball Bearing	606	3
21	ZX-Q49	Dowel Pin	6x18 mm	1

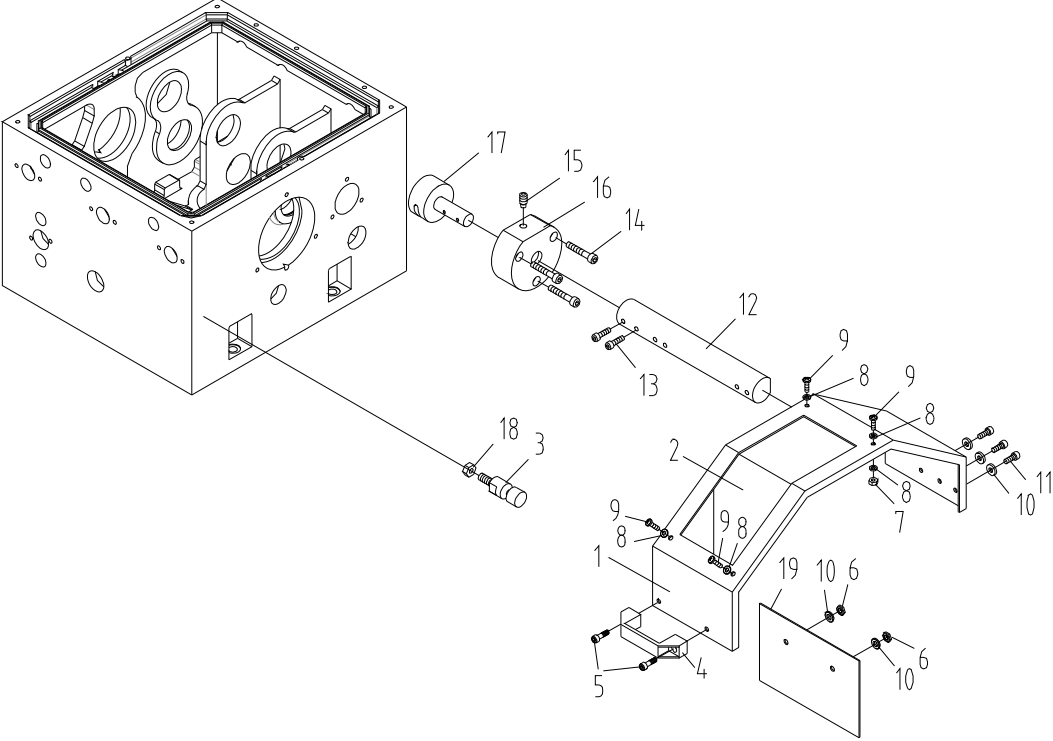
### 14.17.1 Coolant and Work Light Assembly – Exploded View



### 14.17.2 Coolant and Work Light Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	GHB1340-EL	Work Light		1
2	TS-1503051	Hex Socket Hd Cap Screw	M6x20	3
3	TS-1502051	Hex Socket Hd Cap Screw	M5x20	3
4	GH1440K-1704	Coolant Nozzle	C2-77	3
5	TS-1503041	Hex Socket Hd Cap Screw	M6x16	1
6	GHB1440A01739	Rubber Tube		1
7	TS-1482011	Hex Cap Bolt	M6x10	4
8	YSB-12TH	Coolant Pump	3PH	1
	YDB-12TH	Coolant Pump	1PH	1
9	TS-1550041	Flat Washer	6 mm	4
10	GH1440K01715	Coolant Tank		1
11	GH1440K1711	Tube	600 mm	1
12	GH1440K18711	Support		1

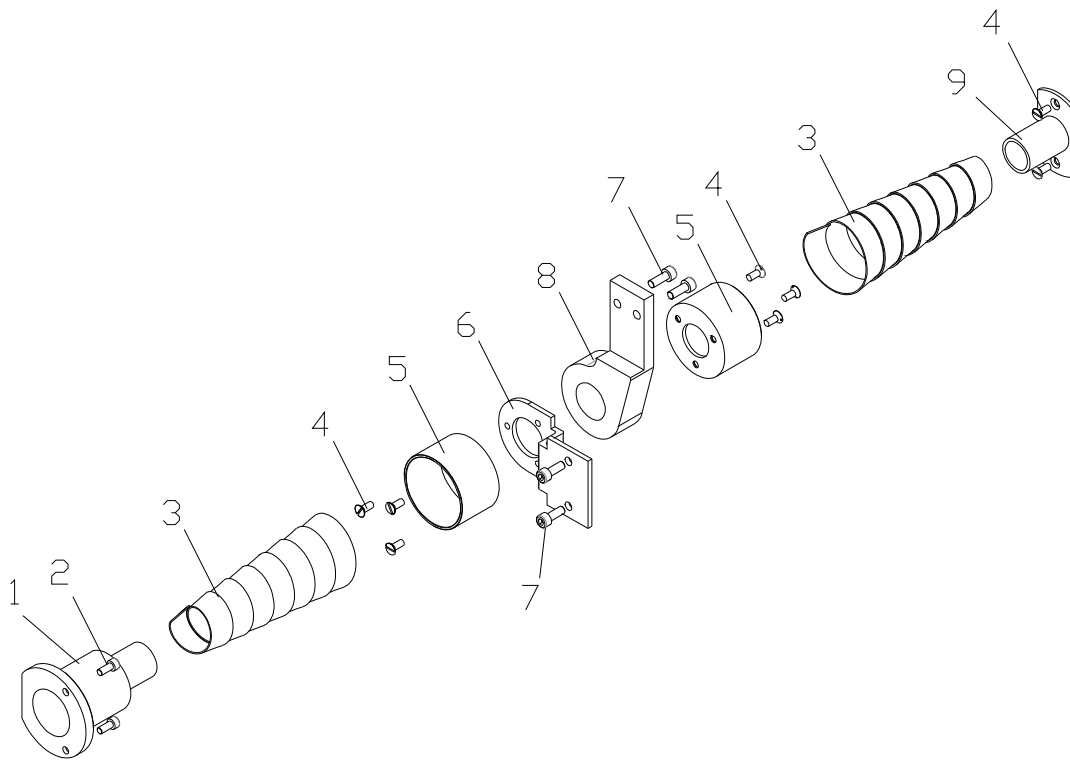
**14.18.1 Chuck Guard Assembly – Exploded View**



**14.18.2 Chuck Guard Assembly – Parts List**

Index No.	Part No.	Description	Size	Qty
.....	GH1440K-CGA.....	Chuck Guard Assembly (#1 thru 19).....		1
1	GH1440K-19701J.....	Chuck Guard.....		1
2	GHB1340A-19501E...	Guard Acrylic Window .....		1
3	ZX-19704E.....	Fixing Rod.....		1
4	A90.....	Handle .....		1
5	TS-1503031 .....	Hex Socket Hd Cap Screw.....	M6x12.....	2
6	TS-1540041 .....	Hex Nut .....	M6.....	2
7	TS-1540021 .....	Hex Nut.....	M4.....	4
8	TS-1550021 .....	Plain Washer.....	4 mm .....	8
9	TS-1532042 .....	Cross Recessed Pan Head Screw .....	M4x12.....	4
10	TS-1550041 .....	Plain Washer.....	6 mm .....	3
11	TS-1534032 .....	Cross Recessed Pan Head Screw .....	M6x10.....	3
12	GH1440K-19702J.....	Rest Bar .....		1
13	TS-1524021 .....	Hex Socket Set Screw .....	M8x10.....	2
14	TS-1503071 .....	Hex Socket Hd Cap Screw.....	M6x30.....	3
15	TS-1524041 .....	Hex Socket Set Screw .....	M8x16.....	1
16	GHB1340A19704 .....	Switch Box .....		1
17	GHB1340A19702E....	Shaft .....		1
18	TS-1540061 .....	Hex Nut.....	M8.....	1
19	GH1440K-19703J .....	Panel.....		1

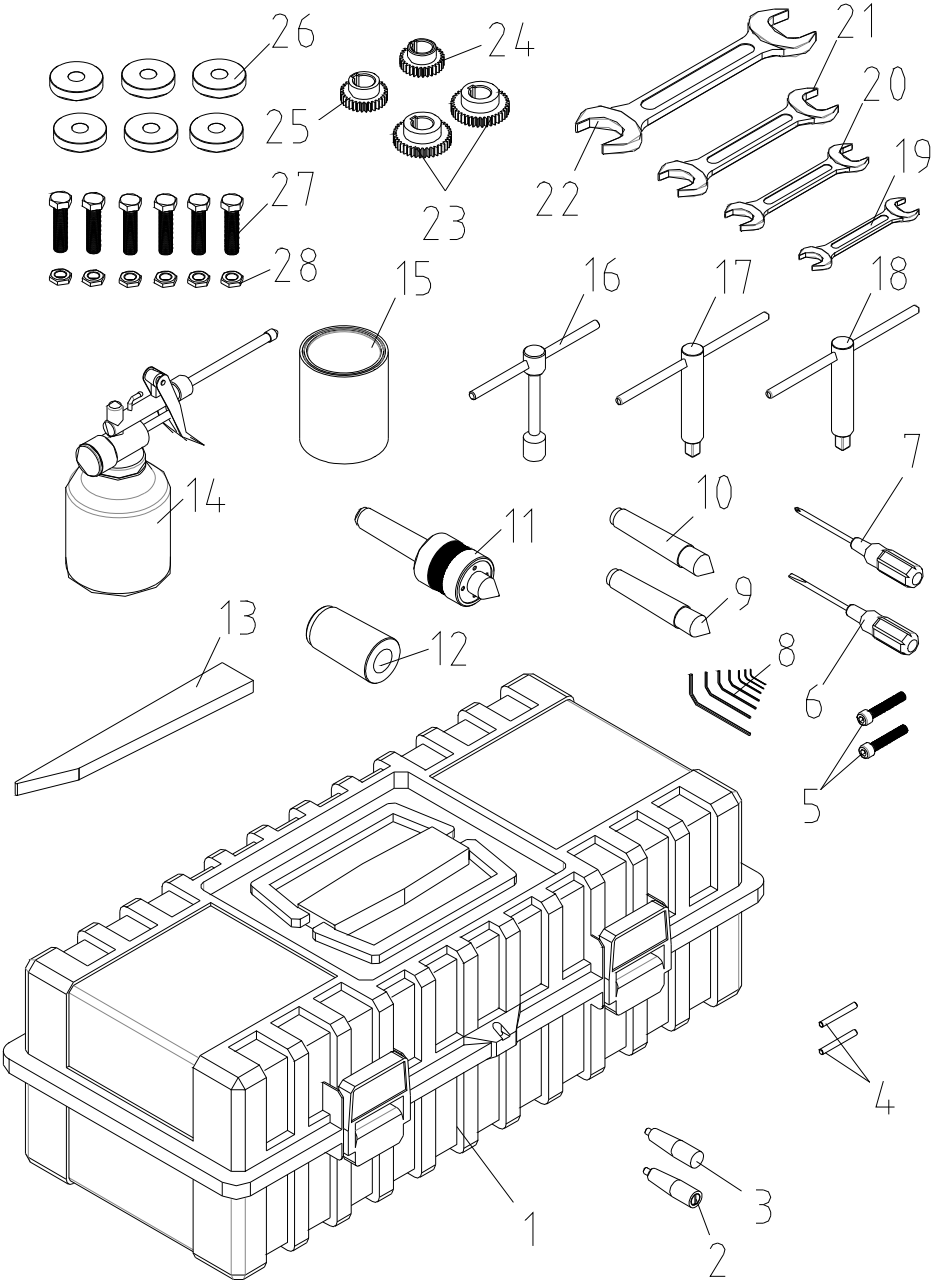
### 14.19.1 Lead Screw Cover Assembly – Exploded View



### 14.19.2 Lead Screw Cover Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	GH1440K-14701	Left Flange		1
2	TS-1502031	Hex Socket Hd Cap Screw	M5x12	2
3	LGB 28-900-70	Telescoping Sleeve		2
4	TS-2285121	Phillips Flat Head Machine Screw	M5x12	8
5	GH1440A-14702	Cover		2
6	GH1440K-14702	Left Flange Bracket		1
7	TS-1503041	Hex Socket Hd Cap Screw	M6x16	4
8	GH1440K-14101	Right Flange Bracket		1
9	GH1440A-14703	Right Flange		1

14.20.1 Accessories I – Exploded View

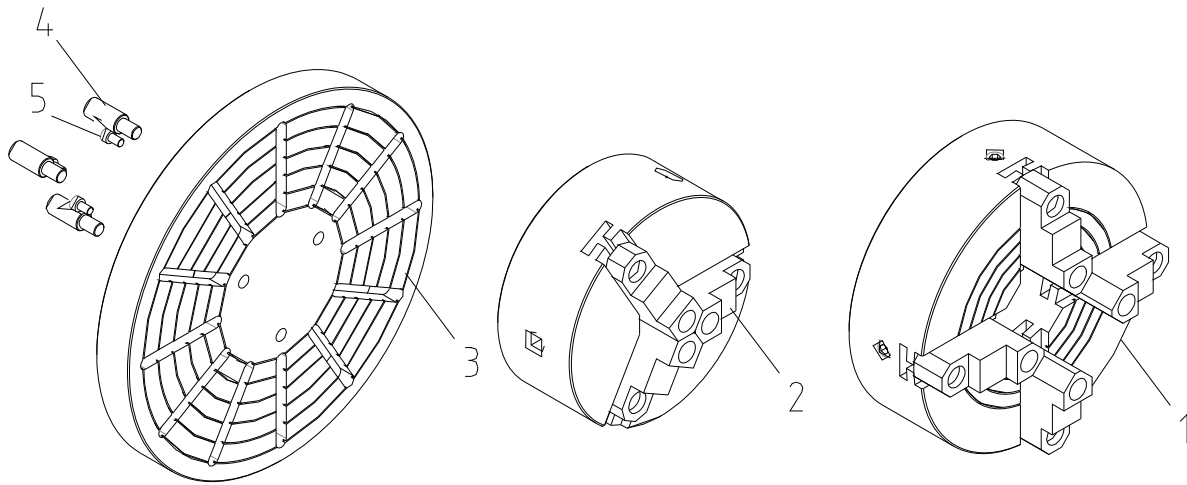




## 14.20.2 Accessories I – Parts List

Index No.	Part No.	Description	Size	Qty
	GH1440-TBCP	Tool Box Complete (#1 thru 28)		1
1		Tool Box		1
2	GH1440-0611	Handle Sleeve		1
	GH1440-0610	Handle Lever		1
3	GH1440A-06719	Handle Sleeve		1
4	GH1440-06-04	Shear Pin	4X35 mm	2
5	TS-1504081	Hex Socket Hd Cap Screw	M8X40	2
6	ZX-OP-14	Flat Blade Screwdriver		1
7	ZX-OP-15	Cross Point Screwdriver		1
8	GH1440-06-08	Hex Socket Wrench Set	.2, 2.5, 3, 4, 5, 6, 8mm	7
9	C0632-09703	Dead Center	MT-3 (Alloy)	1
10	C0632-09702	Dead Center	MT-3	1
11	GH1440-06-11	Live Center	MT-3	1
12	C0632-09701	Tapered Reducing Sleeve	No. 5 to No. 3	1
13	1440R-F001	Drift Key		1
14	GH1440B-1707	Oil Gun		1
15		Touchup Paint Can (Gray)		1
16	C0632-04726	Tool Post Wrench Rod		1
	C0632-04727	Tool Post Wrench		1
17	C0632-09705	Cam Lock Key Rod		1
	C0632-09704	Cam Lock Key		1
18	GH1440-0618	Chuck Key		1
19	GH1340A-TBCP-16-03	Open End Wrench	9-11mm	1
20	6295506	Open End Wrench	10-12mm	1
21	6295507	Open End Wrench	12-14mm	1
22	6295508	Open End Wrench	17-19mm	1
23	GH1440A05735-3	Change Gear	40T	2
24	GH1440A05735-1	Change Gear	30T	1
25	GH1440A05735-2	Change Gear	32T	1
26	GH1440K-01720	Leveling Pads		6
27	GH1440K-01721	Leveling Bolts		6
28	F012321	Hex Thin Jam Nut	M12-1.75	6

### 14.21.1 Accessories II – Exploded View



### 14.21.2 Accessories II – Parts List

Index No.	Part No.	Description	Size	Qty
1	K72200D4	Four Jaw Chuck with Camlock Stud	8"	1
2	K11160AD4	Three Jaw Chuck with Camlock Stud (Direct Mount)	6"	1
3	C0632-09101	Face Plate	12"	1
4	C0632-02722	Camlock Stud		3
5	TS-1503021	Hex Socket Hd Cap Screw	M6X10	3