



# Operating Instructions and Parts Manual

## Variable Speed Turret Mill

Model JTM-4VS

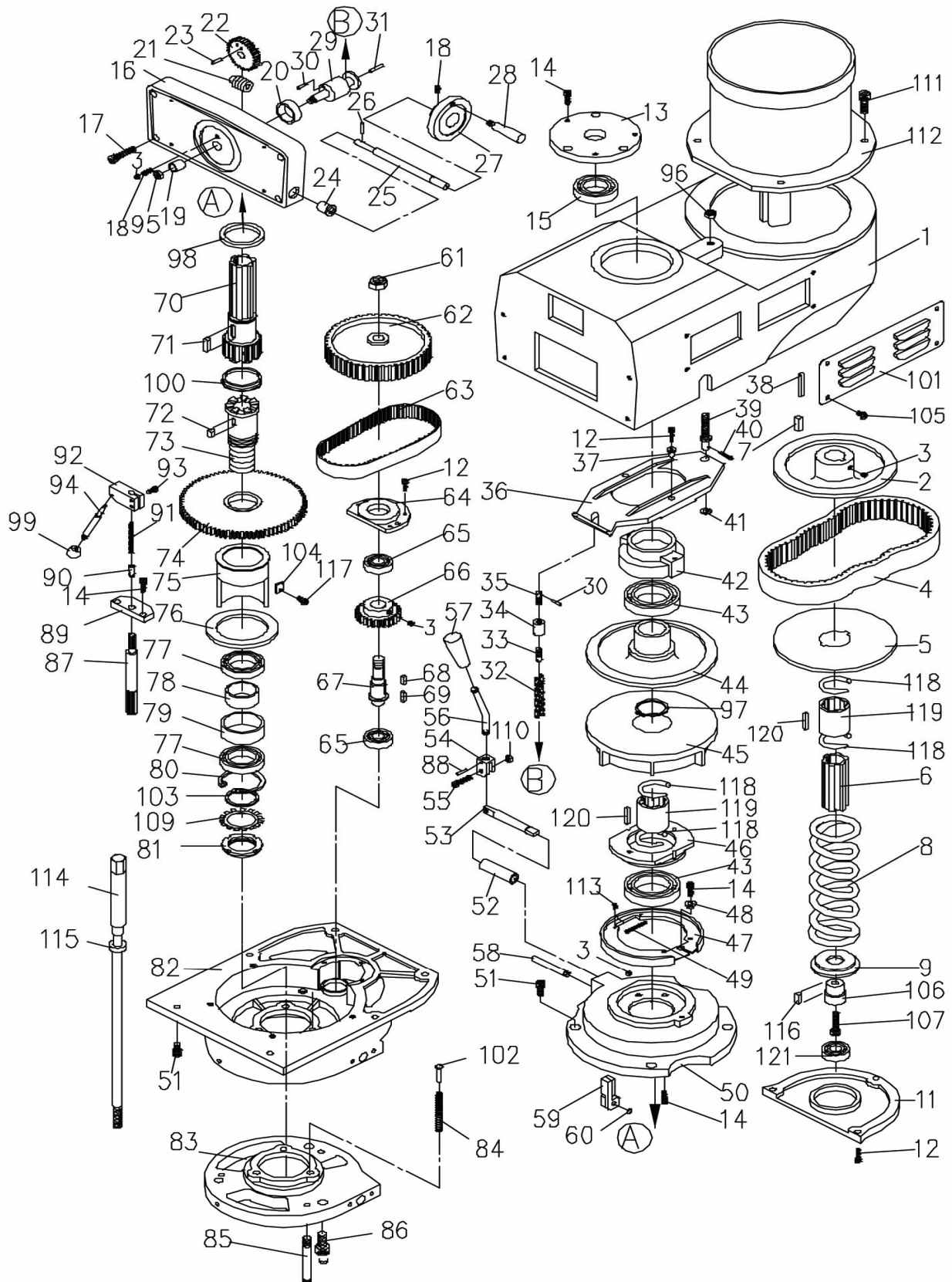


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# Head Assembly



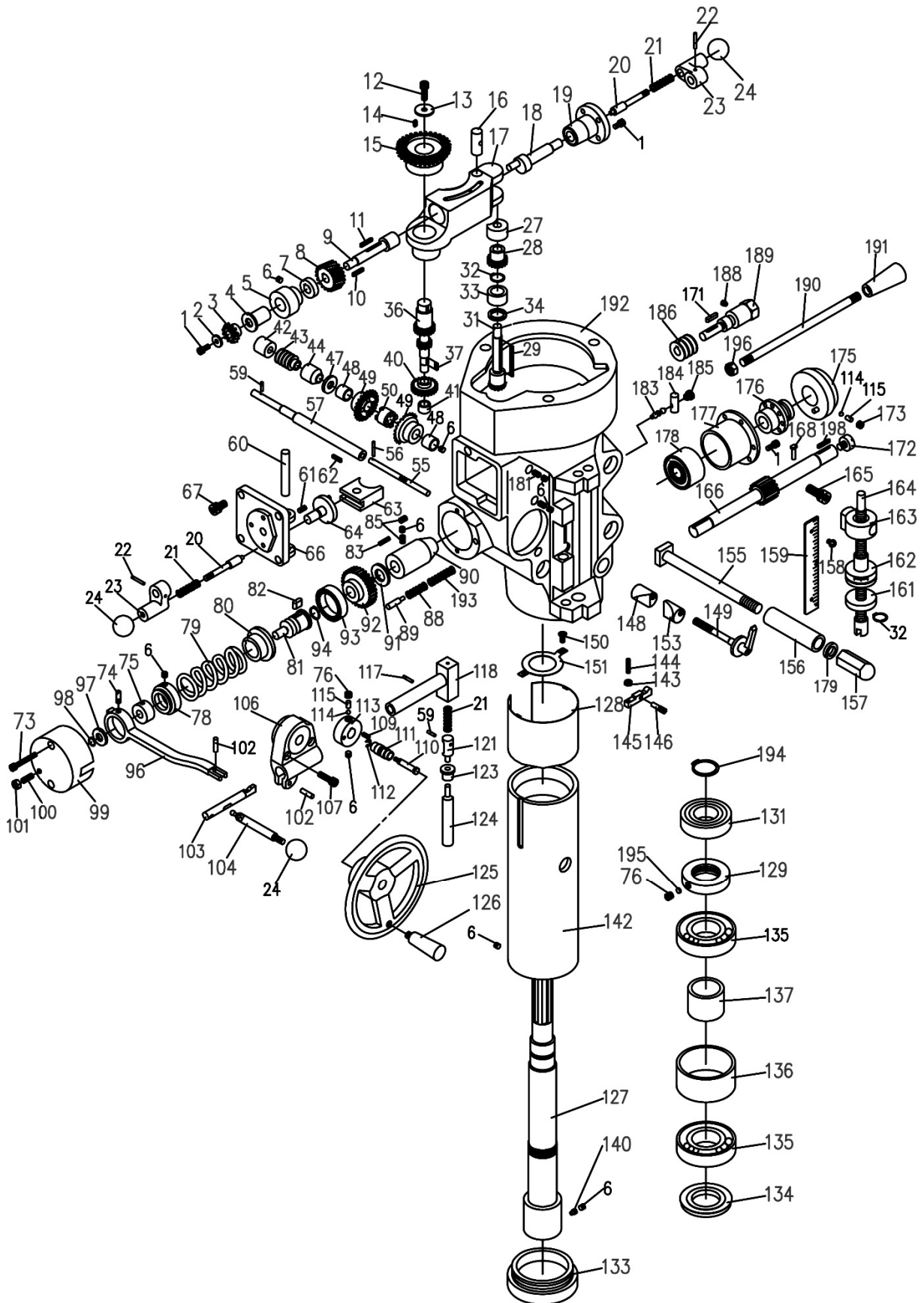
## Parts List for Head Assembly

| Index No. | Part No.       | Description                                   | Size          | Qty |
|-----------|----------------|---|---------------|-----|
|           | JTM4VS-HAG     | Head Assembly with Motor                      |               | 1   |
|           | JTM4VS-HAWOM-G | Head Assembly without Motor                   |               | 1   |
| 1         | VS-001G        | Upper Housing                                 |               | 1   |
| 2         | VS-002         | Motor Pulley                                  |               | 1   |
|           | VS-044A        | Motor Pulley Bushing (not shown)              |               | 1   |
| 3         | TS-1503011     | Set Screw                                     | M6 x 6        | 4   |
| 4         | VS-004         | Belt  | 900VC3830     | 1   |
| 5         | VS-005         | Motor Pulley Disk                             |               | 1   |
| 6         | VS-006         | Motor Pulley Shaft                            |               | 1   |
| 7         | KEY7725        | Key   | 7 x 7 x 25 mm | 1   |
| 8         | VS-008         | Motor Pulley Spring                           |               | 1   |
| 9         | VS-009         | Spring Stop Washer                            |               | 1   |
| 11        | VS-011AG       | Motor Pulley Cover                            |               | 1   |
| 12        | TS-1502051     | Hex Socket Cap Screw                          | M5 x 20       | 8   |
| 13        | VS-013         | Cover   |               | 1   |
| 14        | TS-1503041     | Hex Socket Cap Screw                          | M6 x 16       | 10  |
| 15        | BB-6007ZZ      | Ball Bearing                                  |               | 1   |
| 16        | VS-016G        | Dial Cover                                    |               | 1   |
| 16-1      | VS-016-1       | Dial With Panel Assembly (not shown)          |               | 1   |
| 17        | TS-1503071     | Hex Socket Cap Screw                          | M6 x 30       | 4   |
| 18        | TS-1503041     | Hex Socket Cap Screw                          | M6 x 16       | 2   |
| 19        | VS-019         | Bushing                                       |               | 1   |
| 20        | VS-020         | Bushing                                       |               | 1   |
| 21        | VS-021         | Worm  |               | 1   |
| 22        | VS-022         | Worm Gear                                     |               | 1   |
| 23        | VS-023         | Spring Pin                                    | 5 x 10 mm     | 2   |
| 24        | VS-024         | Bushing                                       |               | 2   |
| 25        | VS-025         | Dial Control Shaft                            |               | 1   |
| 26        | VS-026         | Spring Pin                                    | 3 x 12 mm     | 1   |
| 27        | VS-027         | Dial Wheel                                    |               | 1   |
| 28        | VS-028         | Wheel Handle                                  |               | 1   |
| 29        | VS-029         | Shaft   |               | 1   |
| 30        | VS-030         | Spring Pin                                    | 4 x 16 mm     | 2   |
| 31        | VS-031         | Spring Pin                                    | 3 x 25 mm     | 1   |
| 32        | VS-032         | Speed Change Chain                            |               | 1   |
| 33        | VS-033         | Adjustment Stud                               |               | 1   |
| 34        | VS-034         | Sleeve Nut                                    |               | 1   |
| 35        | VS-035         | Adjustment Stud                               |               | 1   |
| 36        | VS-036         | Tilter  |               | 1   |
| 37        | VS-037         | Bushing                                       |               | 2   |
| 38        | KEY6645        | Key   | 6 x 6 x 45 mm | 1   |
| 39        | VS-039         | Regulating Screw                              |               | 1   |
| 40        | VS-040         | Spring Pin                                    | 3/32" x 3/4"  | 1   |
| 41        | VS-041         | Washer  |               | 1   |
| 42        | VS-042         | Support                                       |               | 1   |
| 43        | BB-6010VV      | Ball Bearing                                  |               | 2   |
| 44        | VS-044         | Driven Pulley Assembly (s/n:xxx1944 & lower)  |               | 1   |
|           | VS-044N        | Driven Pulley Assembly (s/n:xxx1945 & higher) |               | 1   |
| 45        | VS-045         | Steady Pulley (s/n:xxx1944 & lower)           |               | 1   |
|           | VS-045N        | Steady Pulley (s/n:xxx1945 & higher)          |               | 1   |
| 46        | VS-046         | Bearing Cover                                 |               | 1   |
| 47        | VS-047         | Brake Lining                                  |               | 1   |
| 48        | VS-048         | Lock Screw                                    |               | 1   |
| 49        | VS-049         | Brake Spring                                  |               | 2   |
| 50        | VS-050G        | Lower Housing Cover                           |               | 1   |
| 51        | TS-1504031     | Hex Socket Cap Screw                          | M8 x 20       | 4   |
| 52        | VS-052         | Brake Shaft Sleeve                            |               | 1   |

| Index No. | Part No.    | Description             | Size          | Qty |
|-----------|-------------|-------------------------|---------------|-----|
| 53        | VS-053      | Brake Lock Shaft        |               | 1   |
| 54        | VS-054      | Brake Lock Block        |               | 1   |
| 55        | TS-1503061  | Hex Socket Cap Screw    | M6 x 25       | 1   |
| 56        | VS-056      | Brake Lock Handle       |               | 1   |
| 57        | VS-057      | Plastic Ball            |               | 2   |
| 58        | VS-058      | Brake Finger Pivot Stud |               | 1   |
| 59        | VS-059      | Brake Stud              |               | 2   |
| 60        | VS-060      | Snap Ring               | S-8           | 2   |
| 61        | TS-0561072  | Nut                     | 5/8"-18 UNF   | 1   |
| 62        | VS-062      | Timing Belt Pulley      |               | 1   |
| 63        | VB-225L100  | Timing Belt             | 225L100       | 1   |
| 64        | VS-064      | Bearing Retainer        |               | 1   |
| 65        | BB-6203ZZ   | Ball Bearing            |               | 2   |
| 66        | VS-066      | Bull Gear               |               | 1   |
| 67        | VS-067      | Counter Shaft           |               | 1   |
| 68        | VS-068      | Key                     | 5 x 5 x 15 mm | 1   |
| 69        | VS-069      | Key                     | 5 x 5 x 18 mm | 1   |
| 70        | VS-070      | Spindle Pulley Hub      |               | 1   |
| 71        | VS-071      | Key                     | 8 x 7 x 24 mm | 1   |
| 72        | VS-072      | Key                     | 8 x 7 x 12 mm | 1   |
| 73        | VS-073      | Spindle Gear Hub        |               | 1   |
| 74        | VS-074      | Spindle Gear Assembly   |               | 1   |
| 75        | VS-075      | Rack Cup                |               | 1   |
| 76        | VS-076      | Washer                  |               | 1   |
| 77        | BB-6908ZZ   | Ball Bearing            |               | 2   |
| 78        | VS-078      | Bearing Washer          |               | 1   |
| 79        | VS-079      | Bearing Washer          |               | 1   |
| 80        | VS-080      | Snap Ring               |               | 1   |
| 81        | VS-081      | Nut                     |               | 1   |
| 82        | VS-082G     | Lower Housing           |               | 1   |
| 83        | VS-083G     | Fixed Clutch Bracket    |               | 1   |
| 84        | VS-084      | Spring                  |               | 1   |
| 85        | VS-085      | Stud                    |               | 3   |
| 86        | TS-1506021  | Hex Socket Cap Screw    | M12 x 25      | 3   |
| 87        | VS-087      | Gear Shift Pinion       |               | 1   |
| 88        | VS-088      | Pin                     |               | 1   |
| 89        | VS-089      | Detent Plate            |               | 1   |
| 90        | VS-090      | Detent Washer           |               | 1   |
| 91        | VS-091      | Spring                  |               | 1   |
| 92        | VS-092      | Pinion Block            |               | 1   |
| 93        | TS-1503011  | Hex Socket Cap Screw    | M5 x 14       | 2   |
| 94        | VS-094      | Pinion Crank            |               | 1   |
| 95        | VS-095      | Cap Nut                 |               | 1   |
| 96        | TS-0561031  | Hex Nut                 | 3/8"          | 1   |
| 97        | VS-097      | Snap Ring               |               | 1   |
| 98        | VS-098      | Wave Washer             |               | 1   |
| 99        | VS-099      | Plastic Ball            |               | 1   |
| 100       | VS-100      | Snap Ring               |               | 1   |
| 101       | VS-101B     | Cover                   |               | 2   |
| 102       | VS-102      | Spring Shaft            |               | 3   |
| 103       | VS-103      | Washer                  |               | 1   |
| 104       | VS-104      | Copper Washer           |               | 2   |
| 105       | VS-105      | Screw                   | 1/4" x 3/8"   | 8   |
| 106       | VS-107      | Shaft                   |               | 1   |
| 107       | TS-1504061  | Hex Socket Cap Screw    | M8 x 30       | 1   |
| 109       | VS-109      | Lock Washer             |               | 1   |
| 110       | TS-1540041  | Hex Nut                 | M6            | 1   |
| 111       | TS-0209051  | Hex Socket Cap Screw    | 3/8" x 1"     | 4   |
| 112       | VS-000G     | Motor                   | 3HP 3PH       | 1   |
|           | JTM4VS-112G | Motor                   | 2HP 1PH       | 1   |

| Index No. | Part No.     | Description                                 | Size          | Qty |
|-----------|--------------|---|---------------|-----|
| 113       | VS-113       | Oval Head Screw                             | 1/8" x 1/4"   | 4   |
| 114       | JTM1-001VS   | Draw Bar                                    |               | 1   |
| 115       | JTM4VS-A002B | Draw Bar Washer                             |               | 1   |
| 116       | VS-116       | Key   |               | 1   |
| 117       | VS-117       | Oval Head Screw                             | 3/16" x 1/2"  | 1   |
| 118       | VS-007       | Snap Ring                                   |               | 4   |
| 119       | VS-005A      | Plastic Sleeve                              |               | 2   |
| 120       | VS-120       | Key   | 6 x 4 x 32 mm | 2   |
| 121       | BB-6206ZZ    | Ball Bearing                                | 6206ZZ        | 1   |
|           | VS-000A      | Forward-Reverse Switch, 3 Phase (not shown) |               | 1   |
|           | JTM2-598CP   | Forward-Reverse Switch, 1 Phase (not shown) |               | 1   |
|           | JTM1-598D    | Switch Box (not shown)                      |               | 1   |
|           | JTM1-598B    | Switch Knob (not shown)                     |               | 1   |
|           | LK-041B      | Switch Bracket (not shown)                  |               | 1   |

# Spindle Assembly



## Parts List for Spindle Assembly

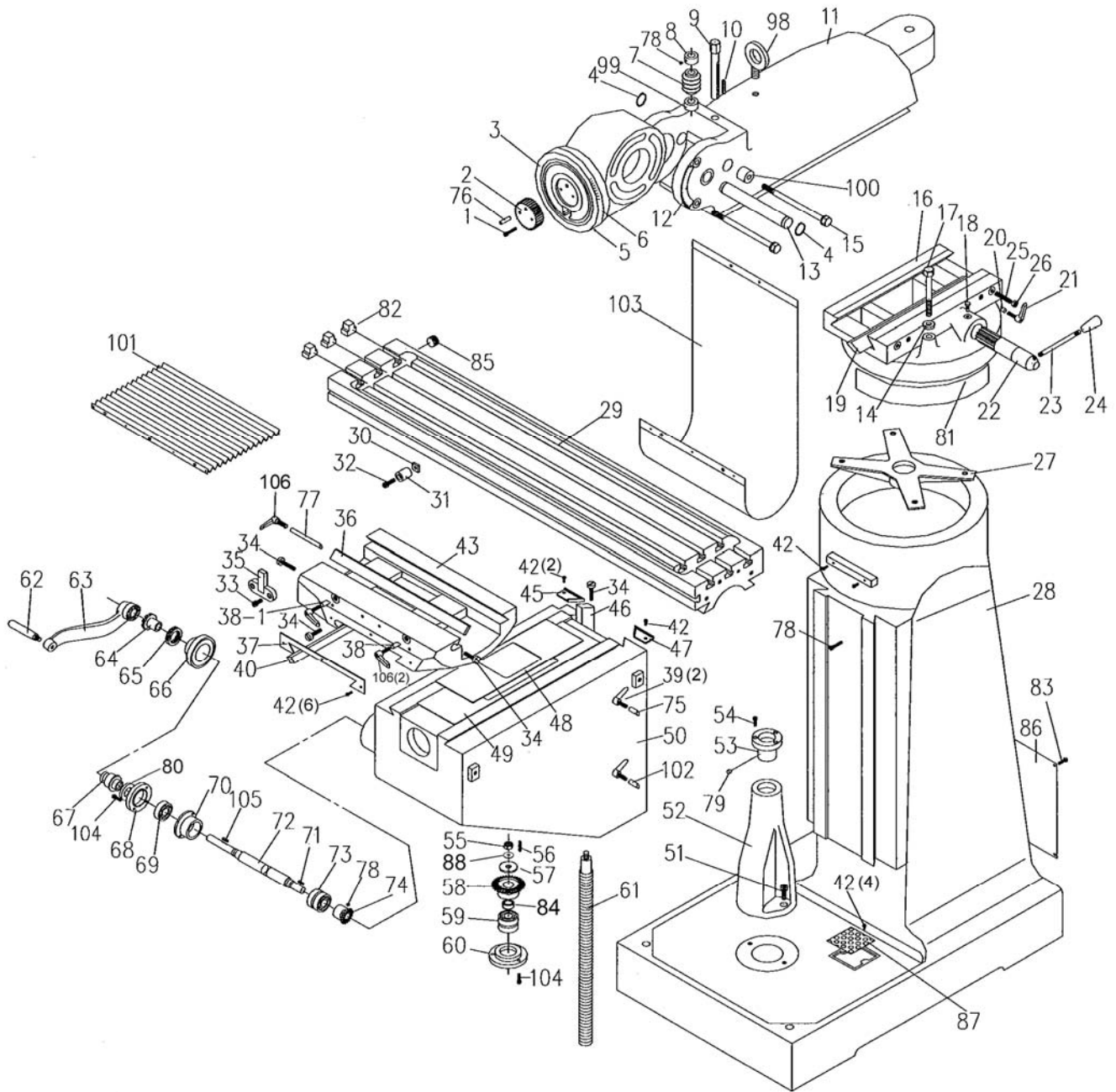
| Index No. | Part No.   | Description              | Size           | Qty |
|-----------|------------|--------------------------|----------------|-----|
| 1         | TS-1533042 | Screw                    | M5 x 10        | 6   |
| 2         | HA-002     | Bevel Pinion Washer      |                | 1   |
| 3         | HA-003     | Feed Gear                |                | 1   |
| 4         | LA-161     | Shaft Sleeve             |                | 1   |
| 5         | LA-162     | Worm Cradle Bushing      |                | 1   |
| 6         | TS-1523011 | Set Screw                | M6 x 6         | 9   |
| 7         | LA-163     | Worm Gear Spacer         |                | 1   |
| 8         | LA-164     | Feed Drive Worm Gear     |                | 1   |
| 9         | LA-165     | Worm Gear Shaft          |                | 1   |
| 10        | HA-010     | Worm Shaft Key           | 3 x 3 x 8 mm   | 1   |
| 11        | HA-011     | Key                      | 3 x 3 x 20 mm  | 1   |
| 12        | HA-012     | Locknut                  | M6 x 16        | 1   |
| 13        | HA-013     | Washer                   |                | 1   |
| 14        | HA-014     | Cluster Gear Key         | 3 x 3 x 8.5 mm | 1   |
| 15        | LA-154     | Feed Reverse Bevel Gear  |                | 1   |
| 16        | LA-167     | Feed Engage Pin          |                | 1   |
| 17        | LA-166     | Worm Gear Cradle         |                | 1   |
| 18        | LA-033     | Worm Gear Throw-Out      |                | 1   |
| 19        | LA-002     | Shift Sleeve             |                | 1   |
| 20        | LA-004     | Plunger                  |                | 2   |
| 21        | LA-005     | Spring                   |                | 3   |
| 22        | HA-022     | Spring Pin               | 3 x 22 mm      | 2   |
| 23        | LA-003     | Shift Crank              |                | 2   |
| 24        | LA-006     | Plastic Ball             |                | 3   |
| 27        | LA-147     | Upper Bushing            |                | 1   |
| 28        | LA-144     | Cluster Gear Assembly    |                | 1   |
| 29        | HA-029     | Cluster Gear Key         | 3 x 3 x 45 mm  | 1   |
| 31        | LA-143     | Cluster Gear Shaft       |                | 1   |
| 32        | HA-032     | Snap Ring                |                | 2   |
| 33        | LA-142     | Bevel Gear Bushing       |                | 1   |
| 34        | LA-141     | Thrust Spacer            |                | 1   |
| 36        | LA-156     | Feed Drive Gear          |                | 1   |
| 37        | HA-037     | Key                      | 3 x 3 x 10 mm  | 1   |
| 40        | LA-157     | Feed Drive Gear          |                | 1   |
| 41        | HA-041     | Needle Bearing           |                | 1   |
| 42        | LA-168     | Bushing                  |                | 1   |
| 43        | LA-139     | Worm                     |                | 1   |
| 44        | LA-138     | Feed Worm Shaft Bushing  |                | 1   |
| 47        | LA-137     | Bevel Gear Thrust Spacer |                | 1   |
| 48        | LA-134     | Bushing                  |                | 2   |
| 49        | LA-135     | Feed Reverse Bevel Gear  |                | 2   |
| 50        | LA-136     | Feed Reverse Clutch      |                | 1   |
| 55        | LA-132     | Reverse Clutch Rod       |                | 1   |
| 56        | HA-056     | Spring Pin               | 3 x 20 mm      | 1   |
| 57        | LA-133     | Feed Worm Shaft          |                | 1   |
| 59        | HA-059     | Spring Pin               | 3 x 12 mm      | 2   |
| 60        | LA-150     | Feed Shift Rod           |                | 1   |
| 61        | TS-1522031 | Set Screw                | M5 x 10        | 1   |
| 62        | HA-062     | Key                      | 3 x 3 x 15 mm  | 1   |
| 63        | LA-149     | Feed Gear Shift Fork     |                | 1   |
| 64        | LA-151     | Cluster Gear Shift Crank |                | 1   |
| 66        | LA-148     | Cluster Gear Cover       |                | 1   |
| 67        | TS-1504011 | Hex Socket Cap Screw     | M8 x 10        | 4   |
| 73        | TS-1502081 | Hex Socket Cap Screw     | M5 x 35        | 2   |
| 74        | LA-081     | Clutch Ring Pin          |                | 2   |
| 75        | LA-080     | Clutch Ring              |                | 1   |
| 76        | TS-1524011 | Set Screw                | M8 x 8         | 1   |

| Index No. | Part No.   | Description                                    | Size         | Qty |
|-----------|------------|--|--------------|-----|
| 78        | LA-082     | Overload Clutch Lockout                        |              | 1   |
| 79        | LA-083     | Safety Clutch Spring                           |              | 1   |
| 80        | LA-084     | Overload Clutch                                | .46T         | 1   |
|           | LA-084N    | Overload Clutch (serial # 6100913 and up)      | .50T         | 1   |
| 81        | LA-085     | Overload Clutch Sleeve                         |              | 1   |
| 82        | LA-090     | Key  |              | 1   |
| 83        | TS-1532052 | Pan Head Machine Screw                         | M4 x 16      | 3   |
| 85        | TS-1523031 | Set Screw                                      | M6 x 10      | 2   |
| 88        | LA-169     | Spring   |              | 1   |
| 89        | LA-089     | Spring Plunger                                 |              | 1   |
| 90        | LA-123     | Pinion Shaft Bushing                           |              | 1   |
| 91        | LA-122     | Spacer   |              | 1   |
| 92        | LA-087     | Overload Clutch Worm Gear                      |              | 1   |
| 93        | LA-086     | Overload Clutch Ring                           | .46T         | 1   |
|           | LA-086N    | Overload Clutch Ring (serial # 6100913 and up) | .50T         | 1   |
| 94        | HA-094     | Snap Ring                                      |              | 1   |
| 96        | LA-079     | Trip Lever                                     |              | 1   |
| 97        | LA-078     | Washer   |              | 1   |
| 98        | HA-098     | Snap Ring                                      |              | 1   |
| 99        | LA-076     | Clutch Arm Cover                               |              | 1   |
| 100       | TS-1523051 | Set Screw                                      | M6 x 10      | 1   |
| 101       | HA-101     | Locknut  |              | 1   |
| 102       | LA-077     | Pin  |              | 3   |
| 103       | LA-091     | Cam Rod  |              | 1   |
| 104       | LA-100     | Trip Handle                                    |              | 1   |
| 106       | LA-092     | Feed Trip Bracket                              |              | 1   |
| 107       | TS-1503051 | Hex Socket Cap Screw                           | M6 x 20      | 2   |
| 109       | HA-109     | Key  | 3 x 3 x10 mm | 1   |
| 110       | LA-130     | Feed Reverse Knob Stud                         |              | 1   |
| 111       | LA-131     | Reverse Knob                                   |              | 1   |
| 112       | HA-112     | Snap Ring                                      |              | 1   |
| 113       | LA-129     | Handwheel Clutch                               |              | 1   |
| 114       | SB-3/16    | Steel Ball                                     | 3/16"        | 2   |
| 115       | HA-115     | Spring   |              | 2   |
| 117       | HA-117     | Spring Pin                                     |              | 1   |
| 118       | LA-093     | Cam Rod Sleeve Assembly                        |              | 1   |
| 121       | LA-095     | Trip Plunger                                   |              | 1   |
| 123       | LA-121     | Bushing  |              | 1   |
| 124       | LA-097     | Feed Trip Plunger                              |              | 1   |
| 125       | LA-126     | Handwheel (chrome)                             |              | 1   |
|           | LA-126-BR  | Handwheel (brushed finish)                     |              | 1   |
| 126       | LA-125     | Handle (chrome)                                |              | 1   |
|           | LA-125-BR  | Handle (brushed finish)                        |              | 1   |
| 127       | LA-050A    | Spindle  |              | 1   |
| 128       | LA-060     | Quill Skirt                                    |              | 1   |
| 129       | LA-048     | Lock Nut                                       |              | 1   |
| 131       | BB-6206ZZ  | Ball Bearing                                   |              | 1   |
| 133       | LA-051     | Nose Piece                                     |              | 1   |
| 134       | LA-052     | Spindle Shield                                 |              | 1   |
| 135       | BB-7207C   | Ball Bearing                                   |              | 2   |
| 136       | LA-054     | Bearing Spacer (large)                         |              | 1   |
| 137       | LA-053     | Bearing Spacer (small)                         |              | 1   |
| 140       | LA-172     | Set Screw                                      |              | 1   |
| 142       | LA-058     | Quill  |              | 1   |
| 143       | TS-154021  | Hex Nut  | M4           | 1   |
| 144       | TS-1521071 | Set Screw                                      | M4 x 20      | 1   |
| 145       | LA-098     | Feed Trip Lever                                |              | 1   |
| 146       | LA-099     | Trip Lever Pin                                 |              | 1   |
| 148       | LA-111     | Quill Lock Sleeve                              |              | 1   |



| Index No. | Part No.   | Description                                       | Size              | Qty |
|-----------|------------|---|-------------------|-----|
| 149       | LA-109     | Lock Handle (chrome)                              |                   | 1   |
|           | LA-109-BR  | Lock Handle (brushed finish)                      |                   | 1   |
| 150       | HA-150     | Screw   | M5 x 10           | 2   |
| 151       | LA-057     | Felt Washer                                       |                   | 1   |
| 153       | LA-110     | Quill Lock Sleeve                                 |                   | 1   |
| 155       | LA-043     | T-Bolt Assembly                                   |                   | 4   |
| 156       | LA-046     | Spacer  |                   | 4   |
| 157       | LA-040     | Lock Nut  |                   | 4   |
| 158       | HA-158     | Screw   | M4 x 5            | 2   |
| 159       | LA-118     | Micrometer Scale                                  |                   | 1   |
| 161       | LA-115     | Quill Micro-Stop Nut                              |                   | 1   |
| 162       | LA-116     | Micrometer Nut                                    |                   | 1   |
| 163       | LA-117     | Quill Stop Knob                                   |                   | 1   |
| 164       | LA-112     | Quill Micro-Screw                                 |                   | 1   |
| 165       | LA-165A    | Screw   | 3/8"-24UNF x 3/4" | 1   |
| 166       | LA-101     | Quill Pinion Shaft                                |                   | 1   |
| 168       | LA-101A    | Pin   |                   | 1   |
| 171       | HA-171     | Key   | 4x4x18 mm         | 1   |
| 172       | LA-107     | Pinion Shaft Hub                                  |                   | 1   |
| 173       | TS-0270021 | Set Screw   | 5/16" x 1/4"      | 1   |
| 175       | LA-106     | Hub   |                   | 1   |
| 176       | LA-104     | Hub Sleeve  |                   | 1   |
| 177       | LA-103     | Spring Cover                                      |                   | 1   |
| 178       | LA-102     | Clock Spring                                      |                   | 1   |
|           | LA-102/3   | Clock Spring Assembly                             |                   | 1   |
| 179       | TS-0680061 | Washer  | 1/2"              | 1   |
| 181       | TS-1523011 | Set Screw   | M6 x 6            | 2   |
| 183       | LA-113     | Lever   |                   | 1   |
| 184       | LA-114     | Plunger   |                   | 1   |
| 185       | LA-124     | Screw   |                   | 1   |
| 186       | LA-018     | Worm Gear   |                   | 1   |
| 188       | LA-173     | Set Screw   |                   | 1   |
| 189       | LA-019     | Worm Shaft  |                   | 1   |
| 190       | LA-105     | Handle  |                   | 1   |
| 191       | LB-017     | Plastic Ball                                      |                   | 1   |
| 192       | LA-016G    | Quill Housing                                     |                   | 1   |
| 193       | HA-193     | Spring  | 10 x 20 mm        | 1   |
| 194       | RINS30     | Snap Ring   |                   | 1   |
| 195       | HB1291     | Lock Washer                                       |                   | 1   |
| 196       | TS-1524011 | Set Screw   | M8 x 8            | 1   |
| 197       | TS-0561031 | Hex Nut   | 3/8"              | 1   |
| 198       | KF2R3320   | Key   | 3x3x20mm          | 1   |
|           | LA-166A    | Worm Gear Cradle Assembly (index # 1-17,36,37,40) |                   | 1   |

# Base Assembly



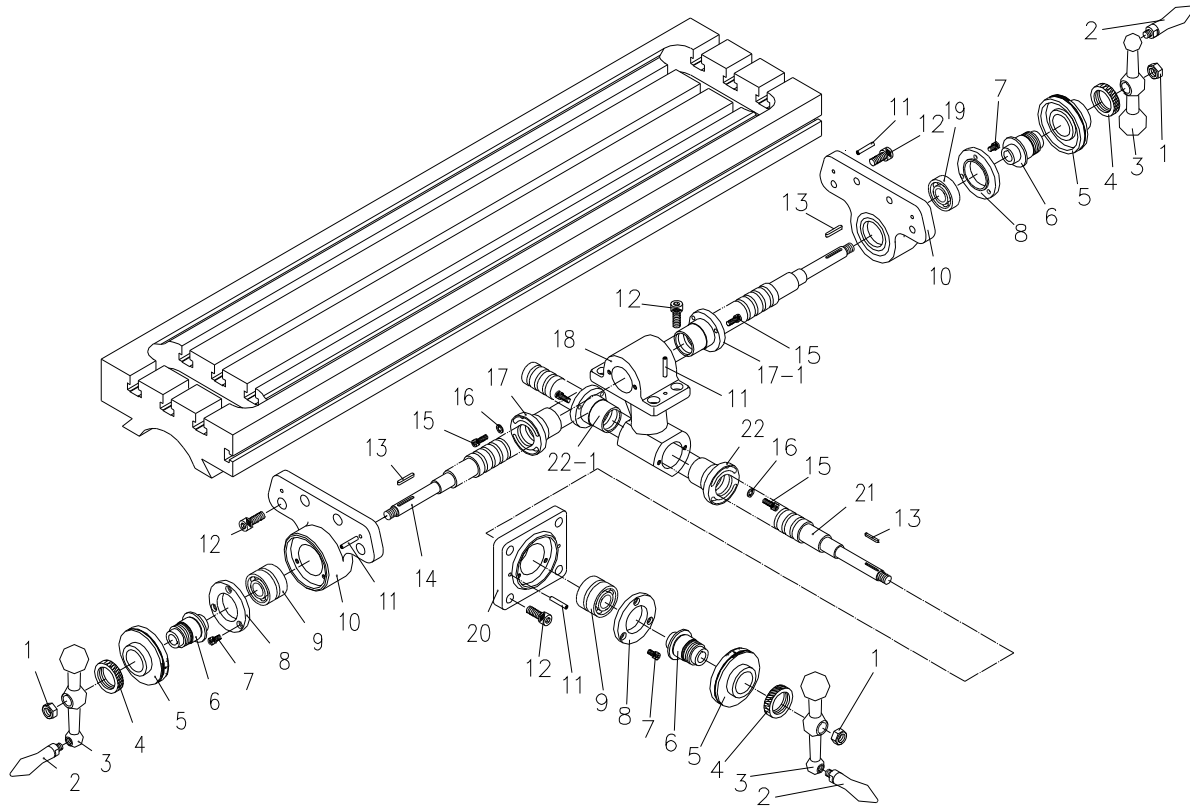
## Parts List for Base Assembly

| Index No. | Part No.   | Description              | Size          | Qty |
|-----------|------------|--------------------------|---------------|-----|
| 1         | LB-001     | Set Screw                | M6 x30        | 2   |
| 2         | LB-023     | Gear                     |               | 1   |
| 3         | LB-020G    | Ram Adapter              |               | 1   |
| 4         | LB-004     | Snap Ring                | S-28          | 2   |
| 5         | LB-005     | Rivet                    |               | 5   |
| 6         | LB-027     | Adapter Scale            |               | 1   |
| 7         | LB-035     | Worm                     |               | 1   |
| 8         | LB-036     | Worm Thrust Washer       |               | 1   |
| 9         | LB-034     | Shaft                    |               | 1   |
| 10        | LB-100     | Key                      | 5 x 5 x 40 mm | 1   |
| 11        | MB-026G    | Ram                      |               | 1   |
| 12        | LB-032     | Angle Plate              |               | 1   |
| 13        | LB-028     | Adapter Pivot Stud       |               | 1   |
| 14        | LB-031     | Washer                   |               | 4   |
| 15        | LB-030     | Adapter Locking Bolt     |               | 3   |
| 16        | MB-009G    | Turret                   |               | 1   |
|           | MB-00B     | Turret Scale (not shown) |               | 1   |
| 17        | LB-030     | Lock Bolt                |               | 4   |
| 18        | LB-041     | Ram Pinion Screw         |               | 1   |
| 19        | LB-011     | Ram/Turret Gib           |               | 1   |
| 20        | LS-005E    | Lock Plunger             |               | 2   |
| 21        | LB-014     | Ram Lock Bolt Handle     |               | 2   |
| 22        | LB-015     | Ram Pinion               |               | 1   |
| 23        | LB-016     | Ram Pinion Handle Rod    |               | 1   |
| 24        | LB-017     | Black Plastic Ball       |               | 1   |
| 25        | TS-0211131 | Set Screw                | 3/8" x 2"     | 2   |
| 26        | TS-0561031 | Hex Nut                  | 3/8"          | 2   |
| 27        | MB-008     | Spider                   |               | 1   |
| 28        | MB-000AG   | Column                   |               | 1   |
| 29        | MT000B     | Table                    |               | 1   |
| 30        | LT-027     | Stop Nut                 |               | 2   |
| 31        | LT-028     | Table Stop               |               | 2   |
| 32        | TS-1504071 | Hex Socket Cap Screw     | M8 x 35       | 2   |
| 33        | TS-1504031 | Hex Socket Cap Screw     | M8 x 16       | 2   |
| 34        | LK-002     | Gib Adjusting Screw      |               | 6   |
| 35        | LS-003     | Table Stop Bracket       |               | 1   |
| 36        | LS-008     | Saddle/Table Gib         |               | 1   |
| 37        | LS-013     | Felt Wiper               |               | 2   |
| 38        | LS-005R    | Table Lock Plunger – R   | 16mm          | 1   |
| 38-1      | LS-005L    | Table Lock Plunger – L   | 13mm          | 1   |
| 39        | LS-011     | Knee Lock Handle         |               | 2   |
| 40        | LS-001     | Saddle/Knee Gib          |               | 1   |
| 42        | LS-042     | Screw                    | 3/16"         | 20  |
| 43        | MS-000G    | Saddle                   |               | 1   |
| 45        | LS-016A    | Felt (left)              |               | 1   |
| 46        | LK-001     | Knee/Column Gib          |               | 1   |
| 47        | LS-016B    | Knee/Wiper Felt (right)  |               | 1   |
| 48        | LK-007     | Upper Chip Guard         |               | 1   |
| 49        | LK-006     | Lower Chip Guard         |               | 1   |
| 50        | MK-000G    | Knee                     |               | 1   |
| 51        | TS-1505031 | Hex Socket Cap Screw     | M10 x 25      | 2   |
| 52        | MK-012G    | Elevating Screw Housing  |               | 1   |
| 53        | MK-014     | Elevating Screw Nut      |               | 1   |
| 54        | TS-1503041 | Hex Socket Cap Screw     | M6 x 16       | 8   |
| 55        | TS-0561052 | Hex Nut                  | 1/2-20UNF     | 1   |
| 56        | LK-058     | Key                      | 4 x 4 x 30 mm | 1   |

| Index No. | Part No.   | Description                                 | Size          | Qty |
|-----------|------------|---|---------------|-----|
| 57        | LK-022     | Washer                                      |               | 1   |
| 58        | MK-021     | Bevel Gear                                  |               | 1   |
| 59        | BB-6306ZZ  | Ball Bearing                                |               | 2   |
| 60        | MK-019     | Bearing Retainer Ring                       |               | 1   |
| 61        | MK-016     | Elevating Screw                             |               | 1   |
| 62        | LK-037     | Handle (chrome)                             |               | 1   |
|           | LK-037-BR  | Handle (brushed finish)                     |               | 1   |
| 63        | LK-036     | Elevating Crank                             |               | 1   |
| 64        | LK-035     | Clutch Insert                               |               | 1   |
| 65        | LK-034     | Dial Lock Nut                               |               | 1   |
| 66        | LK-033     | Dial  |               | 1   |
| 67        | LK-032     | Dial Holder                                 |               | 1   |
| 68        | LK-030     | Bearing Retainer Ring                       |               | 1   |
| 69        | BB-6204ZZ  | Ball Bearing                                |               | 1   |
| 70        | LK-029     | Bearing Cap                                 |               | 1   |
| 71        | LK-075     | Key   | 4 x 4 x 18 mm | 2   |
| 72        | MK-028     | Elevating Shaft                             |               | 1   |
| 73        | BB-6204ZZ  | Ball Bearing                                |               | 2   |
| 74        | MK-024     | Bevel Pinion                                |               | 1   |
| 75        | LK-003B    | Plunger                                     | 32mm          | 1   |
| 76        | LK-081     | Spring Pin                                  | 8 x 30 mm     | 1   |
| 77        | LS-010A    | Saddle Lock Plunger                         | 116mm         | 1   |
| 78        | TS-1515001 | Hex Socket Cap Screw                        | M8 x 12       | 1   |
| 79        | JTM4VS-B79 | Grease Nipple                               | 1/8"PT        | 1   |
| 80        | JTM4VS-B80 | Spacer                                      |               | 1   |
| 81        | JTM4VS-B81 | Turret Scale                                |               | 1   |
| 82        | JTM4VS-B82 | Rubber T-Nut                                |               | 6   |
| 83        | MB-090     | Screw                                       | 1/4" x 3/8"   | 4   |
| 84        | MK-038     | Bushing                                     |               | 1   |
| 85        | VM-I40     | Oil Plug                                    | 3/8" PT       | 2   |
| 86        | MB-004     | Cover                                       |               | 1   |
| 87        | MB-041     | Strainer Screen                             |               | 2   |
| 88        | JTM4VS-B88 | Lock Washer                                 |               | 1   |
| 98        | RIBW34     | Hoisting Ring                               |               | 1   |
| 99        | LB-036     | Worm Thrust Washer                          |               | 1   |
| 100       | LB-033     | Thrust Washer                               |               | 1   |
| 101       | LS-018     | Pleated Way Cover                           |               | 1   |
| 102       | LK-003C    | Lock Plunger                                | 35mm          | 1   |
| 103       | LS-017C    | Flat Way Cover                              |               | 1   |
| 104       | TS-1503051 | Hex Socket Cap Screw                        | M6 x 20       | 6   |
| 105       | KEY3320    | Key   | 3 x 3 x 20 mm | 1   |
| 107       | LS-006B    | Saddle Ratcheting Lever (chrome)            |               | 3   |
|           | LS-006B-BR | Saddle Ratcheting Lever (brushed finish)    |               | 3   |
|           | JTM4VS-TB  | Tool Box Kit Complete (not shown)           |               | 1   |
|           | LC051      | Plastic Electric Cover (not shown)          |               | 1   |
|           | LC051A     | Plastic Electric Cover Assembly (not shown) |               | 1   |

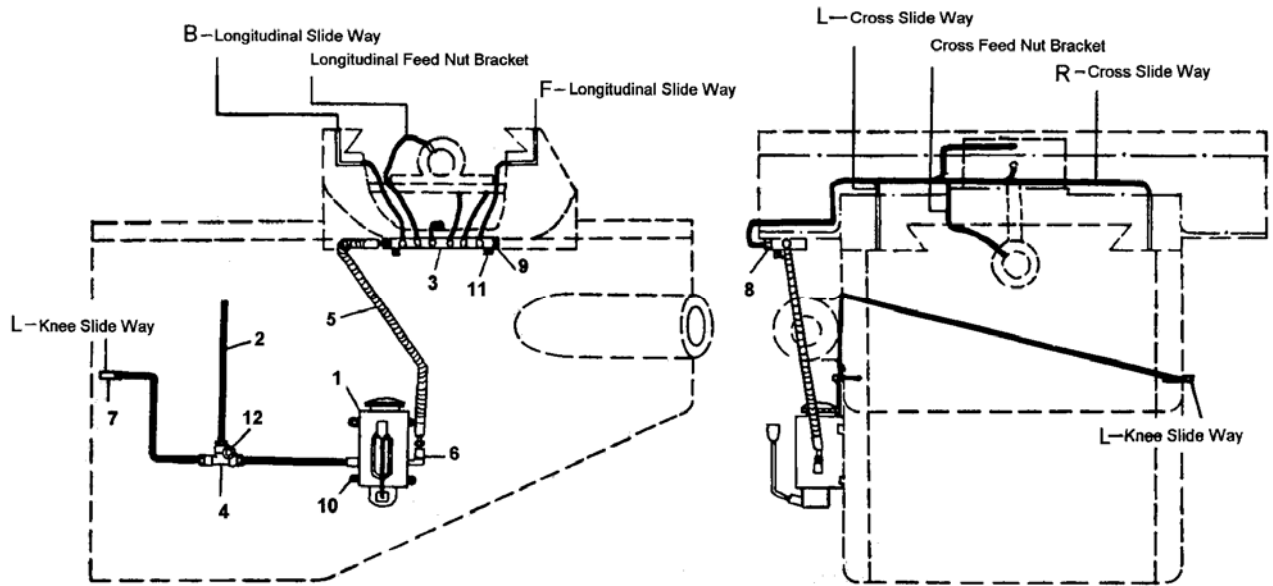
*(Includes switch wire, cover, terminal bracket, power wire, retainer)*

# Lead Screw Assembly



| Index No. | Part No.      | Description                                       | Size           | Qty |
|-----------|---------------|---|----------------|-----|
| 1         | TS-0571052    | Jam Nut   | 1/2-20UNF      | 3   |
| 2         | LT-010C       | Handle  |                | 3   |
|           | LT-010C-CHR   | Chrome Surface Handle                             |                | 3   |
| 3         | LT-010B       | Ball Crank  |                | 3   |
|           | LT-010BSP-CHR | Clutch Ball Crank (for powerfeed only)            | chrome surface | 3   |
|           | LT-010BSP     | Clutch Ball Crank (for powerfeed only)            |                | 3   |
| 4         | LT-009        | Dial Lock Nut                                     |                | 3   |
| 5         | LT-008        | Dial  |                | 3   |
| 6         | LT-007        | Dial Holder                                       |                | 3   |
| 7         | TS-150301     | Hex Socket Cap Screw                              | M6 x 12        | 9   |
| 8         | LT-005        | Bearing Retainer Ring                             |                | 3   |
| 9         | BB-6204ZZ     | Ball Bearing                                      |                | 3   |
| 10        | LT-002        | Bearing Bracket                                   |                | 2   |
| 11        | LS-009        | Spring Pin  | 5 x 30 mm      | 8   |
| 12        | TS-1505031    | Hex Socket Cap Screw                              | M10 x 25       | 16  |
| 13        | LS-014A       | Key   | 3 x 3 x 25 mm  | 3   |
| 14        | MT-015D       | Leadscrew   |                | 1   |
| 15        | TS-1503041    | Hex Socket Cap Screw                              | M6 x 16        | 10  |
| 16        | TS-1550051    | Washer  | M7             | 4   |
| 17        | MT-019B       | Feed Screw Nut (set of 2; includes index # 17-1)  |                | 1   |
| 18        | MT-017        | Feed Nut Bracket                                  |                | 1   |
| 19        | BB-6204ZZ     | Ball Bearing                                      |                | 1   |
| 20        | MT-025        | Cross Feed Bearing Bracket                        |                | 1   |
| 21        | MT-024        | Cross Feed Screw                                  |                | 1   |
| 22        | MT-022        | Cross Feed Nut (set of 2; includes index # 17-22) |                | 1   |

# One-Shot Lubrication System



| Index No. | Part No.             | Description   | Size         | Qty |
|-----------|----------------------|---|--------------|-----|
| .....     | LT-8-A.....          | Hand Oiler Assembly (includes index #1,1A,4,5,9)..... |              | 1   |
| 1.....    | LT-8.....            | Hand Oiler.....                                       |              | 1   |
| 1A.....   | LT-8-SG.....         | Hand Oiler Sight Glass (w/gasket).....                |              | 1   |
| 2.....    | ALMP-04.....         | Aluminum Pipe.....                                    | 3.5M.....    | 1   |
| .....     | ALMP-04-VS.....      | Oil Line Set w/ Fittings.....                         |              | 1   |
| 3.....    | DB-4.....            | Oil Regulating Distributor.....                       |              | 1   |
| 4.....    | PKD-4.....           | T-Joint.....  |              | 1   |
| 5.....    | FHC-404.....         | Flexible Steel Tube.....                              |              | 1   |
| 6.....    | PH-1-1/PB-4.....     | Check Joint.....                                      |              | 2   |
| 7.....    | PH-4.....            | Elbow Joint.....                                      |              | 2   |
| 8.....    | PA-4/PB-4.....       | Straight Joint.....                                   |              | 14  |
| 9.....    | PG-004.....          | Union.....  |              | 1   |
| 10.....   | JTM4VS-BUTW1458..... | Screw.....  |              | 4   |
| 11.....   | TS-1503061.....      | Hex Socket Cap Screw.....                             | M6 x 25..... | 2   |
| 12.....   | TS-1502061.....      | Hex Socket Cap Screw.....                             | M5 x 25..... | 1   |