



# Operating Instructions and Parts Manual Variable Speed Turret Mill

Models JTM-1254VS and JTM-1254RVS

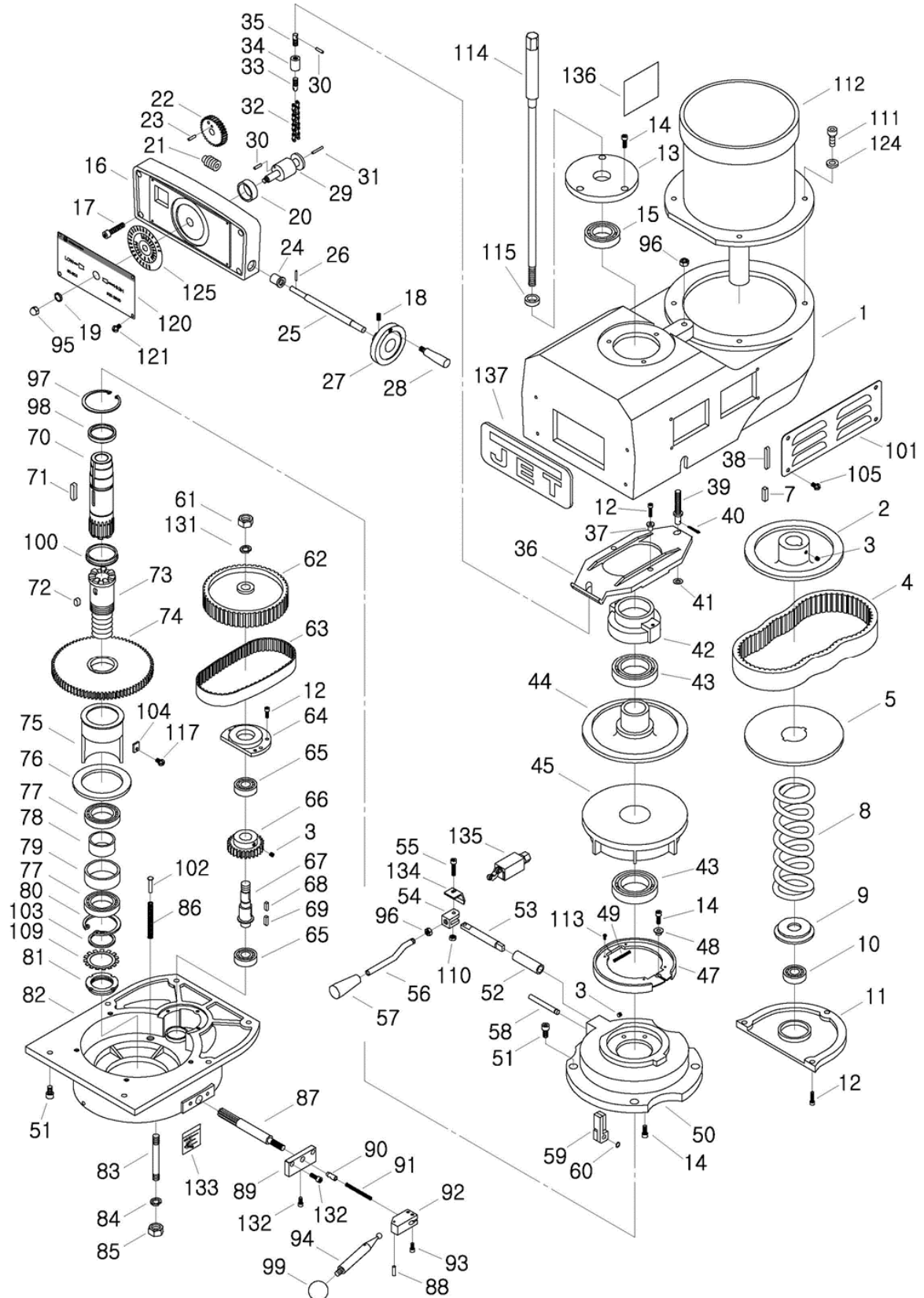


JTM-1254VS shown

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### 12.1.1 JTM-1254VS Upper Head Assembly – Exploded View



## 12.1.2 JTM-1254VS Upper Head Assembly – Parts List

| Index No | Part No        | Description                             | Size       | Qty |
|----------|----------------|---|------------|-----|
| 1        | JTM1254VS-A01  | Upper Pulley Housing                    |            | 1   |
| 2        | JTM1254VS-A02  | Motor Disc - Upper                      |            | 1   |
| 3        | TS-1523011     | Set Screw                               | M6x6L      | 4   |
| 4        | JTM1254VS-A04  | Belt                                    |            | 1   |
| 5        | JTM1254VS-A05  | Motor Disc - Lower                      |            | 1   |
| 7        | 6295247        | Key                                     | 7x7x25L    | 1   |
| 8        | JTM1254VS-A08  | Spring                                  |            | 1   |
| 9        | JTM1254VS-A09  | Washer                                  |            | 1   |
| 10       | BB-6204ZZ      | Ball Bearing                            | 6204ZZ     | 1   |
| 11       | JTM1254VS-A11  | Pulley Cover                            |            | 1   |
| 12       | TS-1503041     | Hex Socket Cap Screw                    | M6x16L     | 4   |
| 13       | JTM1254VS-A13  | Upper Cover                             |            | 1   |
| 14       | TS-1503041     | Hex Socket Cap Screw                    | M6x16L     | 10  |
| 15       | BB-6009ZZ      | Ball Bearing                            | 6009ZZ     | 1   |
| 16       | JTM1254VS-A16  | Dial Housing                            |            | 1   |
| 17       | TS-1503071     | Hex Socket Cap Screw                    | M6x30L     | 4   |
| 18       | TS-1523051     | Set Screw                               | M6x16L     | 2   |
| 19       | JTM1254VS-A19  | Bushing                                 |            | 1   |
| 20       | JTM1254VS-A20  | Spacer                                  |            | 1   |
| 21       | JTM1254VS-A21  | Worm                                    |            | 1   |
| 22       | JTM1254VS-A22  | Worm Gear                               |            | 1   |
| 23       | 5301041        | Spring Pin                              | Ø5x10L     | 2   |
| 24       | JTM1254VS-A24  | Bushing                                 |            | 2   |
| 25       | JTM1254VS-A25  | Shaft                                   |            | 1   |
| 26       | 5302611        | Spring Pin                              | Ø3x12L     | 1   |
| 27       | JTM1254VS-A27  | Handwheel                               |            | 1   |
|          | JTM1254VS-A27A | Handwheel Assembly (includes #18,27,28) |            | 1   |
| 28       | JTM1254VS-A28  | Handle                                  |            | 1   |
| 29       | JTM1254VS-A29  | Chain Axle                              |            | 1   |
| 30       | 5509313        | Spring Pin                              | Ø4x16L     | 2   |
| 31       | GA7X-865       | Spring Pin                              | Ø3x25L     | 1   |
| 32       | JTM1254VS-A32  | Chain                                   |            | 1   |
| 33       | JTM1254VS-A33  | Screw                                   |            | 1   |
| 34       | JTM1254VS-A34  | Spacer                                  |            | 1   |
| 35       | JTM1254VS-A35  | Pin                                     |            | 1   |
| 36       | JTM1254VS-A36  | Adjustable Plate                        |            | 1   |
| 37       | JTM1254VS-A37  | Shift Sleeve                            |            | 2   |
| 38       | 6294761        | Key                                     | 6x6x45L    | 1   |
| 39       | JTM1254VS-A39  | Bottom Pin                              |            | 1   |
| 40       | 5307431        | Spring Pin                              | 3/32"x3/4" | 1   |
| 41       | JTM1254VS-A41  | Flat Washer                             | Ø8.5       | 1   |
| 42       | JTM1254VS-A42  | Bearing Housing                         |            | 1   |
| 43       | BB-6010ZZ      | Ball Bearing                            | 6010ZZ     | 2   |
| 44       | JTM1254VS-A44  | Spindle Disc - Upper                    |            | 1   |
| 45       | JTM1254VS-A45  | Spindle Disc - Lower                    |            | 1   |
| 47       | JTM1254VS-A47  | Brake Lining                            |            | 1   |
| 48       | JTM1254VS-A48  | Lock Collar                             |            | 1   |
| 49       | JTM1254VS-A49  | Spring                                  |            | 1   |
| 50       | JTM1254VS-A50  | Brake Seat                              |            | 1   |
| 51       | TS-1504041     | Hex Socket Cap Screw                    | M8x20L     | 10  |
| 52       | JTM949EVS-A53  | Brake Sleeve                            |            | 1   |
| 53       | JTM949EVS-A54  | Spindle Brake Shaft                     |            | 1   |
| 54       | JTM949EVS-A56  | Spindle Brake Lever Pivot               |            | 1   |
| 55       | TS-1503071     | Hex Socket Cap Screw                    | M6x30L     | 1   |
| 56       | JTM1254VS-A56  | Spindle Brake Lever                     |            | 1   |
| 57       | JTM949EVS-A50  | Brake Lever Knob                        | 3/8"       | 1   |
| 58       | JTM1254VS-A58  | Hand Rod                                |            | 1   |
| 59       | JTM1254VS-A59  | Brake Bracket                           |            | 1   |
| 60       | JTM949EVS-A46  | Retaining Ring                          | STW8       | 1   |
| 61       | TS-0561072     | Hex Nut                                 | 5/8-18UNF  | 1   |

| Index No | Part No          | Description                                    | Size            | Qty |
|----------|------------------|--|-----------------|-----|
| 62       | JTM1254VS-A62    | Timing Wheel                                   |                 | 1   |
| 63       | JTM1254VS-A63    | Timing Belt                                    |                 | 1   |
| 64       | JTM1254VS-A64    | Bearing Seat                                   |                 | 1   |
| 65       | BB-6203ZZ        | Ball Bearing                                   | 6203ZZ          | 2   |
| 66       | JTM1254VS-A66    | Pinion   |                 | 1   |
| 67       | JTM1254VS-A67    | Gear Shaft                                     |                 | 1   |
| 68       | KF2R5515         | Double Round Key                               | 5x5x15L         | 1   |
| 69       | KF2R5518         | Double Round Key                               | 5x5x18L         | 1   |
| 70       | JTM1254VS-A70    | Input Clutch                                   |                 | 1   |
| 71       | 5307741          | Key  | 8x7x24L         | 1   |
| 72       | KF2R8712         | Key  | 8x7x12L         | 1   |
| 73       | JTM1254VS-A73    | Output Clutch                                  |                 | 1   |
| 74       | JTM1254VS-A74    | Gear   |                 | 1   |
| 75       | JTM1254VS-A75    | Bearing Housing                                |                 | 1   |
| 76       | JTM1254VS-A76    | Washer   |                 | 1   |
| 77       | BB-6912ZZ        | Ball Bearing                                   | 6912ZZ          | 2   |
| 78       | JTM1254VS-A78    | Spacer (Small)                                 |                 | 1   |
|          | JTM1254VS-A78A   | Gear Bearing Spacer Assembly (includes #78,79) |                 | 1   |
| 79       | JTM1254VS-A79    | Spacer (Large)                                 |                 | 1   |
| 80       | RTW62            | Retaining Ring                                 | RTW62           | 1   |
| 81       | AN08             | Bearing Nut                                    | AN08            | 1   |
| 82       | JTM1254VS-A82    | Upper Pulley Housing                           |                 | 1   |
| 83       | JTM1254VS-A83    | Stud   | 7/16x4"         | 3   |
| 84       | TS-0720101       | Spring Washer                                  | 7/16"           | 3   |
| 85       | TS-0561041       | Hex Nut  | 7/16"           | 3   |
| 86       | JTM1254VS-A86    | Spring   |                 | 3   |
| 87       | JTM949EVS-A03    | Bull Gear Shifter Pinion Shaft                 |                 | 1   |
| 88       | B-56             | Spring Pin                                     | Ø3x20L          | 1   |
| 89       | JTM949EVS-A04    | Hi-Lo Detent Plate                             |                 | 1   |
| 90       | JTM949EVS-A05    | Sleeve   |                 | 1   |
| 91       | JTM949EVS-A06    | Spring   |                 | 1   |
| 92       | JTM949EVS-A08    | Hi-Lo Pinion Block                             |                 | 1   |
| 93       | TS-1502031       | Hex Socket Cap Screw                           | M5x12           | 2   |
| 94       | JTM949EVS-A09    | Hi-Lo Shift Handle                             |                 | 1   |
| 95       | F004478          | Cap Nut  | 5/16"-18UNC     | 1   |
| 96       | TS-0570031       | Hex Nut  | 3/8"-16UNC      | 2   |
| 97       | RTW80            | Retaining Ring                                 | RTW80           | 1   |
| 98       | JTM1254VS-A98    | Collar   |                 | 1   |
| 99       | BH1/4            | Black Plastic Ball                             | 1/4"            | 1   |
| 100      | JTM1254VS-A100   | Clutch Collar                                  |                 | 1   |
| 101      | JTM1254VS-A101   | Pulley Cover                                   |                 | 2   |
| 102      | JTM1254VS-A102   | Spring Shaft                                   |                 | 3   |
| 103      | JTM1254VS-A103   | Spacer   |                 | 1   |
| 104      | JTM1254VS-A104   | Square Nut                                     |                 | 1   |
| 105      | 5712561          | Pan Head Screw                                 | M5x8L           | 8   |
| 109      | AW08             | Bearing Washer                                 | AW08            | 1   |
| 110      | TS-1540041       | Nut  | M6              | 1   |
| 111      | TS-1209051       | Hex Socket Cap Screw                           | 3/8"x1"L        | 4   |
| 112      | JTM1254VS-A112   | Motor  | 3.75kW,5 HP,3Ph | 1   |
|          | JTM1254VS-A112-1 | Motor Fan (not shown)                          |                 | 1   |
|          | JTM1254VS-A112-2 | Motor Fan Cover (not shown)                    |                 | 1   |
|          | JTM1254VS-A112-3 | Junction Box Cover (not shown)                 |                 | 1   |
| 113      | JTM949EVS-A51    | Pan Head Screw                                 | 1/8"x1/4"L      | 4   |
| 114      | JTM1254VS-A114   | Draw Bar                                       | 5/8"            | 1   |
| 115      | JTM1254VS-A115   | Spacer   |                 | 1   |
| 117      | VS-117           | Pan Head Screw                                 | 3/16"x1/2"L     | 1   |
| 120      | JTM1254VS-A120   | Speed Plate                                    |                 | 1   |
| 121      | TS-2284202       | Pan Head Screw                                 | M4x20L          | 4   |
| 124      | TS-1550071       | Flat Washer                                    | Ø10mm           | 4   |
| 125      | JTM1254VS-A125   | Speed Dial                                     |                 | 1   |
| 131      | TS-0720131       | Spring Washer                                  | 5/8"            | 1   |
| 132      | TS-1502041       | Hex Socket Cap Screw                           | M5x16L          | 3   |

| <b>Index No</b> | <b>Part No</b> | <b>Description</b> | <b>Size</b> | <b>Qty</b> |
|-----------------|----------------|--------------------|-------------|------------|
| 133             | LM000005       | Speed Range Label  |             | 1          |
| 134             | JTM949EVS-A91  | Push Plate         |             | 1          |
| 135             | JTM949EVS-A92  | Limit Switch       |             | 1          |
| 136             | LM000182       | Motor Label        |             | 1          |
| 137             | JET-165        | JET Logo           | 165x68 mm   | 1          |

12.3.1 JTM-1254VS Lower Head Assembly – Exploded View



### 12.3.2 JTM-1254VS Lower Head Assembly – Parts List

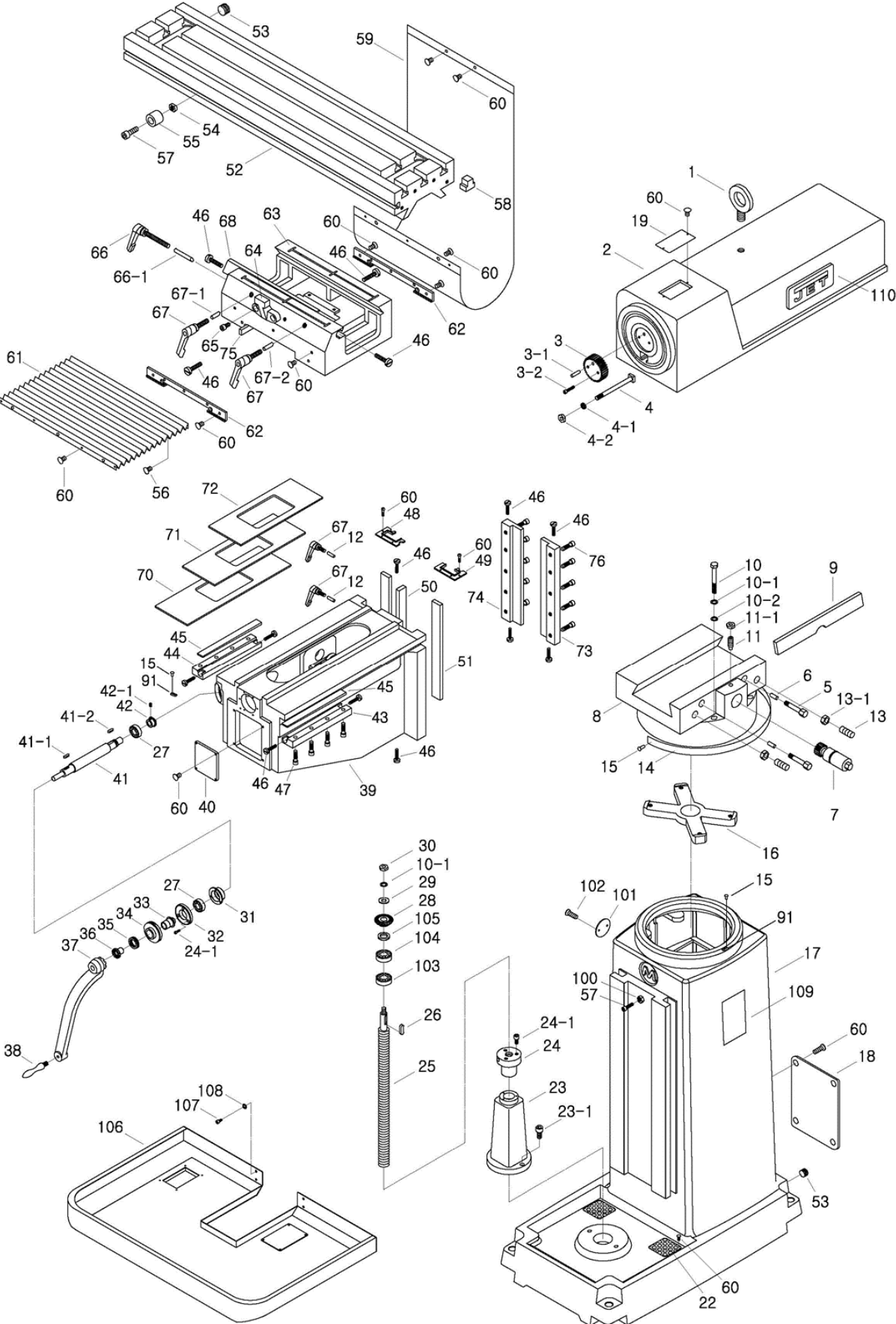
| Index No | Part No         | Description  | Size        | Qty |
|----------|-----------------|--|-------------|-----|
| 1        | TS-1502031      | Hex Socket Cap Screw                                     | M5x12L      | 6   |
| 2        | JTM949EVS-B02   | Flat Washer  | Ø5          | 1   |
| 3        | JTM1254VS-B03   | Feed Gear  |             | 1   |
| 4        | JTM1254VS-B04   | Shaft Sleeve   |             | 1   |
| 5        | JTM1254VS-B05   | Worm Cradle Bushing                                      |             | 1   |
| 6        | JTM1254VS-B06   | Worm Gear Spacer   |             | 1   |
| 7        | KF2R3320        | Key  | 3x3x20L     | 1   |
| 8        | JTM1254VS-B08   | Feed Drive Worm Gear                                     |             | 1   |
| 9        | JTM1254VS-B09   | Worm Gear Shaft  |             | 1   |
| 9-1      | 5308721         | Worm Shaft Key   | 3x3x10L     | 1   |
| 10       | JTM1254VS-B10   | Hex Socket Cap Screw                                     | 5/16"x1/2"L | 1   |
| 11       | JTM1254VS-B11   | Washer   | 5/16"       | 1   |
| 12       | JTM1254VS-B12   | Feed Reverse Bevel Gear                                  |             | 1   |
| 13       | JTM1254VS-B13   | Worm Gear Cradle   |             | 1   |
| 14       | JTM1254VS-B14   | Feed Engage Pin  |             | 1   |
| 15       | JTM949EVS-B18   | Cam Rod  |             | 1   |
| 16       | JTM949EVS-B19   | Shift Sleeve   |             | 1   |
| 17       | JTM949EVS-B20   | Lock Rod   |             | 2   |
| 18       | JTM1254VS-B18   | Feed Drive Gear  |             | 1   |
|          | JTM1254VS-B18A  | Feed Drive Gear Assembly (includes #18,18-1 and 19)      |             | 1   |
| 18-1     | KF2R5508        | Key  | 5x5x8L      | 1   |
| 19       | KF2R5512        | Key  | 5x5x12L     | 1   |
| 20       | JTM1254VS-B20   | Needle Bearing   | BA66        | 1   |
| 21       | JTM1254VS-B21   | Upper Bushing  |             | 1   |
| 22       | JTM1254VS-B22   | Cluster Gear   |             | 1   |
| 23       | JTM1254VS-B23   | Bevel Gear Shaft   |             | 1   |
| 23-1     | KF2R4445        | Key  | 4x4x45L     | 1   |
| 24       | JTM1254VS-B24   | Bevel Gear Bushing                                       |             | 1   |
| 25       | JTM1254VS-B25   | Spacer   |             | 1   |
| 26       | JTM1254VS-B26   | Feed Drive Gear  | TA2620Z     | 1   |
| 27       | JTM1254VS-B27   | Bushing  |             | 1   |
| 28       | JTM1254VS-B28   | Worm   |             | 1   |
| 28-1     | JTM1254VS-B28-1 | Spring Pin   |             | 1   |
| 29       | JTM1254VS-B29   | Feed Worm Shaft Bushing                                  |             | 1   |
| 30       | JTM1254VS-B30   | Bevel Gear Thrust Spacer                                 |             | 1   |
| 31       | JTM1254VS-B31   | Bushing  |             | 2   |
| 32       | JTM1254VS-B32   | Feed Reverse Bevel Gear                                  |             | 2   |
| 33       | JTM1254VS-B33   | Feed Reverse Clutch                                      |             | 1   |
| 33-1     | JTM1254VS-B33-1 | Spring Pin   |             | 1   |
| 34       | TS-1502021      | Hex Socket Cap Screw                                     | M5x10L      | 4   |
| 35       | JTM949EVS-B66   | Cluster Gear Cover                                       |             | 1   |
| 35-1     | TS-1522031      | Socket Set Screw   | M5x10L      | 1   |
| 36       | JTM949EVS-B60   | Feed Shift Rod   |             | 1   |
| 37       | JTM1254VS-B37   | Cluster Gear Shift Crank                                 |             | 1   |
| 38       | JTM1254VS-B38   | Feed Gear Shift Fork                                     |             | 1   |
| 39       | JTM949EVS-B23   | Crank  |             | 2   |
| 40       | 5302731         | Socket Set Screw   | M8x6        | 2   |
| 41       | JTM1254VS-B41   | Feed Worm Shaft  |             | 1   |
| 41-1     | KF2R5515        | Key  | 5x5x15L     | 1   |
| 41-2     | JVM836B79-2     | Key  | 5x5x10L     | 1   |
| 42       | JTM1254VS-B42   | Reverse Clutch Rod                                       |             | 1   |
| 43       | JTM1254VS-B43   | Pinion Shaft   |             | 1   |
| 44       | JTM1254VS-B44   | Overload Clutch Worm Gear                                |             | 1   |
| 44-1     | JTM1254VS-B44-1 | Screw  |             | 3   |
| 45       | JTM1254VS-B45   | Overload Clutch Ring                                     |             | 1   |
| 46       | JTM1254VS-B46   | Overload Clutch Sleeve                                   |             | 1   |
|          | JTM1254VS-B46A  | Overload Clutch Assembly (includes #46,47,49, 49-1,49-2) |             | 1   |
| 46-1     | KF2R5516        | Key  | 5x5x16L     | 1   |
| 47       | JTM1254VS-B47   | Overload Clutch  |             | 1   |
| 48       | JTM1254VS-B48   | Safety Clutch Spring                                     |             | 1   |

| Index No | Part No         | Description                                     | Size            | Qty |
|----------|-----------------|---|-----------------|-----|
| 49       | JTM1254VS-B49   | Overload Clutch Lockout                         |                 | 1   |
| 49-1     | TS-2276081      | Set Screw                                       | M6x8L           | 1   |
| 49-2     | JTM1254VS-B49-2 | Lock Block                                      |                 | 1   |
| 50       | JTM1254VS-B50   | Clutch Ring                                     |                 | 1   |
| 51       | GA7X-122        | Spring Pin                                      | Ø5x20L          | 1   |
| 52       | JTM1254VS-B52   | Trip Lever                                      |                 | 1   |
| 53       | JTM1254VS-B53   | Clutch Ring Pin                                 |                 | 2   |
| 54       | JTM1254VS-B54   | Washer  |                 | 1   |
| 55       | STW10           | Retaining Ring                                  | STW10           | 1   |
| 56       | JTM1254VS-B56   | Clutch Arm Cover                                |                 | 1   |
| 57       | JTM1254VS-B57   | Nose Piece                                      |                 | 1   |
| 58       | JTM1254VS-B58   | Spindle Shield                                  |                 | 1   |
| 59       | BB-7010ZZ       | Ball Bearing                                    | 7010ZZ          | 2   |
| 60       | JTM1254VS-B60   | Bearing Spacer (Large)                          |                 | 1   |
| 61       | JTM1254VS-B61   | Bearing Spacer (Small)                          |                 | 1   |
| 62       | JTM1254VS-B62   | Quill   |                 | 1   |
| 62-1     | 5308081         | Set Screw                                       | M5x5L           | 1   |
| 63       | TS-1523011      | Set Screw                                       | M6x6L           | 2   |
| 64       | AN10            | Bearing Nut                                     | AN10            | 1   |
| 65       | BB-6008ZZ       | Ball Bearing                                    | 6008ZZ          | 1   |
| 65-1     | TS-1533032      | Pan Head Cross Screw                            | M5x10L          | 2   |
| 65-2     | 2210-255        | Retaining Ring                                  | STW40           | 1   |
| 66       | JTM1254VS-B66   | Quill Skirt                                     |                 | 1   |
| 67       | JTM1254VS-B67   | Spindle   | NT40            | 1   |
| 68       | BH1/4           | Black Plastic Ball                              | 1/4"            | 3   |
| 69       | JTM949EVS-B104  | Trip Handle                                     |                 | 1   |
| 70       | JTM1254VS-B70   | Cam Rod   |                 | 1   |
| 71       | JTM1254VS-B71   | Feed Trip Bracket                               |                 | 1   |
| 72       | JTM1254VS-B72   | Handwheel Clutch                                |                 | 1   |
| 73       | 5302731         | Set Screw                                       | M8x6L           | 1   |
| 74       | ETW6            | Retaining Ring                                  | ETW6            | 1   |
| 75       | JTM1254VS-B75   | Feed Reverse Stud                               |                 | 1   |
|          | JTM1254VS-B75A  | Feed Reverse Stud Assembly (includes #74,75,76) |                 | 1   |
| 76       | JTM1254VS-B76   | Feed Reverse Bolt                               |                 | 1   |
| 77       | JTM1254VS-B77   | Cast Handwheel                                  |                 | 1   |
| 77A      | JTM1254VS-B77HA | Handwheel Assembly (includes #77,78)            |                 | 1   |
| 78       | JTM1254VS-B78   | Handle  |                 | 1   |
| 79       | JTM1254VS-B79   | Feed Trip Plunger                               |                 | 1   |
| 80       | JTM1254VS-B80   | Bushing   |                 | 1   |
| 81       | JTM1254VS-B81   | Trip Plunger                                    |                 | 1   |
| 82       | JTM949EVS-B21   | Spring  |                 | 3   |
| 83       | JTM1254VS-B83   | Cam Rod Sleeve Assembly                         |                 | 1   |
| 84       | JTM1254VS-B84   | Micrometer Scale                                |                 | 1   |
| 84-1     | TS-2171012      | Pan Head Cross Screw                            | M4x6L           | 2   |
| 85       | JTM1254VS-B85   | Quill Lock Sleeve                               |                 | 1   |
| 85-1     | JTM1254VS-B85-1 | Spring  |                 | 1   |
| 86       | JTM1254VS-B86   | Quill Lock Sleeve                               |                 | 1   |
| 87       | JTM1254VS-B87   | Lock Handle                                     |                 | 1   |
| 88       | JTM1254VS-B88   | Quill Stop Block                                |                 | 1   |
| 88-1     | TS-0209032      | Hex Socket Cap Screw                            | 3/8"-24UNFx3/4" | 1   |
| 89       | JTM949EVS-B162  | Micrometer Nut                                  |                 | 1   |
| 91       | JTM949EVS-B164  | Quill Micro-Screw                               |                 | 1   |
| 91-1     | STW16           | Retaining Ring                                  | STW16           | 2   |
| 92       | JTM949EVS-B77   | Ball Grip                                       |                 | 1   |
| 93       | JTM949EVS-B84   | Handle  |                 | 1   |
| 94       | JTM949EVS-B138  | Hub   |                 | 1   |
| 94-1     | TS-0270031      | Set Screw                                       | 5/16"x3/8"      | 1   |
| 94-2     | JTM1254VS-B94-2 | Spring  |                 | 1   |
| 94-3     | SB-3/16         | Steel Ball                                      | 3/16 in.        | 1   |
| 95       | JTM1254VS-B95   | Hub Sleeve                                      |                 | 1   |
| 96       | JTM1254VS-B96   | Spring Cover                                    |                 | 1   |
| 97       | JTM1254VS-B97   | Adjustable Spring                               |                 | 1   |



| Index No | Part No         | Description                                     | Size     | Qty |
|----------|-----------------|---|----------|-----|
| 98       | JTM1254VS-B98   | Quill Pinion Shaft                              |          | 1   |
|          | JTM1254VS-B98A  | Quill Pinion Shaft Assembly (includes #98,98-2) |          | 1   |
| 98-1     | KF2R5525        | Key   | 5x5x25L  | 1   |
| 98-2     | JTM1254VS-B98-2 | T type Pin                                      |          | 1   |
| 99       | JTM1254VS-B99   | Pinion Shaft Hub                                |          | 1   |
| 100      | JTM1254VS-B100  | Trip Lever Pin                                  |          | 1   |
| 101      | JTM1254VS-B101  | Rod   |          | 1   |
| 102      | JTM1254VS-B102  | Lever   |          | 1   |
| 103      | JTM1254VS-B103  | Screw   |          | 1   |
| 104      | JTM1254VS-B104  | Feed Trip Lever                                 |          | 1   |
| 105      | JTM1254VS-B105  | Quill Housing                                   |          | 1   |
| 106      | TS-1523021      | Set Screw                                       | M6x8L    | 1   |
| 107      | TS-1502081      | Hex Socket Cap Screw                            | M5x35L   | 2   |
| 108      | TS-1523051      | Set Screw                                       | M6x16L   | 1   |
| 109      | TS-2311061      | Hex Nut   | M6       | 1   |
| 110      | STW22           | Retaining Ring                                  | STW22    | 1   |
| 111      | TS-1521071      | Set Screw                                       | M4x20L   | 1   |
| 112      | TS-1540021      | Hex Nut   | M4       | 1   |
| 113      | TS-1502051      | Hex Socket Cap Screw                            | M5x20L   | 1   |
| 114      | TS-1540031      | Hex Nut   | M5       | 1   |
| 115      | JTM1254VS-B115  | Spring Pin                                      |          | 1   |
| 116      | 5302611         | Spring Pin                                      | Ø3x12L   | 1   |
| 117      | KF2R3312        | Key   | 3x3x12L  | 1   |
| 118      | TS-1523011      | Socket Set Screw                                | M6x6     | 1   |
| 119      | JTM1254VS-B119  | Spring  |          | 1   |
| 120      | SB-3/16         | Steel Ball                                      | 3/16 in. | 1   |
| 121      | TS-1503051      | Hex Socket Cap Screw                            | M6x20    | 2   |
| 122      | 5625391         | Spring Pin                                      | Ø5x16L   | 1   |
| 123      | JTM1254VS-B123  | Worm Gear                                       |          | 1   |
| 124      | JTM1254VS-B124  | Worm Shaft                                      |          | 1   |
|          | JTM1254VS-B124A | Worm Shaft Assembly (includes #124,125,126)     |          | 1   |
| 125      | KF2R4418        | Key   | 4x4x18L  | 1   |
| 126      | JTM1254VS-B126  | Set Screw                                       |          | 1   |
| 127      | JTM949EVS-B25   | Indicator Rod                                   |          | 1   |
| 128      | JTM949EVS-B26   | Indicator Rod Screw                             |          | 1   |
| 129      | JTM1254VS-B129  | Stop Block                                      |          | 2   |
| 130      | TS-1504041      | Hex Socket Cap Screw                            | M8x20L   | 2   |

### 12.5.1 JTM-1254VS Base Machine – Exploded View



## 12.5.2 JTM-1254VS Base Machine – Parts List

| Index No | Part No        | Description             | Size              | Qty |
|----------|----------------|-------------------------|-------------------|-----|
| 1        | JTM1050EVS-C01 | Lifting Ring            | M24               | 1   |
| 2        | JTM1254VS-C02  | Ram                     |                   | 1   |
| 3        | JTM949EVS-C02  | Worm Gear               |                   | 1   |
| 3-1      | 5501115        | Spring Pin              | Ø6x30L            | 1   |
| 3-2      | TS-1504061     | Hex Socket Cap Screw    | M8x30L            | 2   |
| 4        | JTM1254VS-C04  | Bolt                    | 5/8"              | 4   |
| 4-1      | TS-2361161     | Spring Washer           | Ø16               | 4   |
| 4-2      | TS-0561071     | Hex Nut                 | 5/8"              | 4   |
| 5        | JTM1254VS-C05  | Ram Lock Bolt           |                   | 2   |
| 6        | JTM1254VS-C06  | Ram Lock Plunger        |                   | 2   |
| 7        | JTM1254VS-C07  | Ram Pinion              |                   | 1   |
| 8        | JTM1254VS-C08  | Turret                  |                   | 1   |
| 9        | JTM1254VS-C09  | Ram/Turret Gib          |                   | 1   |
| 10       | JTM1254VS-C10  | Hex Head Screw          | M12x185L          | 4   |
| 10-1     | TS-2361121     | Spring Washer           | Ø12               | 5   |
| 10-2     | JTM949EVS-B120 | Flat Washer             | Ø13               | 4   |
| 11       | JWS35X-222     | Socket Set Screw        | M8x30L            | 1   |
| 11-1     | TS-1540061     | Hex Nut                 | M8                | 1   |
| 12       | JTM1254VS-C12  | Knee Lock Plunger       |                   | 2   |
| 13       | JTM1254VS-C13  | Set Screw               | M10x60L           | 2   |
| 13-1     | TS-2331101     | Hex Nut                 | M10               | 2   |
| 14       | JTM1254VS-C14  | Turret Scale            |                   | 1   |
| 15       | RN2L6          | Rivet                   | Ø2x6L             | 6   |
| 16       | JTM1254VS-C16  | Spider                  |                   | 1   |
| 17       | JTM1254VS-C17  | Column                  |                   | 1   |
| 18       | JTM1254VS-C18  | Plate                   |                   | 1   |
| 19       | JTM1254VS-C19  | Ram Cover               |                   | 1   |
| 22       | JTM1254VS-C22  | Strainer Net            |                   | 2   |
| 23       | JTM1254VS-C23  | Elevating Screw Housing |                   | 1   |
| 23-1     | TS-1505071     | Hex Socket Cap Screw    | M10x45L           | 2   |
| 24       | JTM1254VS-C24  | Elevating Nut (Inch)    | Ø32 x 5 tpi       | 1   |
| 24-1     | TS-1503051     | Hex Socket Cap Screw    | M6x20L            | 6   |
| 25       | JTM1254VS-C25  | Lead Screw (Inch)       | Ø35 x 5tpi (590L) | 1   |
| 26       | KF2R5520       | Key                     | 5x5x20L           | 1   |
| 27       | BB-6204ZZ      | Bearing                 | 6204ZZ            | 2   |
| 28       | JTM949EVS-C58  | Bevel Gear              | 36T               | 1   |
| 29       | JTM1254VS-C29  | Washer                  | Ø13xØ32x5t        | 1   |
| 30       | JTM1254VS-C30  | Hex Nut                 | 1/2-20UNF         | 1   |
| 31       | JTM1254VS-C31  | Bearing Seat            |                   | 1   |
| 32       | JTM1254VS-C32  | Cover                   |                   | 1   |
| 33       | JTM1254VS-C33  | Dial Holder             |                   | 1   |
| 34       | JTM1254VS-C34  | Dial (Inch)             | 100/0.001"        | 1   |
| 35       | JTM1254VS-C35  | Dial Lock Nut           |                   | 1   |
| 36       | JTM1254VS-C36  | Clutch Insert           |                   | 1   |
| 37       | JTM1050EVS2-75 | Elevating Crank         |                   | 1   |
| 38       | JTM949EVS-C62  | Handle                  |                   | 1   |
| 39       | JTM1254VS-C39  | Knee                    |                   | 1   |
| 40       | JTM1254VS-C40  | Knee Cover              |                   | 1   |
| 41       | JTM1254VS-C41  | Elevating Shaft         |                   | 1   |
| 41-1     | 5308721        | Key                     | 3x3x10L           | 1   |
| 41-2     | 5510498        | Key                     | 4x4x16L           | 1   |
| 42       | JTM949EVS-C74  | Bevel Gear              | 18T               | 1   |
| 42-1     | TS-1523031     | Socket Set Screw        | M6x10L            | 1   |
| 43       | JTM1254VS-C43  | Support Plate-R         |                   | 1   |
| 44       | JTM1254VS-C44  | Support Plate-L         |                   | 1   |
| 45       | JTM1254VS-C45  | Gib                     |                   | 2   |
| 46       | JTM1254VS-C46  | Adjusting Screw         |                   | 14  |
| 47       | TS-1506041     | Hex Socket Cap Screw    | M12x35L           | 8   |
| 48       | JTM1254VS-C48  | Knee Wiper (left)       |                   | 1   |

| Index No | Part No         | Description                       | Size              | Qty |
|----------|-----------------|-----------------------------------|-------------------|-----|
| 49       | JTM1254VS-C49   | Knee Wiper (right)                |                   | 1   |
| 50       | JTM1254VS-C50   | Knee/ Column Gib                  |                   | 1   |
| 51       | JTM1254VS-C51   | Knee/ Column Gib                  |                   | 2   |
| 52       | JTM1254VS-C52   | Table                             | 12"x54"           | 1   |
| 53       | JTM1254VS-C53   | Oil Plug                          | 1/2"PT            | 3   |
| 54       | JTM1254VS-C54   | Nut                               |                   | 2   |
| 55       | JTM1254VS-C55   | Bushing                           |                   | 2   |
| 57       | TS-1505041      | Hex Socket Cap Screw              | M10x30L           | 3   |
| 58       | JTM1254VS-C58   | T-Rubber                          |                   | 6   |
| 59       | JTM1254VS-C59   | Flat Way Cover (Rear)             |                   | 1   |
| 60       | TS-2245102      | Socket Head Button Screw          | M5x10L            | 39  |
| 61       | JTM1254VS-C61   | Pleated Way Cover (Front)         |                   | 1   |
| 62       | JTM1254VS-C62   | Wiper                             |                   | 2   |
| 63       | JTM1254VS-C63   | Saddle                            |                   | 1   |
| 64       | JTM1254VS-C64   | Table Stop Bracket                |                   | 1   |
| 65       | TS-1505011      | Hex Socket Cap Screw              | M10X16L           | 2   |
| 66       | JTM1254VS-C66   | Lock Handle                       |                   | 1   |
| 66-1     | JTM1254VS-C66-1 | Saddle Lock Plunger               |                   | 1   |
| 67       | JTM1254VS-C67   | Lock Handle                       | M12x25L           | 4   |
| 67-1     | JTM1254VS-C67-1 | Table Lock Plunger 1              |                   | 1   |
| 67-2     | JTM1254VS-C67-2 | Table Lock Plunger 2              |                   | 1   |
| 68       | JTM1254VS-C68   | Gib                               |                   | 1   |
| 70       | JTM1254VS-C70   | Chip Guard (Bottom)               | 680 mm (129x2.0T) | 1   |
| 71       | JTM1254VS-C71   | Chip Guard (Middle)               | 565 mm (129x2.0T) | 1   |
| 72       | JTM1254VS-C72   | Chip Guard (Top)                  | 430 mm (129x2.0T) | 1   |
| 73       | JTM1254VS-C73   | Knee Support Plate (Right)        |                   | 1   |
| 74       | JTM1254VS-C74   | Knee Support Plate (Left)         |                   | 1   |
| 75       | JTM1254VS-C75   | Gib                               |                   | 1   |
| 76       | F005475         | Hex Socket Cap Screw              | M14x35L           | 10  |
| 91       | JTM1254VS-C91   | Pointer                           |                   | 2   |
| 100      | TS-1540071      | Hex Nut                           | M10               | 1   |
| 101      | JTM949EVS-C84   | Side Cover                        |                   | 1   |
| 102      | TS-1503031      | Socket Head Button Screw          | M6x12L            | 2   |
| 103      | BB-51305        | Bearing                           | 51305             | 1   |
| 104      | BB-6205ZZ       | Ball Bearing                      | 6205ZZ            | 1   |
| 105      | JTM949EVS-C44   | Washer                            |                   | 1   |
| 106      | JTM1254VS-C106  | Chip Pan                          |                   | 1   |
| 107      | TS-1504031      | Hex Socket Cap Screw              | M6x12L            | 4   |
| 108      | TS-1550041      | Flat Washer                       | Ø6                | 4   |
| 109      | LM000183        | ID/Warning Label, JTM-1254VS      |                   | 1   |
| 110      | JET-254         | JET Logo                          | 254x105 mm        | 2   |
|          | JTM1254VS-TB    | Tool Box Kit Complete (not shown) |                   | 1   |

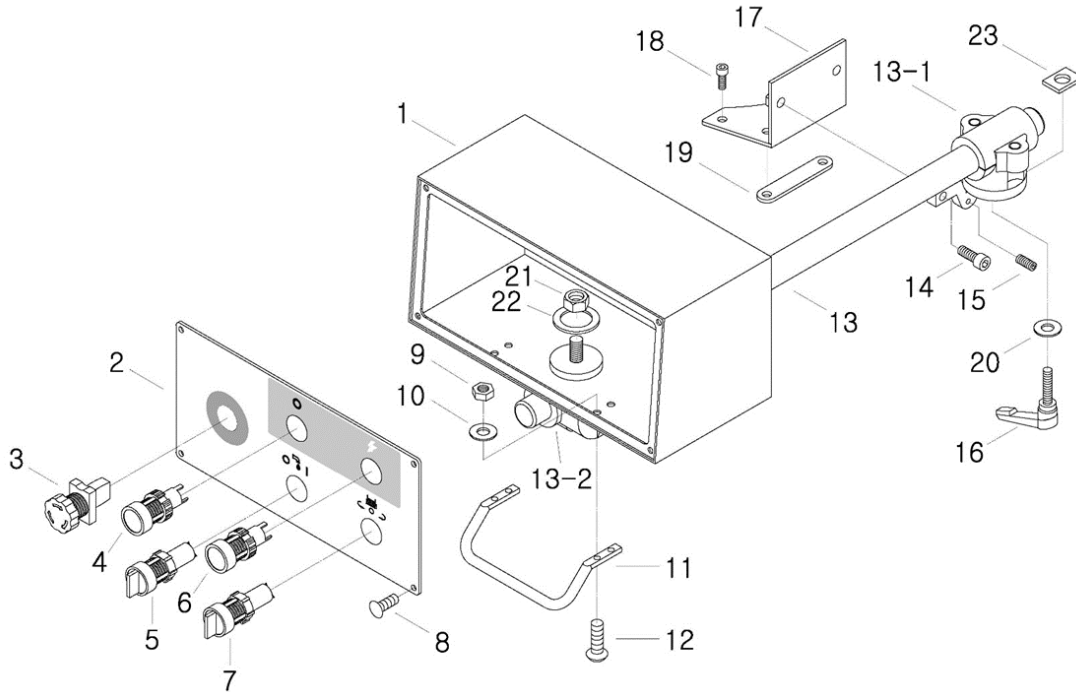
## 12.7.1 JTM-1254VS/RVS Table Assembly – Exploded View



## 12.7.2 JTM-1254VS/RVS Table Assembly – Parts List

| Index No | Part No         | Description                         | Size               | Qty |
|----------|-----------------|-------------------------------------|--------------------|-----|
| 1        | TS-0561052      | Nut                                 | 1/2-20UNF          | 3   |
| 2        | JTM949EVS-D02   | Handle                              | 3/8"               | 3   |
|          | JTM949EVS-D03A  | Ball Crank Assembly (includes #2,3) |                    | 1   |
| 3        | JTM949EVS-D03   | Ball Crank                          |                    | 3   |
| 4        | JTM949EVS-D04   | Dial Lock Nut                       |                    | 3   |
| 5        | JTM949EVS-D05   | Dial (Inch)                         | 200/0.001"         | 3   |
| 6        | JTM949EVS-D06   | Dial Holder                         | 3mm / 56.6L        | 3   |
| 7        | TS-1503031      | Hex Socket Cap Screw                | M6x12              | 9   |
| 8        | JTM949EVS-D08   | Cover                               |                    | 3   |
| 9        | BB-6204ZZ       | Ball Bearing                        | 6204ZZ             | 5   |
| 10       | JTM949EVS-D10   | Bearing Bracket                     | Ø60                | 2   |
| 11       | 5311251         | Spring Pin                          | Ø5x30              | 6   |
| 12       | TS-1505011      | Hex Socket Cap Screw                | M10x16             | 16  |
| 13       | KF2R3325        | Key                                 | 3x3x25             | 3   |
| 14       | JTM1254VS-D14   | Lead Screw                          | Ø32 x 5 tpi (1632) | 1   |
| 15       | TS-1503041      | Hex Socket Cap Screw                | M6x16              | 10  |
| 16       | TS-1550041      | Flat Washer                         | M6                 | 4   |
| 17       | JTM949EVS-D17   | Feed Screw Nut (Inch)               | Ø32 x 5 tpi        | 1   |
| 17-1     | JTM949EVS-D17-1 | Feed Screw Nut (Adjust-I)           | Ø32 x 5 tpi        | 1   |
| 18       | JTM1254VS-D18   | Lead Screw Housing                  |                    | 1   |
| 20       | JTM949EVS-D20   | Cross Bearing Bracket               |                    | 1   |
| 21       | JTM1254VS-D21   | Cross Feed Screw                    | Ø32 x 5 tpi (720)  | 1   |
| 22       | JTM949EVS-D22   | Cross Feed Adjustment Nut (Inch)    | Ø32 x 5 TPI        | 1   |
| 22-1     | JTM949EVS-D22-1 | Cross Feed Nut (Inch)               | Ø32 x 5 TPI        | 1   |
| 23       | JTM949EVS-D23   | Adjusting Washer                    | Ø45xØ34x0.15t      | 3   |

## 12.8.1 JTM-1254VS/RVS Control Box Assembly – Exploded View



## 12.8.2 JTM-1254VS/RVS Control Box Assembly – Parts List

| Index No   | Part No             | Description  | Size             | Qty |
|------------|---------------------|--|------------------|-----|
| .....      | JTM1254VS-CBA.....  | Control Box Assembly (includes #1-8).....                              |                  | 1   |
| 1 .....    | JTM949EVS-E01 ..... | Control Box .....  |                  | 1   |
| 2 .....    | JTM1254VS-CB .....  | Control Panel.....   |                  | 1   |
| 3 .....    | JTM949EVS-E09 ..... | Emergency Switch .....   |                  | 1   |
| 4 .....    | JTM949EVS-E07 ..... | Spindle Stop Button.....   |                  | 1   |
| 5 .....    | JTM949EVS-E06 ..... | Coolant Pump Switch .....  |                  | 1   |
| 6 .....    | JTM949EVS-E08 ..... | Power Start Button .....   |                  | 1   |
| 7 .....    | JTM949EVS-E04 ..... | F/R Select Switch .....  |                  | 1   |
| 8 .....    | TS-2245102 .....    | Socket Head Button Screw.....  | M5x10L .....     | 4   |
| 9 .....    | TS-1540031 .....    | Hex Nut.....   | M5 .....         | 4   |
| 10 .....   | TS-1550031 .....    | Flat Washer .....  | Ø5 .....         | 4   |
| 11 .....   | JTM949EVS-E12 ..... | Handle .....   |                  | 1   |
| 12 .....   | TS-2245162 .....    | Socket Head Button Screw.....  | M5x16 .....      | 4   |
| .....      | JTM949EVS-E14 ..... | Support Rod Unit Assembly (includes #13, 13-1, 13-2, 16, 20, 23) ..... |                  | 1   |
| 13 .....   | JTM1254VS-E13.....  | Rod .....  |                  | 1   |
| 13-1 ..... | JTM1254VS-E13-1.... | Rotating Bracket .....   |                  | 1   |
| 13-2 ..... | JTM1254VS-E13-2.... | Control Box Bracket.....   |                  | 1   |
| 14 .....   | TS-1504041 .....    | Hex Socket Cap Screw.....  | M8X20L .....     | 2   |
| 15 .....   | TS-1523031 .....    | Socket Set Screw .....   | M6x10 .....      | 3   |
| 16 .....   | JTM949EVS-E18 ..... | Lock Handle.....   | M12X35L .....    | 1   |
| 17 .....   | JTM949EVS-E19 ..... | Bracket.....   |                  | 1   |
| 18 .....   | TS-1523051 .....    | Hex Socket Cap Screw.....  | M6x16L .....     | 3   |
| 19 .....   | JTM1254VS-E19.....  | Spacer .....   |                  | 1   |
| 20 .....   | JTM949EVS-B120 .... | Flat Washer .....  | Ø13xØ20x2T ..... | 1   |
| 21 .....   | TS-0640081 .....    | Hex Nylon Lock Nut.....  | 5/16"-18 .....   | 1   |
| 22 .....   | JTM1254VS-E22.....  | Rubber gasket .....  |                  | 1   |
| 23 .....   | JTM1254VS-E23.....  | Nut.....   |                  | 1   |
| .....      | JTM1254VS-D19.....  | Cable (Control Panel to Electrical Box) – not shown.....               |                  | 1   |

## 12.9.1 JTM-1254VS/RVS Electrical Box – Exploded View



## 12.9.2 JTM-1254VS/RVS Electrical Box – Parts List

| Index No | Part No         | Description                                 | Size         | Qty |
|----------|-----------------|---|--------------|-----|
| 1        | JTM949EVS-F01   | Electrical Cabinet (RE: JTM949EVS-F21)      |              | 1   |
| 2        | JTM949EVS-F02   | Electrical Plate (RE: JTM949EVS-F21)        |              | 1   |
| 3        | JTM949EVS-F03   | Electrical Cabinet Door (RE: JTM949EVS-F21) |              | 1   |
|          | JTM949EVS-F21   | Electrical Cabinet Assembly (includes #1-3) |              | 1   |
| 4        | JTM949EVS-F04   | Door Latch                                  |              | 1   |
| 6        | JTM949EVS-F18   | Fan Cover                                   |              | 1   |
| 7        | JTM949EVS-F19   | Electric Receptacle                         |              | 1   |
| 8        | JTM949EVS-F16   | Aluminum Rail                               |              | 2   |
| 9        | JTM949EVS-F14   | Wire Casing                                 |              | 5   |
| 10       | JTM949EVS-F15   | Terminal Block                              |              | 1   |
| 11       | JTM949EVS-F21   | Switch Bracket                              |              | 1   |
| 12       | JTM949EVS-F05-1 | Switch Interface                            |              | 1   |
| QS1      | JTM949EVS-F05   | Door Switch (includes #12)                  |              | 1   |
| TC1      | JTM949EVS-F06   | Transformer                                 | 400VA        | 1   |
| KM1      | JTM1254VS-FKM1  | Magnetic Contactor                          | TECO / CU-11 | 1   |
| FR1      | JTM1254VS-FFR1  | Flicker Relay                               |              | 1   |
| KM2      | JTM1254VS-FKM2  | Magnetic Contactor                          | TECO / CU-11 | 1   |
| KA1      | JTM1254VS-FKA1  | Relay                                       | RMIA4524VAC  | 1   |
| KA2      | JTM1254VS-FKA2  | Relay                                       | RMIA21024VAC | 1   |
| KA3      | JTM1254VS-FKA3  | Relay                                       | RMIA4524VAC  | 1   |
| QF1      | JTM1254VS-FQF1  | Power Circuit Breaker                       | 3P 25A       | 1   |
| QF2      | JTM1254VS-FQF2  | Power Circuit Breaker                       | 1P 2A        | 1   |
| QF3      | JTM1254VS-FQF3  | Power Circuit Breaker                       | 1P 6A        | 1   |
| QF4      | JTM1254VS-FQF4  | Power Circuit Breaker                       | 1P 6A        | 1   |

### 12.10.1 JTM-1254VS/RVS Coolant Pump (Optional) – Exploded View

### 12.11.1 JTM-1254VS/RVS Work Lamp – Exploded View



### 12.10.2 JTM-1254VS/RVS Coolant Pump (Optional) – Parts List

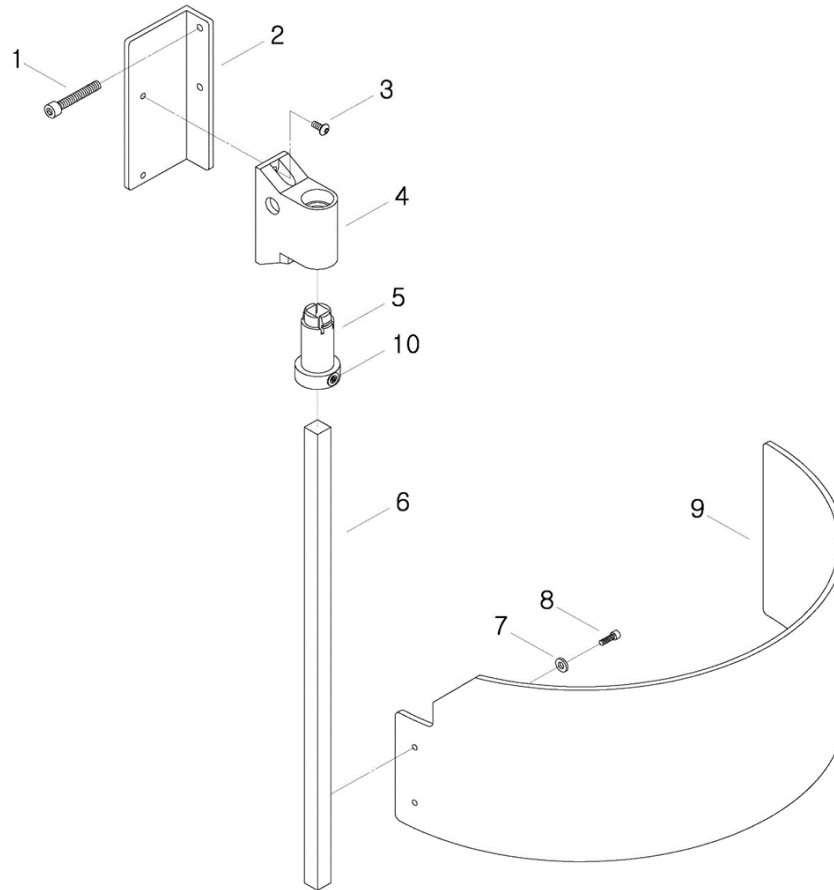
| Index No | Part No       | Description                            | Size                 | Qty   |
|----------|---------------|--|----------------------|-------|
| .....    | JTM949EVS-G00 | Coolant Pump Kit (includes #1 thru 12) | .....                | ..... |
| 1        | JTM949EVS-G01 | Plastic Nozzle                         | .....                | 1     |
| 2        | JTM949EVS-G02 | Valve                                  | PT 3/8" x 1/2"       | 1     |
| 3        | TS-1503091    | Hex Socket Cap Screw                   | M6 x 40              | 2     |
| 4        | JTM949EVS-G04 | Block                                  | .....                | 1     |
| 5        | JTM949EVS-G07 | Hose Fitting                           | PT 3/8" x 1/2" (90°) | 1     |
| 6        | JTM949EVS-G06 | Hose                                   | 1/2"                 | 1     |
| 7        | JTM949EVS-G07 | Hose Fitting                           | PT 3/8" x 1/2" (90°) | 1     |
| 8        | JTM949EVS-G08 | Hose Clamp                             | 5/6" (11 ~ 20)       | 2     |
| 9        | JTM949EVS-G09 | Coolant Pump                           | 1/8HP                | 1     |
| 10       | JTM949EVS-G10 | External Coolant Tank                  | .....                | 1     |
| 11       | JTM949EVS-G11 | Strainer                               | .....                | 1     |
| 12       | JTM949EVS-G12 | Cover with handle                      | .....                | 1     |

### 12.11.2 JTM-1254VS/RVS Work Lamp – Parts List

|    |               |                      |           |   |
|----|---------------|----------------------|-----------|---|
| 13 | JTM949EVS-G13 | Work Lamp            | 24V / LED | 1 |
| 14 | TS-1502041    | Hex Socket Cap Screw | M5X16     | 4 |
| 15 | JTM949EVS-G15 | Work Light Bracket   | .....     | 1 |
| 16 | TS-1503041    | Hex Socket Cap Screw | M6X16     | 6 |
| 17 | TS-1550041    | Flat Washer          | Ø6mm      | 6 |
| 18 | JTM949EVS-G18 | LED Bulb (not shown) | 24V       | 1 |



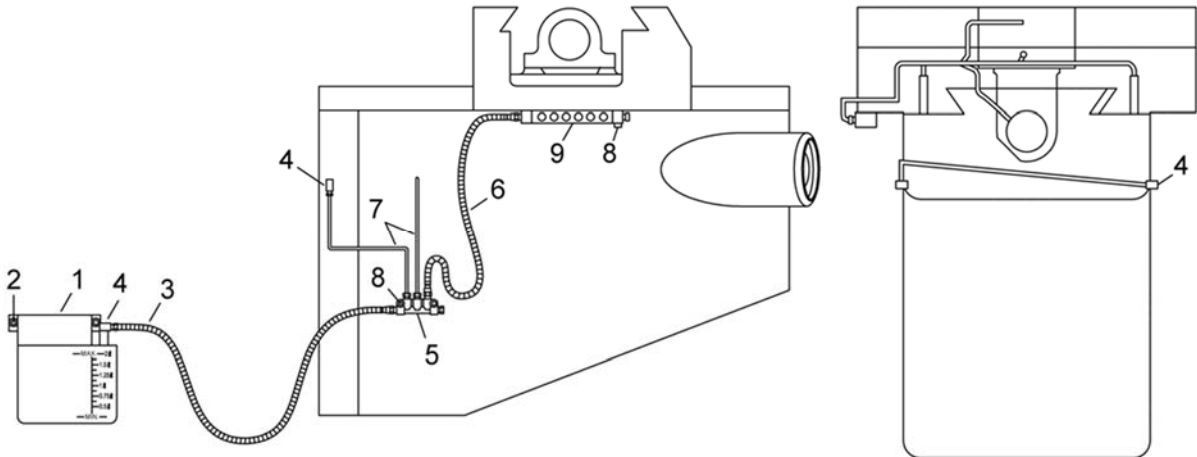
## 12.12.1 JTM-1254VS/RVS Spindle Guard Assembly – Exploded View



## 12.12.2 JTM-1254VS/RVS Spindle Guard Assembly – Parts List

| Index No | Part No        | Description                              | Size  | Qty |
|----------|----------------|--|-------|-----|
|          | JTM949EVS-SGA  | Spindle Guard Assembly (#1 thru 10)      |       |     |
| 1        | TS-1502101     | Hex Socket Cap Screw                     | M5x45 | 2   |
| 2        | JTM949EVS-H02  | Support Plate                            |       | 1   |
| 3        | TS-2245102     | Socket Head Button Screw                 | M5x10 | 2   |
| 4        | JTM949EVS-H04  | Bushing Bracket (Re: JTM949EVS-H04A)     |       | 1   |
|          | JTM949EVS-H04A | Bushing Bracket Assembly (includes #4,5) |       | 1   |
| 5        | JTM949EVS-H05  | Bushing                                  |       | 1   |
| 6        | JTM949EVS-H06  | Support Rod                              |       | 1   |
| 7        | TS-1550031     | Washer                                   | Ø5    | 2   |
| 8        | TS-1502031     | Hex Socket Cap Screw                     | M5x12 | 2   |
| 9        | JTM949EVS-H09  | Spindle Guard                            |       | 1   |
| 10       | TS-1522021     | Socket Set Screw                         | M5x8  | 1   |

12.13.1 JTM-1254VS/RVS Lubrication System – Exploded View



12.13.2 JTM-1254VS/RVS Lubrication System – Parts List

| Index No | Part No        | Description                          | Size         | Qty |
|----------|----------------|--------------------------------------|--------------|-----|
| 1        | JTM949EVS-J01N | Automatic Oiler                      | 2L, 0~180min | 1   |
| 2        | TS-1503061     | Hex Socket Cap Screw                 | M6x25L       | 2   |
| 3        | JTM949EVS-J03  | Flexible Steel Tube                  | Ø4           | 1   |
| 4        | JTM949EVS-J04  | Elbow Adaptor                        | Ø4           | 3   |
| 5        | JTM949EVS-J10  | Oil Distributor                      | Ø4, 6 holes  | 2   |
| 6        | JTM949EVS-J06  | Flexible Steel Tube                  |              | 1   |
| 7        | JTM949EVS-J07  | Aluminum Pipe                        | Ø4           | 2   |
| 8        | TS-1502061     | Hex Socket Cap Screw                 | M5x25L       | 4   |
| 9        | JTM1254VS-J09  | Oil Distributor                      | Ø4, 8 holes  | 1   |
|          | JTM1254VS-J05A | Oil Distributor Kit (incl. #3,5,6,9) |              | 1   |