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|-----------------|-----------------|
| Model No.: | Stock No.: |
| Serial No.: | |
| Purchased From: | |
| Date Purchased: | Date Installed: |

Operation and Maintenance Instructions

ZH Series Large Bore Lathes

Models GH-2680ZH; GH-26120ZH



Model GH-2680ZH shown

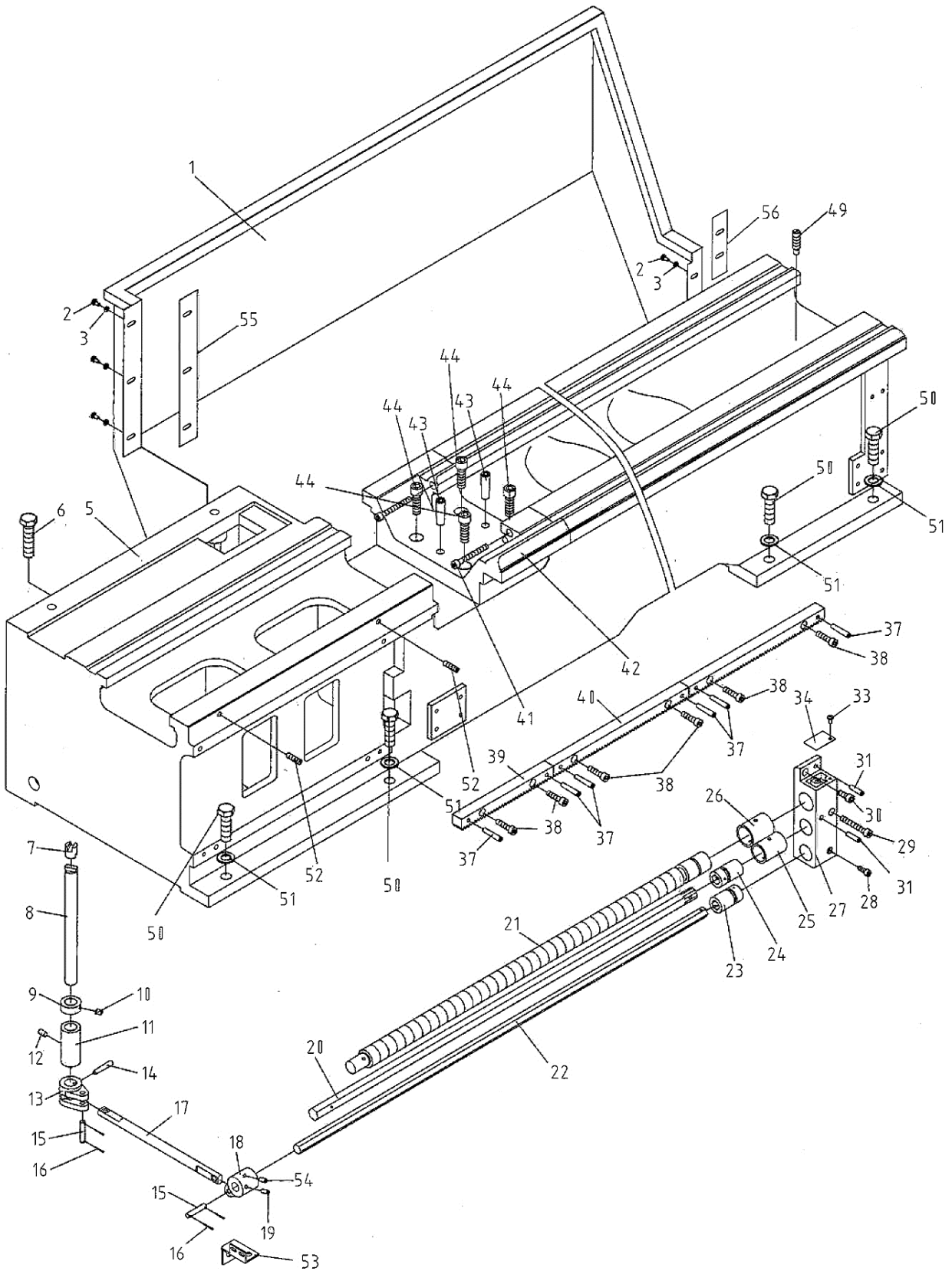
For ZH-Series Lathes Parts List and Electrical Diagrams, see document M-321860-1

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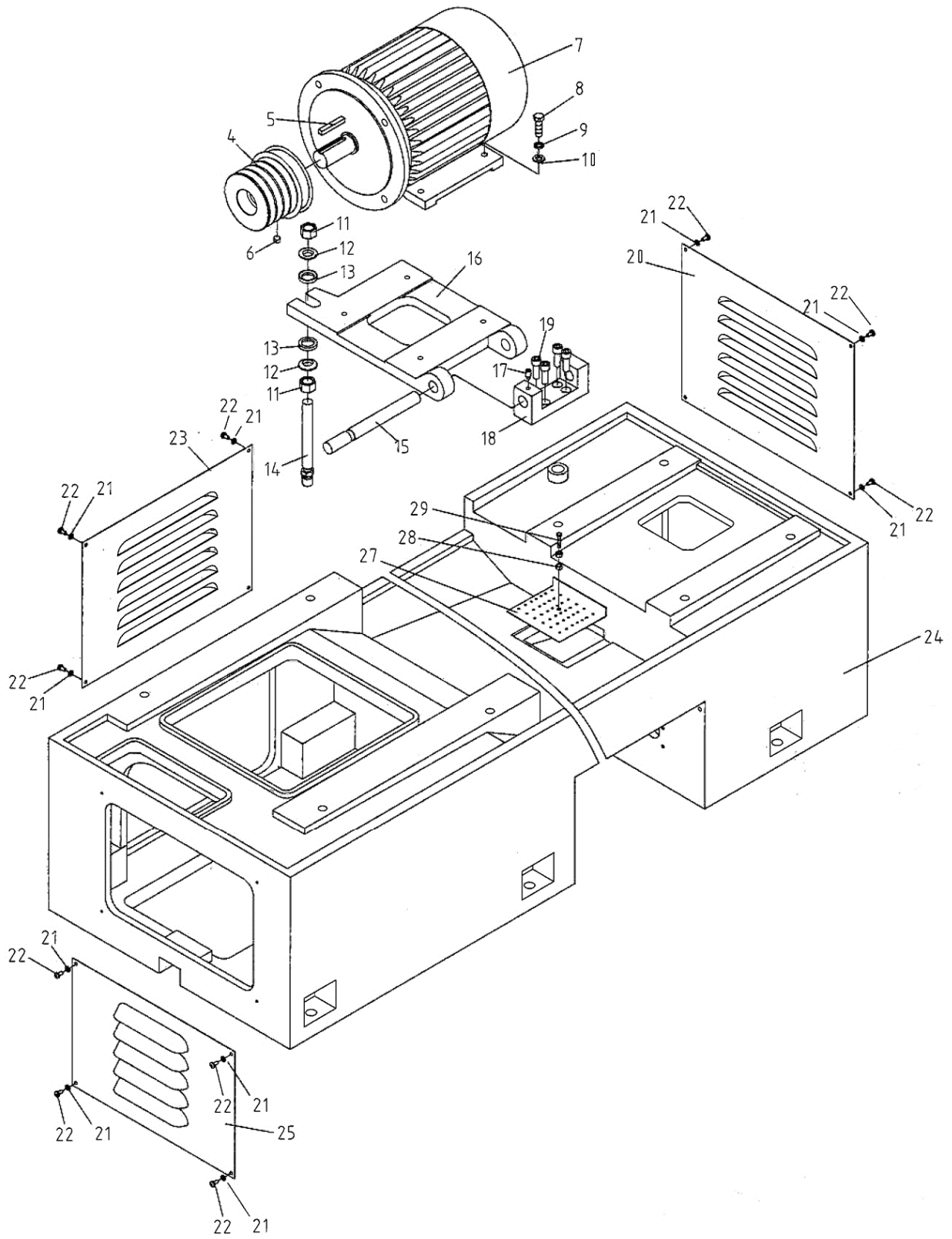
3.0 Bed Assembly I – Exploded View



3.1 Bed Assembly I – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|---------------|---|----------|-----|
| 1 | C6266C12701C | Splash Guard (80" ZH only) | 80" | 1 |
| | C6266C12701D | Traveling Splash Guard (120" ZH only) 24" | 1 | |
| 2 | TS-1503011 | Hex Socket Cap Screw | M6x8 | 8 |
| 3 | TS-1550041 | Flat Washer | 6 mm | 8 |
| 5 | C6266C01101C | Bed (for 80" ZH only) | 80" | 1 |
| | C6266C01101D | Bed (for 120" ZH only) | 120" | 1 |
| 6 | GB5782-M20x60 | Hex Cap Bolt | M20x60 | 4 |
| 7 | C6140W01705 | Crossed Head | | 1 |
| 8 | C6140W01706 | Screw | | 1 |
| 9 | C6140W01707 | Collar | | 1 |
| 10 | GB71-M10x12 | Slotted Set Screw | M10x12 | 1 |
| 11 | C6140W01709 | Sleeve | | 1 |
| 12 | GB71-M10x20 | Slotted Set Screw | M10x20 | 1 |
| 13 | C6140W01104 | Crank | | 1 |
| 14 | GB118-8x50 | Taper Pin | 8x50 mm | 1 |
| 15 | GB71-M10x14 | Slotted Set Screw | M10x14 | 2 |
| 16 | GB91-2x16 | Split Pin | 2x16 mm | 4 |
| 17 | C6140W01711A | Pulling Rod | | 1 |
| 18 | C6266C01106 | Sleeve | | 1 |
| 19 | GB71-M8x16 | Slotted Set Screw | M8x16 | 1 |
| 20 | C6266C01703C | Hex Feed Rod (for 80" ZH only) | | 1 |
| | C6266C01703D | Hex Feed Rod (for 120" ZH only) | | 1 |
| 21 | C6266C01702C | Lead Screw (for 80" ZH only) | | 1 |
| | C6266C01702D | Lead Screw (for 120" ZH only) | | 1 |
| 22 | C6266C01705C | Hex Control Rod (for 80" ZH only) | | 1 |
| | C6266C01705D | Hex Control Rod (for 120" ZH only) | | 1 |
| 23 | C6140W01724 | Sleeve | | 1 |
| 24 | C6140W01725 | Sleeve | | 1 |
| 25 | C6140W01302 | Bronze Bushing | | 1 |
| 26 | C6140W01301 | Bronze Bushing | | 1 |
| 27 | C6140W01109 | Bracket | | 1 |
| 28 | TS-1505041 | Hex Socket Cap Screw | M8x20 | 1 |
| 29 | TS-1505111 | Hex Socket Cap Screw | M10x70 | 1 |
| 30 | TS-1505031 | Hex Socket Cap Screw | M10x25 | 1 |
| 31 | GB118-8x35 | Taper Pin | 8x35 mm | 2 |
| 32 | TS-1550041 | Flat Washer | 6 mm | 8 |
| 33 | TS-1503011 | Hex Socket Cap Screw | M6x8 | 8 |
| 34 | C6140W01726 | Cover | | 1 |
| 37 | C-GB11876845 | Taper Pin | 8x45 mm | 6 |
| 38 | TS-1505051 | Hex Socket Cap Screw | M10x35 | 6 |
| 39 | C6266C01704 | Rack (both models) | | 1 |
| 40 | C6140W01719 | Rack (for 80" ZH) | | 5 |
| | C6140W01719 | Rack (for 120" ZH) | | 8 |
| 41 | GB70-M10x85 | Hex Socket Cap Screw | M10x85 | 2 |
| 42 | C6266C01103 | Gap | | 1 |
| 43 | C-GB11876845 | Taper Pin | 16x60 mm | 2 |
| 44 | GB70-M16x50 | Hex Socket Cap Screw | M16x50 | 4 |
| 49 | C6140W01733 | Pin | | 1 |
| 50 | GB5782-M20x80 | Hex Bolt | M20x80 | 4 |
| 51 | GB97.2-20 | Flat Washer | 20 mm | 8 |
| 52 | GB85-M12x75 | Set Screw | M12x75 | 2 |
| 53 | C6266C18716 | Bracket | | 1 |
| 54 | C6266C01718 | Nut | | 1 |
| 55 | C6266CLR80 | Rubber Gasket (for 80" ZH only) | | 1 |

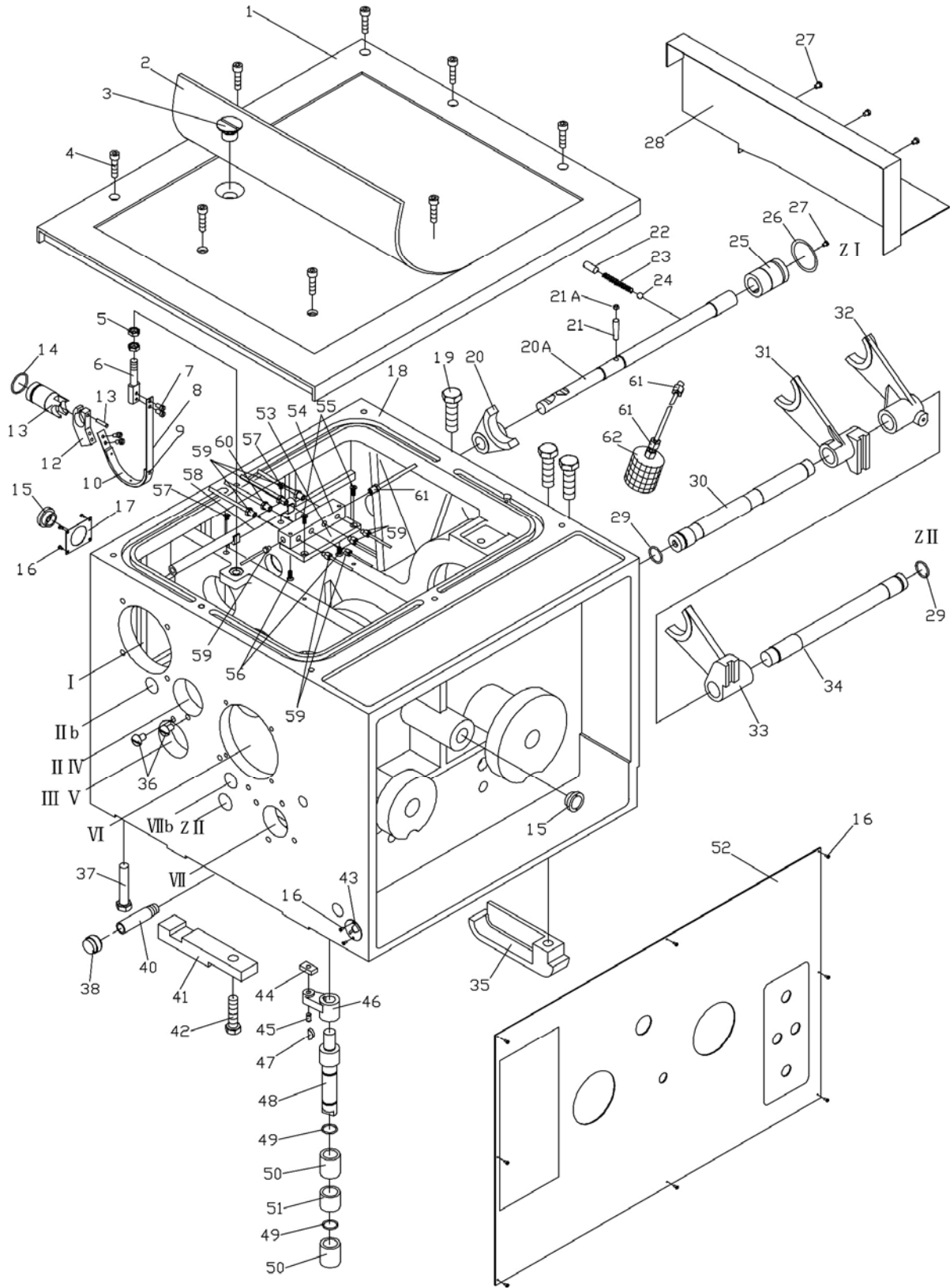
4.0 Bed Assembly II – Exploded View



4.1 Bed Assembly II – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|---------------|-------------------------------------|---------------------|---------|
| 4 | C6266C01105 | Pulley | | 1 |
| 5 | GB1096-10x50 | Flat Key | 10x50 mm | 1 |
| 6 | GB71-M12x16 | Slotted Set Screw | M12x16 | 1 |
| 7 | Y132M-4TH/B3 | Motor | 10HP, 3PH, 230/460V | 1 |
| 8 | GB5782-M10x40 | Hex Bolt | M10x40 | 4 |
| 9 | GB93-10 | Spring Washer | 10 mm | 4 |
| 10 | GB97.2-10 | Flat Washer | 10 mm | 4 |
| 11 | GB6170-M20 | Hex Nut | M20 | 2 |
| 12 | GB850-20 | Taper Washer | 20 mm | 2 |
| 13 | GB849-20 | Spherical Washer | 20 mm | 2 |
| 14 | C6140W01714 | Double Bolt | | 1 |
| 15 | C6266C01711 | Shaft | | 1 |
| 16 | C6266C01104 | Motor Mounting Plate | | 1 |
| 17 | GB75-M10x14 | Slotted Set Screw | M10x14 | 1 |
| 18 | C6266C01107 | Support | | 1 |
| 19 | TS-1506041 | Hex Socket Cap Screw | M12x35 | 4 |
| 20 | C6266C01701 | Cover | | 1 |
| 21 | TS-1550041 | Flat Washer | 6 mm | 12 |
| 22 | GB818-M6x5 | Cross Head Screw | M6x5 | 12 |
| 23 | C6266C01710 | Cover | | 1 |
| 24 | C6266C01102C | Bed Stand (for 80" ZH only) | | 1 |
| | C6266C01108 | Front Bed Stand (for 120" ZH only) | | 1 |
| | C6266C01109 | Middle Bed Stand (for 120" ZH only) | | 1 |
| | C6266C01110 | Rear Bed Stand (for 120" ZH only) | | 1 |
| 25 | C6266C01707 | Cover | | 1 |
| 27 | 1440R01705 | Drain Plate | | 1 |
| 28 | TS-1540041 | Hex Nut | M6 | 1 |
| 29 | TS-1482041 | Hex Cap Screw | M6x20 | 1 |
| 30 | JETLOGO-1 | JET Nameplate (not shown) | | 1 |
| 31 | STRIPE-1-3/4 | Stripe (not shown) | | per ft. |

5.0 Headstock Assembly I – Exploded View

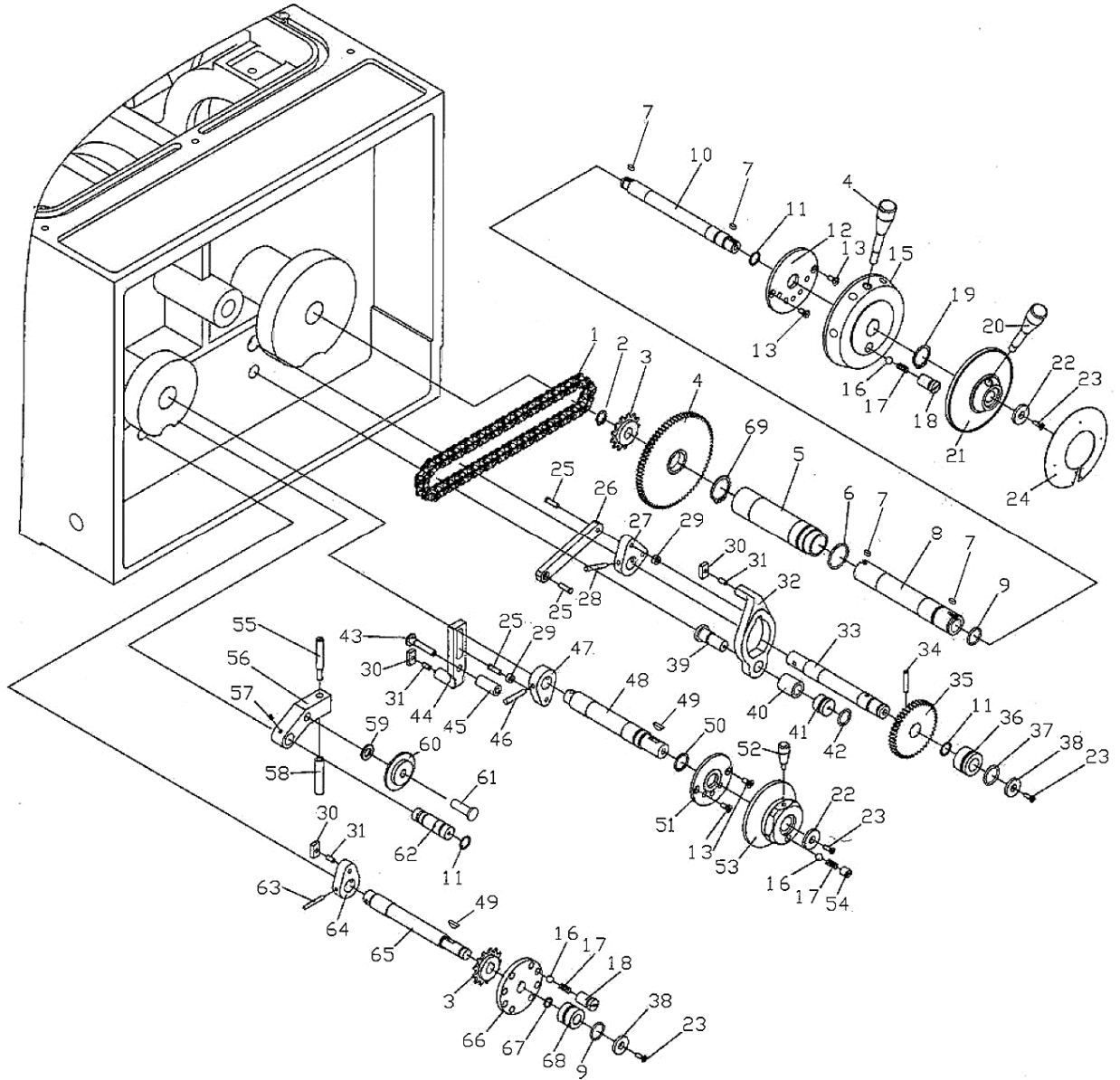


5.1 Headstock Assembly I – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|--------------------|---|--------------|-----|
| 1 | C6266C02502 | Headstock Cover | | 1 |
| 2 | C6266C02501 | Rubber Mat | | 1 |
| 3 | C6140W02835 | Flat Head Countersunk Screw | | 1 |
| 4 | TS-1505051 | Hex Socket Cap Screw | M10x35 | 8 |
| 5 | GB6172-M12 | Hex Nut | M12 | 2 |
| 6 | C6266C02768 | Braking Belt Support | | 1 |
| 7 | GB65-M6x10 | Slotted Socket Cap Screw | M6x10 | 4 |
| 8 | C6266C02767 | Braking Belt (includes #9 and 10) | | 1 |
| 9 | GB867-3x10 | Cup Head Rivet | 3x10 mm | 3 |
| 10 | C6266C02503 | Braking Friction Disc | | 1 |
| 11 | GB119-6n6x14 | Pin | 6n6x14 mm | 1 |
| 12 | C6266C02770 | Braking Belt Support | | 1 |
| 13 | C6266C02769 | Shaft | | 1 |
| 14 | GB3452.1-30x2.65 | O-Ring | 30x2.65 mm | 1 |
| 15 | R51-2 | Oil Glass | | 2 |
| 16 | GB818-M3x4 | Cross Recessed Pan Head Screw | M3x4 | 7 |
| 17 | C6266C02306 | Sign Plate – Oil Level | | 1 |
| 18 | C6266C02101 | Headstock | | 1 |
| 19 | GB5782-M20x75 | Hexagon Head Bolt | M20x75 | 3 |
| 20 | C6266C02125 | Fork | | 1 |
| 20A | C6266C02721 | Control Shaft | | 1 |
| 21 | GB118-8x40 | Pin | 8x40 mm | 1 |
| 21A | GB6172-M8 | Hex Nut | M8 | 1 |
| 22 | GB71-M12x30 | Slotted Set Screw | M12x30 | 1 |
| 23 | Q81-1-1.6x8x70 | Spring | 1.6x8x70 mm | 1 |
| 24 | SB-10MM | Steel Ball | 10 mm | 1 |
| 25 | C6140W02105 | Bushing | | 1 |
| 26 | GB3452.1-38.7x3.55 | O-Ring | 38.7x3.55 mm | 1 |
| 27 | GB818-M6x8 | Cross Head Screw | M6x8 | 1 |
| 28 | C6266C02757 | Cover | | 1 |
| 29 | GB3452.1-26.5x2.65 | O-Ring | 26.5x2.65 mm | 1 |
| 30 | C6266C02761 | Control Shaft | | 1 |
| 31 | C6266C02128 | Fork | | 1 |
| 32 | C6266C02124 | Fork | | 1 |
| 33 | C6266C02120 | Fork | | 1 |
| 34 | C6266C02762 | Control Shaft | | 1 |
| 35 | C6140W02141 | Front Cover | | 1 |
| 36 | C6140W02711 | Screw | | 3 |
| 37 | GB5782-M16x80 | Hexagon Head Bolt | M16x80 | 2 |
| 38 | C6140W02831 | Nut | | 1 |
| 40 | C6140W02832 | Drain Pipe | | 1 |
| 41 | C6140W02833 | Clamping Plate | | 1 |
| 42 | TS-1494052 | Hex Cap Screw | M16x60 | 1 |
| 43 | C6266C02303 | Sign Plate | | 1 |
| 44 | C6140W02143 | Sliding Block | | 1 |
| 45 | GB119-N6x20 | Pin | n6x20 mm | 1 |
| 46 | C6140W02129 | Rocker | | 1 |
| 47 | GB1099-6x22 | Woodruff Key | 6x22 mm | 1 |
| 48 | C6266C02763 | Shaft | | 1 |
| 49 | G51-2A-25x2.4 | O-Ring | 25x2.4 mm | 2 |
| 50 | C6140W02127 | Collar | | 2 |
| 51 | C6266C02119 | Collar | | 1 |
| 52 | C6266C02305-23 | Headstock Label Panel (for 80" ZH only) | | 1 |
| | GH26120ZH-52 | Headstock Label Panel (for 120" ZH only) | | 1 |
| 53 | C6140W02837 | Board | | 1 |
| 54 | C6140W02836 | Oil Distributor | | 1 |
| 55 | GB819-M5x10 | Cross Recessed Hd Countersunk Screw M5x10 | | 2 |
| 56 | GB819-M6x14 | Cross Recessed Hd Countersunk Screw M6x14 | | 2 |
| 57 | GB818-M6x8 | Cross Recessed Pan Head Screw | M6x8 | 2 |

| Index No. | Part No. | Description | Size | Qty |
|------------------|-----------------|----------------------|-------------|------------|
| 58 | C6266C02781 | Oil Sprayer Assembly | | 1 |
| 59 | G92-1A-4 | Fitting | 4 mm | group of 8 |
| 60 | G92-1A-8 | Fitting | 8 mm | 1 |
| 61 | G92-1A-10 | Fitting | 10 mm | group of 4 |
| 62 | SFW-02A | Oil Filter | | 1 |

6.0 Headstock Assembly II – Exploded View

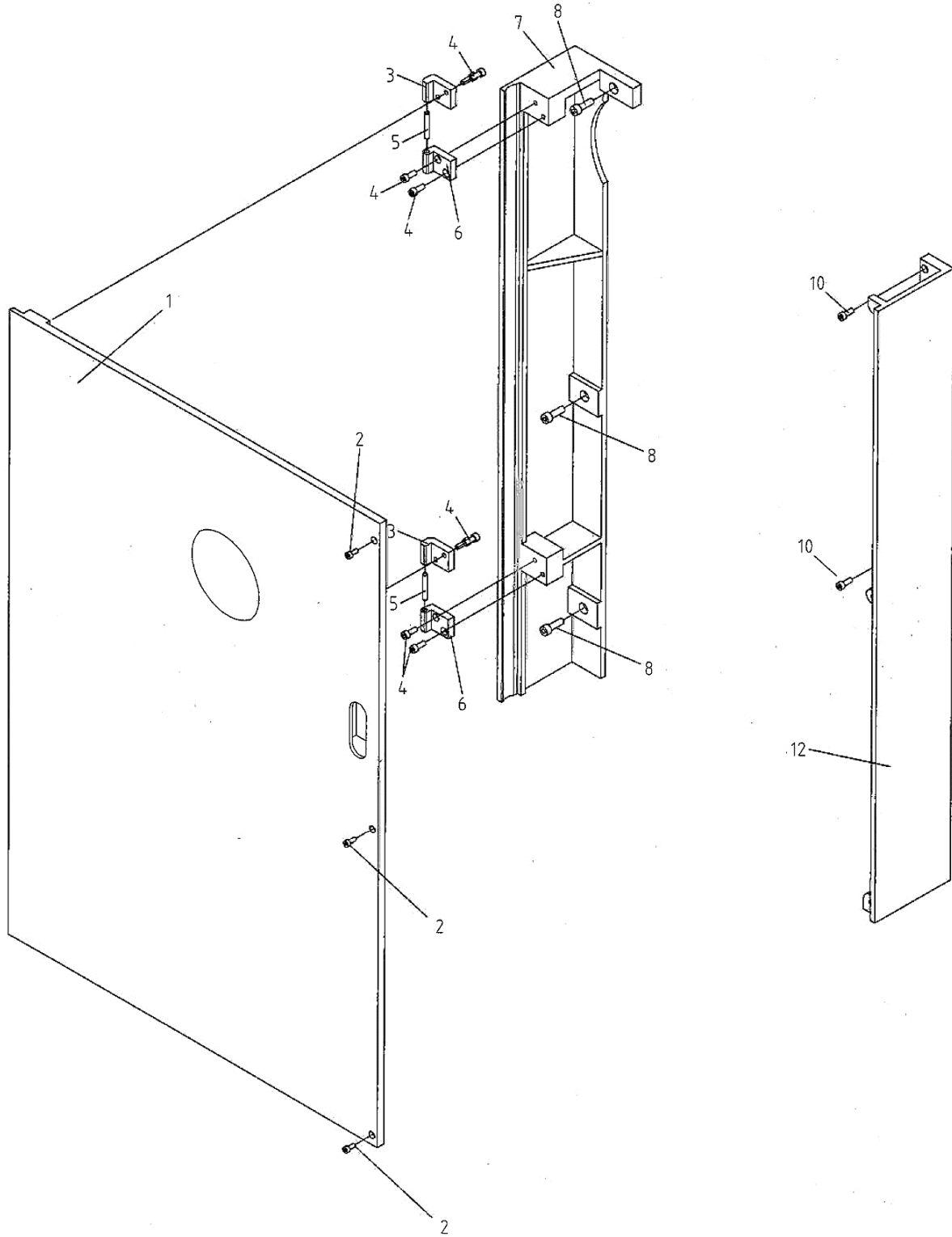


6.1 Headstock Assembly II – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|--------------------|-------------------------------------|--------------|-----|
| 1 | C6266CHA01 | Chain | 12.7 x 58 | 1 |
| 2 | GB894.1-16 | Circlip for Shaft | 16 mm | 1 |
| 3 | C6140W02808 | Chain Wheel | | 2 |
| 4 | C6266C02751 | Gear | | 1 |
| 5 | C6266C02780 | Sleeve | | 1 |
| 6 | GB3452.1-34.5x2.65 | O-Ring | 34.5x2.65 mm | 1 |
| 7 | GB1096-5x10 | Flat Key | 5x10 mm | 4 |
| 8 | C6266C02753 | Collar | | 1 |
| 9 | GB3452.1-25x2.65 | O-Ring | 25x2.65 mm | 2 |
| 10 | C6266C02752 | Shaft | | 1 |
| 11 | GB3452.1-17x1.8 | O-Ring | 17x1.8 mm | 3 |
| 12 | C6266C02756 | Positioning Disc | | 1 |
| 13 | GB819-M6x14 | Cross Recessed Hd Countersunk Screw | M6x14 | 4 |
| 14 | C6140W02799 | Lever | | 1 |
| 15 | C6266C02114 | Lever Support | | 1 |
| 16 | SB-10MM | Steel Ball | 10 mm | 3 |
| 17 | Q81-1-1.6x8x18 | Spring | 1.6x8x18 mm | 3 |
| 18 | C6266C02754 | Positioning Screw | | 2 |
| 19 | GB894.1-30 | Circlip for Shaft | 30 mm | 1 |
| 20 | C6140W02801 | Lever | | 1 |
| 21 | C6140W02123 | Lever Support | | 1 |
| 22 | C6140W02821 | Washer | | 2 |
| 23 | GB819-M5x16 | Cross Recessed Hd Countersunk Screw | M5x16 | 6 |
| 24 | C6266C02304 | Speed Label | | 1 |
| 25 | C6140W02813 | Pin | | 3 |
| 26 | C6266C02775 | Connector | | 1 |
| 27 | C6266C02121 | Rocker | | 1 |
| 28 | GB117-6x45 | Taper Pin | 6x45 mm | 1 |
| 29 | C6140W02812 | Roller | | 2 |
| 30 | C6140W02119 | Sliding Block | | 3 |
| 31 | GB119-6n6x14 | Pin | 6n6x14 mm | 3 |
| 32 | C6266C02122 | Fork | | 1 |
| 33 | C6266C02765 | Axis | | 1 |
| 34 | GB117-6x35 | Taper Pin | 6x35 mm | 1 |
| 35 | C6266C02749 | Gear | | 1 |
| 36 | C6266C02112 | Collar | | 1 |
| 37 | GB3452.1-30x2.65 | O-Ring | 30x2.65 mm | 1 |
| 38 | C6266C02750 | Washer | | 2 |
| 39 | C6266C02764 | Pin | | 1 |
| 40 | C6266C02123 | Collar | | 1 |
| 41 | C6266C02111 | Plug | | 1 |
| 42 | GB3452.1-20x2.65 | O-Ring | 20x2.65 mm | 1 |
| 43 | C6266C02760 | Shaft | | 1 |
| 44 | C6266C02118 | Fork | | 1 |
| 45 | C6266C02116 | Collar | | 1 |
| 46 | GB117-6x40 | Taper Pin | 6x40 mm | 1 |
| 47 | C6266C02117 | Rocker | | 1 |
| 48 | C6266C02759 | Shaft | | 1 |
| 49 | GB1099-5x19 | Woodruff Key | 5x19 mm | 2 |
| 50 | GB3452.1-21.2x2.65 | O-Ring | 21.2x2.65 mm | 1 |
| 51 | C6266C02758 | Positioning Disc | | 1 |
| 52 | C6140W02822 | Lever | | 1 |
| 53 | C6266C02115 | Lever Support | | 1 |
| 54 | GB73-M12x14 | Set Screw | M12x14 | 1 |
| 55 | C6266C02774 | Bolt | | 1 |
| 56 | C6266C02129 | Rocker | | 1 |
| 57 | TS-1522021 | Socket Set Screw | M5x8 | 1 |
| 58 | C6266C02773 | Screw | | 1 |
| 59 | TS-2360121 | Flat Washer | 12 mm | 1 |

| Index No. | Part No. | Description | Size | Qty |
|------------------|-------------------|--------------------|-------------|------------|
| 60 | C6140W02826 | Tightening Wheel | | 1 |
| 61 | C6140W02825 | Pin | | 1 |
| 62 | C6266C02771 | Shaft | | 1 |
| 63 | GB117-5x40 | Taper Pin | 5x40 mm | 1 |
| 64 | C6266C02127 | Rocker | | 1 |
| 65 | C6266C02766 | Shaft | | 1 |
| 66 | C6266C02772 | Positioning Disc | | 1 |
| 67 | GB3452.1-12.5x1.8 | O-Ring | 12.5x1.8 mm | 1 |
| 68 | C6266C02126 | Collar | | 1 |
| 69 | GB894.1-35 | Circlip for Shaft | 35 mm | 1 |

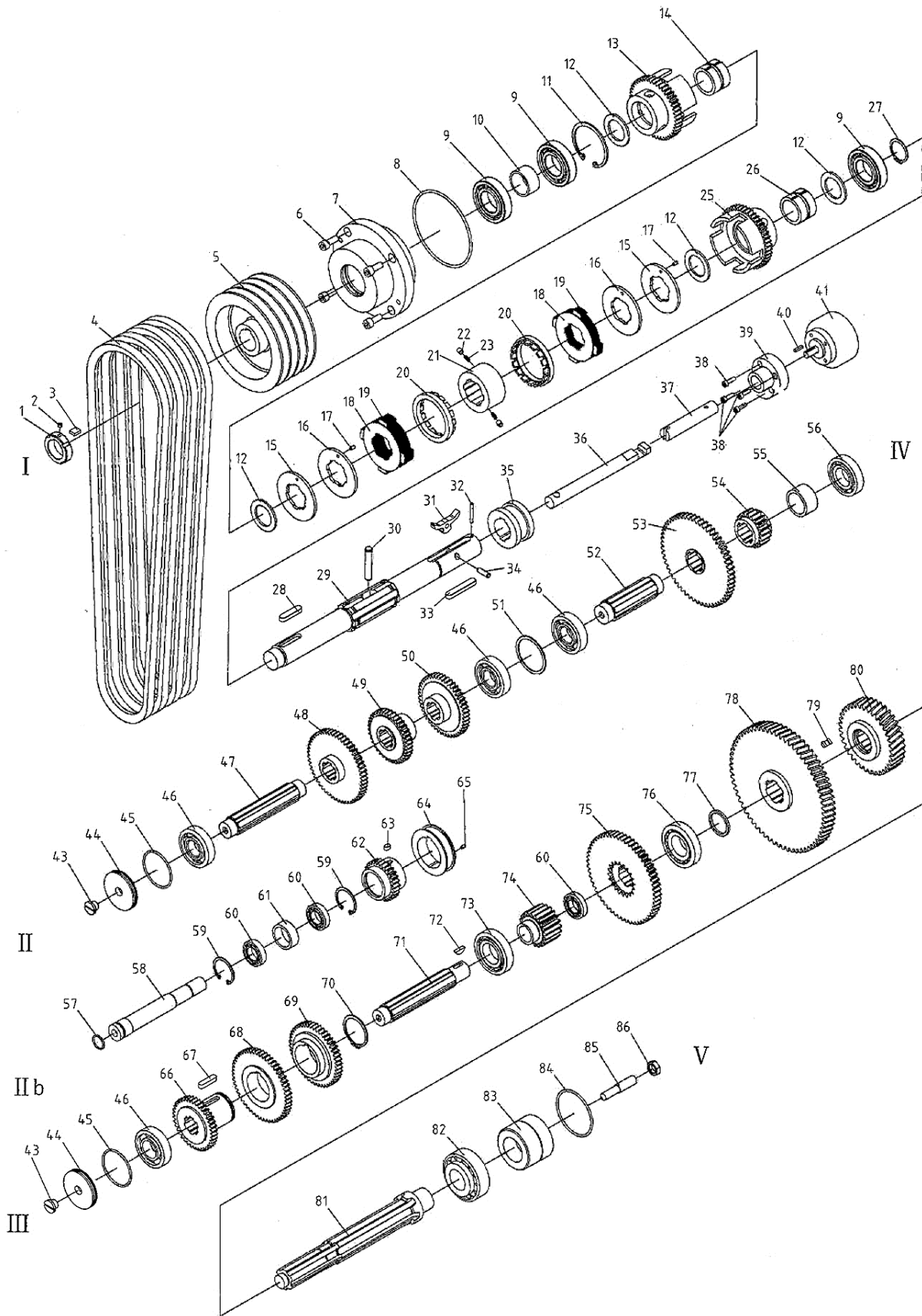
7.0 Headstock Assembly III – Exploded View



7.1 Headstock Assembly III – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|--------------|------------------------|-----------|-----|
| 1 | C6266C08501 | Back Cover | | 1 |
| 2 | TS-1502031 | Hex Socket Cap Screw | M5x12 | 3 |
| 3 | C6266C08706 | Upper Hinge | | 2 |
| 4 | TS-2205201 | Hex Socket Cap Screw | 5x20 mm | 2 |
| 5 | GB119-6h8x40 | Pin | 6h8x40 mm | 2 |
| 6 | C6266C08707 | Lower Hinge | | 2 |
| 7 | C6266C08504 | Rear Side Plate | | 1 |
| 8 | TS-1503041 | Hex Socket Cap Screw | M6x16 | 8 |
| 10 | TS-1503031 | Hex Socket Cap Screw | M6x14 | 2 |
| 12 | C6266C08711A | Lower Front Side Plate | | 1 |

8.0 Headstock Assembly IV – Exploded View

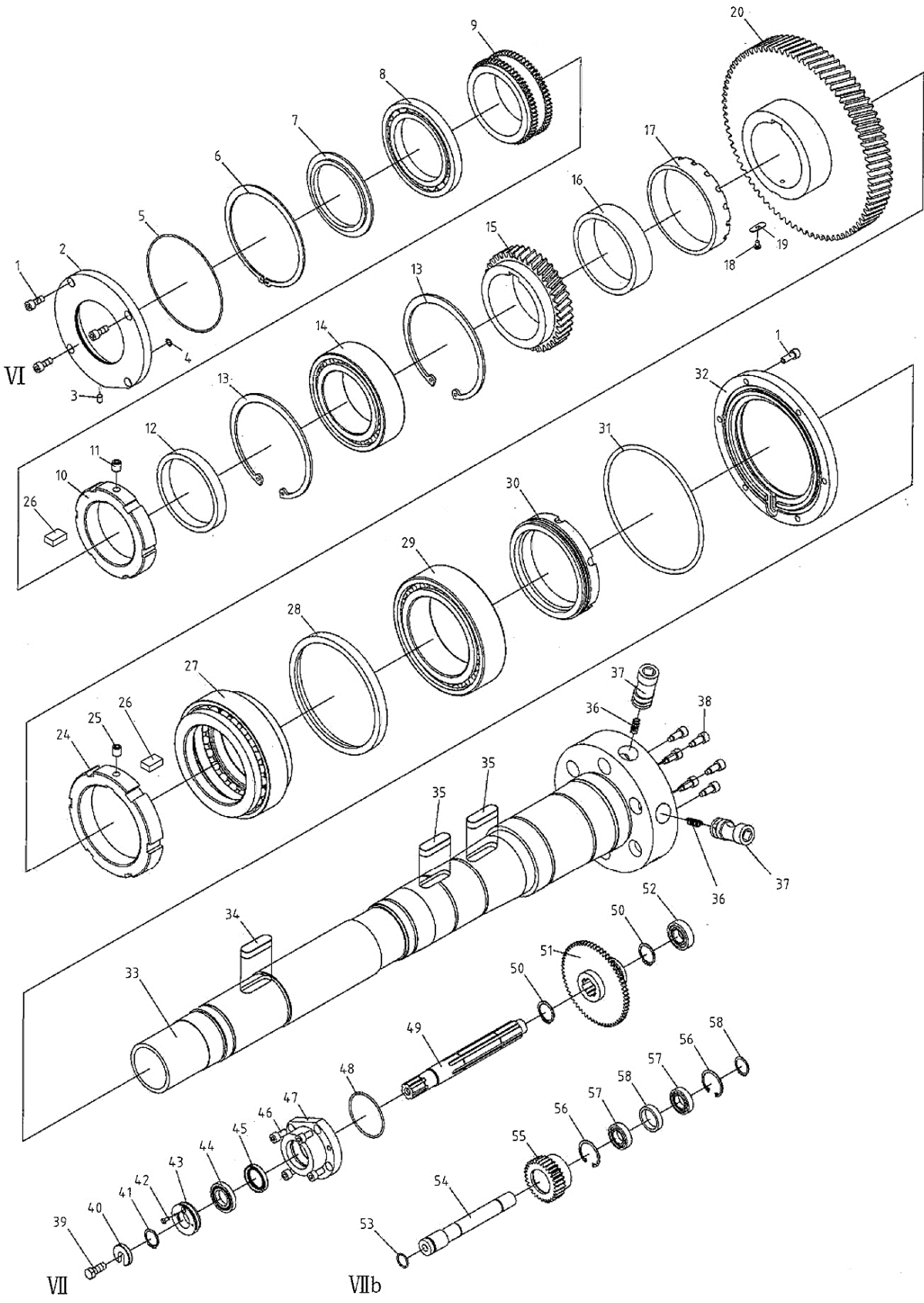


8.1 Headstock Assembly IV – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-------------------|------------------------|-------------|-----|
| 1 | C6140W02752-1/2 | Round Nut | | 1 |
| 2 | TS-1523011 | Hex Socket Set Screw | M6x6 | 1 |
| 3 | C6140W02752-2/2 | Clamping Piece | | 1 |
| 4 | B2464 | Belt | | 4 |
| 5 | C6266C02107 | Pulley | | 1 |
| 6 | TS-1505031 | Hex Socket Cap Screw | M10x25 | 4 |
| 7 | C6266C02105 | Bearing Cover | | 1 |
| 8 | GB3452.1-125x3.55 | O-Ring | 125x3.55 mm | 1 |
| 9 | BB-6208 | Ball Bearing | 6208 | 3 |
| 10 | C6266C02106 | Spacer | | 1 |
| 11 | GB894.1-40 | Circlip for Shaft | 40 mm | 1 |
| 12 | C6266C02723 | Spacer | | 4 |
| 13 | C6266C02730 | Forward Clutch Housing | | 1 |
| 14 | C6266C02302 | Collar | | 1 |
| 15 | C6140W02748 | Pressure Plate | | 2 |
| 16 | C6140W02747 | Pressure Plate | | 2 |
| 17 | GB119-5x10 | Pin | 5x10 mm | 2 |
| 18 | C6140W02746 | Inner Friction Disc | | 13 |
| 19 | C6140W02745 | Outer Friction Disc | | 11 |
| 20 | C6140W02741 | Adjusting Nut | | 2 |
| 21 | C6266C02727 | Spline Sleeve | | 1 |
| 22 | C6140W02744 | Stop Pin | | 2 |
| 23 | Q81-1-0.8x5x16 | Spring | 0.8x5x16 | 2 |
| 25 | C6266C02724 | Reverse Clutch Housing | | 1 |
| 26 | C6266C02301 | Collar | | 1 |
| 27 | GB894.1-40 | Circlip for Shaft | 40 mm | 1 |
| 28 | GB1096-12x50 | Flat Key | 12x50 mm | 1 |
| 29 | C6266C02731 | Shaft (I) | | 1 |
| 30 | GB119-12x70 | Pin | 12x70 mm | 1 |
| 31 | C6240W02732 | Pressure Piece | | 1 |
| 32 | GB119-5x40 | Pin | 5x40 mm | 1 |
| 33 | GB1096-12x70 | Flat Key | 12x70 mm | 1 |
| 34 | GB119-8x25 | Pin | 8x25 mm | 1 |
| 35 | C6140W02733 | Sliding Ring | | 1 |
| 36 | C6266C02728 | Shaft | | 1 |
| 37 | C6266C02722 | Shaft | | 1 |
| 38 | TS-1503051 | Hex Socket Cap Screw | M6x20 | 3 |
| 39 | C6140W02106 | Pump Support | | 1 |
| 40 | GB1096-4x16 | Flat Key | 4x16 mm | 1 |
| 41 | DB-B4 | Bracket | | 1 |
| 43 | C6266C02740 | Bolt | | 2 |
| 44 | C6266C02736 | Cover | | 2 |
| 45 | GB3452.1-65x3.55 | O-Ring | 65x3.55 mm | 2 |
| 46 | BB-6306 | Ball Bearing | 6306 | 3 |
| 47 | C6266C02735 | Shaft (II) | | 1 |
| 48 | C6266C02734 | Gear | | 1 |
| 49 | C6266C02733 | Gear | | 1 |
| 50 | C6266C02732 | Gear | | 1 |
| 51 | C6266C02737 | Circlip | | 1 |
| 52 | C6266C02718 | Shaft (IV) | | 1 |
| 53 | C6266C02720 | Gear | | 1 |
| 54 | C6266C02719A | Gear | | 1 |
| 55 | C6266C02103 | Sleeve | | 1 |
| 56 | BB-6207 | Ball Bearing | 6207 | 2 |
| 57 | GB3452.1-25x2.65 | O-Ring | 25x2.65 mm | 1 |
| 58 | C6266C02729 | Shaft (IIb) | | 1 |
| 59 | GB893.1-47 | Circlip | 47 mm | 2 |
| 60 | BB-6005 | Ball Bearing | 6005 | 2 |
| 61 | C6266C02104 | Sleeve | | 1 |

| Index No. | Part No. | Description | Size | Qty |
|-----------|--------------------|------------------------|--------------|-----|
| 62 | C6266C02726 | Gear | | 1 |
| 63 | GB1096-8x12 | Flat Key | 8x12 mm | 1 |
| 64 | C6266C02725 | Brake Wheel | | 1 |
| 65 | GB73-M5x8 | Slotted Set Screw | M5x8 | 1 |
| 66 | C6266C02741 | Gear | | 1 |
| 67 | GB1096-10x40 | Flat Key | 10x40 mm | 1 |
| 68 | C6266C02738 | Gear | | 1 |
| 69 | C6266C02742 | Gear | | 1 |
| 70 | GB894.1-55 | Circlip for Shaft | 55 mm | 1 |
| 71 | C6266C02739 | Shaft (III) | | 1 |
| 72 | GB1099-6x22 | Woodruff Key | 6x22 mm | 1 |
| 73 | BB-6208 | Ball Bearing | 6208 | 1 |
| 74 | C6266C02717 | Gear | | 1 |
| 75 | C6266C02716A | Gear | | 1 |
| 76 | BB-32208 | Bearing | 32208 | 1 |
| 77 | C6266C02779 | Circlip for Shaft | | 1 |
| 78 | C6266C02715 | Gear | | 1 |
| 79 | C6140W02733 | Clamping Sleeve | | 3 |
| 80 | C6266C02714 | Gear | | 1 |
| 81 | C6266C02713 | Shaft (V) | | 1 |
| 82 | 32308 | Tapered Roller Bearing | 32308 | 1 |
| 83 | C6140W02103 | Shaft Plug (VI) | | 1 |
| 84 | GB3452.1-82.5x3.55 | O-Ring | 82.5x3.55 mm | 1 |
| 85 | C6140W02717 | Hex Socket Cap Screw | | 1 |
| 86 | GB6173-M16x1.5 | Nut | M16x1.5 | 1 |

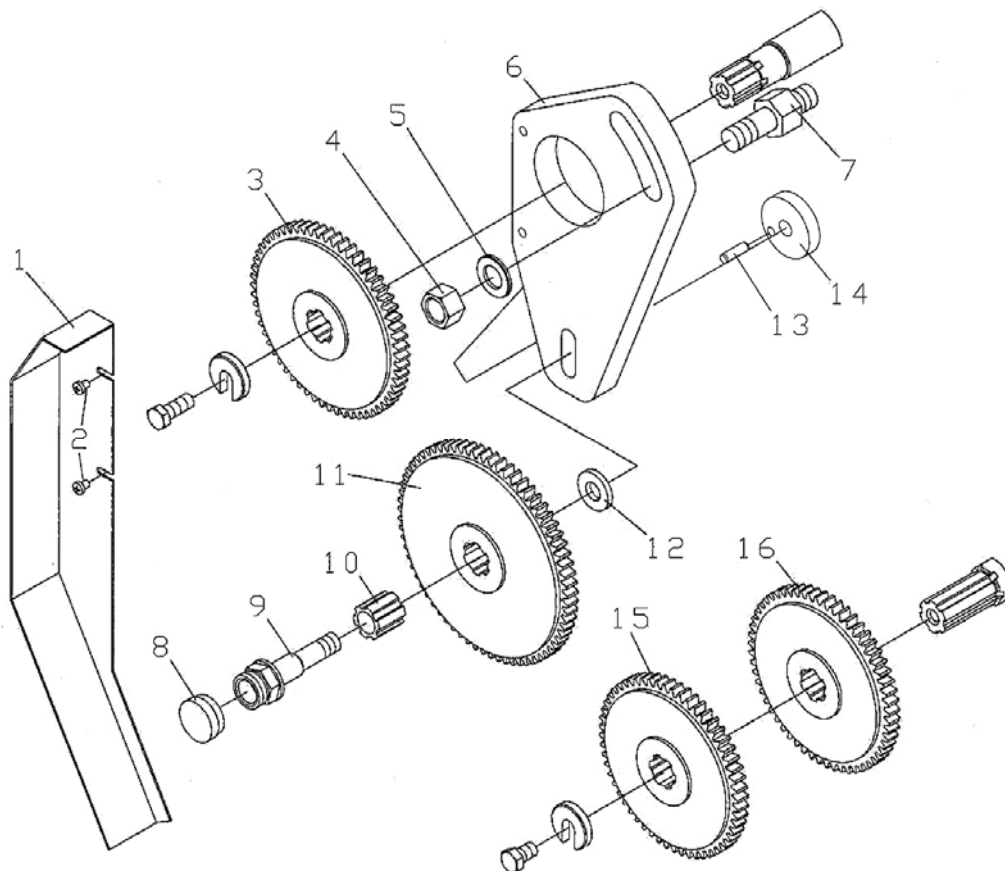
9.0 Headstock Assembly V – Exploded View



9.1 Headstock Assembly V – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-------------------|----------------------------|--------------|-----|
| 1 | TS-1505031 | Hex Socket Cap Screw | M10x25 | 1 |
| 2 | C6266C02108 | Back Flange Cover | | 1 |
| 3 | GB119-6x8 | Pin | 6x8 mm | 1 |
| 4 | G51-2A-12x1.9 | O-Ring | 12x1.9 mm | 4 |
| 5 | GB3452.1-180x2.65 | O-Ring | 18x2.65 mm | 1 |
| 6 | GB894.1-120 | Circlip for Shaft | 120 mm | 1 |
| 7 | C6266C02744 | Bearing Back Circlip | | 1 |
| 8 | 16024 | Ball Bearing | 16024 | 1 |
| 9 | C6266C02743 | Double Gear | | 1 |
| 10 | C6266C02702 | Round Nut | | 1 |
| 11 | TS-1526011 | Hex Socket Cap Screw | M12x12 | 3 |
| 12 | C6266C02703 | Circlip | | 1 |
| 13 | GB893.1-200 | Circlip for Bore | 200 mm | 2 |
| 14 | NN3026K | Cylindrical Roller Bearing | | 1 |
| 15 | C6266C02704 | Gear | | 1 |
| 16 | C6266C02705 | Thread Sleeve | | 1 |
| 17 | C6266C02706 | Nut | | 1 |
| 18 | GB67-M6x10 | Screw | M6x10 | 1 |
| 19 | C6140W02715 | Fixing Plate | | 1 |
| 20 | C6266C02707 | Gear | | 1 |
| 24 | C6266C02708-1 | Round Nut | | 1 |
| 25 | TS-1526021 | Hex Socket Cap Screw | M12x16 | 3 |
| 26 | C6266C02708-2 | Pin | | 3 |
| 27 | 2268930 | Bearing | | 1 |
| 28 | C6266C02709 | Bearing Circlip | | 1 |
| 29 | NN3030K | Bearing | | 1 |
| 30 | C6266C02710 | Round Nut | | 1 |
| 31 | GB3452.1-250x5.3 | O-Ring | 250x5.3 mm | 1 |
| 32 | C6266C02102 | Front Flange Cover | | 1 |
| 33 | C6266C02701 | Spindle | | 1 |
| 34 | GB1096-10x40 | Flat Key | 10x40 mm | 1 |
| 35 | GB1096-10x50 | Flat Key | 10x50 mm | 2 |
| 36 | Q81-1-1x8x16 | Spring | 1x8x16 | 6 |
| 37 | C6266C02711 | Cam | | 6 |
| 38 | C6266C02712 | Positioning Screw | | 6 |
| 39 | TS-1492021 | Hex Cap Screw | M12x30 | 1 |
| 40 | GB851-12 | Split Washer | 12 mm | 1 |
| 41 | GB894.1-30 | Circlip for Shaft | 30 mm | 1 |
| 42 | GB68-M5x12 | Slotted Head Screw | M5x12 | 1 |
| 43 | C6140W02776 | Adjusting Screw | | 1 |
| 44 | BB-6006 | Ball Bearing | 6006 | 1 |
| 45 | GB13871-B-35x51x8 | Oil Seal | B-35x51x8 mm | 1 |
| 46 | TS-1505021 | Hex Cap Screw | M10x20 | 4 |
| 47 | C6266C02110 | Bearing Cover | | 1 |
| 48 | G51-2A-80x3.1 | Oil Seal | 80x3.1 | 1 |
| 49 | C6266C02747 | Shaft (VII) | | 1 |
| 50 | GB894.1-35 | Circlip | 35 mm | 2 |
| 51 | C6266C02746 | Gear | | 1 |
| 52 | BB-6205 | Ball Bearing | 6205 | 1 |
| 53 | GB3452.1-25x2.65 | O-Ring | 25x2.65 mm | 1 |
| 54 | C6266C02748 | Shaft (VIIb) | | 1 |
| 55 | C6266C02745 | Gear | | 1 |
| 56 | GB893.1-47 | Circlip for Bore | 47 mm | 2 |
| 57 | BB-6005 | Ball Bearing | 6005 | 2 |
| 58 | GB894.1-25 | Circlip for Shaft | 25 mm | 1 |
| 59 | C6266C02109 | Sleeve | | 1 |

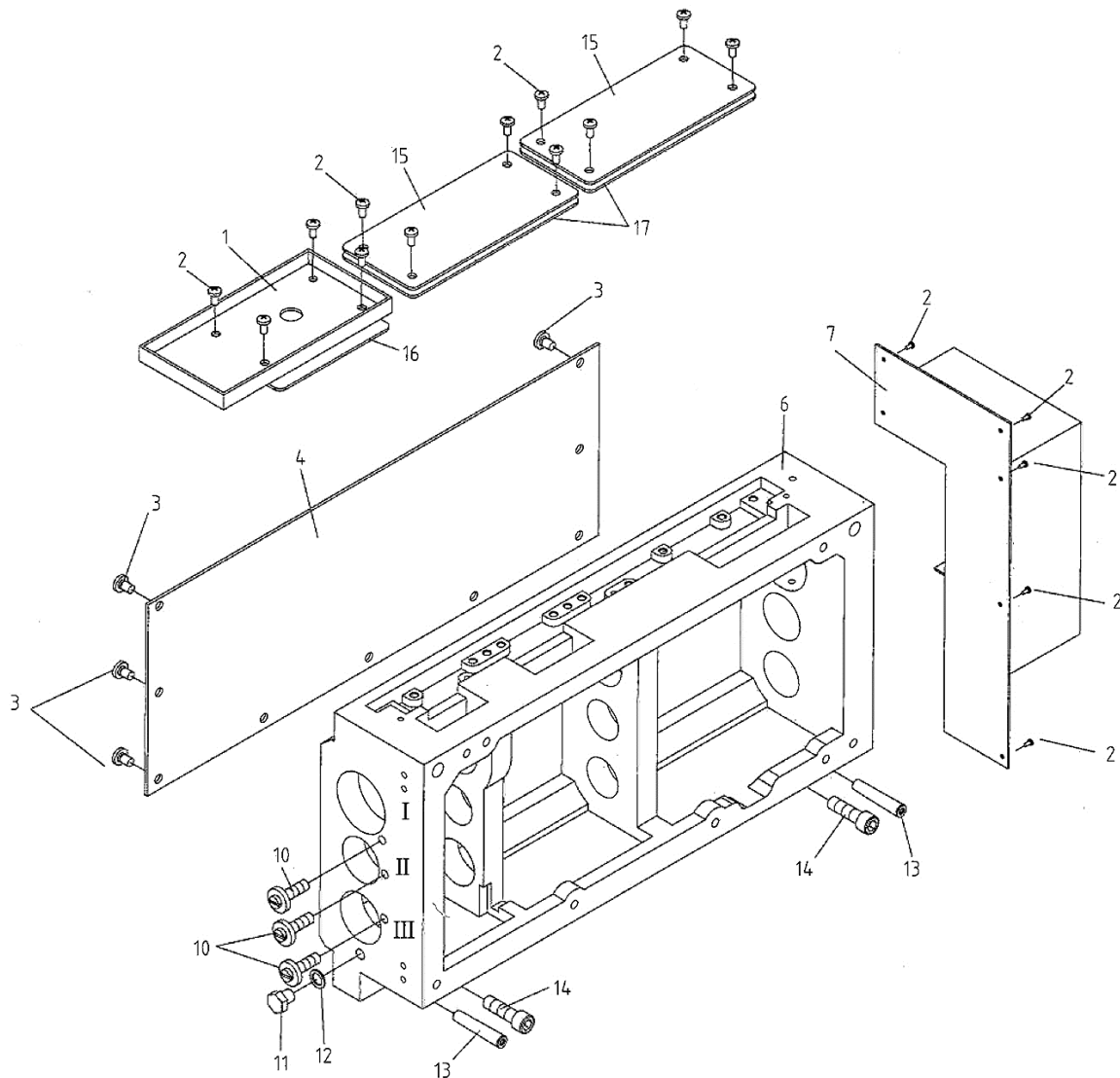
10.0 Gear Assembly – Exploded View



10.1 Gear Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|----------------|---------------|-----------|-----|
| 1 | C6266C08708 | Splash Guard | | 1 |
| 2 | GB818-M6x8 | Screw | M6x8 | 2 |
| 3 | C6266C08702 | Gear (in.) | 2m82T | 1 |
| 4 | GB6172-M20 | Hex Nut | M20 | 1 |
| 5 | GB97.2-20 | Washer | 20 mm | 1 |
| 6 | C6266C08101 | Quadrant | | 1 |
| 7 | C6266C02776 | Bolt | | 1 |
| 8 | C6140W08703 | Nut Cover | | 1 |
| 9 | C6140W08702 | Gear Shaft | | 1 |
| 10 | C6140W08301 | Spline Sleeve | | 1 |
| 11 | C6266C08102 | Gear (in.) | 2m97T | 1 |
| 12 | C6266C08701 | Washer | | 1 |
| 13 | GB119-8n6x20 | Pin | 8n6x20 mm | 1 |
| 14 | C6140W08704 | Position Nut | | 1 |
| 15 | C6266C08703 | Gear (in.) | 2m81T | 1 |
| 16 | C6266C08704 | Gear (in.) | 2m57T | 1 |
| 16-2 | C6266C08716 | Gear (in.) | 2m69T | 1 |
| 16-3 | C6266C08717-63 | Gear (in.) | 2m63T | 1 |
| 16-4 | C6266C08717-90 | Gear (in.) | 2m90T | 1 |
| 16-5 | C6266C08717-78 | Gear (in.) | 2m78T | 1 |

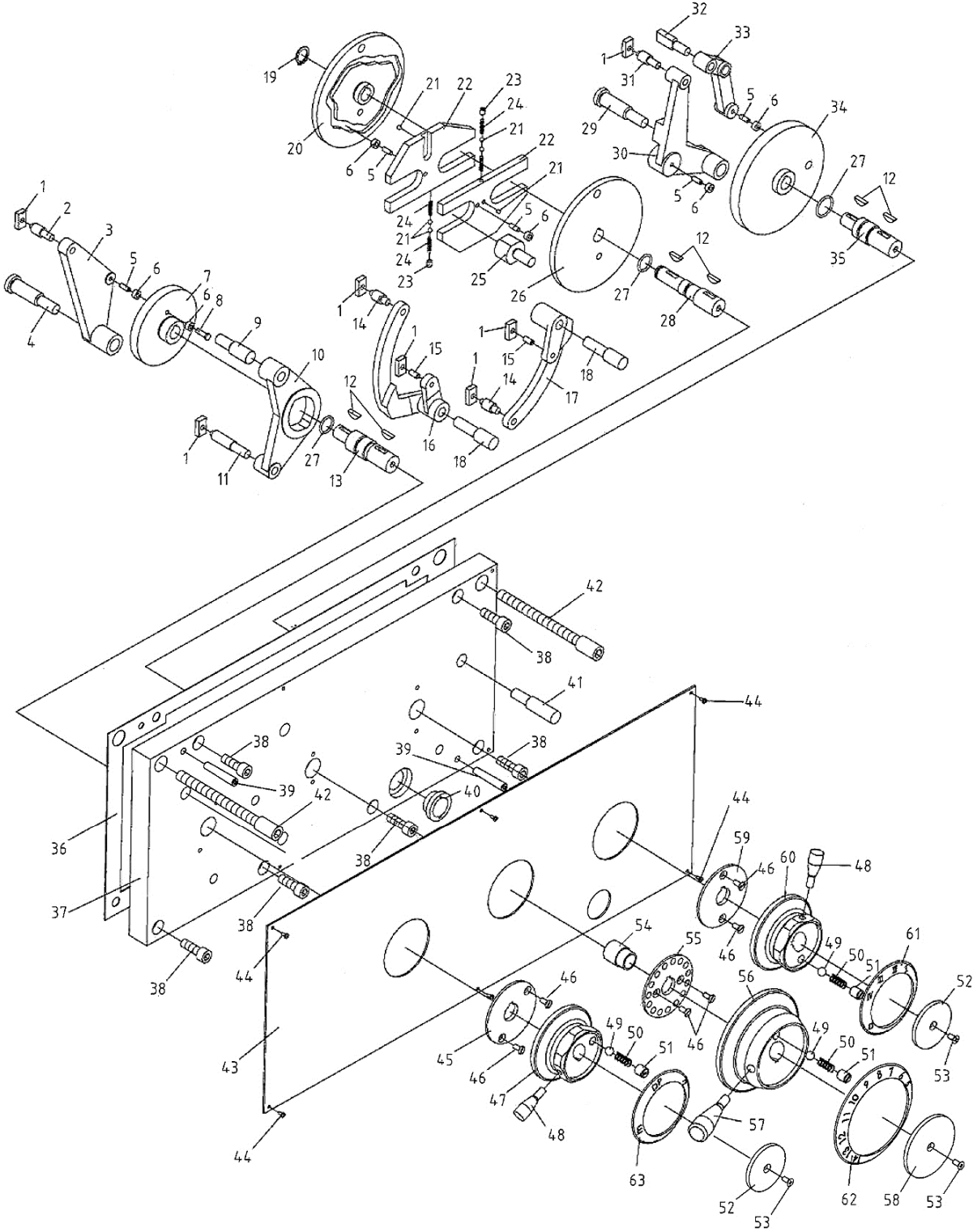
11.0 Gear Box Assembly I – Exploded View



11.1 Gear Box Assembly I – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|----------------|-------------------------------|----------|-----|
| 1 | C6140W05504 | Upper Cover | | 1 |
| 2 | TS-1534032 | Cross Recessed Pan Head Screw | M6x10 | 14 |
| 3 | TS-1490011 | Hex Cap Screw | M8x12 | 9 |
| 4 | C6140W05A729 | Back Cover | | 1 |
| 6 | C6140W05A101 | Feed Box Casting | | 1 |
| 7 | C6266C05765J | Side Splash Guard | | 1 |
| 10 | C6140W05A728 | Bolt with Washer | | 3 |
| 11 | G38-2A-M12x1.5 | Hex Cap Screw | M12x1.5 | 1 |
| 12 | TS-2360121 | Washer | 12 mm | 1 |
| 13 | GB118-10x50 | Taper Pin | 10x50 mm | 2 |
| 14 | TS-1506051 | Hex Socket Cap Screw | M12x40 | 2 |
| 15 | C6266C05768 | Panel | | 2 |
| 16 | C6266C-05501 | Gasket | | 1 |
| 17 | C6266C-05502 | Gasket | | 2 |

12.0 Gear Box Assembly II – Exploded View

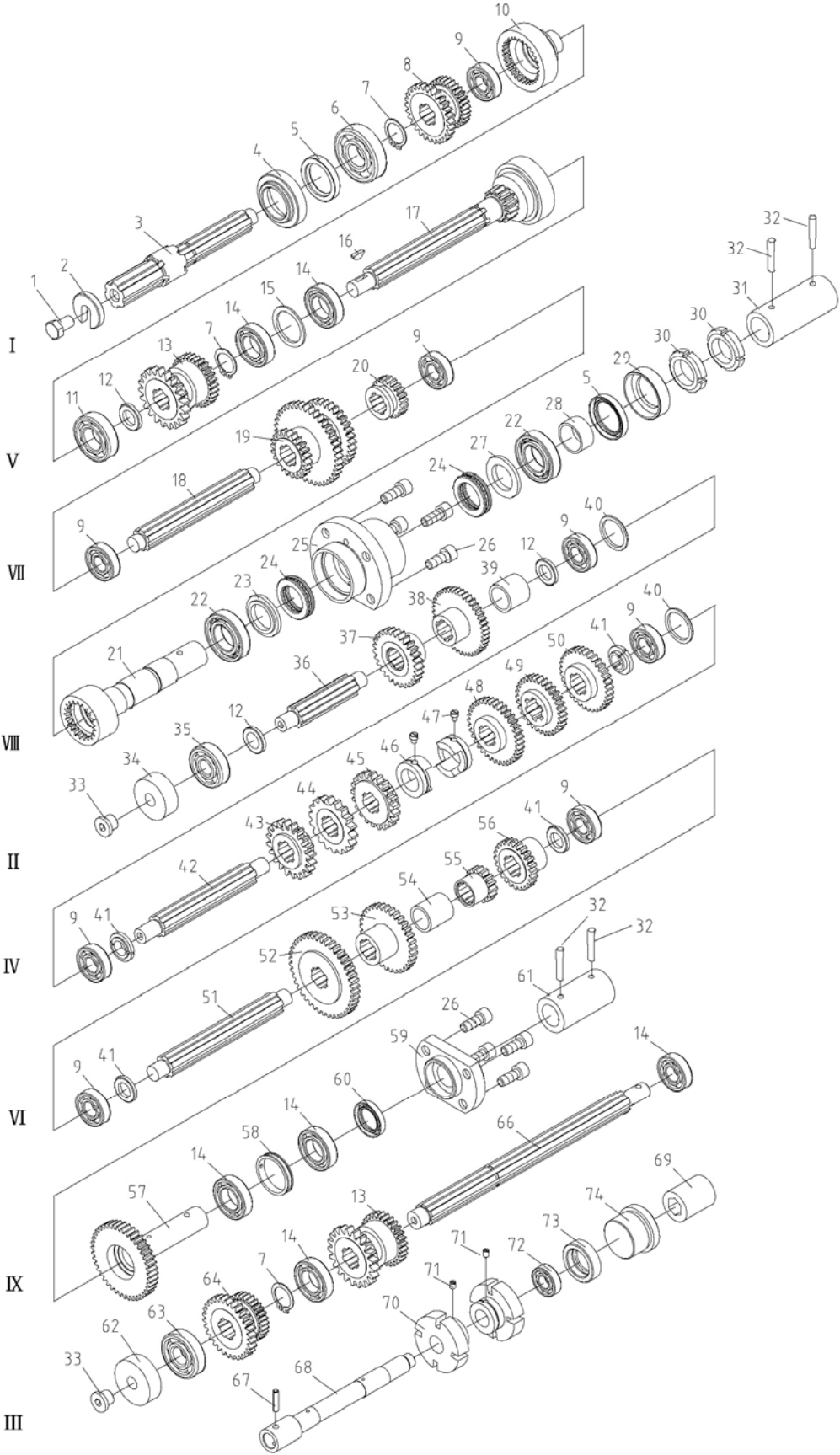


12.1 Gear Box Assembly II – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|----------------|-------------------------------|-------------|-----|
| 1 | C6140W05109 | Sliding Block | | 7 |
| 2 | C6140W05A701 | Shaft | | 2 |
| 3 | C6140W05A105 | Ratio Change Rocker | | 1 |
| 4 | C6140W05709 | Rocker Shaft | | 2 |
| 5 | GB119-5x14 | Pin | 5x14 mm | 6 |
| 6 | C6140W05720 | Roller | | 6 |
| 7 | C6140W05A708 | Cam | | 1 |
| 8 | C6140W05A703 | Roller Shaft | | 1 |
| 9 | C6140W05702 | Shaft | | 1 |
| 10 | C6140W05A103 | Rocker | | 1 |
| 11 | C6140W05A710 | Shaft | | 1 |
| 12 | GB1099-5x19 | Woodruff Key | 5x19 mm | 6 |
| 13 | C6140W05707 | Shaft | | 1 |
| 14 | C6140W05A711 | Shaft | | 1 |
| 15 | GB119-6x14 | Pin | 6x14 mm | 2 |
| 16 | C6140W05A110 | Shaft | | 1 |
| 17 | C6140W05A106 | Upper Rocker | | 1 |
| 18 | C6140W05712 | Shaft | | 2 |
| 19 | GB894.1-16 | Circlip for Shaft | 16 mm | 1 |
| 20 | C6140W05A717 | Cam | | 1 |
| 21 | SB-5MM | Steel Ball | 5 mm | 6 |
| 22 | C6140W05A719 | Pulley | | 2 |
| 23 | TS-1523021 | Set Screw | M6x8 | 2 |
| 24 | Q81-1-0.6x4x20 | Spring | 0.6x4x20 mm | 4 |
| 25 | C6140W05A718 | Positioning Column | | 1 |
| 26 | C6140W05109 | Sliding Block | | 1 |
| 27 | G51-2A-25x2.4 | O-Ring | 25x2.4 mm | 3 |
| 28 | C6140W05A716 | Handle Axle | | 1 |
| 30 | C6140W05A112 | Rocker | | 1 |
| 31 | C6140W05A721 | Shaft | | 1 |
| 32 | C6140W05A722 | Shaft | | 1 |
| 33 | C6140W05A111 | Rocker | | 1 |
| 34 | C6140W05A725 | Cam | | 1 |
| 35 | C6140W05A723 | Shaft | | 1 |
| 36 | C6140W05A501 | Gasket | | 1 |
| 37 | C6140W05A115 | Front Cover | | 1 |
| 38 | TS-1505041 | Hex Socket Cap Screw | M10x30 | 6 |
| 39 | GB118-8x50 | Pin | 8x50 mm | 2 |
| 40 | C6266CGBA40 | Oil Sight Glass | | 1 |
| 41 | C6140W05721 | Shaft | | 1 |
| 42 | C6140W05A727 | Hex Socket Cap Screw | | 1 |
| 43 | C6266C05301A-7 | Gearbox Label Panel | | 1 |
| 44 | TS-1531012 | Cross Recessed Pan Head Screw | M3x6 | 6 |
| 45 | C6140W05A704 | Positioning Disc | | 1 |
| 46 | GB68-M6x12 | Slotted Head Screw | M6x12 | 6 |
| 47 | C6140W05A104 | Lever Support | | 1 |
| 48 | C6140W05705 | Lever | | 2 |
| 49 | SB-10MM | Steel Ball | 10 mm | 3 |
| 50 | Q81-1-1.6x8x28 | Spring | 1.6x8x28 | 3 |
| 51 | GB73-M12x14 | Slotted Set Screw | M12x14 | 3 |
| 52 | C6140W05706 | Disc | | 2 |
| 53 | GB819-M5x12 | Cross Recessed Head Screw | M5x12 | 3 |
| 54 | C6140W05A108 | Collar | | 1 |
| 55 | C6140W05A713 | Positioning Disc | | 1 |
| 56 | C6140W05A107 | Lever Support | | 1 |
| 57 | C6140W05714 | Lever | | 1 |
| 58 | C6140W05715 | Cover | | 1 |
| 59 | C6140W05A724 | Positioning Disc | | 1 |

| Index No. | Part No. | Description | Size | Qty |
|------------------|-----------------|--------------------|-------------|------------|
| 60 | C6140W05A113 | Lever Support | | 1 |
| 61 | C6140W05308 | Handle Panel | | 1 |
| 62 | C6140W05A307 | Handle Panel | | 1 |
| 63 | C6140W05306 | Handle Panel | | 1 |

13.0 Gear Box Assembly III – Exploded View

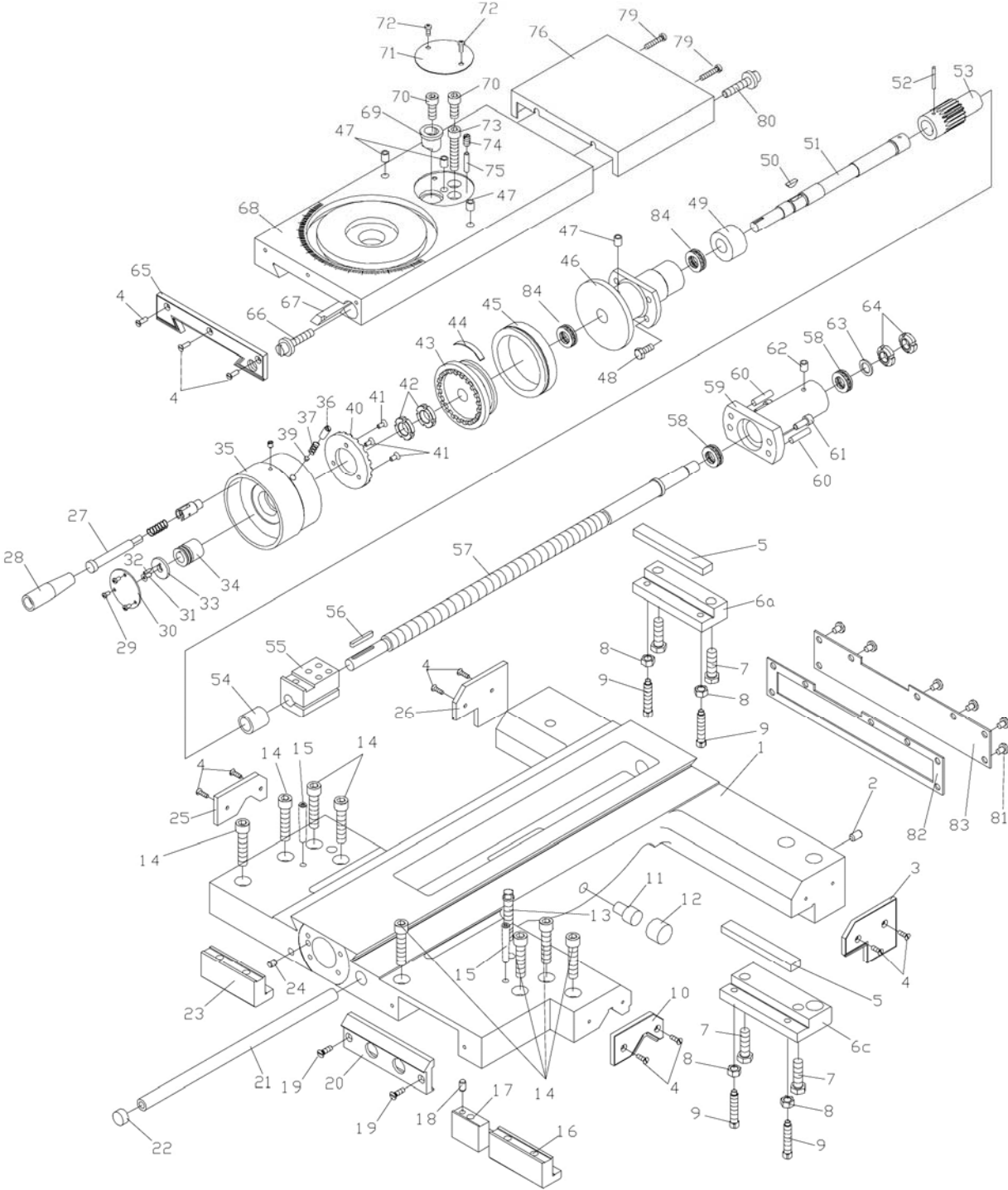


13.1 Gear Box Assembly III – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|--------------------|--------------|-----|
| 1 | GB5783-M12x20 | Hexagon Head Bolt | M12x20 | 1 |
| 2 | GB851-A12x40 | Split Washer | A12x40 | 1 |
| 3 | C6140W05A730 | Shaft (I) | | 1 |
| 4 | C6266C05772J | Bearing Cover | | 1 |
| 5 | G51-1-B35x50x8 | Oil Seal | B-35x50x8 | 2 |
| 6 | BB-6305 | Ball Bearing | 25x62x17 | 1 |
| 7 | GB894.1-25 | Circlip for Shaft | 25 mm | 3 |
| 8 | C6140W05731 | Double Gear | | 1 |
| 9 | BB-6203 | Ball Bearing | 17x40x12 mm | 7 |
| 10 | C6140W05732 | Gear | | 1 |
| 11 | BB-6205 | Ball Bearing | 25x52x15 | 1 |
| 12 | C6140W05127 | Spacer | | 3 |
| 13 | C6140W05733 | Double Gear | | 2 |
| 14 | BB-6005 | Ball Bearing | 25x47x12 | 4 |
| 15 | C6140W05736 | Spacer | | 2 |
| 16 | GB1099-4x16 | Woodruff Key | 4x16 mm | 1 |
| 17 | C6140W05A735 | Shaft (V) | | 1 |
| 18 | C6140W05A738 | Shaft (VII) | | 1 |
| 19 | C6140W05737 | Triple Gear | | 1 |
| 20 | C6140W05739 | Gear | | 1 |
| 21 | C6140W05743 | Shaft (VIII) | | 1 |
| 22 | 16006 | Bearing | 30x55x9 | 2 |
| 23 | C6140W05740 | Spacer | | 2 |
| 24 | BB-51106 | Thrust Bearing | 30x47x11 | 2 |
| 25 | C6140W05A117 | Flange Sleeve | | 1 |
| 28 | C6266C05773J | Sleeve | | 1 |
| 29 | C6266C05741J | Bearing Cover | | 1 |
| 30 | C6140W05742 | Round Nut | | 2 |
| 31 | C6140W05119 | Shaft | | 1 |
| 32 | GB117-6x40 | Taper Pin | 6x40 mm | 4 |
| 33 | G38-4A-M16x1.5 | Plug | M16x1.5 | 2 |
| 34 | C6140W05128 | Bearing Cover | | 1 |
| 35 | BB-6303 | Ball Bearing | 17x47x14 | 1 |
| 36 | C6140W05A762 | Shaft (II) | | 1 |
| 37 | C6140W05763 | Gear | | 1 |
| 38 | C6140W05764 | Gear | | 1 |
| 39 | C6140W05125 | Sleeve | | 1 |
| 40 | C6140W05751 | Sleeve | | 2 |
| 41 | C6140W05A752 | Adjust Washer | | 4 |
| 42 | C6140W05A754 | Shaft (IV) | | 1 |
| 43 | C6140W05A759 | Gear | | 1 |
| 44 | C6140W05758 | Gear | | 1 |
| 45 | C6140W05757 | Gear | | 1 |
| 46 | C6140W05A734 | Positioning Sleeve | | 2 |
| 47 | GB75-M8x10 | Slotted Set Screw | M8x10 | 2 |
| 48 | C6140W05756 | Gear | | 1 |
| 49 | C6140W05755 | Gear | | 1 |
| 50 | C6140W05753 | Gear | | 1 |
| 52 | C6140W05750 | Gear | | 1 |
| 53 | C6140W05A748 | Gear | | 1 |
| 54 | C6140W05A124 | Sleeve | | 1 |
| 55 | C6140W05747 | Gear | | 1 |
| 56 | C6140W05746 | Gear | | 1 |
| 57 | C6140W05745 | Shaft (IX) | | 1 |
| 58 | C6140W05A744 | Sleeve | | 1 |
| 59 | C6266C05121W | Flange Sleeve | | 1 |
| 60 | G51-1-B-25x40x7 | Oil Seal | B-25x40x7 mm | 1 |
| 61 | C6140W05120 | Shaft Connector | | 1 |
| 62 | C6140W05126 | Bearing Cover | | 1 |

| Index No. | Part No. | Description | Size | Qty |
|------------------|-----------------|--------------------|-------------|------------|
| 63 | BB-6304 | Ball Bearing | 20x52x15 | 1 |
| 64 | C6140W05761 | Double Gear | | 1 |
| 66 | C6266C05760W | Shaft (III) | | 1 |
| 67 | GB879-6x25 | Straight Pin | 6x25 mm | 1 |
| 68 | C6266C05770W | Shaft | | 1 |
| 69 | C6140W05122 | Sleeve | | 1 |
| 70 | C6266C05130J | Oil Splash Ring | | 2 |
| 71 | GB71-M6x10 | Slotted Set Screw | M6x10 | 2 |
| 72 | BB-6002 | Ball Bearing | 15x32x9 | 1 |
| 73 | C6266C05774J | Sleeve | | 1 |
| 74 | C6266C05123J | Sleeve | | 1 |

14.0 Saddle and Cross Slide Assembly – Exploded View

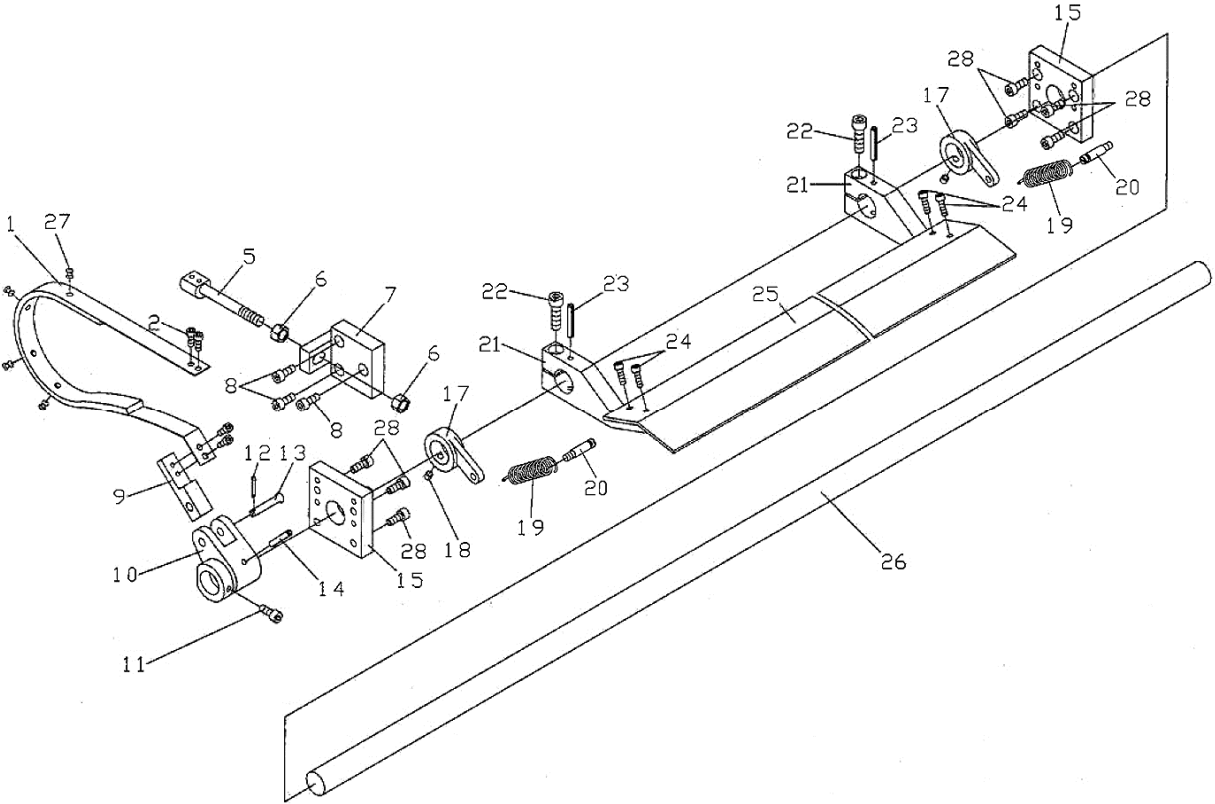


14.1 Saddle and Cross Slide Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|---|----------|-----|
| 1 | C6266C04101A | Saddle | | 1 |
| 2 | GB73-M10x16 | Slotted Set Screw | M10x16 | 1 |
| 3 | C614W04503 | Wipe Plate | | 1 |
| 4 | GB819-M5x16 | Cross Recessed Flat Head Screw | M5x16 | 8 |
| 5 | C614W04107 | Lining Plate | | 1 |
| 6a | C614W04718 | Clamping Plate | | 1 |
| 6c | C614W04720 | Clamping Plate | | 1 |
| 7 | TS-1506061 | Hex Socket Cap Screw | M12x45 | 4 |
| 8 | TS-1540081 | Hex Nut | M12 | 4 |
| 9 | GB85-M10x35 | Square Set Screw | M10x35 | 4 |
| 10 | C6266C04503 | Wipe Plate | | 1 |
| 11 | 1440R04788 | Stop Pin | | 1 |
| 12 | 1440R04507 | Stop Pin Cap | | 1 |
| 13 | GB83-M12x70 | Square Cap Bolt | M12x70 | 1 |
| 14 | GB70-M12x55 | Hex Socket Cap Screw | M12x55 | 8 |
| 15 | GB119-8x60 | Pin | 8x60 mm | 2 |
| 16 | C614W04713 | Front Clamping Plate | | 2 |
| 17 | C614W04712 | Locking Plate | | 1 |
| 18 | GB119-8n6x20 | Pin | 8n6x20 | 1 |
| 19 | GB68-M6x22 | Recessed Countersunk Head Screw | M6x22 | 2 |
| 20 | C614W04715 | Switch Seat | | 1 |
| 21 | C614W04711 | Line Pipe | | 1 |
| 22 | C614W04106 | Plug | | 1 |
| 23 | C614W04720 | Back Clamping Block | | 1 |
| 24 | GB119-8n6x10 | Pin | 8n6x10 | 1 |
| 25 | C6266C04503 | Wipe Plate | | 1 |
| 26 | C614W04504 | Wipe Plate | | 1 |
| 27 | C6266C04756T | Lever Shaft | | 1 |
| 28 | C6266C04757T | Lever Sleeve | | 1 |
| 29 | GB818-M4x8 | Cross Recessed Flat Head Screw | M4x8 | 3 |
| 30 | C6266C04306 | Panel | | 1 |
| 31 | GB819-M5x12 | Cross Recessed Flat Head Screw | M5x12 | 1 |
| 32 | GB119-3n6x10 | Pin | 3n6x10 | 1 |
| 33 | C6266C04725 | Cover | | 1 |
| 34 | C6266C04724J | Sleeve | | 1 |
| 35 | C6266C04754J | Handle | | 1 |
| 36 | GB73-M8x10 | Slotted Set Screw | M8x10 | 1 |
| 37 | Q81-1-0.8x6x12 | Spring | 0.8x6x12 | 1 |
| 39 | C6266C04733 | Positioning Pin | | 1 |
| 40 | C6266C04720 | Connector | | 1 |
| 41 | GB819-M5x14 | Cross Recessed Flat Head Screw | M5x14 | 3 |
| 42 | GB812-M18x1.5 | Round Nut | M18x1.5 | 2 |
| 43 | C6266C04719 | Connector | | 1 |
| 44 | C6266C04718 | Leaf Spring | | 1 |
| 45 | C6266C04735D | Dial (inches) | | 1 |
| 46 | C614W04107 | Screw Support (serial #101129ZH0005 and lower) | | 1 |
| | C6266C04107JA | Screw Support (serial #111105ZH0006 and higher) | | 1 |
| 47 | GB1155-6 | Oil Cup | 6 mm | 1 |
| 48 | GB70-M8x45 | Hex Socket Cap Screw | M8x45 | 4 |
| 49 | C6266C04109J | Sleeve (serial #101129ZH0005 and lower) | | 1 |
| | C6266C04109 | Sleeve (serial #111105ZH0006 and higher) | | 1 |
| 50 | GB1099-5x7.5x19 | Woodruff Key | 5x7.5x19 | 1 |
| 51 | C6266C04726J | Shaft | | 1 |
| 52 | GB117-4x35 | Taper Pin | 4x35 mm | 1 |
| 53 | C6266C04705 | Shaft | | 8 |
| 54 | C6266C04103 | Sleeve | | 1 |
| 55 | C6266C04304YA | Nut (inch threads) | | 1 |
| 56 | GB1096-5x40 | Flat Key | 5x40 mm | 1 |
| 57 | C6266C04701A | Lead Screw (inch threads) | | 1 |

| Index No. | Part No. | Description | Size | Qty |
|-----------|---------------|---|---------|-----|
| 58 | 51103 | Thrust Bearing | 17x30x9 | 2 |
| 59 | C6266C04110 | Bracket | | 1 |
| 60 | GHB1340-84 | Taper Pin | 8x40 mm | 2 |
| 61 | TS-1504041 | Hex Socket Cap Screw | M8x20 | 2 |
| 62 | GB1155-6 | Oil Cup | 6 mm | 1 |
| 63 | C6266C04702 | Washer | | 1 |
| 64 | GB812-M14x1.5 | Round Nut | M14x1.5 | 2 |
| 65 | C6266C04501 | Wipe Plate | | 1 |
| 66 | C6266C04727 | Gib Setting Screw | | 1 |
| 67 | C6266C04728 | Cross Slide Gib | | 1 |
| 68 | C6266C04102A | Cross Slide | | 1 |
| 69 | C6266C04704 | Sleeve | | 1 |
| 70 | TS-1505071 | Hex Socket Cap Screw | M10x45 | 2 |
| 71 | C6140W04714 | Cover | | 1 |
| 72 | GB818-M5x8 | Cross Recessed Pan Head Screw | M5x8 | 2 |
| 73 | GB70-M10x75 | Hex Socket Cap Screw | M10x75 | 1 |
| 74 | GB73-M8x40 | Slotted Set Screw | M8x40 | 1 |
| 75 | GB119-6x35 | Pin | 6x35 mm | 1 |
| 76 | C6266C04703 | Splash Guard | | 1 |
| 79 | GB65-M6x12 | Slotted Socket Cap Screw | M6x12 | 2 |
| 80 | C6266C04727 | Gib Adjusting Screw | | 1 |
| 81 | GB818-M6x8 | Cross Recessed Pan Head Screw | M6x8 | 7 |
| 82 | C6266C04502A | Gasket | | 1 |
| 83 | C6266C04729A | Cover | | 1 |
| 84 | 51104 | Bearing (serial #111105ZH0006 and higher) | | 2 |

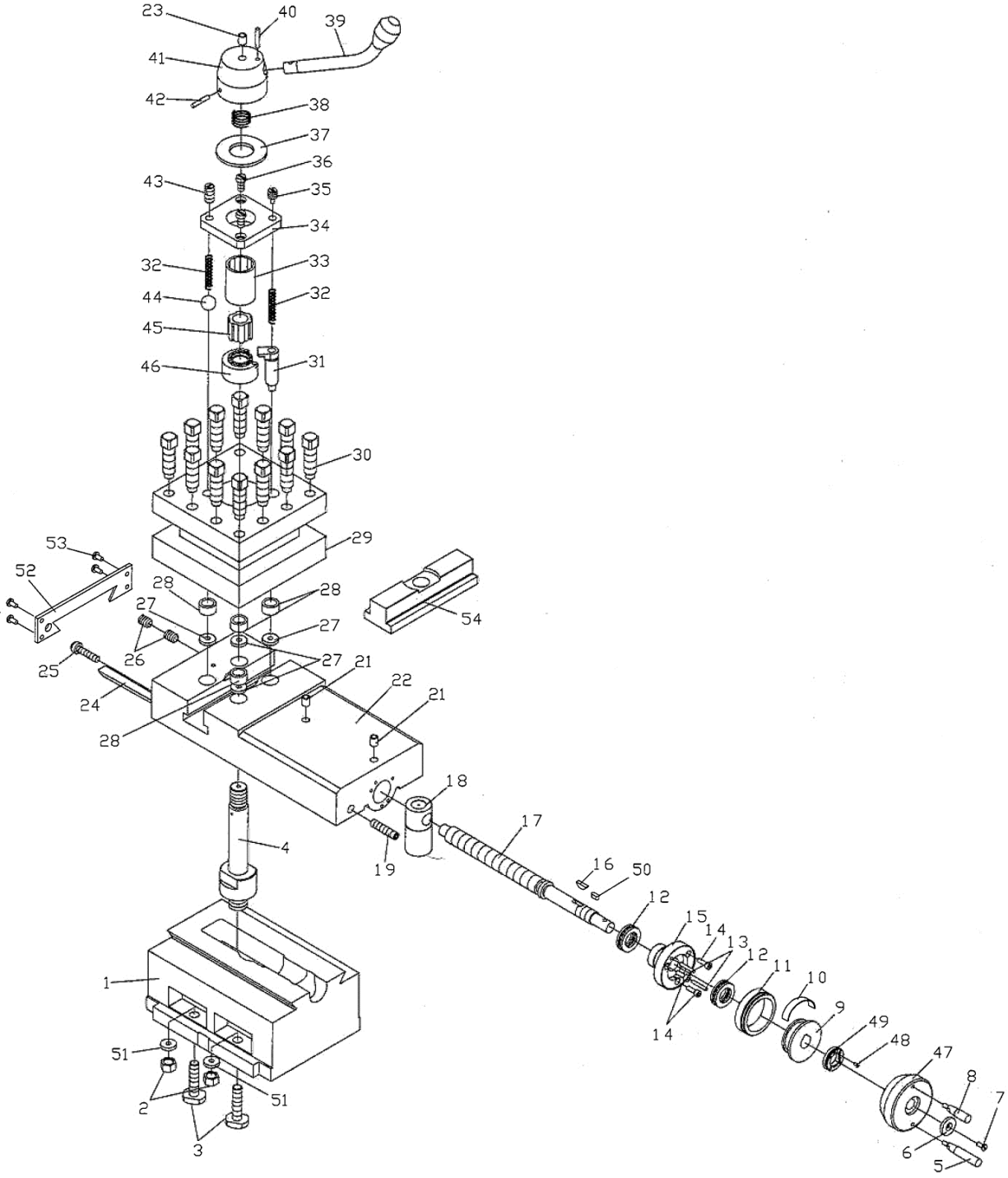
15.0 Brake Assembly – Exploded View



15.1 Brake Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|---------------------------------------|--------------|-----|
| 1 | C6266C22705 | Brake Belt (includes #27) | | 1 |
| 2 | GB70-M6x14 | Hex Socket Cap Screw | M6x14 | 4 |
| 5 | C6266C22704 | Bolt | | 1 |
| 6 | TS-2311121 | Hex Nut | M12 | 2 |
| 7 | C6266C22103 | Braking Belt Support | | 1 |
| 8 | TS-1504041 | Hex Socket Cap Screw | M8x20 | 3 |
| 9 | C6266C22706 | Brake Block | | 1 |
| 10 | C6266C22104 | Fork | | 1 |
| 11 | TS-1504041 | Hex Socket Cap Screw | M8x20 | 1 |
| 12 | GB91-3x20 | Cotter Pin | 3 x 20 mm | 1 |
| 13 | C6266C22707 | Clevis Pin | | 1 |
| 14 | GB879-6x45 | Spring Pin | 6x45 mm | 1 |
| 15 | C6266C22101 | Support (for 80" Lathe) | | 2 |
| | C6266C22101 | Support (for 120" Lathe) | | 4 |
| 17 | C6266C22102 | Brake Support (for 80" Lathe) | | 2 |
| | C6266C22102 | Brake Support (for 120" Lathe) | | 4 |
| 18 | TS-1524041 | Hex Socket Set Screw | M8x8 | 2 |
| | TS-1524041 | Hex Socket Set Screw | M8x84 | 4 |
| 19 | Q81-1-2.5X18X80 | Spring (for 80" Lathe) | 2.5x18x80 mm | 2 |
| | Q81-1-2.5X18X80 | Spring (for 120" Lathe) | 2.5x18x80 mm | 4 |
| 20 | C6266C26702 | Screw (for 80" Lathe) | | 2 |
| | C6266C26702 | Screw (for 120" Lathe) | | 4 |
| 21 | C6266C22105 | Brake Support (for 80" Lathe) | | 3 |
| | C6266C22105 | Brake Support (for 120" Lathe) | | 6 |
| 22 | TS-1505051 | Hex Socket Head Cap Screw | M10x35 | 3 |
| | TS-1505051 | Hex Socket Head Cap Screw | M10x35 | 6 |
| 23 | GB879-6x45 | Spring Pin (for 80" Lathe) | 6x45 mm | 3 |
| | GB879-6x45 | Spring Pin (for 120" Lathe) | 6x45 mm | 3 |
| 24 | TS-1503051 | Hex Socket Cap Screw (for 80" Lathe) | M6x20 | 4 |
| | TS-1503051 | Hex Socket Cap Screw (for 120" Lathe) | M6x20 | 8 |
| 25 | C6266C22708C | Pedal (for 80" Lathe only) | | 1 |
| | C6266C22708D | Pedal (for 120" Lathe only) | | 2 |
| 26 | C6266C22703C | Shaft (for 80" Lathe only) | | 1 |
| | C6266C22703D | Shaft (for 120" Lathe only) | | 1 |
| 27 | GB869-M6x10 | Rivet | M6x10 | 4 |
| 28 | TS-1504041 | Hex Socket Cap Screw (for 80" Lathe) | M8x20 | 8 |
| | TS-1504041 | Hex Socket Cap Screw (for 120" Lathe) | M8x20 | 16 |

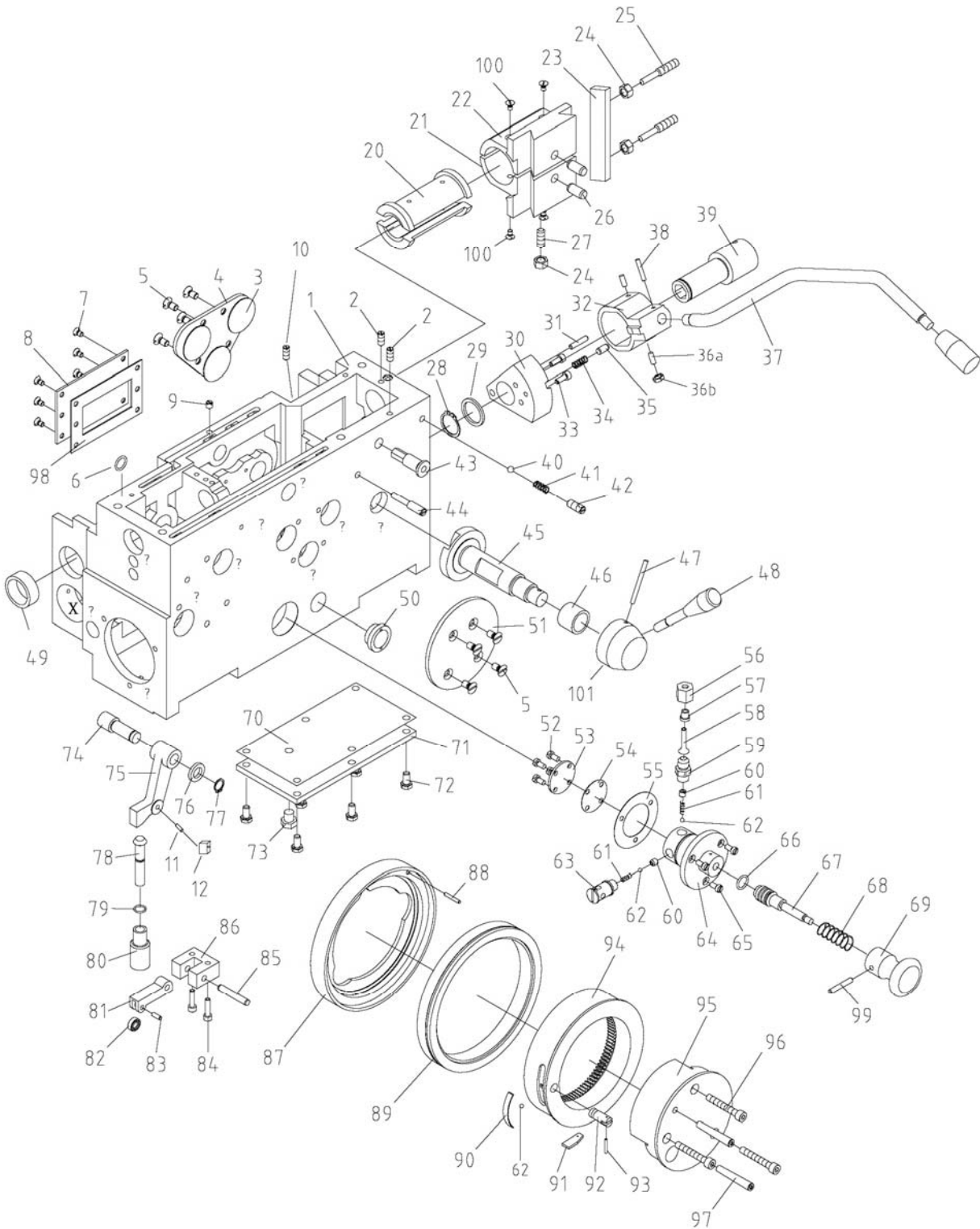
16.0 Tool Post and Compound Rest Assembly – Exploded View



16.1 Tool Post and Compound Rest Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|--|------------|-----|
| | GH2680ZH-CCPA | Complete Compound Assembly (includes #1 thru 54) | | 1 |
| 1 | C6266C04104 | Revolving Plate | | 1 |
| 2 | TS-1540081 | Hex Nut | M12 | 4 |
| 3 | C6266C04706 | Compound Screw | | 4 |
| 4 | C6266C04707 | Shaft (serial #100710ZH0002 and lower) | | 1 |
| | C6266C04707K-1 | Shaft (serial #101129ZH0003 and higher) | | 1 |
| 5 | C666C04758J | Handle | | 2 |
| 6 | GB891-B25 | Circlip | B25 | 1 |
| 7 | GB819-M5x12 | Cross Recessed Flat Head Screw | M5x12 | 1 |
| 8 | C6266C04757J | Handle | | 1 |
| 9 | C6140W04110 | Dial | | 1 |
| 10 | C6140W04739 | Leaf Spring | | 1 |
| 11 | C6266C04736A | Dial (inches) | | 1 |
| 12 | BB-51104 | Thrust Bearing | 20x35x10 | a2 |
| 13 | GB117-4x25 | Taper Pin | 4x25 | 2 |
| 14 | CL1640ZX-0221 | Hex Socket Cap Screw | M5x14 | 3 |
| 15 | C6140W04111A | Bearing | | 1 |
| 16 | GB1099-5x7.5x19 | Woodruff Key | 5x7.5x19 | 1 |
| 17 | C6266C04734JA | Lead Screw (inch) | | 1 |
| 18 | C6266C04301A | Nut (inch) | | 1 |
| 19 | GB77-M12x70 | Hex Socket Set Screw | M12x70 | 1 |
| 21 | GB1155-10 | Oil Cup | 10 mm | 1 |
| 22 | C6266C04105 | Longitudinal Slide (serial #100710ZH0002 and lower) | | 1 |
| | C6266C04105K | Longitudinal Slide (serial #101129ZH0003 and higher) | | 1 |
| 23 | GB1155-6 | Oil Cup | 6 mm | 3 |
| 24 | C6266C04717 | Slide Gib | | 1 |
| 25 | C6266C04716 | Adjust Screw | | 1 |
| 26 | GB73-M10x20 | Slotted Set Screw | M10x20 | 2 |
| 27 | C6140W04727 | Washer | | 1 |
| 28 | C6140W04728 | Positioning Sleeve | | 1 |
| 29 | C6266C04708J | Tool Post | | 1 |
| 30 | GB83-M16x50 | Square Cap Bolt | M16x50 | 12 |
| 31 | C6266C04715 | Positioning Pin | | 1 |
| 32 | Q81-1-1.6x8x100 | Spring | | 4 |
| 33 | C6266C04712 | Spline | | 1 |
| 34 | C6266C04709 | Flange Disc | | 1 |
| 35 | C6140W04732 | Bolt | | 1 |
| 36 | TS-1504031 | Hex Socket Cap Screw | M8x16 | 2 |
| 37 | C6266C04710 | Adjusting Washer | | 1 |
| 38 | Q81-1-3x32x55 | Spring | 3x32x55 mm | 1 |
| 39 | C6266C04711 | Handle | | 1 |
| 40 | GB119-5n6x32 | Pin | 5n6x32 mm | 1 |
| 41 | C6266C04106 | Lever Support | | 1 |
| 42 | GB117-4x40 | Taper Pin | 4x40 mm | 1 |
| 43 | GB73-M12x14 | Slotted Set Screw | M12x14 | 1 |
| 44 | SB-19 | Steel Ball | 19 mm | 1 |
| 45 | C6266C04713 | Connector | | 1 |
| 46 | C6266C04714 | Connector | | 1 |
| 47 | C6266C04752JA | Handle Seat (serial #0811ZH0352 and higher) | | 1 |
| 48 | GB68-M3x6 | Slotted Head Screw (serial #0811ZH0352 and higher) | M3x6 | 1 |
| 49 | C6266C04758T | Locking Nut (serial #0811ZH0352 and higher) | | 1 |
| 50 | GB1096-5x12 | Flat Key (serial #0811ZH0352 and higher) | 5x12 mm | 1 |
| 51 | TS-2360121 | Flat Washer | 12 mm | 4 |
| 52 | C6266C04506 | Wipe Plate | | 1 |
| 53 | TS-1533052 | Cross Recessed Pan Head Screw | M5x16 | 4 |
| 54 | C6266C04707K-2 | T-Groove Block (serial #101129ZH0003 and higher) | | 1 |

17.0 Apron Assembly I – Exploded View

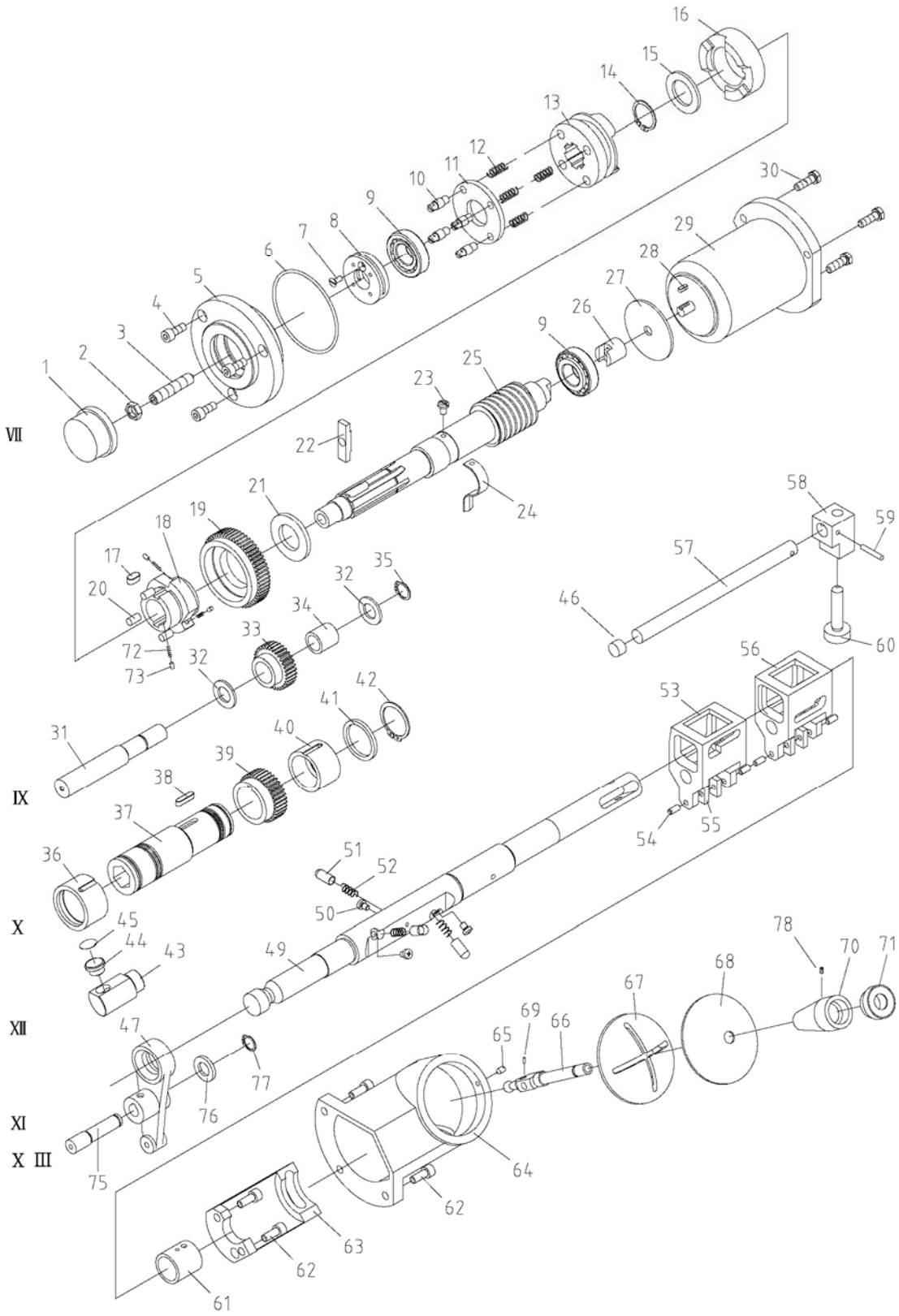


17.1 Apron Assembly I – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|--------------------|---------------------------------|----------------|-----|
| 1 | C6266C06101 | Apron Casting | | 1 |
| 2 | TS-1524051 | Socket Set Screw | M8x20 | 1 |
| 3 | C6266C06506 | Gasket | | 3 |
| 4 | C6140W06750 | Back Cover | | 1 |
| 5 | GB68-M6x12 | Recessed Countersunk Head Screw | M6x12 | 8 |
| 6 | GB3452.1-8.75x1.8G | O-Ring | 8.75x1.8G | 1 |
| 7 | GB68-M6x10 | Recessed Countersunk Head Screw | M6x10 | 4 |
| 8 | C6140W06731 | Cover | | 1 |
| 9 | GB71-M6x10 | Slotted Set Screw | M6x10 | 1 |
| 10 | C6266C06717 | Positioning Screw | | 1 |
| 11 | GB1096-6x14 | Pin | 6x14mm | 1 |
| 12 | C6140W06715 | Block | | 1 |
| 20 | C6140W06302 | Half Nut | | 1 |
| 21 | C6140W06107 | Upper Nut | | 1 |
| 22 | C6140W06108 | Lower Nut | | 1 |
| 23 | C6140W06759 | Gib | | 1 |
| 24 | TS-1540071 | Hex Nut | M10 | 2 |
| 25 | C6140W06758 | Cylindrical End Set Screw | | 1 |
| 26 | GB119-12x25 | Pin | 12x25 mm | 2 |
| 27 | GB73-M10x25 | Slotted Set Screw | M10x25 | 1 |
| 28 | GB894.1-30 | Circlip for Shaft | 30 mm | 1 |
| 29 | C6140W06755 | Washer | | 1 |
| 30 | C6266C06105 | Positioning Block | | 1 |
| 31 | GB117-6x35 | Taper Pin | 6x35 mm | 1 |
| 32 | C6266C06106 | Lever Support | | 1 |
| 33 | TS-1503041 | Hex Socket Cap Screw | M6x16 | 2 |
| 34 | Q81-1-1.2x8x22 | Spring | 1.2x8x22 mm | 1 |
| 35 | GB119-8x15 | Pin | 8x15 mm | 1 |
| 36a | TS-1524051 | Hex Socket Set Screw | M8x20 | 2 |
| 36b | GB6172-M8 | Hex Nut | M8 | 2 |
| 37 | C6266C06711J | Control Handle | | 1 |
| 38 | GB117-5x30 | Taper Pin | 5x30 mm | 1 |
| 39 | C6266C06710 | Positioning Sleeve | | 1 |
| 40 | SB-10MM | Steel Ball | 10 mm | 1 |
| 41 | Q81-1-1.5x8x35 | Spring | 1.5x8x35 mm | 1 |
| 42 | GB73-M12x14 | Slotted Set Screw | M12x14 | 1 |
| 43 | C6266C06A780 | Positioning Sleeve | | 1 |
| 44 | C6140W06716 | Bolt | | 1 |
| 45 | C6140W06725 | Shaft (VII) | | 1 |
| 46 | C6140W06303Y | Sleeve | | 1 |
| 47 | GB119-5x60 | Pin | 5x60 mm | 1 |
| 48 | C6140W02799 | Handle | | 1 |
| 49 | C6266C06104 | Sleeve | | 1 |
| 50 | M27x1.5 | Oil Sight Glass | M27x1.5 | 1 |
| 51 | C6140W06760 | Front Cover | | 1 |
| 52 | GB65-M6x10 | Slotted Socket Cap Screw | M6x10 | 4 |
| 53 | C6266C06713 | Pump Cover | | 1 |
| 54 | C6266C06505 | Gasket | | 1 |
| 55 | C6266C06504 | Gasket | | 1 |
| 56 | Y91-1A-8 | Nut | M8 | 1 |
| 57 | C6266C06727 | Sleeve | | 1 |
| 58 | T3-M | Copper Pipe | Ø6x0.75x450 mm | 1 |
| 59 | C6266C06726 | Valve | | 1 |
| 60 | C6266C06714 | Adjusting Bolt | | 2 |
| 61 | Q81-1-0.3x3x12 | Spring | 0.3x3x12 | 2 |
| 62 | SB-5MM | Steel Ball | 5 mm | 4 |
| 63 | C6266C06715 | Oil Purifier | | 1 |
| 64 | C6266C06107 | Pump | | 1 |
| 65 | GB65-M6x12 | Slotted Socket Cap Screw | M6x12 | 3 |

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|---------------------------------|--------------|-----|
| 66 | G51-2A-20x2.4 | O-Ring | 20x2.4 mm | 1 |
| 67 | C6266C06712J | Piston Rod | | 1 |
| 68 | Q81-1-1.2x19x70 | Spring | 1.2x19x70 mm | 1 |
| 69 | 1440R4783 | Nut | | 1 |
| 70 | C6266C06502 | Gasket | | 1 |
| 71 | C6266C06103 | Button Cover | | 1 |
| 72 | TS-1504021 | Hex Socket Cap Screw | M8x12 | 6 |
| 73 | GB38-2-M12x1.5 | Drain Plug | M12x1.5 | 1 |
| 74 | C6266C06725 | Shaft | | 1 |
| 75 | C6266C06109 | Rocker | | 1 |
| 76 | C6266C06724 | Washer | | 1 |
| 77 | GB894.1-15 | Circlip for Shaft | 15 mm | 1 |
| 78 | C6266C06721 | Rod | | 1 |
| 79 | G51-2A-12x1.9 | O-Ring | 12x1.9 mm | 1 |
| 80 | C6266C06723 | Sleeve | | 1 |
| 81 | C6266C06722 | Block | | 1 |
| 82 | BB-606 | Bearing | 6x17x6 mm | 1 |
| 83 | GB119-6x14 | Pin | 6x14 mm | 1 |
| 84 | GB75-M5x16 | Slotted Socket Set Screw | M5x16 | 1 |
| 85 | GB119-8n6x45 | Pin | 8n6x45 | 1 |
| 86 | C6266C06110 | Positioning Block | | 1 |
| 87 | C6140W06116 | Bracket Disc | | 1 |
| 88 | GB119-6x25 | Pin | 6x25 mm | 1 |
| 89 | C6140W06761 | Dial | | 1 |
| 90 | C6140W06769 | Leaf Spring | | 1 |
| 91 | C6140W06767 | Lock Knob | | 1 |
| 92 | C6140W06768 | Eccentric Shaft | | 1 |
| 93 | GB119-3x12 | Pin | 3x12 mm | 1 |
| 94 | C6266C06762 | Gear (inch) | | 1 |
| 95 | C6266C06117 | Bracket (inch) | | 1 |
| 96 | TS-1504111 | Hex Socket Cap Screw | M8x55 | 3 |
| 97 | GB119-12n6x40 | Pin | 12n6x40 mm | 1 |
| 98 | C6266C06501 | Gasket | | 1 |
| 99 | GB117-4x18 | Taper Pin | 4x18 | 1 |
| 100 | GB68-M6x12 | Recessed Countersunk Head Screw | M6x12 | 4 |
| 101 | C6140W06109 | Handle Seat | | 1 |

18.0 Apron Assembly II – Exploded View

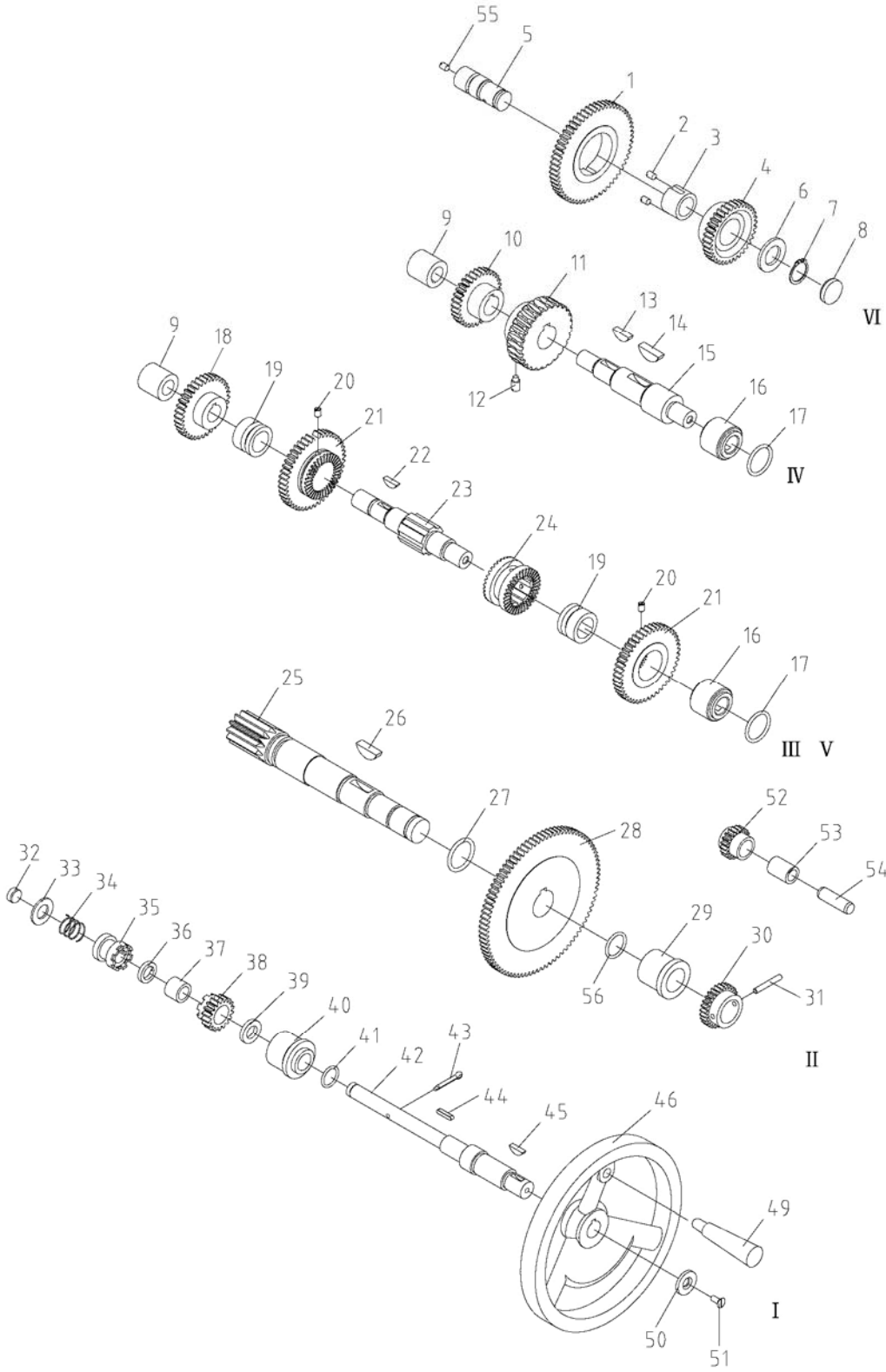


18.1 Apron Assembly II – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-------------------|---------------------------------|-----------------|-----|
| 1 | C6140W06738 | Cap | | 1 |
| 2 | GB6172-M12 | Hex Flat Nut | M12 | 1 |
| 3 | GB78-M12x60 | Hex Set Screw | M12x60 | 1 |
| 4 | TS-1504041 | Hex Socket Cap Screw | M8x20 | 3 |
| 5 | C6140W06111 | Flange | | 1 |
| 6 | G51-2A-90x3.1 | O-Ring | 90x3.1 mm | 1 |
| 7 | GB68-M5x12 | Recessed Countersunk Head Screw | M5x12 | 1 |
| 8 | C6140W06739 | Adjusting Circlip | | 1 |
| 9 | 30502/P6-25x52x15 | Bearing | 25x52x15 mm | 2 |
| 10 | C6266C06734 | Bolt | | 4 |
| 11 | C6140W06740 | Washer | | 1 |
| 12 | Q81-1-1x10x35 | Spring | 1x10x35 mm | 4 |
| 13 | C6266C06707 | Clutch | | 1 |
| 14 | GB894.1-30 | Circlip for Shaft | 30 mm | 1 |
| 15 | C6266C06708 | Washer | | 1 |
| 16 | C6266C06706 | Clutch | | 1 |
| 17 | GB1096-8x16 | Flat Key | 8x16 mm | 1 |
| 18 | C6140W06708 | Star Gear | | 1 |
| 19 | C6140W06709 | Gear | | 1 |
| 20 | C6140W06726 | Pin | | 3 |
| 21 | C6140W06710 | Washer | | 1 |
| 22 | C6140W06737 | Block | | 1 |
| 23 | GB67-M6x10 | Slotted Pan Head Screw | M6x10 | 1 |
| 24 | C6140W06729 | Splash Leaf | | 1 |
| 25 | C6266C06709 | Worm | | 1 |
| 26 | C6140W06728 | Motor Connector | | 1 |
| 27 | C6266C06503 | Washer | | 1 |
| 28 | GB1096-4x14 | Flat Key | 4x14 mm | 1 |
| 29 | YSS5634 | Rapid Feed Motor | 1/2HP, 230/460V | 1 |
| 30 | TS-1490051 | Hex Cap Screw | M8x30 | 3 |
| 31 | C6140W06736 | Shaft (IX) | | 1 |
| 32 | C6140W06735 | Washer | | 2 |
| 33 | C6140W06734 | Gear | | 1 |
| 34 | C6140W06306 | Sleeve | | 1 |
| 35 | GB894.1-16 | Circlip for Shaft | 16 mm | 1 |
| 36 | C6140W06305 | Sleeve | | 1 |
| 37 | C6140W06733 | Shaft (X) | | 1 |
| 38 | GB1096-6x25 | Flat Key | 6x25 mm | 1 |
| 39 | C6140W06732 | Gear | | 1 |
| 40 | C6140W06304 | Sleeve | | 1 |
| 41 | C6140W06730 | Washer | | 1 |
| 42 | GB894.1-38 | Circlip for Shaft | 38 mm | 1 |
| 43 | C6266C6704A | Oil Tap Cover | | 1 |
| 44 | C6266C06705A | Oil Tap | | 1 |
| 45 | C6266C04A311 | Label | | 1 |
| 46 | C6266C06102 | Plug | | 1 |
| 47 | C6140W06103 | Fork | | 1 |
| 49 | C6266C06712 | Control Shaft | | 1 |
| 50 | GB67-M6x8 | Slotted Pan Head Screw | M6x8 | 3 |
| 51 | C6140W06701 | Pin | | 3 |
| 52 | Q81-1-1.6x8x22 | Spring | 1.6x8x22 mm | 3 |
| 53 | C6140W06713 | Fork | | 1 |
| 54 | GB119-6n6x14 | Pin | 6n6x14 | 6 |
| 55 | C6140W06715 | Sliding Block | | 6 |
| 56 | C6140W06714 | Right Fork | | 1 |
| 57 | C6140W06717 | Shaft | | 1 |
| 58 | C6140W06104 | Interlocking Block | | 1 |
| 59 | GB117-5x30 | Taper Pin | 5x30 mm | 1 |
| 60 | C6140W06718 | Shaft | | 1 |

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|----------------------|-------------|-----|
| 61 | C626C06304 | Sleeve | | 1 |
| 62 | TS-1504041 | Hex Socket Cap Screw | M8x20 | 5 |
| 63 | C6140W06719 | Bracket | | 1 |
| 64 | C6140W06105 | Bracket | | 1 |
| 65 | GB71-M6x10 | Slotted Set Screw | M6x10 | 1 |
| 66 | C6140W06722 | Handle | | 1 |
| 67 | C6140W06106 | Cross Cover | | 1 |
| 68 | C6140W06501 | Washer | | 1 |
| 69 | GB6173-M12x1.25 | Hex Flat Nut | M12x1.25 | 1 |
| 70 | C6140W06721 | Handle | | 1 |
| 71 | C6140W06720 | Washer | | 1 |
| 72 | Q81-1-0.3x3x12 | Spring | 0.3x3x12 mm | 3 |
| 73 | C6140W06727 | Pin | | 3 |
| 75 | C6140W06704 | Shaft (XIII) | | 1 |
| 76 | C6140W06705 | Washer | | 1 |
| 77 | GB894.1-14 | Circlip For Shaft | 14 | 1 |
| 78 | GB71-M5x6 | Slotted Set Screw | M5x6 | 1 |

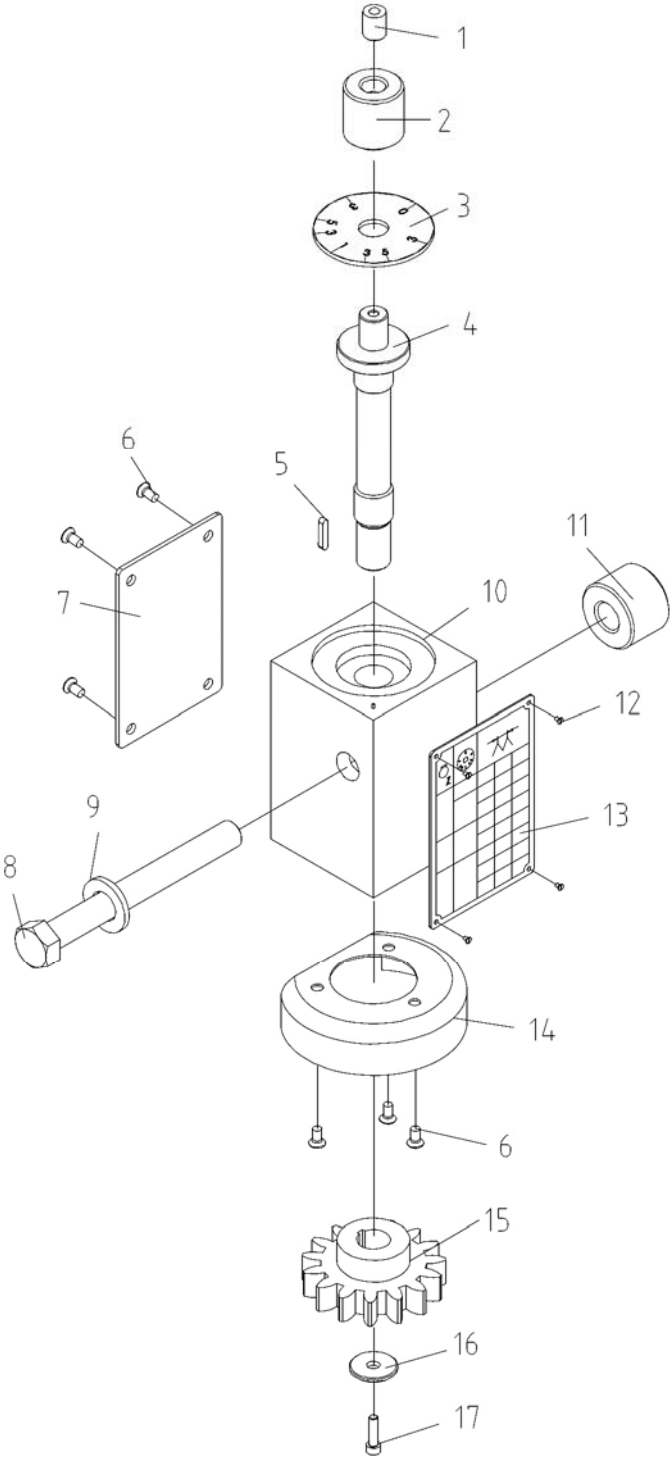
19.0 Apron Assembly III – Exploded View



19.1 Apron Assembly III – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|---------------------------------|--------------|-----|
| 1 | C6140W06751 | Gear | | 1 |
| 2 | GB71-M6x8 | Slotted Set Screw | M6x8 | 2 |
| 3 | C6140W06309 | Sleeve | | 1 |
| 4 | C6140W06752 | Gear | | 1 |
| 5 | C6266C06728 | Shaft (VI) | | 1 |
| 6 | C6140W06754 | Washer | | 1 |
| 7 | GB894.1-20 | Circlip for Shaft | 20 mm | 1 |
| 8 | C6140W06114 | Plug | | 1 |
| 9 | C6140W06113 | Sleeve | | 3 |
| 10 | C6140W06749 | Gear | | 1 |
| 11 | C6140W06308 | Worm Wheel | | 1 |
| 12 | GB72-M8x16 | Slotted Set Screw | M8x16 | 1 |
| 13 | GB1099-6x22 | Woodruff Key | 6x22 mm | 1 |
| 14 | GB1099-8x28 | Woodruff Key | 8x28 mm | 1 |
| 15 | C6140W06748 | Shaft (IV) | | 1 |
| 16 | C6140W06115 | Sleeve | | 3 |
| 17 | G51-2A-35x3.1 | O-Ring | 35x3.1 mm | 3 |
| 18 | C6140W06746 | Gear | | 2 |
| 19 | C6140W06307 | Sleeve | | 4 |
| 20 | GB71-M6x10 | Slotted Set Screw | M6x10 | 4 |
| 21 | C6140W06744 | Gear | | 4 |
| 22 | GB1099-5x16 | Woodruff Key | 5x16 mm | 2 |
| 23 | C6140W06747 | Shaft (III) | | 2 |
| 24 | C6140W06745 | Connector | | 2 |
| 25 | C6140W06743 | Shaft (II) | | 1 |
| 26 | GB1099-8x28 | Woodruff Key | 8x28 mm | 1 |
| 27 | G51-2A-35x3.1 | O-Ring | 35x3.1 mm | 1 |
| 28 | C6140W06742 | Gear | | 1 |
| 29 | C6140W06118 | Sleeve | | 1 |
| 30 | C6266C06764 | Gear (in.) | | 1 |
| 31 | ZX-Q66 | Taper Pin | 5x35 mm | 1 |
| 32 | C6140W06112 | Plug | | 1 |
| 33 | C6140W06774 | Washer | | 1 |
| 34 | Q81-1-1.6x18x25 | Spring | 1.6x18x25 mm | 1 |
| 35 | C6140W06773 | Connector | | 1 |
| 36 | C6140W06772 | Washer | | 1 |
| 37 | C6140W06311 | Sleeve | | 1 |
| 38 | C6140W06771 | Gear | | 1 |
| 39 | C6140W06770 | Washer | | 1 |
| 40 | C6140W06120 | Sleeve | | 1 |
| 41 | G51-2A-18x2.4 | O-Ring | 18x2.4 mm | 1 |
| 42 | C6140W06775 | Shaft (I) | | 1 |
| 43 | GB91-4X25 | Pin | 4X25mm | 1 |
| 44 | GB1096-4x20 | Flat Key | 4x20 mm | 1 |
| 45 | GB1099-5x16 | Woodruff Key | 5x16 mm | 1 |
| 46 | C6266C06111 | Handwheel | | 1 |
| 49 | C6140W06765 | Lever Sleeve | | 1 |
| 50 | GB891-5x12 | Circlip | 5x12 mm | 1 |
| 51 | GB68-25 | Recessed Countersunk Head Screw | 25 mm | 1 |
| 52 | C6266C06763 | Gear (in.) | | 1 |
| 53 | C6140W06310Y | Sleeve | | 1 |
| 54 | GB119-12n6x40 | Pin | 12n6x40 | 1 |
| 55 | GB71-M6x8 | Slotted Set Screw | M6x8 | 1 |
| 56 | G51-2A-25X2.4 | O-Ring | 25x2.4 mm | 1 |

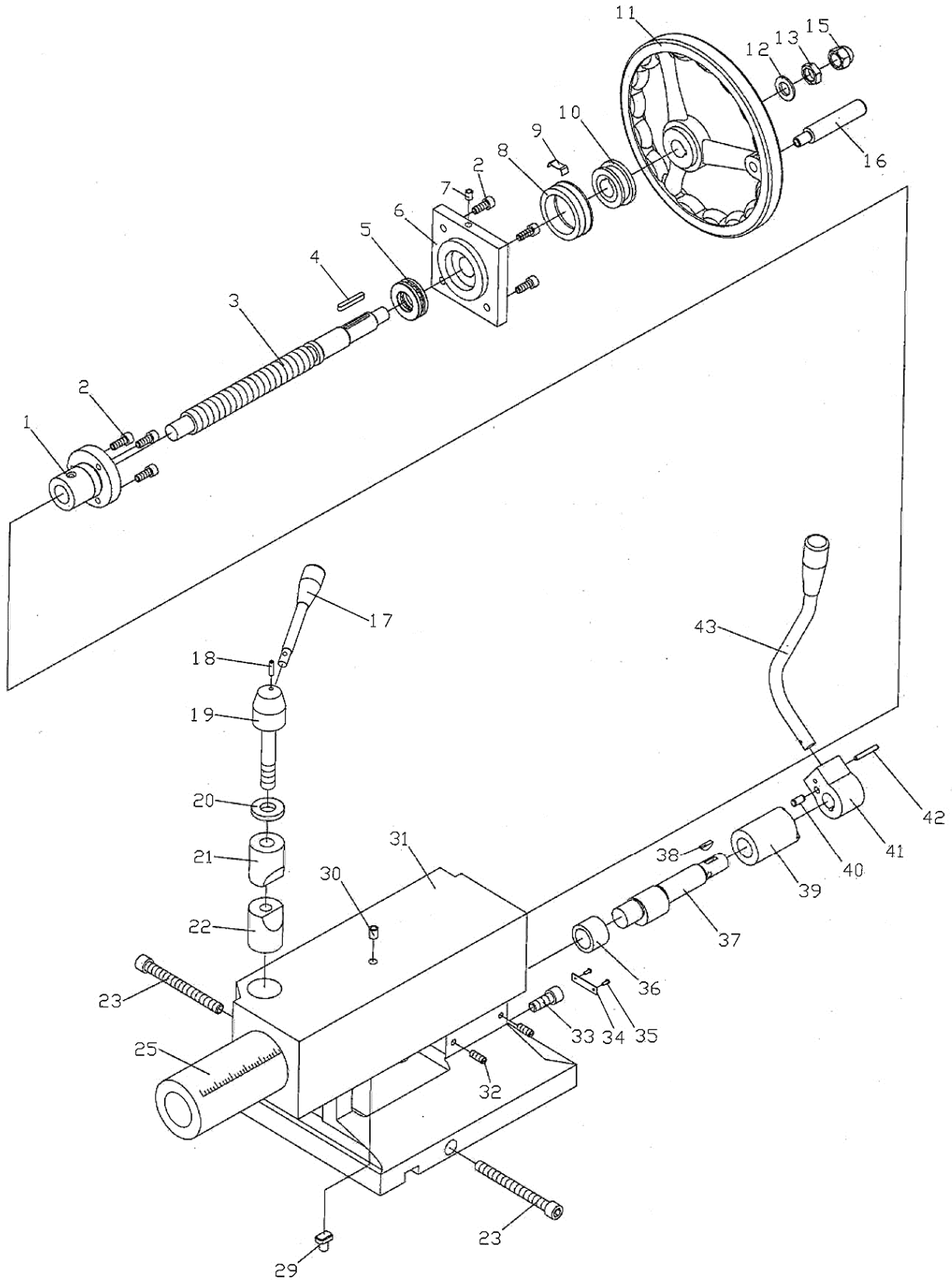
20.0 Apron Assembly IV – Exploded View



20.1 Apron Assembly IV – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|-------------------------------|------------|-----|
| 1 | GB1155-10 | Oil Cup | 10 mm | 1 |
| 2 | C6266C11703 | Handle | | 1 |
| 3 | C6266C11305 | Label | | 1 |
| 4 | C6266C11702 | Shaft | | 1 |
| 5 | GB1096-4x15 | Key | 4x15 mm | 1 |
| 6 | TS-2284082 | Cross Recessed Pan Head Screw | M4x8 | 7 |
| 7 | C6266C11701 | Cover | | 1 |
| 8 | GB5782- M12x110 | Hex Cap Bolt | M12x110 mm | 1 |
| 9 | TS-2360121 | Flat Washer | 12 mm | 1 |
| 10 | C6266C11101 | Casting | | 1 |
| 11 | C6266C11705 | Sleeve | | 1 |
| 12 | GB827-2x5 | Aluminum Rivet | 2x5 mm | 4 |
| 13 | C6266C11306 | Label, Thread Chaser (inches) | | 1 |
| 14 | C6266C11704 | Cover Casting | | 1 |
| 15 | C6266C11104 | Helical Gear | | 1 |
| 16 | C6266C11706 | Washer | | 1 |
| 17 | TS-1502021 | Hex Socket Cap Screw | M5x10 | 1 |

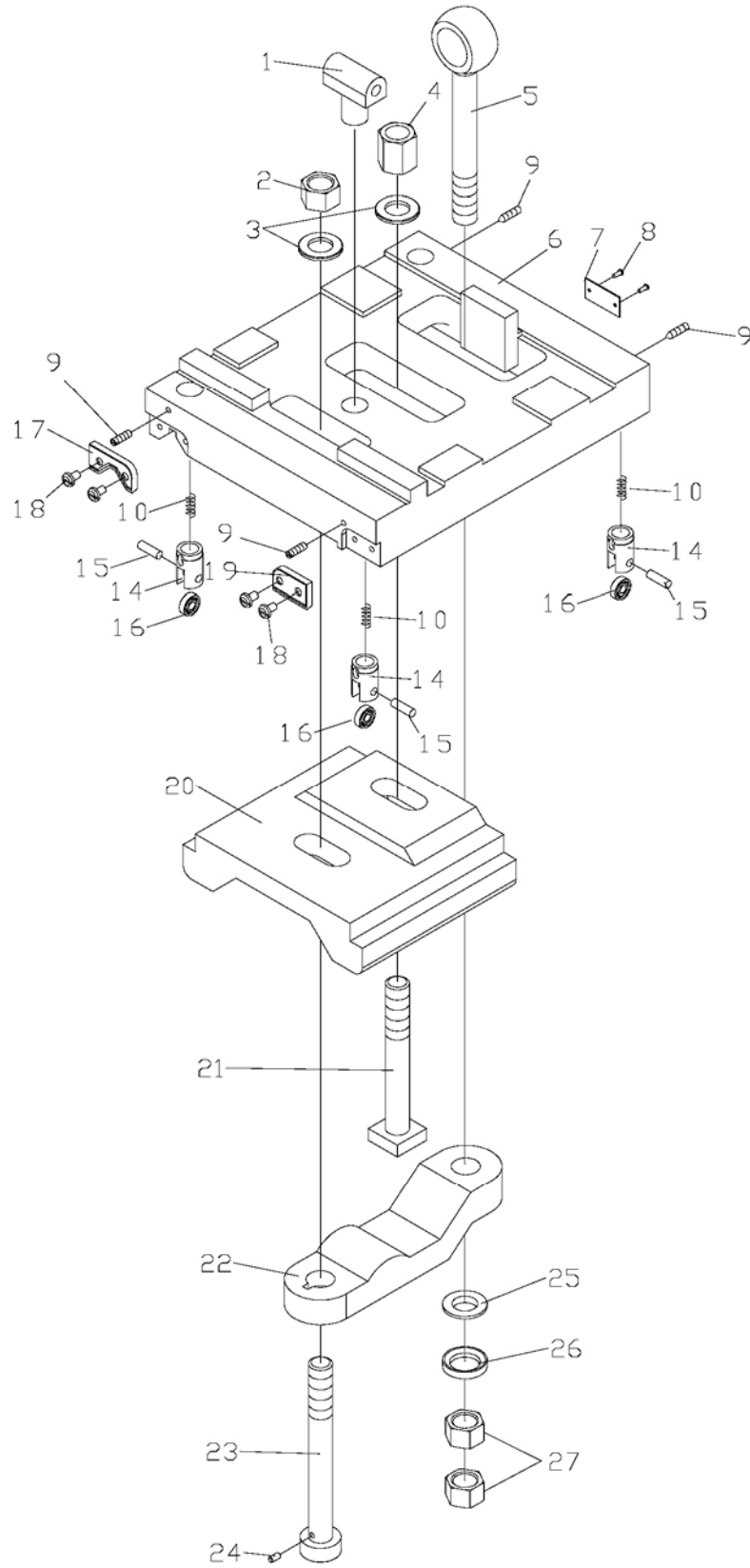
21.0 Tailstock Assembly I – Exploded View



21.1 Tailstock Assembly I – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|--------------|-----------------------------------|-------------|-----|
| 1 | 1440R03105 | Nut | | 1 |
| 2 | TS-1504041 | Hex Socket Cap Screw | M8x20 | 7 |
| 3 | 1860R03710A | Lead Screw | | 1 |
| 4 | GB1096-6x40 | Flat Key | 6x40 mm | 1 |
| 5 | BB-51205 | Thrust Bearing | 25x47x15 mm | 1 |
| 6 | C6266C03105 | Back Cover | | 1 |
| 7 | GB1155-8 | Oil Cup | 8 mm | 2 |
| 8 | 1440R03708 | Dial | | 1 |
| 9 | C613203711 | Leaf Spring | | 1 |
| 10 | 1440R03706 | Sleeve | | 1 |
| 11 | C6140W03107A | Handwheel | | 1 |
| 12 | TS-155010 | Flat Washer | 16 mm | 1 |
| 13 | GB6172-M16 | Hex Flat Nut | M16 | 1 |
| 15 | GB923-M16 | Acorn Nut | M16 | 1 |
| 16 | C613206710A | Lever | | 1 |
| 17 | C6140W03710 | Lever | | 1 |
| 18 | GB117-5x20 | Straight Pin | 5x20 mm | 1 |
| 19 | C6140W03715 | Lever Support | | 1 |
| 20 | C6140W03716 | Washer | | 1 |
| 21 | C6140W03717 | Clamping Block | | 1 |
| 22 | C6140W03718 | Clamping Block | | 1 |
| 23 | GB70-M12x120 | Hex Socket Cap Screw | M12x120 | 2 |
| 25 | 1860R03701A | Center Sleeve | | 1 |
| 28 | TS-1505011 | Hex Socket Cap Screw | M10x16 | 1 |
| 29 | 1440R03702 | Positioning Block | | 1 |
| 30 | GB1155-10 | Oil Cup | 10 mm | 1 |
| 31 | C6266C03101 | Tailstock Casting | | 1 |
| 32 | GB75-M8x25 | Slotted Cylindrical End Set Screw | M8x25 | 2 |
| 33 | TS-1506021 | Hex Socket Cap Screw | M12x25 | 1 |
| 34 | C613203303 | Scale | | 1 |
| 35 | GB867-3x8 | Cup Head Rivet | 3x8 mm | 4 |
| 36 | C6140W03103 | Sleeve | | 1 |
| 37 | C6250B03704 | Eccentric Shaft | | 1 |
| 38 | GB117-6x45 | Taper Pin | 6x45 mm | 1 |
| 39 | C6250B03103 | Sleeve | | 1 |
| 40 | GB119-8x15 | Pin | 8x15 mm | 1 |
| 41 | C6250B03104 | Lever Sleeve | | 1 |
| 42 | GB117-5x40 | Taper Pin | 5x40 mm | 1 |
| 43 | C6250B03705 | Lock Handle | | 1 |

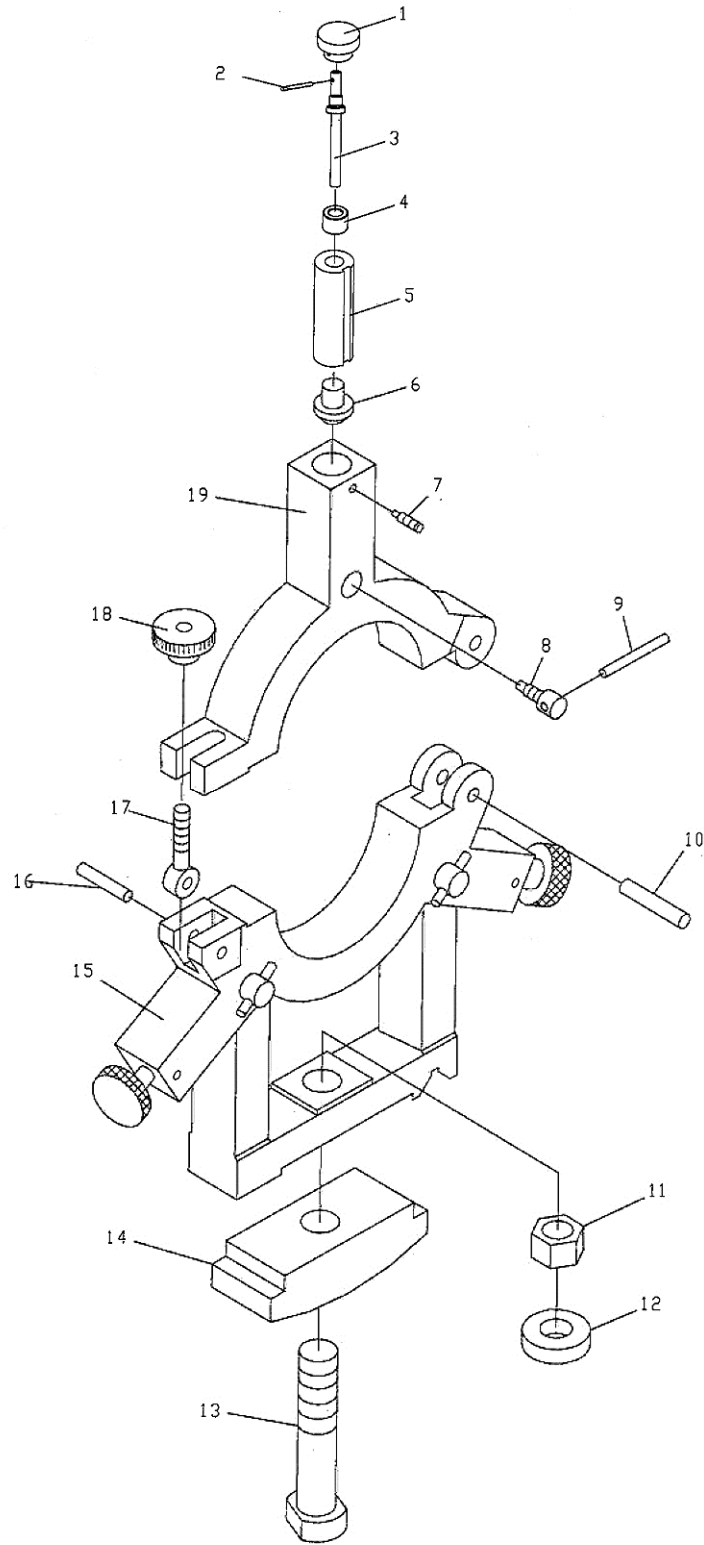
22.0 Tailstock Assembly II – Exploded View



22.1 Tailstock Assembly II – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|------------------|-----------------------------------|--------------|-----|
| 1 | C6140W03110 | Nut | | 1 |
| 2 | GB6171-M20x1.5 | Hex Nut | M20x1.5 | 1 |
| 3 | TS-1550111 | Flat Washer | 20 mm | 1 |
| 4 | GB56-M20 | Hex Thick Nut | M20 | 1 |
| 5 | C6266C03703 | Pulling Rod | | 1 |
| 6 | C6266C03102 | Sliding Base | | 1 |
| 7 | C613203302 | Indicator Plate | | 1 |
| 8 | GB867-3x8 | Cup Head Rivet | 3x8 mm | 4 |
| 9 | GB75-M6x16 | Slotted Cylindrical End Set Screw | M6x16 | 4 |
| 10 | GB2089-1.8x14x18 | Spring | 1.8x14x18 mm | 4 |
| 14 | C6140W03713 | Bearing Support | | 4 |
| 15 | C6140W03714 | Small Axle | | 4 |
| 16 | BB-607ZZ | Ball Bearing | 7x19x6 mm | 4 |
| 17 | C6140W03502 | Wipe Plate | | 1 |
| 18 | TS-1534032 | Phillips Pan Head Machine Screw | M6x10 | 4 |
| 19 | C6140W03503 | Wipe Plate | | 1 |
| 20 | C6140W03104 | Clamping Block | | 1 |
| 21 | C6266C03702 | Screw | | 1 |
| 22 | C6140W03111 | Clamping Block | | 1 |
| 23 | C6266C03701 | Screw | | 1 |
| 24 | GB119-5x10 | Straight Pin | 5x10 mm | 1 |
| 25 | GB849-20 | Spherical Washer | 20 mm | 1 |
| 26 | GB850-20 | Taper Washer | 20 mm | 1 |
| 27 | GB6173-M20x1.5 | Hex Nut | M20x1.5 | 2 |

23.0 Steady Rest Assembly (Small and Large) – Exploded View



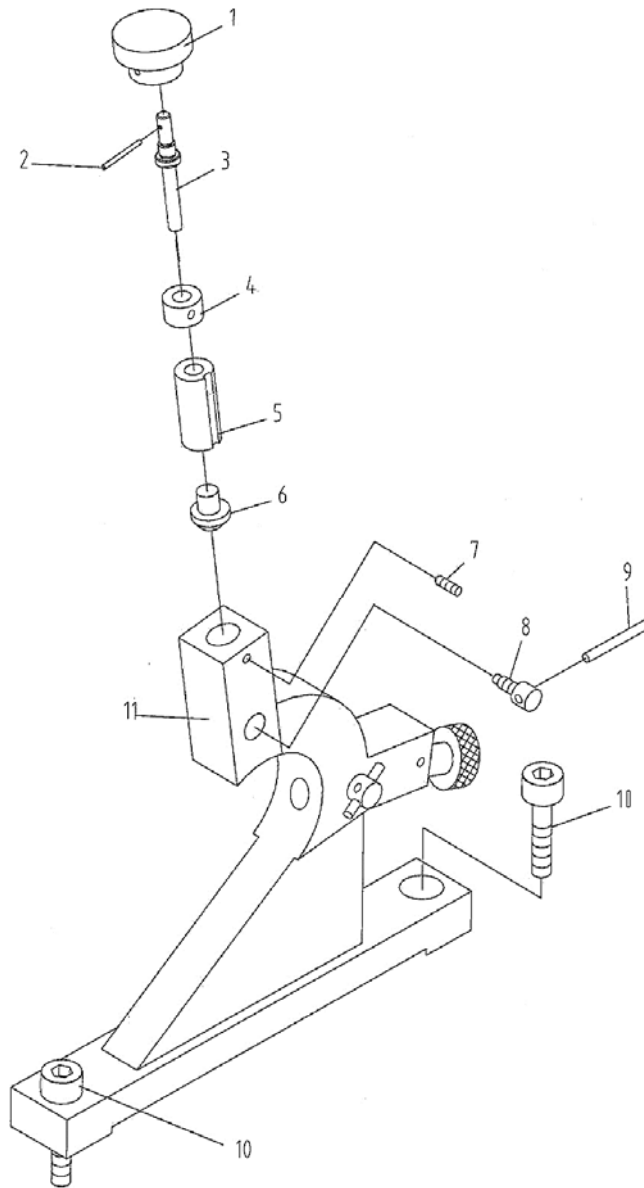
23.1 Steady Rest Assembly (Small) – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|---------------|--|---------|-----|
| | ZH-SRA-1 | Steady Rest Assembly, Small (#1 thru 19) | | 1 |
| 1 | GB4141.29-12 | A-Type Knurled Handle | 12 mm | 3 |
| 2 | GB117-4x25 | Pin | 4x25 mm | 3 |
| 3 | C6140W10702 | Screw | | 3 |
| 4 | C6140W10703 | Nut | | 3 |
| 5 | C6140W10705 | Sliding Sleeve | | 3 |
| 6 | C6140W10301 | Block | | 3 |
| 7 | GB75-M10x16 | Slotted Set Screw | M10x16 | 3 |
| 8 | C6140W10704 | Set Screw | | 3 |
| 9 | GB119-A6x45 | Pin | A6x45 | 3 |
| 10 | GB119-A16x55 | Pin | A16x55 | 1 |
| 11 | ZX-SR10 | Extra Thick Hex Nut | M20 | 1 |
| 12 | ZX-SR11 | Washer | 20 mm | 1 |
| 13 | C6140W10706 | Square Head Bolt | | 1 |
| 14 | C6140W10104 | Clamping Plate | | 1 |
| 15 | C6266C10A101 | Steady Rest Lower Body | | 1 |
| 16 | GB119-A8x55 | Pin | A8x55 | 1 |
| 17 | C6140W10701 | Screw | | 1 |
| 18 | GB4141.29-M12 | B-Type Knurled Handle | M12 | 1 |
| 19 | C6140W10102 | Steady Rest Upper Body | | 1 |

23.2 Steady Rest Assembly (Large) – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|---------------|--|---------|-----|
| | ZH-SRA | Steady Rest Assembly, Large (#1 thru 19) | | 1 |
| 1 | GB4141.29-12 | A-Type Knurled Handle | 12 mm | 3 |
| 2 | GB117-4x25 | Pin | 4x25 mm | 3 |
| 3 | C6266C10702 | Screw | | 3 |
| 4 | C6266C10701 | Nut | | 3 |
| 5 | C6266C10703 | Sliding Sleeve | | 3 |
| 6 | C6266C10301 | Block | | 3 |
| 7 | GB75-M10x16 | Slotted Set Screw | M10x16 | 3 |
| 8 | C6140W10704 | Set Screw | | 3 |
| 9 | GB119-A6x45 | Pin | A6x45 | 3 |
| 10 | GB119-A16x55 | Pin | A16x55 | 1 |
| 11 | ZX-SR10 | Extra Thick Hex Nut | M20 | 1 |
| 12 | ZX-SR11 | Washer | 20 mm | 1 |
| 13 | C6140W10706 | Square Head Bolt | | 1 |
| 14 | C6140W10104 | Clamping Plate | | 1 |
| 15 | C6266C10101 | Steady Rest Lower Body | | 1 |
| 16 | GB119-A8x55 | Pin | A8x55 | 1 |
| 17 | C6140W10701 | Screw | | 1 |
| 18 | GB4141.29-M12 | B-Type Knurled Handle | M12 | 1 |
| 19 | C6266C10102 | Steady Rest Upper Body | | 1 |

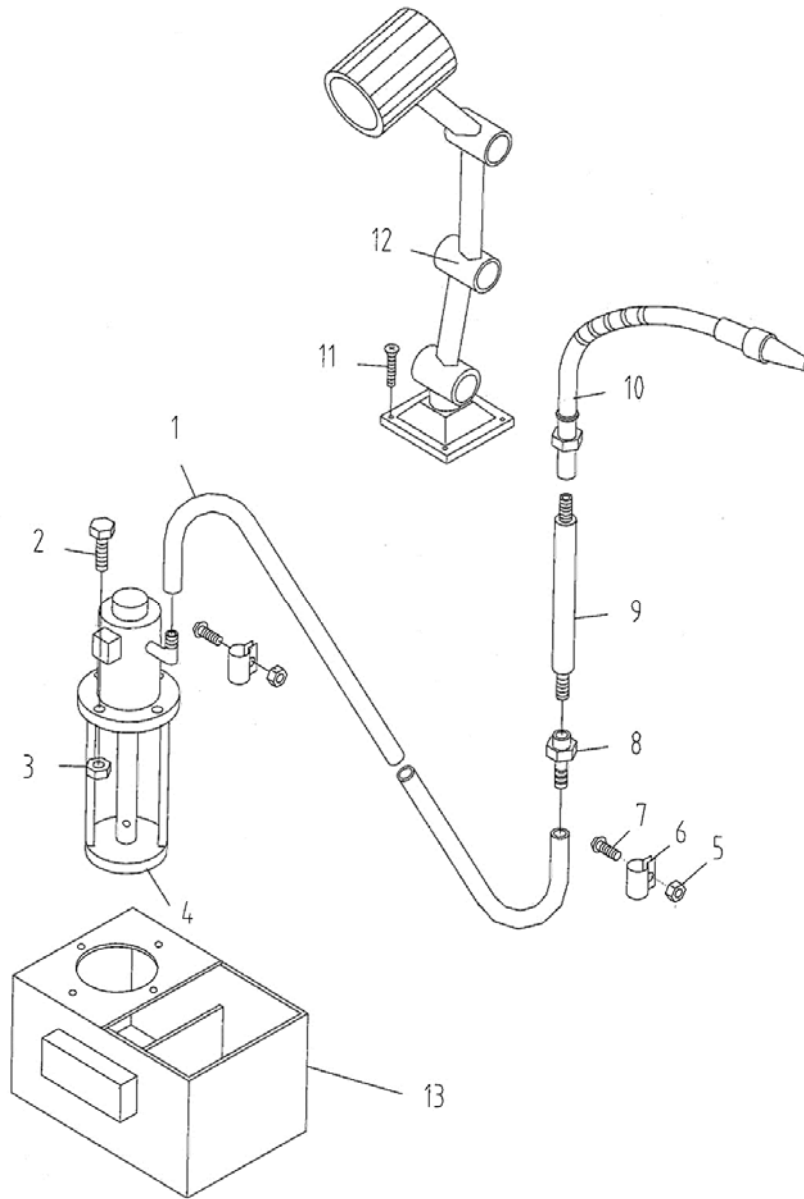
24.0 Follow Rest Assembly – Exploded View



24.1 Follow Rest Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|--------------|-----------------------|---------|-----|
| 1 | GB4141.29-12 | A-Type Knurled Handle | 12 mm | 2 |
| 2 | GB117-4x25 | Pin | 4x25 mm | 2 |
| 3 | C626610705 | Screw | | 2 |
| 4 | C6266C10704 | Nut | | 2 |
| 5 | C6266C10706 | Sliding Sleeve | | 2 |
| 6 | C6266C10302 | Block | | 2 |
| 7 | GB75-M10x16 | Slotted Set Screw | M10x16 | 2 |
| 8 | C6140W10704 | Set Screw | | 2 |
| 9 | GB119-A6x45 | Pin | A6x45 | 2 |
| 10 | GB70-M16x55 | Hex Socket Cap Screw | M16x55 | 2 |
| 11 | C6266C10103 | Follow Rest Casting | | 1 |

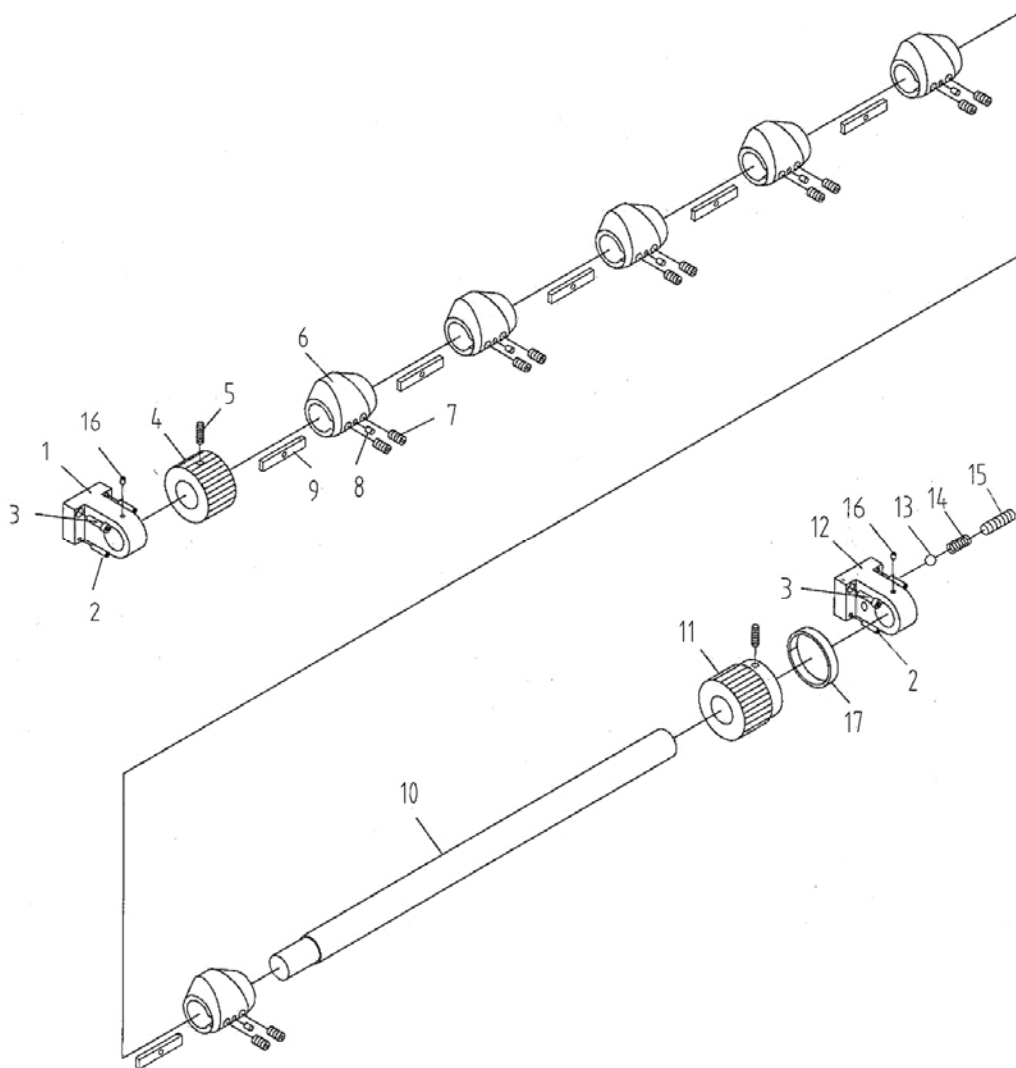
25.0 Coolant and Work Light Assembly – Exploded View



25.1 Coolant and Work Light Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-------------|---------------------------------|----------------|-----|
| 1 | RT-001C | Rubber Tube | ID 1/2" x 2280 | 1 |
| 2 | TS-2205201 | Hex Cap Screw | M5x20 | 4 |
| 3 | ZX-CW03 | Hex Nut | M5 | 4 |
| 4 | AB-25-1/8HP | Coolant Pump | 1/8HP 230/460V | 1 |
| 5 | TS-1540041 | Hex Nut | M6 | 2 |
| 6 | ZX-01727 | Clip for Rubber Tube | | 1 |
| 7 | TS-2286202 | Phillips Pan Head Machine Screw | M6x20 | 2 |
| 8 | C6140W01731 | Fitting | | 1 |
| 9 | C6140W01730 | Flow Pipe | | 1 |
| 10 | ZH-CT | Coolant Tube | 1/2"x16x700 | 1 |
| 11 | TS-1503051 | Hex Socket Cap Screw | M6x20 | 4 |
| 12 | JC52 | Work Lamp | 24V, 50W | 1 |
| 13 | ZX01510 | Coolant Tank | | 1 |

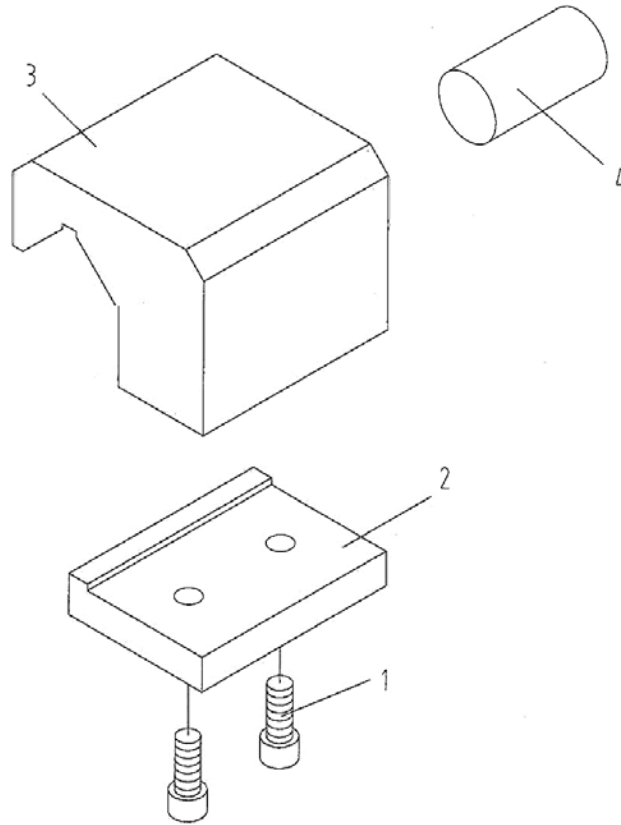
26.0 Travel Stop Assembly – Exploded View



26.1 Travel Stop Assembly – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------|-----------------------------------|-------------|-----|
| 1 | C6266C26A102 | Left Support | | 1 |
| 2 | GB118-10x40 | Pin | 10x40 mm | 4 |
| 3 | TS-1504081 | Hex Socket Cap Screw | M8x40 | 4 |
| 4 | C6266C26A721 | Left Control Ring | | 1 |
| 5 | GB79-M8x16 | Hex Socket Set Screw (Dog Pt.) | M8x16 | 2 |
| 6 | C6266C26712 | Eccentric Travel Setting Ring | | 6 |
| 7 | GB77-M8x8 | Hex Socket Set Screw (Cone Pt.) | M8x8 | 12 |
| 8 | GB119-4x10 | Pin | 4x10 mm | 6 |
| 9 | C6266C26713 | Locking Key | | 6 |
| 10 | C6266C26A707C | Travel Set Rod (for 80" ZH only) | | 1 |
| | C6266C26A707D | Travel Set Rod (for 120" ZH only) | | 1 |
| 11 | C6266C26A720 | Right Control Ring | | 1 |
| 12 | C6266C26A101 | Right Support | | 1 |
| 13 | SB-8MM | Steel Ball | 8 mm | 1 |
| 14 | GB2089-1.5x8x20 | Spring | 1.5x8x20 mm | 1 |
| 15 | GB77-M10x20 | Hex Socket Set Screw | M10x20 | 1 |
| 16 | ZX-CS16 | Oil Cup | 8 mm | 1 |
| 17 | C6266C26A301 | Label, Travel Stop | | 1 |

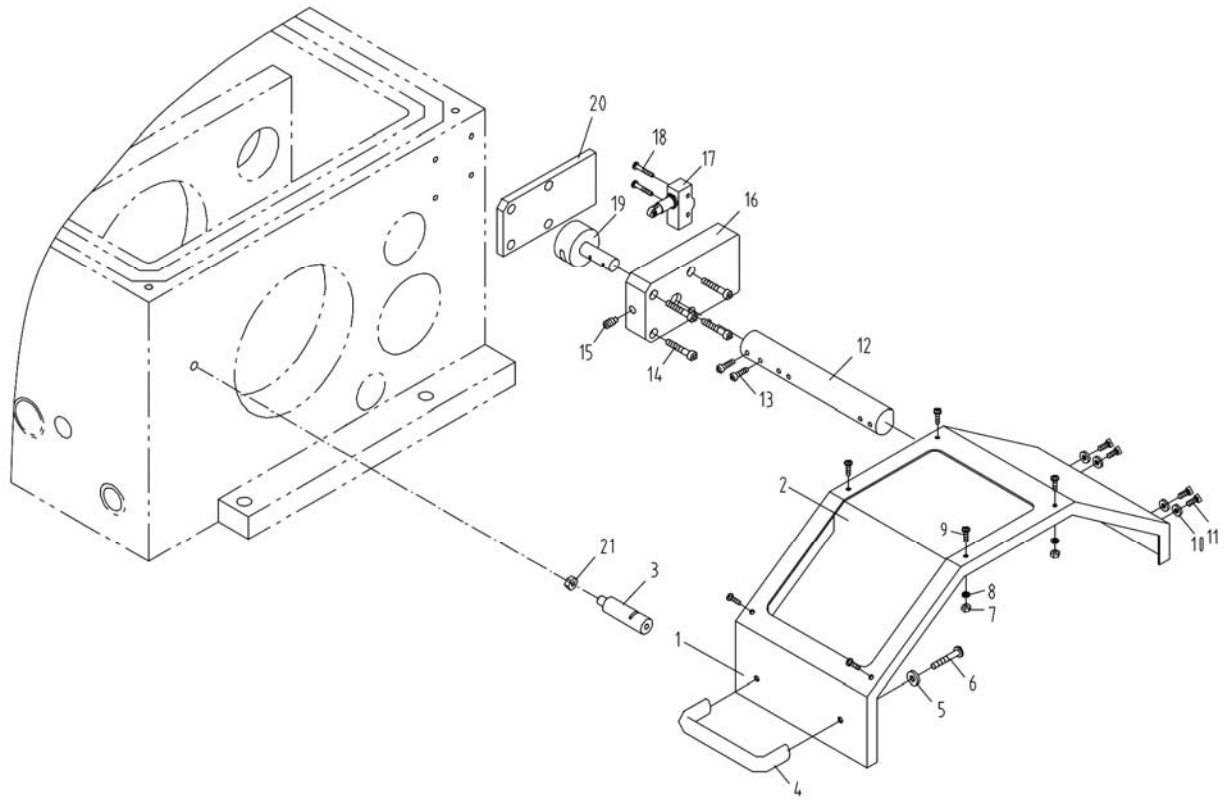
27.0 Small Carriage Stop – Exploded View



27.1 Small Carriage Stop – Parts List

| Index No. | Part No. | Description | Size | Qty |
|-----------|-------------|----------------|----------|-----|
| 1 | TS-1492031 | Hex Cap Screw | M12x35 | 2 |
| 2 | C6266C01112 | Clamping Plate | | 1 |
| 3 | C6266C01111 | Stop | | 1 |
| 4 | GB119-12x40 | Pin | 12x40 mm | 1 |

28.0 Chuck Guard Assembly – Exploded View

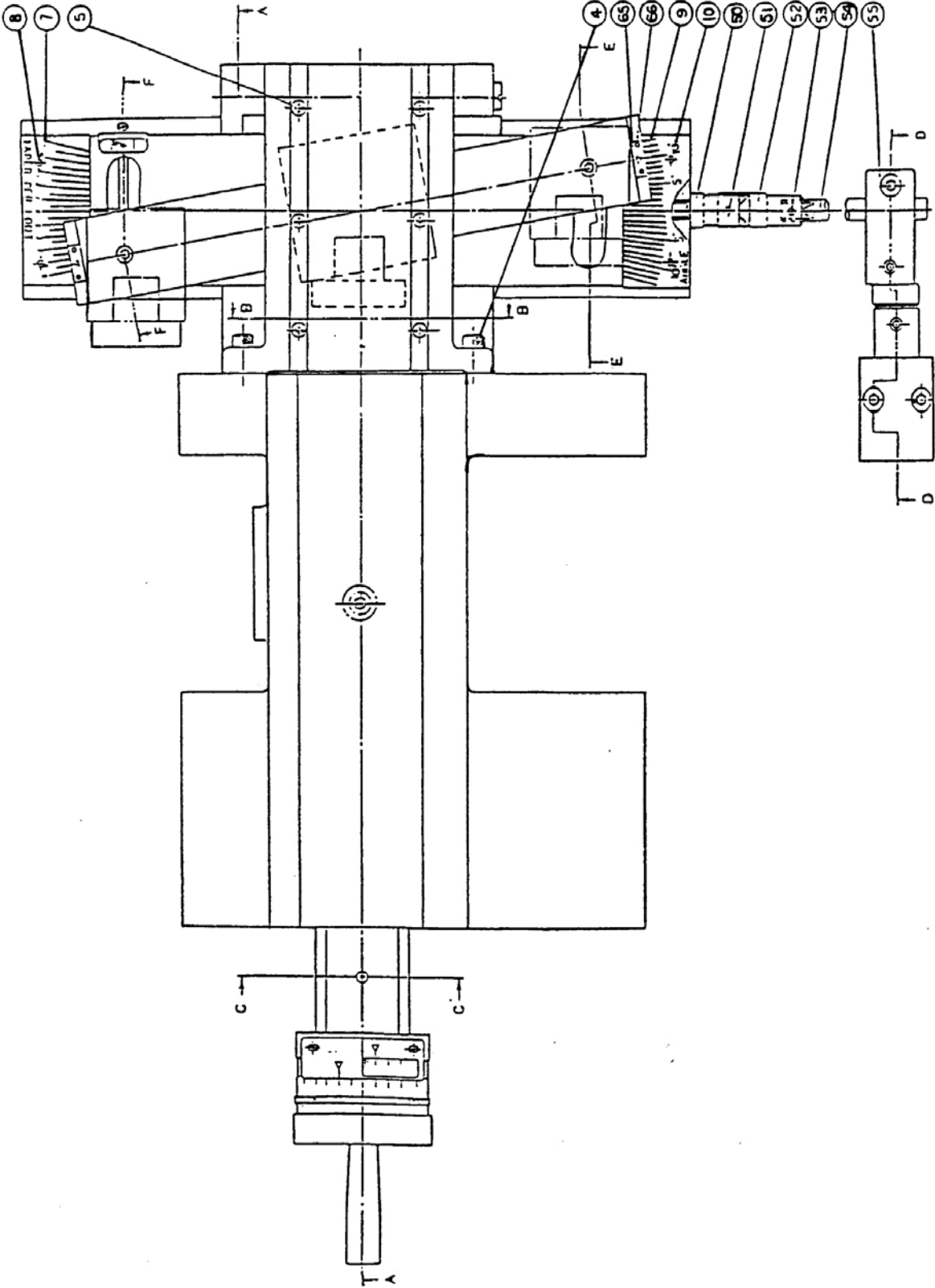


28.1 Chuck Guard Assembly – Parts List

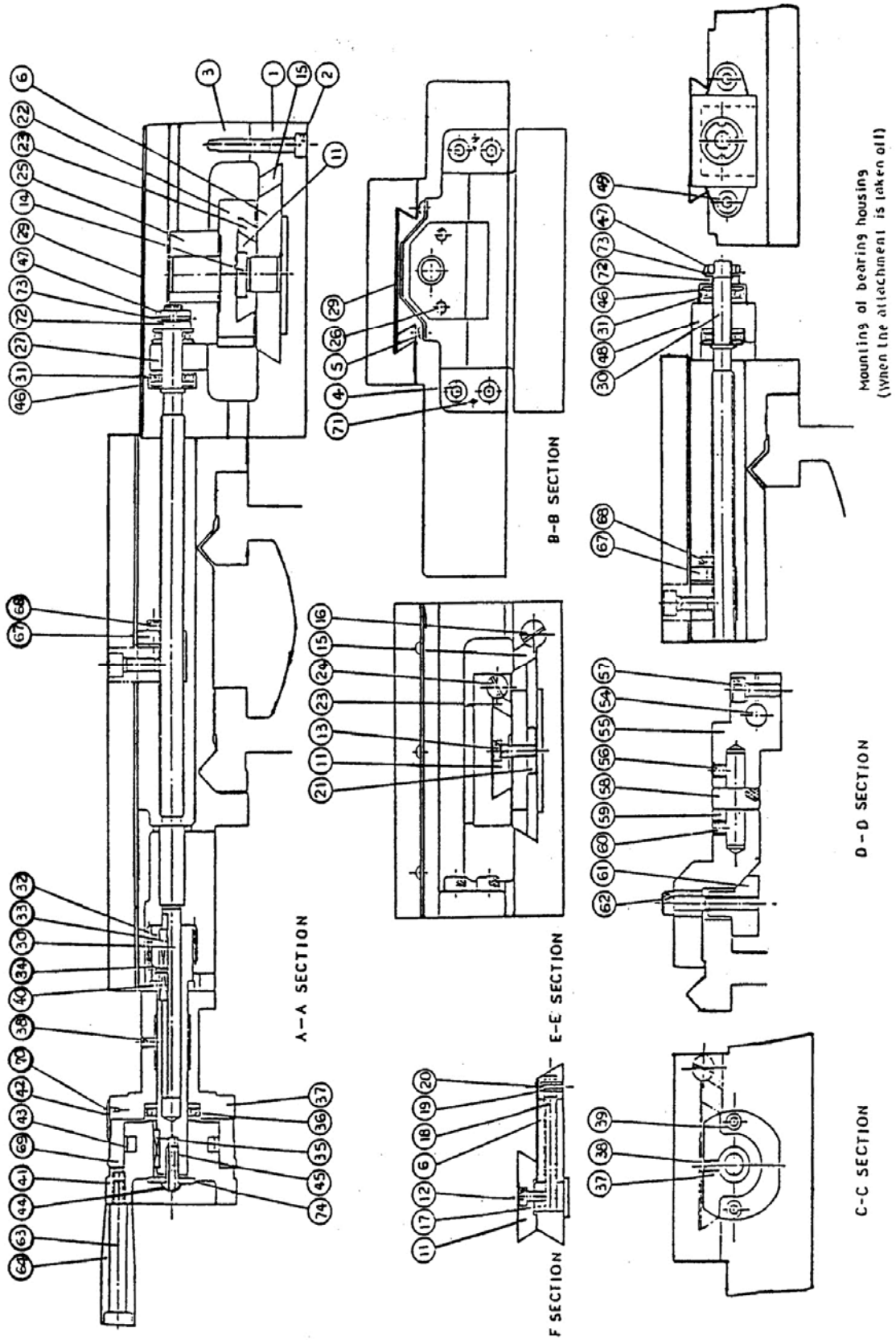
| Index No. | Part No. | Description | Size | Qty |
|-----------|-----------------------------|--|----------------|-----|
| | ZX-CGA..... | Chuck Guard Assembly (includes #1 thru 21) | | 1 |
| 1 | GH1640ZX19701 | Protection Guard..... | | 1 |
| 2 | ZX-19501E | Protection Guard Visual Glass..... | | 1 |
| 3 | ZX-19704E | Fixing Rod..... | | 1 |
| 4 | ZX-S04E..... | Handle | Z96-6..... | 1 |
| 5 | TS-1550041 | Plain Washer | 6 mm..... | 2 |
| 6 | TS-1534042 | Cross Recessed Pan Head Screw | M6x12..... | 2 |
| 7 | ZX-S07E..... | Hex Thin Nut..... | M4..... | 6 |
| 8 | TS-1550021 | Plain Washer | 4 mm..... | 6 |
| 9 | TS-1532042 | Cross Recessed Pan Head Screw | M4x12..... | 6 |
| 10 | TS-1550031 | Plain Washer | 5 mm..... | 4 |
| 11 | TS-1502041 | Hex Socket Cap Screw..... | M5x16..... | 4 |
| 12 | ZX-19703E..... | Rest Bar..... | | 1 |
| 13 | ZX-S13E..... | Slotted Set Screw..... | M8x10..... | 2 |
| 14 | TS-1503081 | Hex Socket Cap Screw..... | M6x35..... | 4 |
| 15 | TS-1524041 | Hex Socket Set Screw..... | M8x16..... | 1 |
| 16 | GH1440A19101E..... | Switch Box..... | | 1 |
| 17 | SQ4E..... | Stroke Switch..... | LXW5-11Q1..... | 1 |
| 18 | ZX-S18E..... | Slotted Pan Head Screw..... | M4x25..... | 2 |
| 19 | ZX-19702E..... | Shaft | | 1 |
| 20 | ZX-19502E..... | Gasket | | 1 |
| 21 | C6266CCGA21-M8... Nut | | M8..... | 1 |

(Note: This device is installed from serial #111105ZH0006)

TAK-13GH/BD Taper Attachment Kit



TAK-13GH/BD Taper Attachment Kit



TAK-13GH/BD Taper Attachment Kit – Parts List

| Index No | Part No | Description | Size | Qty |
|----------|----------------|-----------------------------|---------|-----|
| 1 | 84-0001-00 | Slide Base | | 1 |
| 2 | TS-1504081 | Socket Head Cap Screw | M8x40 | 4 |
| 3 | 84-1001-00 | Slide Bracket | | 1 |
| 4 | TS-1504061 | Socket Head Cap Screw | M4x30 | 4 |
| 5 | TS-1532021 | Countersunk Flat Screw | M4x8 | 6 |
| 6 | 84-0003-00 | Longitudinal Slide | | 1 |
| 7 | 84-0004-00 | Taper Indicator Plate | | 1 |
| 8 | 84-0004-00-1 | Rivet | | 2 |
| 9 | 84-0005-00 | Angle Indicator Plate | | 1 |
| 10 | 84-0005-00-1 | Rivet | | 2 |
| 11 | 84-0006-00 | Taper Slide | | 1 |
| 12 | TS-1503031 | Socket Head Cap Screw | M6x12 | 1 |
| 13 | TS-1503051 | Socket Head Cap Screw | M6x20 | 1 |
| 14 | 84-0007-00 | Axle | | 1 |
| 15 | 84-0008-00 | Gib Strip | | 1 |
| 16 | 84-0006-00 | Adjusting Screw | | 2 |
| 17 | 84-0100-00 | Adjusting Piece | | 1 |
| 18 | 84-0011-00 | Adjusting Screw | | 1 |
| 19 | 84-0012-00 | Adjusting Knob | | 1 |
| 20 | 84-0012-00-1 | Spring Pin | 3x14 | 1 |
| 21 | 84-0013-00 | Clamping Piece | | 1 |
| 22 | 84-1002-00 | Taper Slide Rest | | 1 |
| 23 | 84-0015-00 | Gib Strip | | 1 |
| 24 | 84-0016-00 | Adjusting Screw | | 2 |
| 25 | 84-1003-00 | Cross Slide Block | | 1 |
| 26 | TS-1501061 | Socket Head Cap Screw | M4x20 | 2 |
| 27 | 84-1004-00 | Feed Block | | 1 |
| 29 | 84-1005-00 | Dust Cover | | 1 |
| 30 | 84-1006-2/2-00 | Cross Feed Screw | 10 TPI | 1 |
| 31 | BB-51101 | Thrust Bearing | | 2 |
| 32 | 84-1007-00 | Pinion Shaft | | 1 |
| 33 | 84-1007-00-1 | Double Round Head Key | 5x5x30 | 1 |
| 34 | 84-1007-00-2 | Countersunk Flat Screw | M3x5 | 1 |
| 35 | 84-1007-00-3 | Woodruff Key | 3x13 | 1 |
| 36 | BB-55102 | Thrust Bearing | | 1 |
| 37 | 17-0303A-00 | Cross Bracket | | 1 |
| 38 | 84-0023-01-1 | Ball Cup | 1/4" | 1 |
| 39 | TS-1503051 | Socket Head Cap Screw | M6x20 | 2 |
| 40 | BB-51102 | Thrust Bearing | | 1 |
| 41 | 17-0304-00 | Cross Feed Handwheel | | 1 |
| 42 | 17-0356-2/2-00 | Cross Dial Guard | | 1 |
| 43 | 17-0357-00 | Spring Leaf | | 1 |
| 44 | 17-0504-00-2 | Socket Button Head Screw | M8x20 | 1 |
| 45 | TS-1522061 | Socket Head Set Screw | M5x20 | 1 |
| 46 | 84-0027-00 | Bearing Dust Cover | | 1 |
| 47 | 84-0028-00 | Locking Nut | | 1 |
| 48 | 84-1008-00 | Bearing Housing | | 1 |
| 49 | TS-1504101 | Socket Head Cap Screw | M8x50 | 2 |
| 50 | 84-0030-00 | Joint | | 1 |
| 51 | 84-0030-00-1 | Spring Pin | 4x19 mm | 1 |
| 52 | 84-0031-00 | Universal Joint | | 1 |
| 53 | 84-0031-00-1 | Spring Pin | 4x19 mm | 1 |
| 54 | 84-0032-00 | Adjusting Bar | | 1 |
| 55 | 84-1009-00 | Locking Block Adjusting Bar | | 1 |
| 56 | 84-0033-00-1 | Socket Head Set Screw | M8x8 | 1 |
| 57 | TS-1504041 | Socket Head Cap Screw | M8x20 | 1 |
| 58 | 84-0034-00 | Eccentric Shaft | | 1 |
| 59 | 84-1010-00 | Adjusting Bar Bracket | | 1 |
| 60 | TS-1524011 | Socket Head Set Screw | M8x8 | 1 |
| 61 | 84-0036-00 | Clamping Block | | 1 |

| Index No | Part No | Description | Size | Qty |
|----------|----------------|-----------------------|---------|-----|
| 62 | TS-1504101 | Socket Head Cap Screw | M8x50 | 2 |
| 63 | 17-0308-00 | Bolt | | 1 |
| 64 | 17-0307-00 | Handle | | 1 |
| 65 | 84-0039-00 | Indicator | | 2 |
| 66 | 84-0039-00-1 | Rivet | 2x5 mm | 4 |
| 67 | 17-0323-2/2-00 | Feed Nut | | 1 |
| 68 | TS-1503041 | Socket Head Cap Screw | M6x16 | 1 |
| 69 | 17-0305-2/2-00 | Dual Dial | | 1 |
| 70 | 17-0356-00-1 | Round Head Screw | M4x6 | 2 |
| 71 | 84-0002-00-3 | Spring Pin | 3x20 mm | 2 |
| 72 | 84-0038-00 | Spacer | | 1 |
| 73 | 84-0021-00-2 | Lock Washer | AW#12 | 1 |
| 74 | 17-0306-00 | Washer | | 1 |