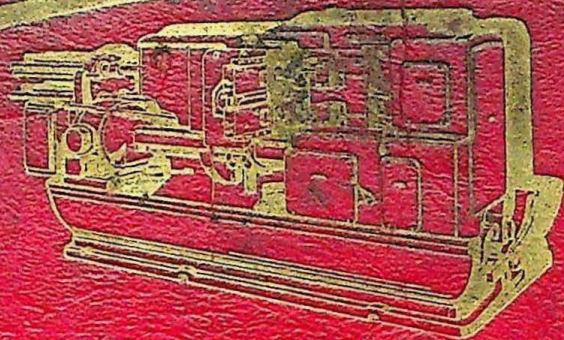




PARTS CATALOG

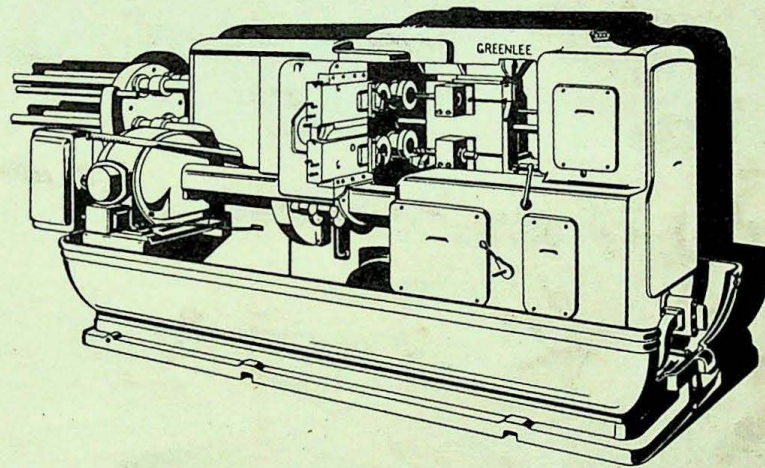
$2\frac{5}{8}$ " FOUR-SPINDLE
AUTOMATIC
BAR
MACHINES



GREENLEE BROS. & CO.
ROCKFORD, ILLINOIS, U.S.A.



REPAIR PARTS



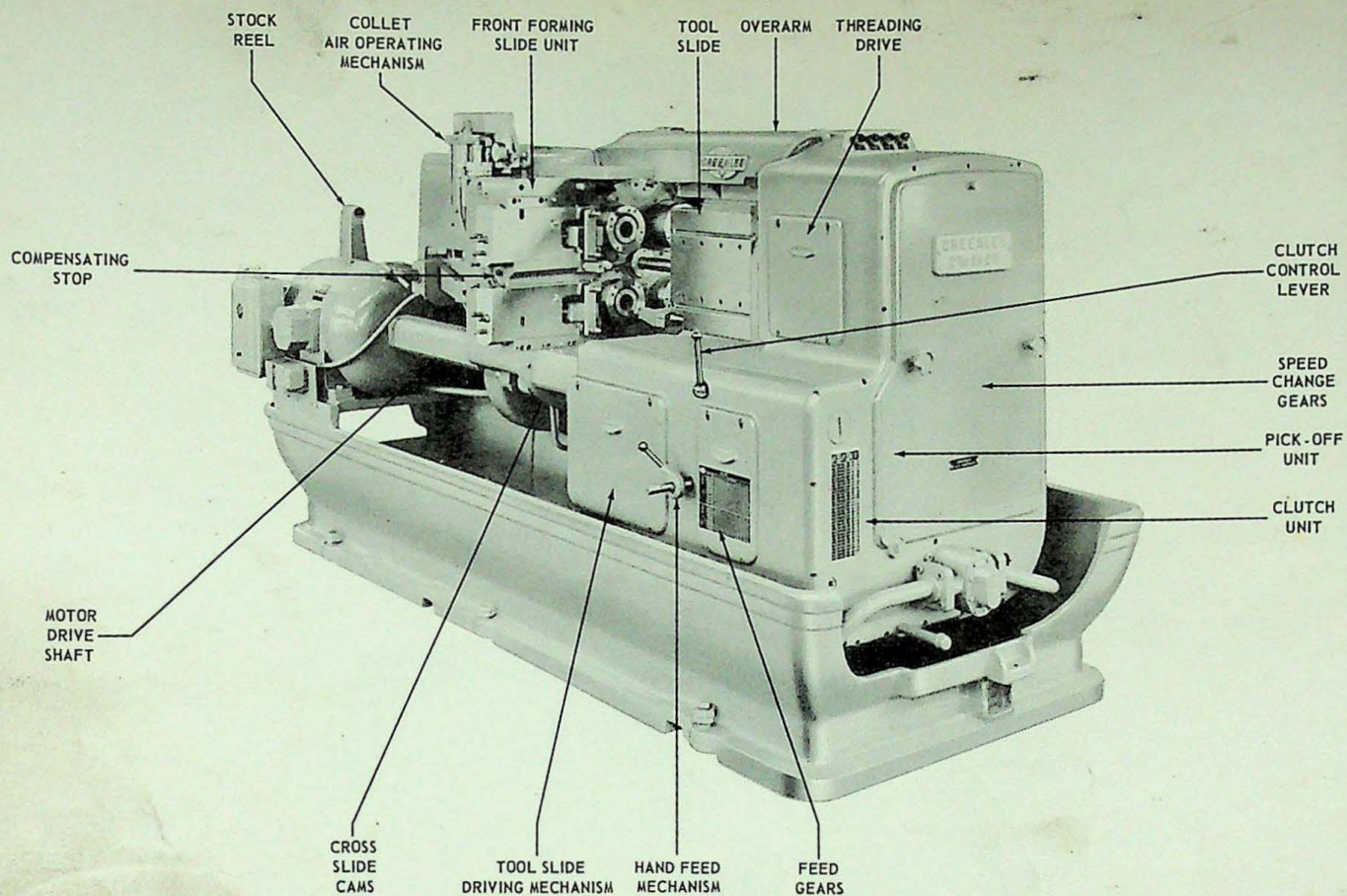
For 2⁵/₈-inch Four Spindle Automatic Bar Machines

(Starting with A1684)

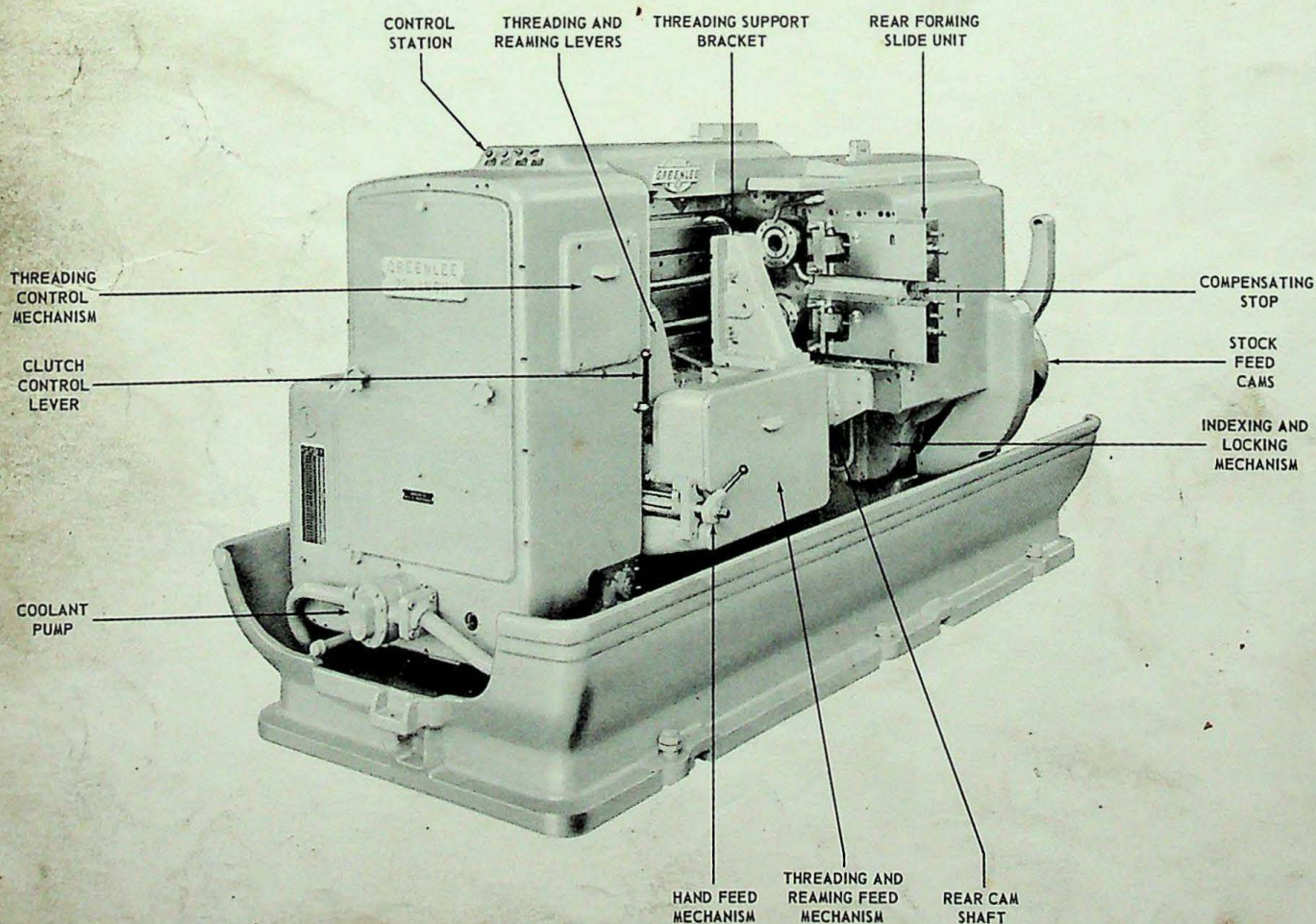
A1197

GREENLEE BROS. & CO.
ROCKFORD, ILLINOIS, U.S.A.

JUNE, 1957



FRONT VIEW



REAR VIEW

INSTRUCTIONS FOR ORDERING REPAIR PARTS

This parts book has been broken down into machine units to more clearly indicate the relative location of the individual parts. The location of the various units can be determined from the keyed photographs on the adjoining page.

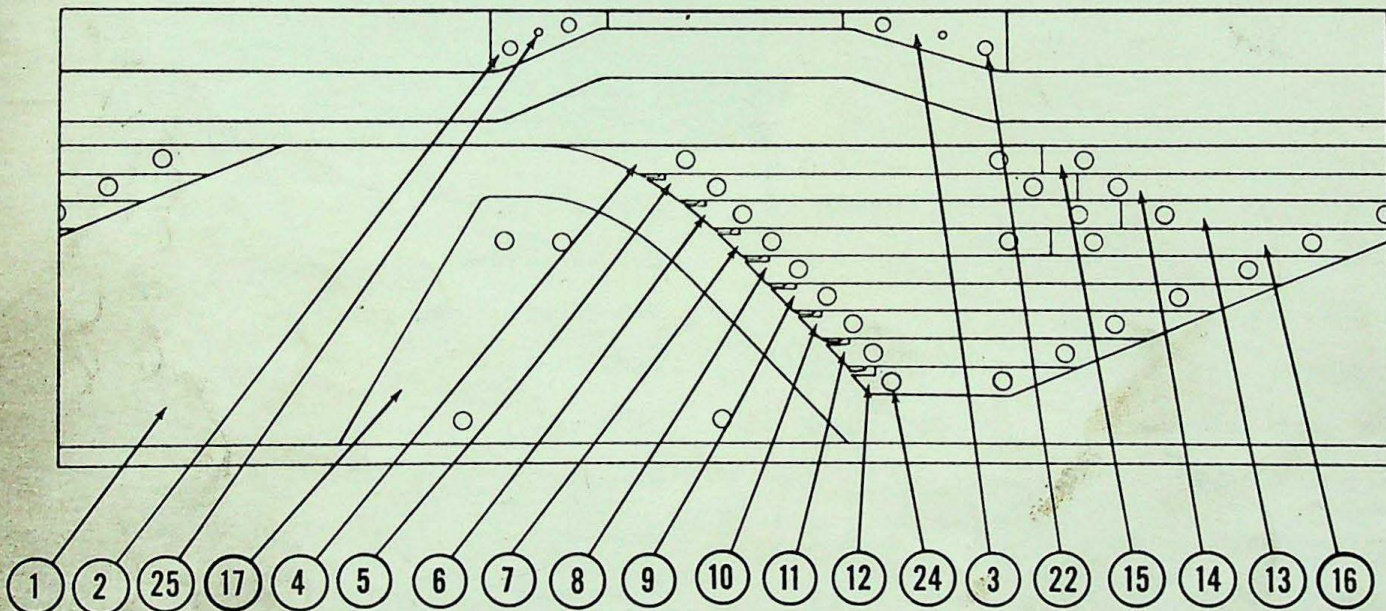
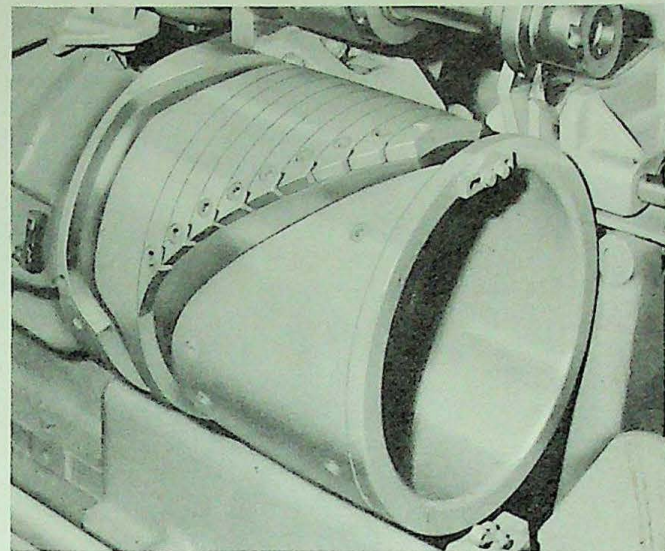
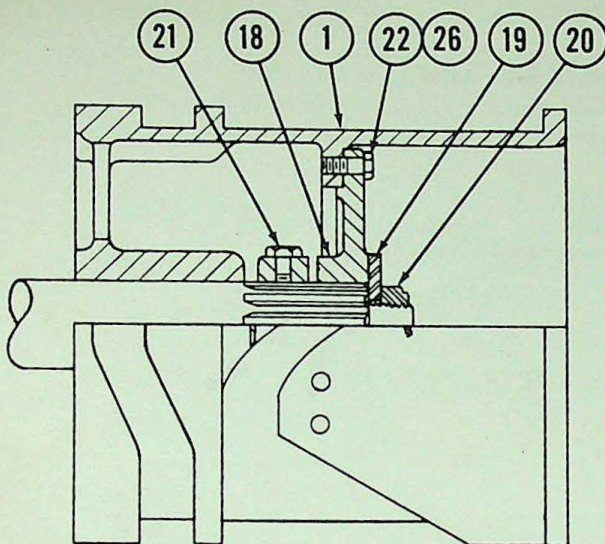
When ordering repair parts, always include the serial number of the machine, as well as the machine size and the number of spindles. The serial number is stamped on the upper surface of the Tool Slide.

Many parts have the part numbers stamped on them, and this number should be used if it is legible, particularly when the stamped number and the parts list number do not agree.

INDEX

DESCRIPTION	PAGE NO.	DESCRIPTION	PAGE NO.
Cam drum	4	Lubricating pump	35
Cam drum brake	5	Main clutch assembly	22, 23
Cam shafts	34	Motor drive	35
Clutch control mechanism	20	Oil filter	40
Collet lever assembly	7	Oil sight	40
Collet operating mechanism	8, 9	Overarm	40
Collet operating shoe	6	Pick-off unit	24, 25, 26
Coolant parts	39	Sliding overhead oil shield	38
Coolant pump	37	Spindle assembly	10, 11
Coolant valve and bracket	7	Spindle carrier and housing	12
Covers, oil shields, splash guards	39	Stock feed shoe	6
Electrical controls	38	Stock reel	36, 37
Feed control mechanism	21	Threading clutch re-set mechanism	26
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Frame parts	40	Threading drive unit	27, 28, 29
Hand feed sleeve	21	Threading drive clutch	30
Handles, cranks, wrenches	40	Tool slide assembly	17, 18, 19
Indexing and locking mechanism	13		

CAM DRUM



Developed view of cam drums showing cam strips.

Order By
This Number

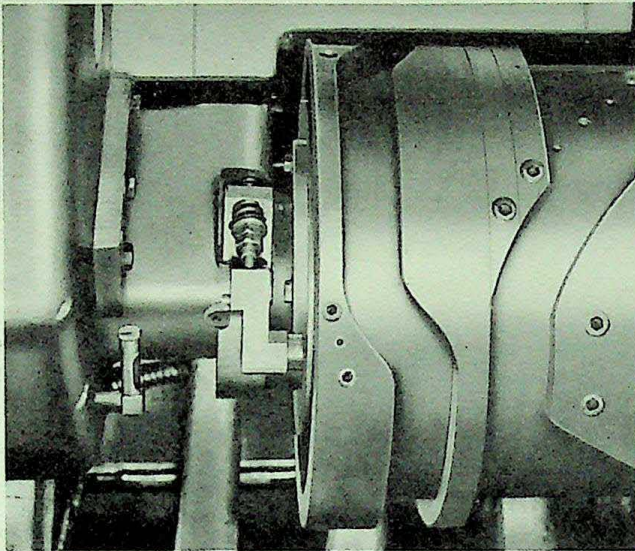
Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	YL305-2	Cam drum
2	1	2732 YL	Cam drum insert
3	1	2733 YL	Cam drum insert
4	1	6178 YL	Stock feed cam
5	1	6179 YL	Stock feed cam
6	1	6180 YL	Stock feed cam
7	1	6181 YL	Stock feed cam
8	1	6182 YL	Stock feed cam
9	1	6183 YL	Stock feed cam
10	1	6184 YL	Stock feed cam
11	1	6185 YL	Stock feed cam
12	1	6186 YL	Stock feed cam
13	1	1877 YL	Stock feed cam
14	1	1879 YL	Stock feed cam
15	1	1928 YL	Stock feed cam

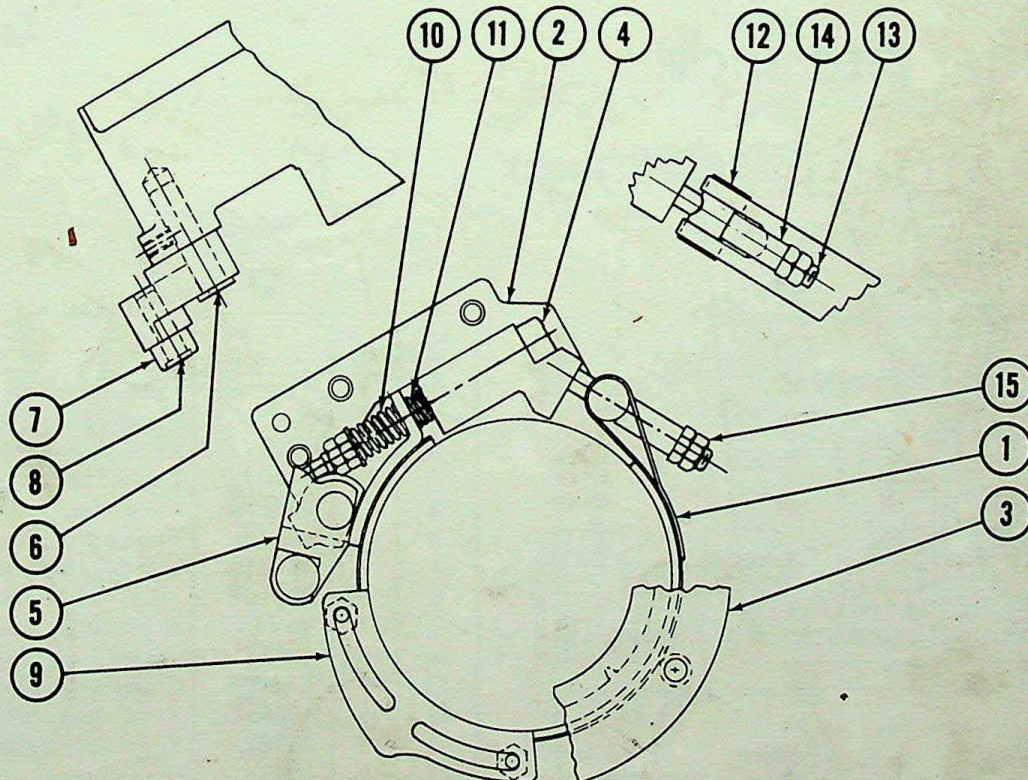
Key No.	Qty.	Part Number	Name of Part
16	1	10481YL	Stock feed cam
17	1	YL440-Y	Stock feed cam
18	1	YL303-2	Cam drum spider
19	1	1552 YL	Cam drum washer
20	1	2346 GB	1-1/2" Castellated nut
21	1	1854 GB	5/8" x 3-1/4" hex. hd. cap screw
22	6	1847 GB	5/8" x 1-1/2" hex. hd. cap screws
23	4	2076 GB	3/8" x 1" socket hd. cap screws
24	30	2098 GB	1/2" x 3/4" socket hd. cap screws
25	2	1099 V	3/8" x 1" dowel pins
26	2	1128 V	3/4" x 1-1/2" dowel pins

CAM DRUM BRAKE

Order By
This Number



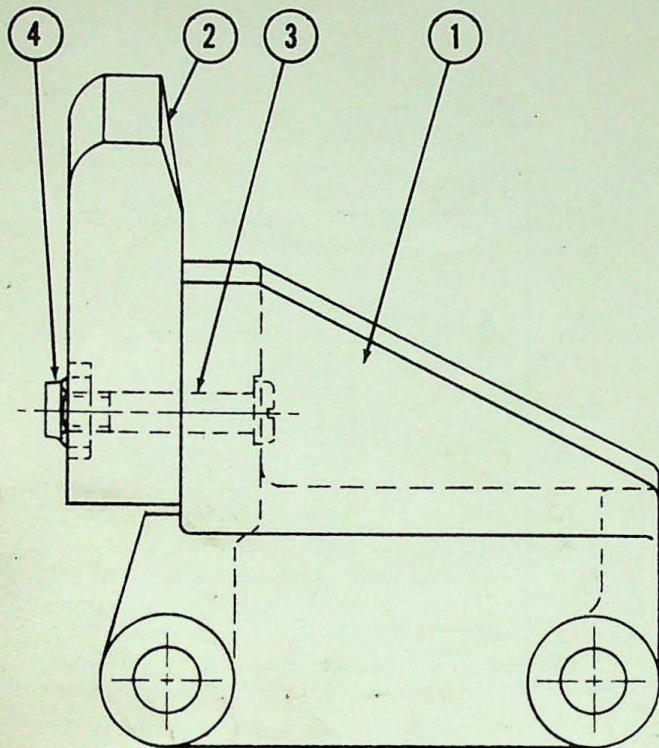
Key No.	Qty.	Part Number	Name of Part
1	1	10148YL	Brake band
2	1	YA1065	Brake mounting bracket
3	1	YL1360-1	Brake drum
4	1	8827YL	Brake operating stud
5	1	8830YL	Brake lever
6	1	8831YL	Brake lever stud
7	1	8832YL	Brake lever roller
8	1	8833YL	Brake lever roller pin
9	1	8834YL	Brake operating cam
10	1	9301YL	Brake operating spring
11	1	9302YL	Brake return spring
12	1	10150YL	Brake band trunnion
13	1	10151YL	Brake adjusting stud
14	1	10152YL	Adjusting stud sleeve
15	2	987GB	Adjusting stud jam nuts



ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

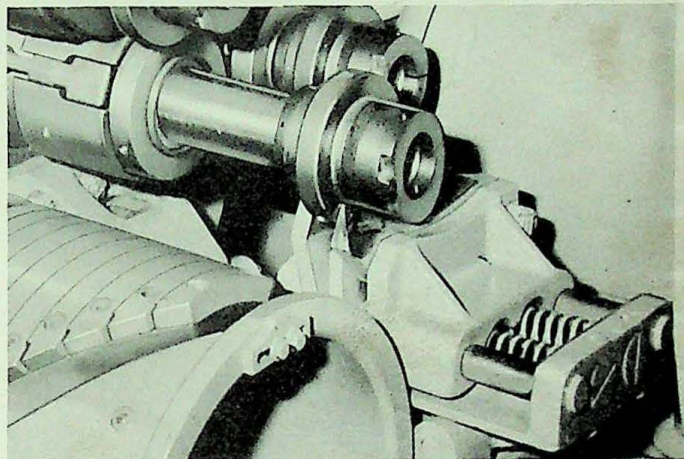
2-5/8" - 4

COLLET OPERATING SHOE

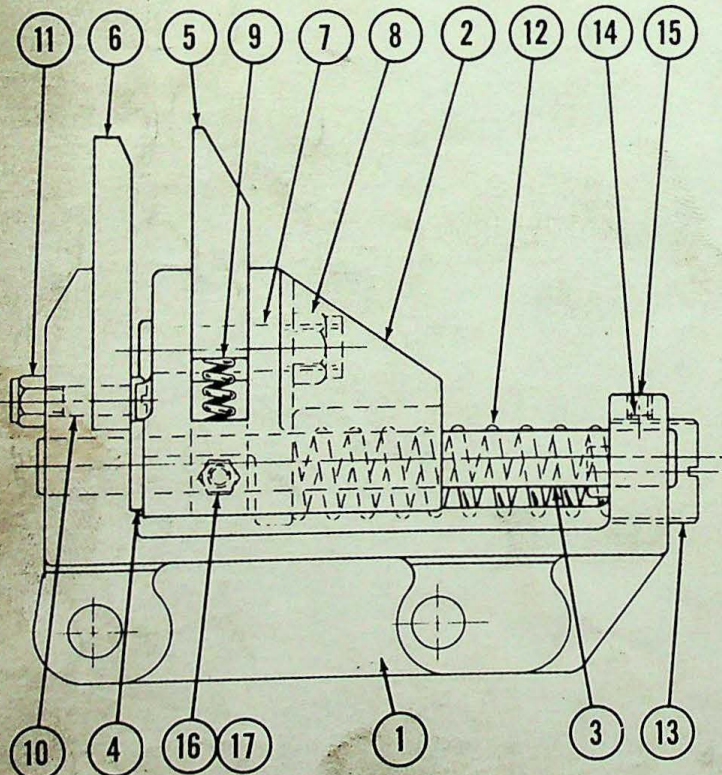


Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	YL513-1	Collet operating shoe
2	1	4135YL	Collet shoe plate
3	3	2432YL	Collet shoe plate screws
4	3	2338GB	1/2" SAE castellated nuts



COLLET FEED SHOE

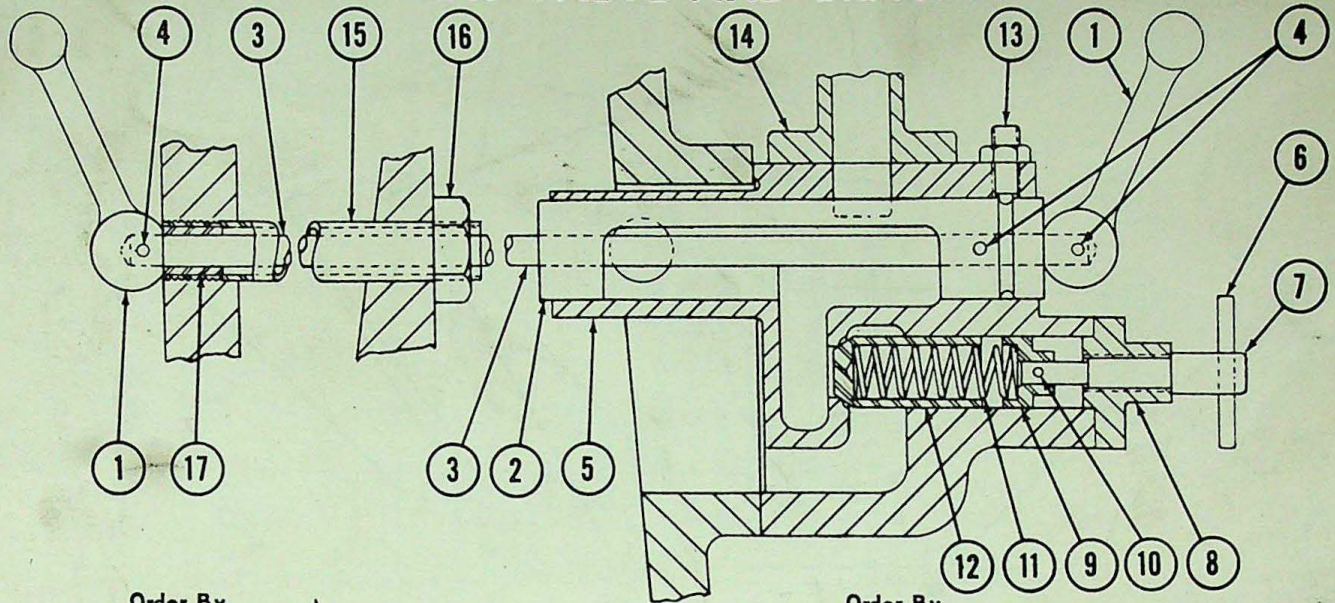


Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	YA434-1	Feed shoe support
2	1	YA432-1	Feed shoe
3	2	1390YA	Feed shoe guide bars
4	1	11808YL	Bumper strip
5	1	1748YL	Feed shoe safety lever
6	1	3010YL	Feed shoe plate
7	1	1388YA	Safety latch pin
8	1	2341GB	3/4" castellated nut
9	1	96ZZF	Safety lever spring
10	3	1898YL	Collet shoe plate screws
11	3	2338GB	Collet shoe plate nuts
12	2	10693YL	Feed shoe springs
13	2	1391YA	Feed shoe spring plugs
14	2	1545V	Brass plugs
15	2	2210GB	3/8" socket head set screws
16	1	1976GB	3/8" x 1-1/2" set screw
17	1	2323GB	3/8" jam nut

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

COOLANT VALVE AND BRACKET



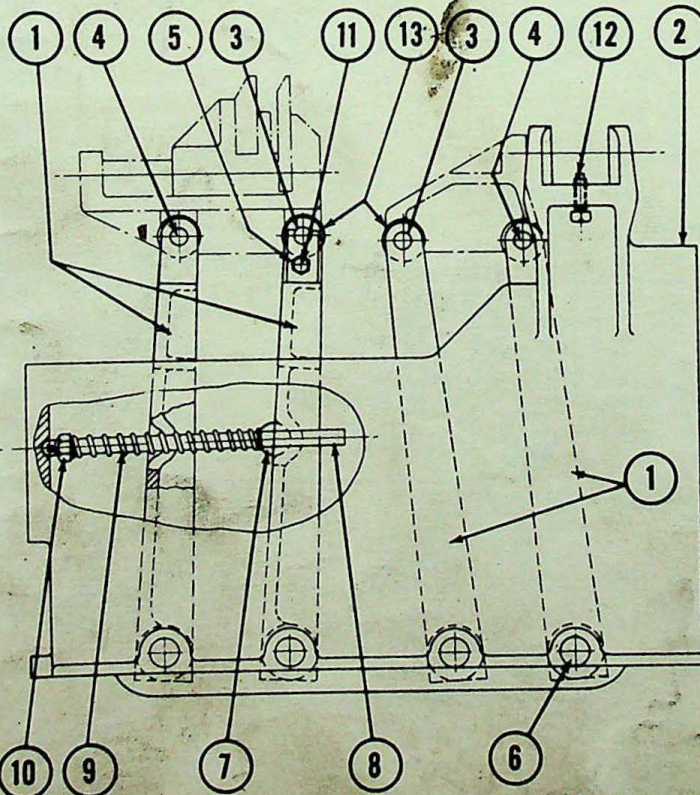
Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	2	888 YA	Coolant valve handle
2	1	11232YL	Coolant valve
3	1	2603 YL	Valve operating rod
4	3	3554 GB	Roll pin
5	1	YL 1789	Coolant valve bracket
6	1	1123 GB	Roll pin
7	1	11235YL	Spring adjusting stud
8	1	YL 1790	Adjusting stud retainer
9	1	11233YL	Spring seat

Order By
This Number

Key No.	Qty.	Part Number	Name of Part
10	1	1113 GB	Roll pin
11	1	11237YL	Relief valve spring
12	1	11234YL	Relief valve
13	1	1466 GB	Vliers spring plunger
14	1	YA258-2	Outlet manifold
15	1	1481 YL	Operating rod pipe
16	1	986 GB	1" - 14 NF Jam Nut
17	1	1480YL	Operating rod bushing

COLLET LEVER ASSEMBLY

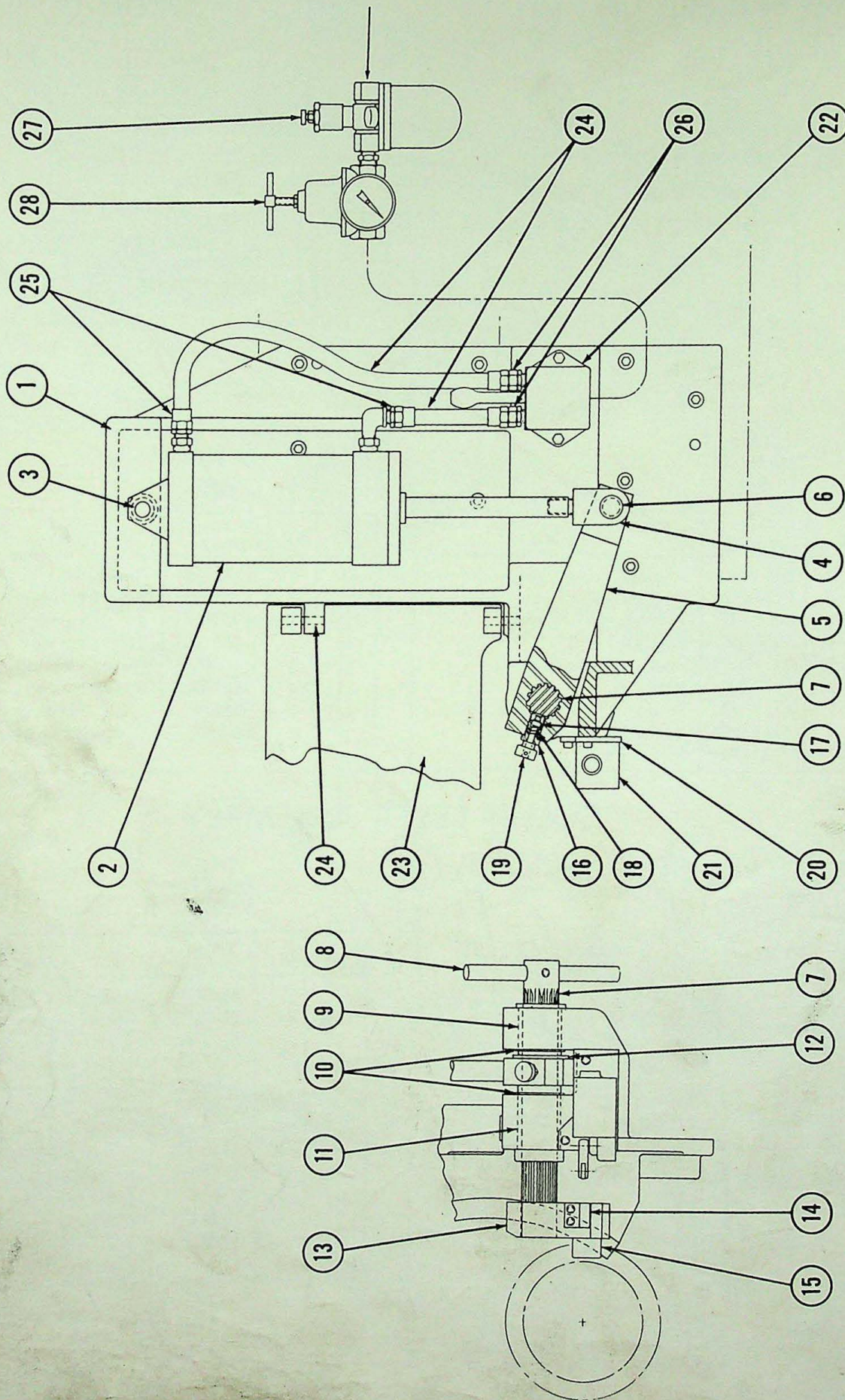


Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	4	YL177-1	Collet and feed shoe levers
2	1	YL435-2	Collet lever bracket
3	2	2146 YL	Collet lever pins <i>Long</i>
4	2	2147 YL	Collet lever pins <i>Short</i>
5	4	3000 YL	Shaft retainers
6	4	4186 YL	Collet lever pivot shafts
7	1	4344 YL	Spring rod guide
8	1	4345 YL	Spring rod
9	1	10537YL	Feed shoe lever spring
10	2	2326 GB	5/8" jam nuts
11	4	1828 GB	1/2" x 1" hex. hd. screws
12	1	1959 GB	1/2" x 2-1/2" sq. hd. screw
13	2	11 YG	Chuck rollers

ALWAYS GIVE SERIAL NUMBER OF
MACHINE WHEN ORDERING PARTS

COLLET OPERATING MECHANISM



2-5/8" - 4

COLLET OPERATING MECHANISM PARTS LIST

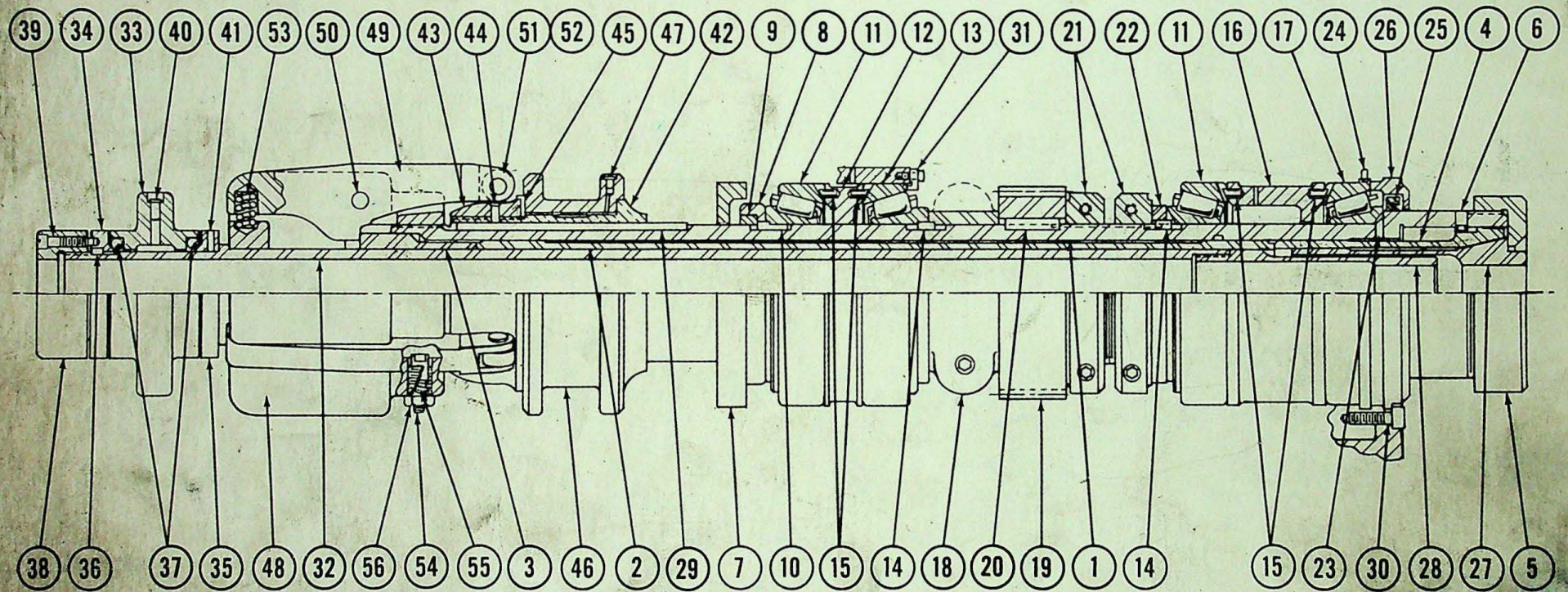
Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	YL 1663-1	Front shield support
2	1		Miller air cylinder #A84
3	1	1074 V	Head pin
4	1	10561YL	Cylinder connector
5	1	10562YL	Cylinder link lever
6	1	1093V	Head pin
7	1	10830YL	Sliding shaft
8	1	10829YL	Shaft handle
9	1	10567YL	Sliding shaft bushing
10	2		Retaining rings #5100-212
11	1	10831YL	Sliding shaft bushing
12	1	12161YL	Fitting spacer
13	1	10564YL	Operating lever
14	1	10726YL	Switch trip cam

Order By
This Number

Key No.	Qty.	Part Number	Name of Part
15	1	10565YL	Operating lever plug
16	1	4353YL	Plunger nut
17	1	10569YL	Plunger
18	1	3529YL	Plunger spring
19	1	10568YL	Plunger knob
20	1	10832YL	Switch plate
21	1	EQ 337	Snap-lock switch #16D-1200-1
22	1		Logan air valve #6556 -3/8"
23	1	YL 1664	Front shield
24	2	869 GB	Oil resistant hoses
25	2		3/8" couplings
26	2		3/8" union couplings
27	1		Norgren #O-41-3 lubricator
28	1		Norgren #2A4-GG regulator

SPINDLE ASSEMBLY



Order By
This Number
↓

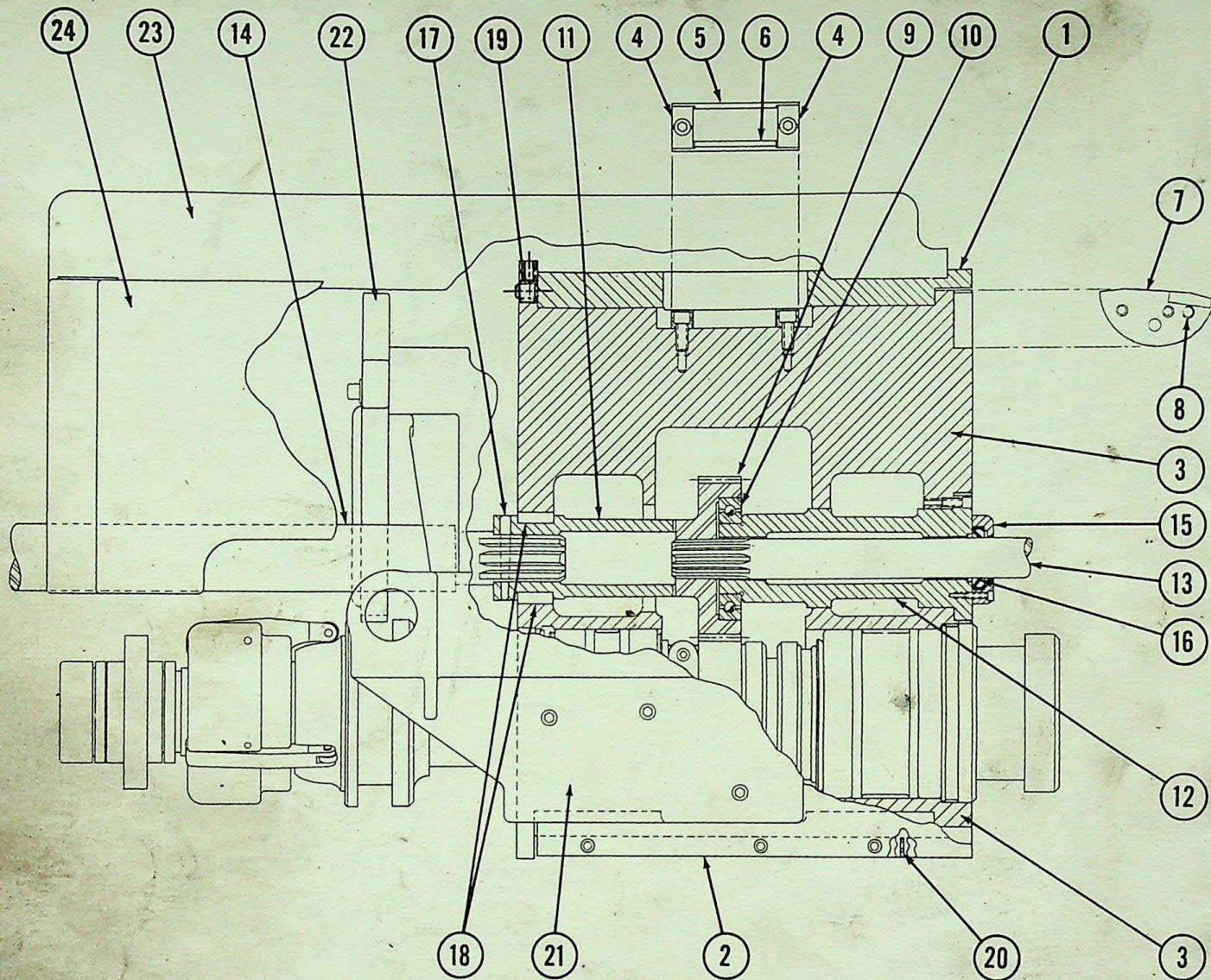
Key No.	Qty.	Part Number	Name of Part
		1017-4	Spindle Unit Assembly (Parts 1 through 31)
1	1	1512YL	Spindle
2	1	1514YL	Collet tube
3	1	1517YL	Collet tube extension
4	1	1496YL	Collet closing sleeve
5	1	1492YL	Spindle nose nut
6	1	1885YL	Spindle nose pin
7	1	YL380	Rear oil retainer
8	1	YL379	Rear bearing retainer
9	1	YL576	Bearing retainer insert
10	1	660YM	Lockwasher key
11	2	8562YL	Timken #64450 - 64700
12	1	YL363	Rear bearing spacer
13	1	8561YL	Timken #64450W - 64700
14	2	8338YL	Bearing lock keys
15	4	7801YA	Bearing lock pins
16	1	YL359	Front bearing spacer
17	1	8563YL	Timken #64450 - 64700B
18	1	YL357	Spindle bearing spacer
19	1	11371YL	Spindle gear
20	1	1488YL	Spindle gear key
21	2	1740YL	Spindle adjusting lock nuts
22	1	1497YL	Bearing adj. lock washer
23	1	8560YL	Bearing lock pin
24	1	7796YA	Bearing lock pin
25	1	1012GB	Clipper oil seal #5926 - LA
26	1	7832YL	Spindle bearing retainer
27	1		Collet
28	1		Pusher
29	1	2120YA	Key
30	7	7629YA	Bearing retainer screws

Order By
This Number
↓

Key No.	Qty.	Part Number	Name of Part
31	1	7790YA 1018-1	Bearing lock plate Feed Tube Unit Assembly (Parts 32 through 41)
32	1	1519YL	Feed tube
33	1	1493YL	Feed tube oiling collar
34	1	1495YL	Feed tube bearing retainer
35	1	1494YL	Feed tube bearing retainer
36	1	2836YG	Feed tube key
37	72	3282GB	5/16" steel balls
38	1	1498YL	Feed tube nut
39	1	2838YG	Feed tube nut screw
40	1	1358GB	#1853 Alemite flush fitting
41	2	1359GB	Roll pins
		1008-2	Collet Spool & Sleeve Unit (Parts 42 through 47)
42	1	YL378	Collet operating sleeve
43	1	1485YL	Collet closing sleeve nut
44	1	2899YA	Closing collet pin
45	1	YL1125	Collet spool thrust washer
46	1	1486YL	Collet spool
47	1	1358GB	#1853 Alemite flush fitting
		1009-5	Collet Lever Body Unit (Parts 48 through 56)
48	1	YL1963	Collet lever body
49	3	632YL	Collet levers
50	3	1503YL	Collet lever pins
51	3	2976YL	Rollers
52	3	1187V	Roller pins
53	3	152HS	Collet finger springs
54	1	7534YL	Chuck body plunger
55	1	3529YL	Spring
56	1	7519YL	Plunger nut

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

SPINDLE CARRIER AND HOUSING



Order By
This Number

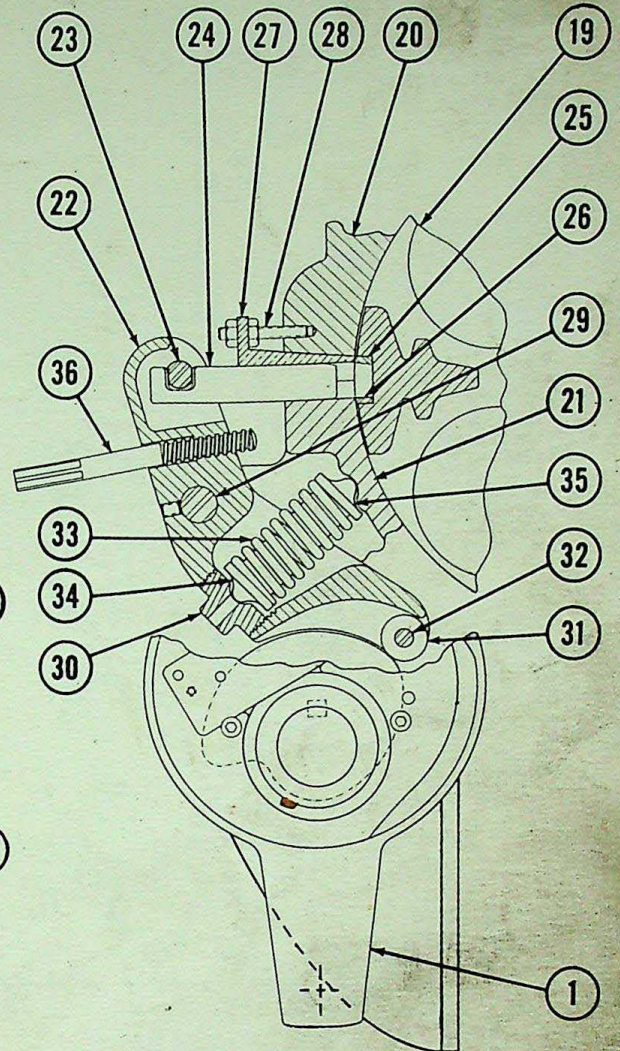
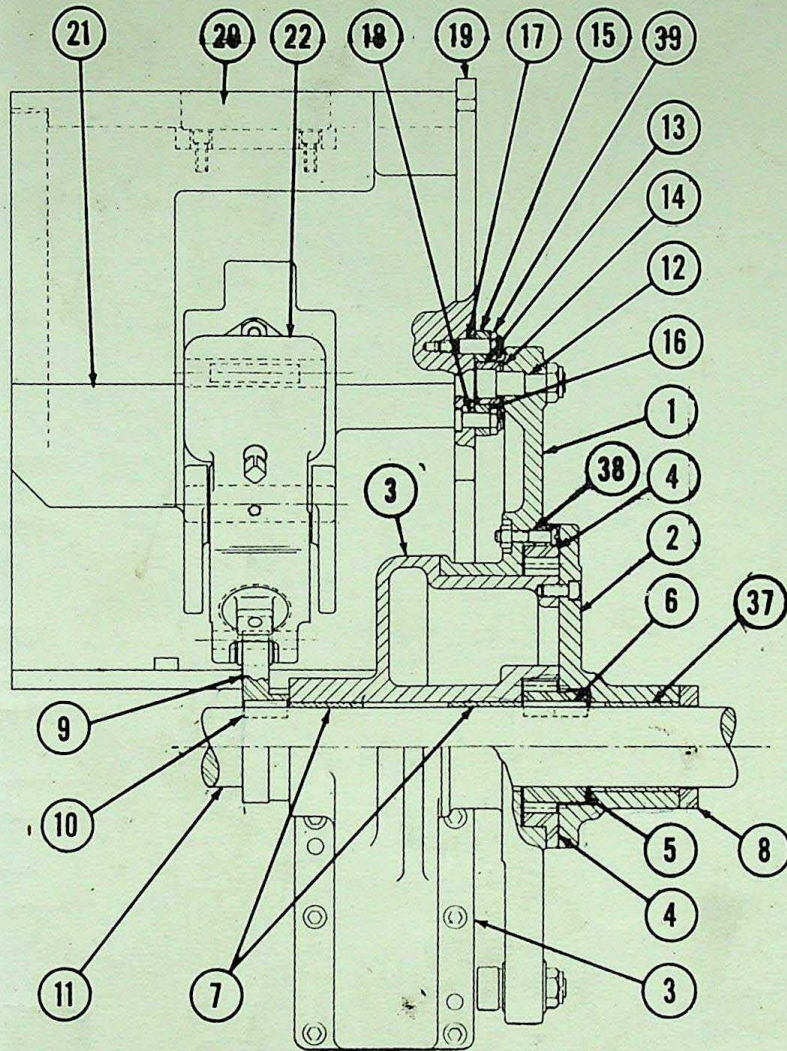
Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	YL1820	Upper carrier housing
2	1	3100177	Lower carrier housing
3	1	YL1819	Spindle carrier
4	8	182YL	Locking block clamps
5	4	219YG	Locking block sides
6	4	220YG	Locking block sides
7	4	2116YL	Comp. wheel shock plates
8	4	2356YL	Compensating wheel pins
9	1	11372YL	Spindle drive gear
10	1	65GB	New departure bearing #3215
11	1	YL509	Stock reel shaft bearing
12	1	YL510	Front center bushing

Key No.	Qty.	Part Number	Name of Part
13	1	11366YL	Spindle drive shaft
14	1	3182YL	Stock reel shaft
15	1	YL1352	Oil seal retainer
16	1	863GB	Garlock Klosure #909
17	1	3417YA	Taper pin
18	2	1490YL	Stock reel bearing keys
19	4	1667YL	Revolving head adj. screws
20	1	3100178	Housing and frame spacer
21	1	YL1663-1	Front shield support
22	1	YL1117	Collar locking ring
23	1	YL1113-2	Upper spindle shield
24	1	YL1664	Front shield

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

INDEXING AND LOCKING MECHANISM



Order By
This Number



Key No.	Qty.	Part Number	Name of Part
1	1	YL596-X1	Index arm
2	1	YL367	Index arm cover
3	1	YL340-2	Index arm bracket
4	1	44 YL	Index arm internal gear
5	1	1487YL	Index drive gear
6	1	4173YL	Index gear key
7	2	YL2029	Bushings
8	1	3387YL	Cam drum washer
9	1	10768YL	Locking block cam
10	1	4172YL	Locking block cam key
11	1	7855YL	Rear cam shaft
12	2	7661YL	Index arm roller studs
13	2	5549YL	Index arm rollers
14	2	7663YL	Index arm roller washers
15	4	1865YL	Index roller guides (L. H.)
16	4	8795YL	Index roller guides (R. H.)
17	16	1501YL	Index guide studs
18	8	1502YL	Index guide studs
19	1	YL1819	Spindle carrier
20	1	YL1820	Upper carrier housing

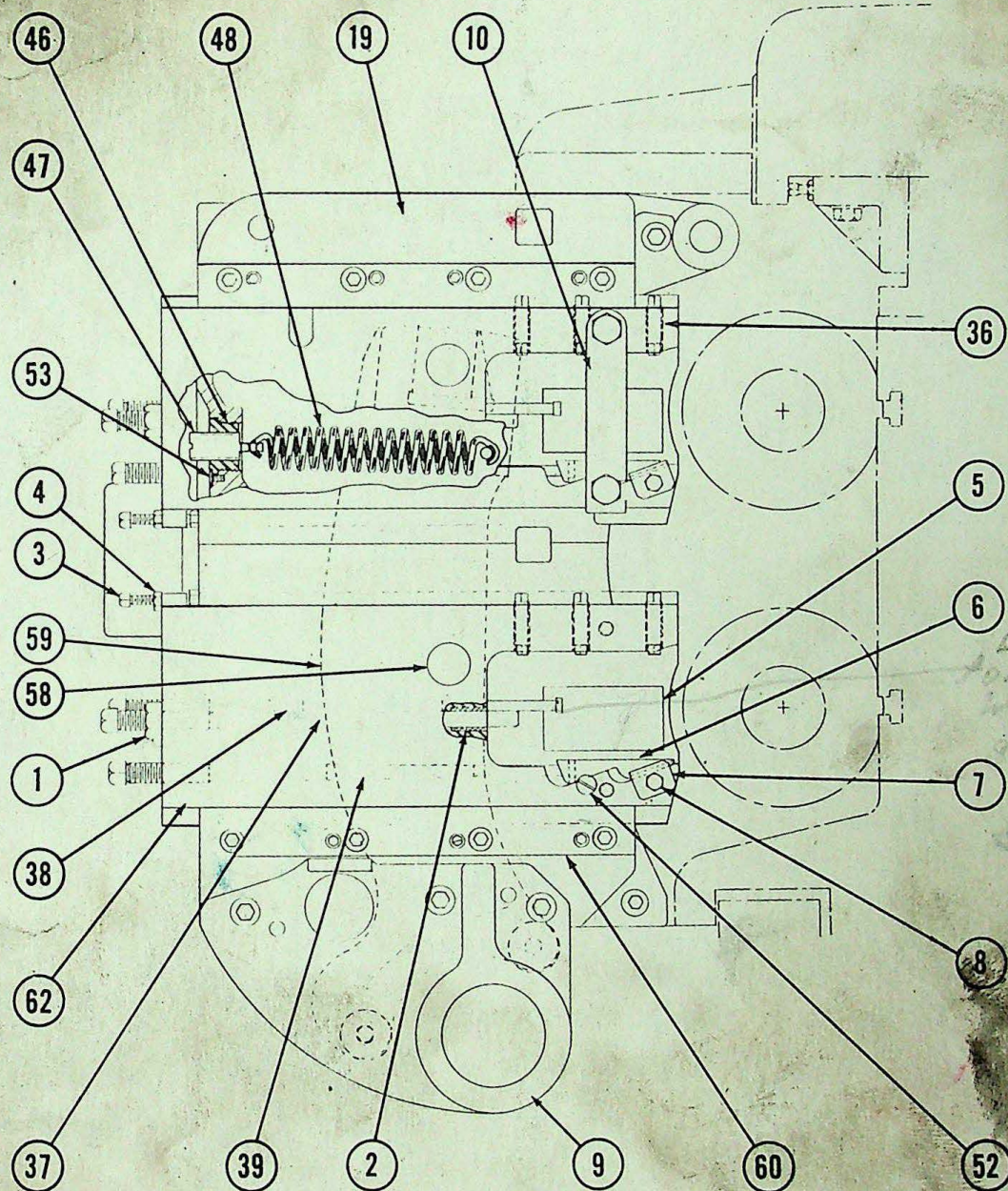
Order By
This Number



Key No.	Qty.	Part Number	Name of Part
21	1	YL1821	Lower carrier housing
22	1	YL304	Locking block lever
23	1	1367YL	Locking block pin
24	1	1366YL	Locking block
25	4	220 YG	Locking block inserts
26	4	219 YG	Locking block inserts
27	1	YL 14	Locking block gib
28	1	191 YG	Locking gib stud
29	1	1528YL	Locking lever shaft
30	1	YL302X	Spring plug
31	1	1529YL	Locking lever roller
32	1	1193V	Locking lever roller pin
33	1	2343YL	Locking lever spring
34	1	YL307X	Spring carrier
35	1	YL307Y	Spring carrier
36	1	1365YL	Locking lever screw
37	1	YL2031	Bushing
38	8	9166YL	Internal gear screws
39	24	3601YL	1/2"-20 slotted nuts

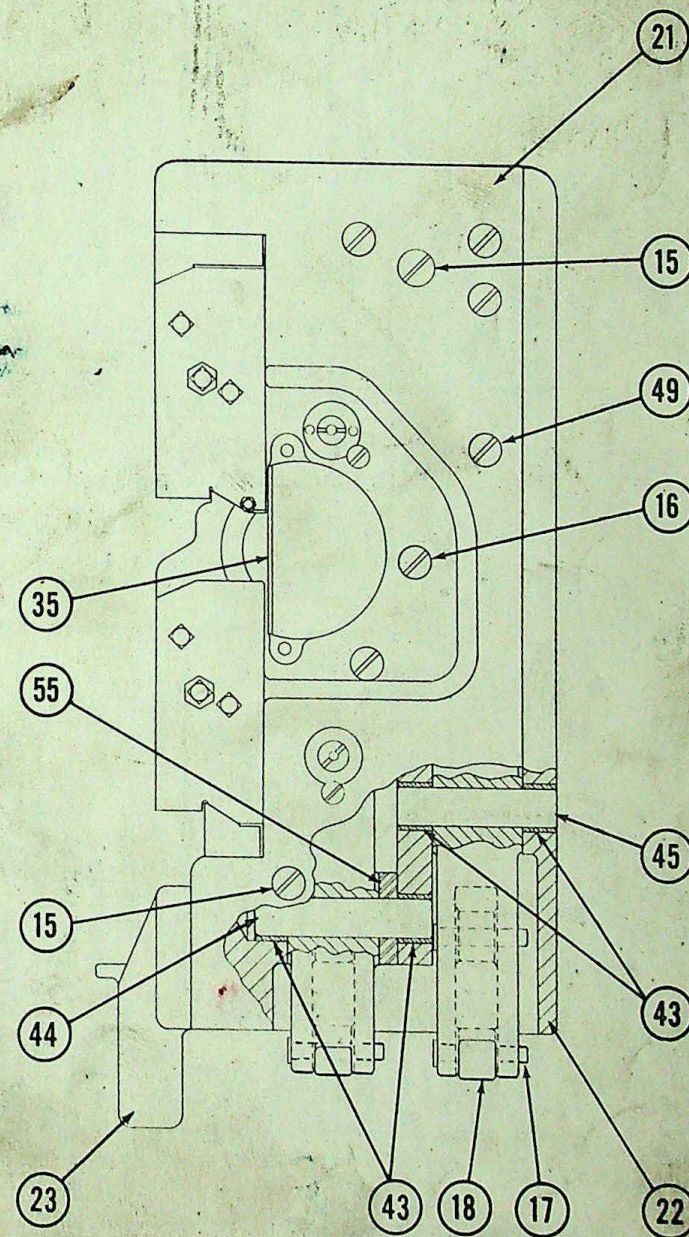
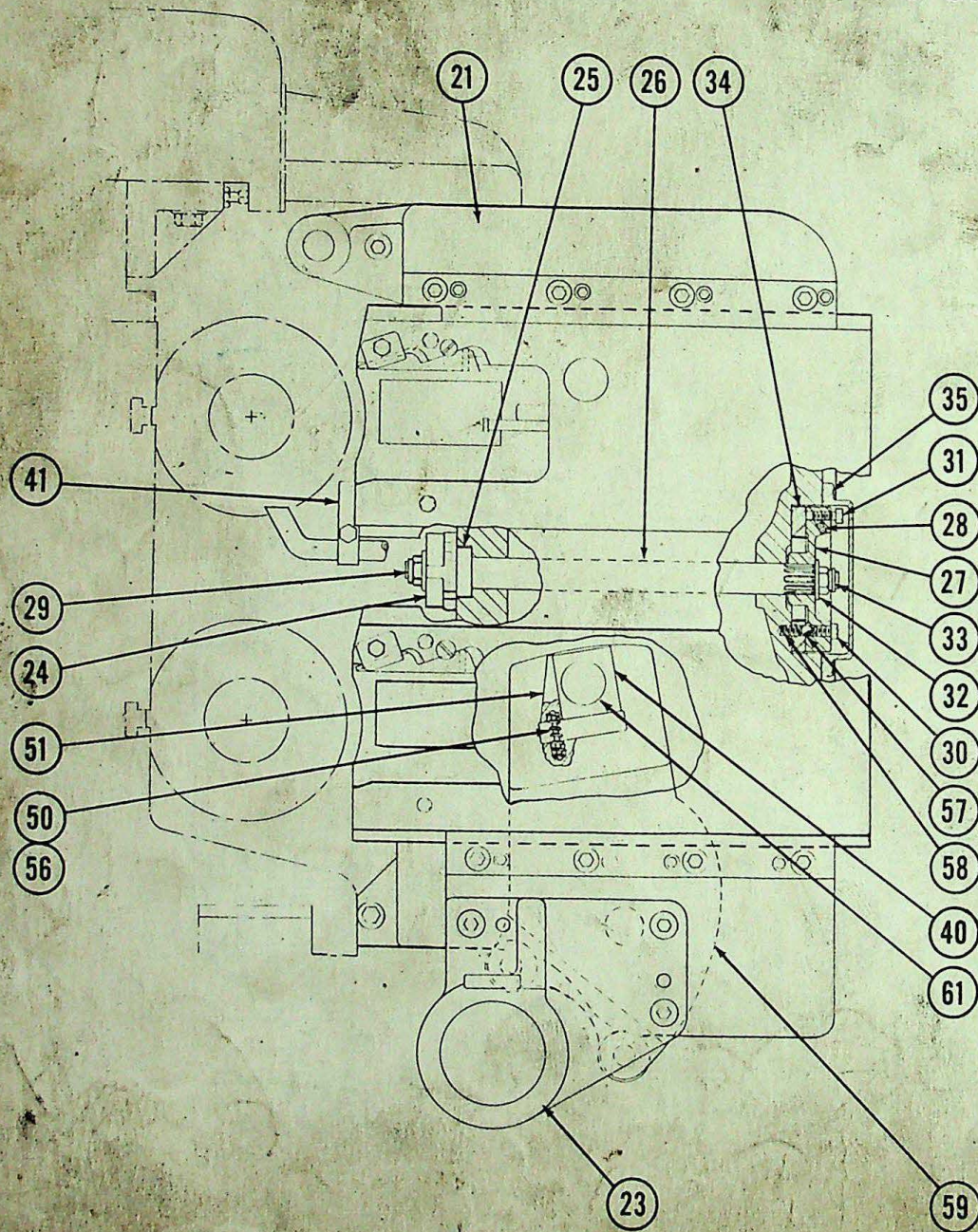
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

2-5/8" - 4



ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

FORMING SLIDE UNIT (Rear)



PARTS LIST ON FOLLOWING PAGE

FORMING SLIDE UNIT PARTS LIST

Order By
This Number



Key No.	Qty.	Part Number	Name of Part
1	4	1576YL	Tool adjusting screw nuts
2	4	1549YL	Tool adjusting screw bushings
3	4	2242YL	Stop adjusting screws
4	4	3243GB	Stop adjusting nuts
5	4	143YL	F. S. wedges (bottom)
6	4	413YA	F. S. wedges (side)
7	4	414YA	Wedge guide plates
8	4	1797GB	5/16" x 1/2" cap screws
9	1	YL521X	Cam shaft support bearing
10	4	144YL	Tool clamps
11	8	1164V	Clamp stud washers
12	8	699YG	Tool clamp studs
13	1	1540YL	Coolant valve (2nd pos.)
14	1	2366YL	Coolant valve
15	2	1371YL	Coolant valves
16	1	2352YL	Coolant valve
17	8	1190V	Lever roller shafts
18	8	1219YG	Lever rollers
19	1	YL383CX1	F. S. bracket (front)
20	1	YL 507	Bracket cover (front)
21	1	YL387CX1	F. S. bracket (rear)
22	1	YL508X	Bracket cover (rear)
23	1	YL1124	Cam shaft sup. brkt. (rear)
24	2	11694YL	Star wheels
25	2	6951YL	Compensating shaft collars
26	2	11695YL	Compensating shafts
27	2	YL1881	Compensating wheels
28	16	YA465	Set screw plugs
29	2	3728GB	Locknuts

Order By
This Number



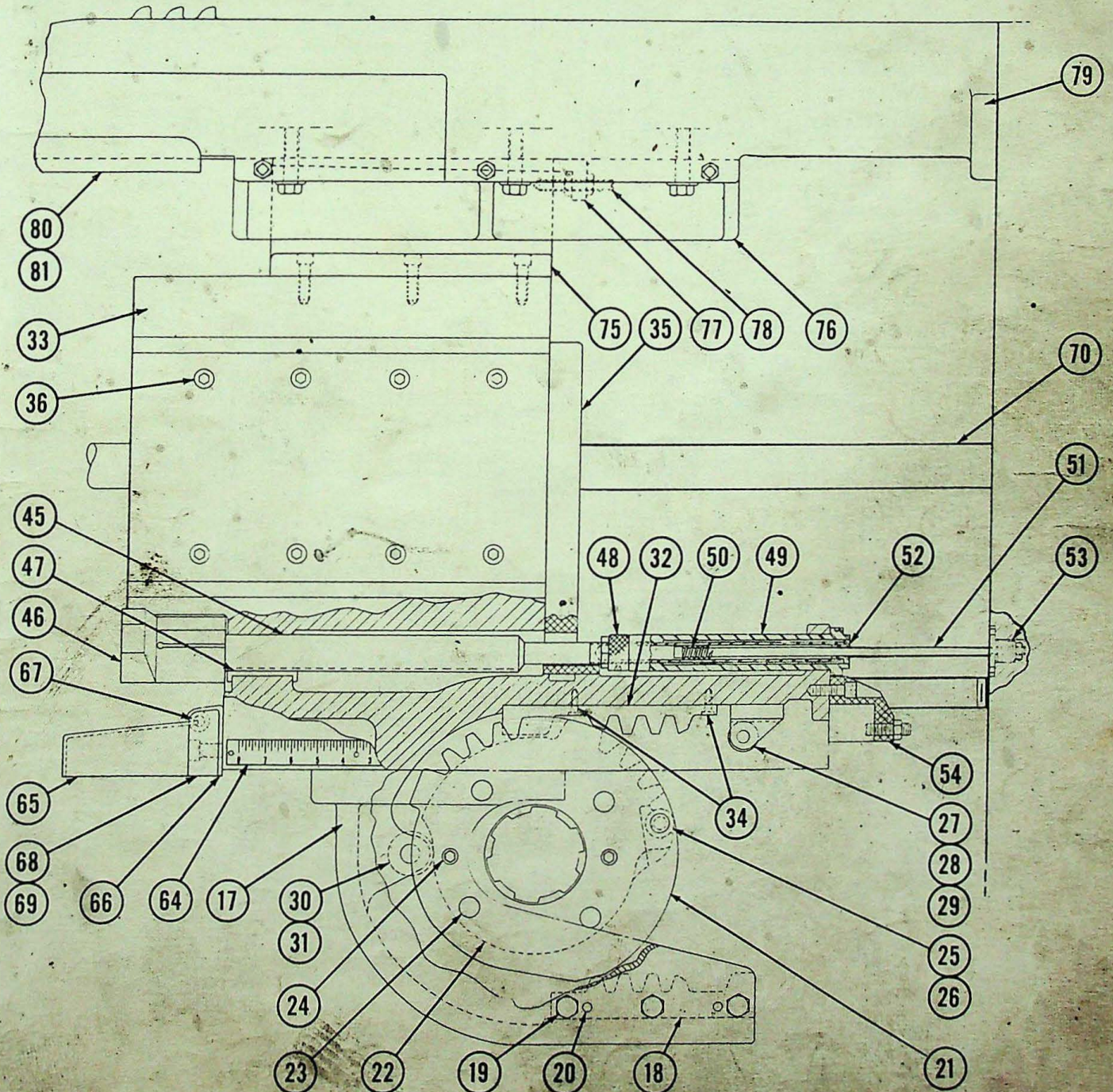
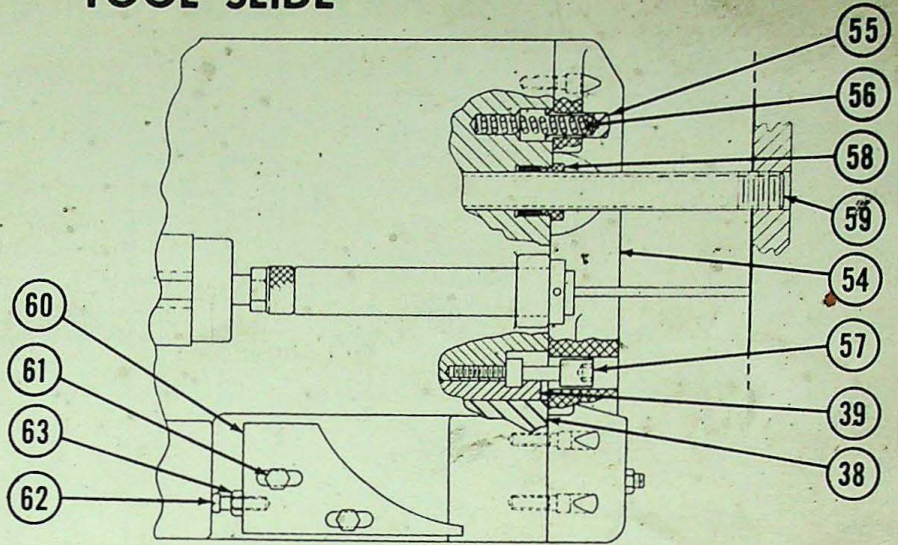
Key No.	Qty.	Part Number	Name of Part
30	2	3773YL	Ball lock screws
31	16	1335YM	Comp. wheel adj. screws
32	2	11622YL	Washers
33	2	3727GB	Locknuts
34	2	8782YL	Comp. wheel sup. plates
35	2	YL1120	Comp. wheel covers
36	12	2163YL	Tool clamp screws
37	4	1546YL	Tool adjusting screws
38	4	1547YL	Wedge adjusting screws
39	4	1548YL	Wedge adj. screws (side)
40	4	1555YL	F. S. stud blocks
41	1	2133YL	Coolant pipe clamp plate
42	3	2447YL	Coolant outlet blocks
43	8	4164YL	F. S. lever shaft bushings
44	2	4165YL	F. S. lever shafts
45	2	4166YL	F. S. lever shafts
46	4	8196YL	Spring adjusting nuts
47	4	10888YL	Spring couplings
48	4	10889YL	Springs
49	12	1215YG	F. S. screw plugs
50	4	123BX	F. S. lever wedge springs
51	4	YL390	F. S. lever wedges
52	4	2304YG	F. S. wedge screws
53	4	3402GB	No. 1-XLO lock screws
54	1	YL 394	Forming slide plate
55	1	1580YL	F. S. lever spacer
56	4	8804YL	Spring guide rod
57	2	3282GB	5/16" steel ball
58	2	727-2	Ball lock spring

ORDER FOLLOWING PARTS ACCORDING TO POSITION ON MACHINE

Key No.	Qty.	Name of Part	1st Position	2nd Position	3rd Position	4th Position
59	1	Forming slide lever	YL388-1	YL389-1	YL401-1	YL402-1
60	1	Forming slide gib	YL396	YL395	YL396	YL404
61	1	Forming slide lever stud	1574YL	1574YL	1554YL	1555YL
62	1	Forming slide	2239YL	2238YL	2240YL	2241YL
63	4	Forming slide gib pins	2130YL	2129YL	2129YL	2130YL

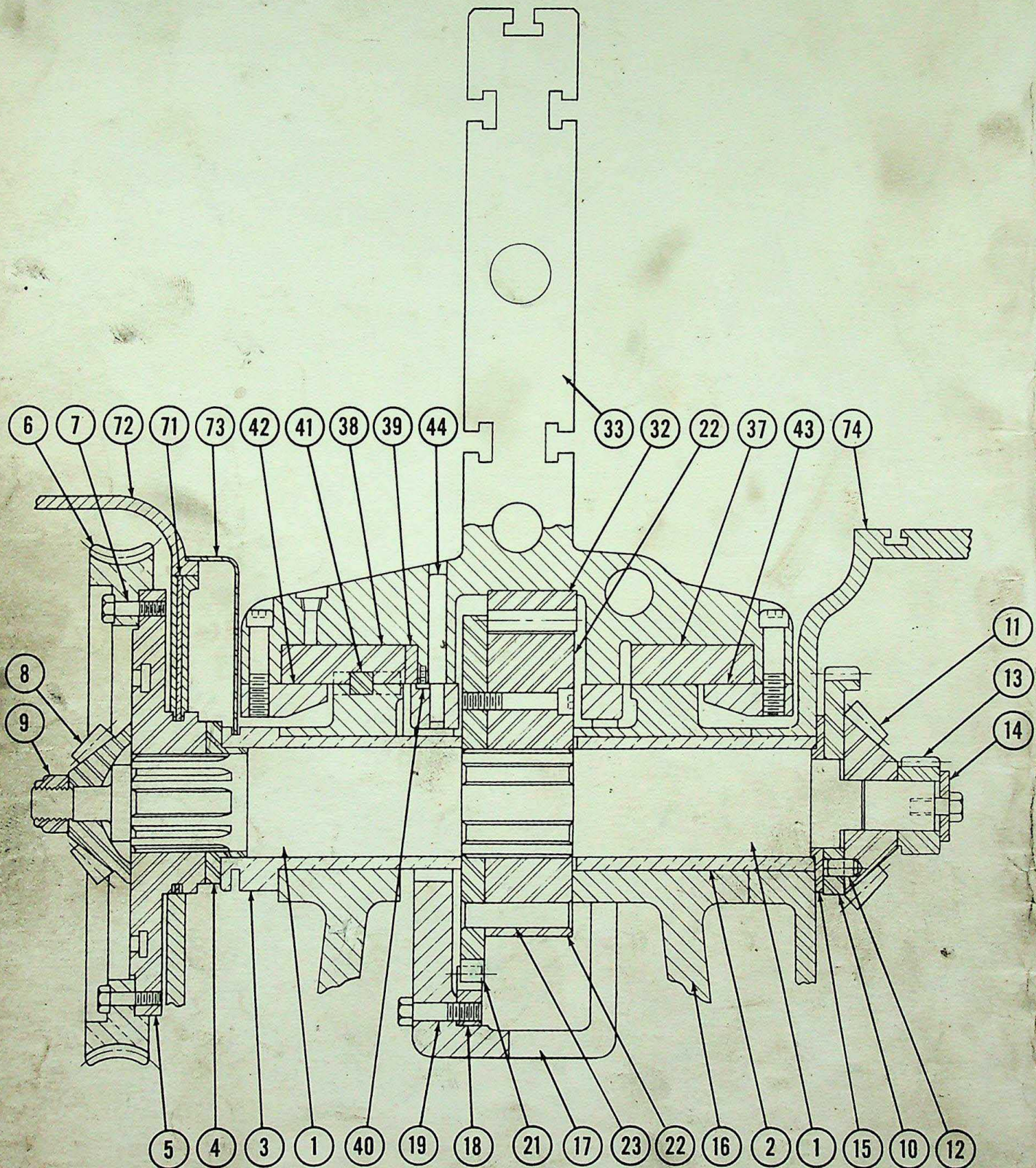
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

TOOL SLIDE



2.5/8" - 4

TOOL SLIDE (Cont'd)



2-5/8" - 4

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

TOOL SLIDE PARTS LIST

Order By
This Number



Key No.	Qty.	Part Number	Name of Part
R1	1	8181YL	Intermittent shaft
R2	1	YL355-Y	Shaft bushing (Rear)
R3	1	YL432-1	Shaft bushing (Front)
4	1	8183YL	Gear spider spacer
5	1	7424YL	Worm gear spider
6	1	YL312-X	Tool slide worm gear
7	10	1810GB	3/8" x 1-1/2" cap screws
8	1	3008YL	Bevel gear (Front)
9	1	2343GB	1" castellated nut
10	1	7579YL	Threading feed gear
11	1	3009YL	Bevel gear (Rear)
12	4	1491V	Dowels
13	1	7580YL	Threading return gear
14	1	1174V	Intermittent shaft washer
15	1	8182YL	Shaft spacer (Rear)
16	1	3100175	Main frame
17	1	YL439-1	Return rack bracket
18	1	1425YL	Return rack
19	3	1832GB	1/2" x 2" cap screws
20	2	1101V	3/8" standard dowels
21	1	1424YL	Tool slide return gear
22	1	1423YL	Tool slide feed gear
23	4	1129V	Feed gear dowel pins
24	2	2105GB	1/2" x 2-1/2" cap screws
25	2	2791YG	Feed gear rollers
26	1	1094YL	Feed gear roller pin
27	1	YL274-X	Roller bracket
28	1	2332YG	Feed rack roller
29	1	292 YA	Feed rack roller pin
30	1	2859YG	Return gear roller
31	1	294 YA	Return gear roller pin
32	1	7645YL	Feed rack
33	1	YL290-1X	Tool slide
34	4	1529YG	Feed rack lock screws
35	1	YL 285	Oil case
36	18	2225GB	3/4" x 5/8" oil plugs
37	1	9294YL	Steel way - R. H. - 1.231
38	1	9295YL	Steel way - L. H. 1.231
39	1	YA270-1	Tool slide taper gib
40	2	2304YG	Lock screws
41	1	8349YA	Key - Frame

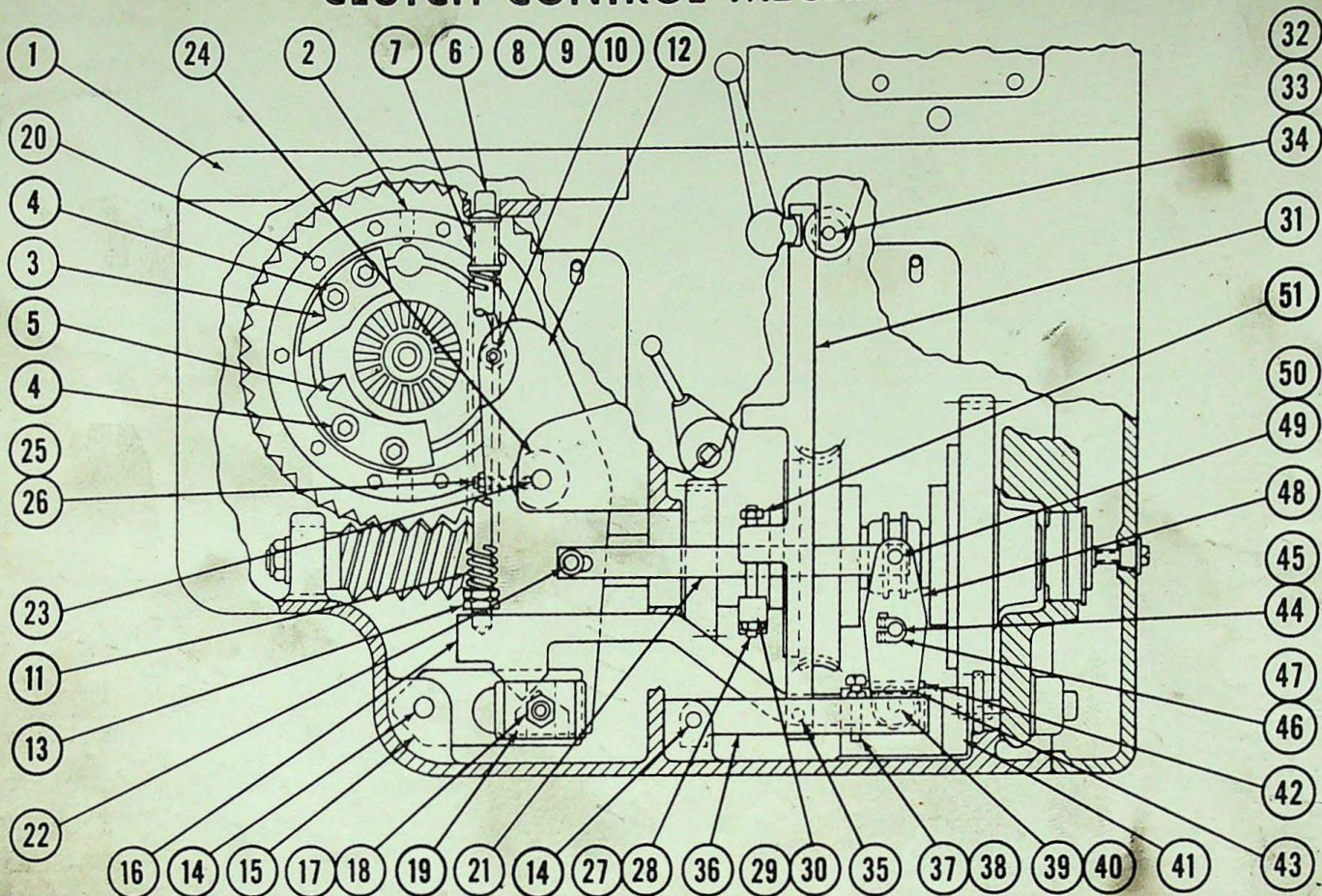
Order By
This Number



Key No.	Qty.	Part Number	Name of Part
42	1	YL693	Front gib
43	1	YL693-X	Rear gib
44	2	2123YL	Dowel pins
45	1	2572YL	Stock stop rod
46	1	1377YL	Stock stop
47	1	973YL	Stop rod key
48	1	11030YL	Stop stop adjusting nut
49	1	1581YA	Stock stop adjusting sleeve
50	1	8807YL	Stock stop rod spring
51	1	9070YL	Stock stop rod pin
52	1	1446YL	Stock stop rod plug
53	1	9071YL	Rod pin retainer plug
54	1	YL692-2X	Rear chip guard
55	2	3002YL	Plungers
56	2	2519YA	Plunger springs
57	1	1729YA	Gib adjusting screw
58	1	98 YG	Packing gland
59	1	161 YL	Sliding oil pipe
60	1	4255YL	Threading reset cam
61	2	1831GB	1/2" x 1-3/4" cap screws
62	1	1944GB	3/8" x 1-1/4" set screw
63	1	2323GB	3/8" jam nut
64	1	5044YL	Scale
65	1	8045YL	Front chip guard
66	1	8044YL	Front guard shield
67	1	8043YL	Chip guard trunnion
68	1	YL1355	Front guard block
69	1	YL1356	Rear guard block
70	1	11366YL	Spindle drive shaft
71	1	2680YL	Worm gear spider cover
72	1	YL338-1	Worm gear case cover
73	1	7478YL	Splash guard
74	1	3100404	Threading mechanism housing
75	1	8204YL	Tool slide steady bearing
76	2	YL1227	Steady bearing gibs
77	1	8392YL	Steady bearing taper gibs
78	1	214YM	Adjusting gib stud
79	1	YL1226	Overarm
80	1	YL1231	Oil shield (Front)
81	1	YL1232	Oil shield (Rear)

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

CLUTCH CONTROL MECHANISM



Order By
This Number

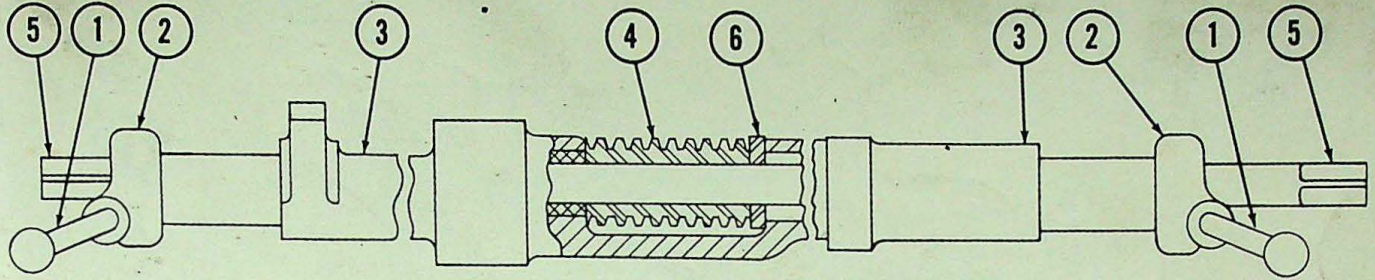
Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	YL338-1	Worm gear case cover
2	2	3006YL	Keys
3	1	762YM	Speed trip dog
4	4	2418YG	"T" bolts
5	1	1226YM	Feed trip dog
6	1	439YA	Control lever spring rod
7	1	440YA	Spring rod collar
8	1	1420YL	Clutch con. roller shaft
9	1	95YM	Clutch control dog roller
10	1	543YM	Roller shaft washer
11	1	1615YL	Control lever spring
12	1	YL346	Clutch control lever
13	2	2327GB	3/4" jam nuts
14	2	4256YL	Pivot pins
15	1	1430YL	Control lever stop plate
16	1	YM212-1	Clutch control plunger
17	1	1422YL	Trip lever fulcrum stud
18	1	2336GB	3/4" Castellated nut
19	1	YL342B	Trip lever fulcrum
20	10	1810GB	3/8" x 1-1/2" cap screws
21	1	1429YL	Safety link
22	1	787V	Pin
23	1	1419YL	Clutch lever shaft
24	1	1421YL	Lever shaft spacer
25	1	1961GB	1/2" x 3" set screw
26	1	2325GB	1/2" jam nut

Key No.	Qty.	Part Number	Name of Part
27	1	1514YA	Stud
28	1	2338GB	1/2" Castellated nut
29	1	3154YL	Brake arm
30	1	2358YL	Brake arm shaft
31	1	4124YL	Clutch control bar
32	1	1461YL	Clutch oper. rack roller
33	1	764V	Roller pin
34	1	YL1130	Plug
35	1	728V	Pin
36	1	1867YL	Clutch operating bar
37	1	1948GB	3/8" x 2-1/4" set screw
38	1	2323GB	3/8" jam nut
39	1	1523YL	Shifting lever roller pin
40	1	1462YL	Shifting lever roller
41	1	3001YL	Bumper
42	1	1736YL	Plunger
43	1	2027YL	Pin retainer
44	1	1467YL	Shifting lever shaft
45	1	YL384	Plug
46	1	1047YM	Split collar
47	1	2216GB	1/2" x 1-1/2" cap screw
48	1	YL343	Clutch shifting lever
49	1	YL682	Shifter shoe (front)
50	1	YL681	Shifter shoe (rear)
51	2	2325GB	1/2" jam nuts

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

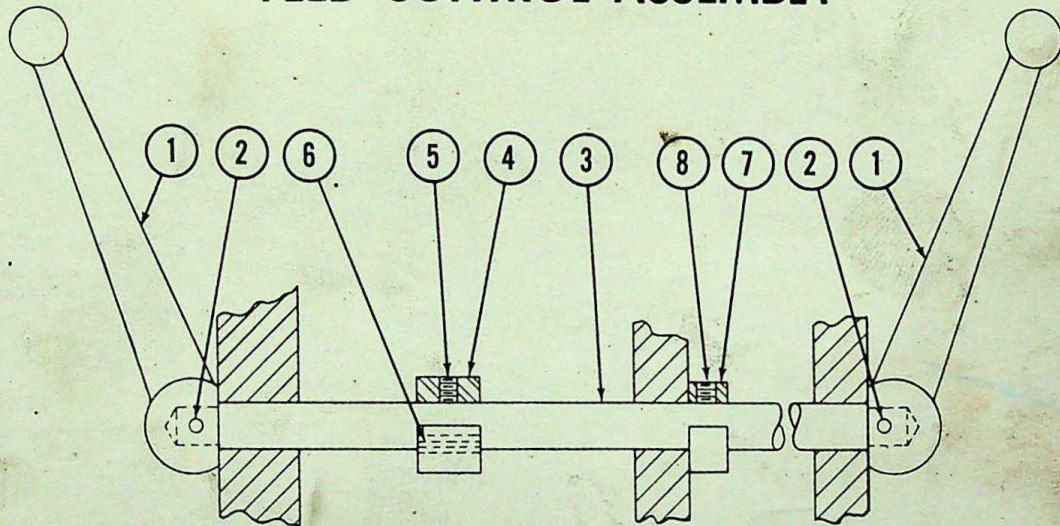
HAND FEED SLEEVE ASSEMBLY



Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	2	2089YM	Hand feed sleeve handles
2	2	YM283	Hand feed sleeve hubs
3	1	YL310-1	Hand feed sleeve
4	1	1415YL	Hand feed worm
5	1	1478YL	Hand feed worm shaft
6	1	1261 V	Washer

FEED CONTROL ASSEMBLY

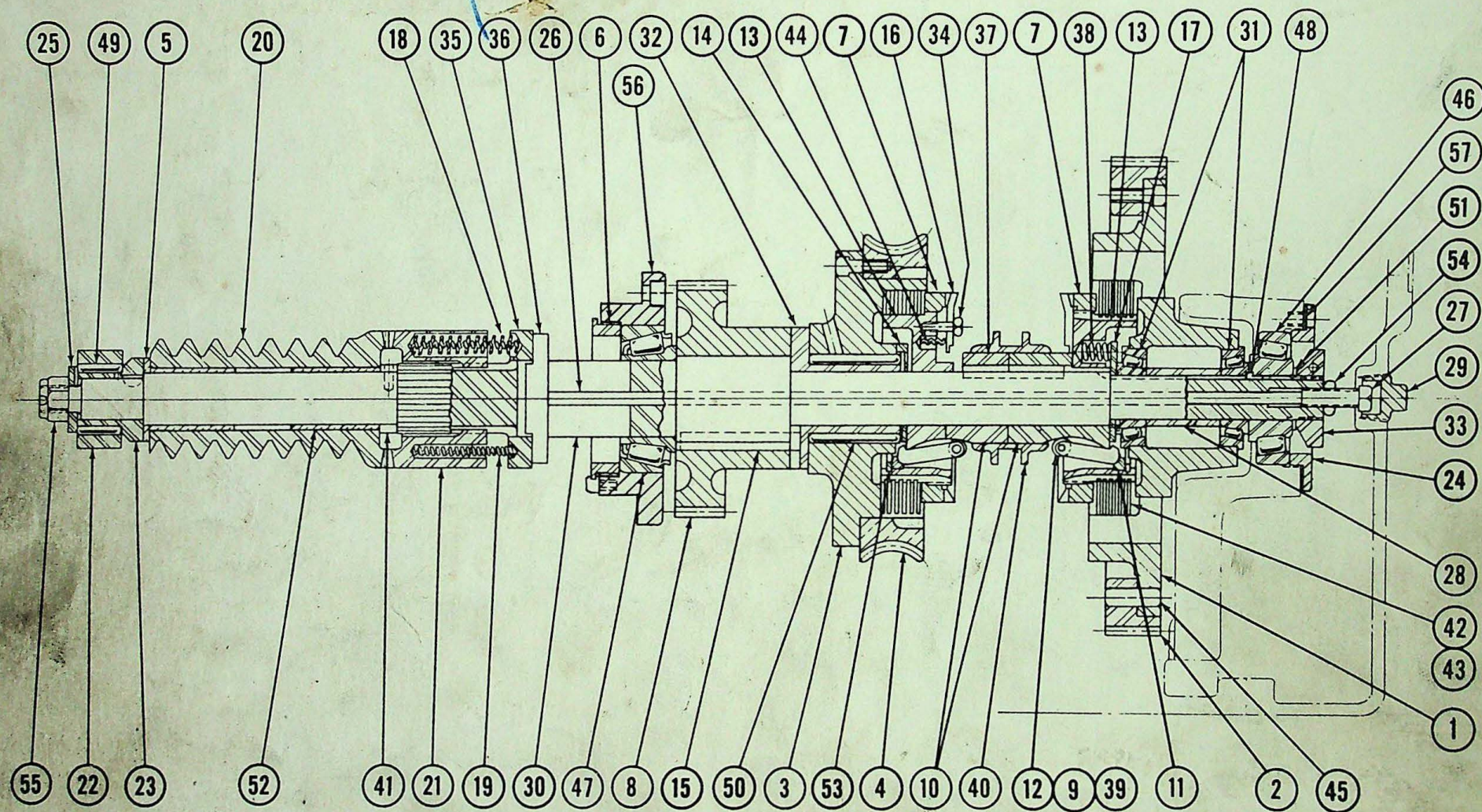


Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	2	887YA	Operating handles
2	2	2401GB	#4 x 1-1/2" taper pins
3	1	4971YL	Operating shaft
4	1	2505YA	Clutch operating cam
5	1	2164GB	1/4" x 1/2" set screw
6	1		Key (std. keystock)
7	1	1196GB	Operating shaft collar
8	1	2169GB	3/8" x 1/2" set screw

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

MAIN CLUTCH ASSEMBLY



MAIN CLUTCH ASSEMBLY PARTS LIST

Order By
This Number
↓

Key No.	Qty.	Part Number	Name of Part
1	1	YA866-2	Hi-speed gear spider
2	1	9208YA	Hi-speed gear
3	1	YL313X	Worm wheel spider
4	1	YM74	Feed worm wheel
5	1	YA1121	Dr. worm bush.
6	1	YM162X	Brg. adj. nut
7	2	YM163X	Clutch thrust nuts
8	1	YM332	Hand feed gear
9	4	2559YA	Clutch lever rollers
10	2	2633YA	Clutch oper. sleeves
11	2	2635YA	Pivot rings
12	4	2638YA	Clutch oper. levers
13	2	2639YA	Clutch drivers
14	1	2651YA	Spider brg. washer
15	1	1202GB	Key - Hand feed gear
16	2	7348YA	Clutch dr. nut keys
17	1	7640YA	Spr. thrust washer
18	8	1616YL	Safety clutch springs
19	12	2016YL	Safety clutch springs
20	1	2338YL	Dr. worm
21	1	2339YL	Safety clutch
22	1	5107YL	Outer race
23	1	9303YL	Inner race
24	1	YL2007	Brg. adj. nut
25	1	5110YL	Main clutch shaft washer
26	1	7867YL	Clutch adj. rod
27	1	7868YL	Clutch adj. scr.
28	1	7869YL	Brg. spacer

Order By
This Number
↓

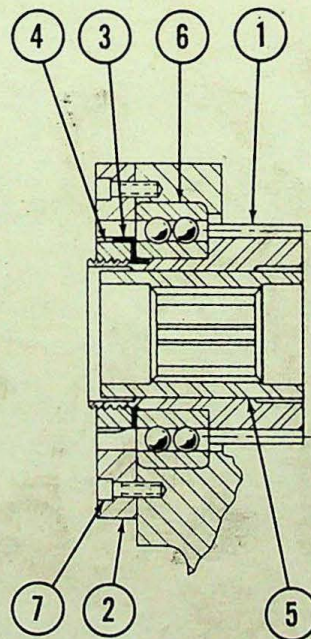
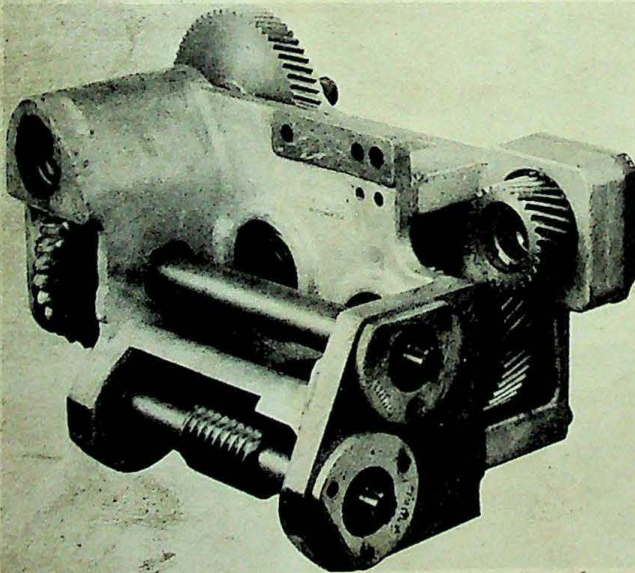
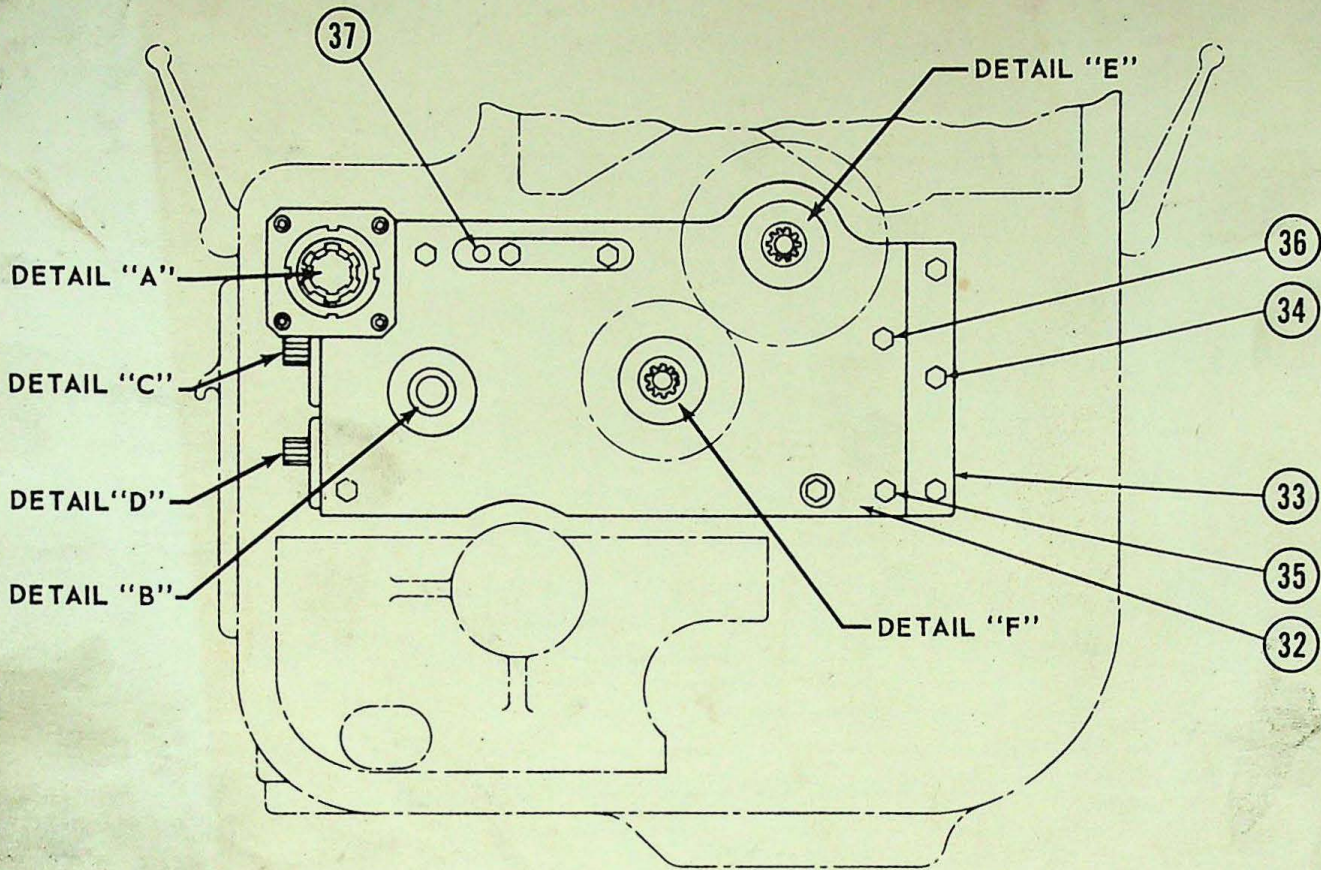
Key No.	Qty.	Part Number	Name of Part
29	1	7870YL	Pipe plug
30	1	7871YL	Main clutch shaft
31	2	311GB	Clutch shaft brgs.
32	1	89YM	Spider brg. bush.
33	1	544YM	Main clutch shaft nut
34	2	1231YM	Cap screws
35	1	127YG	Spring plate
36	1	129YG	Clutch adj. plate
37	2	1201GB	Clutch sleeve keys
38	4	2496YG	Clutch drive springs
39	4	2559YG	Roller pins
40	1	2560YG	Clutch oper. sleeve
41	1	2825YG	Spacing washer
42	14	2912YG-V	Clutch discs (outer)
43	14	2913YG	Clutch discs (inner)
44	2	724-2	Springs for 7348 YA
45	1	1109V	Std. dowel
46	1	3245GB	Timken # 2 (443-W - 432)
47	1	166GB	Timken # 2 (532-A - 539)
48	1	9040YL	Key
49	1	400GB	1-1/2" x 1-1/4" bearing
50	1	413GB	1-7/8" x 2-1/2" bearing
51	1	1737GB	W-06 SKF lockwasher
52	1	2776GB	F-1276 bushing
53	2	805GB	50-400 Walde snap rings
54	1	2325GB	1/2" hardened jam nut
55	1	2341GB	3/4" castellated nut
56	1	YL2018	Bearing sleeve
57	6	3298GB	Timken shims #K-21505

14125W

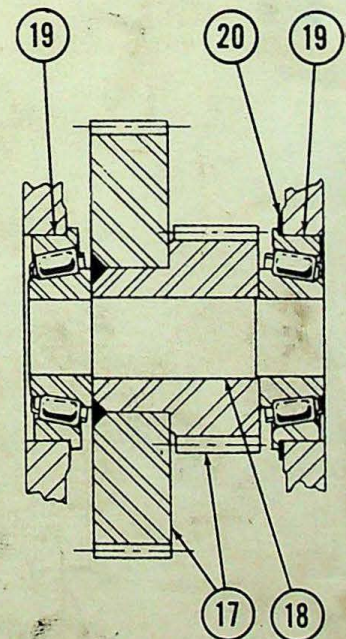
5

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

PICK-OFF UNIT



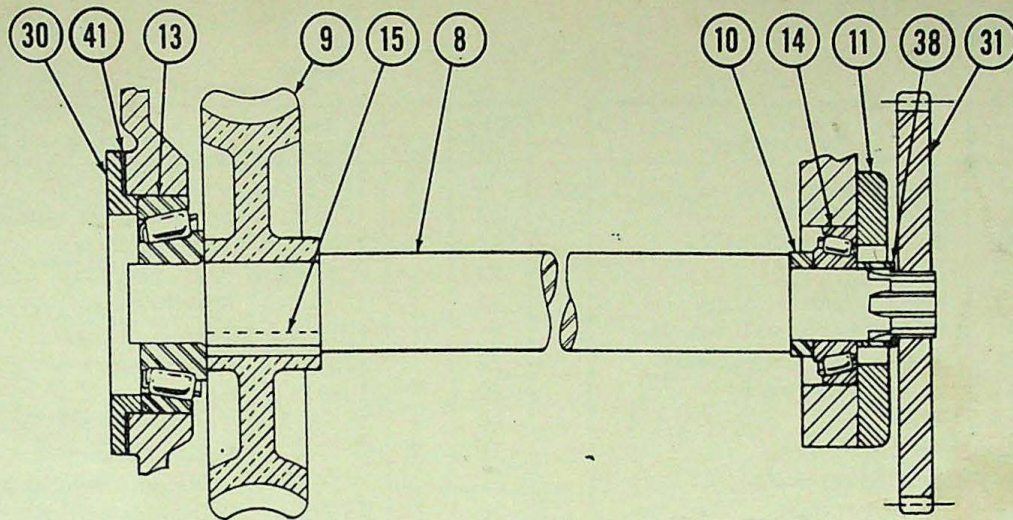
DETAIL "A"



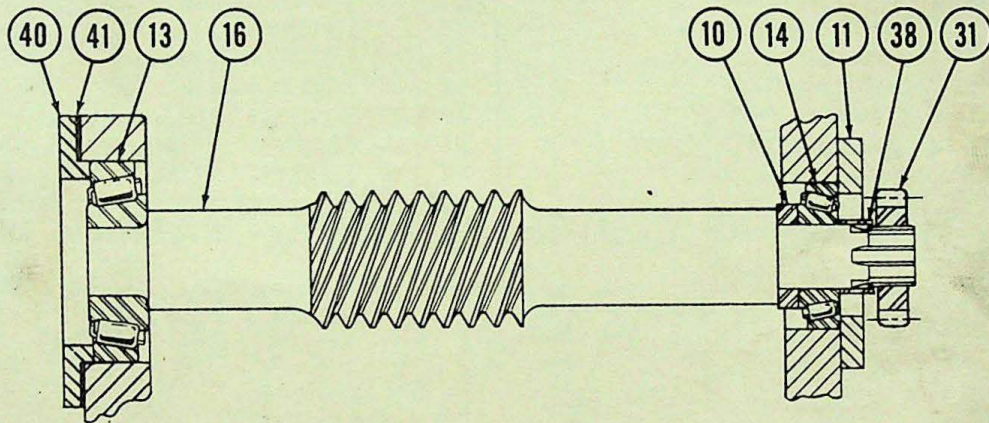
DETAIL "B"

PARTS LIST ON PAGE 26

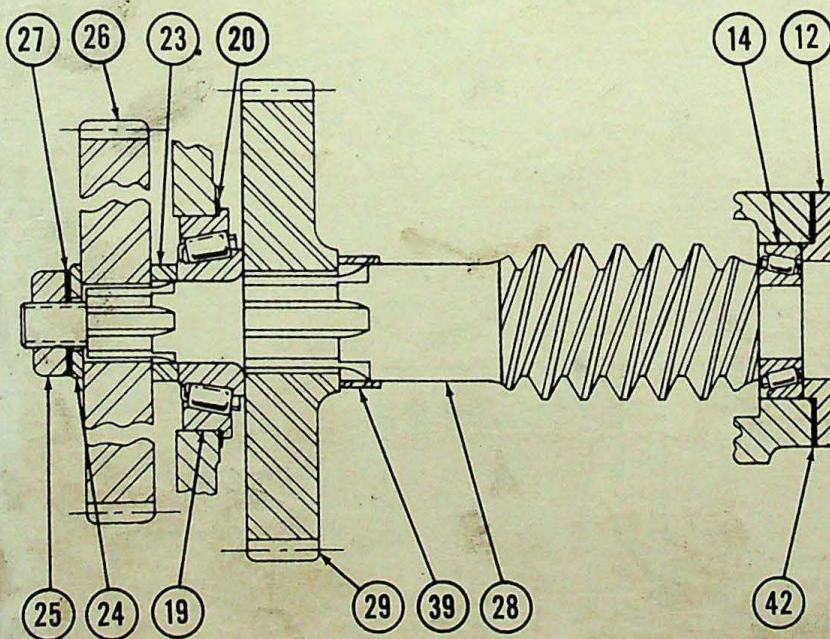
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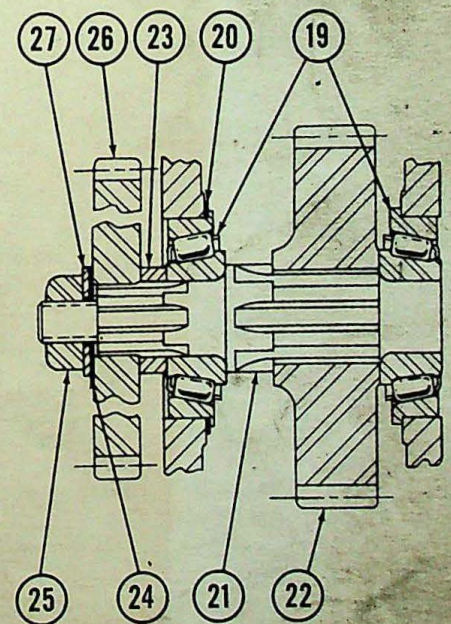
DETAIL "C"



DETAIL "D"



DETAIL "E"



DETAIL "F"

PARTS LIST ON FOLLOWING PAGE

PICK-OFF UNIT PARTS LIST

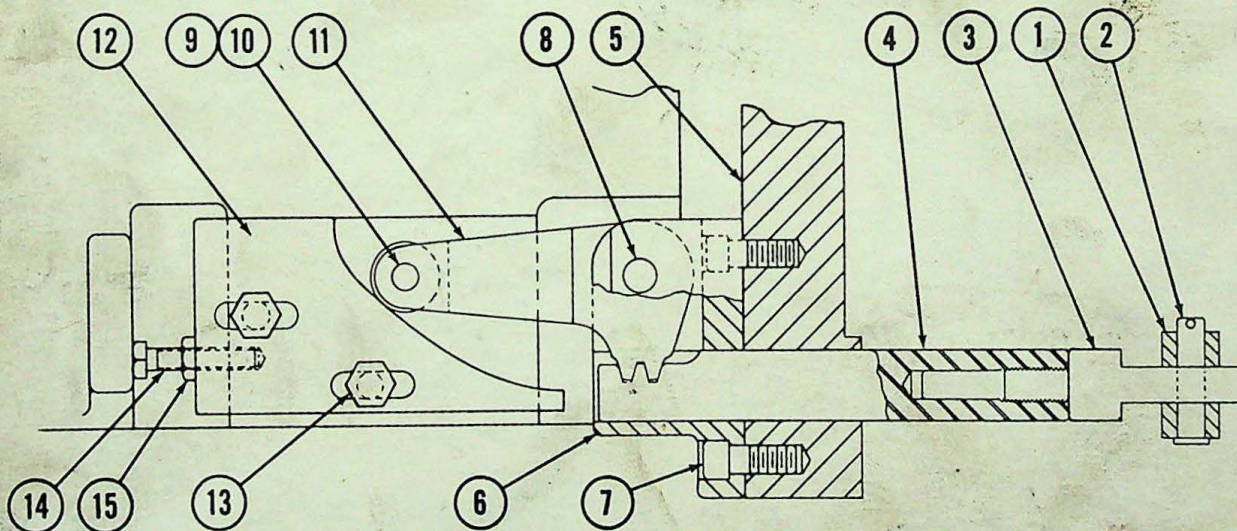
Order By
This Number

Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	9205YA	Motor pinion gear
2	1	YL328	Bearing retainer
3	1	1745GB	W-14 SKF lockwasher
4	1	554V	Locknut
5	1	9203YA	Motor pinion coupling
6	1	23GB	SKF # 5214-R ball bearing
7	4	2075GB	3/8" x 3/4" cap screws
8	1	10949YL	Feed change shaft
9	1	YL79	Worm gear
10	2	1668YL	Shaft spacers
11	2	YM178	Bearing retainers
12	1	YL2011	Bearing retainer
13	2	150GB	Timken # 2 (449-432)
14	3	308GB	Timken # 2 (14117A - 14283)
15	1	Keystock	3/8" x 3/8" key
16	1	10950YL	Feed change worm shaft
17	1	10947YL	Back gear
18	1	7545YL	Back gear shaft
19	5	151GB	Timken # 2 (449-432B)
20	to suit	1264YA	Bearing shims
21	1	9202YA	Speed change shaft

Key No.	Qty.	Part Number	Name of Part
22	1	10948YL	Gear
23	1	1720YL	Speed change washer
24	2	1150V	3/4" washers
25	2	2341GB	3/4" hex. nuts
26	1		Speed change gear (order as reqd)
27	2	1729GB	3/4" lockwasher
28	1	9204YA	Speed change worm shaft
29	1	11361YL	Gear
30	1	YL2012	Bearing retainer
31	2		Feed change gear (order as reqd)
32	1	YL294B	Drive unit front plate
33	1	YL295-3	Drive unit rear plate
34	6	1849GB	5/8" x 2" cap screws
35	3	1861GB	5/8" x 5" cap screws
36	2	2132GB	5/8" x 4-3/4" cap screws
37	2	1130V	Dowels
38	2	9206YA	Spacers
39	1	9207YA	Spacer
40	1	YL2013	Bearing retainer
41	12	3298GB	Timken shims #K-21505 (6/set)
42	6	3292GB	Timken shims #K-21205

THREADING CLUTCH RE-SET MECHANISM



Order By
This Number

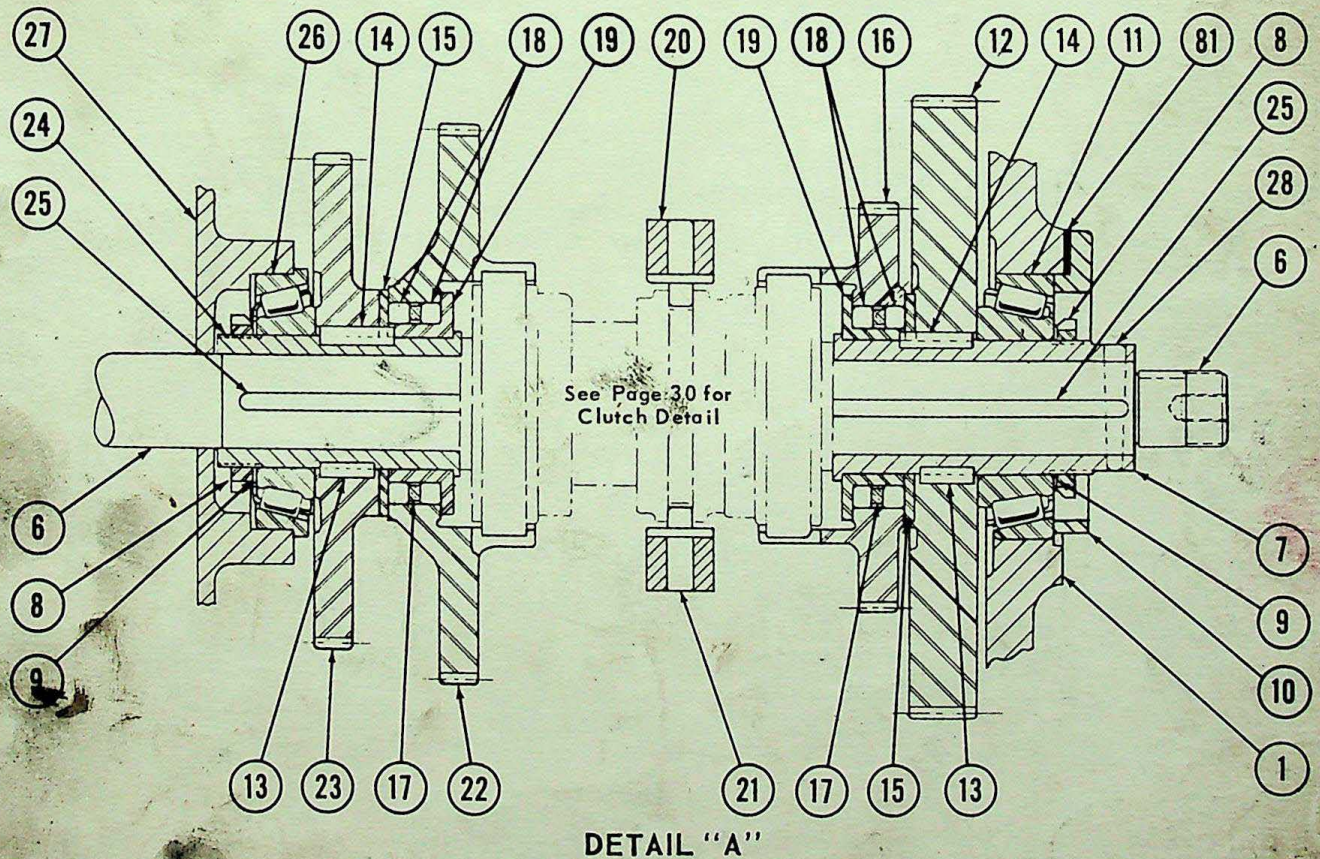
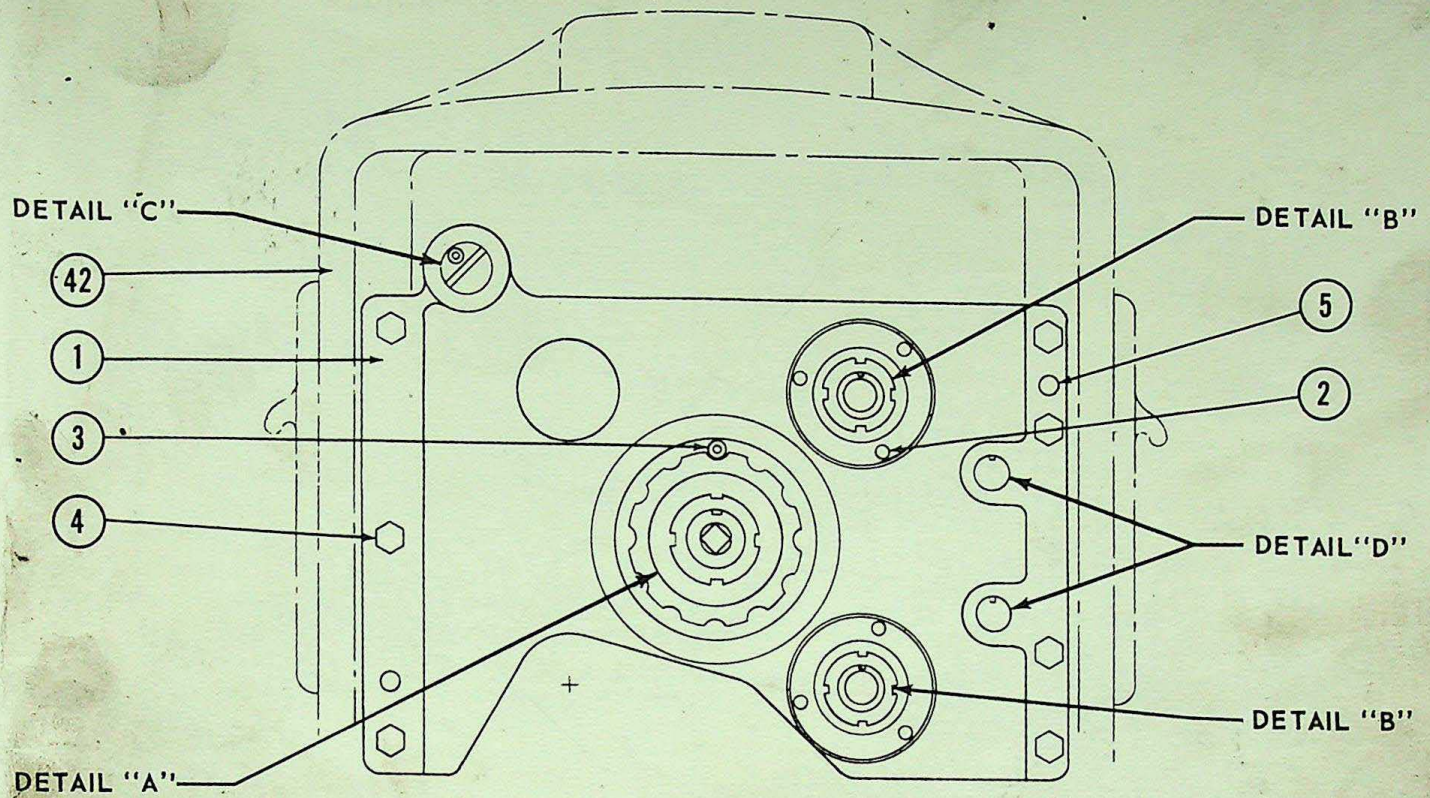
Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	YL685-2	Shifter fork
2	1	729V	Reset shaft pin
3	1	4414YA	Reset shaft head
4	1	5385YL	Reset shaft
5	1	YL683	Gear box threading cover
6	1	YL744	Reset lever bracket
7	2	2099GB	1/2" x 1" cap screws
8	1	1046V	Reset lever pin

Key No.	Qty.	Part Number	Name of Part
9	1	4146YL	Reset lever roller
10	1	1022V	Reset lever roller pin
11	1	YL689	Reset lever
12	1	4255YL	Threading reset cam
13	2	1831GB	1/2" x 1-3/4" cap screws
14	1	1944GB	3/8" x 1-1/4" set screw
15	1	2323GB	3/8" jam nut

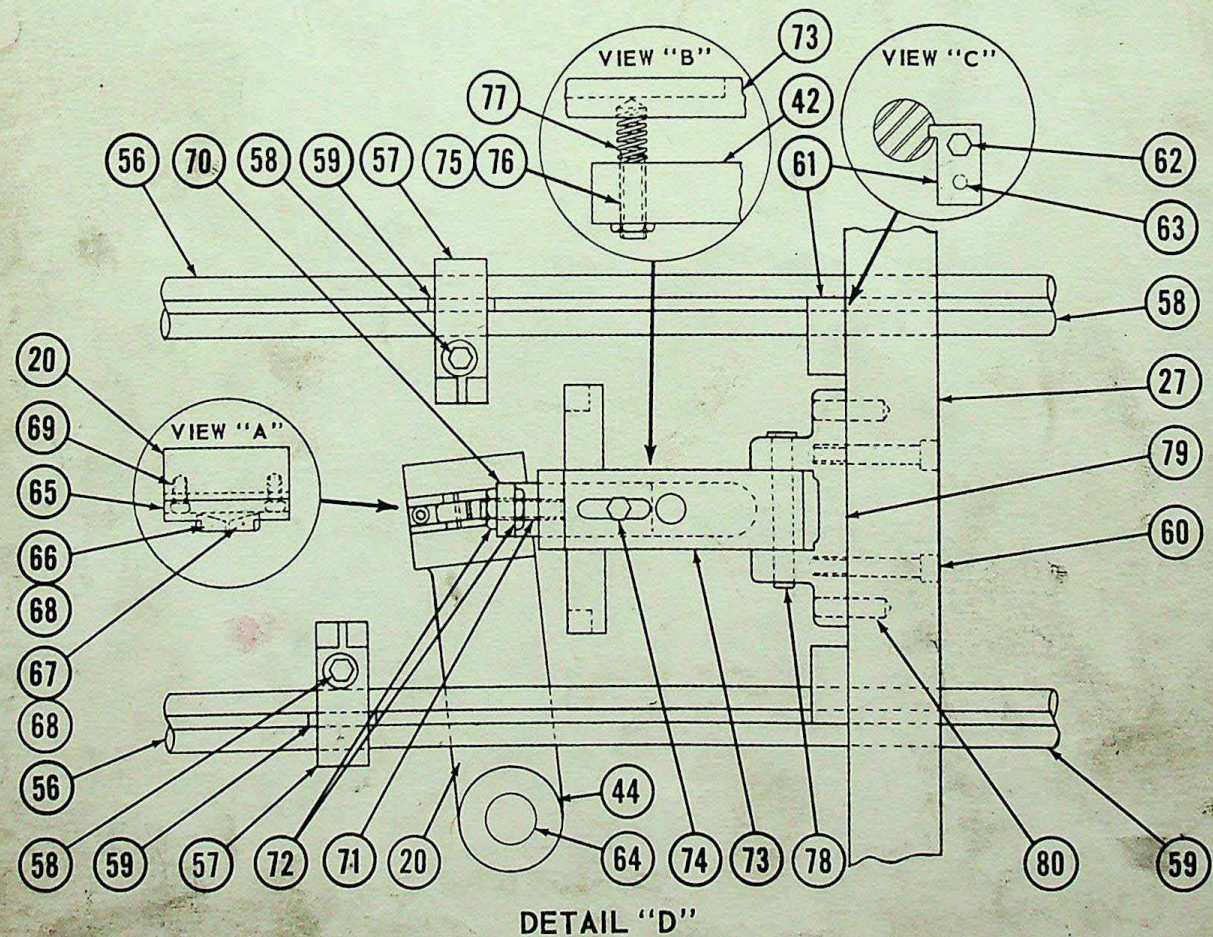
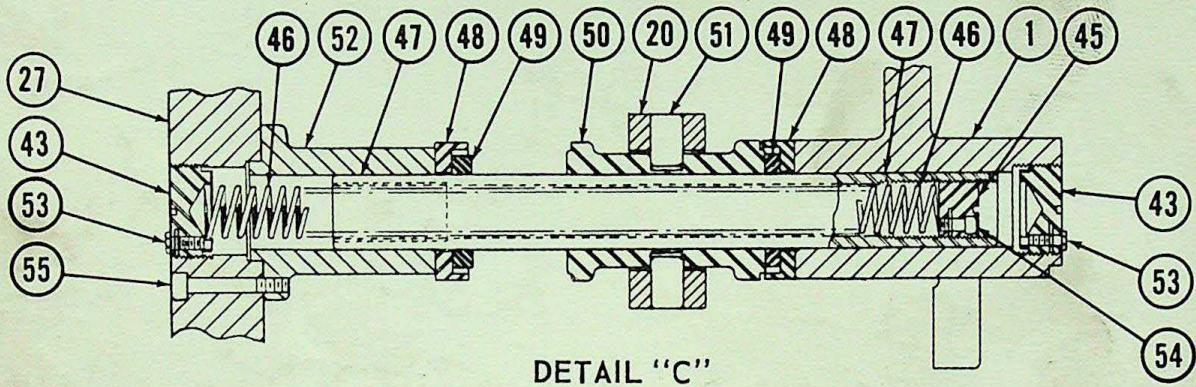
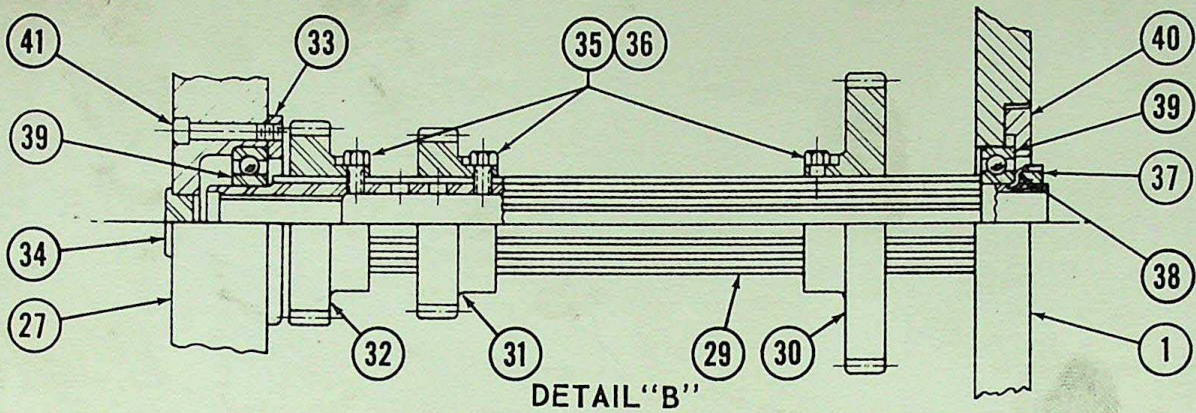
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

THREADING DRIVE UNIT



PARTS LIST ON PAGE 29

THREADING DRIVE UNIT (Cont'd)



ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

THREADING DRIVE UNIT PARTS LIST

Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	YL2021	Front bearing plate
2	6	1799GB	5/16" x 1" cap screws
3	1	2074GB	3/8" x 5/8" cap screw
4	7	1849GB	5/8" x 2" cap screws
5	2	1137V	3/4" x 5/8" dowel pins
6	1	11366YL	Spindle drive shaft
7	1	10096YL	Spindle drive sleeve (R. H.)
8	2	2437YL	Spindle drive sleeve nuts
9	2	1744GB	W-13 SKF lockwashers
10	1	YL2020	Bearing retainer
11	1	176GB	Timken #2 (563-565) bearing
12	1	11364YL	Spindle drive gear
13	1	(Keystock)	3/8" x 1-5/16" key
14	1	(Keystock)	3/8" x 1-3/8" key
15	2	2444YL	Drive gear spacers
16	1	11365YL	Threading drive gear (R.H.)
17	2	YL479	Roller bearing cages
18	48	248GB	3/8" x 3/8" rollers
19	2	3199YL	Bearing inner races
20	1	YL685-2	Shifter fork
21	2	YL680	Clutch shifting pins
22	1	11367YL	Threading drive gear (L. H.)
23	1	11363YL	Hi-Speed drive gear
24	1	10095YL	Spindle drive sleeve (L. H.)
25	1	2956YL	Spindle drive shaft key
26	1	159GB	Timken #2 (472B-483) bearings
27	1	YL683	Gear box threading cover
28	1	2416GB	Taper pin
29	2	YL1879	Spindle spline sleeves
30	2	11370YL	Threading spindle gears (R.H.)
31	2	11369YL	Threading spindle gears (L.H.)
32	1	11368YL	Hi-Speed spindle gear (None required in 4th position)
33	4	YL567	Bearing retainers
34	4	3791GB	Threading cover inserts
35	5	2924YA	Lock screws
36	5	1723GB	Lock washers
37	2	550V	N-10 locknuts
38	2	1741GB	W-10 lockwashers
39	4	55GB	SKF #6210 bearings 1210
40	2	YL1880	Bearing retainers

Order By
This Number

Key No.	Qty.	Part Number	Name of Part
41	8	2065GB	5/16" x 1-3/4" cap screws
42	1	YL558-3	Gear box
43	2	1286YA	Bearing plate spring plugs
44	2	8642YA	Shifter fork washers
45	1	1390YL	Control sleeve plug
46	1	1625YL	Control sleeve spring
47	1	2914YA	Shifter fork control sleeve
48	2	2909YA	Control sleeve washers
49	2	4322YL	Rubber washers
50	1	2910YA	Operative sleeve
51	2	457YA	Operating fork pins
52	1	YA437X11	Control sleeve bearing
53	2	2049GB	1/4" x 5/8" cap screws
54	1	1885GB	1/4" x 1/2" cap screw
55	3	2066GB	5/16" x 2" cap screws
56	2	4136YL	Clutch control rods
57	2	4142YL	Split trip collars
58	2	2078GB	3/8" x 1-1/2" cap screws
59	2	2285YA	Trip collar keys
60	2	2066GB	5/16" x 2" cap screws
61	2	YL688	Control rod keys
62	2	1800GB	5/16" x 1-1/4" cap screws
63	2	(Drill rod)	5/16" x 1-1/8" dowel pins
64	2	3131YL	Shifter fork shafts
65	1	5291YL	Trip block
66	1	5293YL	Trip block insert (Left)
67	1	5292YL	Trip block insert (Right)
68	2	261GB	1/8" x 41/64" McGill rolls
69	2	2060GB	5/16" x 5/8" cap screws
70	1	7218YL	Trip lever insert
71	1	4141YL	Trip plate adjusting stud
72	2	2322GB	5/16" jam nuts
73	1	7222YL	Trip lever and extensions
74	1	1806GB	3/8" x 3/4" cap screw
75	1	2013GB	3/8" x 1-1/2" set screw
76	1	2323GB	3/8" jam nut
77	1	148ER	Trip lever spring
78	1	706V	Trip lever pin
79	1	YL686	Trip lever bracket
80	2	1099V	3/8" x 1" dowel pins
81	6	626GB	Timken shims #K-22005

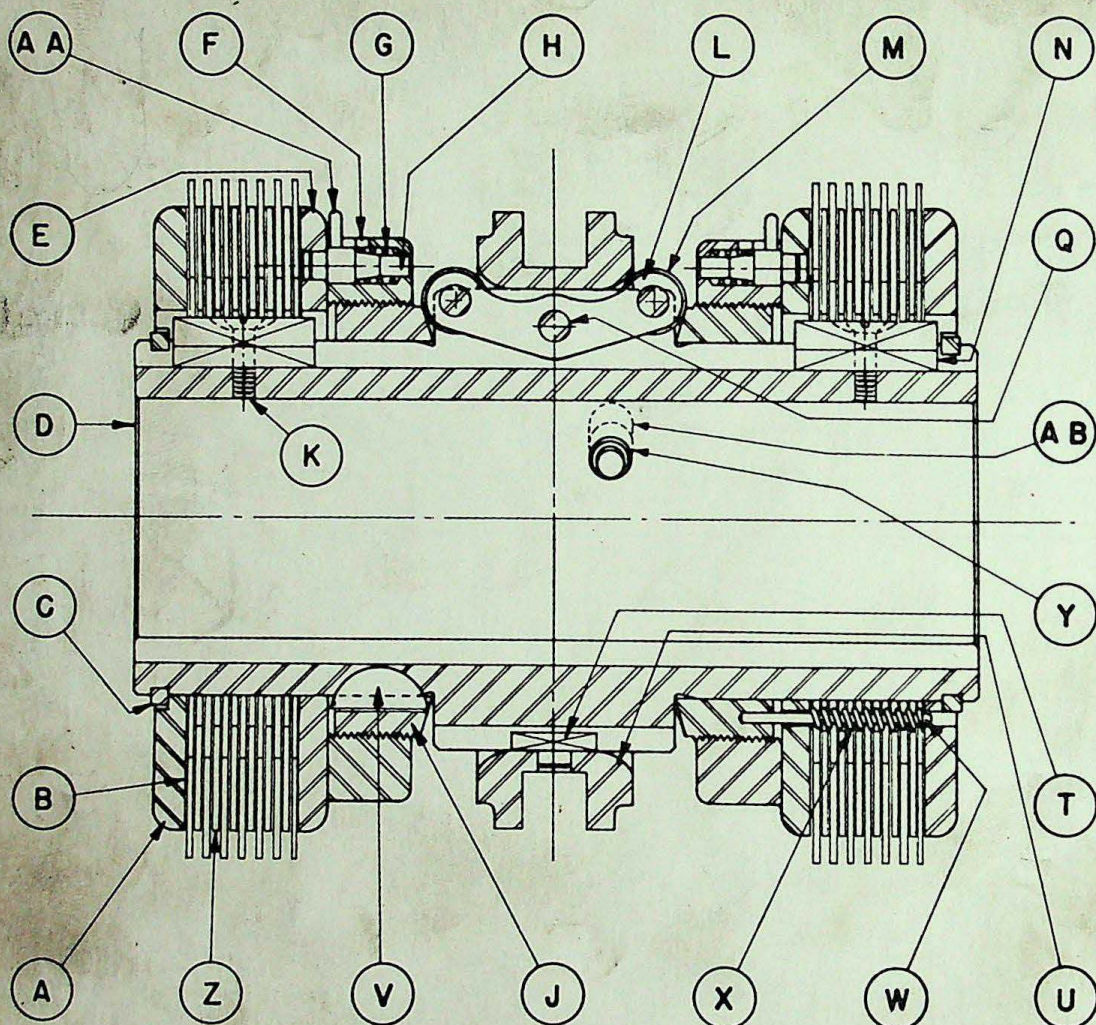
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

THREADING DRIVE CLUTCH

XA3810 MODEL MTU7045 TWIN DISC CLUTCH

SPECIFICATION NO. 18101

No. 2798GB

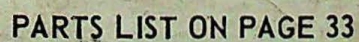


SYMBOL NO.	PART NO.	NO. REQD.	DESCRIPTION
"D"	A 5756	1	Hub Bore 1.750 - 1.749 Keyway 5/16 x 5/32
"V"	M 275	2	Woodruff Keys (#91) 1/4 x 3/4
"Y"	M 514	1	Half Dog Pt. Set Screw (3/8 - 16 NC x 1/2)
"AB"	M 783	1	Cup Pt. Set Screw (3/8 - 16 NC x 1/4)
"U"	A 3672	1	Engaging Cone
"T"	A 1959	1	Cone Key
	A 1960	1	Instruction Plate
	M 422	4	Drive Screws
	X - 194	1	Miscellaneous Clutch Parts
"N"	A 2519	6	Drive Keys
"L"	A 2434	6	Levers
"K"	M 1043	6	Flat Hd. Machine Screws (8 - 32 NC x 7/16)
"F"	A 2084 A	2	Adjusting Rings
"H"	2466 A	2	Adjusting Lock Pins
"G"	2469	2	Adjusting Lock Pin Springs
"AA"	2467	2	Pins
"A"	A 2076	2	Back Plates
"B"	3764	14	Driving Plates
"Z"	A 2078 A	12	Driven Plates
"X"	A 1802	6	Release Springs
"E"	A 2079 A	2	Lock Plates
"W"	A 2679 B	6	Release Spring Pins
"C"	A 2085	2	Snap Rings
"J"	A 2080	2	Roller Rings
"Q"	A 2594 C	3	Lever Pins
"M"	A 2506	6	Rollers

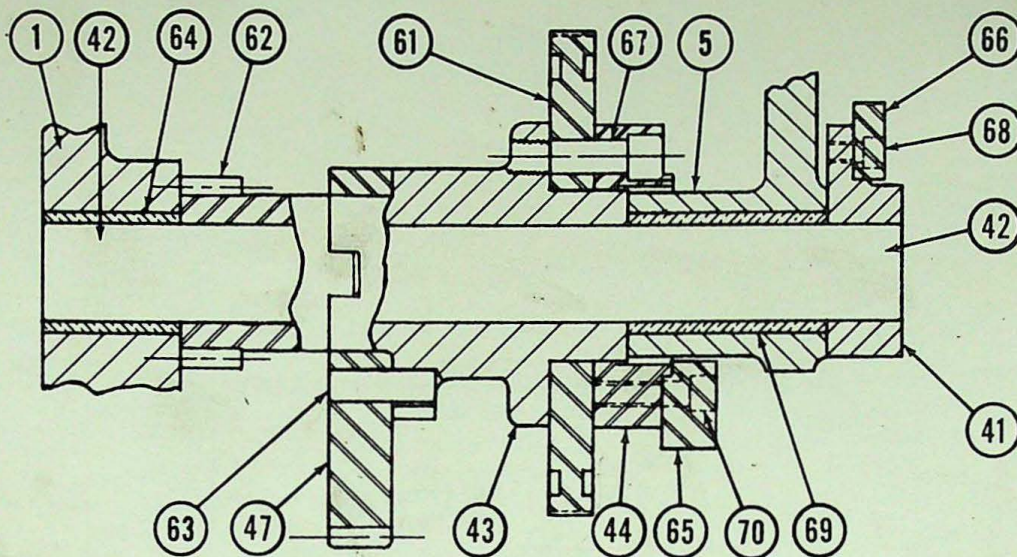
WHEN ORDERING CLUTCH PARTS ALWAYS INCLUDE THE SPECIFICATION NUMBER

Drawing and Parts List Reproduced by Permission of Twin Disc Clutch Company, Racine, Wisconsin

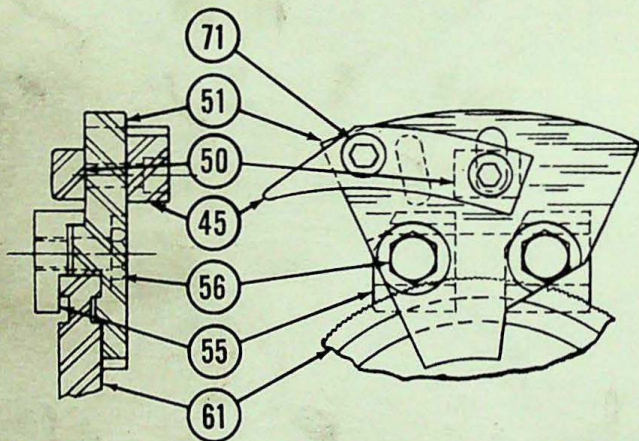
2-5/8" - 4



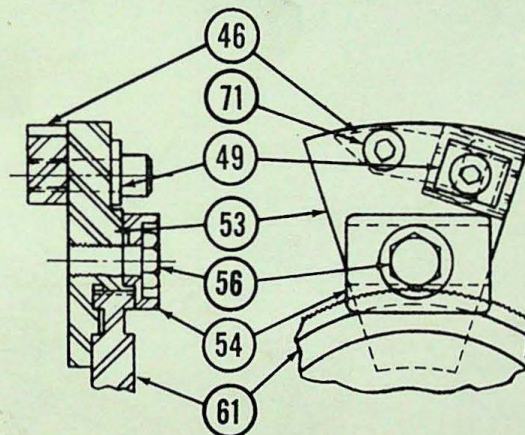
THREADING FEED ASSEMBLY (Cont'd)



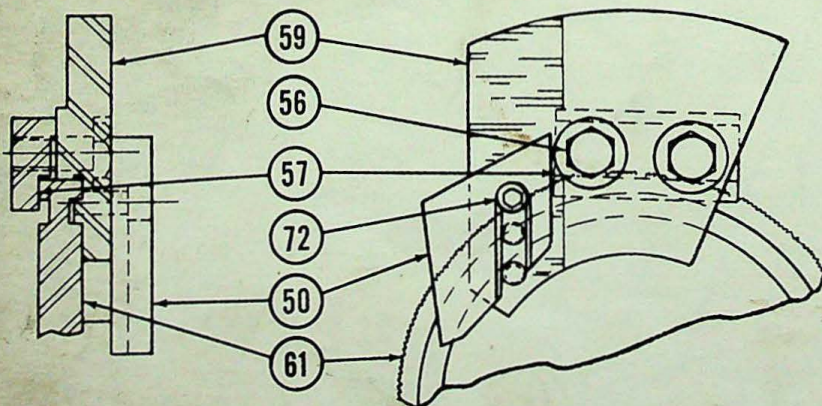
DETAIL "A"



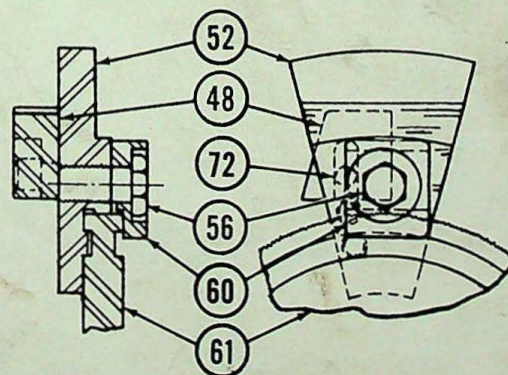
FEED CAM PLATE
3RD POS.



FEED CAM PLATE
4TH POS.



RETURN CAM PLATE
3RD POS.



RETURN CAM PLATE
4TH POS.

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

THREADING FEED ASSEMBLY PARTS LIST

Order By
This Number



Key No.	Qty.	Part Number	Name of Part
1	1	3100404	Threading mechanism housing
2	6	2075GB	3/8" x 3/4" cap screws
3	1	YL 756	Threading housing cover
4	1	6942YL	Housing cover gasket
5	1	YL320-1	Lower plate
6	1	1991GB	5/8" x 5" square head screw
7	1	2326GB	5/8" jam nut
8	1	1459YL	Lower spring
9	2	1911YL	Rollers
10	2	2922YL	Pins
11	2	8784YL	Quick approach cam levers
12	2	8785YL	Lock plates
13	2	9085YL	Clamp screws
14	2	8783YL	Quick approach lever hubs
15	2		Keys (Std. keystock)
16	1	YL450-X1	Cam roller lever (4th pos.)
17	2	2101GB	1/2" x 1-1/2" cap screws
18	1	YL 317	Hand feed sleeve bracket
19	2	2101GB	1/2" x 1-1/2" cap screws
20	1	1957GB	1/2" x 2" set screw
21	1	2325GB	1/2" jam nut
22	2	3022YL	Threading cam rollers
23	2	3021YL	Cam roller shafts
24	3	2076GB	3/8" x 1" cap screws
25	1	YL319-2	Cam roller lever (3rd pos.)
26	1	YL501-1	Upper plate
27	1	2055GB	1/2" x 2-1/2" set screw
28	1	2325GB	1/2" jam nut
29	1	1458YL	Upper spring
30	1	2101GB	1/2" x 1-1/2" cap screw
31	1	2325GB	1/2" jam nut
32	2	4136YL	Clutch control rods
33	2	1189V	Pins
34	1	YL321-1	Feed lever (3rd pos.)
35	1	YL322-1	Feed lever (4th pos.)
36	1	YL413-1	Support bracket
37	4	741 YL	T-Bolts
38	1	1281YA	Support bracket key

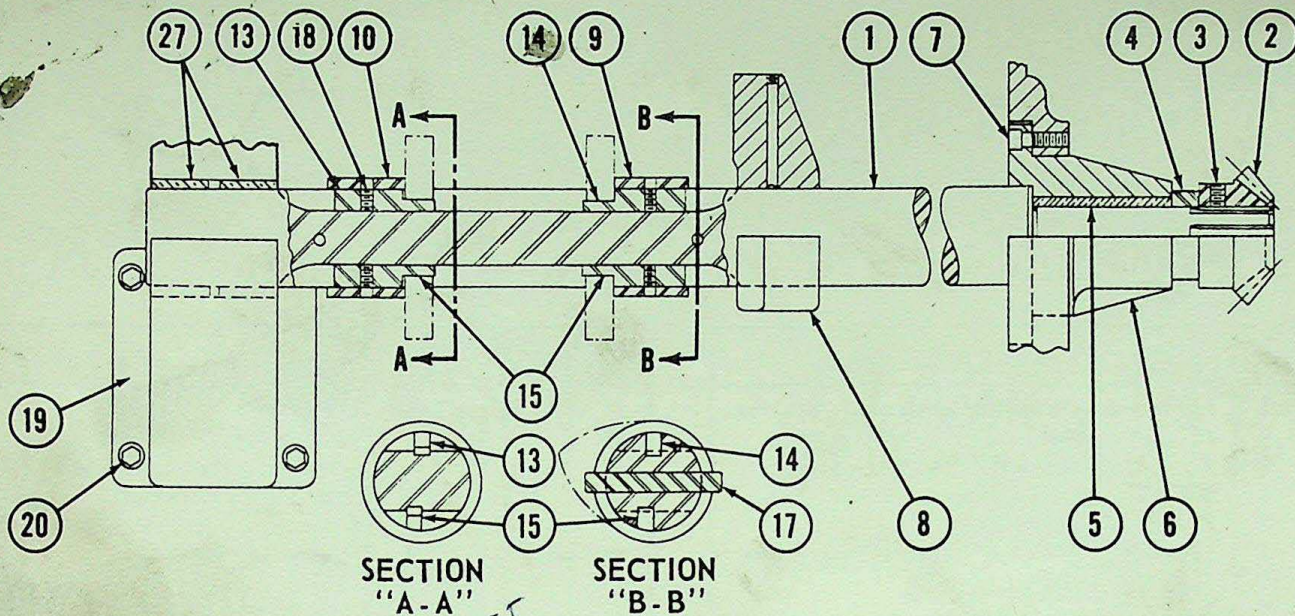
Order By
This Number



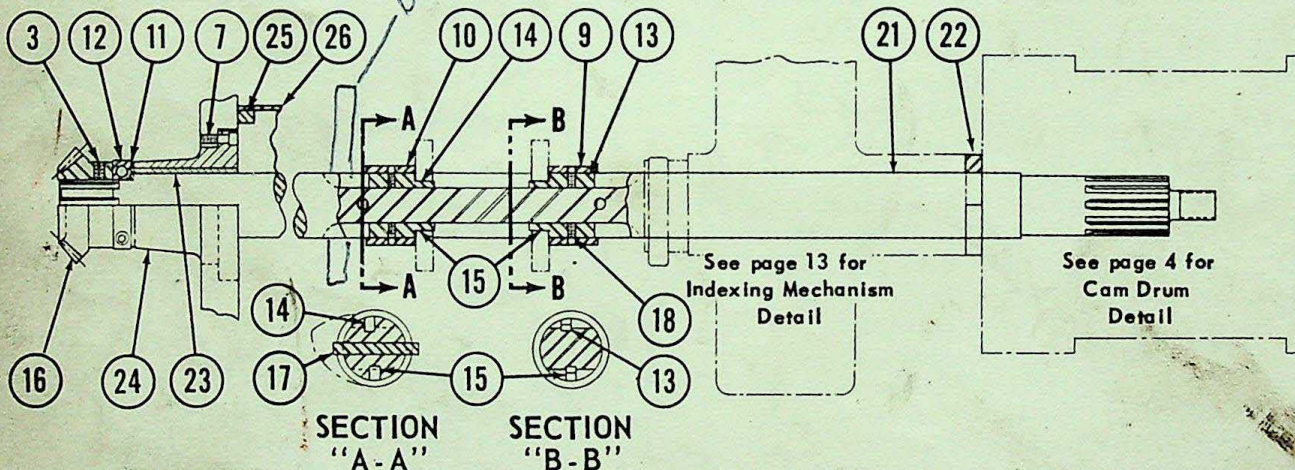
Key No.	Qty.	Part Number	Name of Part
39	2	1622YL	Oil valves
40	2	1110V	1/2" x 1-1/2" dowels
41	1	YA757-1	Quick approach cam hub
42	1	3869YA	Threading cam shaft
43	1	YL 443	Threading cam hub
44	1	1136YA	Cam mounting plate
45	1	1448YL	Cam dog
46	1	1781YL	Cam dog
47	1	1910YL	Threading return driven gear
48	1	7525YL	Return cam (4th pos.)
49	1	1944YL	Lock plate (4th pos.)
50	1	1945YL	Lock plate (3rd pos.)
51	1	2967YL	Feed cam plate (3rd pos.)
52	1	12473YL	Return cam plate (4th pos.)
53	1	12476YL	Feed cam plate (4th pos.)
54	1	2970YL	Cam clamp
55	2	12472YL	Cam clamps
56	6	12471YL	Clamp screws
57	1	12475YL	Cam clamp
58	1	3024YL	Return cam (3rd pos.)
59	1	3025YL	Return cam plate (3rd pos.)
60	1	3026YL	Cam clamp
61	1	3913YL	Cam spider
62	1	4969YL	Threading feed driven gear
63	2	1136V	1/2" dowels
64	1	YL 348	Bushing
65	1	7174YA	Quick approach cam (4th pos.)
66	1	7181YA	Quick approach cam (3rd pos.)
67	2	2101GB	1/2" x 1-1/2" cap screws
68	2	2061GB	5/16" x 3/4" cap screws
69	1	YL347X	Bushing
70	1	2105GB	1/2" x 2-1/2" cap screw
71	4	2100GB	1/2" x 1-1/4" cap screws
72	2	2073GB	3/8" x 1/2" cap screws
73	1	10049YL	Threading housing header
74	1	8224YL	Coolant cover
75	1	10500YL	Coolant cover gasket

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

FRONT CAM SHAFT



REAR CAM SHAFT



Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	7856YL	Front cam shaft
2	1	7223YL	Bevel gear
3	2	2152GB	1/2" x 1/2" set screws
4	1	1477YL	Bevel gear spacer
5	1	YM95X	Cam shaft bracket bushing
6	1	YM94X	Cam shaft bracket
7	4	2099GB	1/2" x 1" cap screws
8	1	YL521X	Cam shaft support bracket
9	2	7849YL	Cam carrier spacers
10	2	7850YL	Cam carrier spacers
11	1	7224YL	Bevel gear spacer
12	1	7232YL	Cam shaft clamp collar
13	2	3069YL	Cam carrier keys
14	2	3068YL	Cam carrier keys

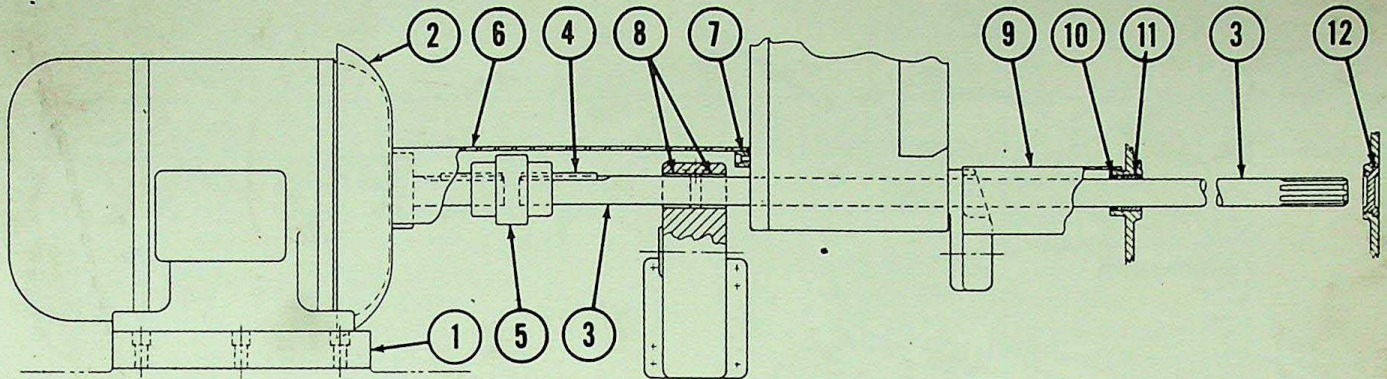
Order By
This Number

Key No.	Qty.	Part Number	Name of Part
15	4	3073YL	Cam carrier keys
16	1	7225YL	Bevel gear
17	4	3045YG	Cam driven pins
18	8	2060GB	5/16" x 5/8" cap screws
19	1	3100464	Cam shaft support bracket
20	4	2100GB	1/2" x 1-1/4" cap screws
21	1	7855YL	Rear cam shaft
22	1	3387YL	Cam drum spacer
23	1	YL 354	Cam shaft bracket bushing
24	1	YL 316	Cam shaft bracket
25	1	12462YL	Guard bracket
26	1	6249YA	Cam shaft guard
27	2	YL2030	Bushings

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

2.5/8" - 4.

MOTOR DRIVE



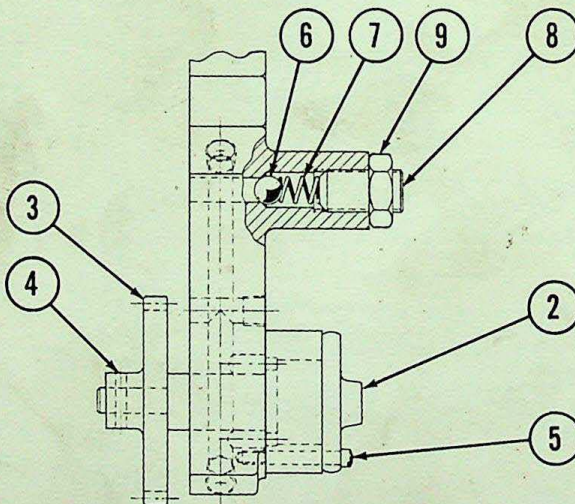
Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	YL2024	Motor bracket
2	1		Motor deflector shield (specify make and size of motor)
3	1	11032YL	Motor shaft extension
4	1	1559YL	Motor shaft key
5	1	4340GB	Lovejoy #L-190 flex. coupling
6	1	12491YL	Motor shaft guard (rear)

Order By
This Number

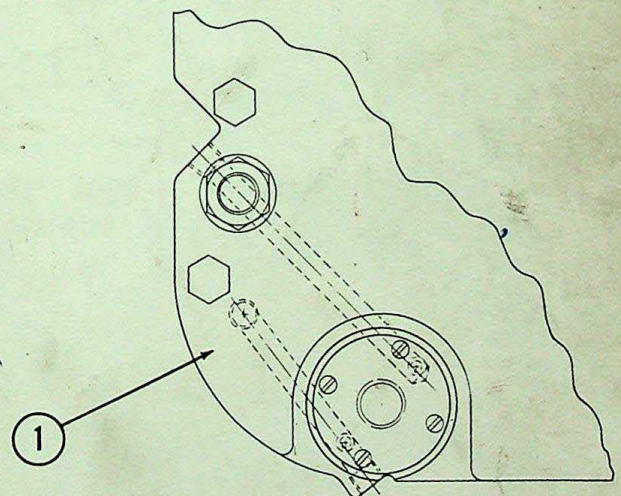
Key No.	Qty.	Part Number	Name of Part
7	1	12462YL	Guard support
8	2	3100460	Motor shaft bushings
9	1	11783YL	Motor shaft guard (front)
10	1	YL943	Motor shaft oil retainer
11	1	3331GB	A-1901 oilite bearing
12	1	YL456X	Plug

LUBRICATING PUMP



Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	3100544	Drive shaft and pump bracket
2	1	4459GB	Tuthill pump #1LF-X
3	1	3100545	Pump drive gear
4	1	3553GB	3/16" rollpin
5	4		#12-24 x 1-3/4" fil. hd. screws

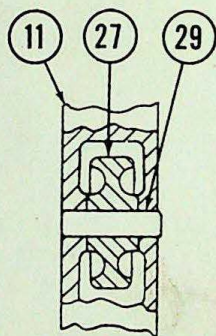
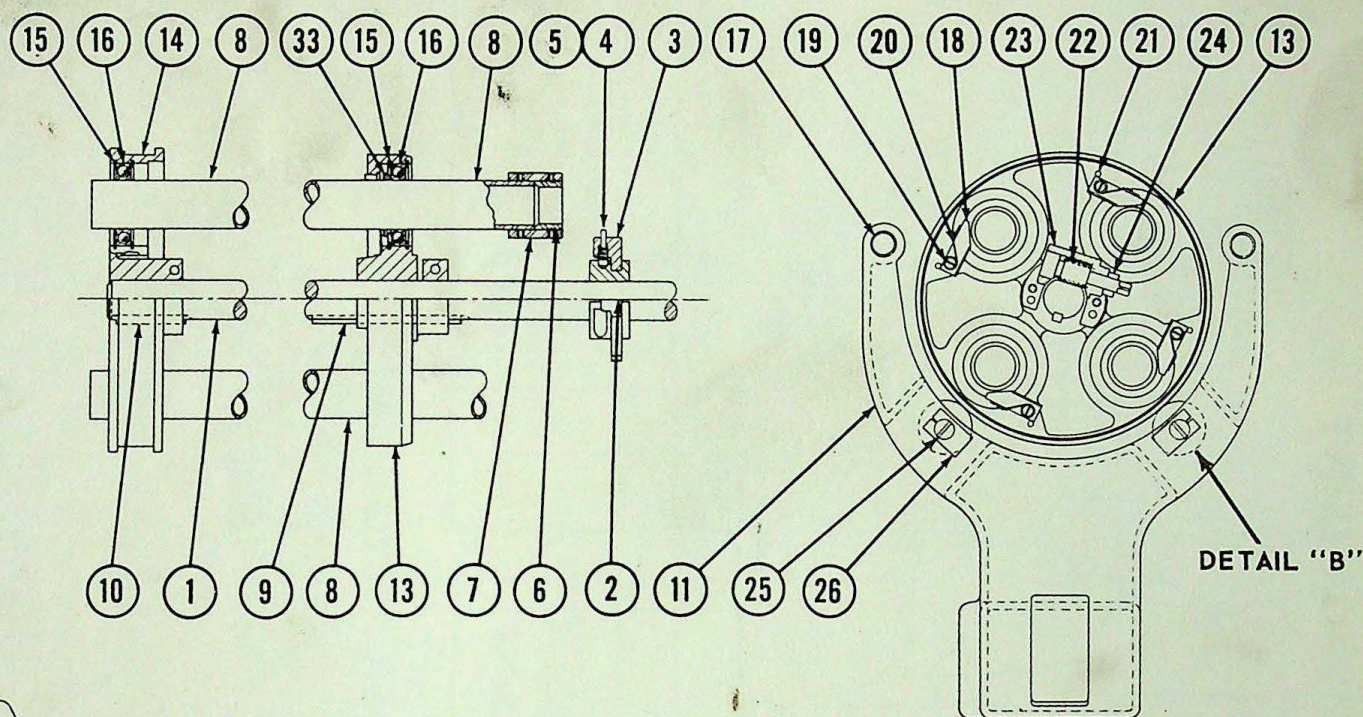
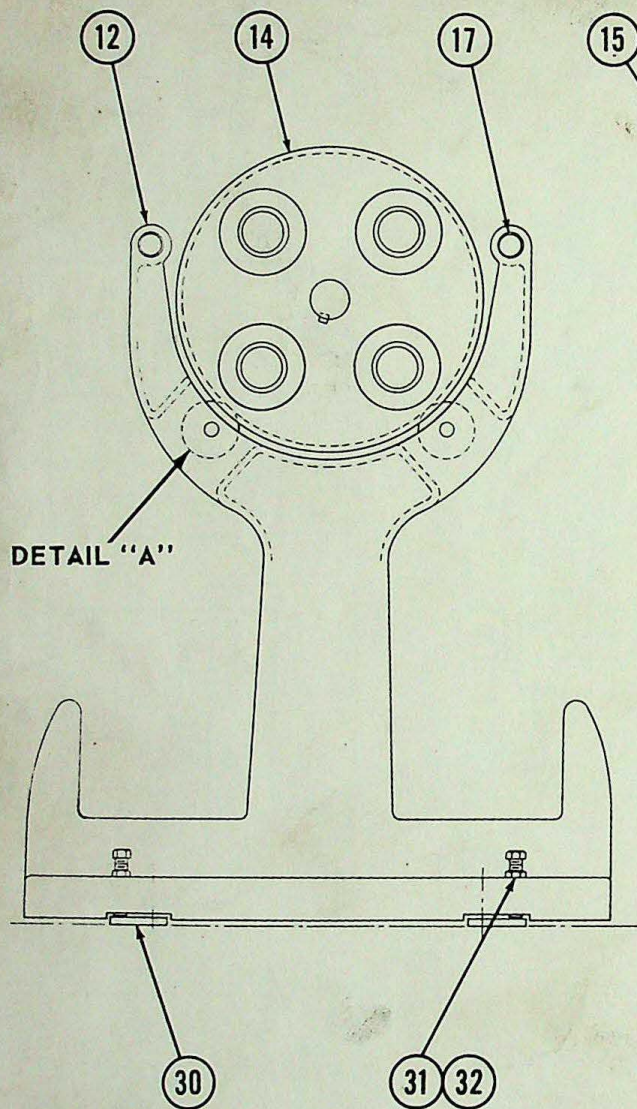


Order By
This Number

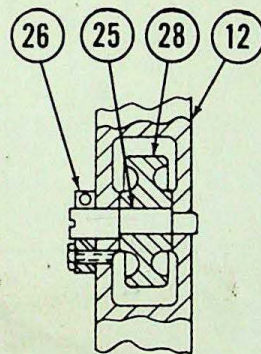
Key No.	Qty.	Part Number	Name of Part
6	1	3284GB	1/2" steel ball
7	1	720-2	Spring
8	1	3572GB	3/4" x 1-1/2" flat pt. set screw
9	1	2327GB	3/4" jam nut

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

STOCK REEL



DETAIL "A"



DETAIL "B"

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

STOCK REEL PARTS LIST

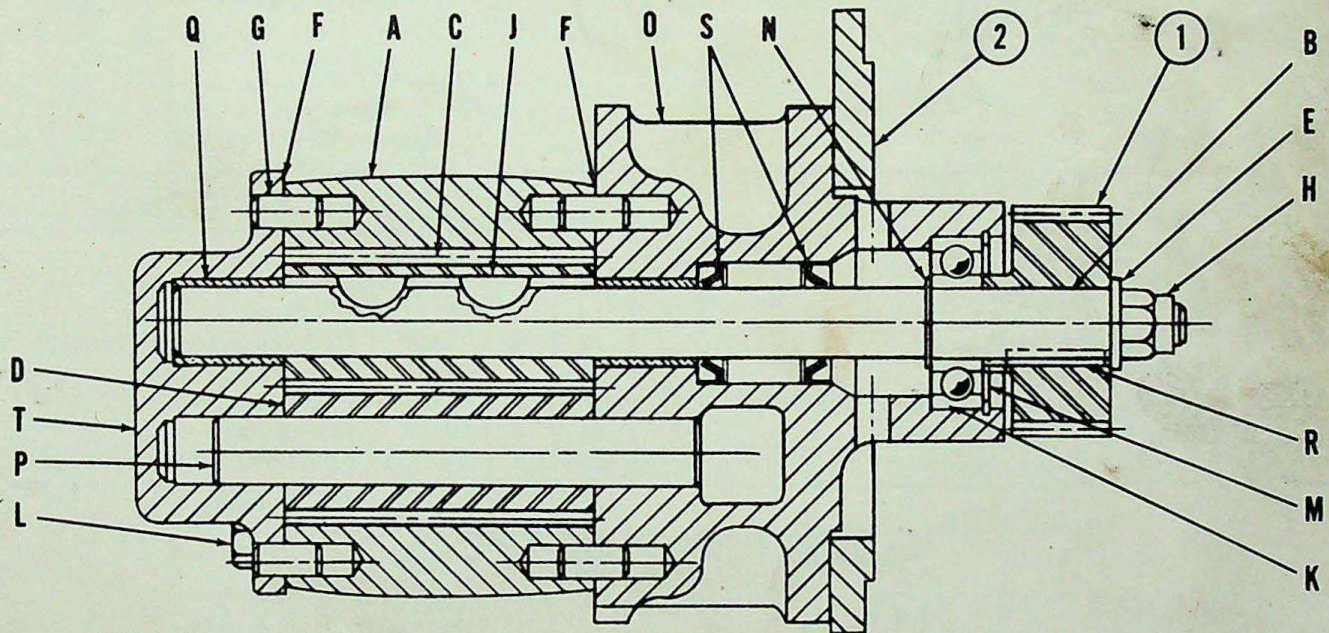
Order By
This Number

Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	3182YL	Stock reel center shaft
2	1	YL 609	Safety plate hub
3	1	YL606	Feed tube safety plate
4	1	1534YA	Plunger
5	1	509V	Plunger spring
6	4		Stock reel bushings (order by size)
7	4	3179YL	Stock reel bushing sleeves
8	4	4299YL	Stock reel tubes
9	1	1713YL	Center shaft key
10	1	1714YL	Stock support wheel key
11	1	YL 691	Front support bracket
12	1	YL690-1	Rear support bracket
13	1	YL1695	Stock reel wheel (front)
14	1	YL1696	Stock reel wheel (rear)
15	16	1404GB	Retaining rings
16	8	1405GB	N.D. # 77517 bearings

Key No.	Qty.	Part Number	Name of Part
17	2	3174YL	Support pipes
18	4	8771YA	Locking fingers
19	4	10777YL	Locking finger studs
20	4	8809YA	Spring lock plates
21	4	1099V	Stop pins
22	1	4241YL	Adjusting gear shaft
23	1	YL 708	Gear shaft support bracket
24	1		7/8" standard collar
25	2	4129YL	Roller eccentric shafts
26	2	4130YL	Shaft clamp blocks
27	2	YA449X1	Stock wheel rollers
28	2	YA449	Stock wheel rollers
29	2	1321YA	Roller shafts
30	4	10945YL	Leveling plates
31	4	11026YL	Leveling screws
32	4	10907YL	Locknuts
33	4	4298YL	Revolving pipe stop collars

COOLANT PUMP



Order By
This Number

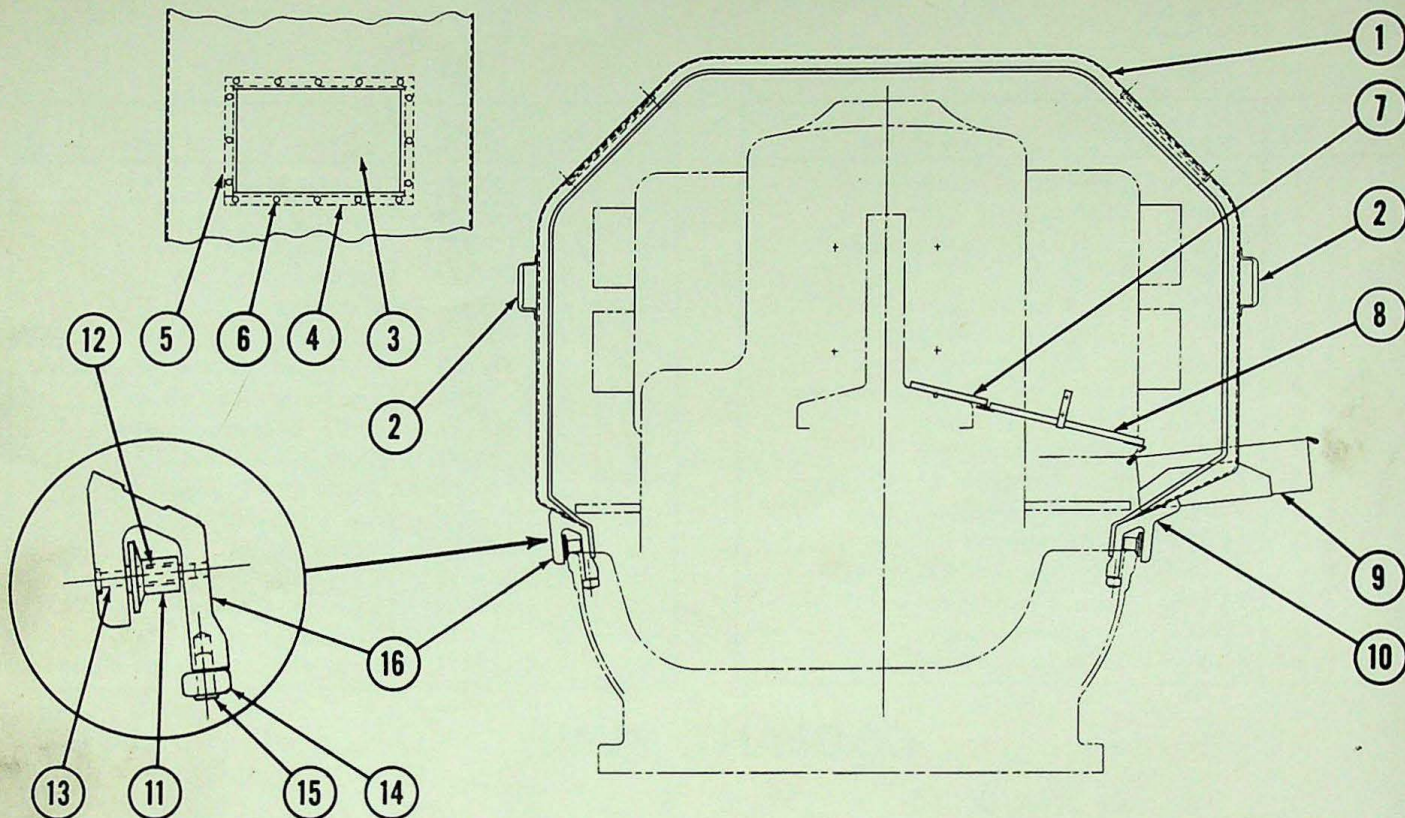
No. 2844GB

Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	11031YL	Pump drive gear
2	1	YL1154	Pump adapter plate
A	1	P1-251	Case
B	1	D1-1137	Drive shaft
C	1	D6-358	Drive cam
D	1	D6-376	Idler cam
E	1	D8-252	Washer
F	2	D11-257	Gaskets
G	4	D48-5	Dowel pins
H	1	19516	Castle nut
J	2	18876	Woodruff keys

Key No.	Qty.	Part Number	Name of Part
K	1	3653 GB	Drive shaft bearing
L	8	21171	Faceplate screws (hex.)
M	1	D14-71	Snap ring (outer)
N	2	20523 A	Snap rings (inner)
O	1	P2-949	Backplate
P	1	BP61-7A	Idler shaft
Q	2	D5-381	Bearing bushings
R	1	D30-9	Drive shaft key
S	2	2943 GB	Oil seals
T	1	P3-344	Faceplate

SLIDING OVERHEAD OIL SHIELD



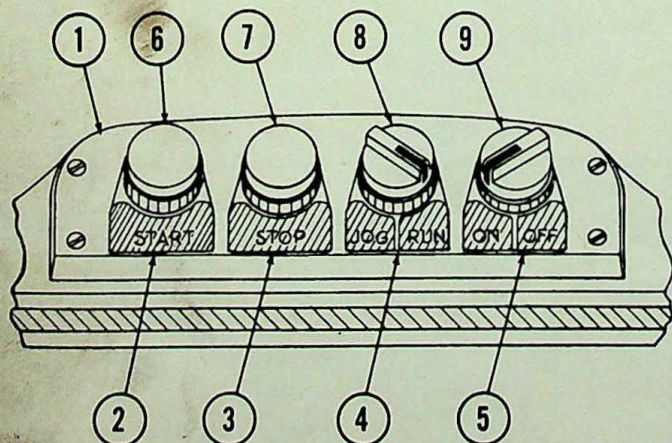
Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	12013YL	Oil shield
2	2	3798GB	Handles
3	2	9886YA	Windows
4	4	9777YA	Long clamps
5	4	9778YA	Short clamps
6	32	3777GB	1/4" button head screws
7	1	8780YL	Work guide plate
8	1	9948YA	Work chute

Order By
This Number

Key No.	Qty.	Part Number	Name of Part
9	1	12281YL	Part box
10	2	YA1314	Oil shield brackets (rear)
11	4	9828YA	Rollers
12	4	206GB	#B - 88 bearings (Torr.)
13	4	1036V	Head pins
14	4	9774YA	Rollers - Lower
15	4	1026V	Head pins
16	2	YA1313	Oil shield brackets (front)

ELECTRICAL CONTROLS



Order By
This Number

Key No.	Qty.	Part Number	Name of Part
1	1	YL1816	Push button cover
2	1	EQ498	Start name plate
3	1	EQ499	Stop name plate
4	1	EQ500	Jog - Run name plate
5	1	EQ500	On - Off name plate
6	1	EQ1093	Push button - black
7	1	EQ1094	Push button - red
8	1	EQ1095	Selector switch (Jog - Run)
9	1	EQ1096	Selector switch (On - Off)

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

COVERS, OIL SHIELDS, SPLASH GUARDS

NO. REQD.	DESCRIPTION OF PART	PART NO.
2	Threading drive covers (Front and Rear)	YL740
2	gaskets	5046YL
1	Clutch control mechanism cover	YL757
1	splash guard	7798YL
1	Feed change gear cover	YL758
1	retainer bracket	YL759
1	splash guard	7799YL
1	Speed change gear cover	5143YL
2	cover handles	YL1284
2	latches	4363YL
2	latch shafts	4364YL
2	latch shaft bushings	4361YL
1	bottom strip	4123YA
1	Threading feed mechanism housing cover	YL756
1	gasket	6942YL
1	Spindle inspection cover	YL556-2
1	Overarm light cover	YL667
1	Coolant valve bracket shield	YA253
1	Upper spindle shield	YL1113-2
1	Front spindle shield	YL1664
1	support	YL1663-1
1	Rear spindle shield	YL1116
1	Index arm shield	YL1118
1	jack screw plug	7744YA
4	Front and rear shield hinge pins	699V
2	lock springs	761YA
1	Locking block lever shield	6929YL
1	locking plate	4270YM
1	Front motor shaft guard (Short)	11783YL
1	Rear motor shaft guard (Long)	4201YL
1	Rear cam shaft guard	6249YA
1	Spindle hinged extension (Front)	YL1231
1	Spindle hinged extension (Rear)	YL1232
4	1-1/2" x 1-3/8" butt hinges	510GB

COOLANT PARTS

NO. REQD.	DESCRIPTION OF PART	PART NO.
1	Roper pump (Spec. #2747, type #4)	2844GB
	NOTE: Coolant pumps are repaired on an exchange basis. Send in complete Roper pump assembly when repairs are necessary.	
1	Pump adapter plate	YL1154
1	Drive gear	11031YL
1	Valve bracket manifold	YL1918
1	Intake manifold	YA1299
1	Coolant strainer manifold	YA1298
1	Frame coolant pipe (1" x 23-3/4")	2575YL
2	Forming slide coolant outlet boxes	2447YL
1	Coolant strainer	YL1712
1	Coolant strainer cover	10909YL
1	Coolant pump pipe (outlet)	11578YL
1	Coolant pump pipe (inlet)	11575YL
2	Oil resistant hose	3888GB
4	Hose clamps	870GB

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

OIL SIGHT

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
1	Oil sight bracket	YL694
1	gasket	5047YL
2	Oil sight glasses	3258GB
4	Composition washers	3261GB
2	Glass retainer nuts	4170YL

OIL FILTER

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
1	#10651 Cuno oil filter (type KT)	3487GB
1	cover	YM392
1	gasket	5045YL
1	packing nut	9346YJ

OVERARM

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
1	Overarm	YL1226
1	glass shield	4650YL
1	shim	8203YL
1	light holder	2202YA
1	Standard brass receptacle	EQ392

FRAME PARTS

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
1	Main frame	3100175
1	Oil pan	YL337-4
6	jack screws	10906YL
6	locknuts	10907YL
6	leveling plates	10908YL
1	chip plate (Front)	12297YL
1	chip plate (Rear)	12295YL
1	angle bracket (Front)	12298YL
1	angle bracket (Rear)	12296YL
6	washers	1154V
1	Gear box	YL558-3
1	Gear box cover	YL516-2X
1	Gear box oil glass (2 - 1/2" x 1/4")	3206GB
1	oil glass nut	3678YS

HANDLES, CRANKS, WRENCHES

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
1	Stock reel crank	1790YL
1	Hand feed crank	1142YG
1	Cross slide operating handle	YL239
1	operating handle pivot	1112YL
1	operating handle pin	1113YL
1	Trip-dog socket wrench	1347GB
1	1/2" Allen "T" wrench	2277YL
1	3/8" Allen "T" wrench	2278YL
1	Housing wrench	1677YL
1	Lower rack wrench	968YM

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

The game plan is savings

SALE

Save 23%...RAWLINGS NFL Jerseys for men

In authentic team colors,
these machine-washable
nylon/cotton jerseys are
licensed by the NFL.
Men's sizes S,M,L,XL.

9⁹⁹

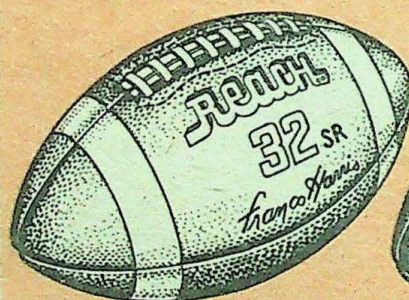
regularly \$13

NFL Jerseys in boys' sizes
S,M,L,XL. regularly \$11

8.99

RAWLINGS
NFL Replica Helmets
with team emblems.
regularly 19.99

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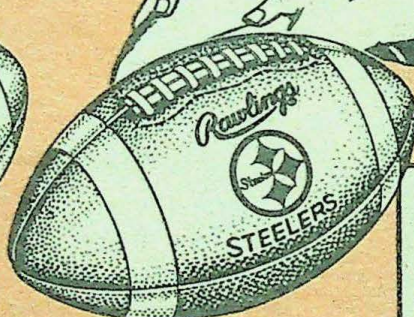


Save 23%...REACH
Franco Harris Footballs

9⁹⁹

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All-leather balls are
double laced and about as
durable as the big
running back himself!

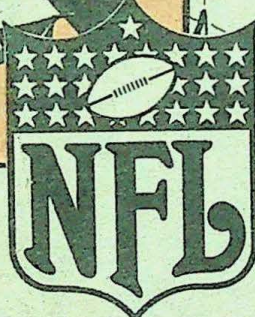


Save 22%...RAWLINGS
Team Emblem Footballs

13⁹⁹

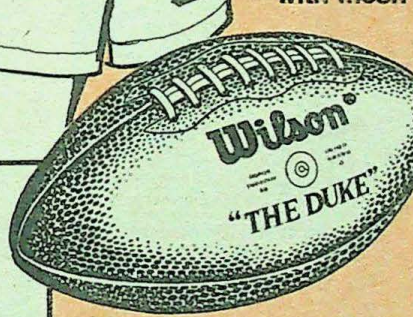
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Cowhide leather balls
with durable two-ply
lining and deep pebble
grain construction.



Herman's is your
NFL Center

We now carry a full line
of equipment and clothing
that is officially licensed
by the NFL. And like every-
thing else at Herman's,
the prices are tough to
beat. So rush in and gear
up for the new season.



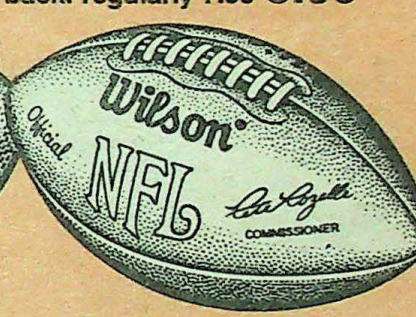
Save \$6...WILSON®
"Duke" Footballs

18⁹⁹

regularly 24.99

Full grain leather, triple-
lined balls can take
whatever you dish out.

"Duke Junior"
regularly 22.99 16.99



WILSON®
NFL Game Balls

32⁹⁹

special value

Used by the pros in every
NFL game. Made of the
finest full grain leather;
triple lined for toughness.

Save 30%...REACH Roger Staubach Football Kits come
complete with sewn vinyl ball, pump and tee. regularly 9.99

6.99

RAWLINGS Shoulder Pads in pro, junior and pee-wee styles.
Medium, regular and extra-large sizes. regularly 19.99

16.99



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Save \$10 . . . Down
Parkas for the
whole family
YOUR CHOICE

49⁹⁹
regularly 59.99

Unisex Super Sweater:
Zip front, wind fighter cuff
snaps, down fill pockets,
drawstring bottom.
Women's ¾ Length Belted
Parkas: Two way zip front,
outside and inside pockets.
80% down/20% feather.
Sizes S,M,L,XL.
Children's Super Sweaters
regularly 44.9934.99

Save \$10 . . . Down
Filled Vests for
men and women

34⁹⁹
regularly 44.99 to \$46

Full snap front, outside
quilting, warm pockets.
80% down/20% feathers.
Men's and women's sizes.

Save \$10 . . . CB SPORTS
Super Goose® Down Unisex Vests

When a parka is too warm, or
not warm enough. Snap front,
down filled pockets and kidney
flap for added warmth.
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\$45
regularly \$55



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Packs made by JANSPORT
or THE NORTH FACE

11⁹⁹
regularly 14.99

With front pockets,
web shoulder straps,
big zippered openings.



High Adventure
Sparrow Day Packs
by DIAMOND & KELTY

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regularly 19.99

Rugged cordura nylon
with zip top and front
pocket. Padded straps.



JANSPORT
Day Packs
in rugged nylon

21⁹⁹
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In cordura nylon
with padded shoulder
straps, outside pocket.



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For women only:
a softer trend
in the new fleece

Pants,
regularly \$14 **10⁹⁹**

Tops,
regularly \$16 **11⁹⁹**

Styled to fit a woman,
and her game. Pullover
shirt, matching pants
in navy/red or blue/
white acrylic. S,M,L.

**Matching Fleece
Shorts for right now
and early fall, too.**
S,M,L. regularly \$9...**6⁹⁹**



**CROSS COURT®
Sweat Pants and
Shirts for men**

Pants,
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Shirts,
regularly \$15 **11⁹⁹**

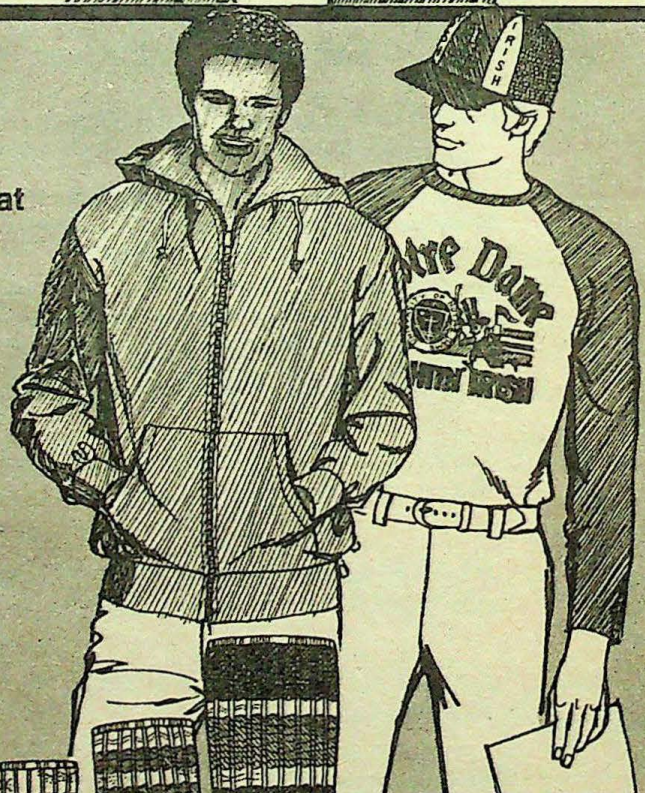
Get ready for those
cool weather runs.
Long sleeve baseball
style zip front jacket
and pull-on sweat pants.
Both are easy-care cotton/
acrylic. Sizes S,M,L,XL.

**Save 29%
Zip Front Sweat
Shirts for men**

9⁹⁹

regularly \$14

The perfect year
round sweat shirt
with hood and
roomy pouch
pockets in front.
Assorted colors.
S,M,L,XL.



**Save 25%
College Baseball
Undershirts
for men**

5⁹⁹

regularly \$8

All cotton, so
you know they're
comfortable and easy
to care for. Your
choice of schools.
Sizes S,M,L,XL.

**Save 29% . . . AMERICAP
Baseball Caps with
college emblems
regularly 6.99...**4.99****

**EVERY INTERWOVEN® SPORT SOCK
IN OUR ENTIRE STOCK**

Every ped, crew and
tube sock, plenty of
styles and colors to
choose.

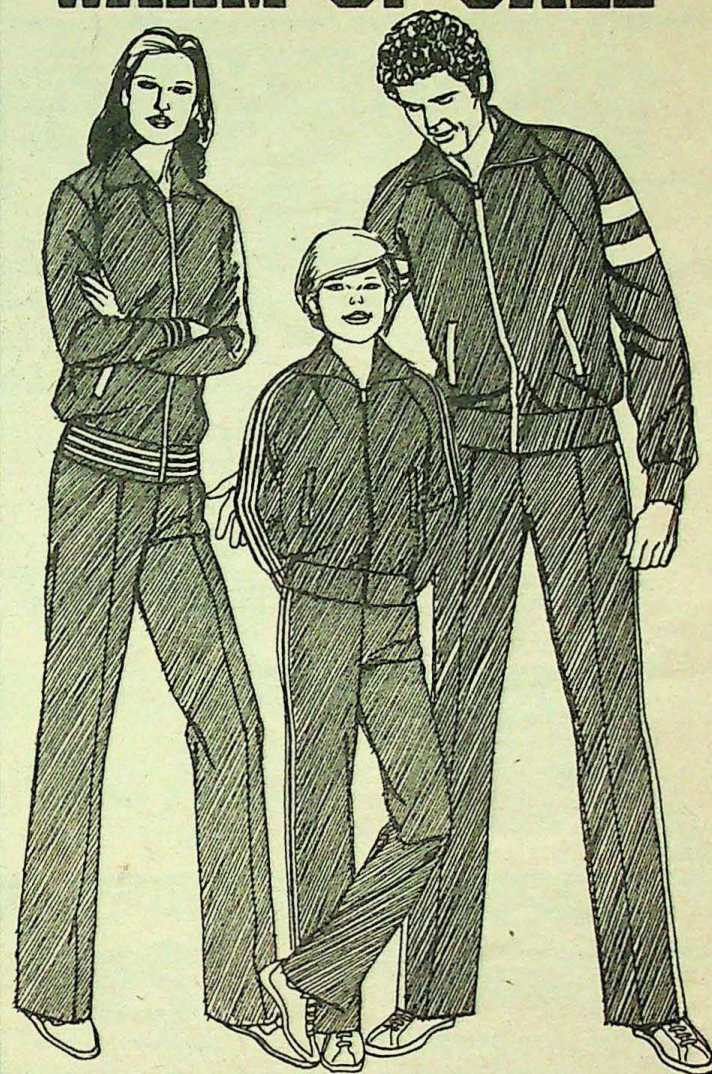
**20%
OFF**

regularly 2.25 to \$3...1.79 to 2.39 pair

*comparable value refers to similar, not identical, merchandise

Herman's
WORLD OF SPORTING GOODS a GABCE company

WARM-UP SALE



**Save \$7...WHITE STAG OR WINNING WAYS
Warm-Up Suits for Women**

Comfortable, triple-knit acrylic for
pre-game warm ups or running.
Solid colors with contrasting stripes
on collars, cuffs. S,M,L.

37⁹⁹
regularly \$45

**Fleece lined acrylic
Warm-Up Suits for Men**

All weather warm-ups lined with
soft, absorbent fleece. Fully
cut for freedom of movement.
Pants with key pocket. Royal
or navy. S,M,L,XL.

19⁹⁹

*comparable value \$28

**Save 20%...Warm-Ups for kids. Easy care,
durable nylon. after sale 19.99**15.99****

**A special group of Famous Maker
Warm-Ups for men at one low price.
regularly \$35 to \$48**27.99****

THE WORLD'S BIGGEST GOLF & RACKET SALE

... here is just a part of our golf, tennis and racquetball savings plan ...

EVERY 11-piece GOLF SET IN STOCK REDUCED

\$20 TO \$60 OFF regular and original prices

Choose from some of the biggest names on any course: WILSON®, SPALDING®, LYNX®, NORTHWESTERN and more.

BUTCHART NICHOLLS® Every Putter and Wedge in stock reduced

44⁹⁹

regularly 54.99

20% OFF
regular prices

EVERY GOLF BAG IN STOCK REDUCED!

Our winning selection includes ARNOLD PALMER, BUTCHART NICHOLLS®, RAM and more!

20% TO 33% OFF
regular prices

EVERY GOLF CART IN STOCK REDUCED!

Save \$7... **BAG BOY** Play Day Golf Carts

29⁹⁹

Other carts at similar savings! regularly 36.99

DUNLOP Blue Maxfli Pro Golf Balls designed for distance and durability.

9⁹⁹

dozen sold in pro shops up to \$19

BUTCHART NICHOLLS® Leather Golf Gloves for men and women

5⁹⁹

regularly 7.99



TENNIS RACKET SALE!

- **BANCROFT Bjorn Borg** Personal Wood Frames custom stringing extra **YOUR CHOICE 29⁹⁹**
- **P.D.P. Aluminum** Mid-Size Rackets
- **HEAD Mark VI** Aluminum Rackets regularly 34.99 to 39.99

- **WILSON® Advantage** Wood Frames* **YOUR CHOICE 39⁹⁹**
- **HEAD Arthur Ashe** Comp I Frames* regularly 49.99 and 56.99

- **HEAD Pro Frames*** **YOUR CHOICE 44⁹⁹**
- **HEAD Edge Mid-Size Frames***
- **PRINCE Classic Over-Sized** Aluminum Frames* regularly 54.99 to 64.99

*cover included; custom stringing extra

DUNLOP Championship Yellow Tennis Balls. if perfect 2.29 **can of 3 1.79**

RACQUETBALL SAVINGS

Save \$5...**LEACH Flex Fiberglass** Racquets. regularly 14.99 **9⁹⁹**

SLAZENGER Precision Aluminum Racquets. **comparable value 24.99 **14⁹⁹**

Save \$5...**LEACH Aluminum** Racquets. regularly 24.99 **19⁹⁹**

**comparable value refers to similar, not identical, merchandise

intermediate markdowns may have been taken



Herman's
WORLD OF SPORTING GOODS a GRACE company

- **MAYFAIR SHOPPING CENTER** (adjacent to Center Court Ice Rink) Phone 476-1145
Monday through Friday 10 a.m. to 9 p.m. Saturday 9:30 a.m. to 5:30 p.m. Sunday Noon to 5 p.m.
- **SOUTHRIDGE SHOPPING CENTER** (upper level next to Sears) Phone 421-6440
Monday through Saturday 10 a.m. to 9:30 p.m. Sunday Noon to 5 p.m.
- **NORTHRIDGE SHOPPING CENTER** (upper level next to Sears) Phone 354-2080
Monday thru Saturday 10 a.m. to 9:30 p.m. Sunday Noon to 5 p.m.
- **AMERICAN EXPRESS®, VISA®, MASTER CHARGE® AND DINERS CLUB INTERNATIONAL ACCEPTED**

Our Policy on Advertised Items

The items in this insert were selected far in advance of this offering. Therefore, situations may occur where all items may not be available at all our stores. If the item is temporarily out of stock, we will issue a raincheck enabling you to obtain the item at the advertised price. If the item is no longer available, we will offer a comparable value.

