



PARTS BOOK FOR GREENLEE

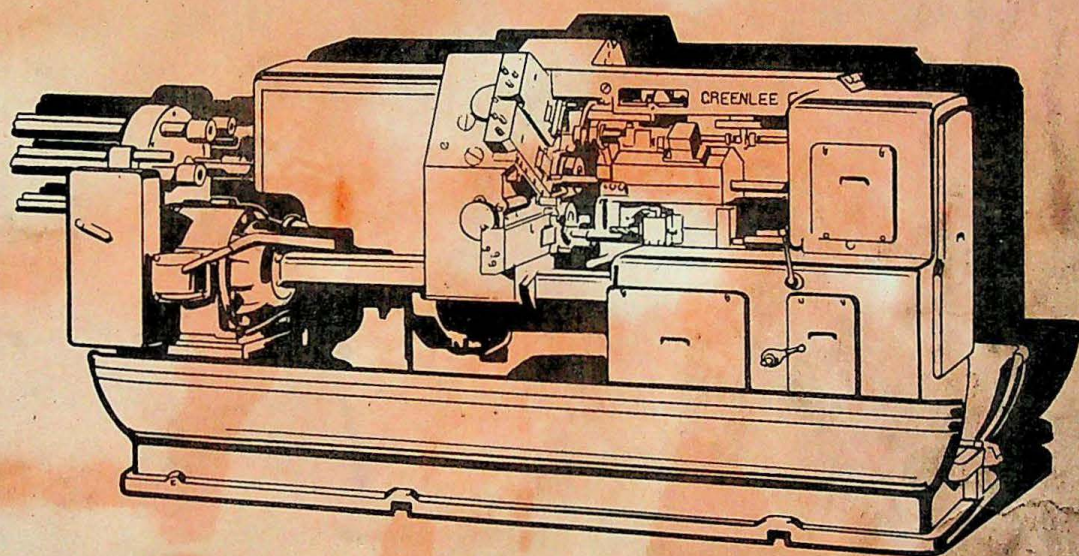
15¹/₈"

6-SPINDLE SCREW MACHINE

 **GREENLEE BROS & CO**
2135 12th St., Rockford, Ill. 61101 U.S.A.
A Unit of Ex-Cell-O Corporation 



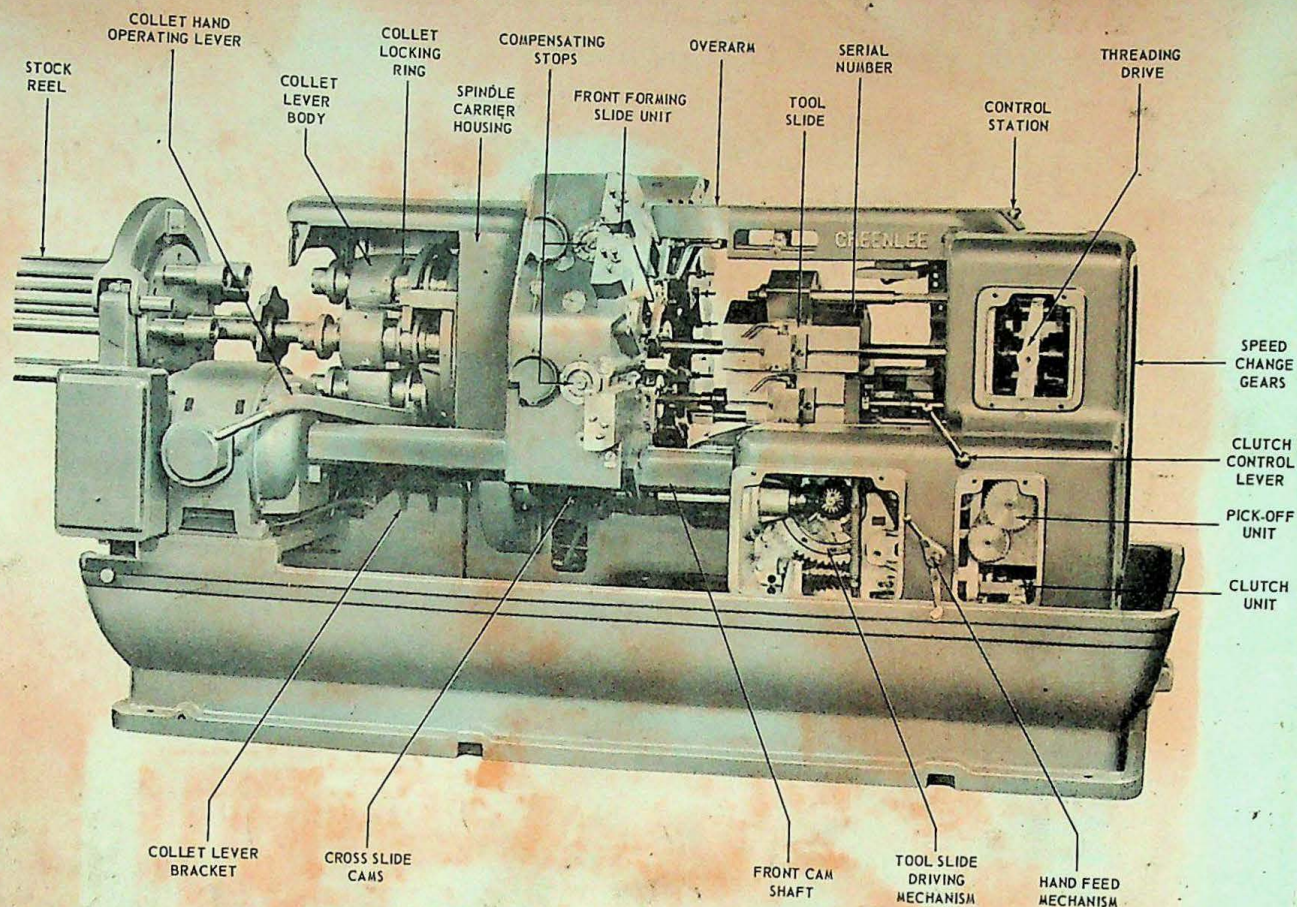
GREENLEE REPAIR PARTS



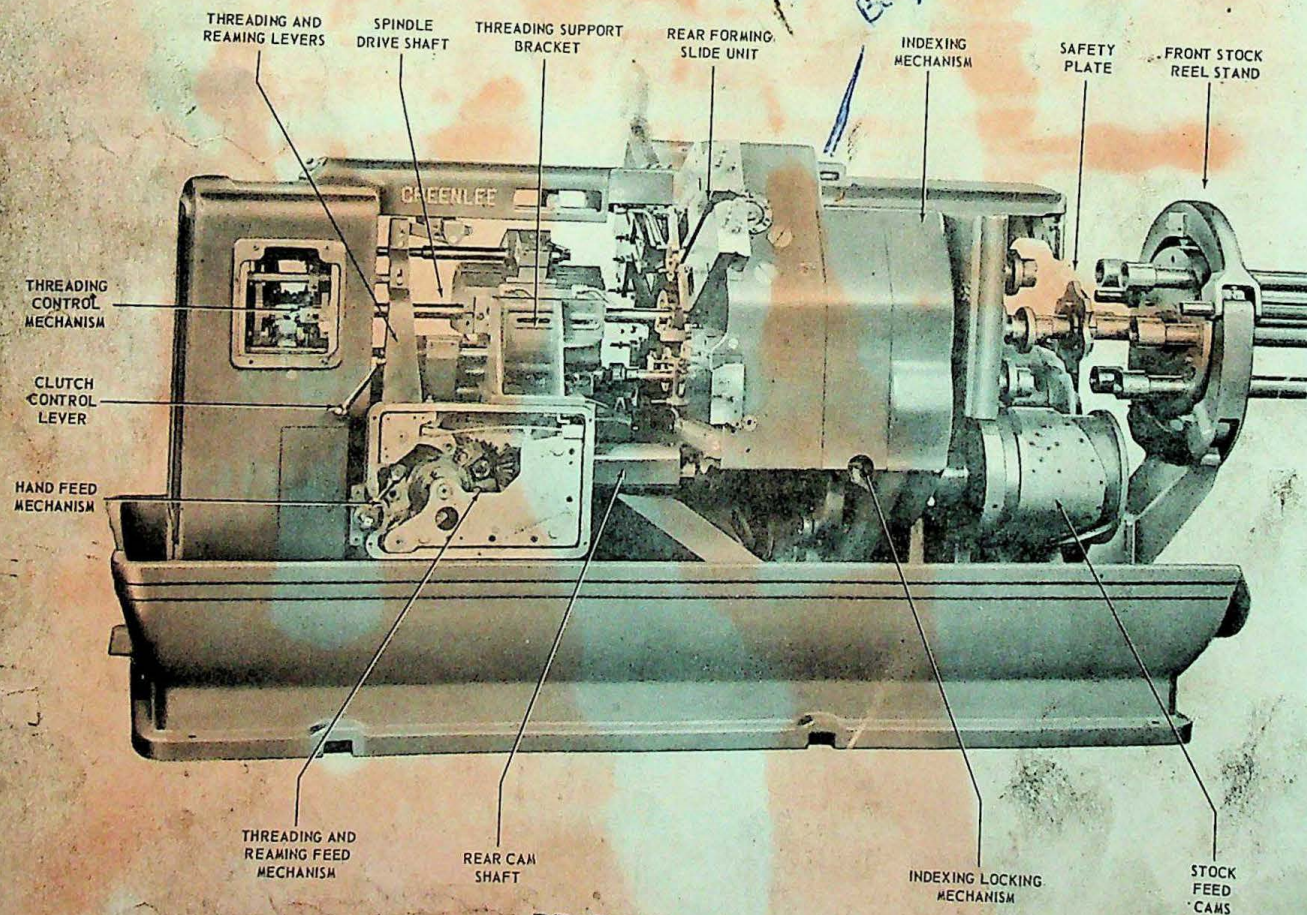
**For 1⁵/₈-inch Six Spindle
Automatic Screw Machines**

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

MAY, 1949



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.

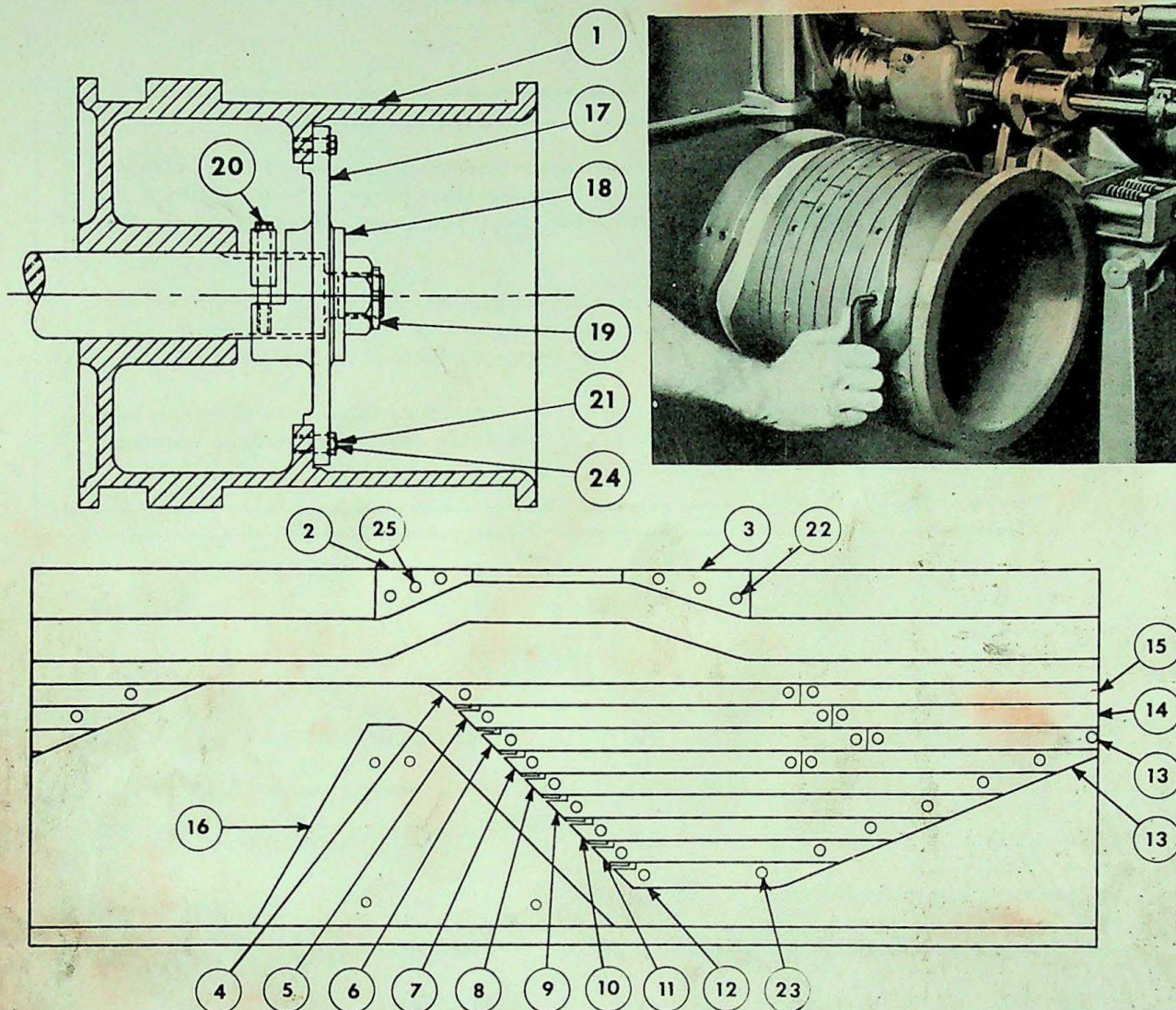
When ordering repair parts, always include the serial number of the machine, as well as the machine size and the number of spindles. The serial number is stamped on the upper surface of the Tool Slide.

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.

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CAM DRUM

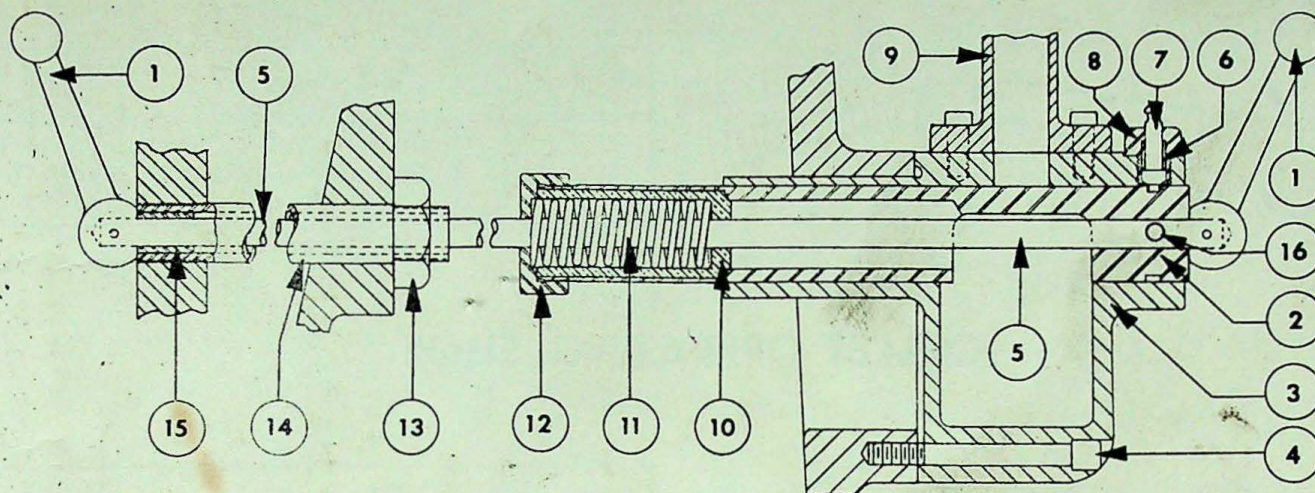


DEVELOPED VIEW OF CAM DRUM SHOWING CAM STRIPS

KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Cam drum	YL305-2	17	1	Cam drum spider	YL303-2
2	1	Cam drum insert	2732YL	18	1	Washer (cam drum)	1552YL
3	1	Cam drum insert	2733YL	19	1	1-1/2" S.A.E.	
4	1	Stock feed cam	6178YL	20	1	5/8" x 3-1/4" hex. hd.	GB2346
5	1	Stock feed cam	6179YL	21	6	cap screw	GB1854
6	1	Stock feed cam	6180YL	22	4	5/8" x 1-1/2" hex. hd.	GB1847
7	1	Stock feed cam	6181YL	23	30	cap screws	GB2076
8	1	Stock feed cam	6182YL	24	2	3/4" x 1-1/2" straight	GB2098
9	1	Stock feed cam	6183YL	25	2	dowel pins	1128V
10	1	Stock feed cam	6184YL			3/8" x 1" straight dowel	
11	1	Stock feed cam	6185YL			pins	1099V
12	1	Stock feed cam	6186YL				
13	2	Stock feed cams	1877YL				
14	1	Stock feed cam	1879YL				
15	1	Stock feed cam	1928YL				
16	1	Stock feed cam	YL440-Y				

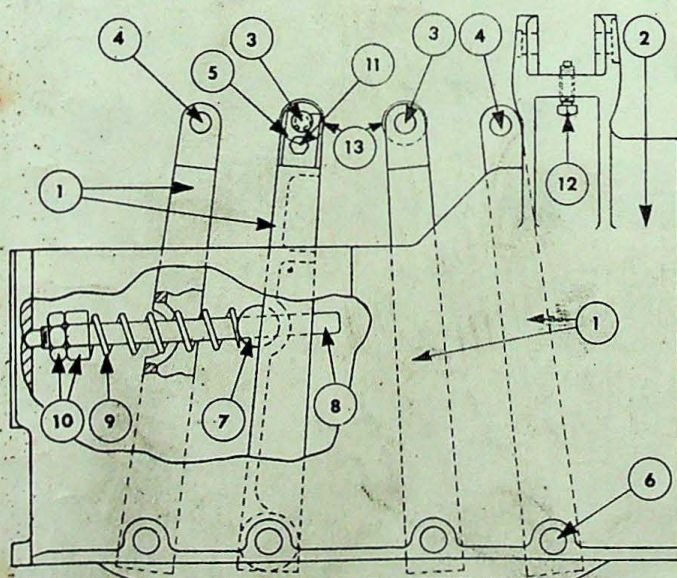
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

COOLANT VALVE AND BRACKET



KEY	NO. REQD.	NAME OF PART	PART NO.
1	2	Coolant valve handles	888YA
2	1	Coolant valve	7460YA
3	1	Coolant valve bracket	YL309-1
4	3	3/8" x 3-3/8" cap screws	2085GB
5	1	Valve operating rod	7460YL
6	1	Plunger spring	3529YL
7	1	Plunger	5546YL
8	1	Plunger nut	5547YL

KEY	NO. REQD.	NAME OF PART	PART NO.
9	1	Outlet manifold	YA258-2
10	1	Relief valve	YL1157
11	1	Relief valve spring	7 516YL
12	1	Valve spring plug	7461YL
13	1	Pipe clamp nut	188YM
14	1	Operating rod pipe	1481YL
15	1	Operating rod bushing	1480YL
16	1	#3 taper pin	721GB

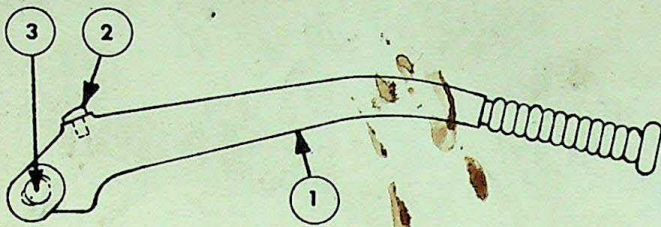


COLLET LEVER ASSEMBLY

KEY	NO. REQD.	NAME OF PART	PART NO.
1	4	Collet & feed shoe levers	YL177-1
2	1	Collet lever bracket	YL435-1
3	2	Collet shoe shafts	2146YL
4	2	Collet shoe shafts	2147YL
5	4	Shaft retainers	3000YL
6	4	Collet lever pivot shafts	4186YL
7	1	Spring rod guide	4344YL
8	1	Spring rod	4345YL
9	1	Feed shoe lever spring	537-V
10	2	5/8" jam nuts	2326GB
11	4	1/2" x 1" hex. hd. screws	1828GB
12	1	1/2" x 2 1/2" sq. hd. screw	1959GB
13	2	Chuck rollers	11YG

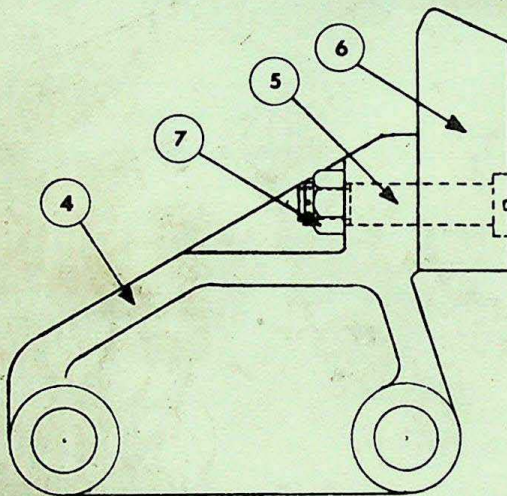
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COLLET HAND OPERATING LEVER

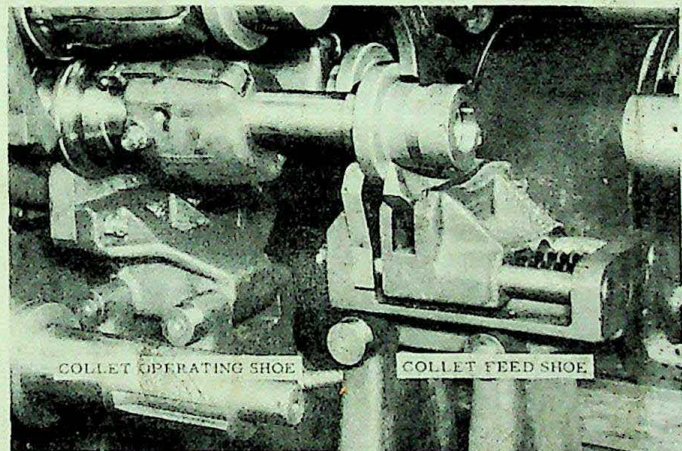


KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Collet operating lever	YA368-2
2	1	Collet lever plug	1476YL
3	1	Collet lever shaft	1531YL

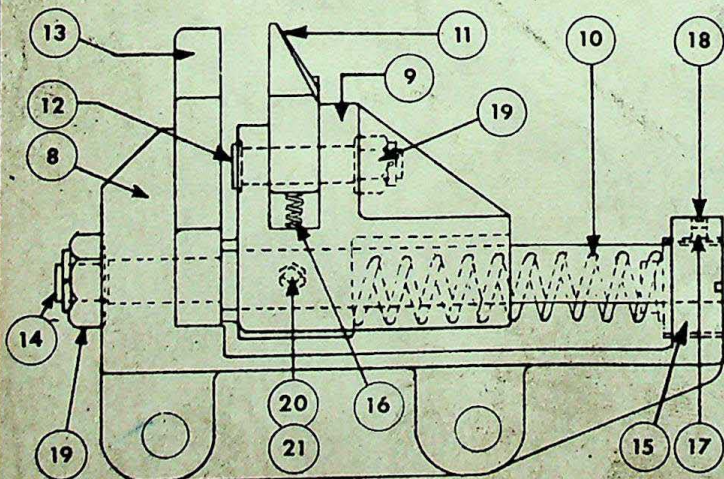
COLLET OPERATING SHOE



KEY	NO. REQD.	NAME OF PART	PART NO.
4	1	Collet operating shoe	YL514
5	3	Shoe plate screws	3013YL
6	1	Shoe plate	3808YL
7	3	5/8" SAE castell. nuts	2340GB



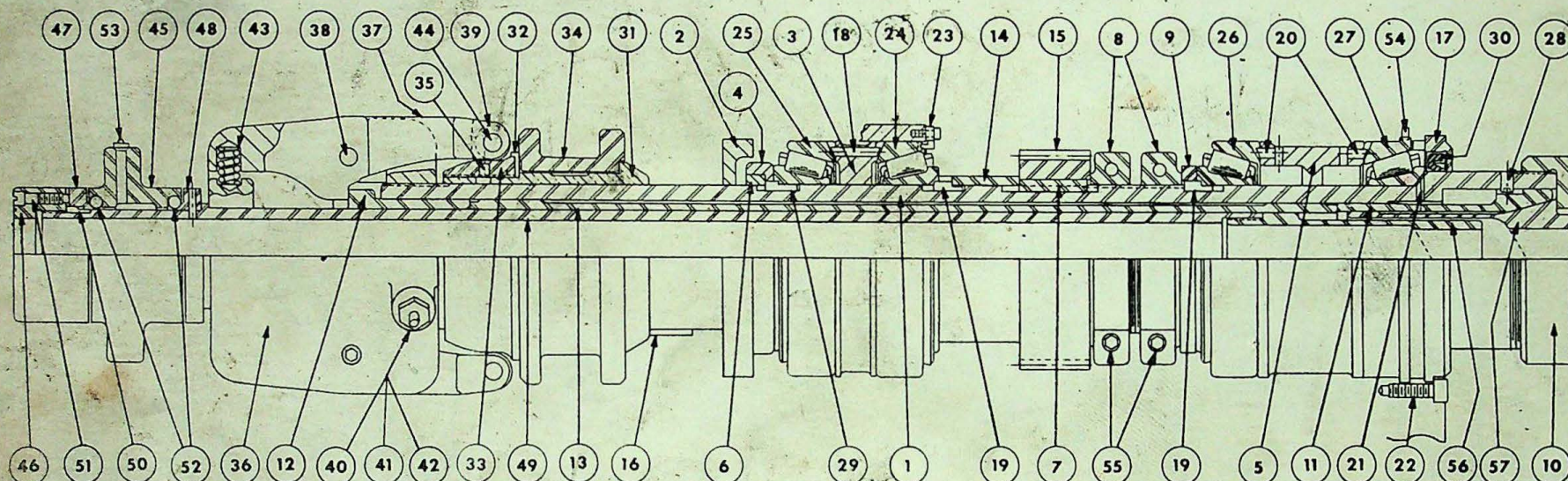
COLLET FEED SHOE



KEY	NO. REQD.	NAME OF PART	PART NO.
8	1	Feed shoe support	YL527-1
9	1	Feed shoe	YL528
10	2	Feed shoe springs	744YL
11	1	Feed shoe safety plate	3081YL
12	1	Safety latch pin	3086YL
13	1	Feed shoe support plate	4163YL
14	2	Feed shoe shafts	4207YL
15	2	Feed shoe spring plugs	1391YA
16	1	Safety lever spring	96ZZF
17	2	Brass plugs	573-3
18	2	3/8" Allen hd. setscrews	2210GB
19	3	3/4" SAE castell. nuts	2341GB
20	1	3/8" x 1-1/4" set screw	1975GB
21	1	3/8" Jam nut	2323GB

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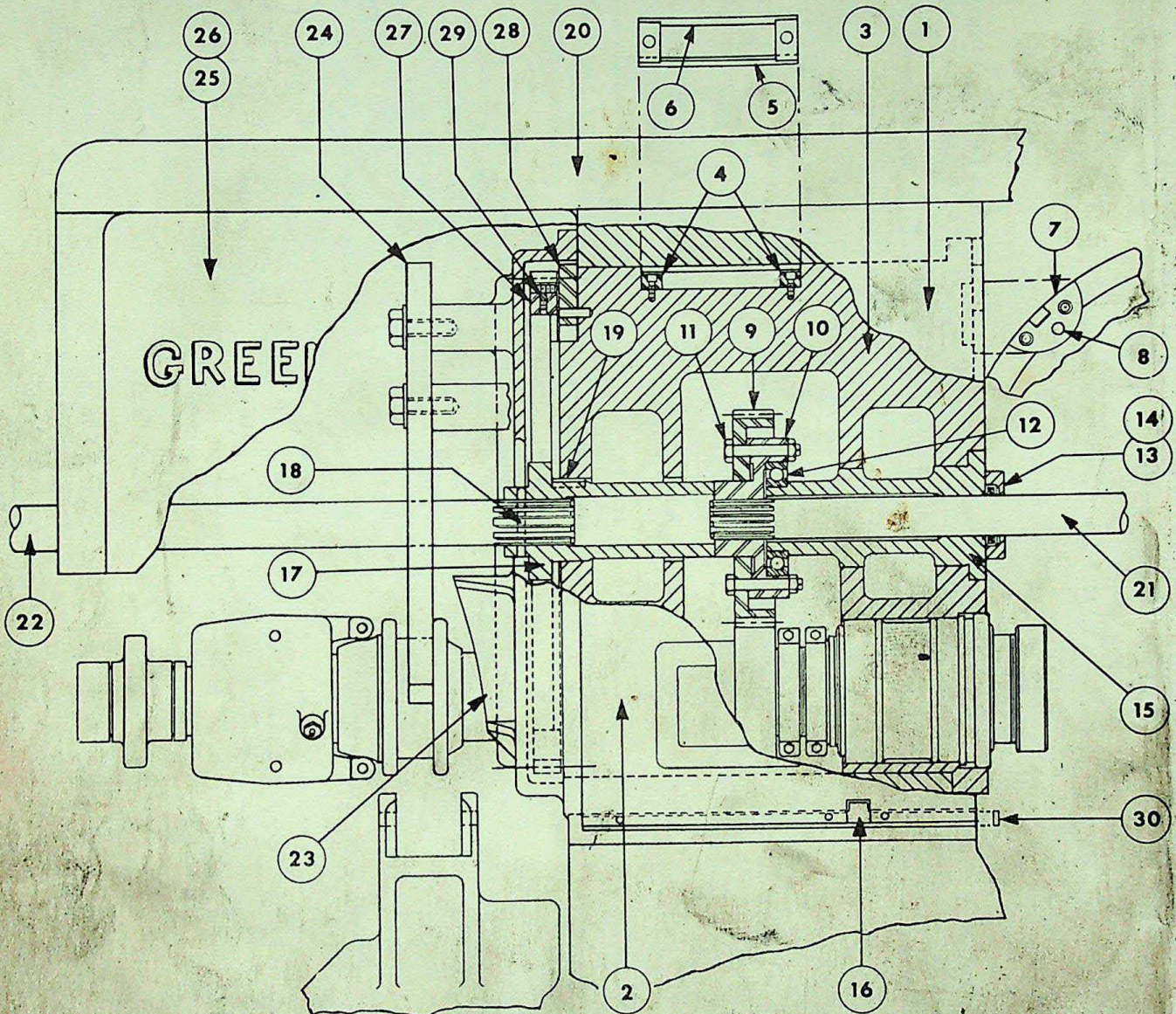
SPINDLE ASSEMBLY



KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Spindle tube	5693YA	20	2	Bearing lock pins	78 01YA	39	2	Rollers	2976YL
2	1	Rear oil retainer	YA200	21	1	Bearing lock pin	7802YA	40	1	Spring	3529YL
3	1	Rear bearing spacer	YA2 01	22	7	Bearing retainer screws	7887YA	41	1	Plunger nut	7519YL
4	1	Rear bearing retainer	YA202	23	1	Bearing lock plate	7790YA	42	1	Chuck body plunger	7534YL
5	1	Front bearing spacer	YA207	24	1	Timken #3 (597-592A)	7803YA	43	2	Collet finger springs	443HS
6	1	Bearing retainer insert	YA424	25	1	Timken #3 (597-592A)	7804YA	44	2	Roller pins	1187V
7	2	Spindle gear keys	252YA	26	1	Timken #3 (594W-592A)	7805YA	45	1	Feed tube oiling collar	253YA
8	2	Spindle adj. lock nuts	256YA	27	1	Timken #3 (594W-592B)	7806YA	46	1	Feed tube nut	262YA
9	1	Bearing adj. washer	258YA	28	1	Spindle nose pin	1885YL	47	1	Feed tube brg. retnr.	263YA
10	1	Spindle nose nut	261YA	29	1	Bearing lock key	660YM	48	1	Feed tube brg. retnr.	264YA
11	1	Collet closing sleeve	265YA	30	1	Garlock Klosure Seal	2939GB	49	1	Feed tube	271YA
12	1	Collet tube extension	268YA	31	1	Collet operating sleeve	YA204	50	1	Feed tube key	2836YG
13	1	Collet tube	272YA	32	1	Collet spool washer	YL989	51	1	Feed tube nut screw	2838YG
14	1	Bearing spacer	481YA	33	1	Collet closing sleeve nut	266YA	52	54	5/16" steel balls	3282GB
15	1	Spindle gear (40T)	1460YA	34	1	Collet spool	270YA	53	1	#1743 Alemite fitting	3443GB
16	1	Key	2120YA	35	1	Collet closing pin	2899YA	54	1	Bearing locking pin	7796YA
17	1	Spindle brg. retainer	7018YA	36	1	Collet lever body	YA205	55	4	3/8" Allen hd. screw	2079GB
18	1	Rear brg. lock pin	7797YA	37	2	Collet levers	273YA	56	1	Pusher (order by size)	
19	2	Bearing lock keys	7798YA	38	2	Collet lever pins	1503YL	57	1	Collet (order by size)	

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

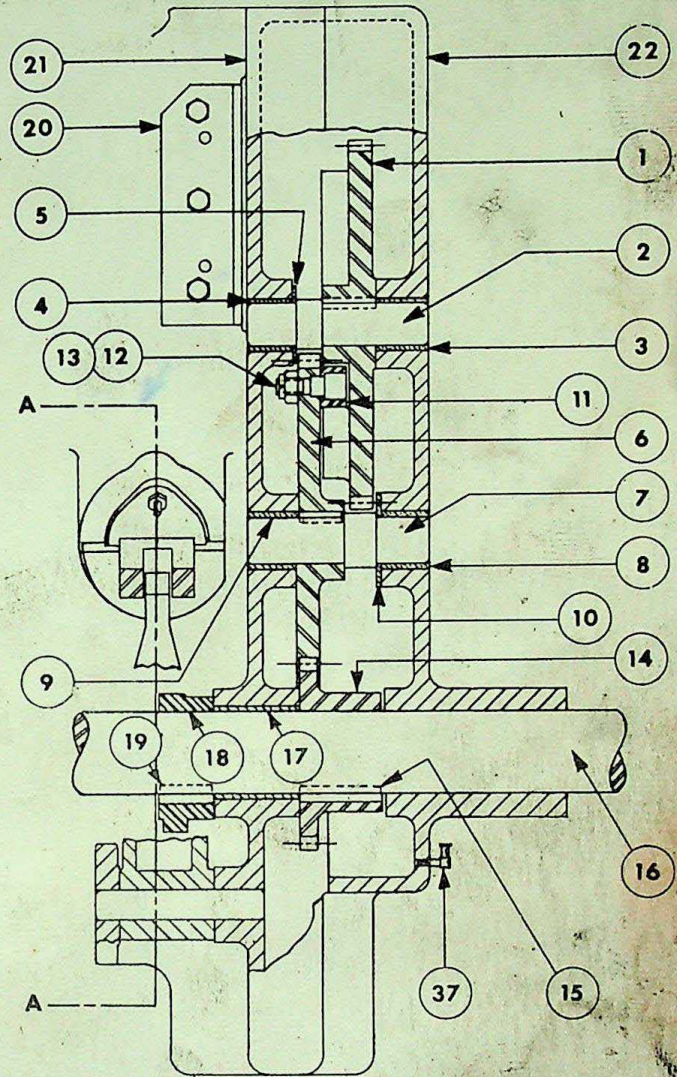
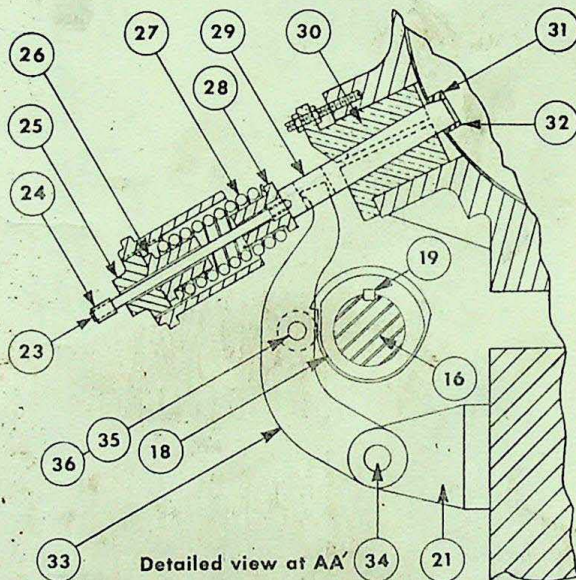
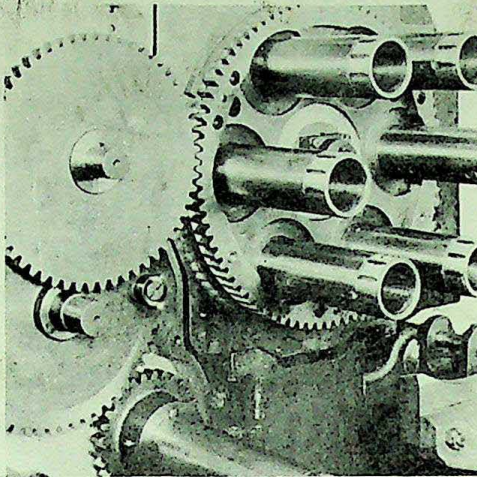
SPINDLE CARRIER AND HOUSING



KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Upper carrier housing	YL542-1	16	2	Housing keys	4108YL
2	1	Lower carrier housing	YL543-1	17	1	Stock reel shaft brg.	YA483
3	1	Spindle carrier	YA443	18	1	Taper pin	3417YA
4	12	Locking block clamps	182YL	19	2	Stock reel brg. keys	1490YL
5	6	Locking block sides	220YG	20	1	Upper spindle shield	YL557-1
6	6	Locking block sides	219YG	21	1	Spindle drive shaft	3147YL
7	6	Comp. wheel stock plates	1465YA	22	1	Stock reel shaft	3171YL
8	6	Comp. wheel oper. pins	3057YL	23	1	Index gear guard	YL547
9	1	Spindle drive gear	1461YA	24	1	Collet lock ring	YL545
10	1	Drive gear hub	1463YA	25	1	Front shield	YL553
11	6	Drive gear studs	1462YA	26	1	Rear shield	YL554
12	1	New Dept. Brg. #2314	64GB	27	1	Spdl. carrier index gear	1464YA
13	1	Oil seal retainer	YL1352	28	3	End adjusting plates	476YA
14	1	#909 Garlock Klosure		29	3	Plugs	573-3
15	1	Drive shaft bearing	YA482	30	1	Housing and frame spacer	3094YL

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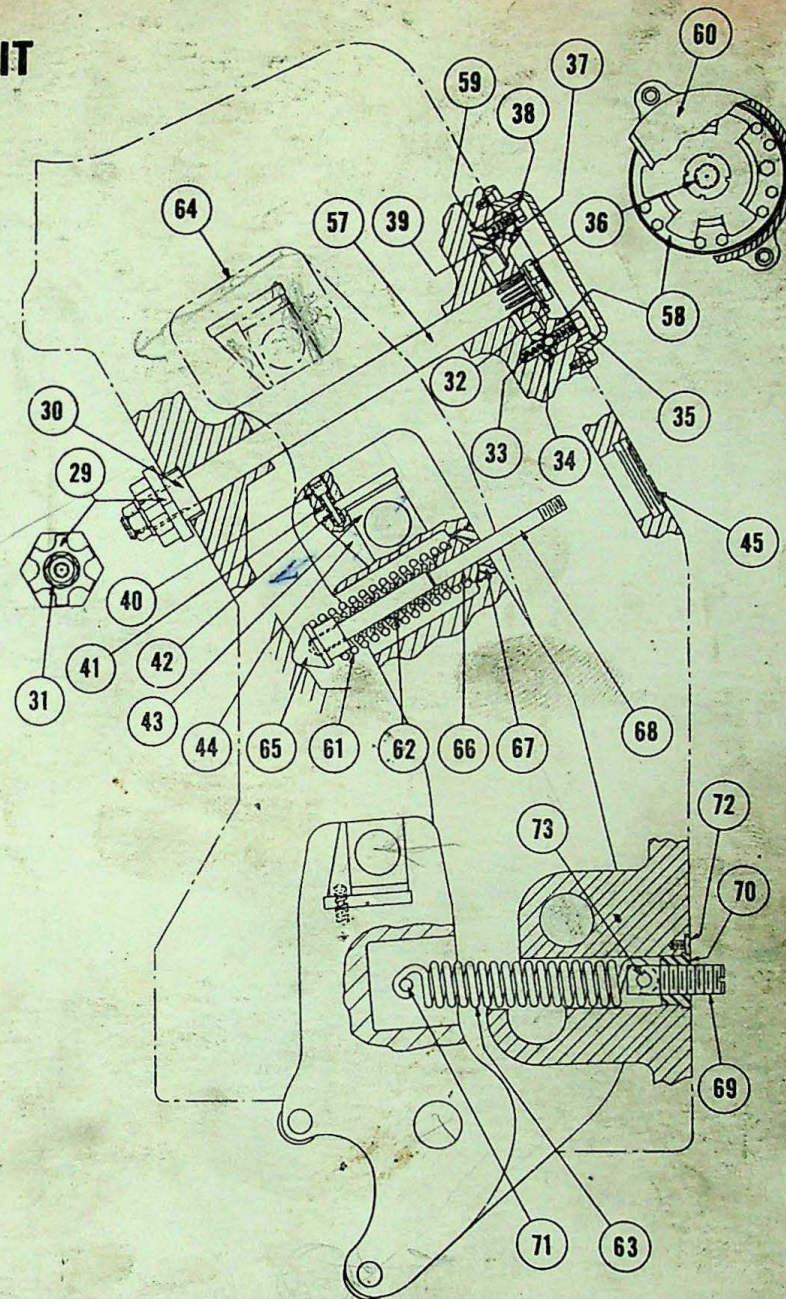
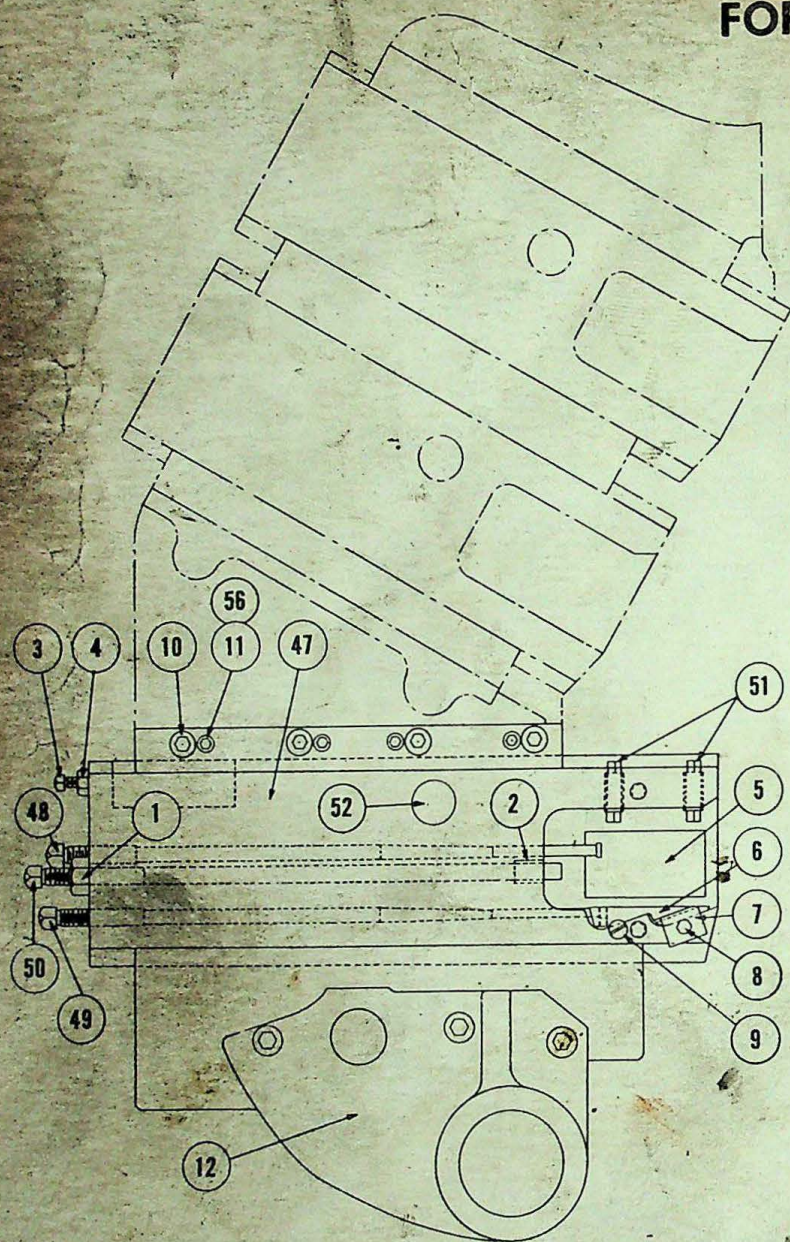
INDEXING AND LOCKING MECHANISM



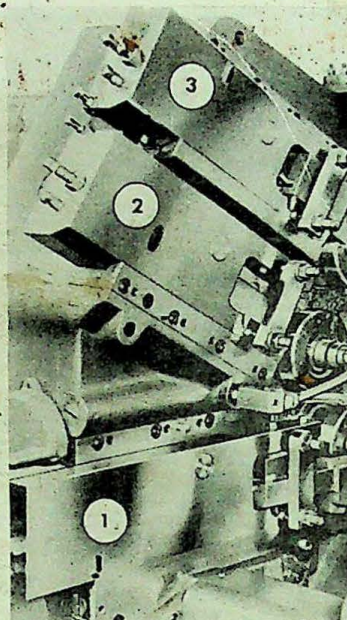
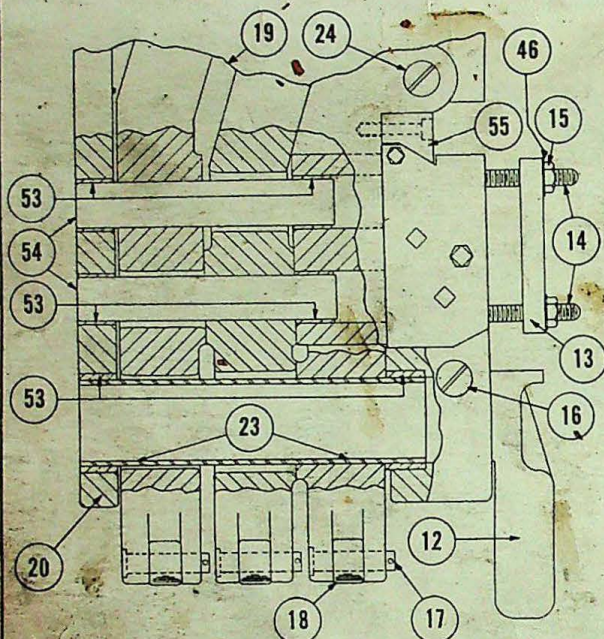
KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Geneva gear (56T)	3088YL	20	1	Index case supp. brkt.	3335YL
2	1	Geneva gear shaft	3083YL	21	1	Index case	YL525-1
3	1	Gear shaft bushing	YA323	22	1	Index case cover	YL526
4	1	Gear shaft bushing	YA324	23	1	Locking block screw	1262YA
5	1	Geneva gear washer	YA339	24	1	Locking block screw nut	1263YA
6	1	Index gear (56T)	7664YL	25	1	Spring plug	YL302X
7	1	Index gear shaft	3084YL	26	1	Spring carrier	YL307X
8	1	Gear shaft bushing	YA326	27	1	Locking lever spring	2343YL
9	1	Gear shaft bushing	YA327	28	1	Spring carrier	YL697
10	1	Index gear washer	YA340	29	1	Locking block	3284YL
11	2	Index rollers	5549YL	30	1	Locking block guide	YL532
12	2	Index roller studs	7660YL	31	6	Locking block sides	220YG
13	2	3/4" Castellated nuts	2341GB	32	6	Locking block sides	219YG
14	1	Index drive gear (28T)	3085YL	33	1	Locking block lever	YL529
15	1	Index gear key	3145YL	34	1	Locking lever shaft	3078YL
16	1	Rear cam shaft	4214YL	35	1	Locking lever roller	2431YL
17	1	Index bracket bushing	YL531	36	1	Lever roller pin	1194V
18	1	Locking block cam	YL530X	37	1	#4202 Oil gauge	2659GB
19	1	Locking block cam key	3144YL				

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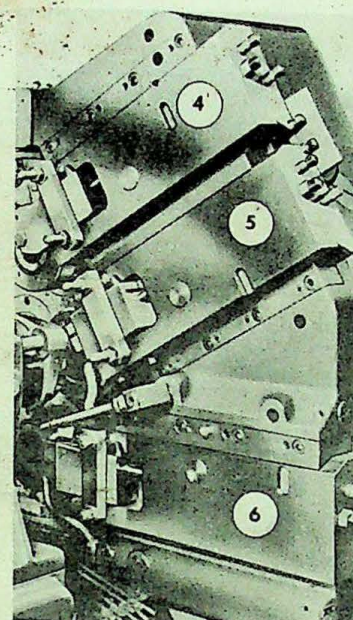
FORMING SLIDE UNIT



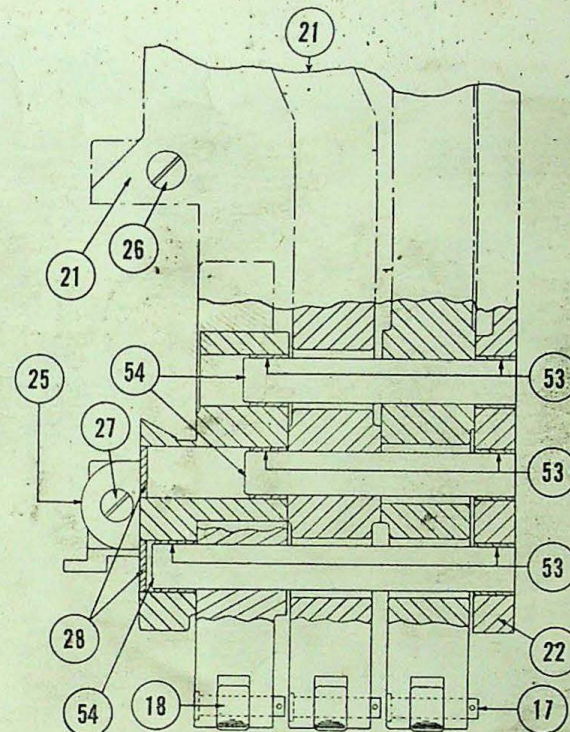
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS



Front Forming
Slide Unit



Rear Forming
Slide Unit



Nylon

KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	6	Tool adj. screw nuts	1576YL	16	1	Oil valve (1st pos.)	3059YL	32	3	W-04 lockwashers	1735GB
2	6	Tool adj. screw bushings	1549YL	17	12	Lever roller shafts	3060YL	33	3	Ball lock springs	593V
3	5	Stop adjusting screws	918YM	18	12	Lever rollers	3067YL	34	3	5/16" steel balls	3282GB
4	5	Stop adj. screw nuts	916YM	19	1	F. S. bracket (front)	YL550-2	35	3	Ball lock screws	3773YL
5	6	F. S. wedges (bottom)	143YL	20	1	Bracket cover (front)	YL551-1	36	3	Standard lock nuts	544V
6	6	F. S. wedges (side)	413YA	21	1	F. S. bracket (rear)	YL569-2	37	30	1/4" hdless. set screws	2198GB
7	6	Wedge guide plates	414YA	22	1	Bracket cover (rear)	YL570-1	38	30	Comp. wheel adj. screws	1335YM
8	6	Wedge guide screws	1797GB	23	1	Lever sleeve	3064YL	39	30	Set screw plugs	YA465
9	6	F. S. wedge screws	2304YG	24	1	Oil valve (2nd pos.)	3058YL	40	2	1/2" x 1/2" set screws	2214GB
10	24	1/2" Allen cap screws	2109GB	25	1	Coolant valve bracket	YL533X	41	6	F. S. wedge springs	123BX
11	12	1/2" Allen set screws	2189GB	26	1	Oil valve (5th pos.)	3101YG	42	6	Spring guide rod	8804YL
12	12	1/2" Allen set screws	2188GB	27	1	Oil valve (6th pos.)	7475YL	43	6	F. S. stud blocks	1555YL
13	1	Cam shaft support brg.	YL521X	28	2	Plugs	YS309	44	6	F. S. lever wedges	YL390
14	6	Tool clamps	276YA	29	3	Star wheels	4824YL	45	4	F. S. bracket plugs	4273YL
15	12	Tool clamp studs	699YG	30	3	Comp. shaft collars	4825YL	46	12	Clamp stud washers	1164V
		1/2" hex. head nuts	2314GB	31	3	Comp. shaft nuts	2357YL				

Forming Slide Unit Parts List Continued On Next Page

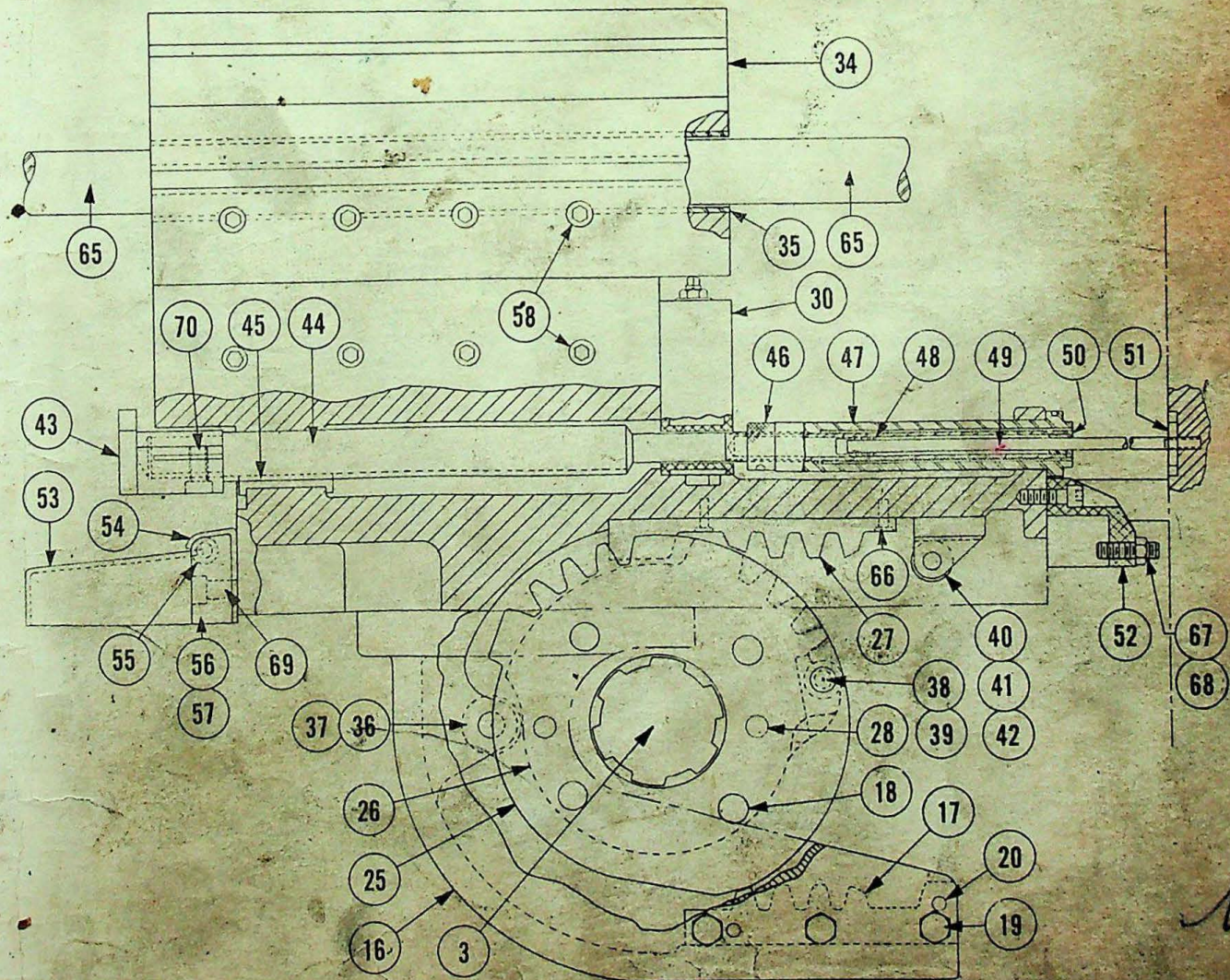
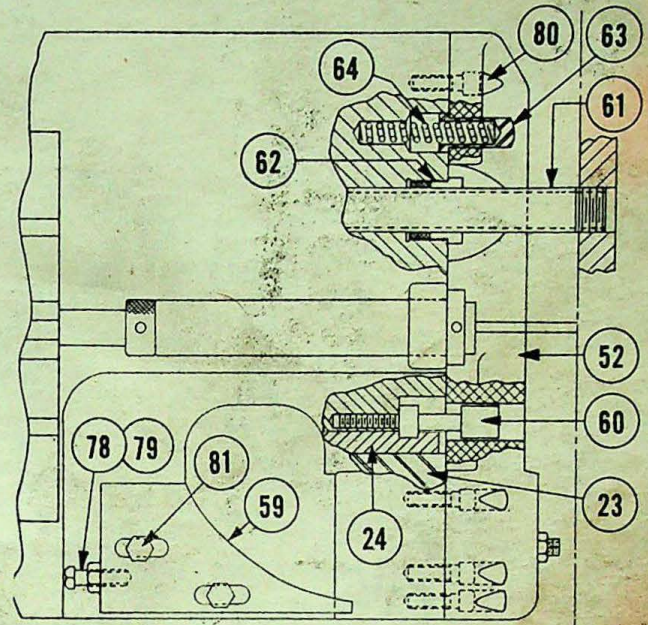
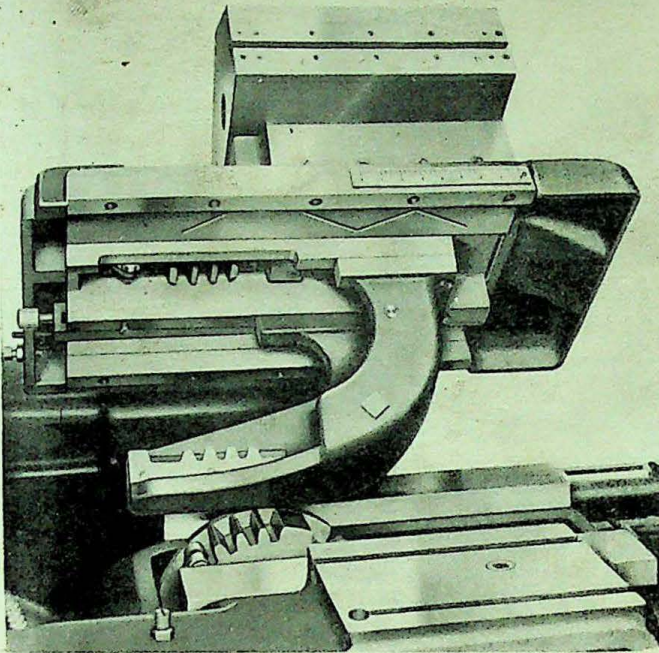
FORMING SLIDE UNIT PARTS LIST (CONT'D)

Order Following Parts According to Position on Machine

KEY	NAME OF PART	NO. REQD. EACH POS.	1ST POSITION	2ND POSITION	3RD POSITION	4TH POSITION	5TH POSITION	6TH POSITION
47	Forming slide	1	3090YL	30 91YL	3092YL	30 91YL	3092YL	3093YL
48	Wedge adj. screw (bottom)	1	3076YL	1548YL	1548YL	1548YL	1548YL	3112YL
49	Wedge adj. screw (side)	1	3075YL	1547YL	1547YL	1547YL	1547YL	3111YL
50	Tool adj. screw	1	3074YL	280YA	280YA	280YA	280YA	3110YL
51	Tool clamp screws	2	412YA	1930YA	412YA	1930YA	412YA	1930YA
52	Form slide lever stud	1	282YA	5144YL	5144YL	5144YL	5144YL	5145YL
53	Form slide lever shaft bush.	2	3120YL	3119YL	3119YL	3119YL	3119YL	3119YL
54	Form slide lever shaft	1		5163YL	30 61YL	30 61YL	30 61YL	3103YL
55	Form slide gib	1	YL395X2	YL523X1	YL524X1	YL523X1	YL524X1	YL519X1
56	Form slide gib pins	4	635YA	2130YL	635YA	2130YL	635YL	2130YL
57	Compensating wheel shaft	1	4823YL	4822YL	4822YL	4822YL	4822YL	
58	Compensating wheel	1	YL792	YL793	YL793	YL793	YL793	
59	Comp. wheel support plate	1	8263YL	82 61YL	826 1YL	8262YL	8262YL	
60	Compensating wheel cover	1	YL605B	YL604B	YL604B	YL604B	YL604B	
61	F. S. lever spring (outer)	1		6506YL	6508YL	6508YL	6506YL	
62	F. S. lever spring (inner)	1		6507YL	6509YL	6509YL	6507YL	
63	Form slide lever spring	1	8194YL					8194YL
64	Form slide lever arms	1	YL734	YL735	YL736	YL725	YL726	YL727
65	Spring stud tip	1		6820YL	6820YL	6820YL	6820YL	
66	Spring guide	1		YL1159	YL1159	YL1159	YL1159	
67	Spring seat plug	1		7470YL	7470YL	7470YL	7470YL	
68	Spring stud	1		7472YL	7469YL	7469YL	7472YL	
69	Spring coupling	1	8209YL					8209YL
70	Spring adjusting nut	1	8196YL					8196YL
71	Spring anchor pin	1	2130YL					2130YL
72	No. 1-XLO lock screw	1	3402GB					3402GB
73	Spring coupling pin	1	8805YL					8805YL

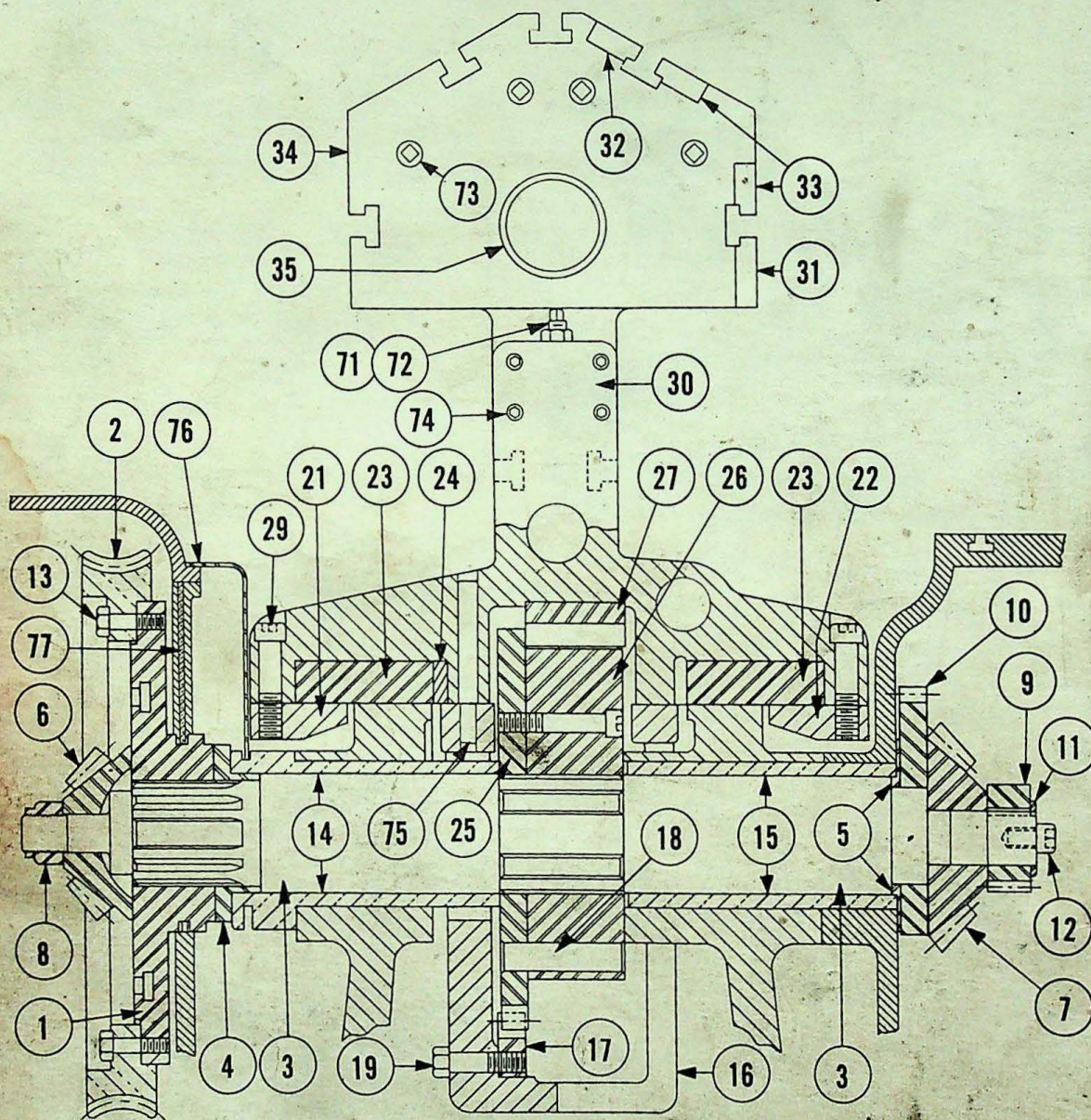
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

TOOL SLIDE



Parts List on page 15

TOOL SLIDE (Cont'd)



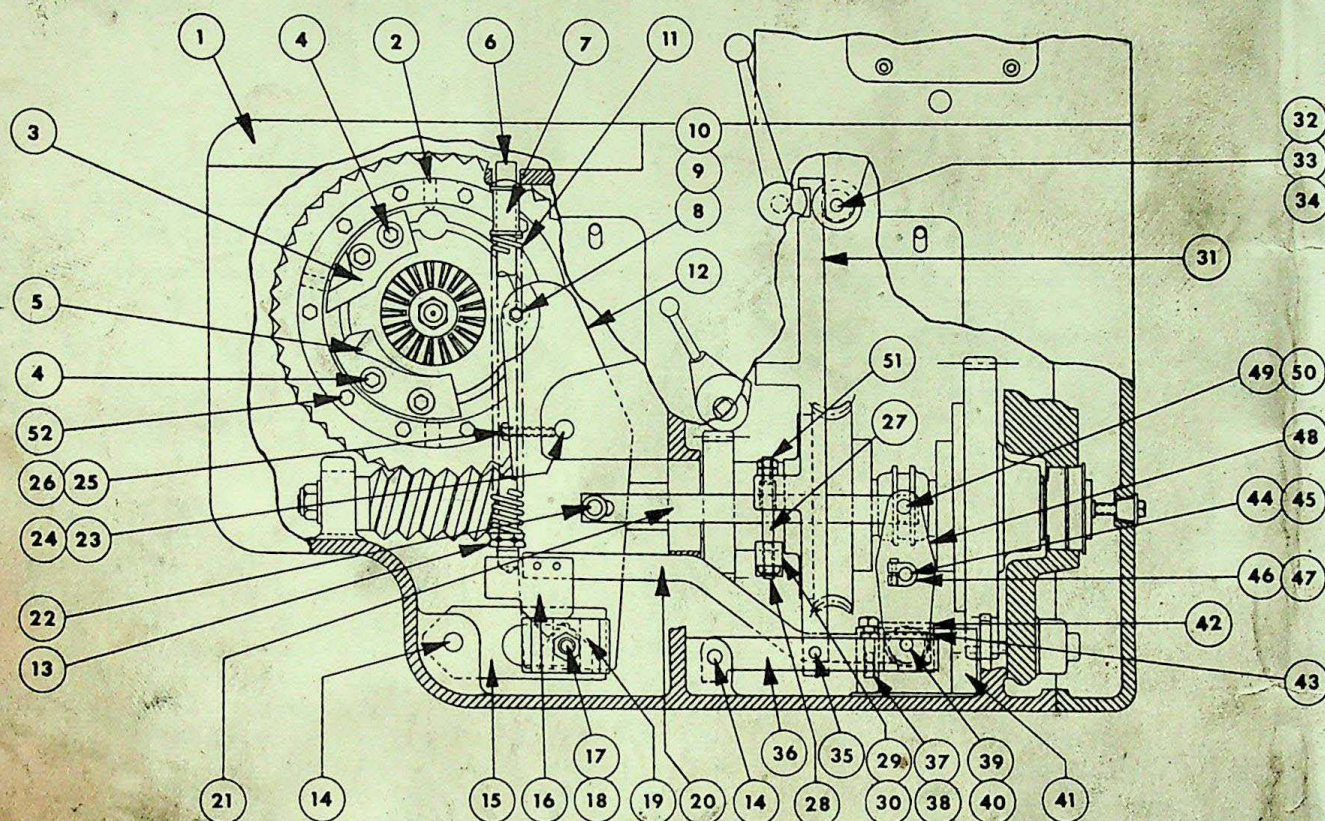
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

Tool Slide Parts List

KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Worm gear spider	7424YL	42	1	Roller pin	292YA
2	1	Tool slide worm gear	YL312-X	43	1	Stock stop	3052YL
3	1	Intermittent shaft	8181YL	44	1	Stock stop rod	3050YL
4	1	Gear spider spacer	8183YL	45	1	Stop rod key	973YL
5	1	Shaft spacer (rear)	8182YL	46	1	Stock stop lock nut	2571YL
6	1	Bevel gear (front)	3008YL	47	1	Stock rod adj. sleeve	1581YA
7	1	Bevel gear (rear)	3009YL	48	1	Stock stop rod spring	8807YL
8	1	1" Castellated nut	2343GB	49	1	Stock stop rod pin	8806YL
9	1	Threading return gear	7580YL	50	1	Stock stop rod plug	1446YL
10	1	Threading feed gear	7579YL	51	1	Stop rod sleeve insert	6657YA
11	1	Intermittent shaft washer	1174V	52	1	Rear chip guard	YL692-2X
12	1	$\frac{1}{2}$ x 1" cap screw	2099GB	53	1	Front chip guard	8045YL
13	10	$\frac{3}{8}$ x $1\frac{1}{2}$ " cap screws	1810GB	54	1	Front guard shield	8044YL
14	1	Shaft bushing (front)	YL432-1	55	1	Chip guard trunnion	8043YL
15	1	Shaft bushing (rear)	YL355-Y	56	1	Front guard block	YL1355
16	1	Return rack bracket	YL439-1	57	1	Rear guard block	YL1356
17	1	Return rack	1425YL	58	24	$\frac{3}{4}$ x $\frac{5}{8}$ " oil plugs	2225GB
18	4	Feed gear dowel pins	1096YL	59	1	Threading reset cam	4255YL
19	3	$\frac{1}{2}$ x 2" cap screws	1832GB	60	1	Gib adjusting screw	1729YA
20	2	$\frac{3}{8}$ " std. dowels	1101V	61	1	Slide oil pipe	3044YL
21	1	Front gib	YL693	62	1	Oil pipe gland	1394YA
22	1	Rear gib	YL693X	63	2	Plungers	3002YL
23	2	Steel ways	4109YL	64	2	Plunger springs	2519YA
24	1	Tool slide taper gib	YA270-1	65	1	Spindle drive shaft	3147YL
25	1	Tool slide return gear	1424YL	66	4	Feed rack lock screws	1529YG
26	1	Tool slide feed gear	1423YL	67	1	$\frac{3}{8}$ x $1\frac{3}{4}$ " set screw	2174GB
27	1	Feed rack	7645YL	68	1	$\frac{3}{8}$ " jam nut	2323GB
28	2	$\frac{1}{2}$ x $2\frac{1}{2}$ " cap screws	2105GB	69	2	$\frac{1}{2}$ x $1\frac{1}{4}$ " cap screws	2100GB
29	15	$\frac{5}{8}$ x $2\frac{1}{4}$ " cap screws	2123GB	70	2	$\frac{1}{2}$ x $1\frac{1}{2}$ " cap screws	2101GB
30	1	Oil case	YL518	71	1	$\frac{3}{8}$ x 1" set screw	1942GB
31	1	Tool slide clamp strip	4443YL	72	1	$\frac{3}{8}$ " jam nut	2323GB
32	1	Tool slide clamp strip	4440YL	73	4	$\frac{3}{8}$ " pipe plugs	1683GB
33	2	Tool slide clamp strips	4442YL	74	5	$\frac{3}{8}$ x $2\frac{1}{4}$ " cap screws	2081GB
34	1	Tool slide	YL517-2X	75	2	Dowel pins	2123YL
35	1	Coolant retainer pipe	3466YL	76	1	Splash guard	7478YL
36	1	Return gear roller	2859YG	77	1	Worm gear spider cover	2680YL
37	1	Return gear roller pin	294YA	78	1	$\frac{3}{8}$ x $1\frac{1}{4}$ " set screw	1944GB
38	2	Feed gear rollers	2791YG	79	1	$\frac{3}{8}$ " jam nut	2323GB
39	1	Roller pin	1094YL	80	5	$\frac{3}{8}$ x $2\frac{1}{4}$ " cap screws	2081GB
40	1	Feed rack bracket	YL274X	81	2	$\frac{1}{2}$ x $1\frac{3}{4}$ " cap screws	1831GB
41	1	Feed rack roller	2332YG				

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

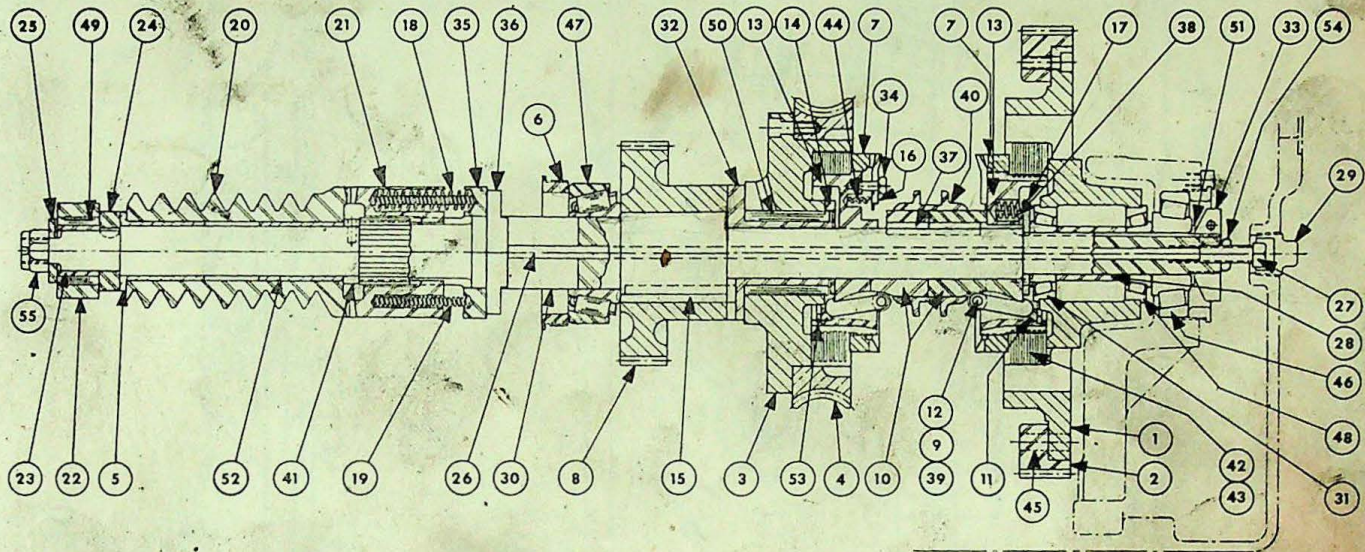
CLUTCH CONTROL MECHANISM



KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Worm gear case cover	YL338-1	27	1	Stud	1514YA
2	2	Keys	3006YL	28	1	$\frac{1}{2}$ " Castellated nut	2338GB
3	1	Speed trip dog	762YM	29	1	Brake arm	3154YL
4	4	"T" bolts	2418YG	30	1	Brake arm shaft	2358YL
5	1	Feed trip dog	1226YM	31	1	Clutch control bar	4124YL
6	1	Control lever spring rod	439YA	32	1	Clutch oper. rack roller	4461YL
7	1	Spring rod collar	440YA	33	1	Roller pin	764V
8	1	Clutch con. roller shaft	1420YL	34	1	Plug	YL1130
9	1	Clutch control dog roller	95YM	35	1	Pin	728V
10	1	Roller shaft washer	543YM	36	1	Clutch operating bar	1867YL
11	1	Control lever spring	1615YL	37	1	$\frac{3}{8}$ " x 2-1/4" set screw	1948GB
12	1	Glutch control lever	YL346	38	1	$\frac{3}{8}$ " jam nut	2323GB
13	2	$\frac{3}{4}$ " jam nuts	2327GB	39	1	Shifting lever roller pin	1523YL
14	2	Pivot pins	4256YL	40	1	Shifting lever roller	1462YL
15	1	Control lever stop plate	1430YL	41	1	Bumper	3001YL
16	1	Clutch control plunger	YM212	42	1	Plunger	1736YL
17	1	Trip lever fulcrum stud	1422YL	43	1	Pin retainer	2027YL
18	1	$\frac{3}{4}$ " Castellated nut	2336GB	44	1	Shifting lever shaft	1467YL
19	1	Trip lever fulcrum	YL342B	45	1	Plug	YL384
20	1	Clutch control link	1464YL	46	1	Split collar	1047YL
21	1	Safety link	1429YL	47	1	$\frac{1}{2}$ " x $1\frac{1}{2}$ " cap screw	2216GB
22	1	Pin	787V	48	1	Clutch shifting lever	YL343
23	1	Clutch lever shaft	1419YL	49	1	Shifter shoe (front)	YL682
24	1	Lever shaft spacer	1421YL	50	1	Shifter shoe (rear)	YL681
25	1	$\frac{1}{2}$ " x 3" set screw	1961GB	51	2	$\frac{1}{2}$ " jam nuts	2325GB
26	1	$\frac{1}{2}$ " jam nut	2325GB	52	10	$\frac{3}{8}$ " x $1\frac{1}{2}$ " cap screws	1810GB

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

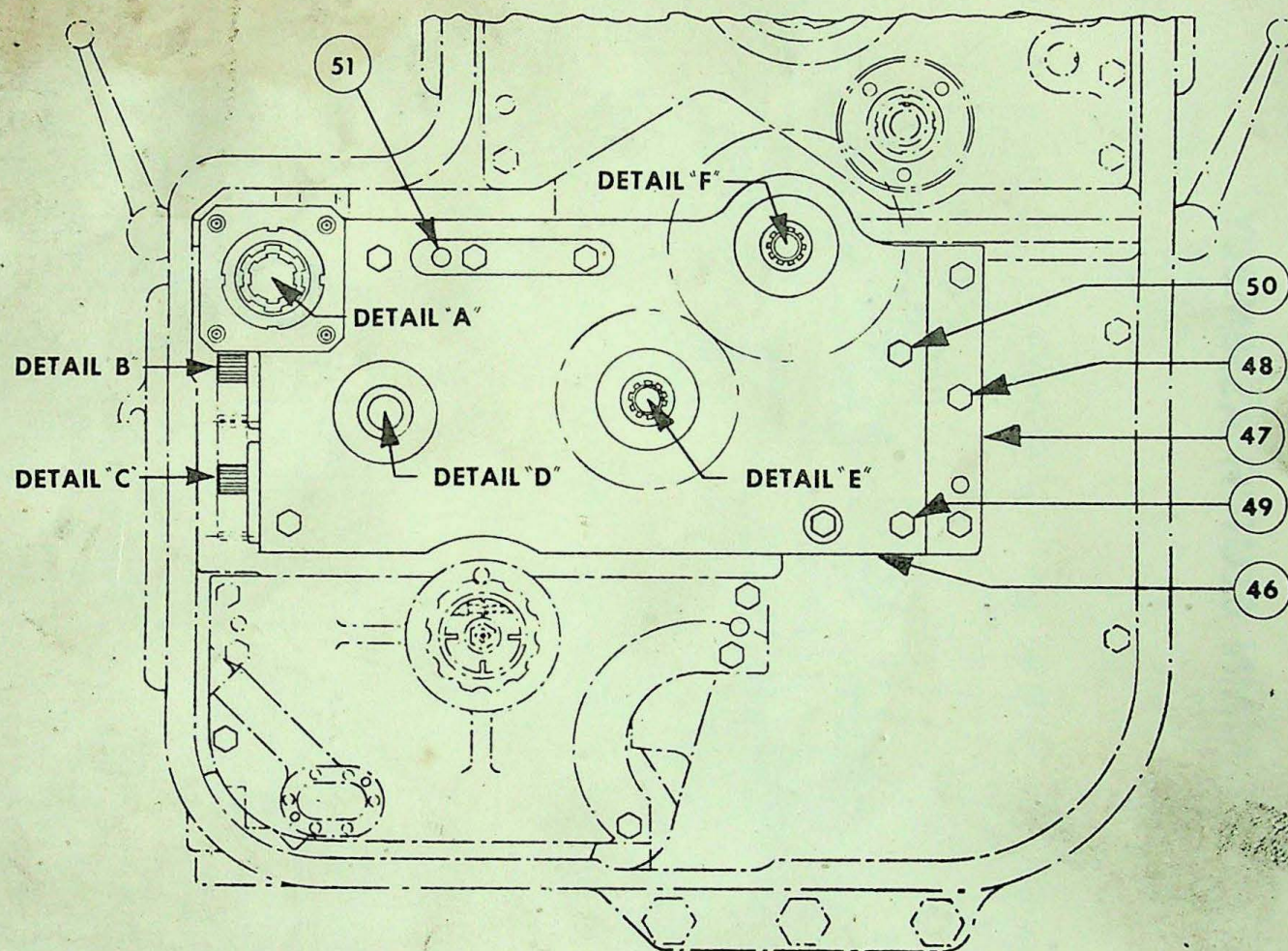
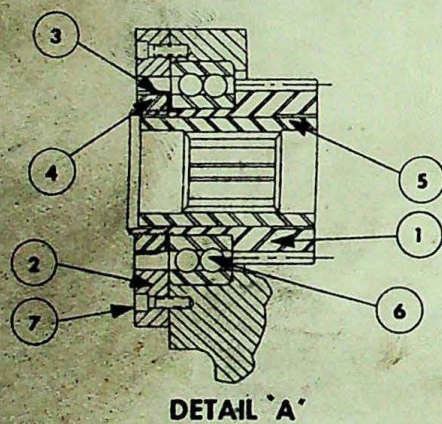
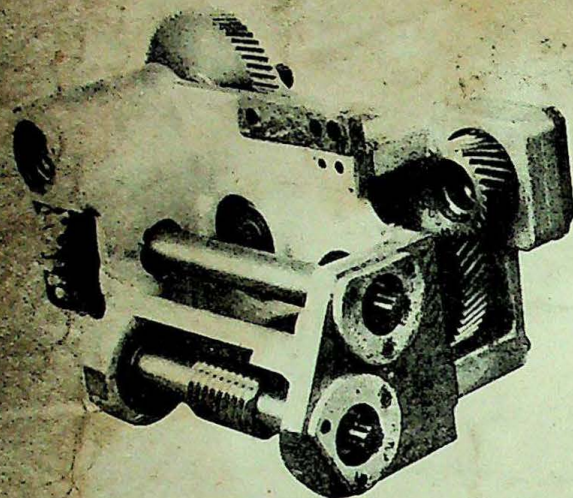
MAIN CLUTCH ASSEMBLY



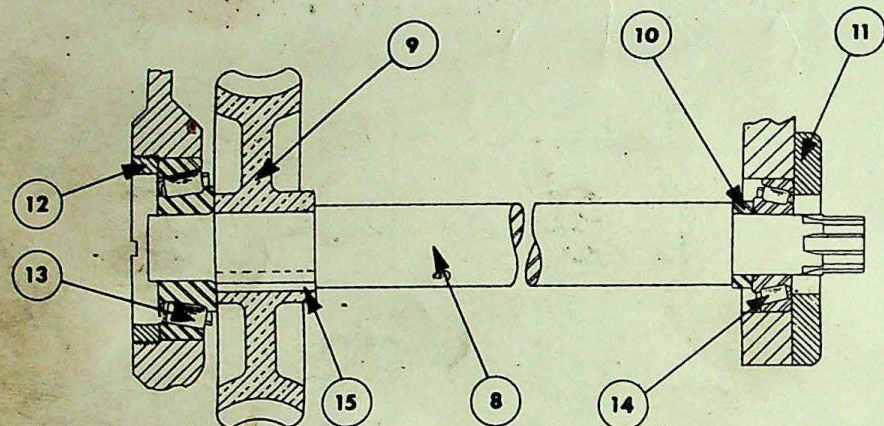
KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Hi-speed gear spider	YA866-2	29	1	Pipe plug (Make from 1" std. pipe plug)	7870YL
2	1	Hi-speed gear	1258YA	30	1	Main clutch shaft	7871YL
3	1	Worm wheel spider	YL313X	31	1	Clutch shaft brg.	7872YL
4	1	Feed worm wheel	YM74	32	1	Spider brg. bush.	89YM
5	1	Dr. worm bush.	YM106	33	1	Main clutch shaft nut	544YM
6	1	Brg. adj. nut	YM162X	34	2	Cap screws	1231YM
7	2	Clutch thrust nuts	YM163X	35	1	Spring plate	127YG
8	1	Hand feed gear	YM332	36	1	Clutch adj. plate	129YG
9	4	Clutch lever rollers	2559YA	37	2	Clutch sleeve keys	1838YG
10	2	Clutch oper. sleeves	2633YA	38	4	Clutch drive springs	2496YG
11	2	Pivot rings	2635YA	39	4	Roller pins	2559YG
12	4	Clutch oper. levers	2638YA	40	1	Clutch oper. sleeve	2560YG
13	2	Clutch drivers	2639YA	41	1	Spacing washer	2825YG
14	1	Spider brg. washer	2651YA	42	14	Clutch discs (outer)	2912YG-V
15	1	Key - Hand feed gear	5698YA	43	14	Clutch discs (inner)	2913YG
16	2	Clutch dr. nut keys	7348YA	44	2	Springs for 7348YA	724-2
17	1	Spr. thrust washer	7640YA	45	2	Std. dowels	1100V
18	8	Safety clutch springs	1616YL	46	1	Timken #2 (443-432)	148GB
19	12	Safety clutch springs	2016YL	47	1	Timken #2 (532A-539)	166GB
20	1	Dr. worm	2338YL	48	1	Timken #2 (14125-1427GB)	311GB
21	1	Safety clutch	2339YL	49	1	1 1/2" x 1-1/4" bearing	400GB
22	1	Outer race	5107YL	50	1	1-7/8" x 2 1/2" bearing	413GB
23	1	Inner race	5108YL	51	1	W-06 SKF lockwasher	1737GB
24	1	Spacing collar	5109YL	52	1	F-1276 bushing	2776GB
25	1	Main clutch shaft washer	5110YL	53	2	50-400 Waldes snap rings	805GB
26	1	Clutch adj. rod	7867YL	54	1	1/2" hardened jam nut	2325GB
27	1	Clutch adj. scr.	7868YL	55	1	3/4" Castellated nut	2341GB
28	1	Brg. spacer	7869YL				

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

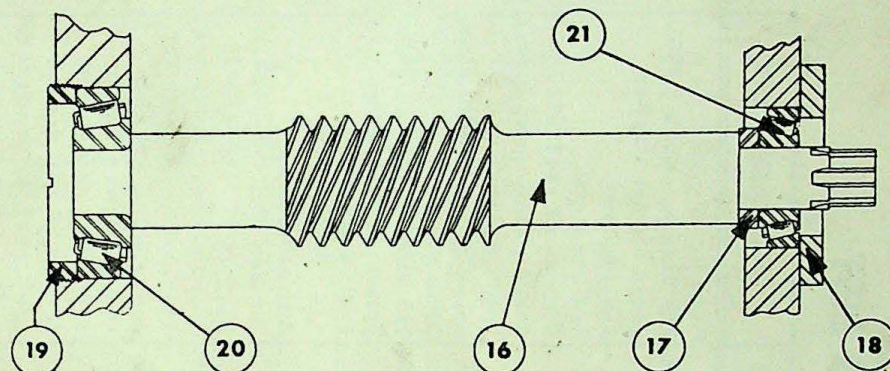
PICK-OFF UNIT



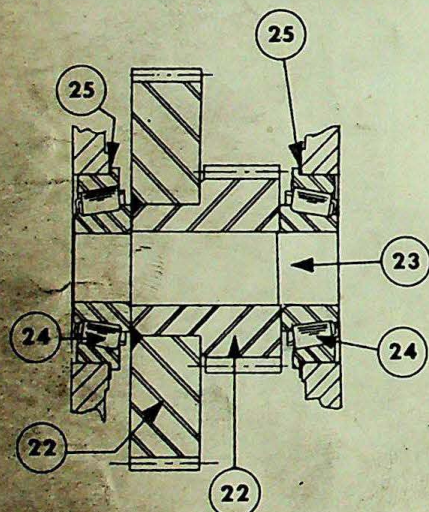
PARTS LIST ON PAGE 20



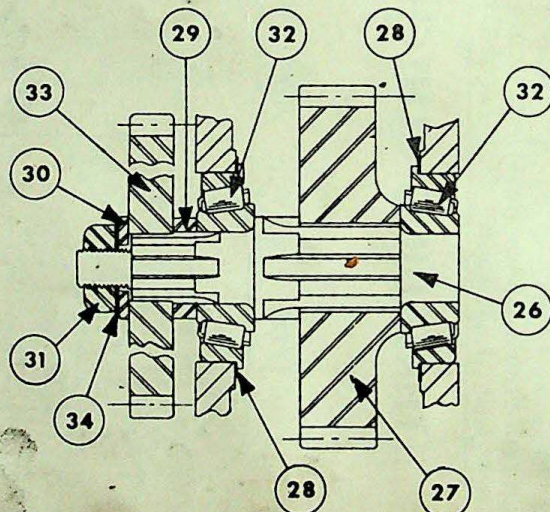
DETAIL 'B'



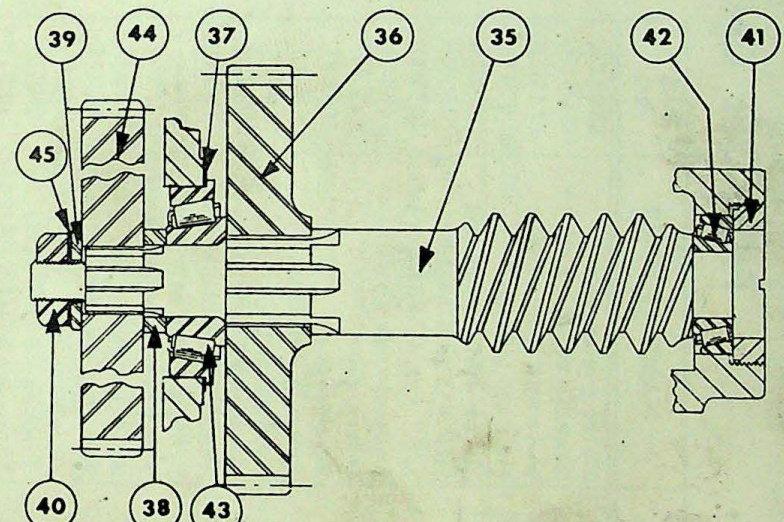
DETAIL 'C'



DETAIL 'D'



DETAIL 'E'



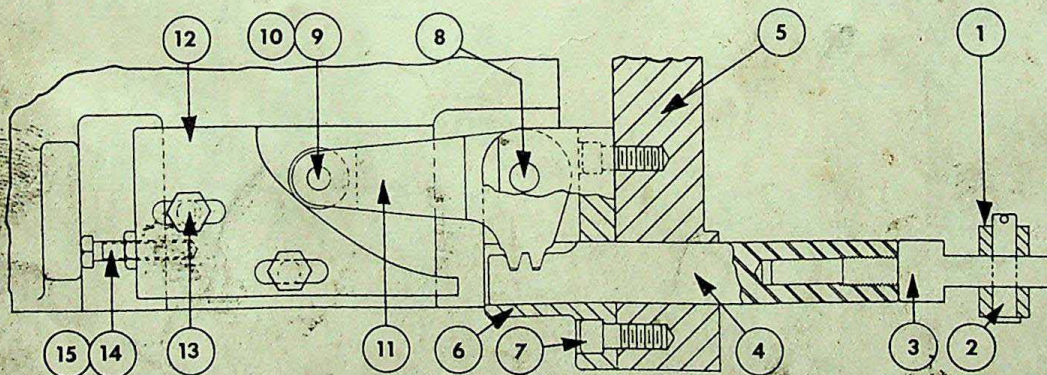
DETAIL 'F'

PARTS LIST ON FOLLOWING PAGE

PICK-OFF UNIT PARTS LIST

KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Motor pinion gear	2598YL	27	1	Gear	1407YL
2	1	Bearing retainer	YL328	28	To Suit	#15 Timken shims (.005)	3298GB
3	1	W-14 SKF lockwasher	1745GB	29	1	Speed change washer	1720YL
4	1	#14 SKF locknut	554V	30	1	3/4" washer	1316V
5	1	Motor pinion coupling	1413YL	31	1	3/4" hex. nut	2341GB
6	1	SKF #5214-R ball bearing	23GB	32	2	Timken #2 (449 432B)	151GB
7	4	3/8" x 3/4" cap screws	2075GB	33	1	Speed change gear (order as reqd.)	1729GB
8	1	Feed change shaft	1414YL	34	1	3/4" lockwasher	1416YL
9	1	Worm gear	YL79	35	1	Speed change worm shaft	3553YL
10	1	Shaft spacer	1668YL	36	1	Gear	3298GB
11	1	Bearing retainer	YM178	37	To Suit	#15 Timken shims (.005)	1720YL
12	1	Adjusting nut	YM169	38	1	Speed change washer	1316V
13	1	Timken #2 (449-432)	150GB	39	1	3/4" washer	2341GB
14	1	Timken #2 (14118-14283)	308GB	40	1	3/4" hex. nut	YM170
15	1	3/8" x 3/8" key (std. keystock)	1417YL	41	1	Adjusting nut	308GB
16	1	Feed change worm shaft	1668YL	42	1	Timken #2 (14118-14283)	151GB
17	1	Shaft spacer	YM178	43	1	Timken #2 (449-432B)	1729GB
18	1	Bearing retainer	YM169	44	1	Speed change gear (order as reqd.)	YL294B
19	1	Adjusting nut	150GB	45	1	3/4" lockwasher	YL295B
20	1	Timken #2 (449-432)	308GB	46	1	Drive unit front plate	1849GB
21	1	Timken #2 (14118-14283)	7542YL	47	1	Drive unit rear plate	1861GB
22	1	Front gear	7545YL	48	6	5/8" x 2" cap screws	2132GB
23	1	Back gear shaft	151GB	49	3	5/8" x 5" cap screws	1137V
24	2	Timken #2 (449-432B)	3298GB	50	2	5/8" x 4-3/4" cap screws	
25	To Suit	#15 Timken shims (.005)	1410YL	51	2	3/4" x 5/8" dowel pins	
26	1	Speed change shaft					

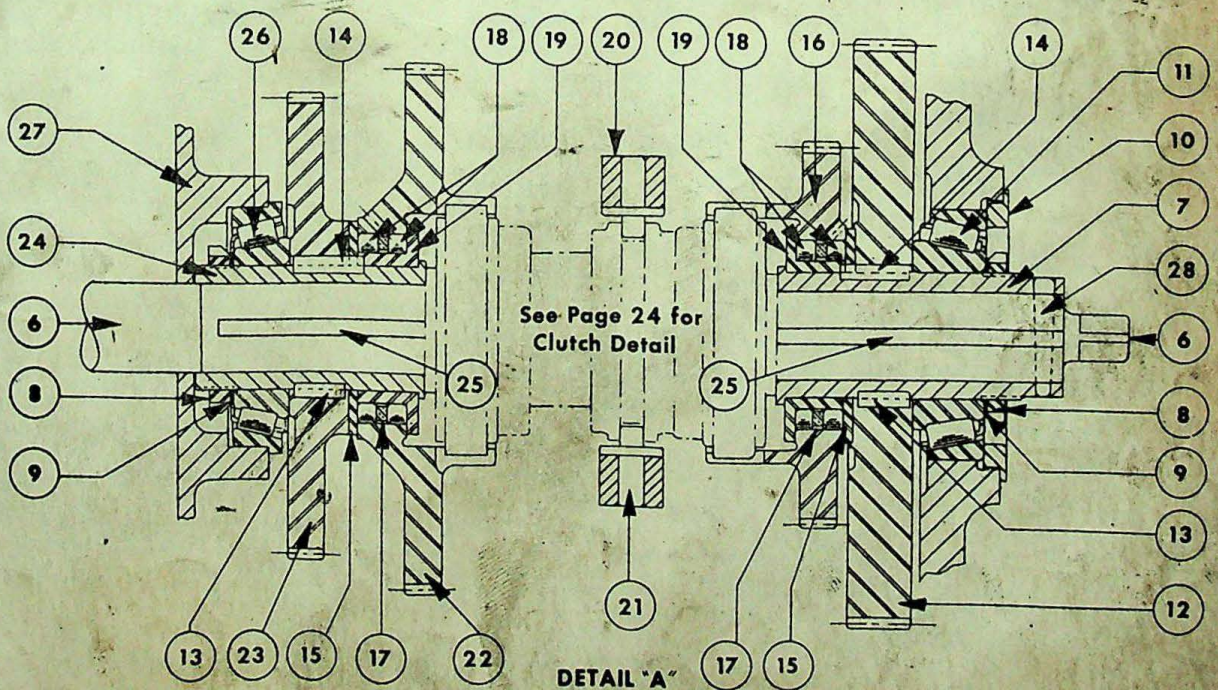
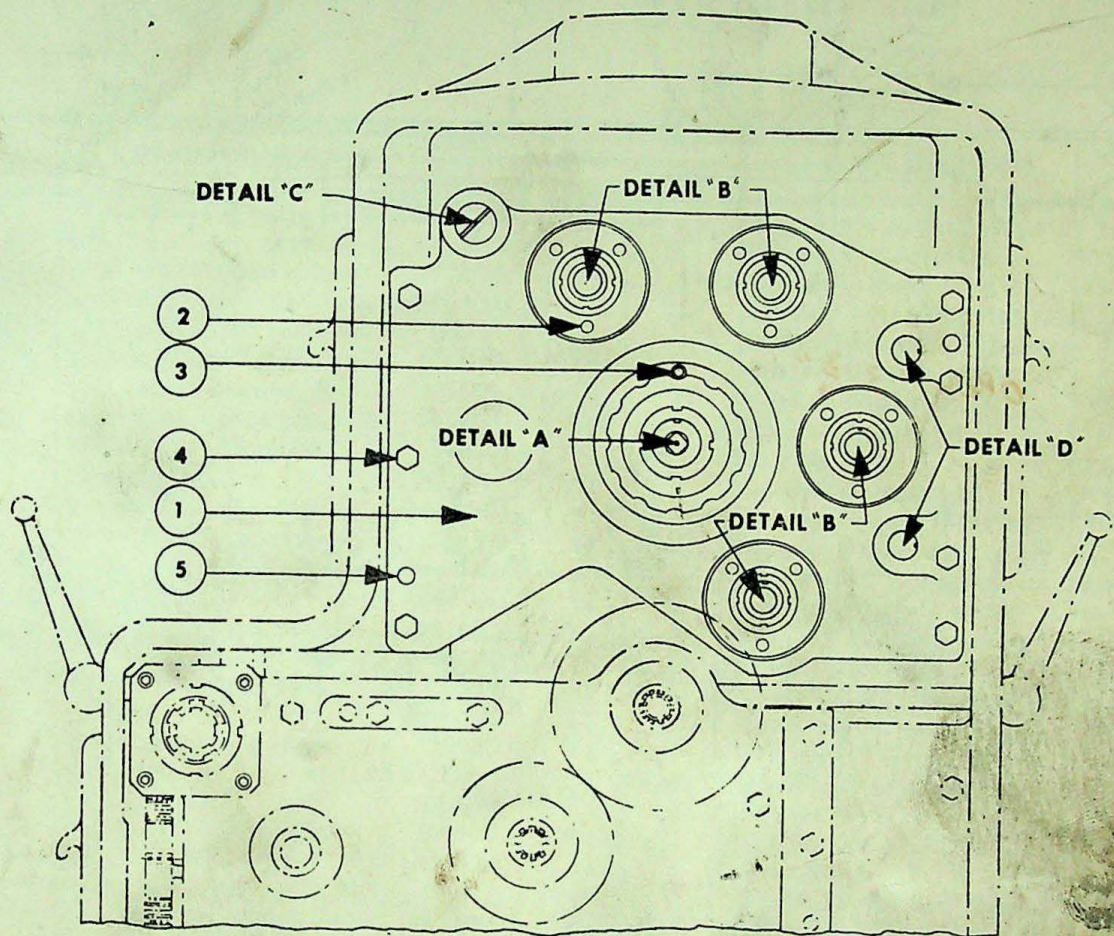
THREADING CLUTCH RE-SET MECHANISM



KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Shifter fork	YL552-3	9	1	Reset lever roller	4146YL
2	1	Reset shaft pin	729V	10	1	Reset lever roller pin	1022V
3	1	Reset shaft head	4414YA	11	1	Reset lever	YL689
4	1	Reset shaft	5385YL	12	1	Threading reset cam	4255YL
5	1	Gear box threading cover	YL520-3Y	13	2	1/2" x 1-3/4" cap screws	1831GB
6	1	Reset lever bracket	YL744	14	1	3/8" x 1-1/4" set screw	1944GB
7	2	1/2" x 1" cap screws	2099GB	15	1	3/8" jam nut	2323GB
8	1	Reset lever pin	1048V				

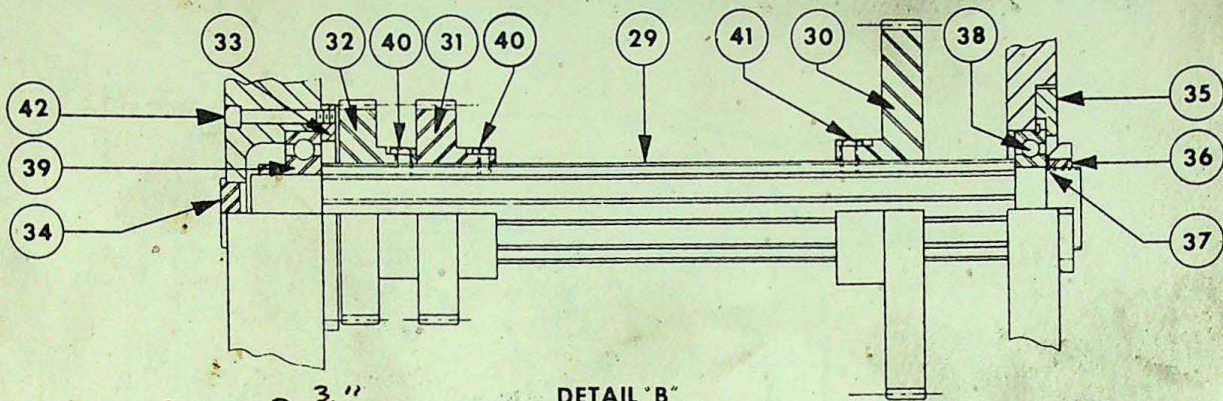
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

THREADING DRIVE UNIT



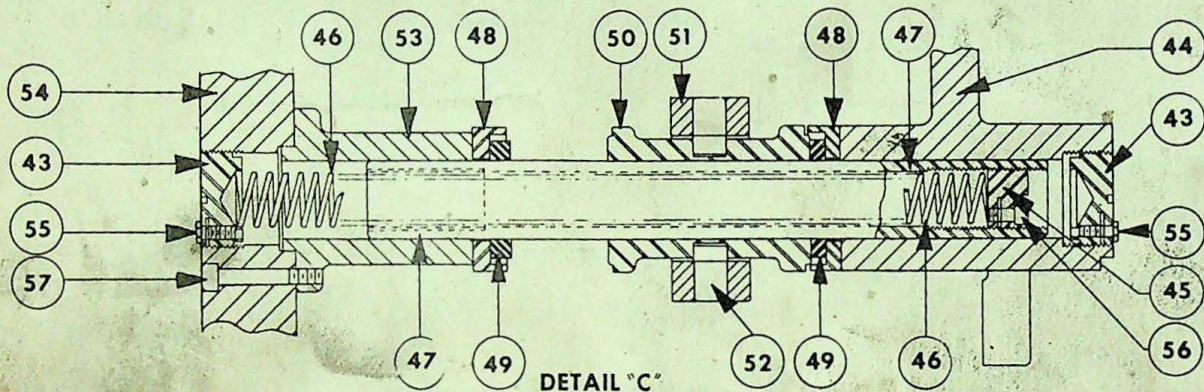
PARTS LIST ON PAGE 23

THREADING DRIVE UNIT (CONT'D)

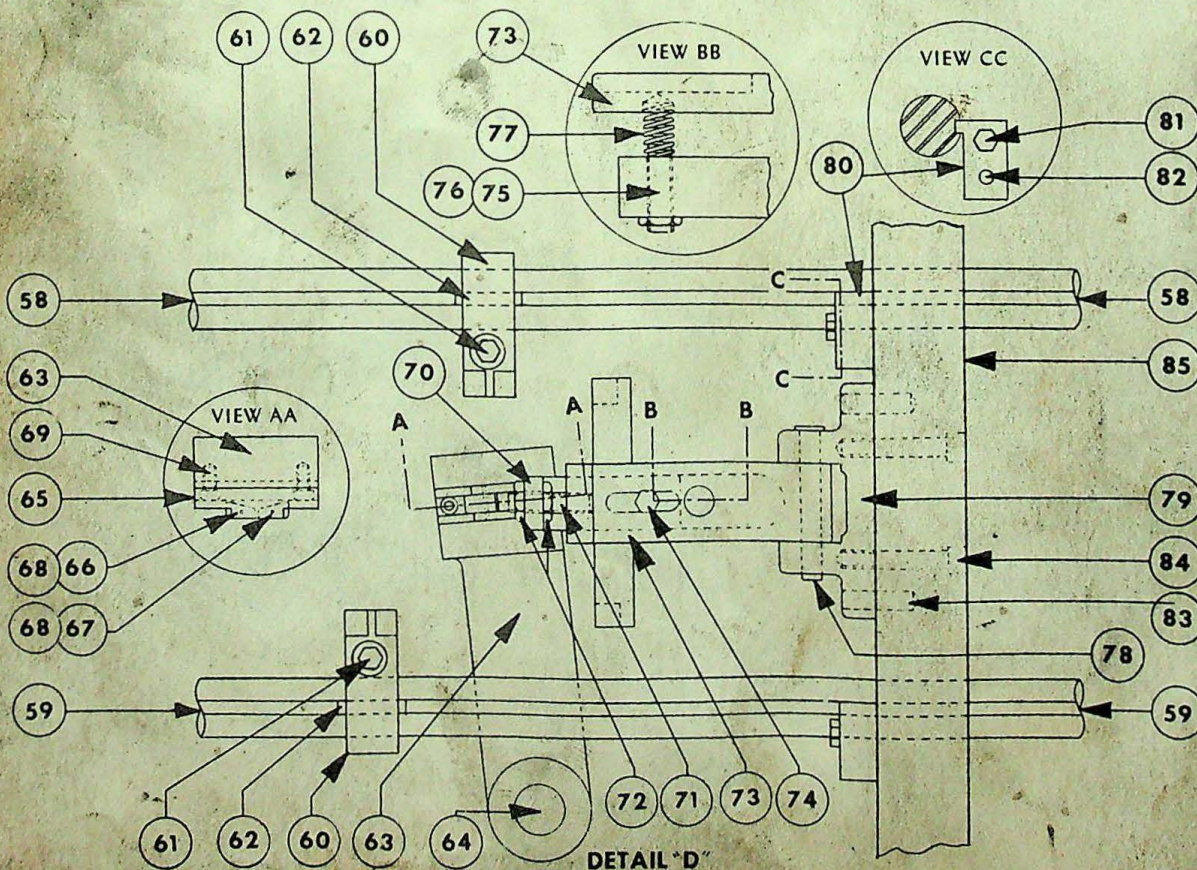


Open 3 $\frac{3}{4}$ "

DETAIL "B"



DETAIL "C"



DETAIL "D"

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

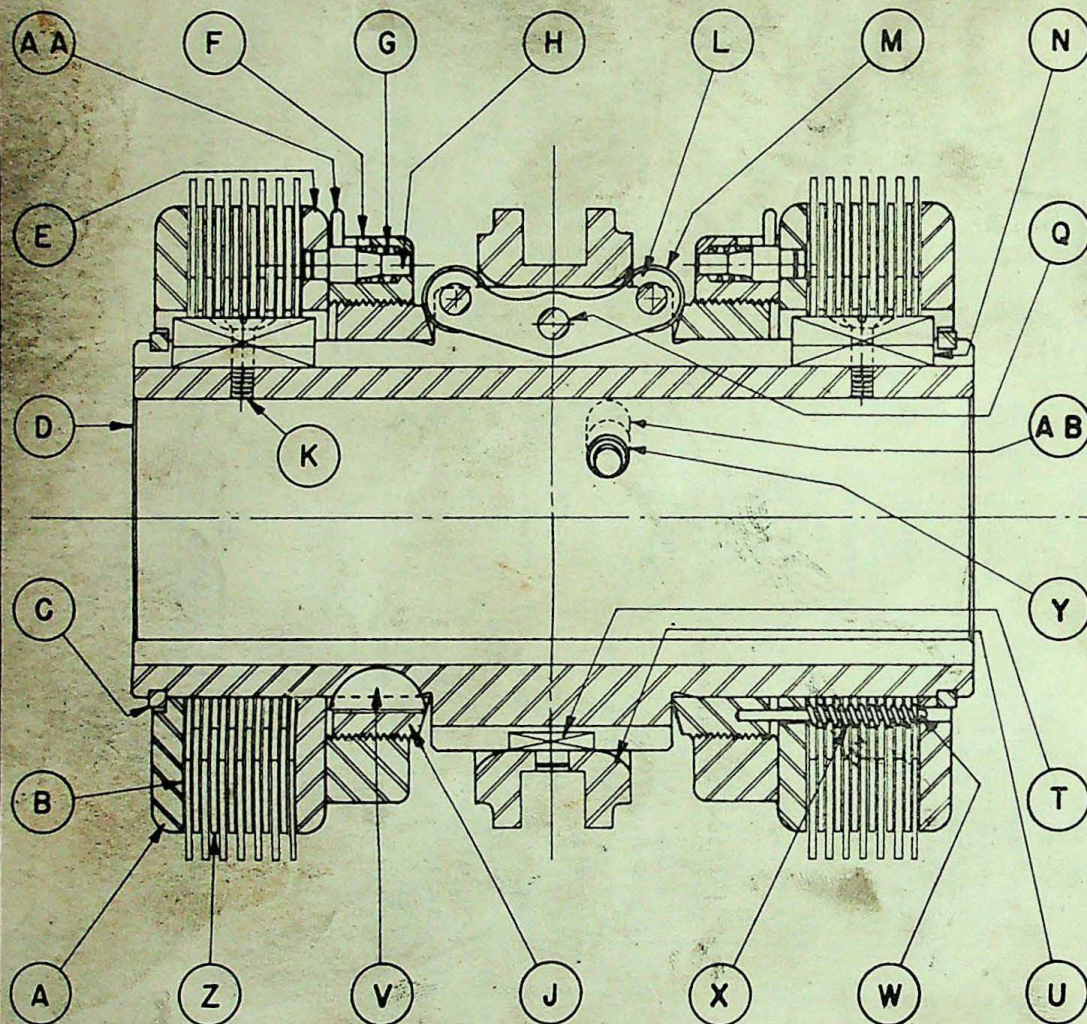
THREADING DRIVE UNIT PARTS LIST

KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Front bearing plate	YL549-IX1	43	2	Brg. plate spring plugs	1286YA
2	12	5/16" x 1" cap screws	1799GB	44	1	Front bearing plate	YL549-IX1
3	1	3/8" x 5/8" cap screw	2074GB	45	1	Control sleeve plug	1390YL
4	7	5/8" x 2" cap screws	1849GB	46	1	Control sleeve spring	1625YL
5	2	3/4" x 5/8" dowel pins	1137V	47	1	Shifter fork control sleeve	2914YA
6	1	Spindle drive shaft	3147YL	48	2	Control sleeve washers	2909YA
7	1	Spdl. drive sleeve (R.H.)	YL603	49	2	Rubber washers	4322YL
8	2	Spindle drive sleeve nuts	2437YL	50	1	Operating sleeve	2910YA
9	1	W-13 SKF lockwasher	1744GB	51	1	Shifter fork	YL552-3
10	1	Bearing adjusting nut	YL386	52	2	Operating fork pin	457YA
11	1	Timken #2 (563-565)	176GB	53	1	Control sleeve bearing	YA437X6
12	1	Spindle drive gear	3554YL	54	1	Gear box threading cover	YL520-3Y
13	1	3/8" x 1-5/16" key (std. keystack)		55	2	1/4" x 5/8" cap screws	2049GB
14	1	3/8" x 1-3/8" key (std. keystack)		56	1	1/4" x 1/2" cap screw	1885GB
15	2	Drive gear spacers	2444YL	57	3	5/16" x 2" cap screws	2066GB
16	1	Thrd. drive gear (R.H.)	3165YL	58	1	Clutch cont. rod, pos. 3,4	4238YL
17	2	Roller bearing cages	YL479	59	1	Clutch cont. rod, pos. 5,6	4239YL
18	48	3/8" x 3/8" rollers	248GB	60	2	Split trip collars	4249YL
19	2	Bearing inner race	3199YL	61	2	3/8" x 1 1/2" cap screws	2078GB
20	1	Shifter fork	YL552-3	62	2	Trip collar keys	2285YA
21	2	Clutch shifting pins	YL680	63	1	Shifter fork	YL552-3
22	1	Thrd. drive gear (L.H.)	5666YL	64	2	Shifter fork shafts	3131YL
23	1	Hi-speed drive gear	4253YL	65	1	Trip block	5291YL
24	1	Spdl. drive sleeve (L.H.)	YL602	66	1	Trip block insert (left)	5293YL
25	1	Spindle drive shaft key	2956YL	67	1	Trip block insert (right)	5292YL
26	1	Timken #2 (472B-483)	159GB	68	2	1/8 x 41/64" McGill rolls	261GB
27	1	Gear box threading cover	YL520-3Y	69	2	5/16" x 5/8" cap screws	2060GB
28	1	Taper pin	2416GB	70	1	Trip lever insert	7218YL
29	1	Spindle spline sleeve	YL566X1	71	1	Trip plate adjusting stud	4141YL
30	1	Thrd. spindle gear (R.H.)	4338YL	72	2	5/16" jam nuts	2322GB
31	1	Thrd. spindle gear (L.H.)	5665YL	73	1	Trip lever and extensions	7221YL
32	1	Hi-speed spindle gear (None reqd. for 6th pos.)	3255YL	74	1	3/8" x 3/4" cap screw	1806GB
33	1	Bearing retainer	YA290	75	1	3/8" x 1 1/2" set screw	2013GB
34	1	Threading cover insert	1286YM	76	1	3/8" jam nut	2323GB
35	1	Rear bearing retainer	YL1131	77	1	Trip lever spring	148ER
36	1	Locknut	548V	78	1	Trip lever pin	706V
37	1	W-08 SKF lockwasher	1739GB	79	1	Trip lever bracket	YL709
38	1	#43208 New Dept. bearing	47GB	80	2	Control rod keys	YL688
39	1	#WIR 208 Fafnir bearing	667GB	81	2	5/16" x 1-1/4" cap screws	1800GB
40	2	Cap screws	2925YA	82	2	5/16" x 1-1/8" dowel pins (drill rod)	
41	1	Cap screw	2924YA	83	2	3/8" x 1" dowel pins	1099V
42	18	5/16" x 2" cap screws	2066GB	84	2	5/16" x 2" cap screws	2066GB
				85	1	Gear box threading cover	YL520-3Y

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

THREADING DRIVE CLUTCH

XA3810 MODEL MTU7045 TWIN DISC CLUTCH
SPECIFICATION NO. 18101

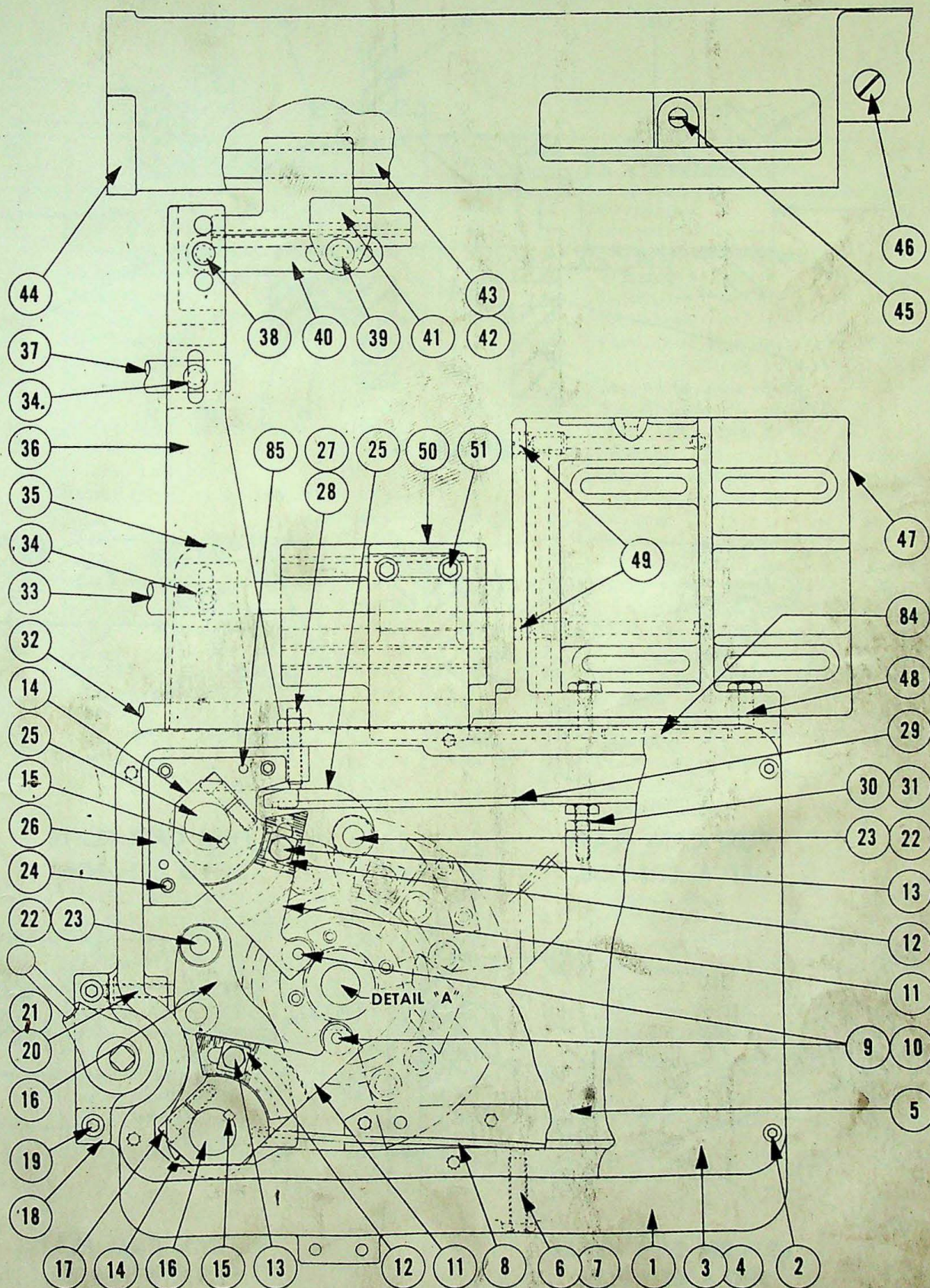


SYMBOL NO.	PART NO.	NO. REQD.	DESCRIPTION
"D"	A5756	1	Hub Bore 1.750-1.749 Keyway 5/16 x 5/32
"V"	M275	2	Woodruff Keys (#91) 1/4 x 3/4
"Y"	M514	1	Half Dog Pt. Set Screw (3/8-16NC x 1/2)
"AB"	M783	1	Cup Pt. Set Screw (3/8-16NC x 1/4)
"U"	A3672	1	Engaging Cone
"T"	A1959	1	Cone Key
	A1960	1	Instruction Plate
	M422	4	Drive Screws
	X-194	1	Miscellaneous Clutch Parts
"N"	A2519	6	Drive Keys
"L"	A2434	6	Levers
"K"	M1043	6	Flat Hd. Machine Screws (8-32NC x 7/16)
"F"	A2084A	2	Adjusting Rings
"H"	2466A	2	Adjusting Lock Pins
"G"	2469	2	Adjusting Lock Pin Springs
"AA"	2467	2	Pins
"A"	A2076	2	Back Plates
"B"	3764	14	Driving Plates
"Z"	A2078A	12	Driven Plates
"X"	A1802	6	Release Springs
"E"	A2079A	2	Lock Plates
"W"	A2679B	6	Release Spring Pins
"C"	A2085	2	Snap Rings
"J"	A2080	2	Roller Rings
"Q"	A2594C	3	Lever Pins
"M"	A2506	6	Rollers

WHEN ORDERING CLUTCH PARTS ALWAYS INCLUDE THE SPECIFICATION NUMBER

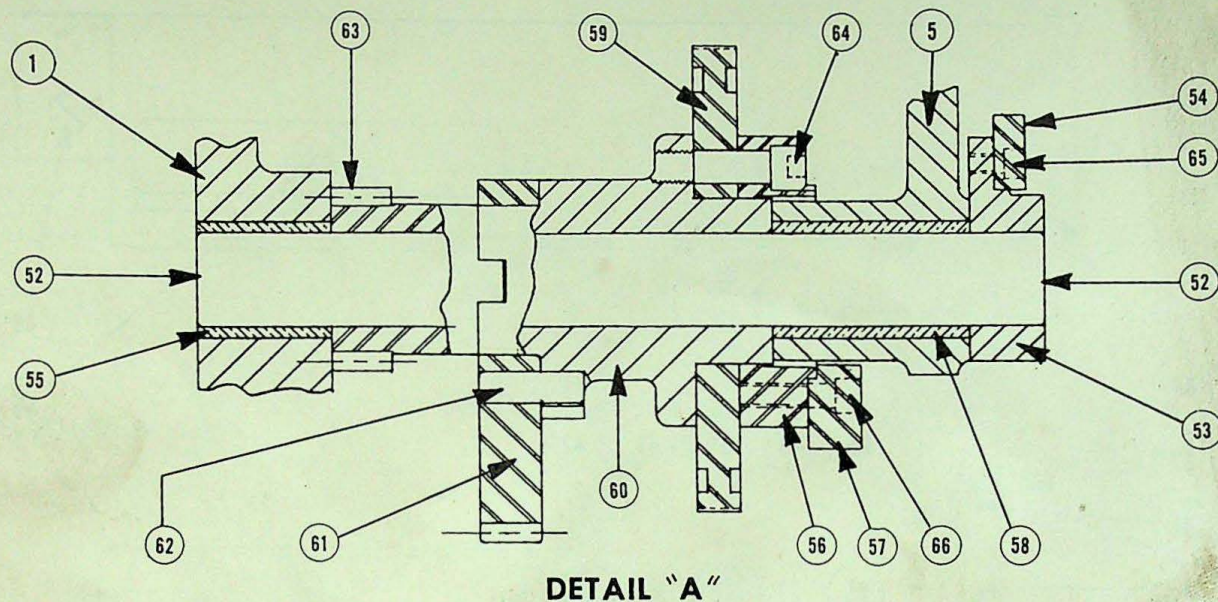
Drawing and Parts List Reproduced by Permission of Twin Disc Clutch Company, Racine, Wisconsin

THREADING FEED ASSEMBLY

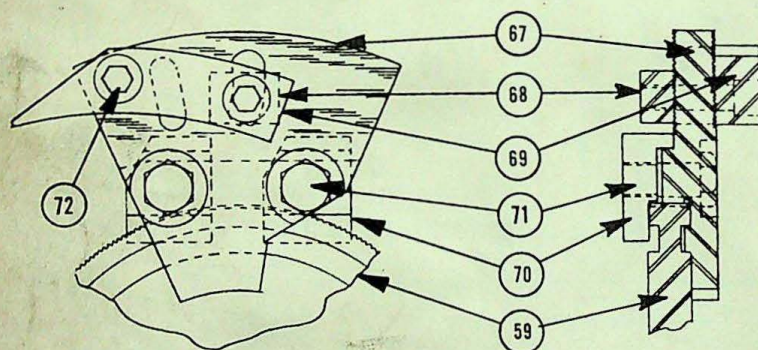


PARTS LIST ON PAGE 27

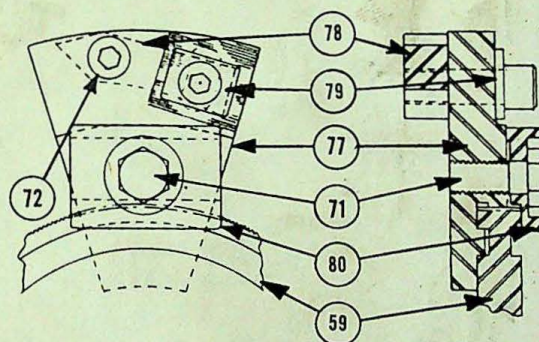
THREADING FEED ASSEMBLY (CONT'D.)



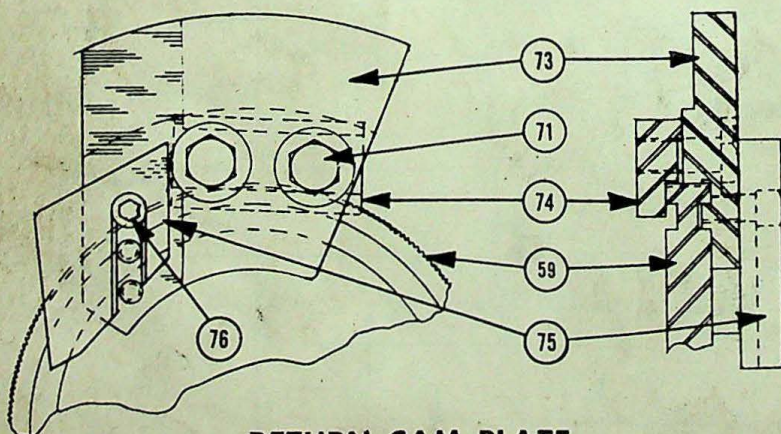
DETAIL "A"



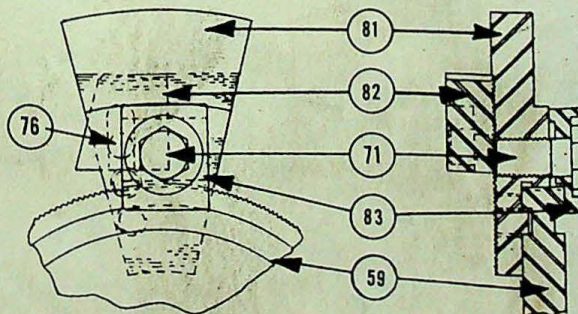
FEED CAM PLATE
3RD & 4TH POS.



FEED CAM PLATE
5TH & 6TH POS.



RETURN CAM PLATE
3RD & 4TH POS.



RETURN CAM PLATE
5TH & 6TH POS.

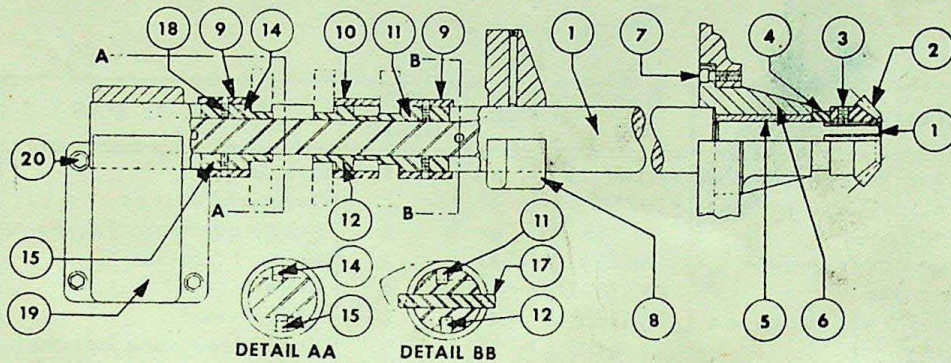
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

THREADING FEED ASSEMBLY PARTS LIST

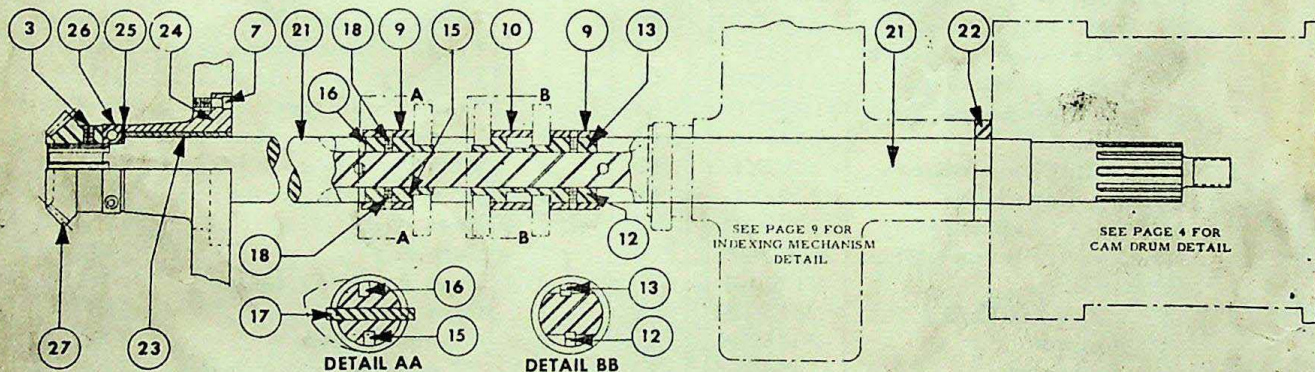
KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Thrd. mechanism housing	YL308-2X	44	1	Overarm	YL582-2
2	6	3/8" x 3/4" cap screws	2075GB	45	2	Overarm valves	678YA
3	1	Housing cover	YL756	46	2	3-way overarm valves	1348YA
4	1	Housing cover gasket	6942YL	47	1	Support bracket	YL534-1
5	1	Lower plate	YL320-1	48	4	T-bolts	741YL
6	1	5/8" x 5" sq. hd. screw	1991GB	49	2	Oil valves	678YA
7	1	5/8" jam nut	2326GB	50	1	Thrd. feed shoe bracket	YL540
8	1	Lower spring	1459YL	51	2	1/2" x 1-3/4" cap screws	2102GB
9	2	Rollers	1911YL	52	1	Threading cam shaft	3869YA
10	2	Pins	2922YL	53	1	Quick approach cam hub	YA757-1
11	2	Quick appr. cam levers	8783YL	54	1	Quick appr. cam (3 & 4)	7181YA
12	2	Lock plates	8785YL	55	1	Bushing	YL348
13	2	Clamp screws	2972YL	56	1	Cam mounting plate	1136YA
14	2	Quick approach lever hub	8783YL	57	1	Quick appr. cam (5 & 6)	7174YA
15	2	Keys (std. keystick)	YL450X1	58	1	Bushing	YL347X
16	1	Cam roller lever 4th pos.	YL450X1	59	1	Cam spider	3913YL
17	2	1/2" x 1 1/2" cap screws	2101GB	60	1	Threading cam hub	YL443
18	1	Hand feed sleeve bracket	YL317	61	1	Thrd. return driven gear	1910YL
19	2	1/2" x 1 1/2" cap screws	2101GB	62	2	1/2" x 5/8" step dowels	1136V
20	1	1/2" x 2" set screw	1957GB	63	1	Thrd. feed driven gear	4969YL
21	1	1/2" jam nut	2325GB	64	2	1/2" x 1 1/2" cap screws	2101GB
22	2	Threading cam rollers	3022YL	65	2	5/16" x 3/4" cap screws	2061GB
23	2	Cam roller shafts	3021YL	66	1	1/2" x 2 1/2" cap screw	2105GB
24	3	3/8" x 1" cap screws	2076GB	67	1	Feed cam plate	2967YL
25	1	Cam roller lever 3rd pos.	YL319-2	68	1	Cam dog	1448YL
26	1	Upper plate	YL501-1	69	1	Feed cam lock plate	1945YL
27	1	1/2" x 2 1/2" set screw	2055GB	70	2	Cam clamps	2971YL
28	1	1/2" jam nut	2325GB	71	2	Clamp screws	2972YL
29	1	Upper spring	1458YL	72	4	1/2" x 1-1/4" cap screws	2100GB
30	1	1/2" x 1 1/2" cap screws	2101GB	73	1	Return cam plate	3025YL
31	1	1/2" jam nut	2325GB	74	1	Cam clamp	3023YL
32	1	Feed shoe guide bar	3129YL	75	1	Return cam	3024YL
33	1	Clutch control rod (5 & 6)	4239YL	76	2	3/8" x 1/2" cap screws	2073GB
34	2	Pins	1189V	77	1	Feed cam plate	2969YL
35	1	Feed lever (5 & 6)	YL539-X	78	1	Cam dog	1781YL
36	1	Feed lever (3 & 4)	YL537-1	79	1	Feed cam lock plate	1944YL
37	1	Clutch control rod	4238YL	80	1	Cam clamp	2970YL
38	1	Feed lever link pin	783V	81	1	Return cam plate	7526YL
39	1	Feed lever link pin	787V	82	1	Return cam	7525YL
40	1	Feed lever link	3449YA	83	1	Cam clamp	3026YL
41	1	Feed shoe bracket	YL538	84	1	Key	1281YA
42	1	Stationary guide bar	595YA	85	2	1/2" x 1 1/2" dowels	1110V
43	1	Feed shoe guide bar	3138YL				

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

FRONT CAM SHAFT



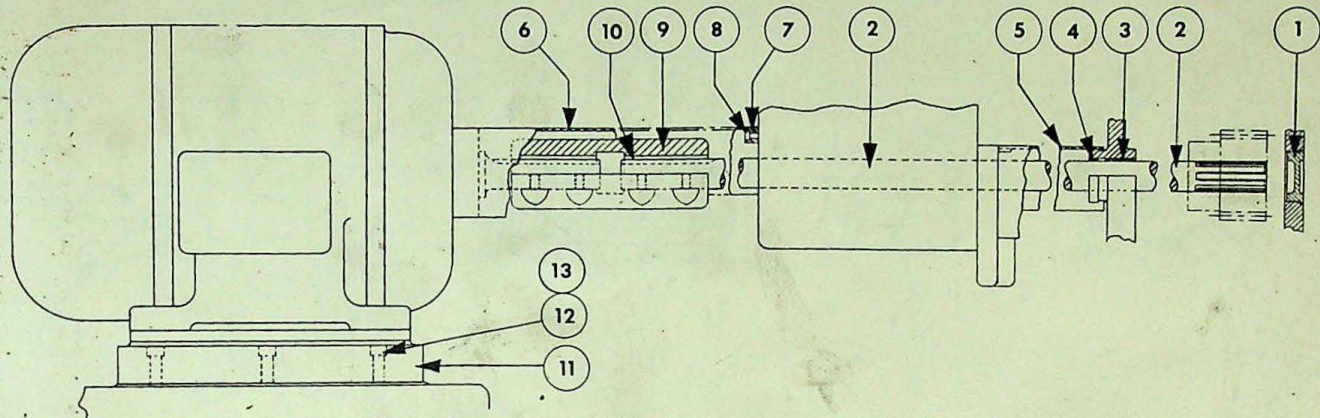
REAR CAM SHAFT



KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Front cam shaft	3142YL	15	2	Cam carrier keys	3073YL
2	1	Bevel gear	7223YL	16	1	Cam carrier key	3069YL
3	2	$\frac{1}{2}$ " x $\frac{1}{2}$ " set screws	2152GB	17	4	Cam driven pins	3045YG
4	1	Bevel gear spacer	1477YL	18	8	$\frac{5}{16}$ " x $\frac{5}{8}$ " cap screws	2060GB
5	1	Cam shaft brkt. bushing	YM95X	19	1	Cam shaft supp. bracket	YL300
6	1	Cam shaft bracket	YM94X	20	4	$\frac{1}{2}$ " x 1- $\frac{1}{4}$ " cap screws	2100GB
7	4	$\frac{1}{2}$ " x 1" cap screws	2099GB	21	1	Rear cam shaft	4214YL
8	1	Cam shaft supp. bracket	YL521-X	22	1	Cam drum spacer	3387YL
9	4	Cam carrier spacers	3063YL	23	1	Cam shaft brkt. bushing	YL354
10	2	Cam carrier spacers	3062YL	24	1	Cam shaft bracket	YL316
11	1	Cam carrier key	3070YL	25	1	Bevel gear spacer	7224YL
12	2	Cam carrier keys	3072YL	26	1	Cam shaft clamp collar	7232YL
13	1	Cam carrier key	3071YL	27	1	Bevel gear	7225YL
14	1	Cam carrier key	3068YL				

ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

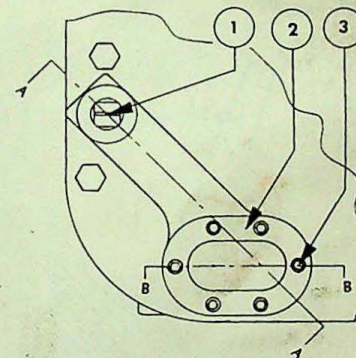
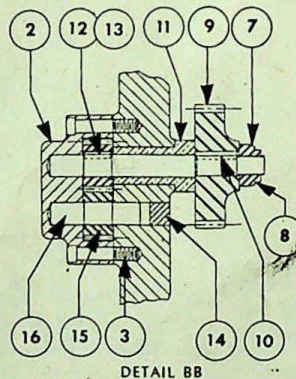
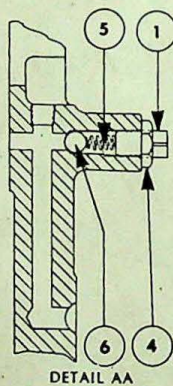
MOTOR DRIVE



KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Plug	YL456X
2	1	Motor shaft extension	1473YL
3	1	A-1901 Oilite bearing	3 331GB
4	1	Motor shaft oil retainer	YL943
5	1	Motor shaft guard (front)	329YA
6	1	Motor shaft guard (rear)	4201YL
7	1	Guard support	2007YL

KEY	NO. REQD.	NAME OF PART	PART NO.
8	2	1/4" x 1" cap screws	2051GB
9	1	Motor coupling	YL718
10	1	Motor shaft key	1559YL
11	1	Motor bracket	YL480
12	3	1/2" x 1-3/4" cap screws	2102GB
13	3	5/8" x 2-1/4" cap screws	2123GB

LUBRICATING PUMP

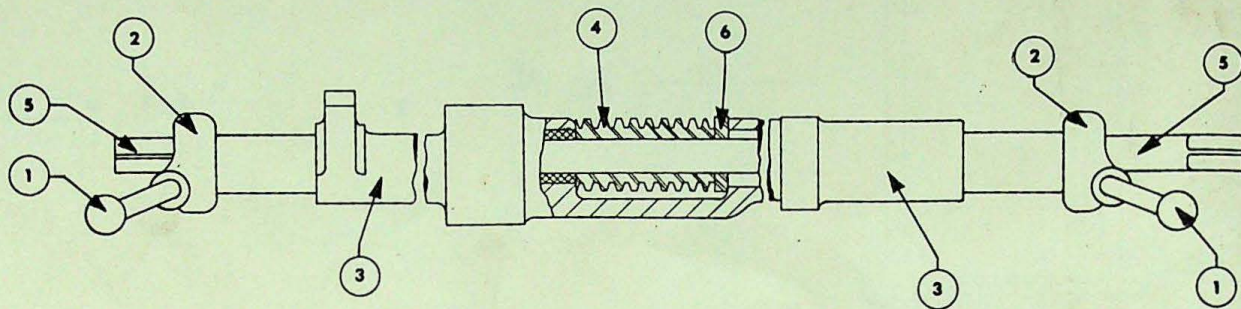


KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Spring retainer plug	192YM
2	1	Oil pump body	YS470
3	6	5/16" x 2" cap screws	2066GB
4	1	3/4" jam nut	2327GB
5	1	1-7/8" spring	598V
6	1	1/2" steel ball	3284GB
7	1	1/2" Castellated nut	2325GB
8	1	Drive shaft	586YM

KEY	NO. REQD.	NAME OF PART	PART NO.
9	1	Drive gear	1409YL
10	1	Key (std. keystock)	
11	1	Drive shaft bushing	YA425
12	1	Drive shaft gear	6621YS
13	1	Key (std. keystock)	
14	1	Plug	YL1160
15	1	Pump shaft gear	6620YS
16	1	Pump shaft	1992YS

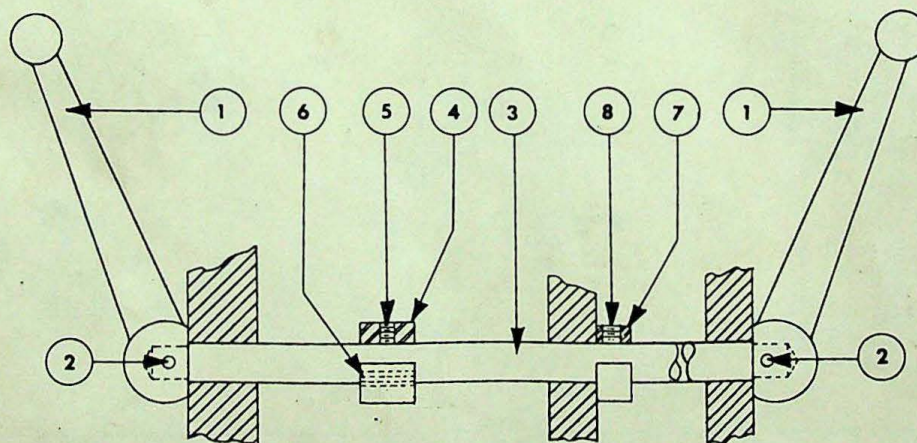
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

HAND FEED SLEEVE ASSEMBLY



KEY	NO. REQD.	NAME OF PART	PART NO.
1	2	Hand feed sleeve handles	2089YM
2	2	Hand feed sleeve hubs	YM283
3	1	Hand feed sleeve	YL310-1
4	1	Hand feed worm gear	1415YL
5	1	Hand feed worm shaft	1478YL
6	1	Washer	1261V

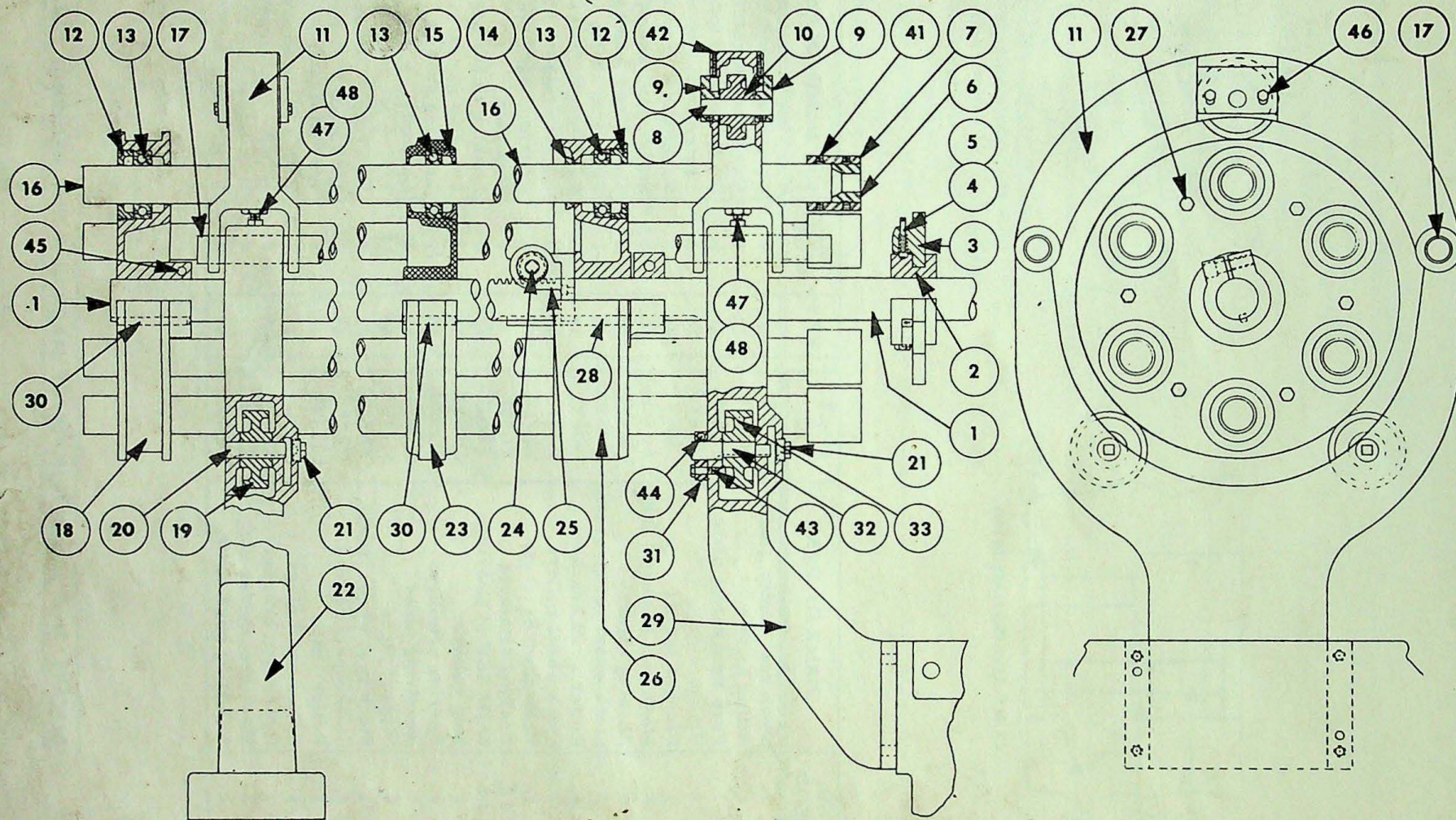
FEED CONTROL ASSEMBLY



KEY	NO. REQD.	NAME OF PART	PART NO.
1	2	Operating handles	887YA
2	2	#4 x 1 1/2" taper pins	2401GB
3	1	Operating shaft	4971YL
4	1	Clutch operating cam	2505YA
5	1	1/4" x 1/2" set screw	2164GB
6	1	Key (std. keystock)	
7	1	Operating shaft collar	1530YL
8	1	3/8" x 1/2" set screw	2169GB

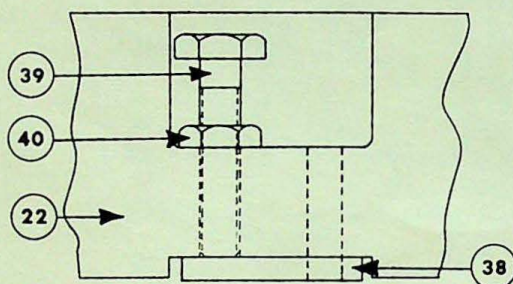
ALWAYS GIVE SERIAL NUMBER OF MACHINE WHEN ORDERING PARTS

STOCK REEL

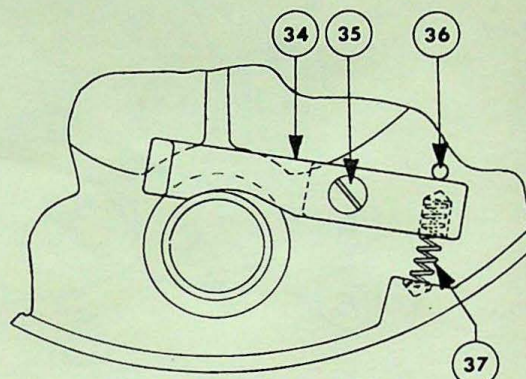


PARTS LIST AND DETAILED DRAWINGS ON FOLLOWING PAGE

STOCK REEL PARTS LIST



STOCK REEL LEVELING PLATE DETAIL



STOCK REEL LOCKING FINGER DETAIL

KEY	NO. REQD.	NAME OF PART	PART NO.	KEY	NO. REQD.	NAME OF PART	PART NO.
1	1	Stock reel center shaft	3171YL	25	1	Gear shaft supp. bracket	YL708
2	1	Safety plate hub	YL609	26	1	Stock reel wheel (front)	YL583-1
3	1	Feed tube safety plate	YL608	27	6	$\frac{1}{2}$ " Castellated nuts	2338GB
4	1	Plunger	1534YA	28	1	Center shaft key	4258YL
5	1	Plunger spring	509V	29	1	Front supp. bracket	YL691
6	6	Stock reel bushings (order by size)		30	2	Stock supp. wheel keys	1714YL
7	6	Bushing sleeves	3169YL	31	2	Shaft clamp blocks	4130YL
8	2	Stock wheel roller shafts	3905YL	32	2	Eccentric shafts	4129YL
9	4	Roller shaft brackets	3906YL	33	2	Stock wheel rollers	YA449
10	2	Stock wheel rollers	YA449	34	6	Locking fingers	YL590-1
11	2	Hold-down brackets	YL724	35	6	Locking finger studs	3177YL
12	12	Bearing retainers	YL587	36	6	Stop pins	1323YA
13	18	#6212 SKF #1 Bearings	60GB	37	6	Locking finger springs	527V
14	6	Stop collars	4296YL	38	2	Leveling plates	4128YL
15	6	Bearing retainers	YL587X	39	4	Leveling screws	2061YL
16	6	Revolving pipes	4336YL	40	4	Locknuts	1455YJ
17	2	Support pipes	3174YL	41	24	$\frac{3}{8}$ " x $\frac{1}{2}$ " set screws	2169GB
18	1	Stock reel wheel (rear)	YL585	42	4	$\frac{5}{16}$ " x $\frac{1}{2}$ " set screws	695GB
19	4	Stock wheel rollers	YL705	43	2	$\frac{3}{8}$ " x 1- $\frac{1}{4}$ " cap screws	1809GB
20	2	Roller shafts	1321YA	44	2	$\frac{3}{8}$ " x 1- $\frac{3}{4}$ " cap screws	1811GB
21	4	Roller shaft plugs	477YM	45	2	$\frac{5}{8}$ " x 2- $\frac{1}{2}$ " cap screws	2123GB
22	1	Rear supp. bracket	YL609	46	8	$\frac{1}{2}$ " x 1" cap screws	1828GB
23	1	Stock reel center supp.	YL591-1	47	4	$\frac{1}{2}$ " x 1- $\frac{1}{4}$ " set screws	1954GB
24	1	Adjusting gear shaft	4241YL	48	4	$\frac{1}{2}$ " jam nuts	2325GB

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COVERS, OIL SHIELDS, SPLASH GUARDS

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
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.....	YL556-1
1	Overarm light cover.....	YL667
1	Coolant valve bracket shield.....	YA253
1	Upper spindle shield.....	YL557-1
1	gasket.....	5048YL
1	Front spindle shield.....	YL553
1	support.....	YL546
1	Rear spindle shield.....	YL554
1	support.....	YL544
4	Front and rear shield hinge pins.....	699V
2	lock springs.....	761YA
1	Locking block lever shield.....	3188YL
1	Front splash guard (straight).....	5278YL
1	bracket.....	YL750
1	Rear splash guard (offset).....	4747YL
1	bracket.....	YL773
4	Front and rear splash guard rollers.....	4615YL
4	shafts.....	4616YL
4	clamps.....	4617YL
1	Front motor shaft guard (short).....	329YA
1	Rear motor shaft guard (long).....	4201YL
1	Rear cam shaft guard.....	4831YA

OIL FILTER

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
1	#10651 Cuno oil filter (type KT).....	2833GB
1	cover.....	YM392
1	gasket.....	5045YL
1	packing nut.....	9346YJ

WORK CHUTE

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
1	Work chute.....	8034YL
1	plate.....	8036YL
1	support bracket.....	8Q38YL
1	guide plate.....	8235YL

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COOLANT PARTS

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
1	Roper pump (spec. #1389).....	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.....	7490YL
1	Manifold.....	YL1112
1	Intake manifold.....	YL1155
1	Outlet manifold.....	YL1156
1	Oil resist hose (2" x 2-5/8" x 6-1/2").....	557GB
2	hose clamps.....	558GB
1	Frame coolant pipe (1" x 23-3/4").....	2575YL
2	Forming slide coolant outlet boxes.....	2447YL
1	Coolant strainer.....	YM230-1
1	Coolant strainer baffle plate.....	8047YL

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

OVERARM

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
1	Overarm.....	YL582-2
2	coolant valves.....	678YA
2	3-way coolant valves.....	1348YA
1	glass shield.....	4650YL
1	shim.....	4242YL
1	light holder.....	2202YA

ELECTRICAL EQUIPMENT

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
1	Push button cover.....	YL612X2
1	Start button.....	EQ325
1	Stop button.....	EQ326
1	Selector switch (single pole-double throw).....	EQ330
1	Start name plate.....	EQ498
1	Stop name plate.....	EQ499
1	Jog-run name plate.....	EQ500
1	On-off name plate.....	EQ500
1	Selector switch.....	EQ329
1	Standard brass receptacle.....	EQ392

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FRAME PARTS

<u>NO. REQD.</u>	<u>DESCRIPTION OF PART</u>	<u>PART NO.</u>
1	Main frame.....	YL600-1
1	Oil pan.....	YL337-2
1	Gear box.....	YL558-2
1	Gear box end section.....	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.....	2543YL
1	1/2" Allen "T" wrench.....	2277YL
1	3/8" Allen "T" wrench.....	2278YL
1	Housing wrench.....	1677YL
1	Lower rack wrench.....	368YM

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