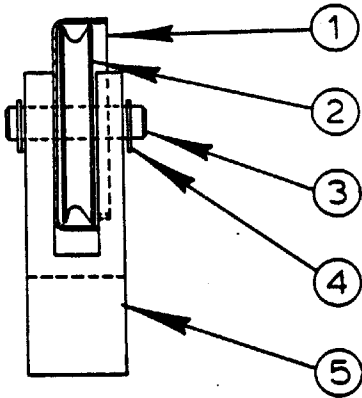
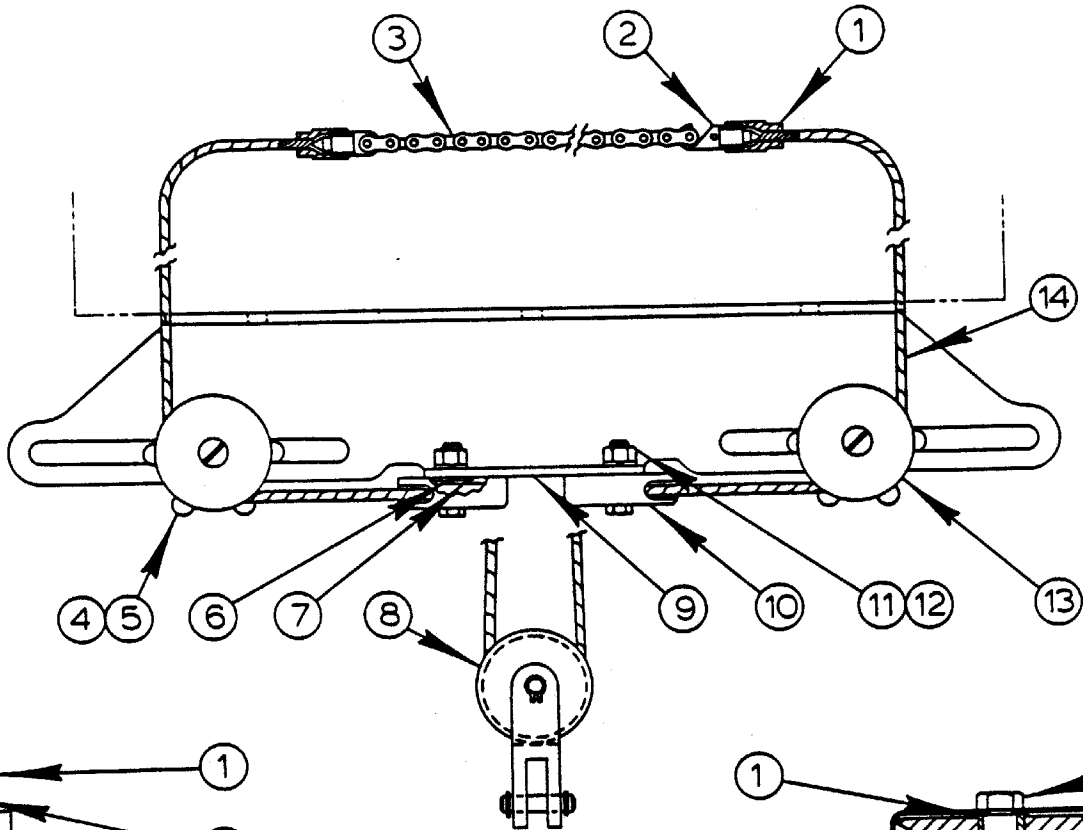


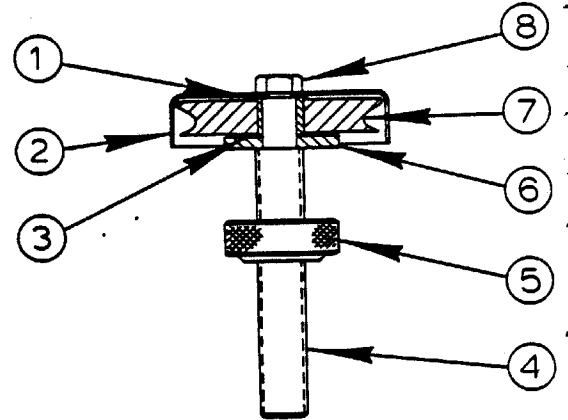
BAND FILING ASSEMBLY  
 BAND POLISHING ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	080-447808	Band Filing Assembly (Short Guides, 26" Table)	1
Ref.	081-119489	Band Filing Assembly (Long Guides, 26" Table)	1
Ref.	084-049949	Band Filing Assembly (Short Guides, 30" Table)	1
Ref.	081-327736	Band Filing Assembly (Long Guides, 30" Table)	1
Ref.	080-485329	Band Filing Assembly (Short Guides, Flange Wheels Only)(1612-3, 2612-2H, 2613-3, 3612-3, 6013-3 Only)	1
Ref.	084-014380	Band Filing Assembly (Long Guides, Flange Wheels Only)(1612-3, 2612-2H, 2613-3, 3612-3, 6013-3 Only)	1
1	134-093129	. File Guide Back-Up.....	1
	091-109314	. File Guide Back-Up (Flange Wheels Only).....	1
2	090-013715	. Adaptor.....	1
3	134-090018	. File Guide Back-Up Screw.....	1
4	090-106279	. Center Plate (26" Table).....	1
	091-201285	. Center Plate (30" Table).....	1
5	080-274871	. 1/4" File Guide Assembly (Short Guides).....	1
	080-274905	. 1/4" File Guide Assembly (Long Guides).....	1
	090-340969	. 1/4" File Guide Assembly (Short Guides, Flange Wheels Only).....	1
	090-340993	. 1/4" File Guide Assembly (Long Guides, Flange Wheels Only).....	1
	080-274889	. 3/8" File Guide Assembly (Short Guides).....	1
	080-274913	. 3/8" File Guide Assembly (Long Guides).....	1
	090-340977	. 3/8" File Guide Assembly (Short Guides, Flange Wheels Only).....	1
	090-341033	. 3/8" File Guide Assembly (Long Guides, Flange Wheels Only).....	1
	080-274897	. 1/2" File Guide Assembly (Short Guides).....	1
	080-274921	. 1/2" File Guide Assembly (Long Guides).....	1
	090-340985	. 1/2" File Guide Assembly (Short Guides, Flange Wheels Only).....	1
	090-341041	. 1/2" File Guide Assembly (Long Guides, Flange Wheels Only).....	1
6	106-093073	. . Insert (1/4", Short Guides).....	1
	106-093032	. . Insert (1/4", Long Guides).....	1
	106-093016	. . Insert (3/8", Short Guides).....	1
	106-093057	. . Insert (3/8", Long Guides).....	1
	106-093099	. . Insert (1/2", Short Guides).....	1
	106-093115	. . Insert (1/2", Long Guides).....	1
7	090-274176	. . Bracket (1/4", Short Guides).....	1
	090-274184	. . Bracket (1/4", Long Guides).....	1
	090-340951	. . Bracket (1/4", Short Guides, Flange Wheels Only).....	1
	090-340944	. . Bracket (1/4", Long Guides, Flange Wheels Only).....	1
	090-274200	. . Bracket (3/8", Short Guides).....	1
	090-274218	. . Bracket (3/8", Long Guides).....	1
	090-340936	. . Bracket (3/8", Short Guides, Flange Wheels Only).....	1
	090-340928	. . Bracket (3/8", Long Guides, Flange Wheels Only).....	1
	090-274192	. . Bracket (1/2", Short Guides).....	1
	090-274226	. . Bracket (1/2", Long Guides).....	1
	090-340910	. . Bracket (1/2", Short Guides, Flange Wheels Only).....	1
	090-340902	. . Bracket (1/2", Long Guides, Flange Wheels Only).....	1
8	106-093081	. . File Guide (1/4", Short Guides).....	1
	106-093040	. . File Guide (1/4", Long Guides).....	1
	106-093024	. . File Guide (3/8", Short Guides).....	1
	106-093065	. . File Guide (3/8", Long Guides).....	1
	106-093107	. . File Guide (1/2", Short Guides).....	1
	106-093123	. . File Guide (1/2", Long Guides).....	1
9	106-093149	. . Washer (1/4" File Guides).....	2
	106-093131	. . Washer (3/8" And 1/2" File Guides).....	2
10	091-986885	. . Screw, Fill. Hd. Mach. #4-40NC x 5/8 (1/4" File Guides).....	2
	091-986992	. . Screw, Fill. Hd. Mach. #10-24NC x 5/8 (3/8" And 1/2" File Guides).....	2
11	091-993154	. . Washer, Lock #4 Std. (1/4" File Guides).....	2
	091-993196	. . Washer, Lock #10 Std. (3/8" And 1/2" File Guides).....	2
12	134-093137	. . Guide Plate (1/4", Long Guides Only).....	2
13	134-094028	. . Pin (1/4", Long Guides Only).....	2
Ref.	081-069577	Band Polishing Assembly	1
Ref.	090-290230	Band Polishing Assembly (1612-3, 1613-2, 3612-3, 3613-2 Only)	1
Ref.	090-274853	Band Polishing Assembly (2612-2H, 2613-2, 6013-2 Only)	1
1	090-105701	. Center Plate (081-069577 Only).....	1
2	090-013715	. Adaptor (081-069577, 090-290230 Only).....	1
3	134-090018	. Back-Up Screw (081-069577, 090-290230 Only).....	1
4	134-104025	. Guide Back-Up.....	1
5	090-166869	. Band Polishing Sub-Assembly.....	1
6	091-986965	. . Screw, Fill. Hd. Mach. #10-24NC x 3/8.....	3
7	090-274127	. . Bracket.....	1
8	106-103013	. . Back-Up Plate.....	1
9	134-105048	. . Back-Up Cloth.....	1
Ref.	080-076458	Small Parts Filing Assembly	1
1	090-120460	. Plate.....	2
2	091-987487	. Screw, Flat Hd. Mach. #10-24NC x 3/8.....	2
3	090-120452	. Center Plate.....	1

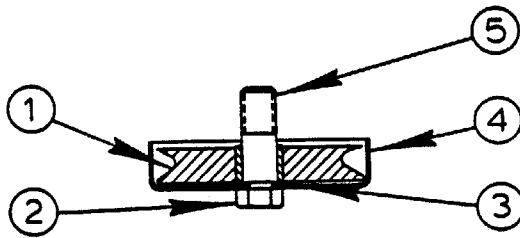
NEW DRG.
S.C.L. 4-7-86
REVISIONS



093-153625  
EQUALIZER PULLEY ASSEMBLY



135-063956  
HORIZONTAL PULLEY ASSEMBLY



135-063964  
VERTICAL PULLEY ASSEMBLY

MODEL	FIRST MACH	LAST MACH
2013-V	457-86101	
2013-20	377-861284	
2614-1	364-86254	
3613-1	440-86214	
3613-20	399-86628	

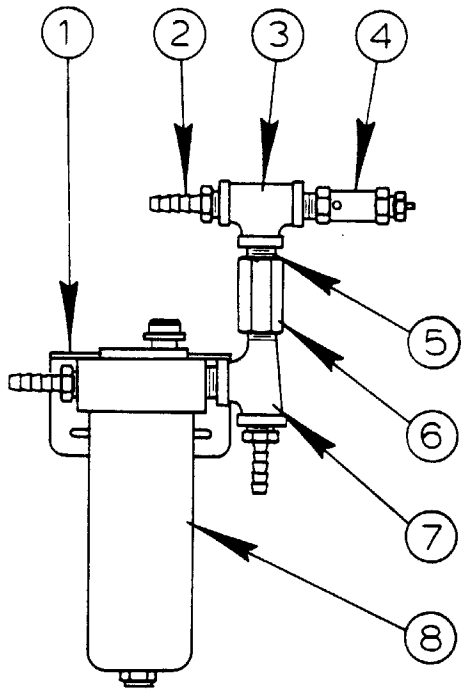
CARRIER AND CABLE ASSEMBLY  
(AIR FEED)

C-9-23

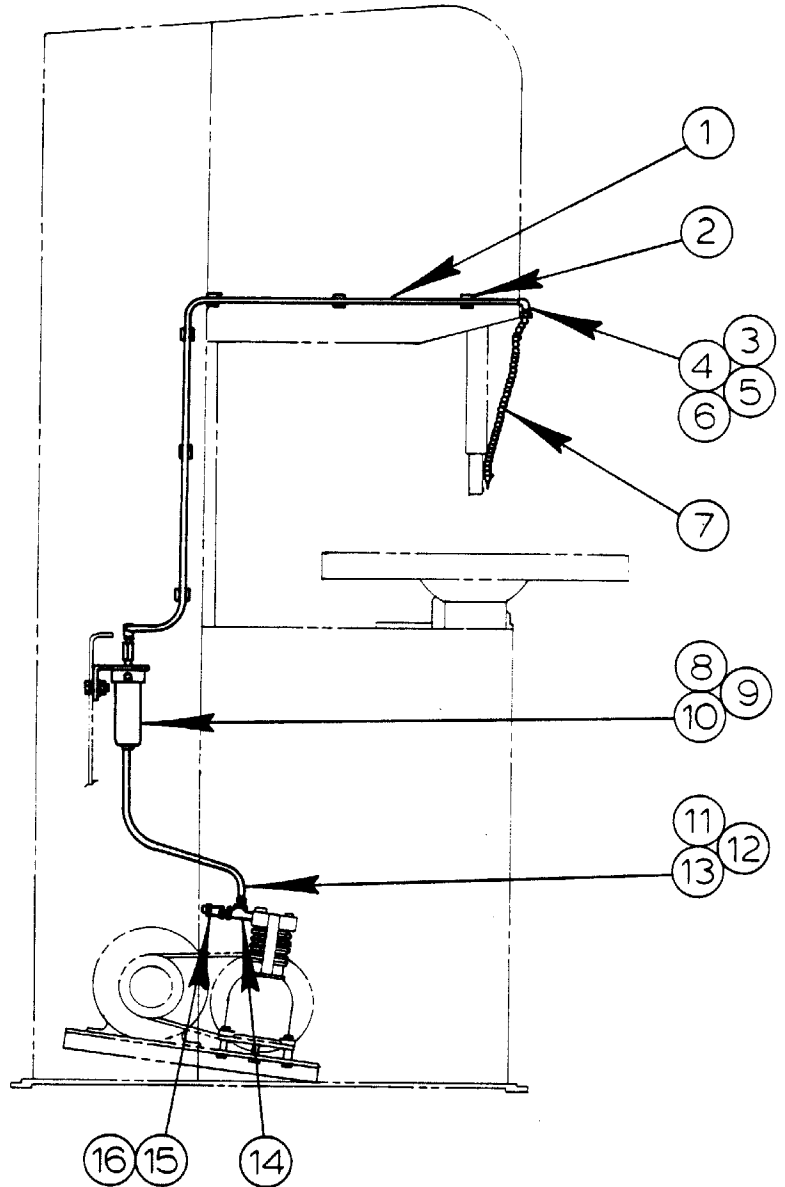
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A-11

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SCL 7-15-88



AIR AND COOLANT SUB-ASSEMBLY



MODEL    FIRST MACH.    LAST MACH.  
 2013-V    457-86101

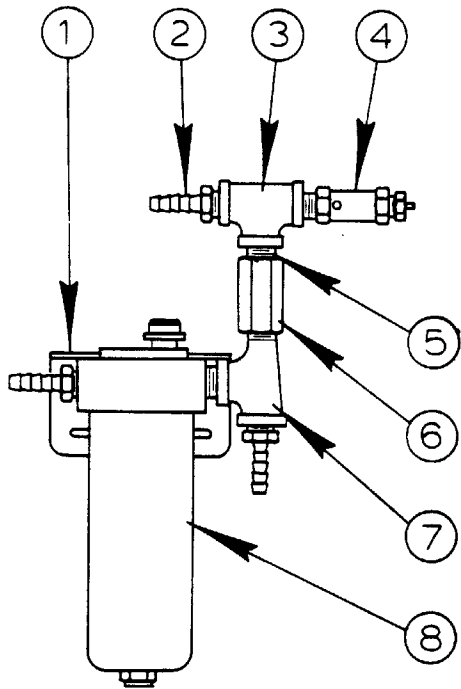
CHIP BLOWER ASSEMBLY

C - 9 - 21

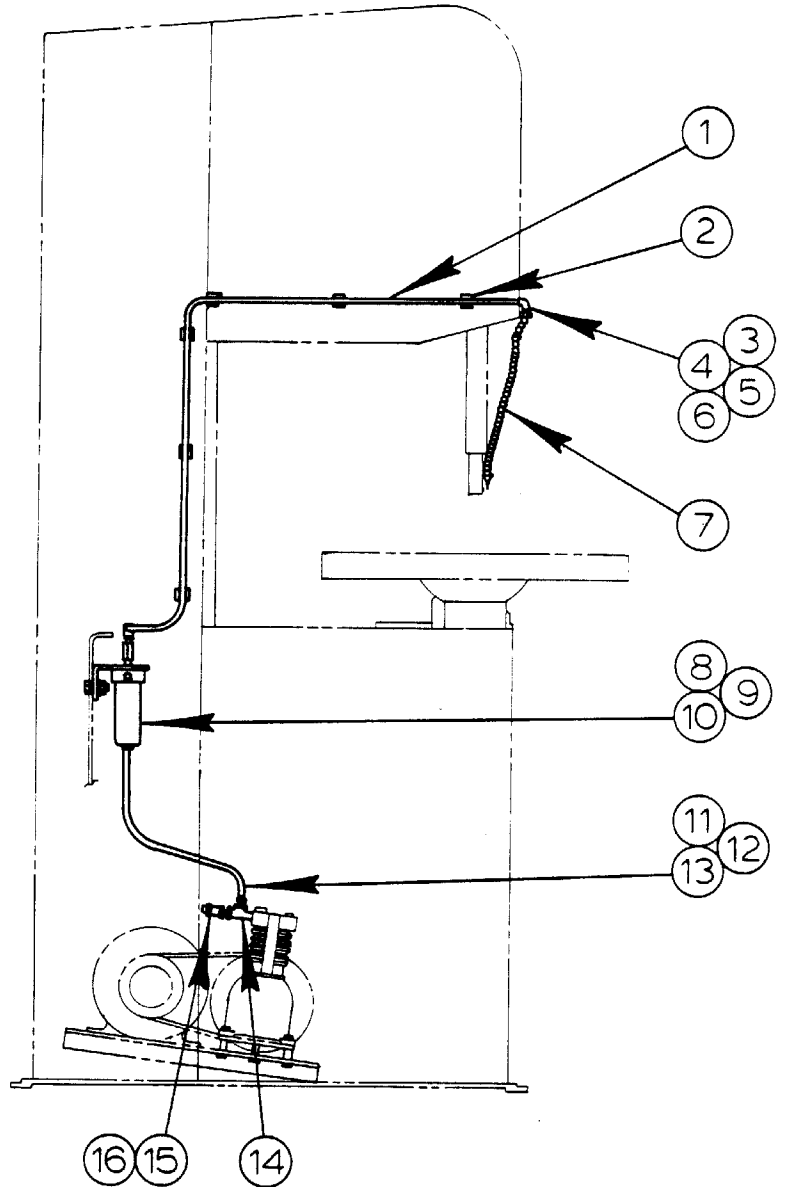
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B-1

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SCL 7-15-88



AIR AND COOLANT SUB-ASSEMBLY



MODEL FIRST MACH. LAST MACH.  
2013-V 457-86101

CHIP BLOWER ASSEMBLY

C - 9 - 21

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B-1

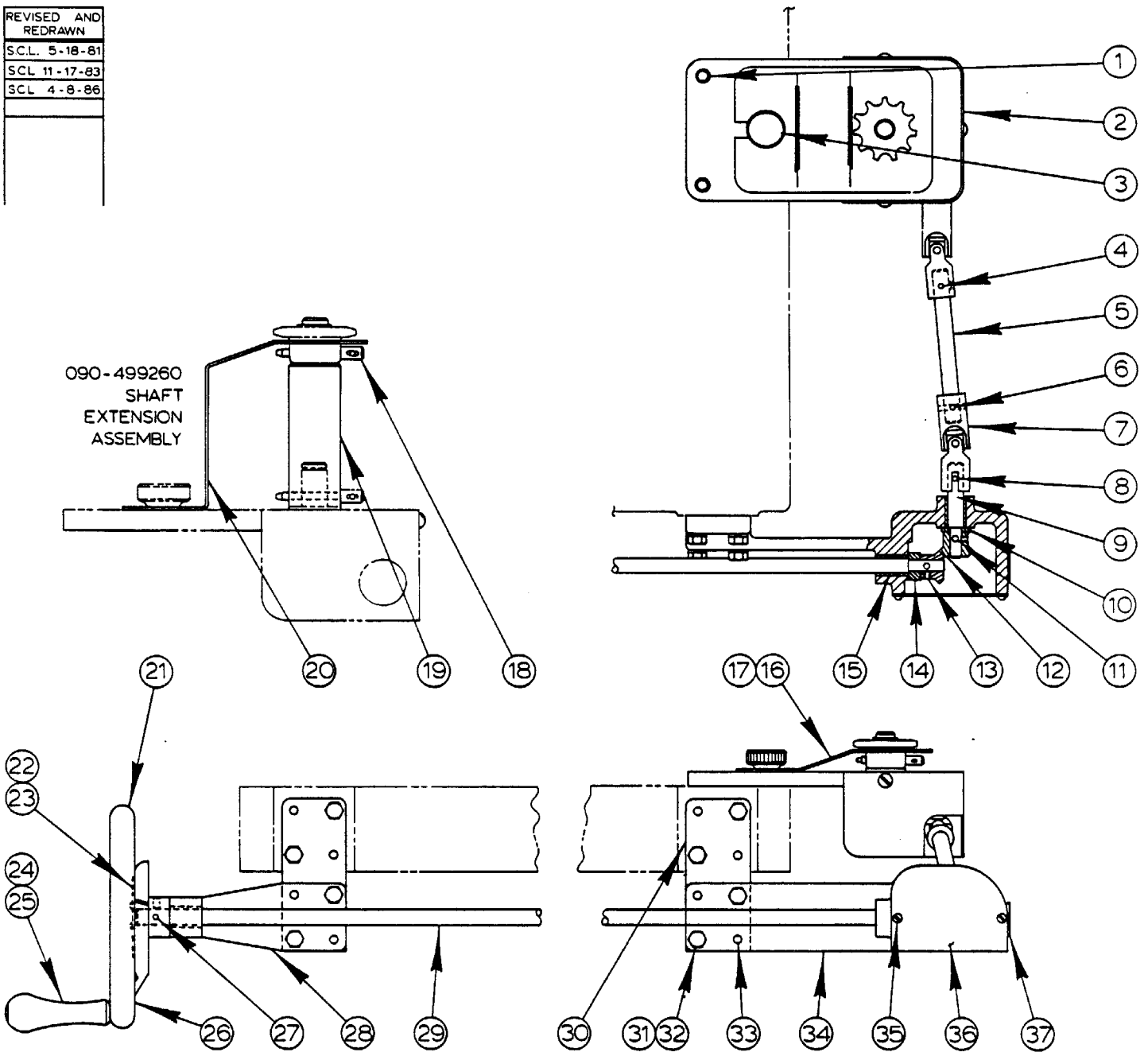
CHIP BLOWER ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	084-142777	Chip Blower Assembly	
Ref.	084-145127	Chip Blower Assembly (w/Air Table Option)	
1	091-971499	. Plastic Tubing 3/8 I.D.....	A.R.
2	091-760058	. Hose Clip.....	6
3	091-281790	. Barbed Insert.....	1
4	135-036473	. 90° Elbow.....	1
5	090-099557	. Tubing Clamp.....	1
6	091-994848	. Screw, Rd. Hd. Self-Tap 1/4-20NC x 1/2.....	1
7	091-725309	. Coolant And Air Hose.....	1
	091-725291	. . Connector.....	1
	091-973222	. . Segmented Hose (Specify Length).....	A.R.
	091-725283	. . Nozzle.....	1

Following Used On Air Table Option Only:

8	093-136679	. Air And Coolant Sub-Assembly (See Detail).....	1
9	091-980086	. Screw, Hex. Hd. Cap 1/4-20NC x 3/4.....	2
10	091-993741	. Washer, Lock 1/4 Shakeproof Ext.....	2
	091-991158	. Nut, Hex. 1/4-20NC.....	2
11	090-020041	. Barbed Insert.....	1
12	135-068880	. Hose Clamp.....	4
13	091-970947	. Neoprene Hose 11/16 O.D. (Black).....	A.R.
14	135-008472	. Service Tee.....	1
15	114-035074	. Close Nipple.....	1
16	091-283796	. Safety Valve.....	1
Ref.	093-136679	. Air And Coolant Sub-Assembly	
1	091-458844	. . Bracket.....	1
2	090-020041	. . Barbed Insert.....	3
3	135-024743	. . Pipe Tee.....	1
4	091-180885	. . Safety Valve.....	1
5	114-035074	. . Close Nipple.....	2
6	093-034106	. . Orifice (.033 Dia.).....	1
7	135-008472	. . Service Tee.....	1
8	091-458836	. . Oil-Fog Lubricator.....	1

REVISED AND REDRAWN
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SCL 11-17-83
SCL 4-8-86



CONTOUR ASSEMBLY

MODEL	FIRST MACH.	LAST MACH.
1612-0	277-711094	277-751728
2612-1	285-68101	285-76200
3613-0	278-68101	278-77825
2012-A	320-72101	320-74333
2012-1A	340-74101	340-78421
2012-2A	389-77101	389-86419
3613-20	399-78101	
E3613-20	410-79101	410-85114
3613-1	440-83101	
2013-V	457-86101	
2013-20	377-77101	

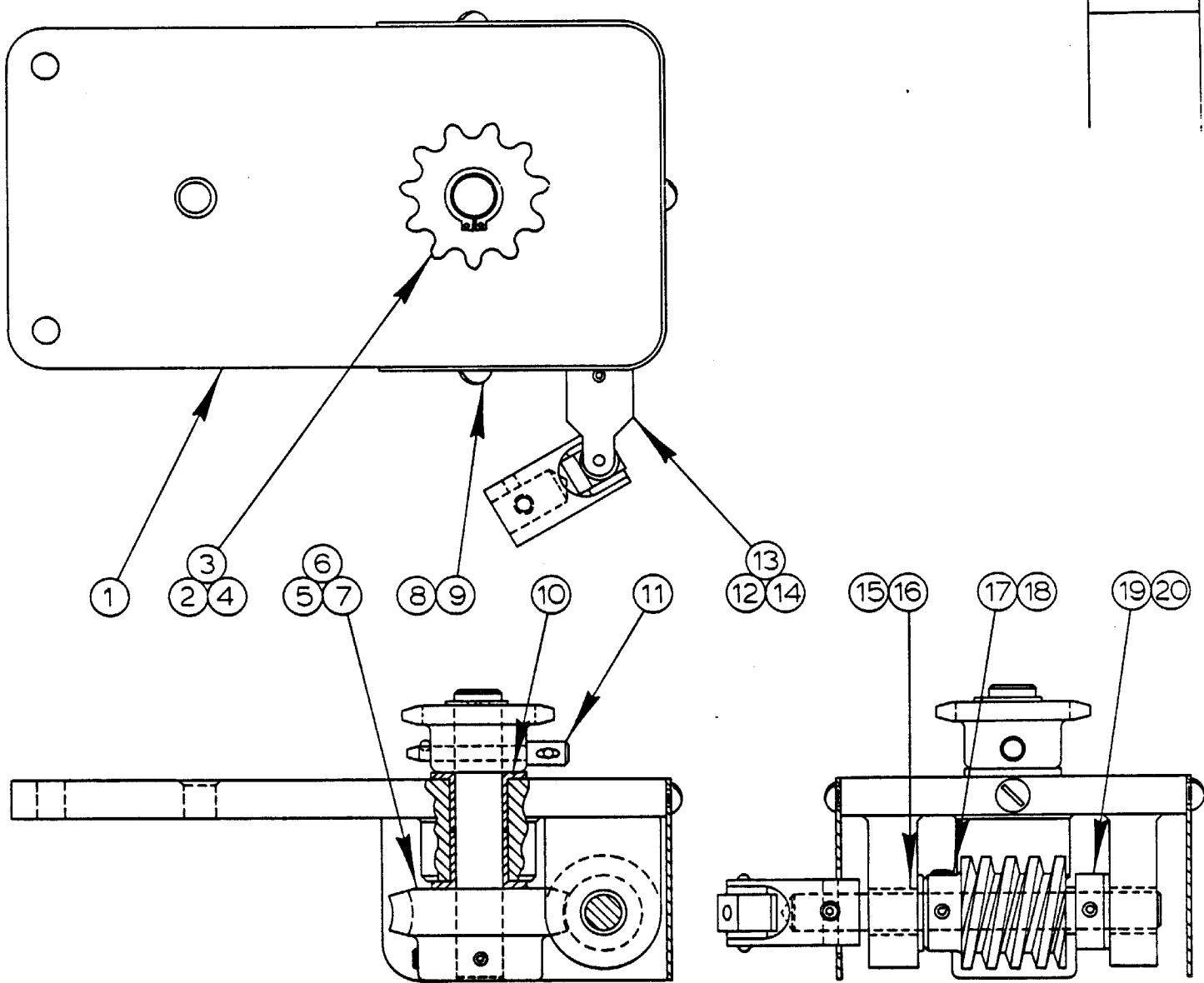
CONTOUR ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	085-015170	Contour Assembly	
1	090-107269	. Dowel Pin.....	2
2	090-479312	. Contour Attachment Sub-Assembly (See Detail).....	1
3	091-597736	. Thumb Screw Assembly.....	1
	091-597724	. . Knob.....	1
	091-982819	. . Screw, Soc. Hd. Cap 3/8-16NC x 1-1/2.....	1
4	090-042573	. Roll Pin.....	2
5	091-087601	. Shaft.....	1
6	091-984229	. Screw, Soc. Set 1/4-20NC x 1/4.....	3
7	091-396911	. Universal Joint.....	1
8	090-042441	. Roll Pin.....	1
9	091-253450	. Shaft.....	1
10	091-253609	. Washer.....	1
11	090-042409	. Roll Pin.....	2
12	091-253583	. Gear.....	2
13	091-984104	. Screw, Soc. Set #10-24NC x 1/4.....	2
14	091-253591	. Spacer.....	1
15	135-006476	. Oilite Bearing.....	3
16	090-499138	. Chain Guide (Standard).....	1
17	090-499260	. Shaft Extension Assembly.....	1
18	091-085365	. . Pin.....	1
19	090-362385	. . Shaft Extension.....	1
20	090-499187	. . Chain Guide.....	1
21	094-033693	. Contour Handwheel Sub-Assembly.....	1
22	091-256297	. . Name Plate (Servo-Contour).....	1
23	091-993972	. . Screw, Rd. Hd. Drive #2 x 1/4.....	2
24	091-181164	. . Handle.....	1
25	091-181172	. . Pin.....	1
26	090-486432	. . Handwheel.....	1
27	090-042615	. Roll Pin.....	1
28	090-202052	. Bracket.....	1
29	091-253443	. Shaft.....	1
30	091-086231	. Adaptor.....	2
31	091-980300	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/4.....	8
32	091-993238	. Washer, Lock 5/16 Std.....	8
33	091-338756	. Dowel Pin.....	8
34	090-202045	. Gear Box.....	1
35	091-988386	. Screw, Rd. Hd. Mach. #6-32NC x 1/4.....	2
36	090-016965	. Cover.....	1
37	090-033259	. Plug Button.....	1

Following Not Shown:

135-050136	. Chain Assembly.....	1
084-033109	. Contour Clamp Ring Assembly (See Detail).....	1

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S.C.L. 11-17-83



CONTOUR ATTACHMENT SUB-ASSEMBLY

C-3-76 CM-3-72

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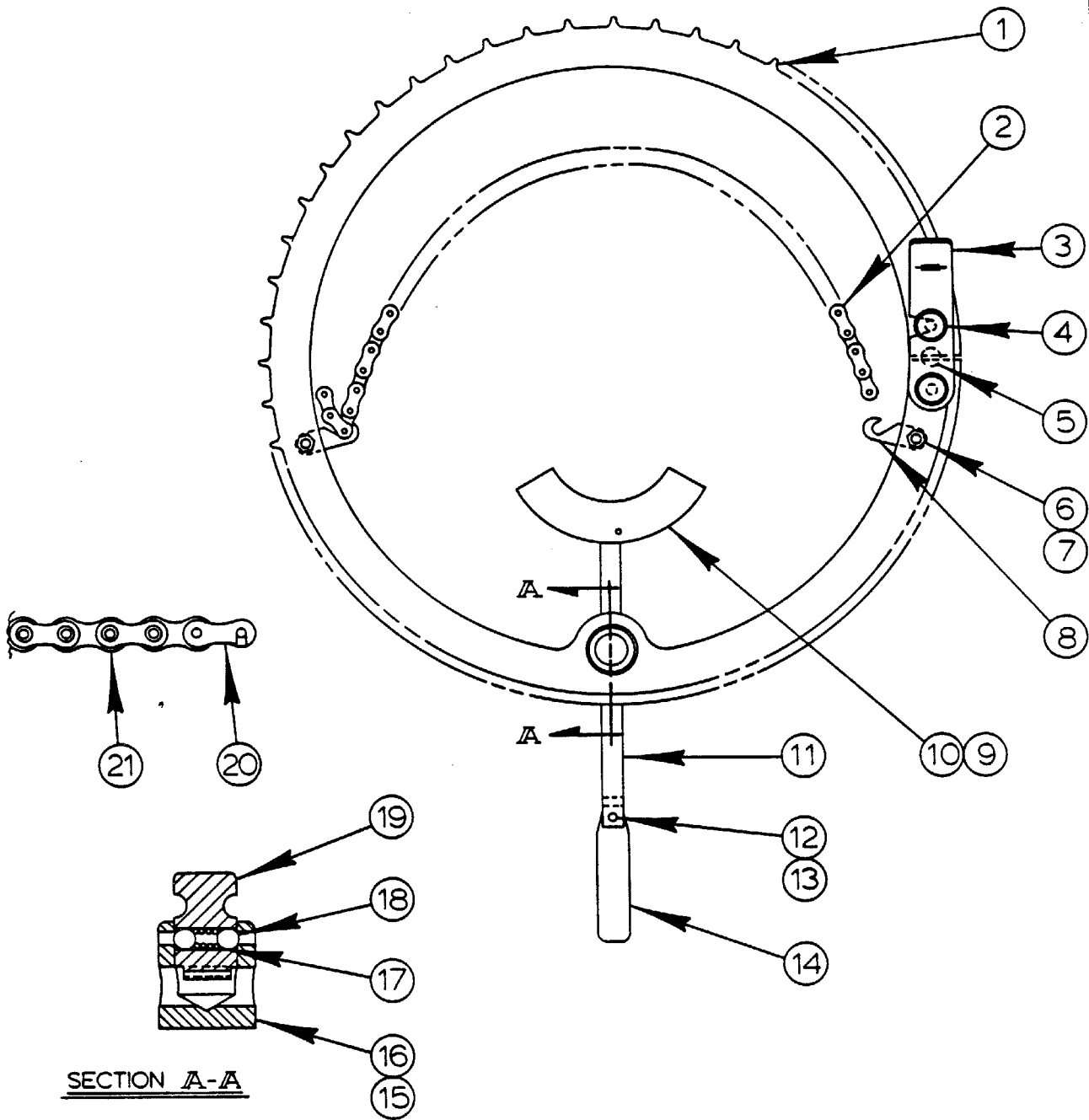
CONTOUR ATTACHMENT SUB-ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
	090-479312	Contour Attachment Sub-Assembly	
1	090-333295	. Bracket Weldment.....	1
2	091-085357	. Sprocket Assembly.....	1
	091-085340	. . Oilite Sleeve Bearing.....	1
	091-085332	. . Sprocket.....	1
3	135-064269	. Retaining Ring.....	1
4	091-087296	. Axle.....	1
5	091-085266	. Worm Gear.....	1
6	090-042631	. Roll Pin.....	1
7	091-984245	. Screw, Soc. Set 1/4-20NC x 3/8.....	1
8	090-333055	. Guard.....	1
9	091-990150	. Screw, Truss Hd. Mach. #10-24NC x 3/8.....	3
10	091-007955	. Oilite Bearing.....	2
11	091-085365	. Pin.....	1
12	091-422535	. Universal Joint.....	1
13	090-042573	. Roll Pin.....	1
14	091-984229	. Screw, Soc. Set 1/4-20NC x 1/4.....	2
15	091-087577	. Shaft.....	1
16	091-081463	. Oilite Bearing.....	2
17	091-085274	. Worm Gear.....	1
18	090-042599	. Roll Pin.....	2
19	091-083923	. Thrust Bearing.....	2
20	134-054105	. Steel Collar.....	1

Following Not Shown:

094-092205	. Corner Bracket.....	4
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S.C.L. 5-19-81
SCL 11-17-83



CONTOUR CLAMP RING ASSEMBLY

C-3-77 CM-3-75

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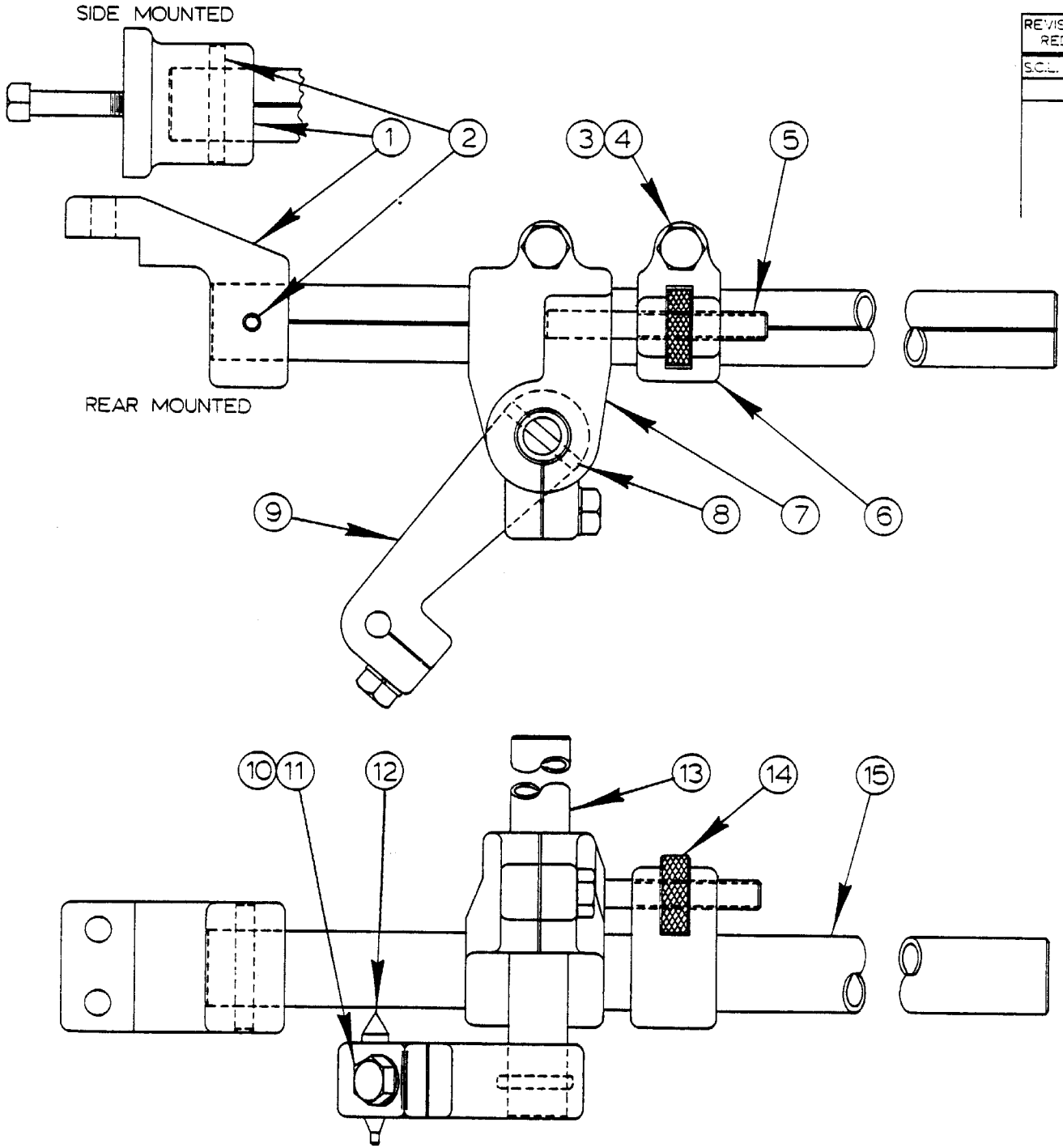
CONTOUR CLAMP RING ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	084-033109	Contour Clamp Ring Assembly	
1	095-015160	. Clamping Ring.....	1
2	091-253336	. Chain.....	1
3	091-253328	. Clamp.....	1
4	091-333724	. Thumb Screw.....	2
5	090-130428	. Dowel Pin.....	2
6	091-982272	. Screw, Soc. Hd. Cap #10-24NC x 1-1/2.....	2
7	091-991117	. Nut, Hex. #10-24NC.....	2
8	135-003291	. Chain Connector.....	1
9	091-253351	. Jaw.....	1
10	090-042557	. Roll Pin.....	1
11	091-253344	. Screw.....	1
12	091-052639	. Belleville Washer.....	1
13	090-042516	. Roll Pin.....	1
14	091-253385	. Handle.....	1
15	091-253393	. Swivel.....	1
16	091-984021	. Screw, Soc. Set #6-32NC x 1/4.....	1
17	105-035018	. Detent Spring.....	1
18	105-035026	. Steel Ball.....	2
19	105-034029	. Key.....	1
20	091-253427	. Cover Plate.....	1
21	091-253419	. Roller Chain.....	1

Following Not Shown:

091-540690	. Plastic Bag.....	1
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S.C.L. 2-18-81



DISC CUTTER ASSEMBLY

C-10-2 CM-9-1 Z-9-4

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CODE NO. C-10-2  
CM-9-1  
Z-9-4

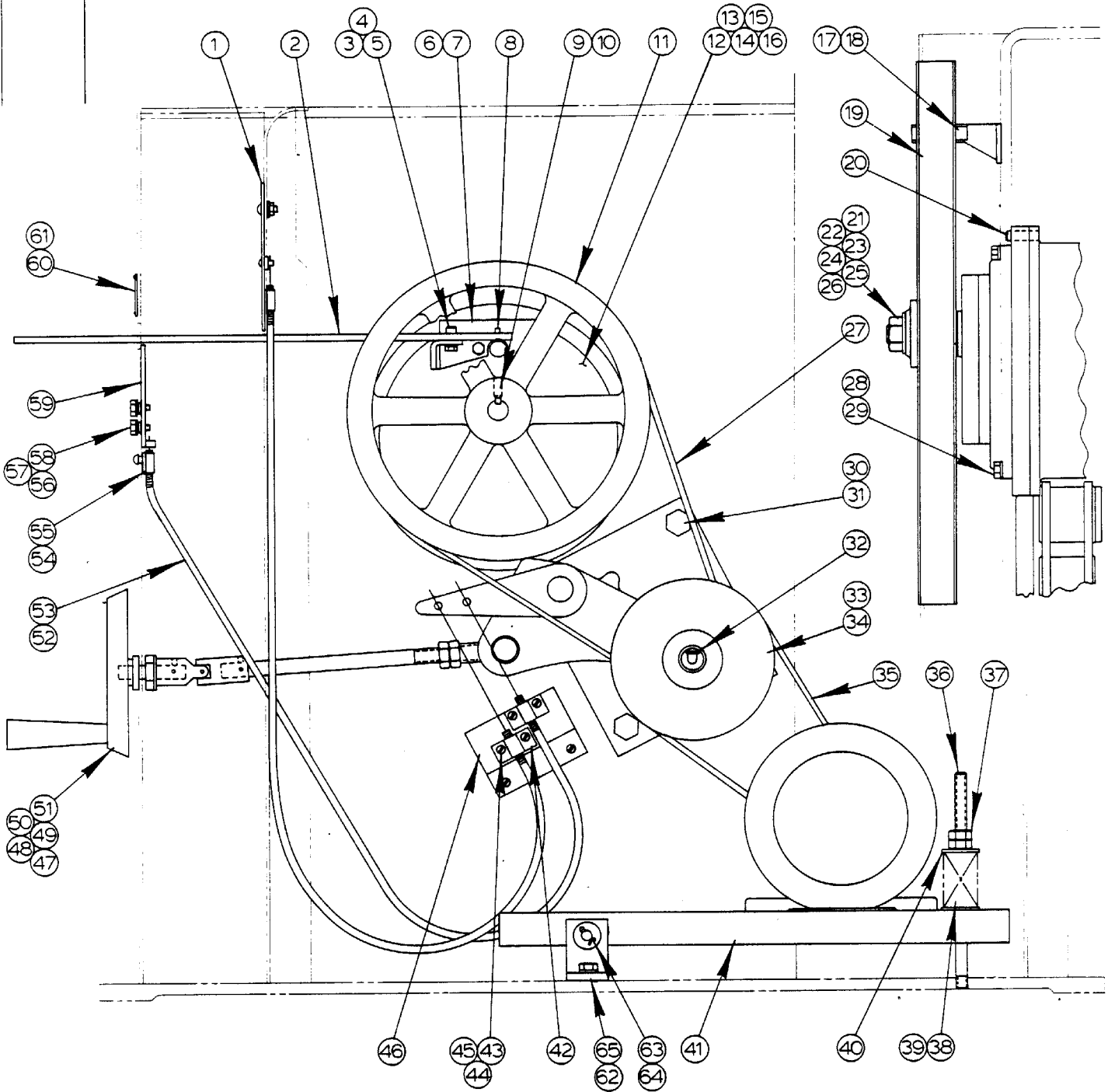
DISC CUTTER ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	084-020809	Disc Cutter Assembly (Rear Mounted)	
Ref.	080-400443	Disc Cutter Assembly (Side Mounted)	
1	090-390196	. Bracket (Rear Mounted) .....	1
	090-200452	. Bracket (Side Mounted) .....	1
2	090-042763	. Roll Pin (Rear Mounted) .....	1
	090-042755	. Roll Pin (Side Mounted) .....	1
3	091-980466	. Screw, Hex. Hd. Cap 3/8-16NC x 1 .....	3
4	091-993329	. Washer, Lock 3/8 Std. ....	3
5	105-154132	. Adjustment Rod .....	1
6	105-151096	. Adjustment Housing .....	1
7	135-034007	. Radius Arm Clamp .....	1
8	090-042615	. Roll Pin .....	1
9	135-034023	. Center Pin Clamp .....	1
10	091-980292	. Screw, Hex. Hd. Cap 5/16-18NC x 1 .....	1
11	091-993238	. Washer, Lock 5/16 Std. ....	1
12	105-154157	. Center Pin .....	1
13	135-034015	. Center Adjustment Tube .....	1
14	105-154124	. Adjustment Wheel .....	1
15	135-033991	. Radius Arm .....	1

Following Not Shown and Used For Mounting:

134-203082	. Wrench .....	1
091-980292	. Screw, Hex. Hd. Cap 5/16-18NC x 1 (Rear Mounted)	2
091-980318	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/2(Side Mounted)	2
091-992628	. Washer, Flat 5/16 S.A.E. Std. ....	2
091-993238	. Washer, Lock 5/16 Std. ....	2

REVISIONS



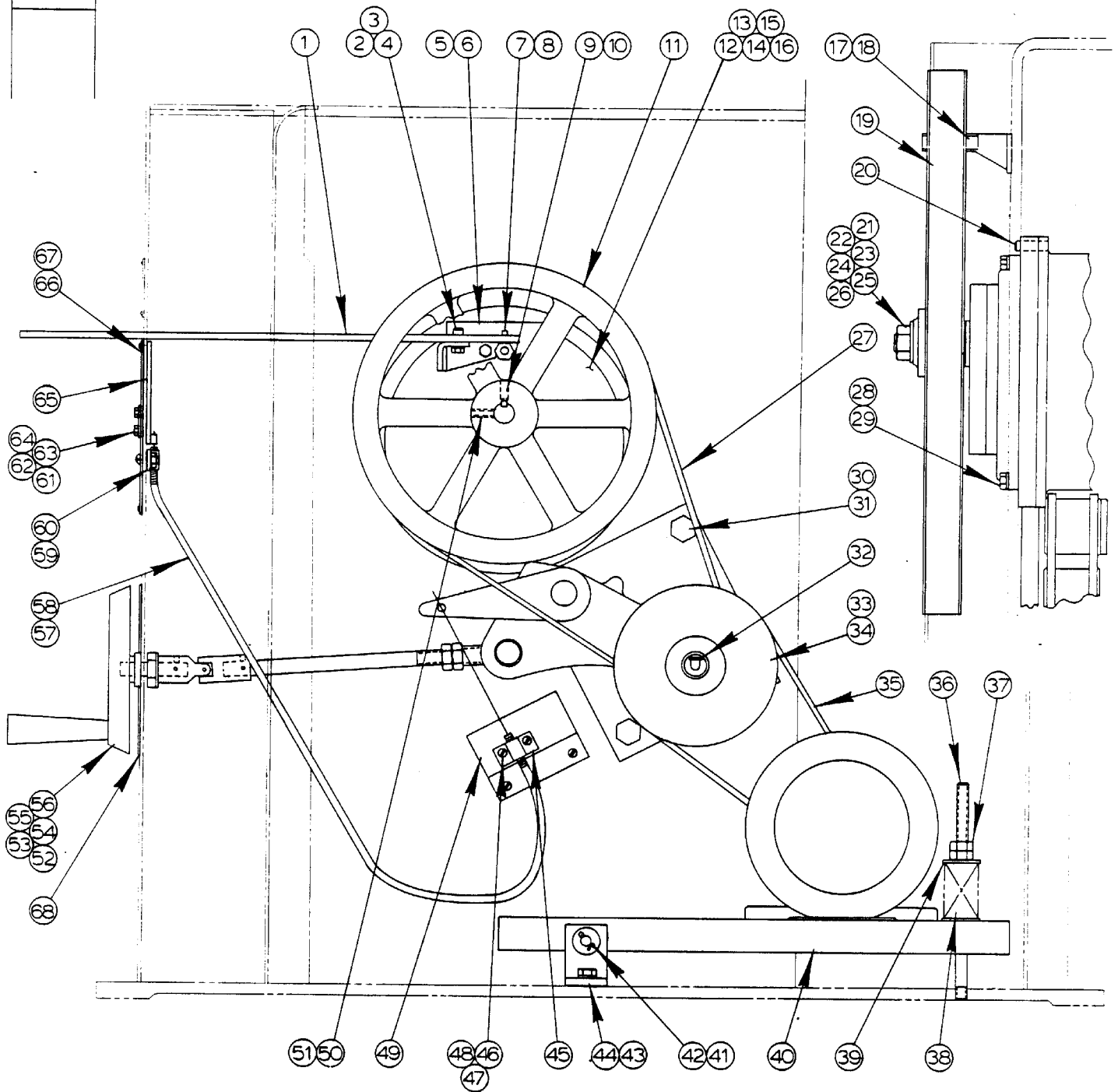
MODEL	FIRST MACH	LAST MACH
2013-V	457 - 86101	457 - 87612

DRIVE ASSEMBLY

DRIVE ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	095-130126	Drive Assembly	
1	093-147551	. Speed Indicator Assembly (Inch/English)(See Detail)	1
	093-146413	. Speed Indicator Assembly (Metric/International)(See Detail)	1
2	093-146744	. Shift Lever	1
3	091-207969	. Screw, Soc. Hd. Shoulder 1/4-20NC x 3/8	2
4	091-993212	. Washer, Lock 1/4 Std.	3
5	091-991760	. Nut, Hex. 1/4-20NC	1
6	093-151793	. Shift Arm Mounting Bracket	1
7	091-982363	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2	2
8	091-723999	. Adaptor	1
9	107-013450	. Key	1
10	091-984377	. Screw, Soc. Set 5/16-18NC x 1/2	2
11	095-085833	. Pulley	1
12	095-068276	. Transmission Assembly (See Detail)	1
13	091-335703	. Shim (.005)	A.R.
14	091-335711	. Shim (.008)	A.R.
15	091-335729	. Shim (.010)	A.R.
16	091-335737	. Shim (.020)	A.R.
17	090-166646	. Brush Holder Weldment	1
18	090-166844	. Wheel Brush	1
19	090-397126	. Bandwheel Assembly	1
	094-025996	. Bandwheel	1
	091-253575	. Tire	1
20	135-066959	. Dowel Pin	1
21	091-991406	. Nut, Hex. Jam 3/4-10NC	1
22	091-993782	. Washer, Lock 3/4 Shakeproof Ext.	1
23	105-046049	. Woodruff Key	1
24	091-333161	. Spacer (.014/.016)	A.R.
25	091-333179	. Spacer (.028/.032)	A.R.
26	091-333187	. Spacer (.127/.143)	A.R.
27	091-006411	. V-Belt	1
28	091-980318	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/2	4
29	091-993238	. Washer, Lock 5/16 Std.	4
30	091-980532	. Screw, Hex. Hd. Cap 3/8-16NC x 2-3/4	3
31	091-993329	. Washer, Lock 3/8 Std.	3
32	090-108613	. Oiler	1
33	090-454232	. Variable Assembly (6P-A Speedmaster)(See Detail)	1
34	091-984377	. Screw, Soc. Set 5/16-18NC x 1/2	1
35	090-162181	. V-Belt	1
36	135-087658	. Stud	1
37	091-991273	. Nut, Hex. Jam 3/8-16NC	2
38	135-087591	. Spring	1
39	091-331975	. Wire	2
40	134-054147	. Drive Motor Washer	2
41		. Motor Base Assembly (See Detail)	1
42	091-186981	. Strap	2
43	091-988691	. Screw, Rd. Hd. Mach. #10-24NC x 1/2	14
44	091-993196	. Washer, Lock #10 Std.	12
45	091-991117	. Nut, Hex. #10-24NC	12
46	093-151835	. Bracket	1
47	094-142684	. Variable Linkage Sub-Assembly (See Detail)	1
48	091-333104	. Shim (.035)	A.R.
49	091-333112	. Shim (.0149)	A.R.
50	091-333120	. Shim (.005)	A.R.
51	091-333138	. Shim (.003)	A.R.
52	091-973172	. Nylon Tubing 3/16 O.D.	A.R.
53	091-657189	. Wire	1
54	091-186981	. Strap	1
55	091-187047	. Spacer	1
56	091-980011	. Screw, Hex. Hd. Cap #10-24NC x 1/2	2
57	091-992586	. Washer, Flat #10 S.A.E. Std.	3
58	091-123646	. Spacer	2
59	093-146728	. Lockout Plate Weldment	1
60	091-726547	. Escutcheon (Caution)(English)	1
	091-726554	. Escutcheon (Caution)(International)	1
61	091-993964	. Screw, Rd. Hd. Drive #2 x 3/16	4
62	093-149656	. Angle Bracket	2
63	091-711044	. Pivot Pin	1
64	091-995134	. Cotter Pin	2
65	091-980441	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	2

NEW DRG  
 SOL 4-27-87  
 REVISED  
 SOL 7-15-88



MODEL FIRST MACH LAST MACH  
 2013-V 457 - 87613

DRIVE ASSEMBLY

C - 5 - 111

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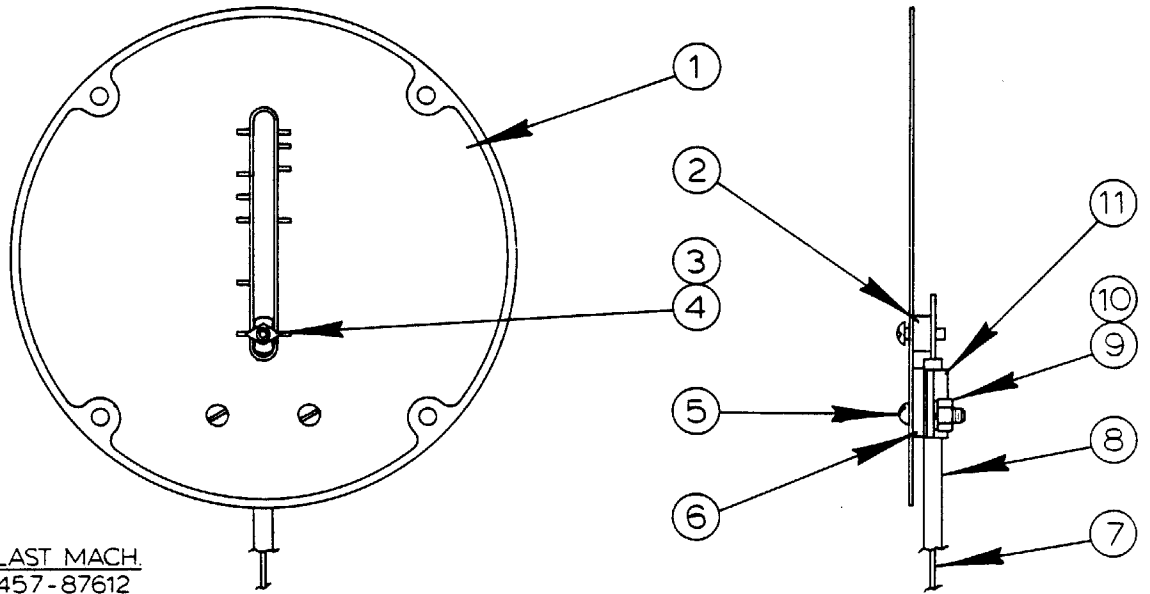
DRIVE ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
	095-130126	Drive Assembly	
1	093-146744	. Shift Lever.....	1
2	091-207969	. Screw, Soc. Hd. shoulder 1/4-20NC x 3/8.....	1
3	091-993212	. Washer, Lock 1/4 Std.....	3
4	091-991760	. Nut, Hex. 1/4-20NC.....	1
5	093-151793	. Shift Arm Mounting Bracket.....	1
6	091-982363	. Screw, Soc. hd. Cap 1/4-20NC x 1/2.....	2
7	091-723999	. Adaptor.....	1
8	091-740555	. Screw, Soc. hd. Shoulder 1/4-20NC x 3/8.....	1
9	107-013450	. Key.....	1
10	091-984393	. Screw, Soc. Set 5/16-18NC x 3/4.....	1
11	095-085833	. Pulley.....	1
12	095-068276	. Transmission Assembly (See Detail).....	1
13	091-335703	. Shim (.005).....	A.R.
14	091-335711	. Shim (.008).....	A.R.
15	091-335729	. Shim (.010).....	A.R.
16	091-335737	. Shim (.020).....	A.R.
17	090-166646	. Brush Holder Weldment.....	1
18	090-166844	. Wheel Brush.....	1
19	090-397126	. Bandwheel Assembly.....	1
	094-025996	. Bandwheel.....	1
	091-253575	. Tire.....	1
20	135-066959	. Dowel Pin.....	1
21	091-991406	. Nut, Hex. Jam 3/4-10NC.....	1
22	091-993782	. Washer, Lock 3/4 Shakeproof Ext.....	1
23	105-046049	. Woodruff Key.....	1
24	091-333161	. Spacer (.014/.016).....	A.R.
25	091-333179	. Spacer (.028/.032).....	A.R.
26	091-333187	. Spacer (.127/.143).....	A.R.
27	091-006411	. V-Belt.....	1
28	091-980318	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/2.....	4
29	091-993238	. Washer, Lock 5/16 Std.....	4
30	091-980532	. Screw, Hex. Hd. Cap 3/8-16NC x 2-3/4.....	3
31	091-993329	. Washer, Lock 3/8 Std.....	5
32	090-108613	. Oiler.....	1
33	090-454232	. Variable Assembly (6P-A Speedmaster) (See Detail).....	1
34	091-984401	. Screw, Soc. Set 5/16-18NC x 1.....	1
35	090-162181	. V-Belt.....	1
36	135-087658	. Stud.....	1
37	091-991273	. Nut, Hex. Jam 3/8-16NC.....	2
38	135-087591	. Spring.....	1
39	134-054147	. Drive Motor Washer.....	2
40		. Motor Base Assembly (See Detail).....	1
41	091-711044	. Pivot Rod.....	1
42	091-995134	. Cotter Pin.....	2
43	093-149656	. Angle Bracket.....	2
44	091-980441	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4.....	2
45	091-186981	. Strap.....	1
46	091-988691	. Screw, Rd. Hd. Mach. #10-24NC x 1/2.....	4
47	091-993196	. Washer, Lock #10 Std.....	4
48	091-991117	. Nut, Hex. #10-24NC.....	4
49	093-158178	. Bracket.....	1
50	091-985176	. Screw, Soc. Set 5/16-18NC x 3/4 (Cone Pt).....	1
51	091-709097	. Adhesive (Permagard #LM-113).....	A.R.
52	094-142684	. Variable Linkage Sub-Assembly (See Detail).....	1
53	091-333104	. Shim (.035).....	A.R.
54	091-333112	. Shim (.0149).....	A.R.
55	091-333120	. Shim (.005).....	A.R.
56	091-333138	. Shim (.003).....	A.R.
57	091-973172	. Nylon Tubing 3/16 O.D.....	A.R.
58	091-657189	. Wire.....	1
59	091-186981	. Strap.....	1
60	091-187047	. Spacer.....	1
61	091-732602	. Pointer Plate.....	1
62	091-980011	. Screw, Hex. Hd. Cap #10-24NC x 1/2.....	2
63	091-992586	. Washer, Flat #10 S.A.E. Std.....	3
64	091-732594	. Spacer.....	2
65	093-155489	. Lockout Plate Weldment.....	1
66	093-155497	. Escutcheon (Band Speed) (Feet/English).....	1
	093-161594	. Escutcheon (Band Speed) (Metric/International).....	1
67	091-994608	. Screw, Rd. Hd. Self-Tap #6-32NC x 1/4.....	4
68	091-011585	. Escutcheon (International).....	1

Following Not Shown:

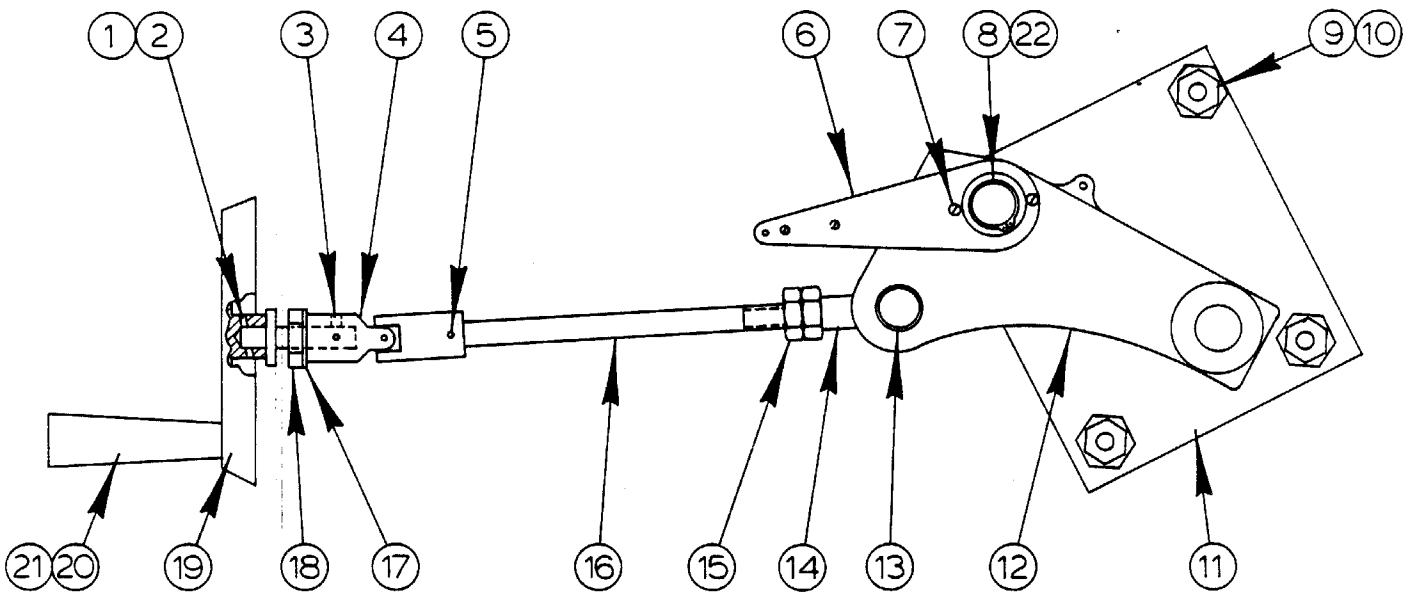
091-988956	. Screw, Rd. Hd. Mach. 1/4-20NC x 1/2.....	2
091-994665	. Screw, Rd. Hd. Self-Tap #10-24NC x 1/2.....	4

NEW DRG
SCL 3-12-85
REVISIONS
SCL 4-27-87
SCL 7-15-88



MODEL FIRST MACH. LAST MACH.  
2013-V 457-86101 457-87612

SPEED INDICATOR ASSEMBLY



VARIABLE LINKAGE SUB-ASSEMBLY

MODEL FIRST MACH. LAST MACH.  
2013-V 457-86101

DRIVE SUB-ASSEMBLIES

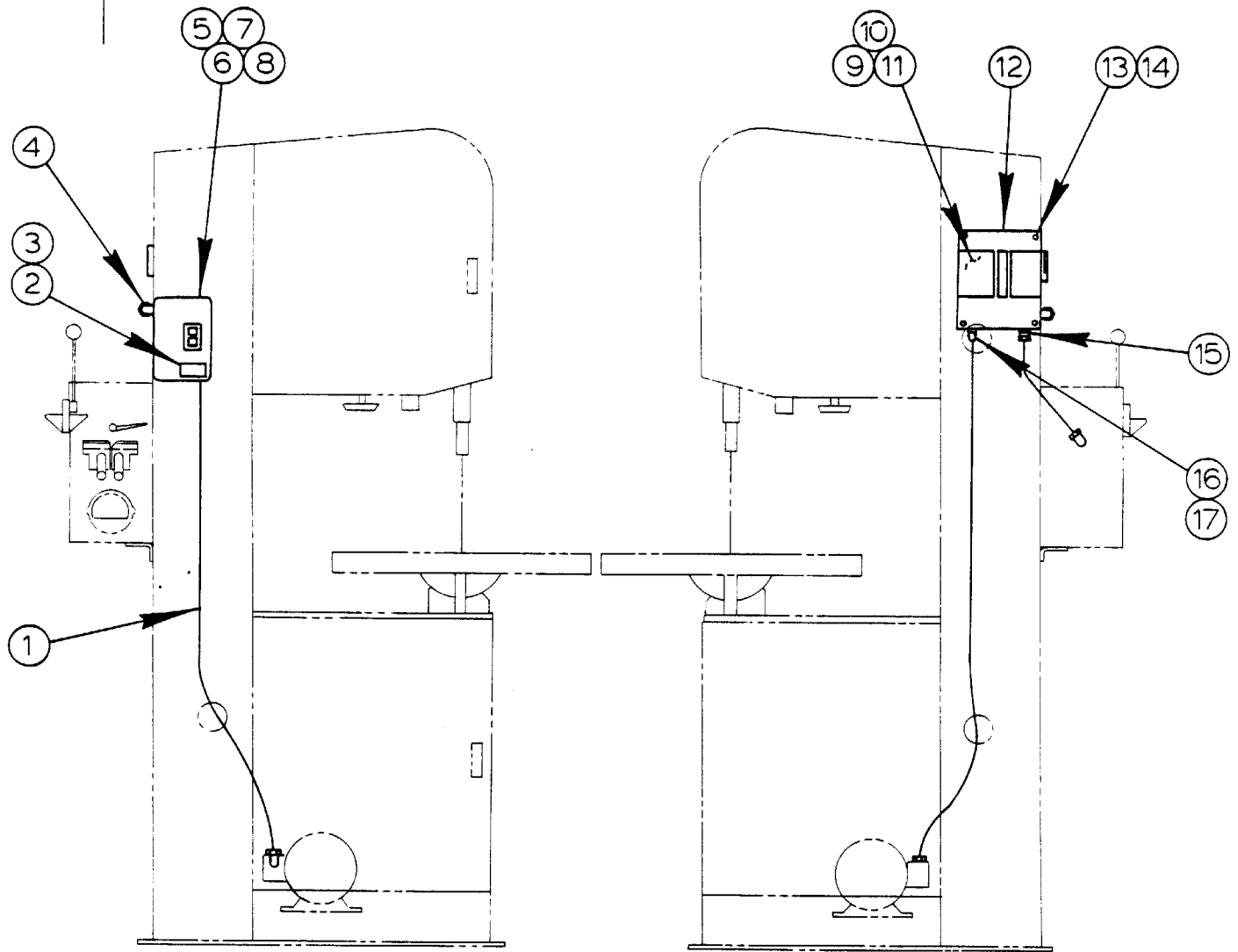
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DRIVE SUB-ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	093-147551	Speed Indicator Assembly (Inch/English)	
Ref.	093-146419	Speed Indicator Assembly (Metric/International)	
1	093-146355	. Dial (Inch/English).....	1
	093-146405	. Dial (Metric/International).....	1
2	091-194134	. Spacer.....	1
3	105-054076	. Pointer.....	1
4	091-984005	. Screw, Soc. Set #4-40NC x 1/8.....	1
5	091-988550	. Screw, Rd. Hd. Mach. #8-32NC x 1/2.....	2
6	091-187047	. Spacer.....	1
7	090-033564	. Wire.....	1
8	091-973172	. Nylon Tubing 3/16 O.D.....	A.R.
9	091-991091	. Nut, Hex. Jam #8-32NC.....	2
10	091-993188	. Washer, Lock #8 Std.....	2
11	091-186981	. Strap.....	1
Ref.	094-142684	Variable Linkage Sub-Assembly	
1	091-072801	. Shaft.....	1
2	090-042599	. Roll Pin.....	1
3	091-984229	. Screw, Soc. Set 1/4-20NC x 1/4.....	2
4	091-422535	. Universal Joint.....	1
5	090-042573	. Roll Pin.....	1
6	091-740126	. Indicator Arm Sub-Assembly.....	1
	091-186999	. . Arm.....	1
	091-992925	. . Washer, Flat #8-S Brass.....	1
	135-063287	. . Swivel Block.....	1
	091-986877	. . Screw, Fill. Hd. Mach. #4-40NC x 3/8.....	1
7	091-988543	. Screw, Rd. Hd. Mach. #8-32NC x 1/2.....	2
8	135-075588	. Retaining Ring.....	1
9	090-059569	. Adjusting Screw.....	4
10	091-991422	. Nut, Hex. Jam 3/4-16NF.....	3
11	093-151827	. Base.....	1
12	095-130175	. Arm.....	1
13	090-061755	. Trunnion Pin.....	1
14	090-079799	. Spacer.....	2
15	105-134100	. Screw Stop Nut 1/2-13NC x 3/8.....	4
16	093-151801	. Variable Screw.....	1
17	091-992669	. Washer, Flat 1/2 S.A.E Std.....	1
18	091-245944	. Bushing.....	1
19	090-425356	. Handwheel.....	1
20	091-181164	. Handle.....	1
21	091-181172	. Pin.....	1
22	090-029158	. Spacer.....	1

NEW DRG
SCL 10-8-85
REVISIONS
SCL 7-15-88



<u>MODEL</u>	<u>FIRST MACH.</u>	<u>LAST MACH.</u>
2013-V	457 - 86101	457 - 88969

ELECTRICAL ASSEMBLY

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ELECTRICAL ASSEMBLY

INDEX NO. Ref.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
		Electrical Assembly	
1	091-971564	. Sealtite Conduit 1/2 I.D. ....	A.R.
2	090-161563	. Escutcheon (Warning) .....	1
3	091-993964	. Screw, Rd. Hd. Drive #2 x 3/16 .....	4
4	090-145046	. 90° Sealtite Connector .....	4
5	091-651539	. Manual Starter (208V, 60 Hz) .....	1
	091-651547	. Manual Starter (230V, 60 Hz) .....	1
	091-651554	. Manual Starter (380V, 50 Hz) .....	1
	091-651562	. Manual Starter (415V, 50 Hz) .....	1
	091-651570	. Manual Starter (460V, 60 Hz) .....	1
	091-651588	. Manual Starter (575V, 60 Hz) .....	1
	091-577296	. Manual Starter (110/115V, 50/60 Hz) .....	1
	091-577304	. Manual Starter (220/230V, 50/60 Hz) .....	1
6	091-988691	. Screw, Rd. Hd. Mach. #10-24NC x 1/2 .....	3
7	091-993204	. Washer, Lock #10 Std. ....	5
8	091-991125	. Nut, Hex. #10-24NC .....	2
9	091-047704	. Ground Tag .....	1
10	091-391946	. Ground Terminal .....	1
11	091-988758	. Screw, Rd. Hd. Mach. #10-24NC x 1 .....	1
12	091-018234	. Safety Switch .....	1
13	091-990200	. Screw, Truss. Hd. Mach. 1/4-20NC x 1/2 .....	4
14	091-993212	. Washer, Lock 1/4 Std. ....	4
15	090-145459	. Sealtite Connector .....	1
16	090-157652	. 90° Jake Connector .....	1
17	090-145079	. 45° Sealtite Connector .....	1

Following Items Not Shown:

091-972349	. Grommet Strip .....	A.R.
091-971853	. Wire, #12 Black (Nylon Jacket) .....	A.R.

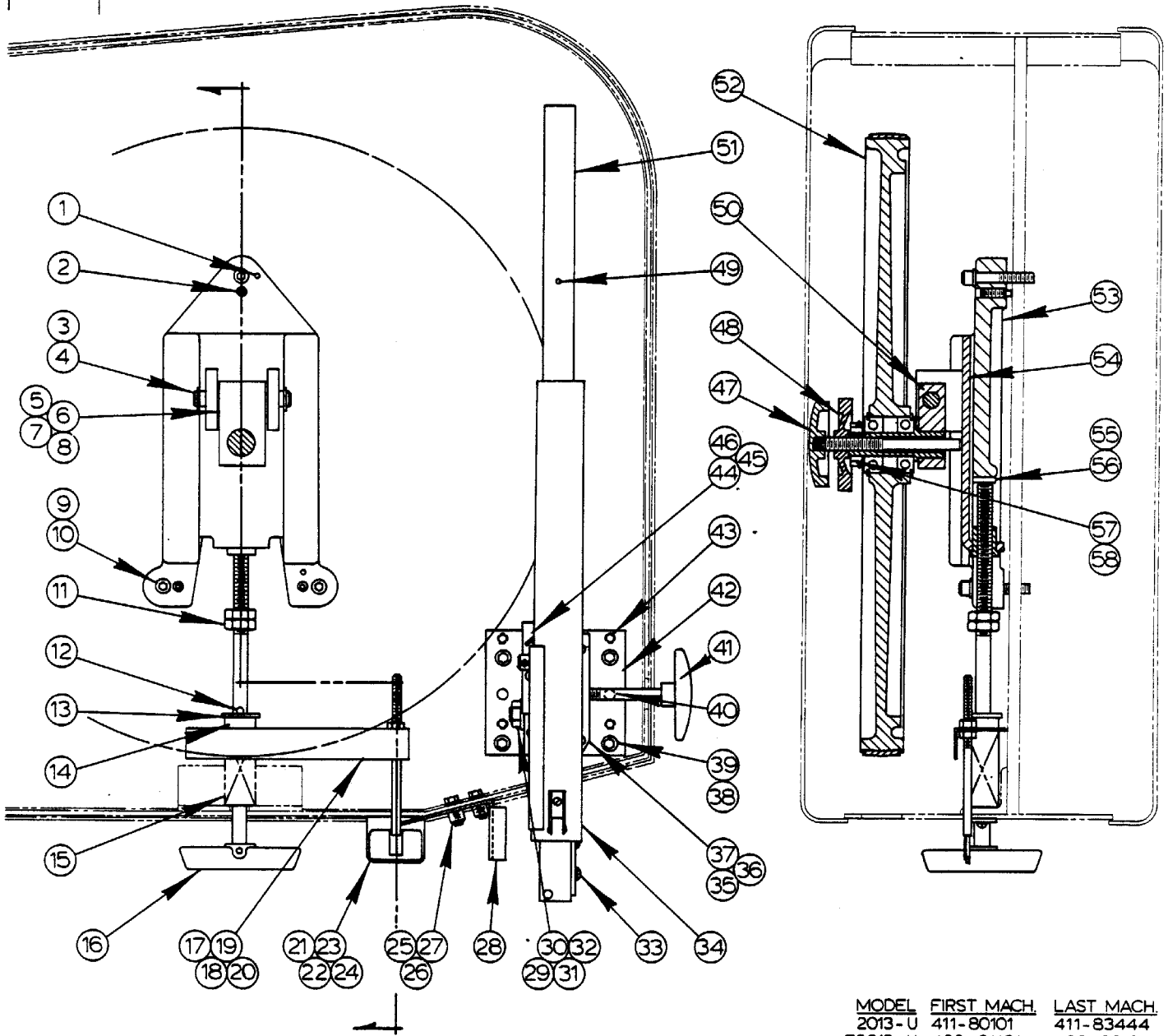
ELECTRICAL CONTROL ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
		Electrical Control Assembly	
1	091-761429	. Transformer (208V).....	1
	091-761411	. Transformer (230V, 460V, 575V).....	1
	091-761478	. Transformer (380V, 415V).....	1
2	091-988832	. Screw, Rd. Hd. Mach. #10-32NC x 1/4.....	4
3	091-993733	. Washer, Lock #10 Shakeproof Ext.....	4
4	091-755520	. Magnetic Contactor.....	1
5	091-755124	. Overload Relay (115V).....	1
	091-755090	. Overload Relay (208V, 230V 3 Phase).....	1
	091-755108	. Overload Relay (230V 1 Phase).....	1
	091-755082	. Overload Relay (380V).....	1
	091-755074	. Overload Relay (460V).....	1
	091-755066	. Overload Relay (575V).....	1
6	091-751057	. Safety Switch.....	1
7	091-755660	. Shaft Extension.....	1
8	091-755678	. Shaft Extension Interlock.....	1
9	091-391946	. Ground Terminal.....	1
10	091-047704	. Ground Tag.....	1
11	091-988758	. Screw, Rd. Hd. Mach. #10-24NC x 1.....	1
12	091-991125	. Nut, Hex. #10-24NC.....	2
13	094-153038	. Box.....	1
14	090-161563	. Escutcheon (Warning).....	1
15	091-696740	. Mounting Channel.....	A.R.
16	091-988519	. Screw, Rd. Hd. Mach. #8-32NC x 1/4.....	2
17	091-442194	. Fuse Block (115V Only).....	1
18	091-988519	. Screw, Rd. Hd. Mach. #8-32NC x 1/4 (115V Only).....	2
19	091-761486	. Fuse (.6 Amp).....	1
20	091-755652	. Pushbutton Operator (Green).....	1
21	091-755611	. Contact Block (1-NO).....	1
22	091-755637	. Pushbutton Operator (Red Mushroom).....	1
23	091-755629	. Contact Block (1-NC).....	1
24	091-755645	. Selector Switch Lever (2 Position).....	1
25	091-755611	. Contact Block (1-NO).....	1
26	091-745521	. Escutcheon (Standard).....	1
	091-745539	. Escutcheon (W/Worklight).....	1

ELECTRICAL CONTROL ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
		Electrical Control Assembly	
1	091-761429	. Transformer (208V).....	1
	091-761411	. Transformer (230V, 460V, 575V).....	1
	091-761478	. Transformer (380V, 415V).....	1
2	091-988832	. Screw, Rd. Hd. Mach. #10-32NC x 1/4.....	4
3	091-993733	. Washer, Lock #10 Shakeproof Ext.....	4
4	091-755520	. Magnetic Contactor.....	1
5	091-755124	. Overload Relay (115V).....	1
	091-755090	. Overload Relay (208V, 230V 3 Phase).....	1
	091-755108	. Overload Relay (230V 1 Phase).....	1
	091-755082	. Overload Relay (380V).....	1
	091-755074	. Overload Relay (460V).....	1
	091-755066	. Overload Relay (575V).....	1
6	091-751057	. Safety Switch.....	1
7	091-755660	. Shaft Extension.....	1
8	091-755678	. Shaft Extension Interlock.....	1
9	091-391946	. Ground Terminal.....	1
10	091-047704	. Ground Tag.....	1
11	091-988758	. Screw, Rd. Hd. Mach. #10-24NC x 1.....	1
12	091-991125	. Nut, Hex. #10-24NC.....	2
13	094-153038	. Box.....	1
14	090-161563	. Escutcheon (Warning).....	1
15	091-696740	. Mounting Channel.....	A.R.
16	091-988519	. Screw, Rd. Hd. Mach. #8-32NC x 1/4.....	2
17	091-442194	. Fuse Block (115V Only).....	1
18	091-988519	. Screw, Rd. Hd. Mach. #8-32NC x 1/4 (115V Only).....	2
19	091-761486	. Fuse (.6 Amp).....	1
20	091-755652	. Pushbutton Operator (Green).....	1
21	091-755611	. Contact Block (1-NO).....	1
22	091-755637	. Pushbutton Operator (Red Mushroom).....	1
23	091-755629	. Contact Block (1-NC).....	1
24	091-755645	. Selector Switch Lever (2 Position).....	1
25	091-755611	. Contact Block (1-NO).....	1
26	091-745521	. Escutcheon (Standard).....	1
	091-745539	. Escutcheon (W/Worklight).....	1

REVISED AND  
REDRAWN  
S.C.L. 10-10-85



MODEL	FIRST MACH.	LAST MACH.
2013-U	411-80101	411-83444
E2013-U	420-81101	420-82104
2013-V	439-83101	439-86903
2013-V	457-86101	

HEAD ASSEMBLY

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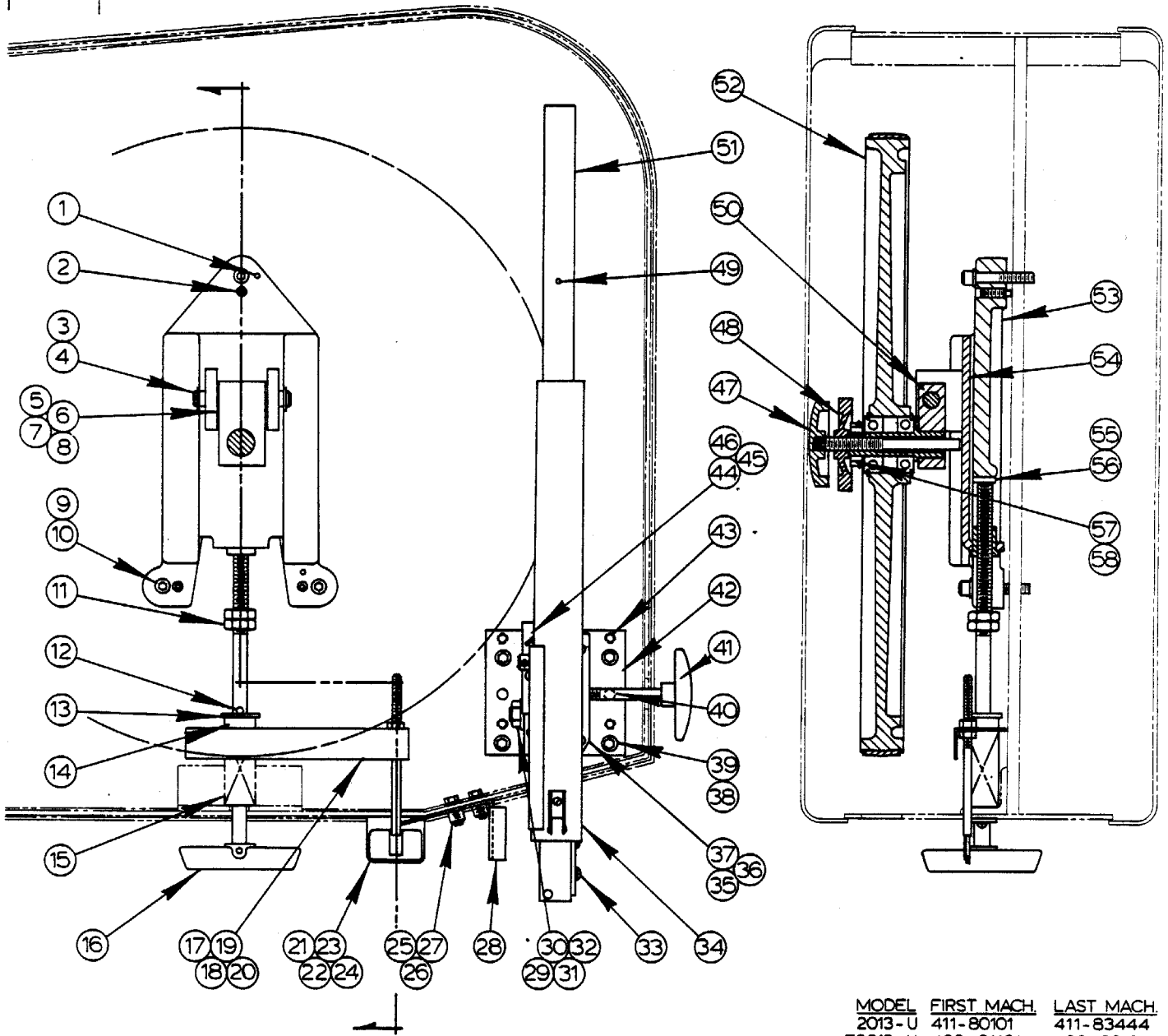
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S.C.L. 10-10-85



MODEL	FIRST MACH.	LAST MACH.
2013-U	411-80101	411-83444
E2013-U	420-81101	420-82104
2013-V	439-83101	439-86903
2013-V	457-86101	

HEAD ASSEMBLY

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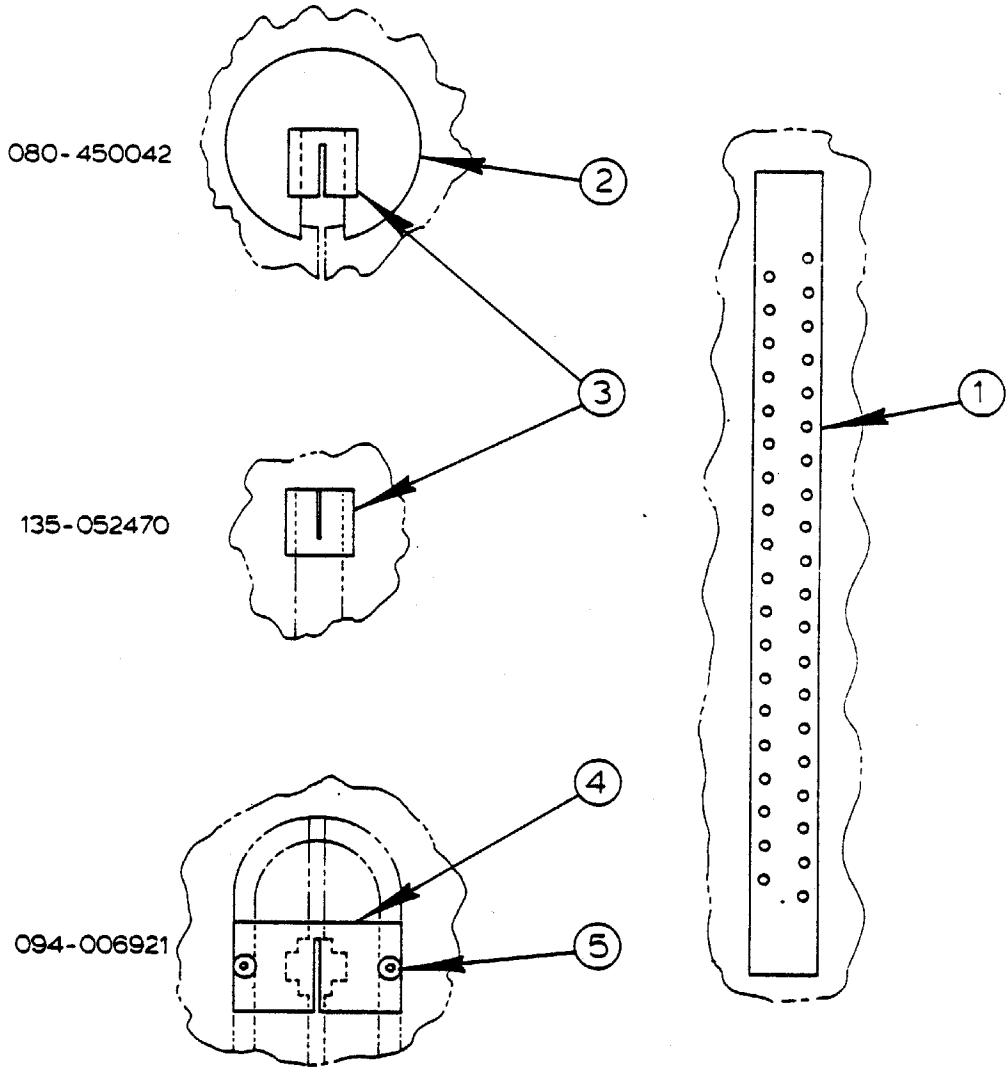
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HEAD ASSEMBLY

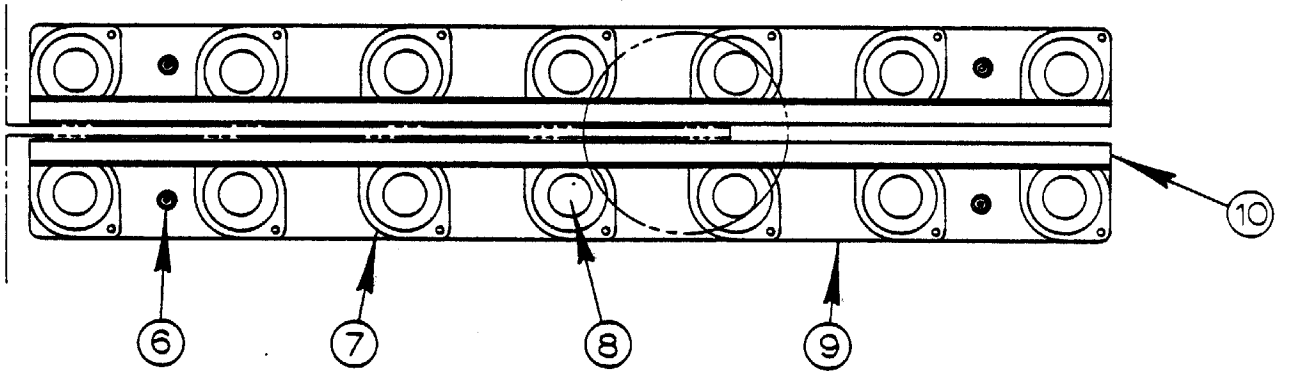
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY
1	095-086336	Head Assembly		*35	093-146397	. Post Guide.....	1
2	090-042656	. Roll Pin.....	1	36	091-982470	. Screw, Soc. Hd. Cap 1/4-20NC x 2	3
	091-986133	. Screw, Soc. Set 5/16-18NC x 1 (Half Dog Pt.).....	3	37	090-042847	. Roll Pin.....	2
		. Pin.....	1	38	091-982801	. Screw, Soc. Hd. Cap 3/8-16NC x 1-1/4.....	4
3	091-206276	. Retaining Ring.....	2	39	091-993329	. Washer, Lock 3/8 Std.....	4
4	135-096139	. Shim (.035)(If Supplied).....	A.R.	40	135-004455	. Dowel Pin (If Supplied).....	2
5	091-333104	. Shim (.0149)(If Supplied).....	A.R.	41	091-650762	. Lockscrew Sub-Assembly.....	1
6	091-333112	. Shim (.005)(If Supplied).....	A.R.		090-051319	. Handwheel.....	1
7	091-333120	. Shim (.003)(If Supplied).....	A.R.		090-042292	. Roll Pin.....	1
8	091-333138	. Screw, Soc. Hd. Cap 5/16-18NC x 2..	3		091-647534	. Stud.....	1
9	091-982645	. Washer, Lock 5/16 Std.....	3	42	094-105632	. Post Guide Plate.....	1
10	091-993238	. Nut, Hex. Jam 1/2-13NC.....	3	43	091-984591	. Screw, Soc. Set 3/8-24NF x 1....	4
11	091-991323	. Roll Pin.....	1	44	091-650796	. Guard Stop Assembly.....	1
12	090-042599	. Washer, Flat 1/2 S.A.E. Std.....	1		091-650770	. Stop.....	1
13	091-992669	. Thrust Bearing.....	1		091-650788	. Stop Mount.....	1
14	135-028108	. Spring.....	1	45	091-980086	. Screw, Hex. Hd. Cap 1/4-20NC x 3/4.....	1
15	136-087617	. Band Tension Screw Sub-Assembly....	1	46	091-992586	. Washer, Flat #10 S.A.E. Std.....	1
16	093-044956	. Handwheel.....	1	47	091-391821	. Tilting Screw Sub-Assembly.....	1
	105-161020	. Screw.....	1		105-011084	. Knob.....	1
	091-391235	. Roll Pin.....	1		091-391573	. Tilting Screw.....	1
17	091-440628	. Angle.....	1		105-011092	. Tilting Locknut.....	1
18	091-991232	. Nut, Hex. Jam 5/16-18NC.....	2	48	091-982355	. Screw, Soc. Hd. Cap 1/4-20NC x 3/8.....	1
19	091-422501	. Band Tension Pointer.....	1	49		. Wheel Hinge Sub-Assembly.....	1
20	091-630803	. Retaining Compound (Loctite #271)..	A.R.	50	093-023463	. Axis Stud.....	1
21	091-391227	. Bracket.....	1		105-014245	. Block.....	1
22	091-994657	. Screw, Rd. Hd. Self-Tap #10-24NC x 3/8.....	2		091-206243	. Screw, Soc. Set 1/4-20NC x 5/16	1
		. Washer, Lock #10 Std.....	3		091-984237	. Post.....	1
23	091-993204	. Escutcheon (Band Tension)(Inch/English).....	1	51	093-030294	. Bandwheel Assembly.....	1
24	091-177378	. Escutcheon (Band Tension)(Metric/International).....	1	52	094-025988	. Tire.....	1
	091-314245	. Thumb Screw.....	2		091-253575	. Bandwheel.....	1
25	091-333724	. Screw, Hex. Hd. Cap 1/4-20NC x 3/4..	2		094-025970	. Wheel Bearing.....	2
26	091-980086	. Washer, Lock 1/4 Std.....	2	53	105-015085	. Head Casting.....	1
27	091-993212	. Guard Guide.....	1	54	095-046215	. Head Slide Sub-Assembly.....	1
28	093-044659	. Screw, Soc. Set 1/2-13NC x 1 (Half Dog Pt.).....	1		094-153699	. Slide.....	1
29	091-986117	. Belleville Washer.....	1		093-168532	. Pad.....	2
30	091-052639	. Washer, Flat #6 S.A.E. Std. (Cadmium).....	1	55	091-759696	. Coupling Nut.....	1
31	091-992735	. Friction Plug.....	1	56	091-758318	. Bumper.....	1
32	091-710491	. Screw, Fill. Hd. Mach. #10-24NC x 1/2.....	2	57	091-656868	. Cement.....	A.R.
33	091-986984	. Saw Band Guard Assembly.....	1	58	134-015031	. Bearing Lockwasher.....	1
	093-060549	. Guard Weldment.....	1		105-015077	. Bearing Locknut.....	1
	093-044451	. Guard Slide Cover.....	1		105-015069		
	091-388157	. Thumb Nut.....	2				
	090-030487	. Spring Clip (If Supplied).....	1				

\*NOTE: #35 was 093-089290 Before Serial #439-85805 And On All 2013-U and E2013-U Models.

REVISED AND  
REDRAWN  
SCL 2-27-81



HEAVY WORK SUPPORT ASSEMBLY



HEAVY DUTY WORK TRANSFER ASSEMBLY

C-10-23 CM-10-33 Z-10-12

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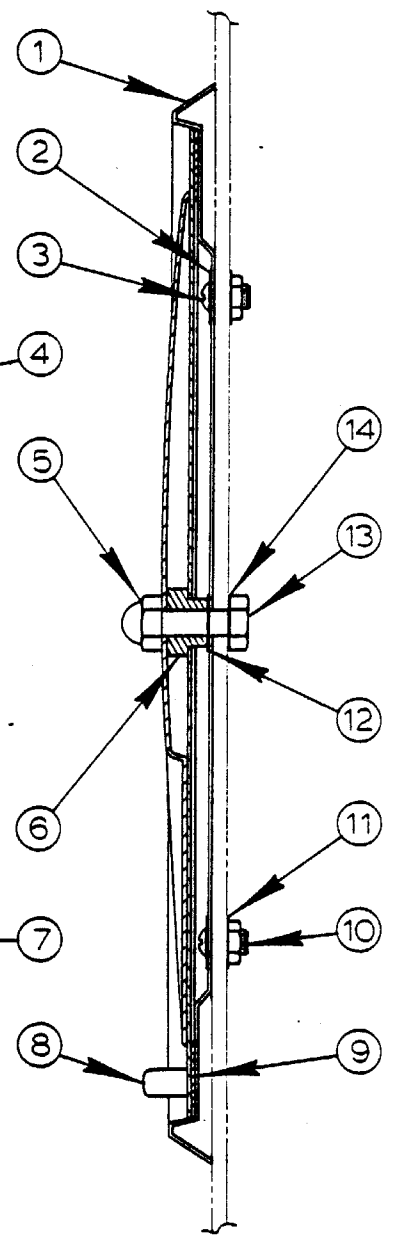
CODE NO. C-10-23  
CM-10-33  
Z-10-12

HEAVY WORK SUPPORT AND HEAVY  
DUTY WORK TRANSFER ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	080-450042	Heavy Work Support Assembly (1612, 1612-0, 1612-1, 2013, 2013-0, 2013-1, 2013-10, 2013-2, 2013-20, 2012-2A, 2612-1, 2614-1, 3612, 3612-1, 3613-0, 3613-1, 3613-10, 3613-2, 3613-20, E3613-20, 2013-V)	
Ref.	135-052470	Heavy Work Support Assembly (1613-2, 2613-2, 3613-2, 6013-2, ZS-3620, ZV-3620, ZW-3620, HS-6013)	
Ref.	094-006921	Heavy Work Slide Assembly (2612-2H)	
1	106-233190	. Transport Bar .....	2
2	090-279506	. Center Plate .....	1
3	106-234529	. Center Support .....	1
4	091-178145	. Center Support .....	1
5	091-983205	. Screw, Flat Hd. Soc. Cap 1/4-20NC x 3/4 .....	2
Ref.	094-006145	Heavy Duty Work Transfer Assembly (1612-H, 1612-3, 2012-A, 2012-AT, 2012-1H, 2012-1H3, 2012-2H, 2013-1, 2013-10, 2612-H, 2612-2H, 2612-1H, 2612-1H3, 2613-3, 2614-1, 3612, 3612-H, 3612-3, 3612-1H, 3612-1H3, 3612-2H, 3612-2H3, 3613-20, 6013-2, 6013-H3)	
6	091-982397	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4 .....	4
7	090-333667	. Heavy Duty Work Transfer Assembly .....	2
8	091-085878	. . Ball Transfer .....	7
*9	090-333683	. . Bar .....	1
10	090-333675	. . Shield .....	1

\*NOTE: For Machines with Assembly 090-314477 Heavy Duty Transfer Assembly Use 091-085860 Bar Instead of Item #9.

REVISED AND  
REDRAWN  
SCL 3-6-81  
SCL 9-17-84



FIRST USED SEPTEMBER 17, 1962

JOB SELECTOR ASSEMBLY

C-8-104 CM-8-53 Z-6-54

PRINTED IN U.S.A.

CODE NO. C-8-104  
CM-8-53  
Z-6-54

JOB SELECTOR ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
REF.	090-468174	Job Selector Assembly (Inch/English)	
REF.	094-060829	Job Selector Assembly (Metric/International)	
REF.	094-097201	Job Selector Assembly (Metric/English)	
REF.	094-060514	Job Selector Assembly (2012-A, 2013; For Sweden)	
REF.	090-435603	Job Selector Assembly (Inch/English)(16M, 1612-1, 26-2, 26-3, 2612-1, 2613-2, 36-2, 36-W, 3613-1, 149 Prefix Only, 6013-2, HS-6013)	
*1	090-426727	. Job Selector Frame.....	1
*2	091-992602	. Washer, Flat 1/4 S.A.E. Std.....	4
*3	091-988907	. Screw, Rd. Hd. Mach. 1/4-20NC x 1/4.....	4
4	094-008380	. Job Selector Plate (Inch/English).....	1
	094-009370	. Job Selector Plate (Metric/International).....	1
	094-097185	. Job Selector Plate (Metric/English).....	1
	094-015534	. Job Selector Plate (For Sweden).....	1
5	090-044499	. Acorn Nut 5/16-18NC.....	1
6	106-144017	. Bushing.....	1
	090-027012	. Bushing (Assembly #090-435603 Only).....	1
7	094-008398	. Job Selector Dial (Inch/English).....	1
	094-009388	. Job Selector Dial (Metric/International, for Sweden).....	1
	094-097193	. Job Selector Dial (Metric/English).....	1
8	134-144039	. Knob.....	1
9	106-143043	. Outer Edge Felt.....	4
*10	091-991141	. Nut, Hex. Jam 1/4-20NC.....	4
*11	091-993741	. Washer, Lock 1/4 Shakeproof Ext.....	4
*12	091-992628	. Washer, Flat 5/16 S.A.E. Std.....	1
13	091-990283	. Screw, Truss Hd. Mach. 5/16-18NC x 2/4.....	1
	091-980300	. Screw, Hex. Hd. Cap 5/16-18NC x 1 1/4 (Assembly #090-435603 Only).....	1
*14	091-993238	. Washer, Lock, 5/16 Stud.....	1

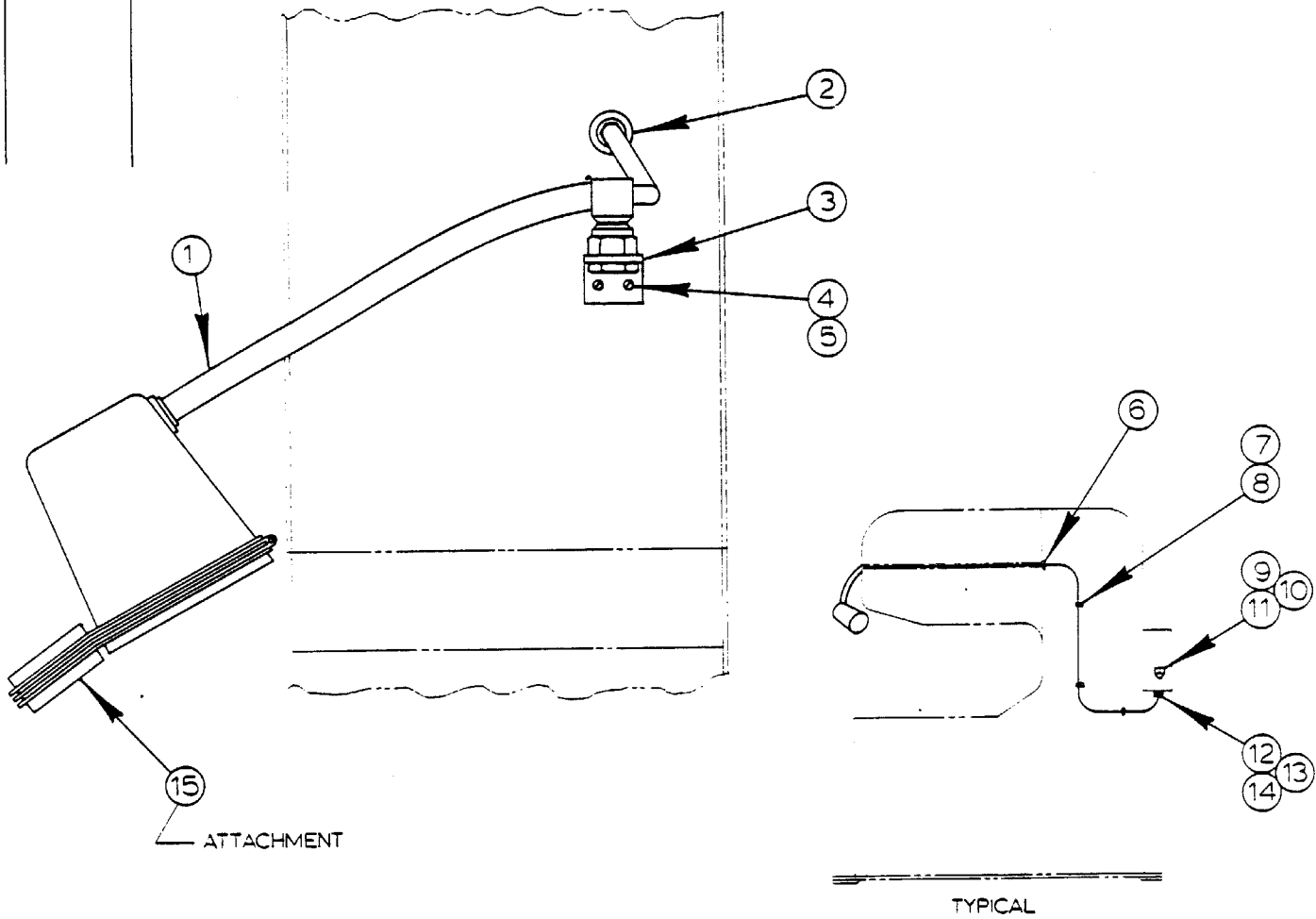
\*NOTE: These Items used on Assembly #090-435603 Only.

\*\*NOTE: Before 9-17-62, #094-008380 And #094-008398 Must Be Ordered As A Unit.

If the following machines are supplied with a set of Job Selector cards, use assembly #094-015610 Job Selector Assembly (See Detail): 1612-H, 1612-3, 1613-2, 2612-2H, 2612-H, 2613-2, 3612-H, 3612-3, 3613-2, 151 prefix only, 6013-2, 6013-3.

REVISED AND  
REDRAWN

S.C.L. 9-10-84



O.S.H.A. REQUIREMENT:

WIRE LAMP DIRECT TO CONTROL  
BOX. MOUNT SWITCH ON SIDE OF  
CONTROL BOX.

NOTE:

ORDER PARTS THAT ARE  
APPLICABLE TO YOUR  
MACHINE.

USED ON ALL MODELS WITH  
WORKLAMP SINCE 1964

LAMP ASSEMBLY & MAGNIFIER

C - 8 - 9 CM - 8 - 14 Z - 7 - 10

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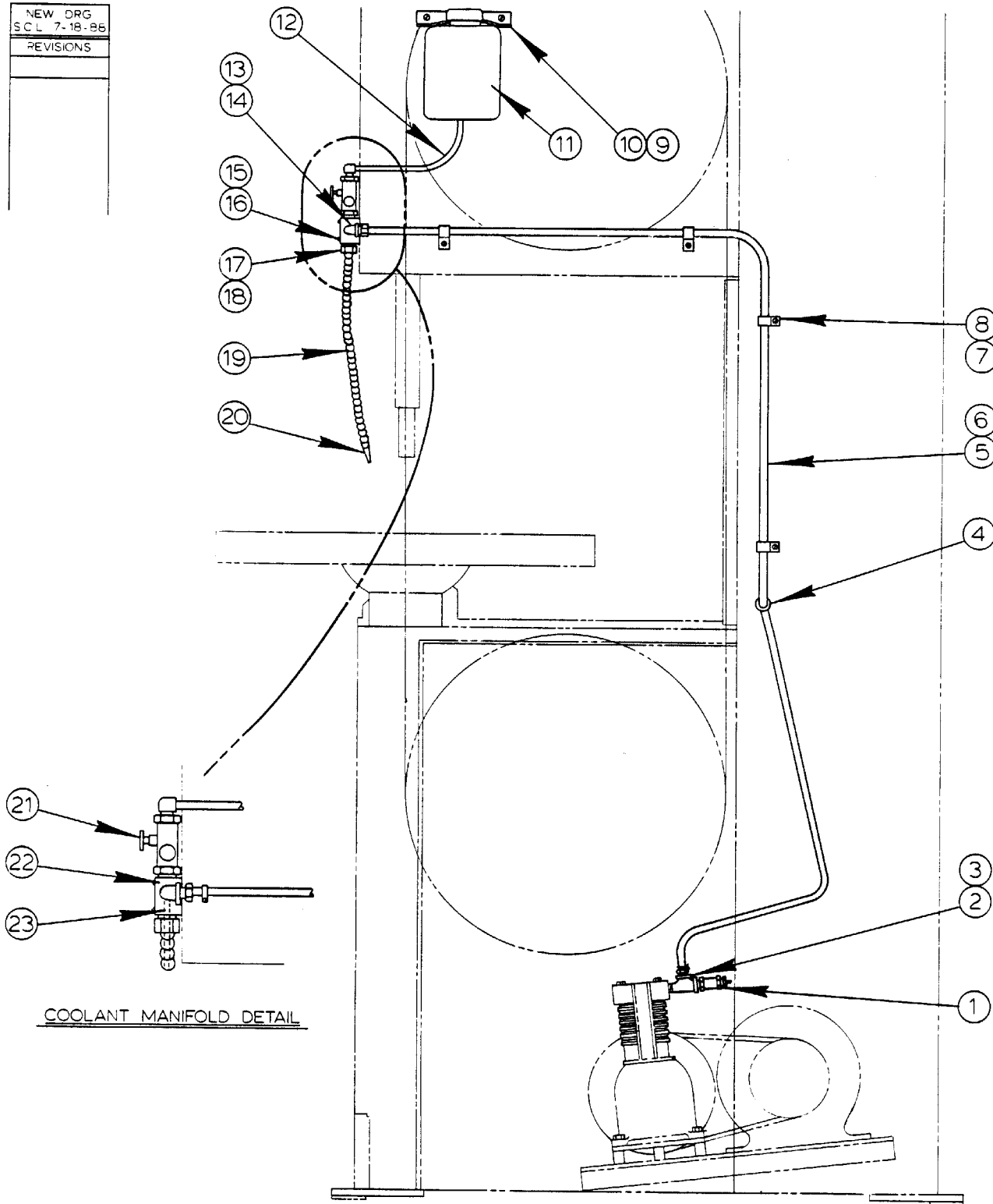
CODE NO. C-8-9  
CM-8-14  
Z-7-10

LAMP ASSEMBLY AND MAGNIFIER

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
REF		Lamp Assembly	
*1	091-688424	. Lamp Assembly (W/O Plug).....	1
*	091-688440	. Lamp Assembly (W/Plug) (2013-V, E2013-V Only).....	1
*	091-688432	. Lamp Assembly (Extra Work Height).....	1
2	090-151390	. Cord Grip Connector.....	1
	091-375576	. Bushing (1612, 1612-0, 1612-H Only).....	1
	090-157801	. Rubber Grommet (ZS-3620, ZV-3620, ZW-3620 Only).....	2
3	091-025049	. Bracket.....	1
4	091-988659	. Screw, Rd. Hd. Mach. #10-24NC x 1/4.....	2
5	091-993196	. Washer, Lock #10 Std.....	2
6	090-055930	. Plastic Bushing.....	1
	090-151390	. Cord Grip Connector.....	1
7	090-099557	. Tubing Clamp (If Supplied).....	A.R.
	090-172479	. Hose Clamp (2013-V, E2013-V Only).....	3
8	091-988675	. Screw, Rd. Hd. Mach. #10-24NC x 3/8.....	A.R.
	091-994699	. Screw, Rd. Hd. Self-Tap #8-32NC x 1/2 (2013-V, E2013-V Only)	3
9	090-152455	. Selector Switch (2 Position).....	1
10	091-048207	. Contact Block (1-NO).....	1
11	091-333591	. Legend Plate (Worklight) (English).....	1
	091-369135	. Legend Plate (Worklight) (International).....	1
12	090-145459	. Sealite Connector.....	1
	090-151390	. Cord Grip Connector (W/Rubber Bushing).....	1
13	090-144114	. Flange Washer.....	1
14	090-145053	. O-Ring.....	1
15	081-384364	. Magnifier (Optional).....	1
*NOTE: If Your Machine Has Old Style Bracket (Item #3), Also Order Instead Of Items #4 And 5:			
4	091-988931	. Screw, Rd. Hd. Mach. 1/4-20NC x 5/16.....	2
	091-988956	. Screw, Rd. Hd. Mach. 1/4-20NC x 1/2 (2013-V, E2013-V Only)..	2
5	091-993212	. Washer, Lock 1/4 Std.....	2



NEW DRG
SCL 7-18-86
REVISIONS



COOLANT MANIFOLD DETAIL

MODEL FIRST MACH. LAST MACH.  
2013-V 457-86101

MIST COOLANT ASSEMBLY

C - 8 - 12

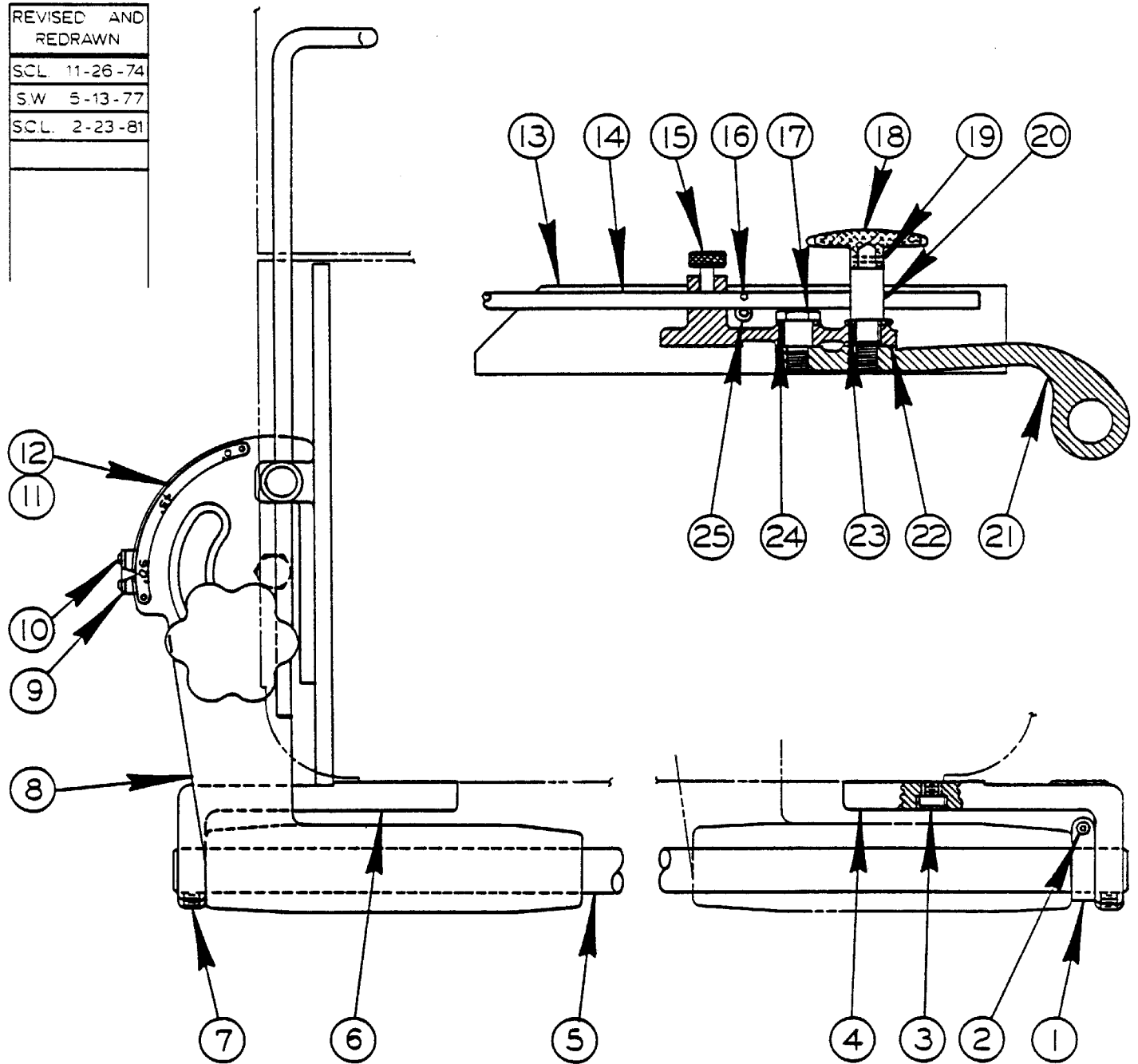
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D-7

MIST COOLANT ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	085-123149	Mist Coolant Assembly	
1	091-283796	. Safety Valve.....	1
2	135-008472	. Service Tee.....	1
3	090-020041	. Barbed Insert.....	1
4	090-058470	. Grommet.....	1
5	091-970962	. Neoprene Hose 5/8 O.D. (Black).....	A.R.
6	090-179029	. Hose Clamp.....	2
7	091-323758	. Conduit Strap.....	4
8	091-994848	. Screw, Rd. Hd. Self-Tap 1/4-20NC x 1/2.....	4
9	093-039568	. Bracket.....	1
10	091-994848	. Screw, Rd. Hd. Self-Tap 1/4-20NC x 1/2.....	2
11	091-369181	. Bottle Assembly.....	1
12	091-971440	. Plastic Tubing 1/4 I.D. (Clear).....	A.R.
13	091-281790	. Barbed Insert.....	1
14	105-045207	. 90° Street Elbow.....	1
15	091-994830	. Screw, Rd. Hd. Mach. #10-24NC x 1-1/2.....	2
16	090-383035	. Coolant Manifold Assembly.....	1
17	091-725309	. . Coolant And Air Hose.....	1
18	091-725291	. . . Connector.....	1
19	091-973222	. . . Segmented Hose (Specify Length).....	A.R.
20	091-725283	. . . Nozzle.....	1
21	105-275077	. . Sight Feed Valve.....	1
22	091-199109	. . Manifold.....	1
23	091-199778	. . Coolant Tube Assembly (Standard).....	1
	091-971408	. . . Nylon Tubing .089 O.D. (Specify Length).....	A.R.
	091-368936	. . . Glue (Meta Grip #3802).....	A.R.
	091-199125	. . . Pipe Plug.....	1

REVISED AND REDRAWN
SCL. 11-26-74
S.W. 5-13-77
SCL. 2-23-81



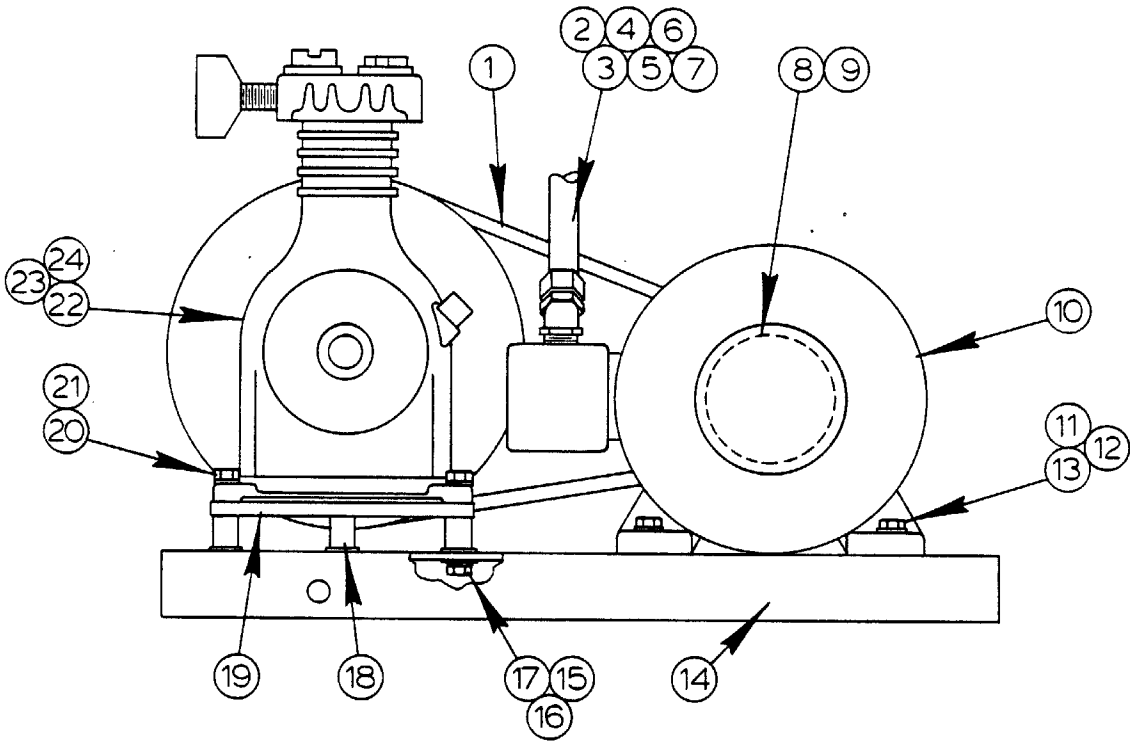
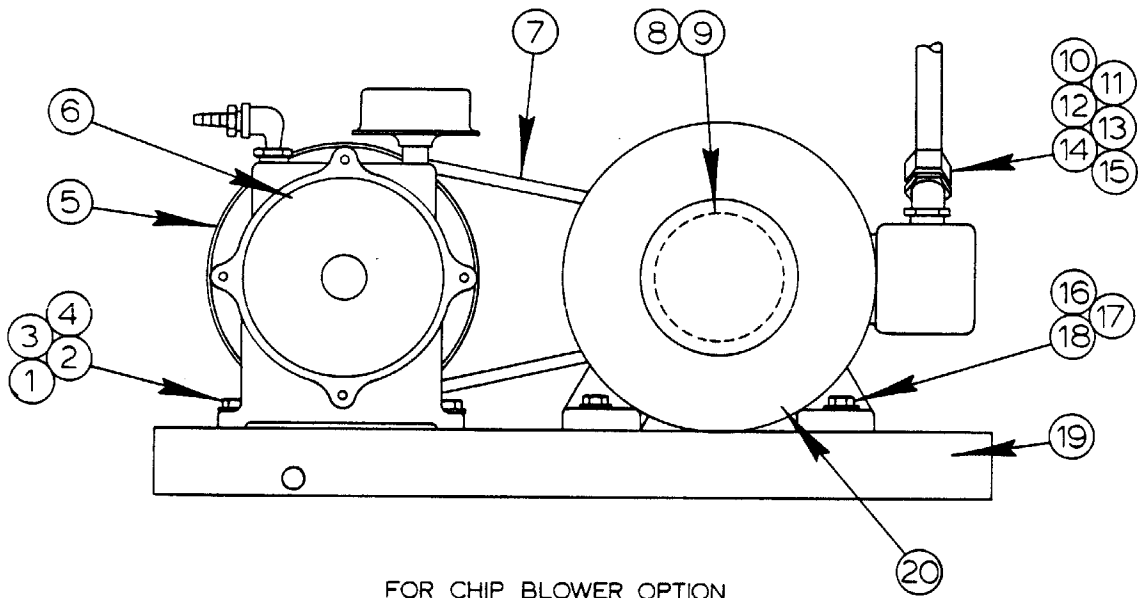
MITRE ASSEMBLY  
(\*2 STD. CUT-OFF)

C-10-28 Z-10-6  
D-9

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MITRE ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	090-504192	Mitre Assembly (#2 Std. Cut-off)(20" x 20" Table)	
Ref.	080-552904	Mitre Assembly (#2 Std. Cut-off)(24" x 24" Table)	
Ref.	080-553050	Mitre Assembly (#2 Std. Cut-off)(26" x 26" Table)	
Ref.	080-505118	Mitre Assembly (#2 Std. Cut-off)(30" x 30" Table)	
1	111-281093	. Stop Collar .....	1
2	091-982207	. Screw, Soc. Hd. Cap #10-24NC x 1/2 (20", 24", 30" Tables) .....	1
	091-982199	. Screw, Soc. Hd. Cap #10-24NC x 3/8 (26" Table)	1
3	091-982769	. Screw, Soc. Hd. Cap 3/8-16NC x 1/2 (20", 30" Tables) .....	4
	091-982785	. Screw, Soc. Hd. Cap 3/8-16NC x 3/4 (24", 26" Tables) .....	4
4	090-036823	. Rear Slide Rod Bracket (20" Table) .....	1
	090-295833	. Rear Slide Rod Bracket (24", 26", 30" Tables) ....	1
5	103-204061	. Slide Rod (20" Table) .....	1
	104-204011	. Slide Rod (24" Table) .....	1
	091-019356	. Slide Rod (26" Table) .....	1
	091-019315	. Slide Rod (30" Table) .....	1
6	090-036815	. Front Slide Rod Bracket (20" Table) .....	1
	090-295841	. Front Slide Rod Bracket (24", 26", 30" Tables) ...	1
7	091-984237	. Screw, Soc. Set 1/4-20NC x 5/16 .....	2
8	090-507112	. Mitre Sub-Assembly (20" Table) .....	1
	090-507104	. Mitre Sub-Assembly (24" Table) .....	1
	090-553041	. Mitre Sub-Assembly (26" Table) .....	1
	090-507120	. Mitre Sub-Assembly (30" Table) .....	1
9	090-036765	. . Pointer .....	1
10	091-990085	. . Screw, Truss Hd. Mach. #8-32NC x 1/4 .....	2
11	090-036724	. . Degree Plate .....	1
12	091-993998	. . Screw, Rd. Hd. Drive #4 x 1/4 .....	4
13	103-203063	. . Mitre Bar (20" Table) .....	1
	104-203013	. . Mitre Bar (24" Table) .....	1
	091-029447	. . Mitre Bar (26" Table) .....	1
	111-203014	. . Mitre Bar (30" Table) .....	1
14	104-203021	. . Gauge Rod .....	1
15	134-174010	. . Thumb Screw .....	1
16	090-042540	. . Roll Pin .....	2
17	134-204072	. . Mitre Head Pivot .....	1
18	090-051319	. . Handwheel .....	1
19	090-042292	. . Roll Pin .....	1
20	090-036773	. . Stud .....	1
21	090-405986	. . Slide Arm .....	1
22	090-209412	. . Mitre Head .....	1
23	134-204106	. . Locking Stud Washer .....	1
24	134-204098	. . Pivot Washer .....	1
25	091-982363	. . Screw, Soc. Hd. Cap 1/4-20NC x 1/2 .....	2



MODEL   FIRST MACH.   LAST MACH.  
 2013-V   457-86101

MOTOR BASE ASSEMBLY

MOTOR BASE ASSEMBLY

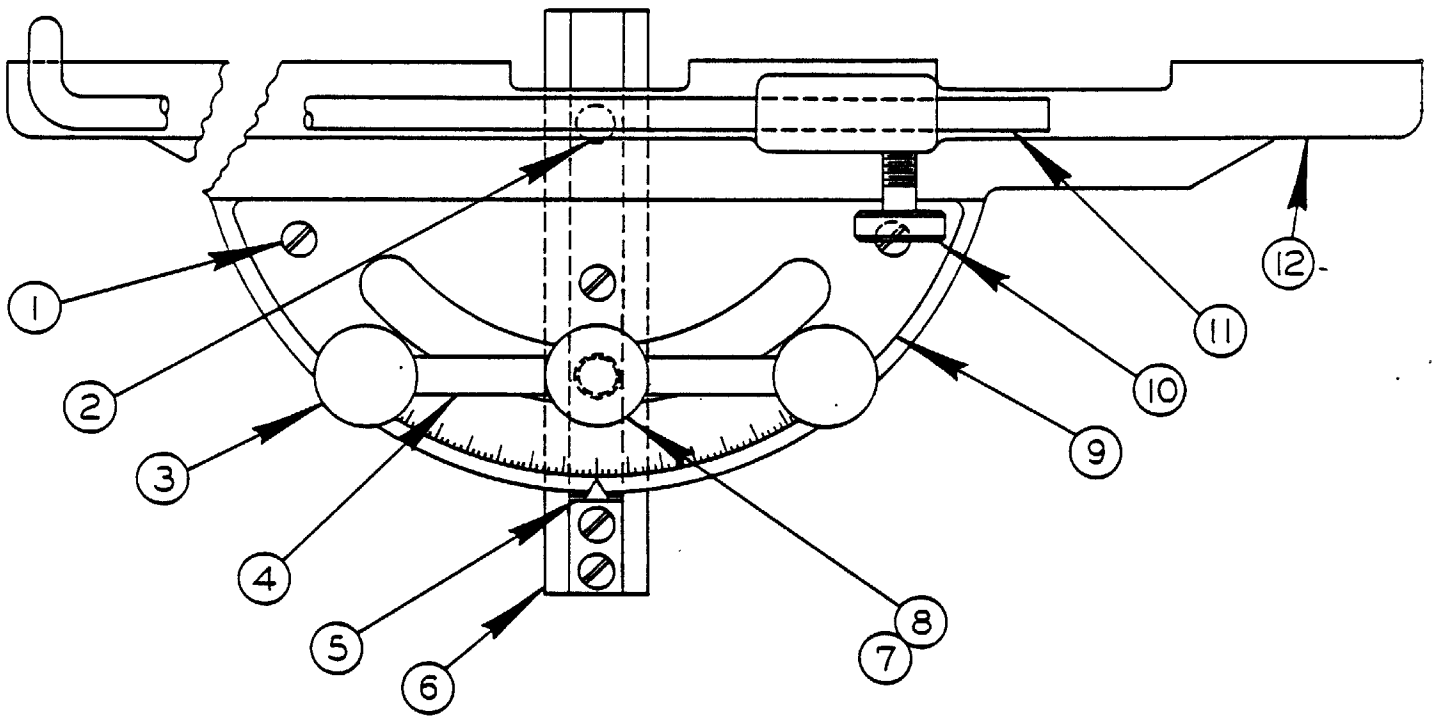
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.		Motor Base Assembly (w or w/o Chip Blower Option)	
1	091-980110	. Screw, Hex. Hd. Cap 1/4-20NC x 1-1/4.....	2
2	091-992602	. Washer, Flat 1/4 S.A.E. Std.....	2
3	091-993212	. Washer, Lock 1/4 Std.....	2
4	091-991158	. Nut, Hex. 1/4-20NC.....	2
5	105-113161	. Pulley.....	1
6	090-427089	. Air Pump Assembly (See Detail).....	1
7	135-003408	. V-Belt.....	1
8	093-088243	. Pulley (60 Hz).....	1
	093-118206	. Pulley (50 Hz).....	1
9	091-984252	. Screw, Soc. Set 1/4-20NC x 1/2.....	1
10	091-971564	. Sealtite Conduit 1/2 I.D.....	A.R.
11	091-971853	. Wire, #12 Black (Nylon Jacket).....	A.R.
	091-971788	. Wire, #10 Black (Nylon Jacket)(115V Only).....	A.R.
12	091-971861	. Wire, #12 Green/Yellow (Flamenal).....	A.R.
	091-972430	. Wire, #10 Green/Yellow (Flamenal)(115V Only).....	A.R.
13	090-145079	. 45° Sealtite Connector.....	1
14	090-144114	. Flange Washer.....	1
15	090-145053	. O-Ring.....	1
16	091-980300	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/4.....	4
17	091-993014	. Washer, Flat 5/16 Wrought.....	4
18	091-991224	. Nut, Hex. 5/16-18NC.....	4
19	095-127338	. Motor Base Plate.....	1
20	091-338798	. Electric Motor (115V).....	1
	091-733717	. Electric Motor (208V, 240V, 480V).....	1
	091-410019	. Electric Motor (415V).....	1
	091-361170	. Electric Motor (575V).....	1
	091-490359	. Electric Motor (50 Hz).....	1
Ref.		Motor Base Assembly (w/Mist Coolant and/or Air Table Option)	
1	090-027723	. V-Belt.....	1
2	091-971564	. Sealtite Conduit 1/2 I.D.....	A.R.
3	091-971853	. Wire, #12 Black (Nylon Jacket).....	A.R.
	091-971788	. Wire, #10 Black (Nylon Jacket)(115V Only).....	A.R.
4	091-971861	. Wire, #12 Green/Yellow (Flamenal).....	A.R.
	091-972430	. Wire, #10 Green/Yellow (Flamenal)(115V Only).....	A.R.
5	090-145079	. 45° Sealtite Connector.....	1
6	090-144114	. Flange Washer.....	1
7	090-145053	. O-Ring.....	1
8	093-088243	. Pulley (60 Hz).....	1
	093-118206	. Pulley (50 Hz).....	1
9	091-984252	. Screw, Soc. Set 1/4-20NC x 1/2.....	1
10	091-338798	. Electric Motor (115V).....	1
	091-733717	. Electric Motor (208V, 240V, 480V).....	1
	091-410019	. Electric Motor (415V).....	1
	091-361170	. Electric Motor (575V).....	1
	091-490359	. Electric Motor (50 Hz).....	1
11	091-980300	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/4.....	4
12	091-993014	. Washer, Flat 5/16 Wrought.....	4
13	091-991224	. Nut, Hex. 5/16-18NC.....	4
14	095-127338	. Motor Base Plate.....	1
15	091-980347	. Screw, Hex. Hd. Cap 5/16-18NC x 2-1/2.....	2
16	091-992628	. Washer, Flat 5/16 S.A.E. Std.....	6
17	091-211607	. Spacer.....	2
18	091-211615	. Spacer.....	1
19	091-211631	. Plate Weldment.....	1
20	091-980276	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4.....	2
21	091-993238	. Washer, Lock 5/16 Std.....	5
*22	094-019577	. Air Compressor.....	1
23	091-384461	. Oil (ASTM Grade 465).....	A.R.
24	091-318170	. Tag.....	1
	091-971796	. Wire, #10 White (Nylon Jacket).....	A.R.

Following Not Shown:

091-971796 . Wire, #10 White (Nylon Jacket)..... A.R.

\*NOTE: Order Compressor Parts From Manufacturer (Model #28 - E.L. Smith And Sons).

REVISED AND REDRAWN
SCL 11-22-74
SCL 3-9-81



PROTRACTOR WORK STOP  
AND  
ALIGNMENT GAGE ASSEMBLY

C-10-42 CM-10-7

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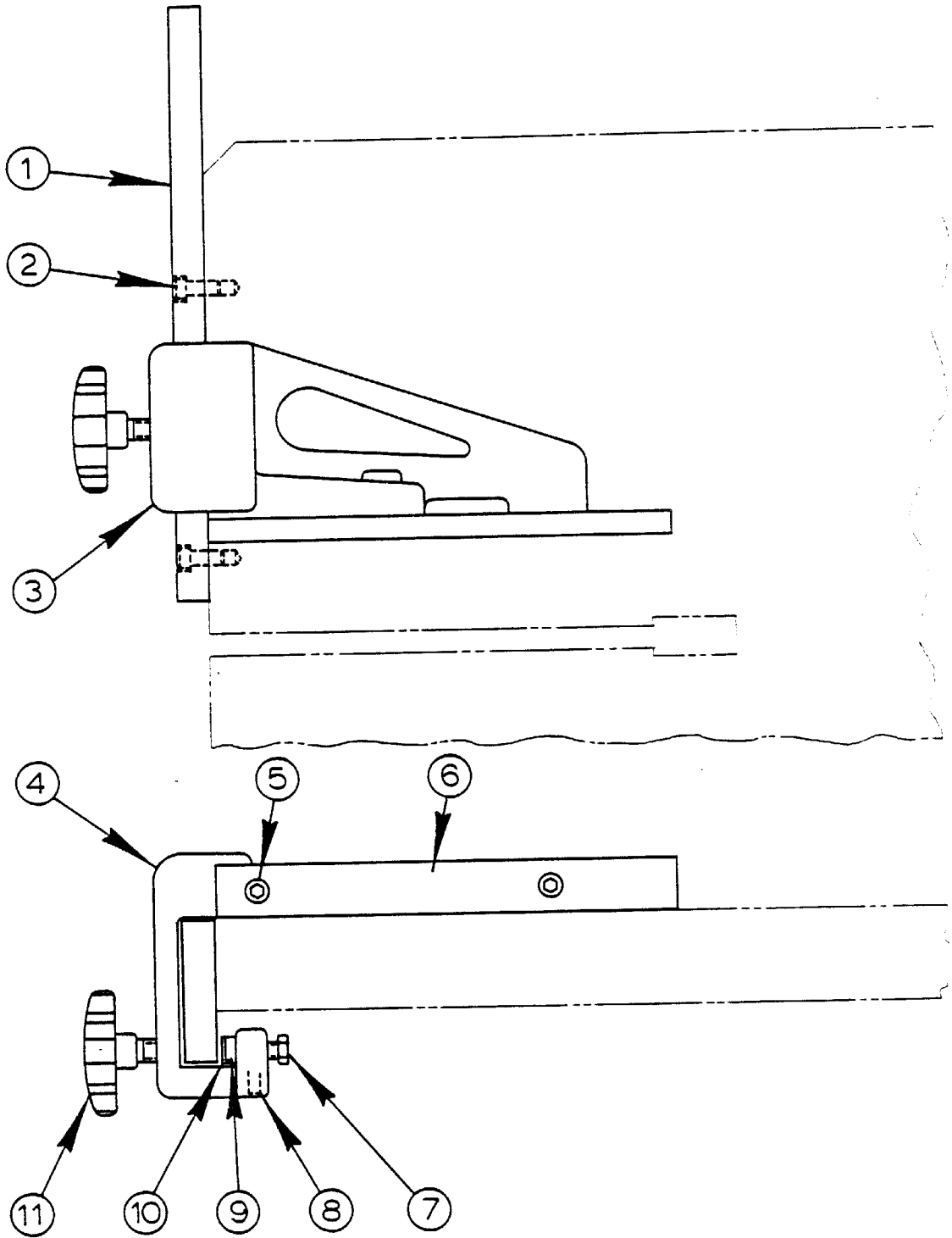
CODE NO. C-10-42  
CM-10-7

PROTRACTOR WORK STOP & ALIGNMENT GAGE ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	080-514953	Protractor Work Stop & Alignment Gage Assembly	
Ref.	080-547581	Protractor Work Stop & Alignment Gage Assembly (26-HB2 Only)	
1	091-988675	. Screw, Rd. Hd. Mach. #10-24NC x 3/8 .....	5
2	114-004732	. Dowel Pin .....	1
3	091-339713	. Knob .....	2
4	090-116344	. Shaft .....	1
5	090-116336	. Pointer .....	1
6	090-253022	. Tee Nut (Assembly 080-514953) .....	1
	090-291626	. Tee Nut (Assembly 080-547581) .....	1
7	090-116351	. Stud (Assembly 080-514953) .....	1
	091-011189	. Stud (Assembly 080-547581) .....	1
8	091-992651	. Washer, Flat 7/16 S.A.E. Std. ....	1
9	135-016145	. Protractor Plate .....	1
10	134-174010	. Thumbscrew .....	1
11	135-019768	. Gage Rod .....	1
12	090-514969	. Mitre Head .....	1



REVISED AND  
REDRAWN  
SCL. 12-7-83



RIP FENCE ASSEMBLY

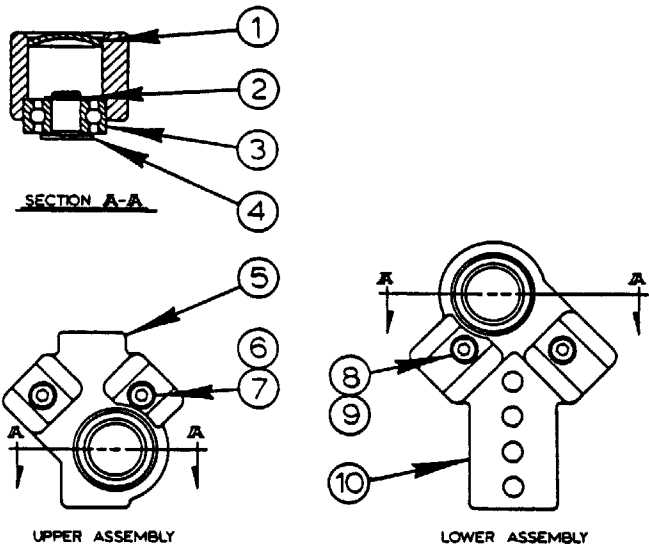
C-10-6 Z-9-5

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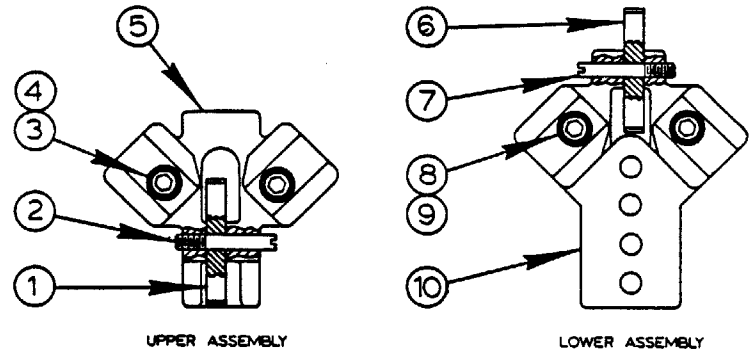
CODE NO. C-10-6  
Z-9-5

RIP FENCE ASSEMBLY

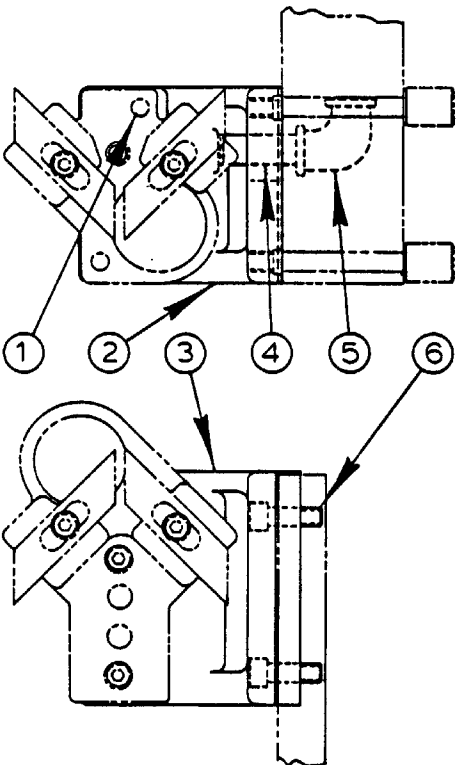
INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	135-005437	Rip Fence Assembly (24" Table)	
Ref.	080-477797	Rip Fence Assembly (26" Table)	
Ref.	135-005429	Rip Fence Assembly (30" Table)	
1	105-163026	. Clamp Guide (24" and 26" Tables) .....	1
	111-163028	. Clamp Guide (30" Table) .....	1
2	091-982785	. Screw, Soc. Hd. Cap 3/8-16NC x 3/4 .....	2
3	135-052512	. Rip Fence Sub-Assembly (24" Table) .....	1
	135-051787	. Rip Fence Sub-Assembly (26" and 30" Table) .....	1
4	135-005452	. . Clamp (24" Table) .....	1
	135-005445	. . Clamp (26" and 30" Tables) .....	1
5	091-982785	. . Screw, Soc. Hd. Cap 3/8-16NC x 3/4 .....	2
6	135-005486	. . Work Guide (24" Table) .....	1
	135-005460	. . Work Guide (26" and 30" Tables) .....	1
7	105-164032	. . Clamp Bar Screw .....	2
8	091-984252	. . Screw, Soc. Set 1/4-20NC x 1/2 .....	2
9	105-163034	. . Clamp Bar .....	1
10	134-065044	. . Spring Clip .....	2
11	105-160048	. . Handwheel Assembly .....	1
	105-161020	. . . Handwheel .....	1
	135-015253	. . . Handwheel Screw .....	1
	091-317958	. . . Loctite (#35) .....	A.R.



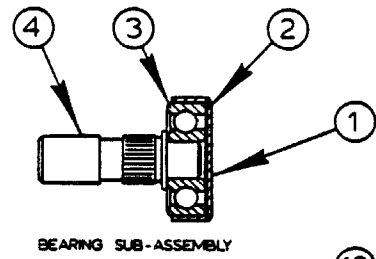
UPPER ASSEMBLY  
 LOWER ASSEMBLY  
**HIGH SPEED SAW GUIDE ASSEMBLY**  
 STANDARD FOR CROWNED BANDWHEELS  
 (1/16" - 1/2")



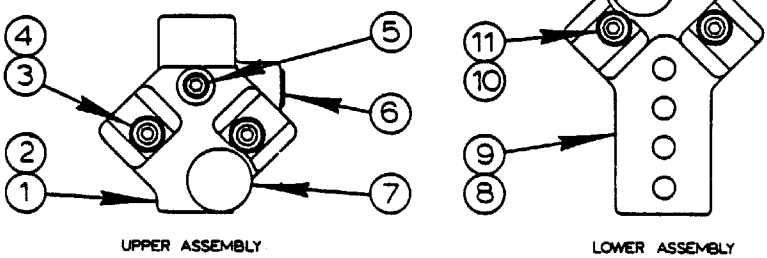
UPPER ASSEMBLY  
 LOWER ASSEMBLY  
**SAW GUIDE ASSEMBLY**  
 STANDARD FOR FLANGED BANDWHEELS



**90° SAW GUIDE ASSEMBLY**  
 (LAST USED APRIL 1980)

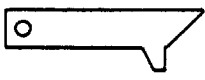


**BEARING SUB-ASSEMBLY**

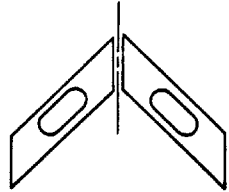


UPPER ASSEMBLY  
 LOWER ASSEMBLY  
**PRECISION SAW GUIDE ASSEMBLY**  
 (1/16" - 1/4")

REVISED AND REDRAWN
REVISIONS
S.C.L. 3-13-81
S.C.L. 12-3-84



**SAW GUIDE INSERT GAGE**



**SAW GUIDE INSERTS**  
 (SET OF 4)

USED ON UPRIGHT SAWS  
 WHEN APPLICABLE.

**SAW GUIDE SELECTION**

C-7-20 CM-7-29

PRINTED IN U.S.A.

SAW GUIDE SELECTION

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY																																	
<u>HIGH SPEED SAW GUIDES (STANDARD FOR CROWNED BANDWHEELS)</u>				<u>PRECISION SAW GUIDE ASSEMBLY (1/16" - 1/4")</u>																																				
Ref.	090-280819	High Speed Upper Saw Guide Assembly (1/16" - 1/2")		Ref.	090-115197	Precision Upper Saw Guide Assembly																																		
Ref.	090-280827	High Speed Lower Saw Guide Assembly (1/16" - 1/2")		27	090-252495	. Upper Saw Guide Block.....	1																																	
1	091-373399	. Core Hole Plug.....	1	28	091-985010	. Screw, Soc. Set #8-32NC x 1/4 (Cone Pt.).....	1																																	
2	090-115411	. Retaining Ring.....	1	29	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8.....	2																																	
3	135-022804	. Bearing.....	1	30	134-085026	. Insert Washer.....	2																																	
4	090-184151	. Bearing Cap.....	1	31	091-984450	. Screw, Soc. Set 5/16-24NF x 1/2..	1																																	
5	090-279811	. Upper Saw Guide Block.....	1	32	091-203695	. Pipe Plug.....	1																																	
6	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8..	2	33	134-080092	. Bearing Sub-assembly (See Detail)	1																																	
7	134-085026	. Insert Washer.....	2	Ref.	090-115072	Precision Lower Saw Guide Assembly																																		
8	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8..	2	34	090-252479	. Lower Saw Guide Block.....	1																																	
9	134-085026	. Insert Washer.....	2	35	091-985010	. Screw, Soc. Set #8-32NC x 1/4 (Cone Pt.).....	1																																	
10.	090-279837	. Lower Saw Guide Block.....	1	36	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8.....	2																																	
<u>STANDARD FOR FLANGED BANDWHEELS</u>				37	134-085026	. Insert Washer.....	2																																	
Ref.	093-048437	Upper Saw Guide Assembly (Carbide Insert)		38	134-080092	. Bearing Sub-assembly (See Detail)	1																																	
11	091-212100	. Back-up Insert.....	1	Ref.	134-080092	Bearing Sub-assembly																																		
12	091-402040	. Pivot Bolt.....	1	39	134-083096	. Roller Seal.....	1																																	
13	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4.....	2	40	134-083120	. Washer.....	1																																	
14	134-085026	. Insert Washer.....	2	41	135-090439	. Bearing.....	1																																	
15	094-064300	. Upper Saw Guide Block.....	1	42	134-084185	. Shaft.....	1																																	
Ref.	093-048445	Lower Saw Guide Assembly (Carbide Insert)		<u>SAW GUIDE INSERT GAGE</u>																																				
16	091-212100	. Back-up Insert.....	1	134-083203	. Insert Gage (.025).....	1																																		
17	091-402040	. Pivot Bolt.....	1	113-083034	. Insert Gage (.032).....	1																																		
18	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4.....	2	113-083075	. Insert Gage (.035).....	1																																		
19	134-085026	. Insert Washer.....	2	134-085067	. Box (For Inserts and Gages).....	1																																		
20	094-067683	. Lower Saw Guide Block.....	1	<u>SAW GUIDE INSERT SELECTION (SET OF 4)*</u>																																				
<u>90° SAW GUIDE ASSEMBLY (LAST USED APRIL 1980)</u>				<table border="1"> <thead> <tr> <th>STEEL</th> <th>SIZE</th> <th>CARBIDE</th> </tr> </thead> <tbody> <tr> <td>090-044991</td> <td>1/16"</td> <td></td> </tr> <tr> <td>090-044983</td> <td>3/32"</td> <td></td> </tr> <tr> <td>090-044975</td> <td>1/8"</td> <td>091-417593</td> </tr> <tr> <td>090-044967</td> <td>3/16"</td> <td></td> </tr> <tr> <td>090-044959</td> <td>1/4"</td> <td>090-161688</td> </tr> <tr> <td>090-039603</td> <td>3/8"</td> <td>090-161704</td> </tr> <tr> <td>090-039595</td> <td>1/2"</td> <td>090-132911</td> </tr> <tr> <td>090-039587</td> <td>5/8"</td> <td>091-058941</td> </tr> <tr> <td>090-039579</td> <td>3/4"</td> <td>090-132929</td> </tr> <tr> <td>090-039561</td> <td>1"</td> <td>090-089822</td> </tr> </tbody> </table>				STEEL	SIZE	CARBIDE	090-044991	1/16"		090-044983	3/32"		090-044975	1/8"	091-417593	090-044967	3/16"		090-044959	1/4"	090-161688	090-039603	3/8"	090-161704	090-039595	1/2"	090-132911	090-039587	5/8"	091-058941	090-039579	3/4"	090-132929	090-039561	1"	090-089822
STEEL	SIZE	CARBIDE																																						
090-044991	1/16"																																							
090-044983	3/32"																																							
090-044975	1/8"	091-417593																																						
090-044967	3/16"																																							
090-044959	1/4"	090-161688																																						
090-039603	3/8"	090-161704																																						
090-039595	1/2"	090-132911																																						
090-039587	5/8"	091-058941																																						
090-039579	3/4"	090-132929																																						
090-039561	1"	090-089822																																						
Ref.	090-448044	90° Saw Guide Assembly		*Note: Some Insert Packs May Not Include All Inserts Listed Above.																																				
21	091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1....	2																																					
22	090-275975	. 90° Upper Angle Saw Guide Bracket...	1																																					
23	090-275966	. 90° Lower Angle Saw Guide Bracket...	1																																					
24	090-116583	. Nipple.....	1																																					
25	135-036473	. 90° Elbow.....	1																																					
26	091-982397	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4..	2																																					
	090-292616	. Center Plate (24" x 24" Table)(Not Shown).....	1																																					
	093-021780	. Center Plate (30"x 30" Table)(Not Shown).....	1																																					



SAW GUIDE SELECTION

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY
<b>HEAVY DUTY SAW GUIDE ASSEMBLY (CARBIDE BACK-UP)</b>				<b>HEAVY DUTY SAW GUIDE ASSEMBLY (STEEL BACK-UP)</b>			
Ref.	091-199182	Upper Saw Guide Assembly (1/16" - 1/2")		Ref.	091-201434	Upper Saw Guide Assembly (1/16" - 1/2")	
Ref.	090-178617	Upper Saw Guide Assembly (5/8" & 3/4")		Ref.	090-115288	Upper Saw Guide Assembly (5/8" & 3/4")	
Ref.	093-030112	Upper Saw Guide Assembly (1")		Ref.	090-115304	Upper Saw Guide Assembly (1")	
1	134-085026	. Insert Washer.....	2	27	091-984450	. Screw, Soc. Hd. Cap 5/16-24NF x 1/2 (5/8" & 3/4", 1").....	1
2	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8 (1/16" - 1/2").....	2	28	090-380767	. Upper Saw Guide Block (1/16" - 1/2").....	1
	091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1 (5/8" & 3/4", 1").....	2		090-252529	. Upper Saw Guide Block (5/8" & 3/4").....	1
3	091-984450	. Screw, Soc. Hd. Cap 5/16-24NF x 1/2 (5/8" & 3/4", 1").....	1		090-252537	. Upper Saw Guide Block (1").....	1
4	090-380767	. Upper Saw Guide Block (1/16" - 1/2")	1	29	091-203695	. Pipe Plug (5/8" & 3/4", 1").....	1
	090-252529	. Upper Saw Guide Block (5/8" & 3/4")	1	30	134-085026	. Insert Washer.....	2
	090-252537	. Upper Saw Guide Block (1")	1	31	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4 (1/16" - 1/2", 1").....	2
5	091-354415	. Locknut (5/8" & 3/4", 1").....	1		091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1 (5/8" & 3/4").....	2
6	091-332023	. Pipe Plug (5/8" & 3/4", 1").....	1	32	090-115296	. Bearing.....	2
7	090-183377	. Guide Guard (5/8" & 3/4", 1").....	1	33	090-115403	. Bearing Cap.....	1
8	090-115296	. Bearing.....	2	34	090-115411	. Retaining Ring.....	1
9	090-172180	. Bearing Cap Assembly (Includes Carbide).....	1	Ref.	091-201426	Lower Saw Guide Assembly (1/16" - 1/2")	
10	090-115411	. Retaining Ring.....	1	Ref.	090-115437	Lower Saw Guide Assembly (5/8" & 3/4")	
Ref.	091-201194	Upper Saw Guide Assembly (1") (Used Instead Of #093-030112 And Used On Models 1612-3, 2612-2H, 2613-3, 3613-3, 6013-3, 6013-H3)		Ref.	090-115429	Lower Saw Guide Assembly (1")	
11	090-335092	. Coolant Nozzel.....	1	35	090-377383	. Lower Saw Guide Block (1/16" - 1/2").....	1
12	090-336314	. Upper Saw Guide Block.....	1		090-252586	. Lower Saw Guide Block (5/8" & 3/4").....	1
13	134-085026	. Insert Washer.....	2		090-252578	. Lower Saw Guide Block (1").....	1
14	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4	2	36	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4 (1/16" - 1/2", 1").....	2
15	091-354415	. Locknut.....	1		091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1 (5/8" & 3/4").....	2
*16	091-081166	. 90° Barbed Insert.....	1	37	134-085026	. Insert Washer.....	2
17	090-183377	. Guide Guard.....	1	38	090-115296	. Bearing.....	2
18	090-115296	. Bearing.....	2	39	090-115403	. Bearing Cap.....	1
19	090-172180	. Bearing Cap Assembly (Includes Carbide).....	1	40	090-115411	. Retaining Ring.....	1
20	090-115411	. Retaining Ring.....	1				
*Note: If Your Machine Has 2 Coolant Lines To The Upper Saw Guide, Delete #16 And Order The Following:							
	091-094524	. Swivel Joint.....	1				
	090-160011	. Barbed Insert.....	2				
Ref.	091-190017	Lower Saw Guide Assembly (1/16" - 1/2")		<b>SAW GUIDE INSERT GAGE</b>			
Ref.	090-181686	Lower Saw Guide Assembly (5/8" & 3/4")		134-083203	. Insert Gage (.025).....	1	
Ref.	090-177320	Lower Saw Guide Assembly (1")		113-083034	. Insert Gage (.032).....	1	
21	090-377383	. Lower Saw Guide Block (1/16" - 1/2")	1	113-083075	. Insert Gage (.035).....	1	
	090-252586	. Lower Saw Guide Block (5/8" & 3/4")	1	134-085067	. Box (For Inserts and Gages).....	1	
	090-252578	. Lower Saw Guide Block (1")	1	<b>SAW GUIDE INSERT SELECTION (SET OF 4)*</b>			
22	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8 (1/16" - 1/2").....	2	<b>STEEL</b>	<b>SIZE</b>	<b>CARBIDE</b>	
	091-982421	. Screw, Soc. Hd. Cap 1/4-20NC x 1 (5/8" & 3/4").....	2	090-044991	1/16"		
	091-982447	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4 (1").....	2	090-044983	3/32"		
		. Insert Washer.....	2	090-044975	1/8"	091-417593	
23	134-085026	. Bearing Cap Assembly (Includes Carbide).....	1	090-044967	3/16"		
24	090-172180	. Bearing Cap Assembly (Includes Carbide).....	1	090-044959	1/4"	090-161688	
25	090-115296	. Bearing.....	2	090-039603	3/8"	090-161704	
26	090-115411	. Retaining Ring.....	1	090-039595	1/2"	090-132911	
				090-039587	5/8"	091-058941	
				090-039579	3/4"	090-132929	
				090-039561	1"	090-089822	

\*Note: Some Insert Packs May Not Include All Inserts Listed Above.

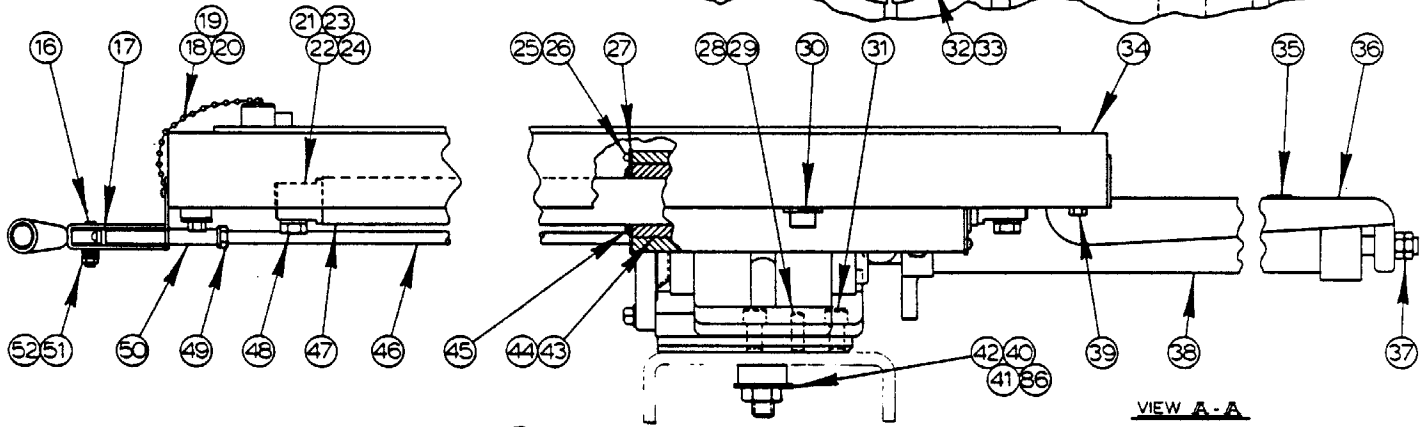
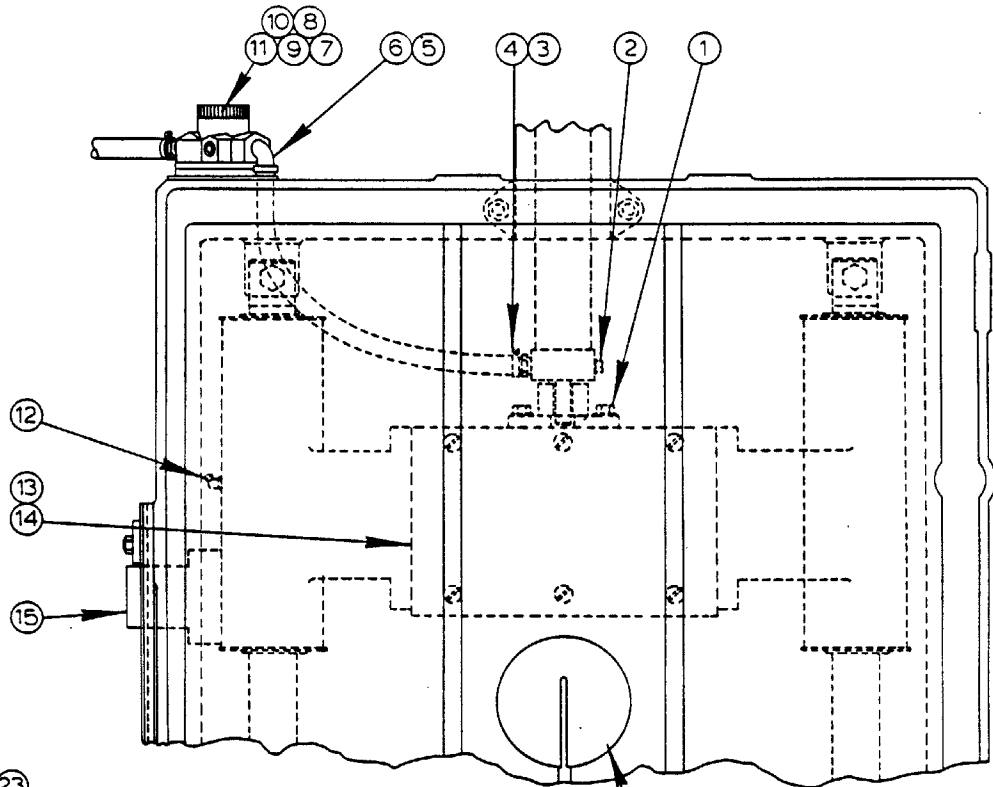


SAW GUIDE SELECTION

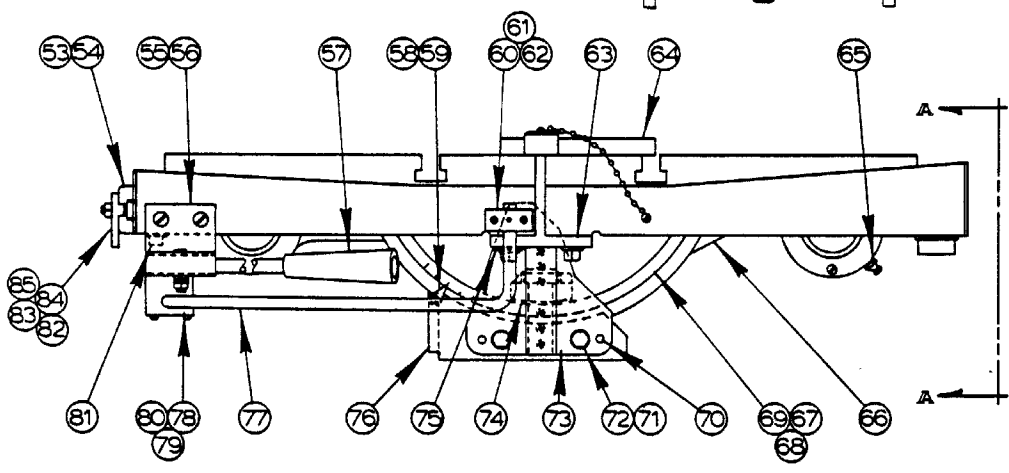
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY
<u>TYPE I - ROLLER SAW GUIDE ASSEMBLY</u>							
Ref.	090-292566	1/4" Upper Roller Saw Guide Assembly		27	090-017419	. Plug.....	2
Ref.	090-292582	3/8" Upper Roller Saw Guide Assembly		28	090-336363	. Coolant Guard.....	1
Ref.	090-295064	1/2" Upper Roller Saw Guide Assembly		Ref.	090-172156	Lower Saw Guide Block Assembly	
1	See Below	. Back-up Roller Assembly (See Detail)	1	29	090-277435	. Lower Saw Guide Block.....	1
2	090-289604	. Upper Guide Block.....	1	30	091-984492	. Screw, Soc. Set 3/8-16NC x 1/2....	2
3	091-982397	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4..	2	31	090-017419	. Plug.....	2
4	091-993212	. Washer, Lock 1/4 Std.....	2	32	091-982355	. Screw, Soc. Hd. Cap 1/4-20NC x 3/8.....	2
5	See Below	. Side Roller Assembly (See Detail)...	1	33	090-021403	. Chip Deflector.....	1
Ref.	090-292574	1/4" Lower Roller Saw Guide Assembly		Not Shown:			
Ref.	090-292590	3/8" Lower Roller Saw Guide Assembly		091-317982	. Cloth Bag.....		1
Ref.	090-295056	1/2" Lower Roller Saw Guide Assembly		<u>ROLLER ASSEMBLIES</u>			
6	See Below	. Back-up Roller Assembly (See Detail).	1	Ref.	090-207994	1/4" Side Roller Assembly	
7	090-289612	. Lower Guide Block.....	1	Ref.	090-208075	3/8" Side Roller Assembly	
8	091-982397	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4..	2	Ref.	090-202920	1/2" Side Roller Assembly	
9	091-993212	. Washer, Lock 1/4 Std.....	2	Ref.	090-210725	5/8" Side Roller Assembly	
10	See Below	. Side Roller Assembly (See Detail)...	1	Ref.	090-202938	3/4" Side Roller Assembly	
<u>ROLLER ASSEMBLIES</u>							
Ref.	090-289828	1/4" Back-up Roller Assembly		*Ref.	090-289679	1" Side Roller Assembly	
Ref.	090-289786	3/8" Back-up Roller Assembly		34	090-015686	. Retaining Ring.....	1
Ref.	090-289760	1/2" Back-up Roller Assembly		35	090-013038	. Retaining Ring.....	2
11	090-115411	. Retaining Ring.....	1	36	090-017799	. Bearing.....	1
12	091-000463	. Retaining Ring.....	2	37	090-135310	. 1/4" Side Roller.....	1
13	090-115296	. Bearing.....	1		090-135401	. 3/8" Side Roller.....	1
14	090-289836	. 1/4" Back-up Roller.....	1		090-135336	. 1/2" Side Roller.....	1
	090-289794	. 3/8" Back-up Roller.....	1		090-135427	. 5/8" Side Roller.....	1
	090-289778	. 1/2" Back-up Roller.....	1		090-135351	. 3/4" Side Roller.....	1
15	090-182965	. Shaft.....	1	38	091-007583	. 1" Side Roller.....	1
Ref.	090-289844	1/4" Side Roller Assembly			090-135302	. Spindle.....	1
Ref.	090-289802	3/8" Side Roller Assembly		Ref.	090-207986	1/4" Back-up Roller Assembly	
Ref.	090-289745	1/2" Side Roller Assembly		Ref.	090-208083	3/8" Back-up Roller Assembly	
16	090-182965	. Shaft.....	1	Ref.	090-202953	1/2" Back-up Roller Assembly	
17	090-289851	. 1/4" Side Roller.....	1	Ref.	090-210717	5/8" Back-up Roller Assembly	
	090-289810	. 3/8" Side Roller.....	1	Ref.	090-202961	3/4" Back-up Roller Assembly	
	090-289752	. 1/2" Side Roller.....	1	*Ref.	090-289687	1" Back-up Roller Assembly	
18	090-115296	. Bearing.....	1	39	090-135302	. Spindle.....	1
19	091-000463	. Retaining Ring.....	2	40	090-135328	. 1/4" Back-up Roller.....	1
20	090-115411	. Retaining Ring.....	1		090-135419	. 3/8" Back-up Roller.....	1
<u>TYPE II - ROLLER SAW GUIDE ASSEMBLY</u>							
Ref.	091-095174	Upper Saw Guide Block Assembly			090-135344	. 1/2" Back-up Roller.....	1
21	090-335175	. Upper Saw Guide Block.....	1		090-135435	. 5/8" Back-up Roller.....	1
22	091-982363	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2.....	1		090-135369	. 3/4" Back-up Roller.....	1
		. Washer, Lock 1/4 Std.....	1		091-007575	. 1" Back-up Roller.....	1
23	091-993212	. Coolant Nozzel.....	1	41	090-017799	. Bearing.....	1
24	090-335092	. Barbed Insert.....	1	42	090-013038	. Retaining Ring.....	2
25	090-160011	. Screw, Soc. Set 3/8-16NC x 3/8.....	2	43	090-015686	. Retaining Ring.....	1
26	091-984484	. Screw, Soc. Set 3/8-16NC x 3/8.....	2	* NOTE: To Be Used With Flanged Rubber-tired Wheels Using 1/4", 1/2", 3/4", Or 1" Bands. Also Used With Steel Flanged And Rubber Crowned Wheels Using 1" Band Only.			



REVISED AND  
REDRAWN  
SCL 11-22-83  
SCL 4-8-86  
SCL 6-22-87



VIEW A-A



SLIDING TABLE ASSEMBLY  
(AIR FEED)

MODEL	FIRST MACH	LAST MACH
2012-A	320-74299	320-74333
2012-AT	330-74111	330-74111
2012-1A	340-74101	340-78421
2012-1AT	341-74102	341-77116
2012-2A	389-77101	389-86419
2013-20	377-77101	
3613-1	440-83101	
2013-V	457-86101	
3613-2	398-78101	398-86171
3613-20	399-78101	

C-3-53

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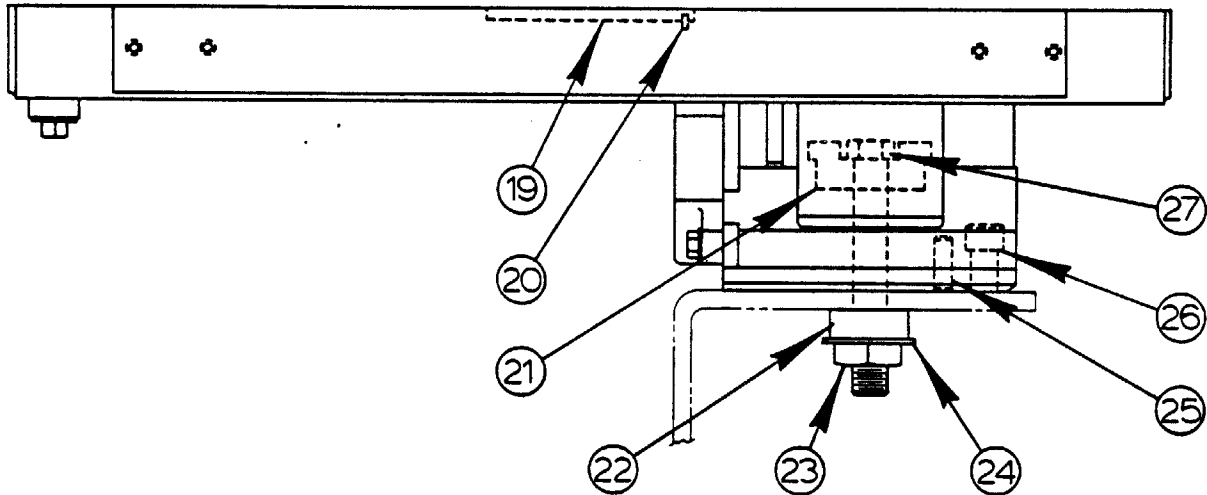
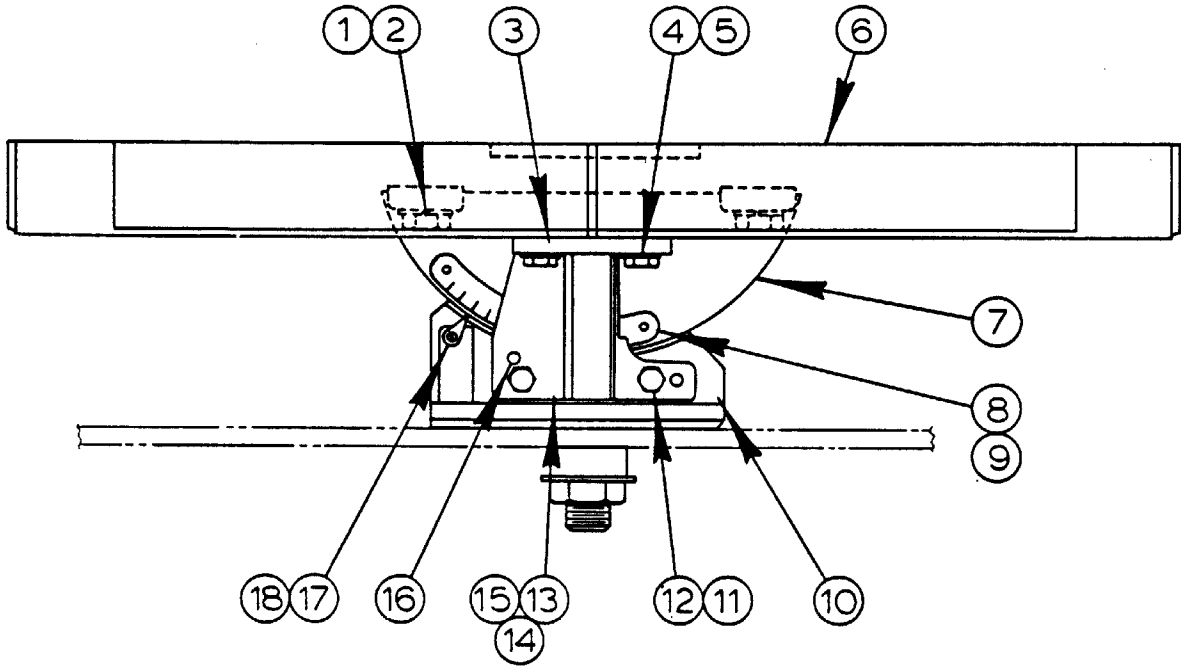
SLIDING TABLE ASSEMBLY  
(AIR FEED)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY
Ref.	095-038261	Sliding Table Assembly (Air Feed) (2012-A, 2012-AT, 2012-1A, 2012-1AT, 2012-2A, 2013-20, 2013-V)		48	091-980698	. Screw, Hex. Hd. Cap 1/2-13NC x 2	4
				49	091-991273	. Nut, Hex. Jam 3/8-16NC.....	1
				50	091-253880	. Shaft (4" Long).....	1
Ref.	095-127577	Sliding Table Assembly (Air Feed) (3613-1, 3613-2, 3613-20)		091-727305	. Shaft (5" Long).....	1	
1	091-980276	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4.....	2	51	091-156604	. Locknut 1/4-28F.....	1
2	111-055091	. Pipe Plug.....	1	52	091-046326	. Belleville Washer.....	6
3	090-020041	. Barbed Insert.....	4	53	090-239674	. Slide Bar.....	2
4	135-068880	. Hose Clamp.....	4	54	091-982215	. Screw, Soc. Hd. Cap #10-24NC x 5/8.....	1
5	117-135210	. 90° Street Elbow.....	1	55	091-253898	. Bracket Weldment.....	1
6	091-970962	. Neoprene Hose 5/8 O.D. (Black)....	A.R.	56	091-988956	. Screw, Rd. Hd. Mach. 1/4-20NC x 1/2.....	4
7	091-256743	. Regulating Valve.....	1	57	091-310110	. Handle Sub-Assembly.....	1
8	091-253864	. Mounting Plate.....	1	091-181164	. Handle.....	1	
9	091-986786	. Screw, Fill. Hd. Mach. #12-24NC x 1-1/4.....	2	090-042429	. Roll Pin.....	1	
10	091-980094	. Screw, Hex. Hd. Cap 1/4-20NC x 7/8	2	58	134-033158	. Shaft.....	1
11	091-227488	. Pipe Plug.....	1	59	091-988386	. Pointer.....	1
12	135-017754	. Grease Fitting.....	1	60	091-357301	. Support Block.....	1
13	095-030458	. Pan.....	1	61	091-984062	. Screw, Soc. Set #8-32NC x 1/4...	2
14	091-990192	. Screw, Truss Hd. Mach. 1/4-20NC x 3/8.....	6	62	091-988477	. Screw, Rd. Hd. Mach. #6-32NC x 1-1/4".....	2
15	090-095035	. Stop.....	1	63	090-045998	. Clamp.....	1
16	091-982520	. Screw, Soc. Hd. Cap 1/4-28NF x 1-1/4.....	1	64	091-253617	. Square Weldment.....	1
17	090-042441	. Roll Pin.....	1	65	090-106568	. 45° Grease Fitting.....	1
18	091-295907	. Chain.....	1	66	090-507914	. Trunnion.....	1
19	091-988519	. Screw, Rd. Hd. Mach. #8-32NC x 1/4	2	67	090-216219	. Trunnion Plate.....	1
20	091-253930	. Plug.....	1	68	091-988220	. Screw, Pan Hd. Mach. 1/4-20NC x 3/8.....	2
21	091-333104	. Shim (.035).....	A.R.	69	091-993568	. Washer, Lock 1/4 Shakeproof Int.	6
22	091-333112	. Shim (.0149).....	A.R.	70	091-338756	. Dowel Pin.....	2
23	091-333120	. Shim (.005).....	A.R.	71	091-980474	. Screw, Hex. Hd. Cap 3/8-16NC x 1-1/4.....	4
24	091-333138	. Shim (.003).....	A.R.	72	091-993329	. Washer, Lock 3/8 Std.....	10
25	091-988675	. Screw, Rd. Hd. Mach. #10-24NC x 3/8.....	16	73	090-242413	. Keeper Block.....	1
26	091-993196	. Washer, Lock #10 Std.....	16	74	090-394644	. Head.....	1
27	090-051764	. Retainer.....	4	75	091-992644	. Washer, Flat 3/8 S.A.E. Std.....	2
28	090-163510	. Dowel Pin (1" Long).....	1	76	090-409038	. Cradle.....	1
29	135-004455	. Dowel Pin (1-1/2" Long).....	1	77	093-036010	. Guard Bar.....	1
30	135-065803	. Pipe Plug.....	1	78	091-357418	. Support Block.....	1
31	091-982918	. Screw, Soc. Hd. Cap 1/2-13NC x 3/4	4	79	091-988501	. Screw, Rd. Hd. Mach. #6-32NC x 1-3/4.....	2
32	090-104902	. Center Plate.....	1	80	091-993170	. Washer, Lock #6 Std.....	4
33	090-042094	. Roll Pin.....	1	81	106-335185	. Pipe Plug.....	1
34	095-013801	. Table.....	1	82	090-095043	. Dog.....	2
35	090-062910	. Plug Button.....	1	83	090-093923	. T-Bolt 5/16-18NC.....	2
36	090-410614	. Cylinder Bracket.....	1	84	091-991224	. Nut, Hex. 5/16-18NC.....	2
37	091-991349	. Nut, Hex. Jam 1/2-20NF.....	2	85	091-982181	. Screw, Soc. Hd. Cap #10-24NC x 1/4.....	2
38	094-033206	. Table Cylinder Assembly (Air Feed) (See Detail).....	1	86	091-992685	. Washer, Flat 3/4 S.A.E. Std.....	1
39	091-980441	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	2				
40	090-105016	. Spacer.....	1				
41	091-991414	. Nut, Hex. 3/4-16NF.....	1				
42	091-981068	. Screw, Hex. Hd. Cap 3/4-16NF x 5..	1				
43	090-036476	. Ball Bushing.....	4				
44	090-051806	. Spacer.....	2				
45	091-655078	. Rod Wiper.....	4				
46	091-253872	. Actuator Rod.....	1				
47	090-216128	. Guide Rod.....	2				

Following Not Shown:  
090-410937 . Chip Guard Assembly (3613-1,  
3613-2, 3613-20)..... 1  
090-450801 . Chip Guard Assembly (3613-1,  
3613-2, 3613-20)..... 1

REVISED AND  
REDRAWN

S.C.L. 3-13-87



<u>MODEL</u>	<u>FIRST MACH.</u>	<u>LAST MACH.</u>
2013	301-74161	301-74165
2013-0	321-74344	321-74357
2013-1	338-74101	338-78245
2013-10	339-74101	339-781036
2013-20	377-77101	
2013-2	396-78101	396-86273
2013-U	411-80101	411-83444
E2013-U	420-81101	420-82104
2013-V	439-83101	439-86905
2013-V	457-86101	

TABLE AND TRUNNION ASSEMBLY

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