

Parts Manual



SAWING PRODUCTS

TF-1418

Serial No: 605-12101 to 605-13199

Band Sawing Machine

MACHINE SPECIFICATIONS

MODEL SERIAL NO.

VOLTAGE CYCLE PHASE

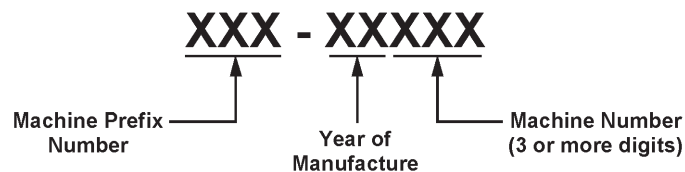
For your information and future reference, insert pertinent data concerning your machine in the spaces provided above. This information is printed on a label attached to the machine frame.

Always specify model and serial numbers on all parts orders and correspondence concerning your machine. This will help avoid unnecessary delays and inconvenience during processing.

The specifications contained herein were in effect at the time this manual was approved for printing. The DoALL Company, whose policy is one of continuous product improvement, reserves the right to change specifications or design at any time without notice and without incurring obligations.

How to read your serial number:

Example: 500-001234



For Sales, Parts and Service, call 1-888-362-5572
For general information, visit our web site at: www.doallsawing.com



DoALL SAWING PRODUCTS
2375B TOUHY AVENUE
ELK GROVE, ILLINOIS 60007 U.S.A.

YOUR SERVICE REPRESENTATIVE:

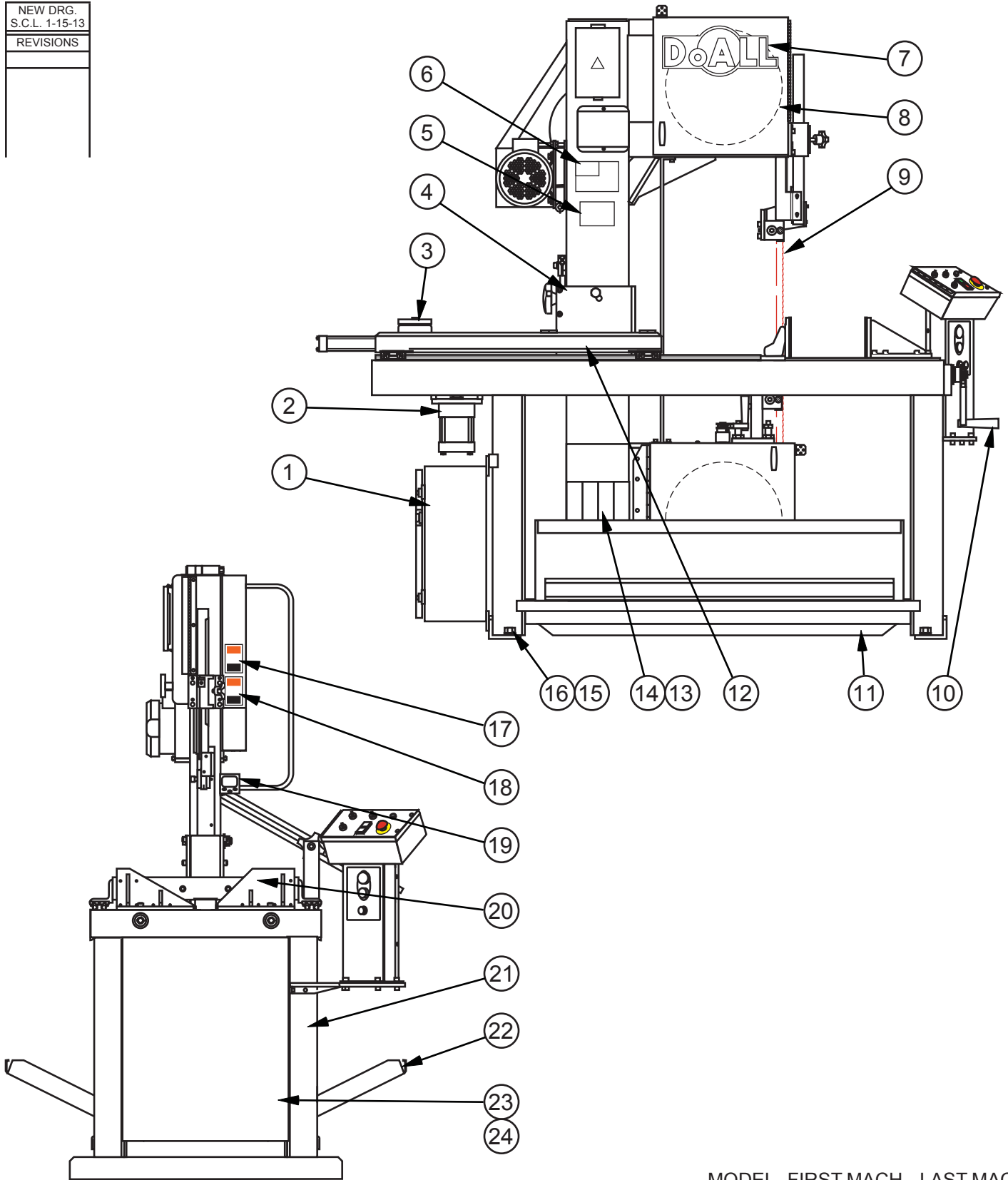
PARTS MANUAL INDEX

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Fiche No. D-24 Model TF-1418 Serial No. 605-12101 to 605-13199

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MODEL FIRST MACH. LAST MACH.
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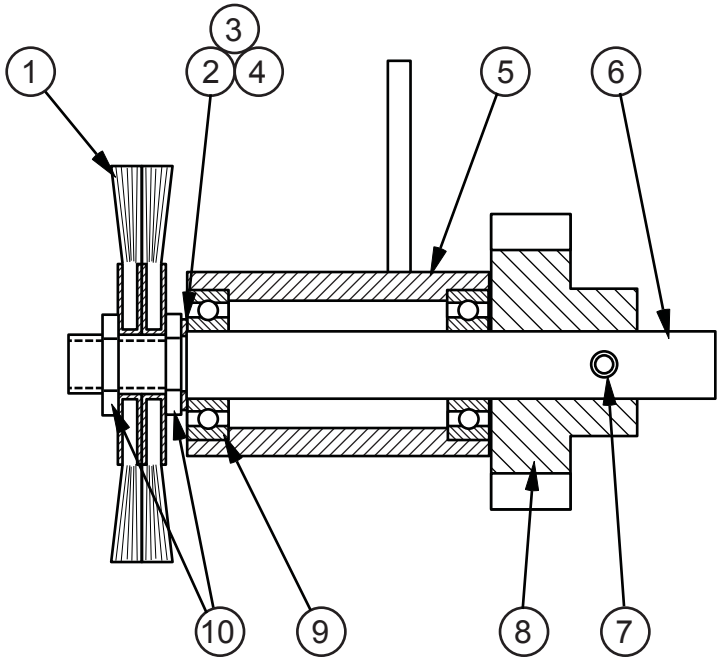
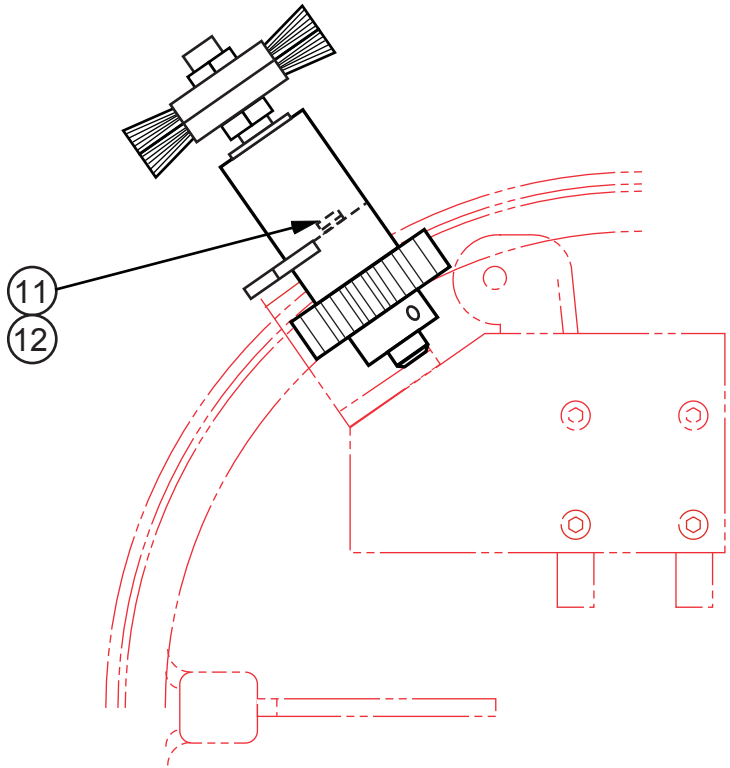
FINAL ASSEMBLY

FINAL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	225040	Final Assembly	
Ref.	522860	Saw and Base Assembly	
1	225214	. Electrical Assembly (See Detail)	1
2	225275	. Pneumatic/Hydraulic Assembly (See Detail)	1
3	225274	. Mist Lubricator Assembly (See Detail)	1
4	421632	. Cradle Assembly (See Detail)	1
5	1012541	. Label (Machine Data)	1
6	201469	. Decal (Flag)	1
7	1009936	. Label (DoALL Logo)	1
8	522857	. Head Assembly (See Detail)	1
9	225142	. Saw Band (1", 4-6P, 157" Long)	1
10	225000	. Handle Ratchet (Also Used for Band Tensioning)	1
11	421627	. Chip Pan Weldment	1
12	522858	. Carriage Assembly (See Detail)	1
13	1014248	. Counterbalance Weight	1
14	198303	. Screw, Soc. Hd. Cap 1/2-13NC x 4	6
15	198076	. Screw, Hex. Hd. Cap 1/2-13NC x 4	4
16	199327	. Washer, Lock 1/2 Std.	4
17	201467	. Label (Warning - Eye Protection)	1
18	201465	. Label (Warning - Saw Blade)	1
19	225028	. Magnetic Digital Angle Gauge	1
20	421635	. Vise Assembly (See Detail)	1
21	522854	. Base Weldment	1
22	421629	. Chip Pan Wing Weldment	2
23	1014228	. Front Panel	1
24	199243	. Screw, Button Hd. Soc. M5-0.8 x 12	6
Following Not Shown:			
	225301	. Documentation CD	1
	1014171	. Shipping Bracket	1
	404476	. Label (Warning) (Rear Drive Cover)	1
	1018687	. Saw Band Selector (Rear Drive Cover)	1

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BAND BRUSH ASSEMBLY

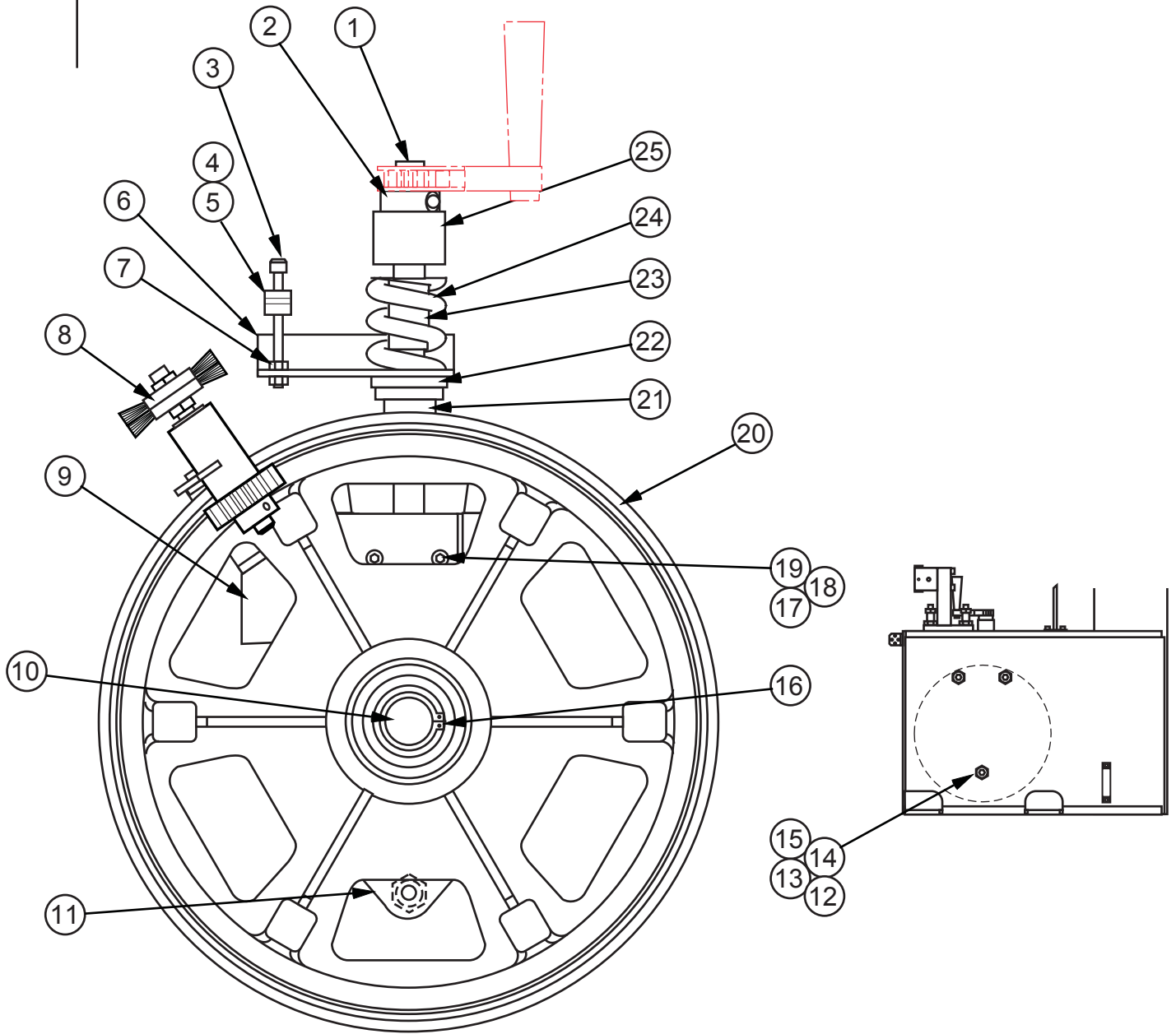
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BAND BRUSH ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	320800	Band Brush Assembly	
1	010983	. Wire Brush	2
2	208826	. Retaining Ring	1
3	133470	. Spacer (.0149)	A.R.
4	133471	. Spacer (.0299)	A.R.
5	320799	. Bracket Weldment	1
6	209672	. Shaft	1
7	004260	. Spring Pin	1
8	320801	. Pinion	1
9	207462	. Bearing	2
10	199222	. Nut, Hex. Jam M12-1.75	2
		Mounting Band Brush:	
11	199051	. Screw, Soc. Hd. Cap M6-1.0 x 12	2
12	199965	. Washer, Flat M6	2

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BANDWHEEL ASSEMBLY (LOWER - WITH BAND TENSION)

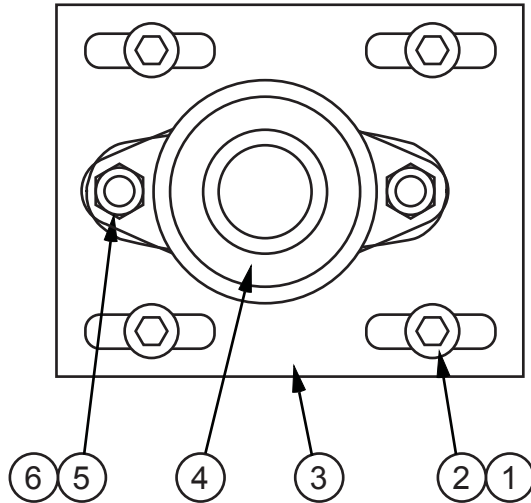
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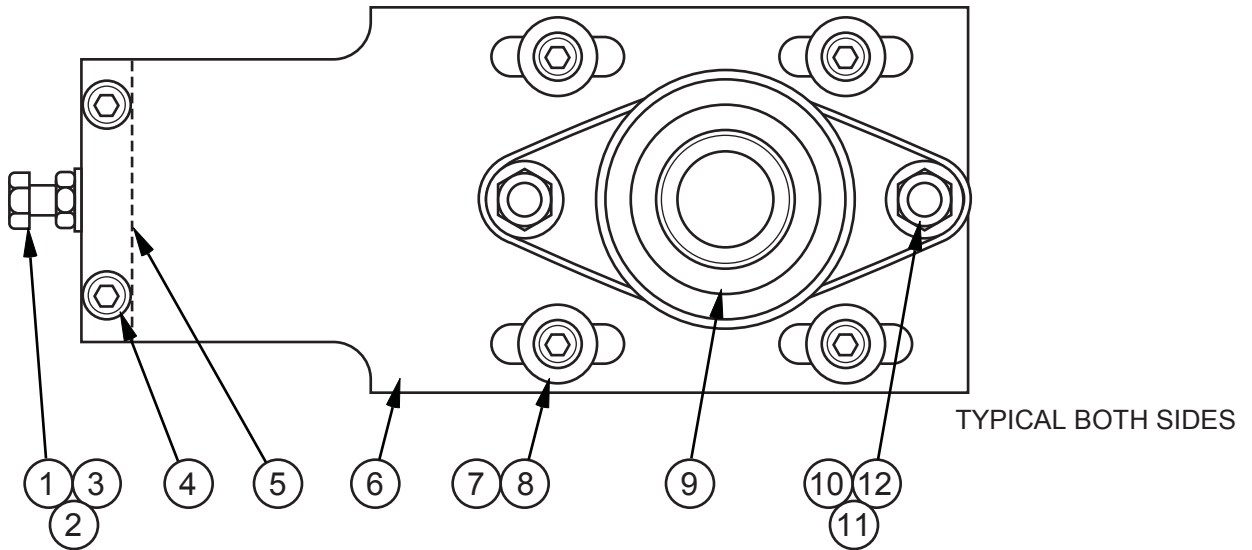
BANDWHEEL ASSEMBLY
(Lower - With Band Tension)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	421633	Bandwheel Assembly (Lower - With Band Tension)	
1	224599	. Band Tension Screw	1
2	1013354	. Collar	1
3	199756	. Screw, Soc. Hd. Cap M6-1.0 x 70	1
4	1014374	. Close Nipple	1
5	202383	. Adhesive (Loctite #242)	A.R.
6	225023	. Actuator	1
7	199188	. Nut, Hex. M6-1.0	2
8	320800	. Band Brush Assembly (See Detail)	1
9	327203	. Brush Bracket Weldment	1
10	327202	. Head Slide Sub-Assembly	1
11	517542	. Head Casting	1
12	005956	. Adjustment Screw 3/4-10NC x 2-5/16 (.42 Dia.)	3
13	100142	. Nut, Hex. Jam 3/4-10NC	3
14	199980	. Screw, Soc. Hd. Cap M10-1.5 x 80	3
15	199346	. Washer, Lock M10	3
16	204455	. Retaining Ring	1
17	199662	. Screw, Soc. Hd. Cap M6-1.0 x 25	4
18	199965	. Washer, Flat M6	4
19	224583	. Spacer	2
20	225001	. Bandwheel Assembly (Idler)	1
	522856	. . Bandwheel	1
	137905	. . Ball Bearing	2
21	1014101	. Collar 3/4-10NC (L.H.)	1
22	108749	. Thrust Ball Bearing	1
23	108748	. Tube	1
24	108750	. Compression Spring	1
25	157703	. Rubber Bushing	1

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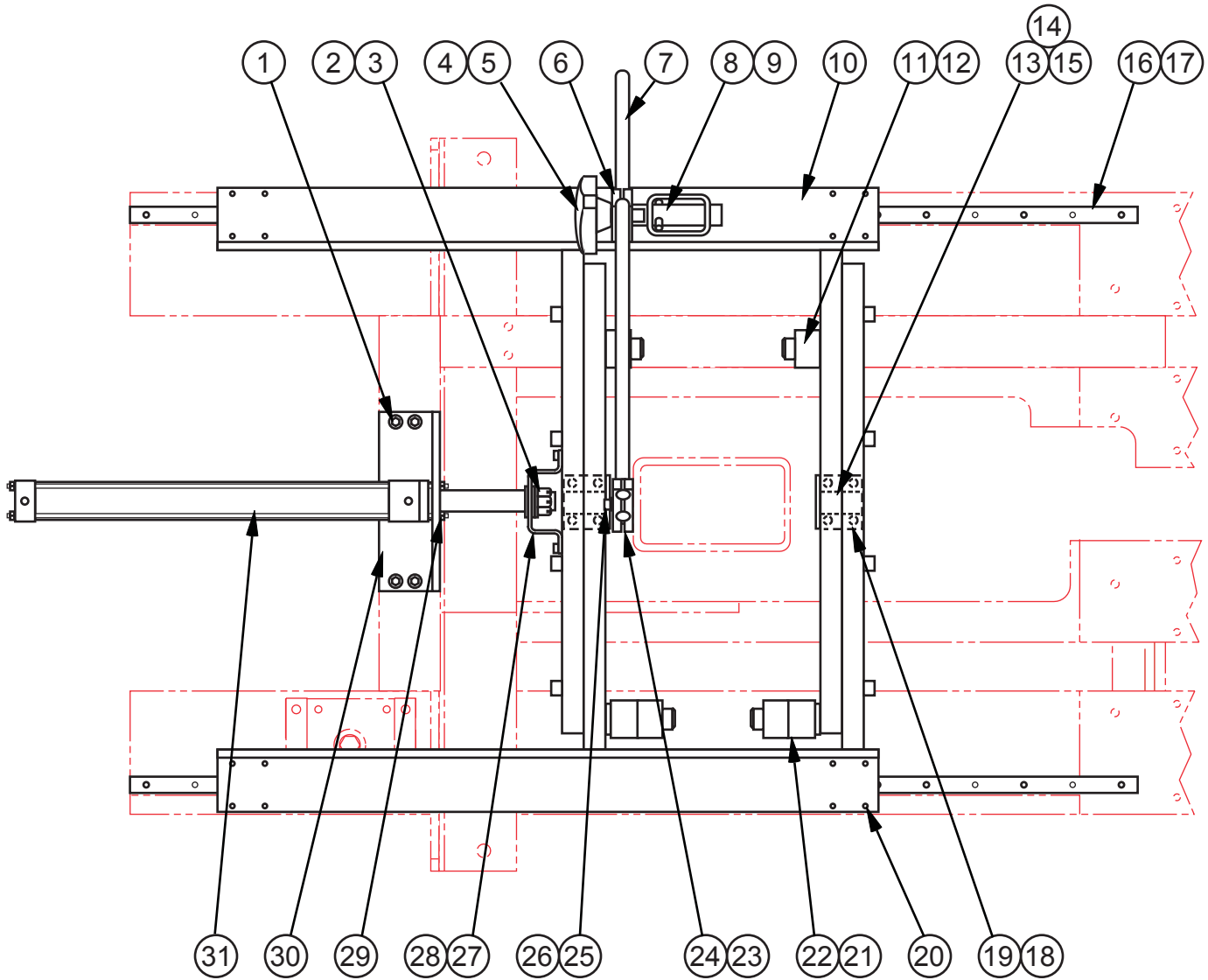
MODEL FIRST MACH. LAST MACH.
TF-1418 605-13104 605-13199

BEARING ADJUSTMENT ASSEMBLY

BEARING ADJUSTMENT ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	225003	Bearing Adjustment Assembly	
1	199819	. Screw, Soc. Hd. Cap M8-1.25 x 16	4
2	199967	. Washer, Flat M8	4
3	225004	. Adjuster Plate	1
4	1008462	. Ball Bearing	1
5	199102	. Screw, Soc. Hd. Cap M8-1.25 x 25 (Low Head)	2
6	199941	. Nut, Hex. M8-1.25	2
Ref.	1014186	Bearing Adjustment Assembly	
1	198167	. Screw, Hex. Hd. Cap M8-1.25 x 40	1
2	199250	. Nut, Hex. Jam M8-1.25	1
3	199967	. Washer, Flat M8	1
4	199926	. Screw, Hex. Hd. Cap M8-1.25 x 25	4
5	1014264	. Tie Bar	1
6	1014265	. Adjustable Bearing Plate	1
7	199926	. Screw, Hex. Hd. Cap M8-1.25 x 25	8
8	199264	. Washer, Flat 3/8 S.A.E. Std.	8
9	1014407	. Flanged Bearing	2
10	199102	. Screw, Soc. Hd. Cap M8-1.25 x 25 (Low Head)	4
11	199941	. Nut, Hex. M8-1.25	4
12	199264	. Washer, Flat 3/8 S.A.E. Std.	4

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CARRIAGE ASSEMBLY

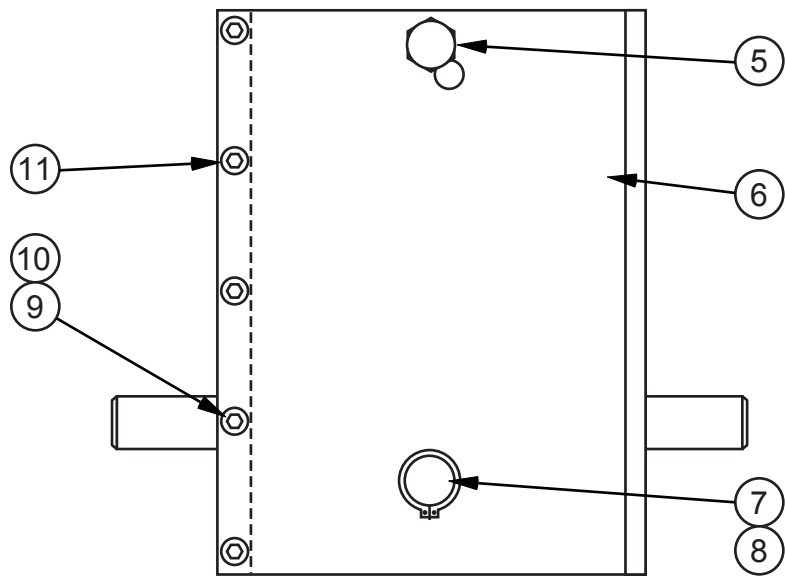
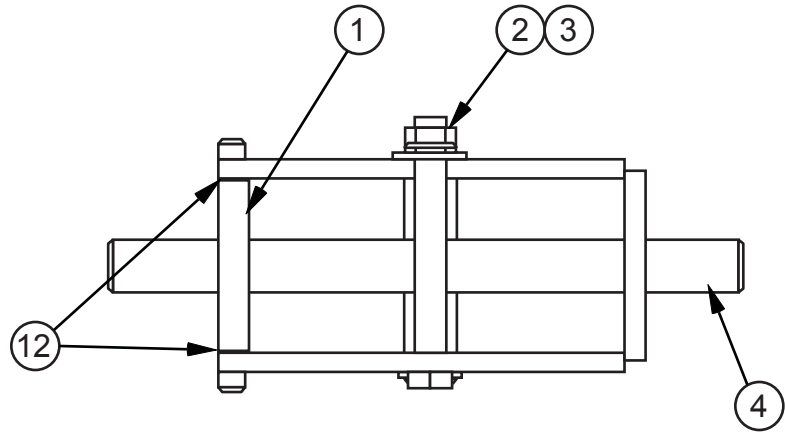
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CARRIAGE ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
	522858	Carriage Assembly	
1	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	4
2	012596	. Nut, Slotted Hex. 3/4-16NF	1
3	199268	. Washer, Flat 3/4 S.A.E. Std.	3
4	117670	. Handwheel Knob	1
5	199266	. Washer, Flat 1/2 S.A.E. Std.	1
6	225029	. Rod Clamp	2
7	225031	. Angle Clamp Rod	2
8	225030	. Clamp Nut	1
9	004294	. Spring Pin	1
10	522867	. Carriage Weldment	1
11	157703	. Rubber Bushing	2
12	147519	. Screw, Soc. Hd. Shoulder 5/8-11NC x 1-1/4 (3/4 Dia.)	2
13	202605	. DU Sleeve Bearing	2
14	202606	. DU Thrust Washer	4
15	220181	. Washer, Flat 1-1/4 S.A.E. Std.	2
16	327024	. Linear Bearing Rail and Truck	2
17	199898	. Screw, Soc. Hd. Cap M5-0.8 x 16	22
18	327206	. Pivot Block	2
19	199287	. Screw, Soc. Hd. Cap M10-1.5 x 60	8
20	199898	. Screw, Soc. Hd. Cap M5-0.8 x 16	16
21	157703	. Rubber Bushing	4
22	110980	. Screw, Soc. Hd. Shoulder 5/8-11NC x 2-3/4 (3/4 Dia.)	2
23	225029	. Rod Clamp	2
24	004273	. Spring Pin	2
25	176374	. Screw, Soc. Hd. Shoulder 3/8-16NC x 1-1/2 (1/2 Dia.)	1
26	199280	. Washer, Flat M12	1
27	327207	. Cylinder Connector Bracket	1
28	199993	. Screw, Soc. Hd. Cap M6-1.0 x 20	4
29	199119	. Nut, Hex. 1/4-28NF	4
30	225006	. Cylinder Mounting Bracket	1
31	1014241	. Air Cylinder (Feed)	1

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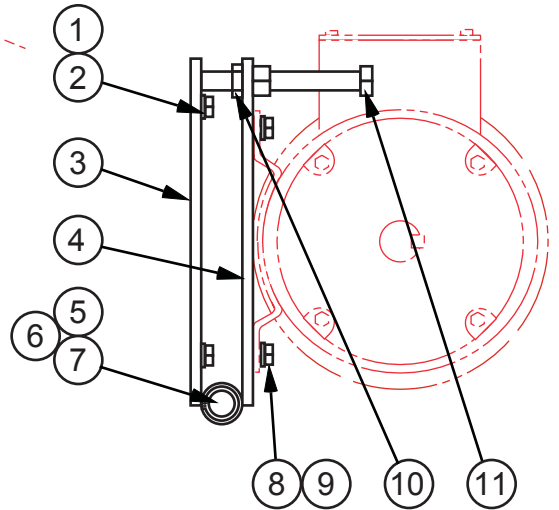
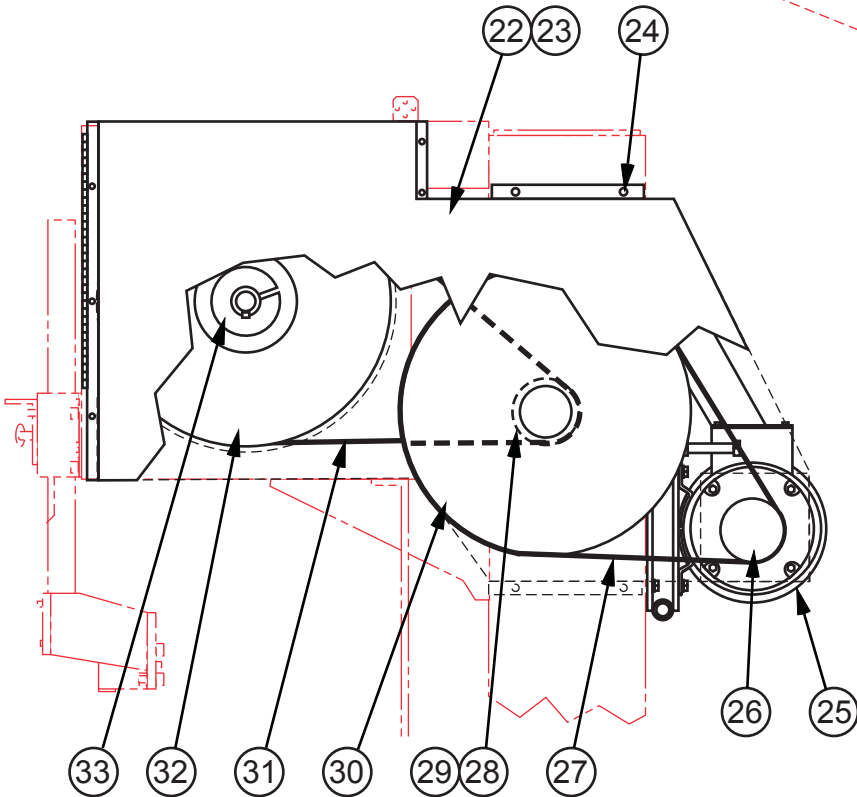
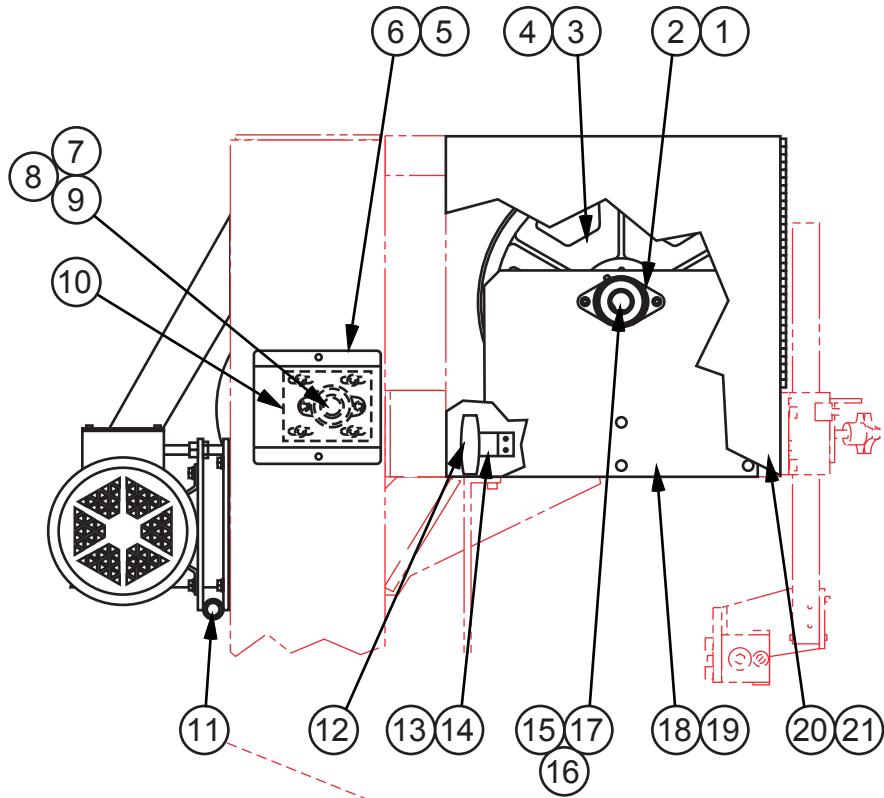
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CRADLE ASSEMBLY

CRADLE ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
	421632	Cradle Assembly	
1	421647	. Cradle End Plate	1
2	199285	. Washer, Flat M16	1
3	199059	. Nut, Hex. M16-2.0	1
4	225024	. Pin	1
5	1014413	. Screw, Hex. Hd. Cap M16-2.0 x 150 (Black Oxide)	1
6	421646	. Cradle Weldment	1
7	225025	. Pin	1
8	003077	. Retaining Ring	2
9	198990	. Screw, Soc. Hd. Cap M12-1.75 x 25	1
10	199445	. Screw, Soc. Set M12-1.75 x 16 (Cone Point)	1
11	198990	. Screw, Soc. Hd. Cap M12-1.75 x 25	9
12	225141	. Shim (.06)	2

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MOTOR BASE ASSEMBLY

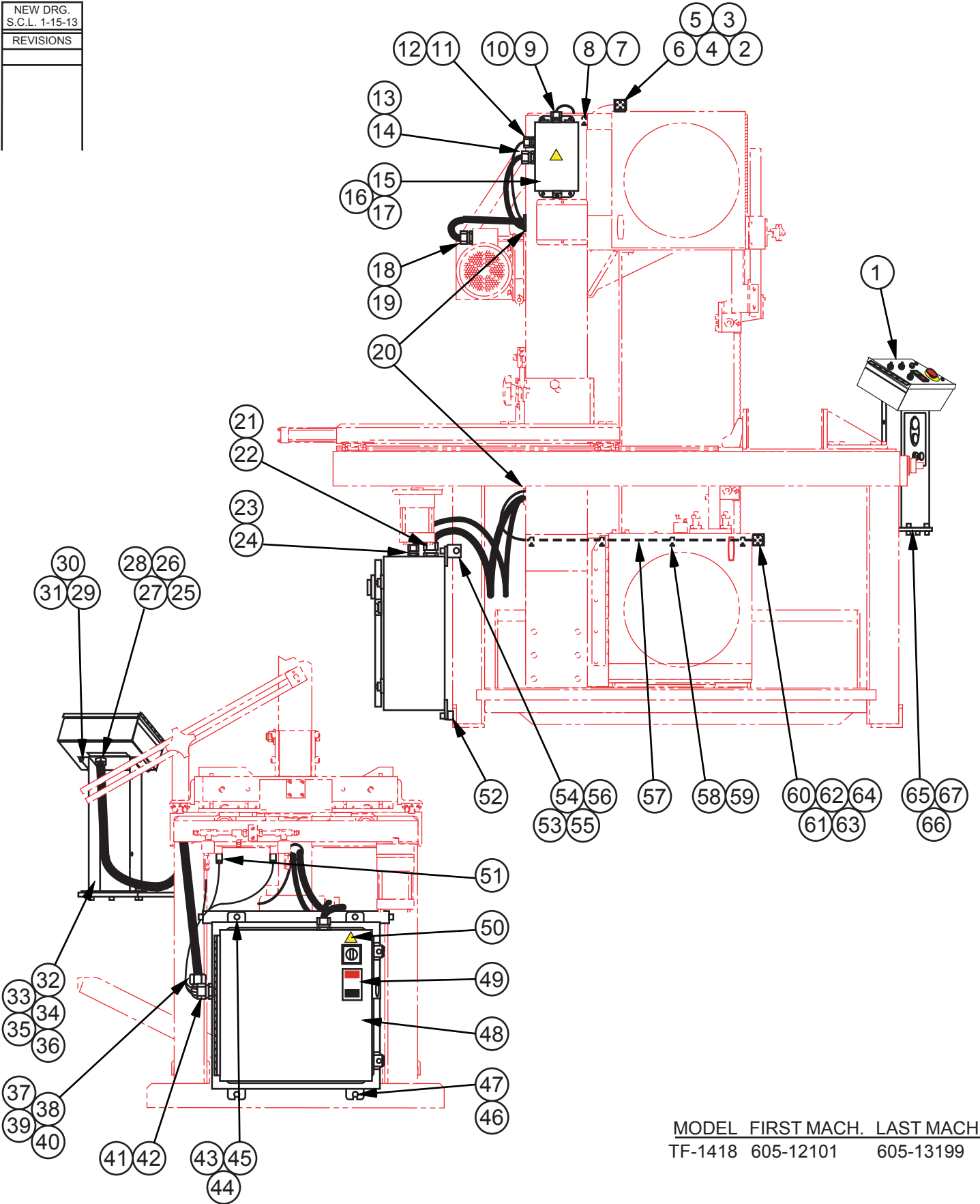
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DRIVE ASSEMBLY

DRIVE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	421625	Drive Assembly	
1	225020	. Flanged Bearing	2
2	198990	. Screw, Hex. Hd. Soc. M12-1.75 x 25	4
3	522855	. Bandwheel	1
4	224598	. Tapered Bushing	1
5*	1014287	. Bearing Cover	1
6	199819	. Screw, Soc. Hd. Cap M8-1.25 x 16	2
7	224595	. Shaft	1
8	004443	. Key	2
9	35-007558	. Retaining Ring (Far Side)	1
10*	1014286	. Bearing Adjustment Assembly (See Detail)	2
11	327205	. Motor Base Assembly (See Detail)	1
12	172762	. Door Latch	1
13	225017	. Latch Bracket	1
14	199246	. Screw, Soc. Hd. Cap M6-1.0 x 12	2
15	224596	. Shaft	1
16	014215	. Key	2
17	003077	. Retaining Ring (Far Side)	1
18	327209	. Front Plate	1
19	199929	. Screw, Soc. Hd. Soc. M12-1.75 x 20	6
20	421637	. Upper Door Weldment	1
21	199246	. Screw, Soc. Hd. Cap M6-1.0 x 12	3
22	1014156	. Rear Drive Cover Weldment	1
23	199246	. Screw, Soc. Hd. Cap M6-1.0 x 12	5
24	199819	. Screw, Soc. Hd. Cap M8-1.25 x 16	4
25	209621	. Electric Motor	1
	209622	. Electric Motor (575V Only)	1
26	224597	. Motor Sheave	1
27	225096	. V-Belt	1
28	1014249	. Timing Pulley	1
29	1014250	. Taperlock Bushing	1
30	225095	. Sheave	1
31	1014252	. Timing Belt	1
32	1014251	. Timing Pulley	1
33	1014254	. Taperlock Bushing	1
	*NOTE: Before Serial #605-13104:		
5	225098	. Bearing Cover	1
10	225003	. Bearing Adjustment Assembly (See Detail)	2
Ref.	327205	. Motor Base Assembly	
1	199836	. Screw, Hex. Hd. Cap M8-1.25 x 16	4
2	199968	. Washer, Lock M8	4
3	225011	. Hinged Base Plate Weldment	1
4	225010	. Motor Base Plate Weldment	1
5	225012	. Pin	1
6	199266	. Washer, Flat 1/2 S.A.E. Std.	2
7	35-008688	. Retaining Ring	2
8	199836	. Screw, Hex. Hd. Cap M8-1.25 x 16	4
9	199968	. Washer, Lock M8	4
10	199222	. Nut, Hex. Jam M12-1.75	1
11	199845	. Screw, Hex. Hd. Soc. M12-1.75 x 50	1

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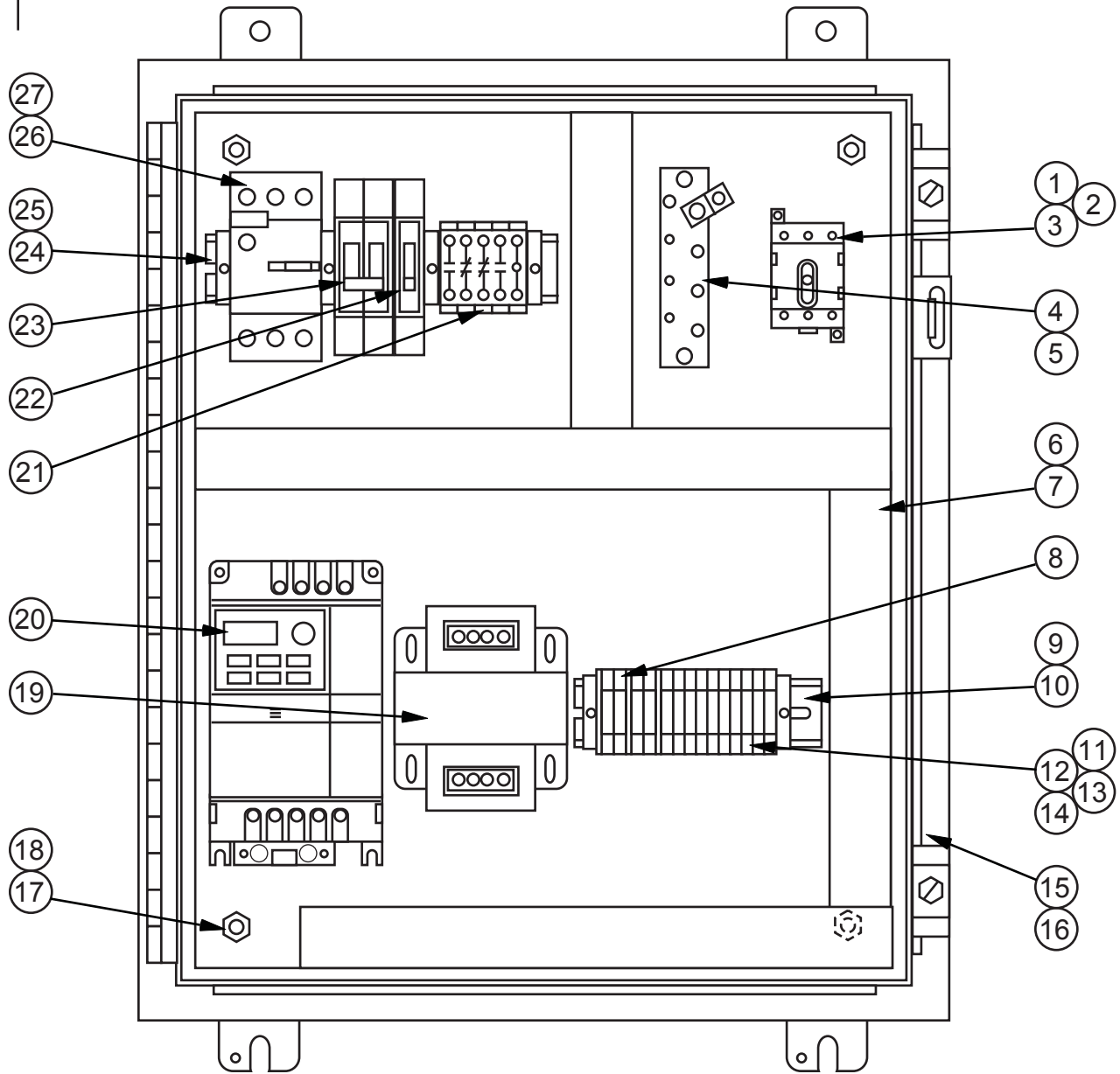
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ELECTRICAL ASSEMBLY

ELECTRICAL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	225214	Electrical Assembly	
1		. Pushbutton Box Assembly (See Detail)	1
2	215624	. Limit Switch (Door Interlock)	1
3	199389	. Screw, Button Hd. Soc. M4-0.7 x 30	2
4	225135	. Switch Key Bracket	1
5	199728	. Screw, Button Hd. Soc. M4-0.7 x 30	4
6	215619	. Cord Grip Connector (.236-.472)	1
7	167329	. Hose Clamp	1
8	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	1
9	201688	. Cord Grip Connector (.200-.394)	1
10	197332	. Electrical Cord (#18-2 Conductor)	A.R.
11	201688	. Cord Grip Connector (.200-.394)	1
12	197332	. Electrical Cord (#18-2 Conductor)	A.R.
13	201696	. Cord Grip Connector (.394-.551)	1
14	197436	. Electrical Cord (#18-8 Conductor)	A.R.
15		. Junction Box Assembly (Head) (See Detail)	1
16	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	4
17	176528	. Label (Electrical Hazard)	1
18	015835	. Cord Grip Connector (.500-.625)	1
19	197218	. Electrical Cord (#14-4 Conductor)	A.R.
20	197351	. Grommet Strip	A.R.
21	201687	. Cord Grip Connector (.545-.709)	1
22	197218	. Electrical Cord (#14-4 Conductor)	A.R.
23	201696	. Cord Grip Connector (.394-.551)	1
24	197436	. Electrical Cord (#18-8 Conductor)	A.R.
25	014486	. Sealtite Connector	1
26	014480	. Flange Washer	1
27	014772	. Insulated Bushing	1
28	197158	. Sealtite Conduit 3/4 I.D.	A.R.
29	199202	. Nut, Hex. M5-0.8	4
30	199244	. Washer, Flat M5	4
31	199348	. Washer, Lock M5	4
32	1014111	. Console Column	1
33	199981	. Screw, Soc. Hd. Cap M8-1.25 x 30	4
34	199941	. Nut, Hex. M8-1.25	4
35	1014174	. Column Cover	1
36	199527	. Screw, Pan Hd. Self-Tap M5.5 x 13	4
37	014484	. 90° Sealtite Connector	1
38	014480	. Flange Washer	1
39	015607	. Bond Nut	1
40	197158	. Sealtite Conduit 3/4 I.D.	A.R.
41	201687	. Cord Grip Connector (.545-.709)	1
42	1004154	. 3-Hole Insert	1
43	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	2
44	199939	. Nut, Hex. M10-1.5	2
45	199346	. Washer, Lock M10	2
46	199919	. Screw, Soc. Hd. Cap M10-1.5 x 25	2
47	199346	. Washer, Lock M10	2
48		. Electrical Box Enclosure Assembly (See Detail)	1
49	201464	. Label (Danger - High Voltage)	1
50	176528	. Label (Electrical Hazard)	1
51	224950	. Solenoid DIN Connector (Mist Lube)	1
52	1014169	. Spacer	2
53	1014175	. Enclosure Mounting Bracket	1
54	199818	. Screw, Soc. Hd. Cap M10-1.5 x 20	2
55	199346	. Washer, Lock M10	2
56	198976	. Washer, Flat M10	2
57	197332	. Electrical Cord (#18-2 Conductor)	A.R.
58	167329	. Hose Clamp	4
59	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	4
60	215624	. Limit Switch (Door Interlock)	1
61	199389	. Screw, Button Hd. Soc. M4-0.7 x 30	2
62	225135	. Switch Key Bracket	1
63	199728	. Screw, Button Hd. Soc. M4-0.7 x 30	4
64	215619	. Cord Grip Connector (.236-.472)	1
65	1014114	. Column Bracket Weldment	1
66	199818	. Screw, Soc. Hd. Cap M10-1.5 x 20	2
67	199346	. Washer, Lock M10	2

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Enclosure Door Removed to Show Detail.

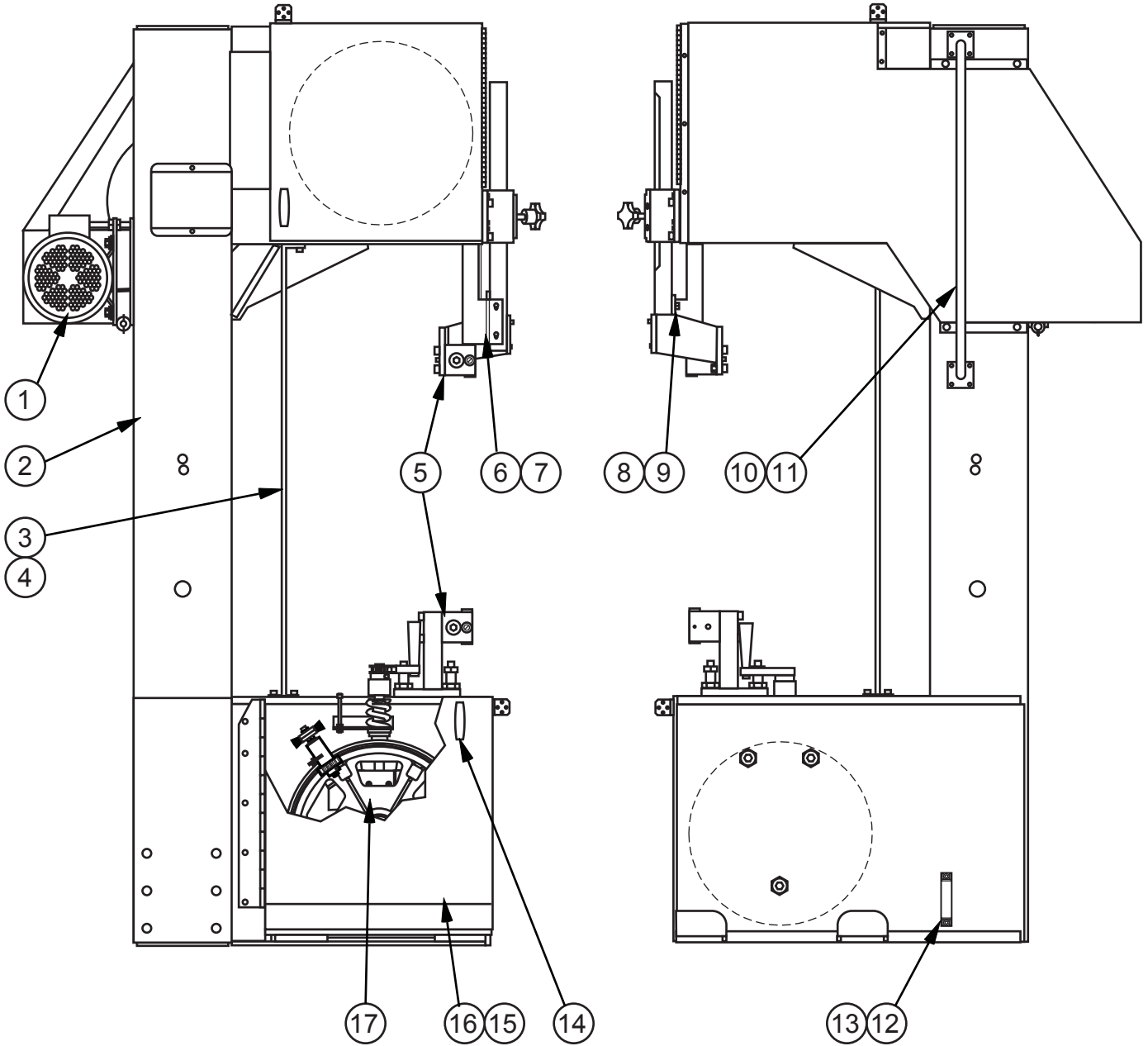
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ELECTRICAL BOX ENCLOSURE ASSEMBLY

ELECTRICAL BOX ENCLOSURE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	225214	Electrical Box Enclosure Assembly	
1	1007434	. Disconnect Switch	1
2	1007437	. Disconnect Switch Handle	1
3	1007441	. Disconnect Switch Shaft	1
4	320740	. Grounding Bus	1
5	139194	. Wire Terminal Lug	1
6	197208	. 1" Panel Channel	A.R.
7	197210	. 1" Panel Channel Cover	A.R.
8	222284	. Terminal Block (Yellow)	2
9	169674	. Mounting Channel	A.R.
10	200618	. End Stop	2
11	200615	. Terminal Block (Gray)	12
12	200617	. End Section	3
13	202922	. Jumper Bar	1
14	225210	. Terminal Marker Set	1
15	225213	. Enclosure	1
16	225209	. CB and MSP Schedule (Inside Door)	1
17	199126	. Nut, Hex. 3/8-16NC	4
18	199325	. Washer, Lock 3/8 Std.	4
19	320113	. Transformer (208V)	1
	320114	. Transformer (230V, 460V, 575V)	1
	217753	. Transformer (400V)	1
20	225206	. Variable Speed Drive Module (208V, 230V)	1
	225207	. Variable Speed Drive Module (400V, 460V)	1
	225208	. Variable Speed Drive Module (575V)	1
21	221997	. Control Relay	1
22	420361	. Circuit Breaker	1
23	1007400	. Circuit Breaker (208V, 230V)	1
	1007399	. Circuit Breaker (400V, 460V)	1
	215212	. Fuse Block (575V)	2
	203158	. Fuse (1 Amp) (575V)	2
24	169674	. Mounting Channel	A.R.
27	200618	. End Stop	4
26	220647	. Motor Starter Protector (208V, 230V)	1
	220646	. Motor Starter Protector (400V, 460V)	1
	220645	. Motor Starter Protector (575V)	1
27	220654	. Auxiliary Contact (1-NO)	1
Following Not Shown:			
	1012541	. Label (Machine Data)	1
	197339	. Wire, #14 Black (19 Strand).....	A.R.
	197195	. Wire, #14 Green/Yellow (19 Strand)	A.R.
	197343	. Wire, #16 Green/Yellow (19 Strand)	A.R.
	197325	. Wire, #16 White (19 Strand)	A.R.
	197197	. Wire, #16 Red (19 Strand)	A.R.
	197345	. Shielded Cable (#20-3 Conductor)	A.R.
	007635	. Wire Terminal Ring #10	9
	207111	. Wire Terminal Locking Fork #8	5

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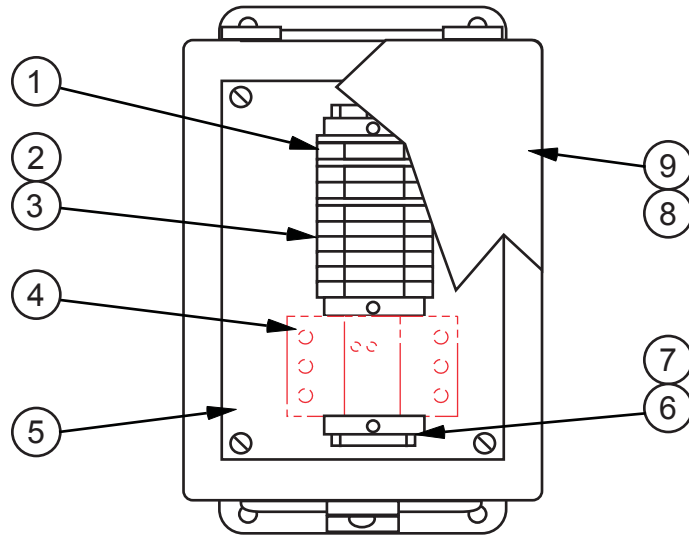
HEAD ASSEMBLY

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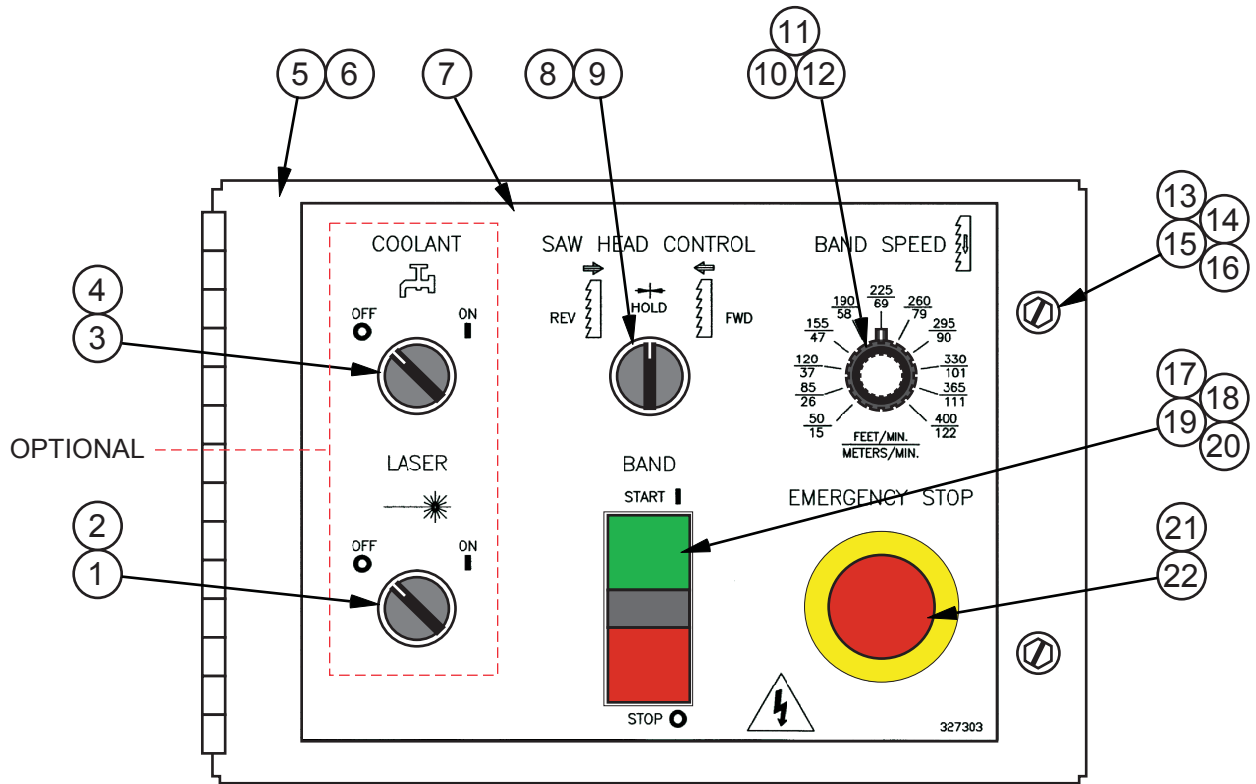
HEAD ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
	522857	Head Assembly	
1	421625	. Drive Assembly (See Detail)	1
2	522861	. Head Weldment	1
3	421640	. Band Guard Weldment	1
4	199819	. Screw, Soc. Hd. Cap M8-1.25 x 16	6
5	522859	. Saw Guide Assemblies (See Detail)	1
6	1014162	. Left Rear Post Guard	1
7	198373	. Screw, Button Hd. Soc. 5/16-18NC x 3/8	2
8	1014161	. Right Rear Post Guard	1
9	198025	. Screw, Hex. Hd. Cap 5/16-18NC x 1/2	2
10	1014168	. Handle Weldment	1
11	199898	. Screw, Soc. Hd. Cap M5-0.8 x 16	8
12	171912	. Pull Handle	1
13	199819	. Screw, Soc. Hd. Cap M8-1.25 x 16	2
14	172762	. Door Latch	1
15	421639	. Lower Door Weldment	1
16	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	5
17	421633	. Bandwheel Assembly (Lower - With Band Tension) (See Detail)	1

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JUNCTION BOX ASSEMBLY
(HEAD)



PUSHBUTTON BOX ASSEMBLY

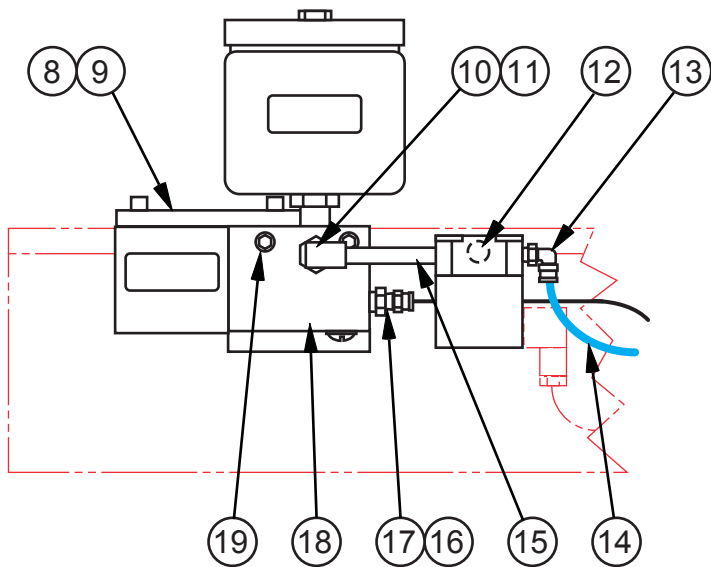
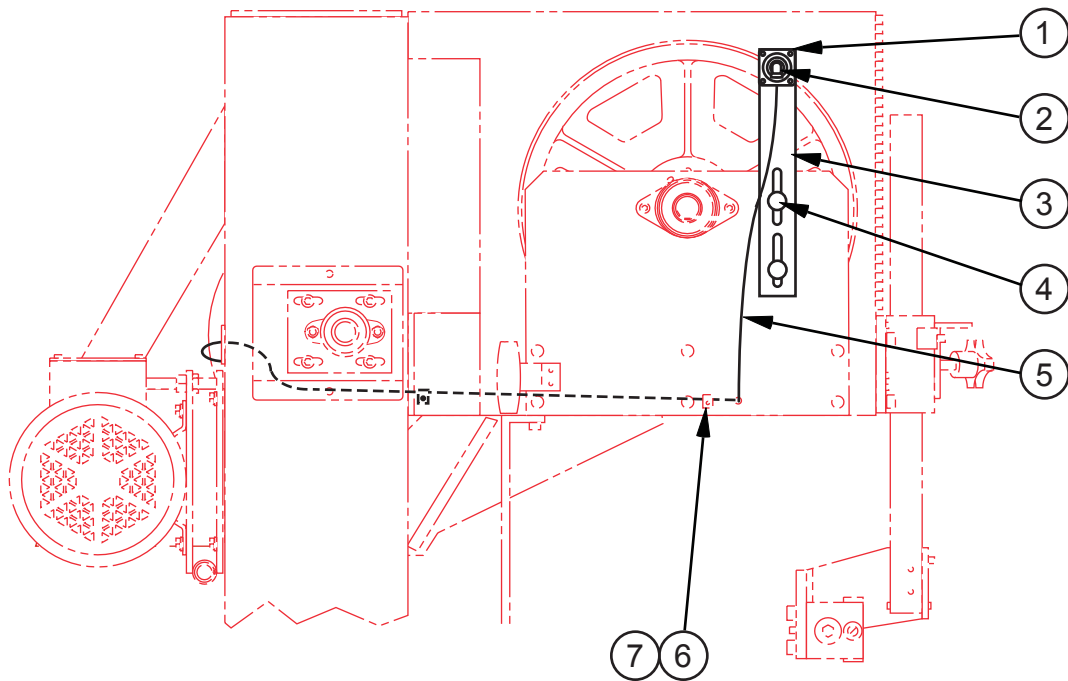
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JUNCTION/PUSHBUTTON BOX ASSEMBLIES

JUNCTION/PUSHBUTTON BOX ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	225214	Junction Box Assembly (Head)	
1	222284	. Terminal Block (Yellow)	1
2	200615	. Terminal Block (Gray)	8
3	200617	. End Section	3
4	219373	. Power Supply (Laser Option)	1
5	135454	. Junction Box Panel	1
6	169674	. Mounting Channel	A.R.
7	200618	. End Stop	3
8	133882	. Junction Box (With Lift-Off Cover)	1
9	215267	. Gasket Strip	A.R.
Ref.	225214	Pushbutton Box Assembly	
1	135106	. Hole Seal (Standard)	1
	207181	. Selector Switch (2 Position) (Laser Option).....	1
2	207185	. Contact Block (1-NO) (Laser Option)	1
3	135106	. Hole Seal (Standard)	1
	207181	. Selector Switch (2 Position) (Flood Coolant Option)	1
4	207185	. Contact Block (1-NO) (Flood Coolant Option)	1
5	1014086	. Enclosure Weldment	1
6	215267	. Gasket Strip	A.R.
7	327303	. Escutcheon	1
8	207181	. Selector Switch (3 Position)	1
9	207185	. Contact Block (1-NO)	1
10	223353	. Potentiometer	1
11	178146	. Knob	1
12	200044	. Hex. Seal	1
13	207171	. Rivet Nut M5-0.8	2
14	207170	. Screw, Hex. Hd. Slotted M5-0.8 x 20	2
15	204150	. Retaining Ring	2
16	204152	. Nylon Washer	2
17	221140	. Double Pushbutton Operator (Red/Green)	1
18	207185	. Contact Block (1-NO)	2
19	207186	. Contact Block (1-NC)	1
20	221385	. Seal Boot	1
21	207191	. Pushbutton Operator (Red Mushroom)	1
22	207186	. Contact Block (1-NC)	1

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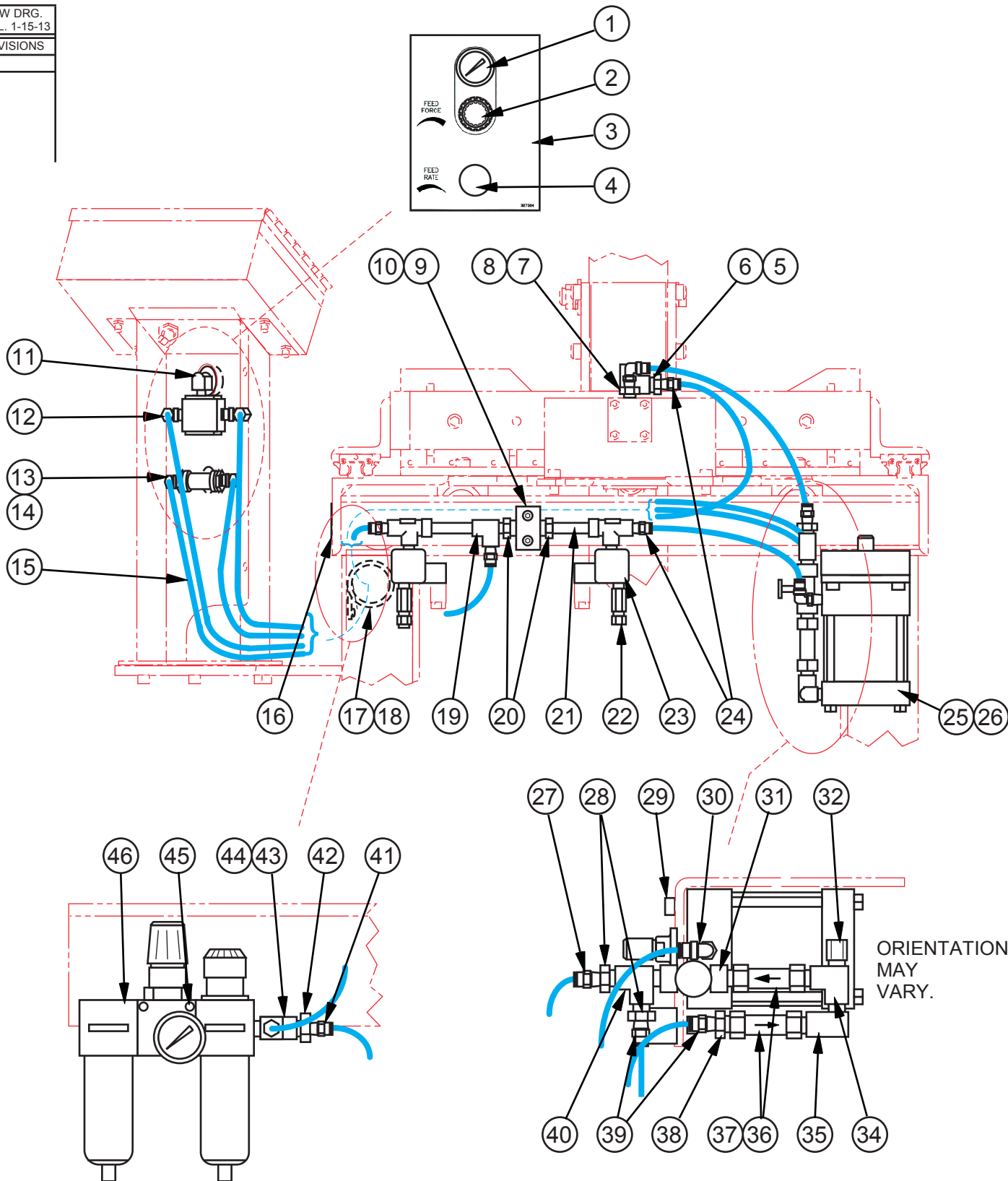
MODEL FIRST MACH. LAST MACH.
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MIST LUBRICATOR ASSEMBLY

MIST LUBRICATOR ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
	225274	Mist Lubricator Assembly	
1	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	4
2	200135	. 90° Swivel Male Elbow	1
3	323615	. Nozzle Mounting Bracket	1
4	1014414	. Studded Knob	2
5	197142	. Nylon Tubing 1/8 O.D.	A.R.
6	209458	. Hose Clip	3
7	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	3
8	324191	. Mounting Bracket	1
9	199923	. Screw, Soc. Hd. Cap M6-1.0 x 10	2
10	260426	. Reducer Bushing	1
11	5-027506	. 90° Street Elbow	1
12	176811	. Vent Filter/Breather	1
13	200135	. 90° Swivel Male Elbow	1
14	197438	. Polythelene Tubing 1/4 O.D. (Blue)	A.R.
15	203144	. Pipe Nipple (Brass)	1
16	260426	. Reducer Bushing	1
17	200133	. Swivel Male Elbow	1
18	208833	. Mist Lubricator (Includes Solenoid, Nozzle, Hose, etc.)	1
19	199824	. Screw, Soc. Hd. Cap M6-1.0 x 55	2

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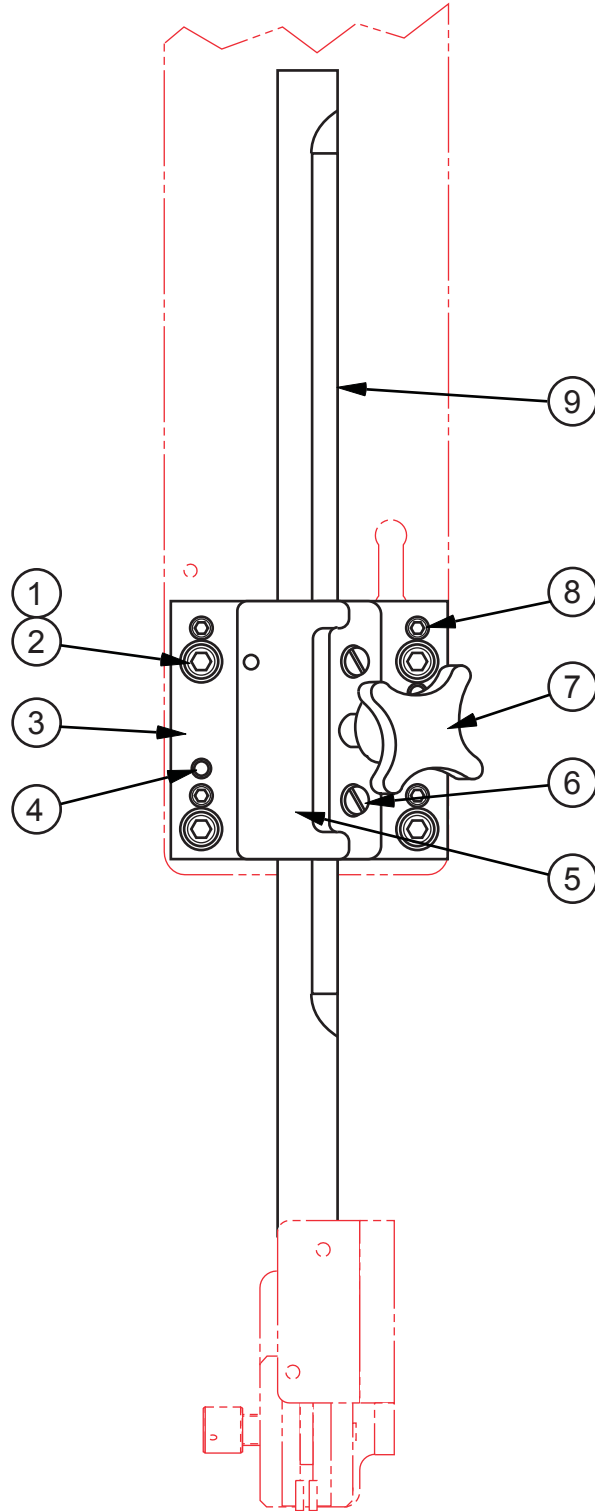
MODEL FIRST MACH. LAST MACH.
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PNEUMATIC/HYDRAULIC ASSEMBLY

PNEUMATIC/HYDRAULIC ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	517262	Pneumatic/Hydraulic Assembly	
1	200137	. Gauge	1
2	206114	. Air Regulator	1
3	327304	. Escutcheon	1
4	158827	. Needle Valve	1
5	133542	. Service Tee	1
6	134352	. Reducer Bushing	1
7	134352	. Reducer Bushing	1
8	200135	. 90° Swivel Male Elbow	1
9	114433	. Manifold	1
10	199233	. Screw, Soc. Hd. Cap M6-1.0 x 30	2
11	5-027506	. 90° Street Elbow	1
12	200135	. 90° Swivel Male Elbow	2
13	260426	. Reducer Bushing	2
14	200135	. 90° Swivel Male Elbow	2
15	197438	. Polyethylene Tubing 1/4 O.D. (Blue)	A.R.
16	176879	. Escutcheon (Air Supply Limits)	1
17	016561	. Hose Clamp	3
18	199243	. Screw, Button Hd. Soc. M5-0.8 x 12	3
19	112043	. Street Tee	1
20	260426	. Reducer Bushing	2
21	203144	. Pipe Nipple (Brass)	2
22	176811	. Vent Filter Breather	2
23	176829	. Solenoid Valve	2
24	200133	. Male Swivel Connector	2
25	318130	. Pneumatic Cylinder (Accumulator)	1
26	201030	. Transmission Fluid (1 Quart)	A.R.
27	200133	. Male Swivel Connector	1
28	260426	. Reducer Bushing	2
29	199819	. Screw, Soc. Hd. Cap M8-1.25 x 16	4
30	200135	. 90° Swivel Male Elbow	1
31	158827	. Needle Valve	1
32	123835	. 90° Reducing Elbow	1
34	120857	. Service Tee	1
35	008254	. 90° Street Elbow	1
36	008048	. Check Valve	2
37	14-003507	. Close Nipple	3
38	260426	. Reducer Bushing	2
39	200133	. Male Swivel Connector	2
40	120857	. Service Tee	1
41	200133	. Male Swivel Connector	1
42	260426	. Reducer Bushing	1
43	120857	. Service Tee	1
44	200133	. Male Swivel Connector	1
45	199040	. Screw, Soc. Hd. Cap M4-0.7 x 35	2
46	209272	. Filter/Regulator/Lubricator	1

NEW DRG. S.C.L. 1-15-13
REVISIONS



MODEL FIRST MACH. LAST MACH.
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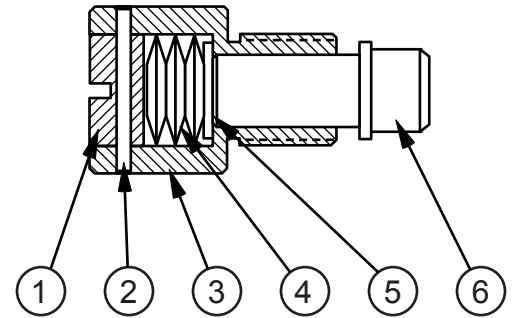
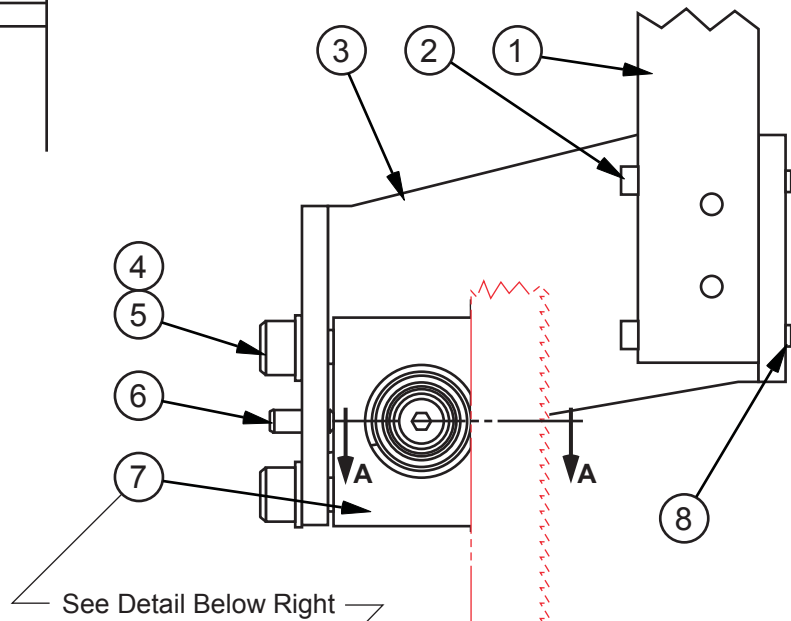
POST ASSEMBLY

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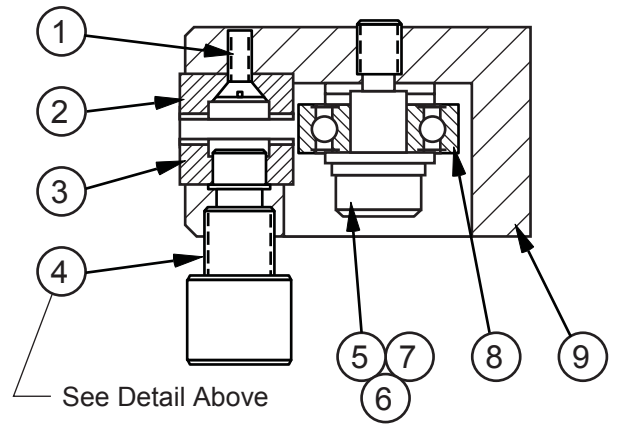
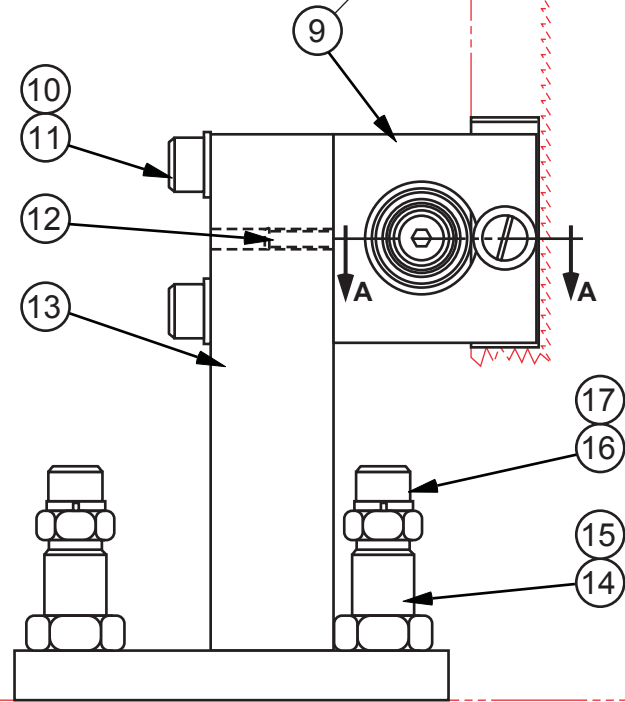
POST ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	224593	Post Assembly	
1	198280	. Screw, Soc. Hd. Cap 3/8-16NC x 1-1/4	4
2	199325	. Washer, Lock 3/8 Std.	4
3	319741	. Post Slide Plate	1
4	004282	. Spring Pin	2
5	417394	. Post Slide Casting	1
6	204850	. Spring Plunger	2
7	224594	. Knob	1
8	198459	. Screw, Soc. Set 3/8-24NF x 1	4
9	417400	. Post	1

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ADJUSTING SCREW ASSEMBLY



GUIDE BLOCK ASSEMBLY
(Section A - A)

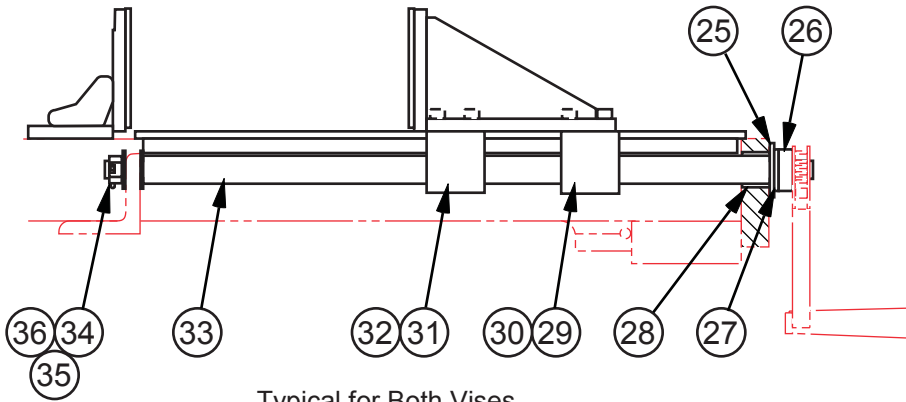
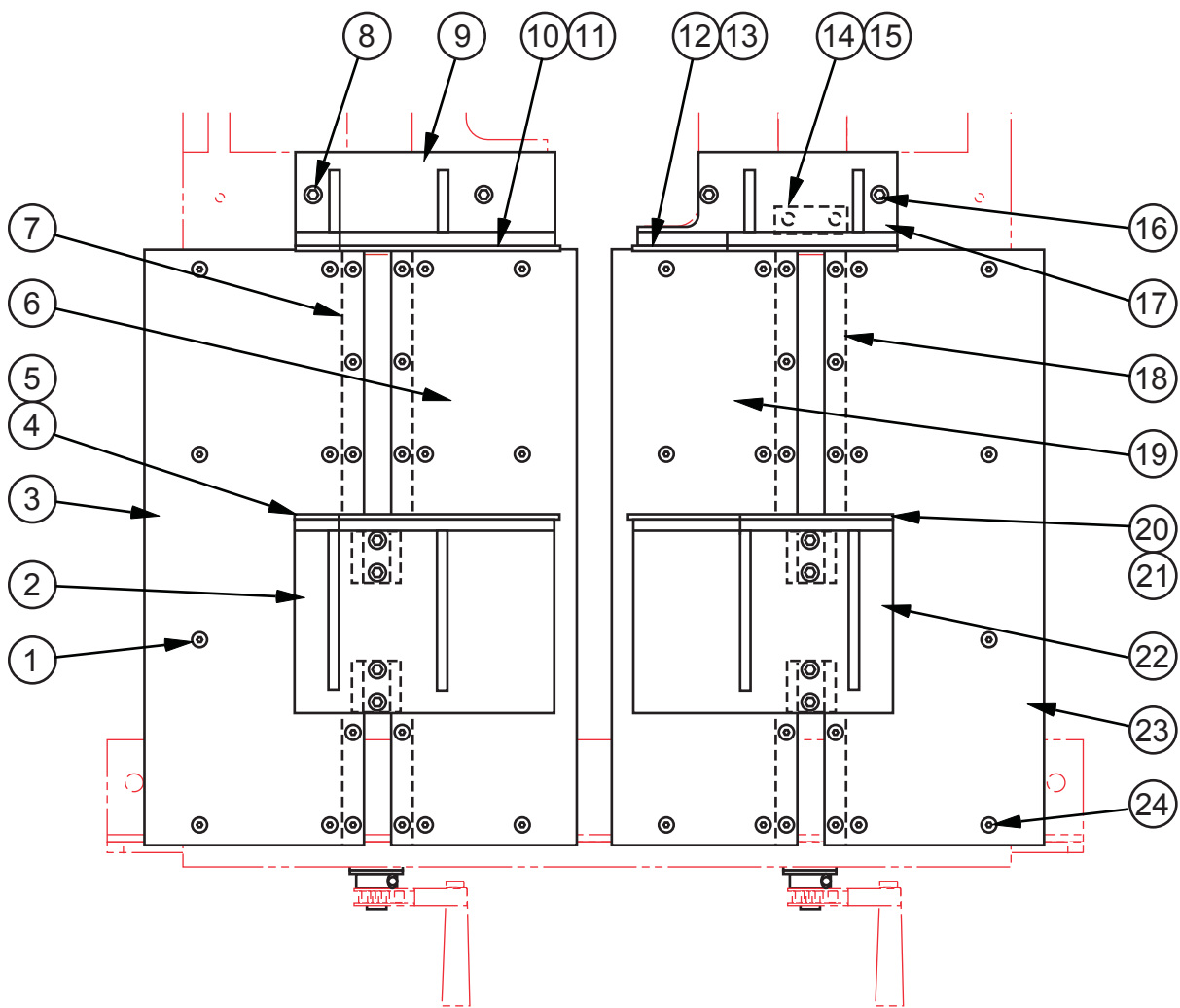
MODEL FIRST MACH. LAST MACH.
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SAW GUIDE ASSEMBLIES

SAW GUIDE ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	522859	Saw Guide Assembly	
1	224593	. Post Assembly (See Detail)	1
2	198246	. Screw, Soc. Hd. Cap 1/4-20NC x 1-3/4	2
3	225089	. Upper Saw Guide Bracket	1
4	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	2
5	198976	. Washer, Flat M10	2
6	199409	. Screw, Soc. Set M6-1.0 x 20	2
7	224566	. Guide Block Assembly (See Detail)	1
8	004251	. Spring Pin	2
9	224566	. Guide Block Assembly (See Detail)	1
10	198724	. Screw, Soc. Hd. Cap M10-1.5 x 55	2
11	198976	. Washer, Flat M10	2
12	199409	. Screw, Soc. Set M6-1.0 x 20	2
13	327228	. Lower Post Weldment	1
14	005956	. Adjustment Screw 3/4-10NC x 2-5/16 (.42 Dia.)	3
15	100142	. Nut, Hex. Jam 3/4-10NC	3
16	199980	. Screw, Soc. Hd. Cap M10-1.5 x 80	3
17	199346	. Washer, Lock M10	3
Ref.	224566	. Guide Block Assembly	
1	198749	. . Screw, Flat Hd. Mach. #10-24NC x 1/2	1
2	137158	. . Insert Assembly (Fixed)	1
3	137155	. . Insert Assembly (Adjustable)	1
4	124419	. . Adjusting Screw Assembly (See Detail)	1
5	176077	. . Screw, Soc. Hd. Shoulder M8-1.25 x 16 (10 mm Dia.)	1
6	198976	. . Washer, Flat M10	3
7	199346	. . Washer, Lock M10	1
8	011529	. . Ball Bearing	1
9	225021	. . Guide Housing	1
Ref.	124419	. . Adjusting Screw Assembly	
1	124033	. . . Plug	1
2	004217	. . . Spring Pin	1
3	124418	. . . Housing	1
4	104632	. . . Belleville Washer	6
5	199257	. . . Washer, Flat #8 S.A.E. Std.	1
6	124417	. . . Plunger	1

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S.C.L. 1-15-13



Typical for Both Vises

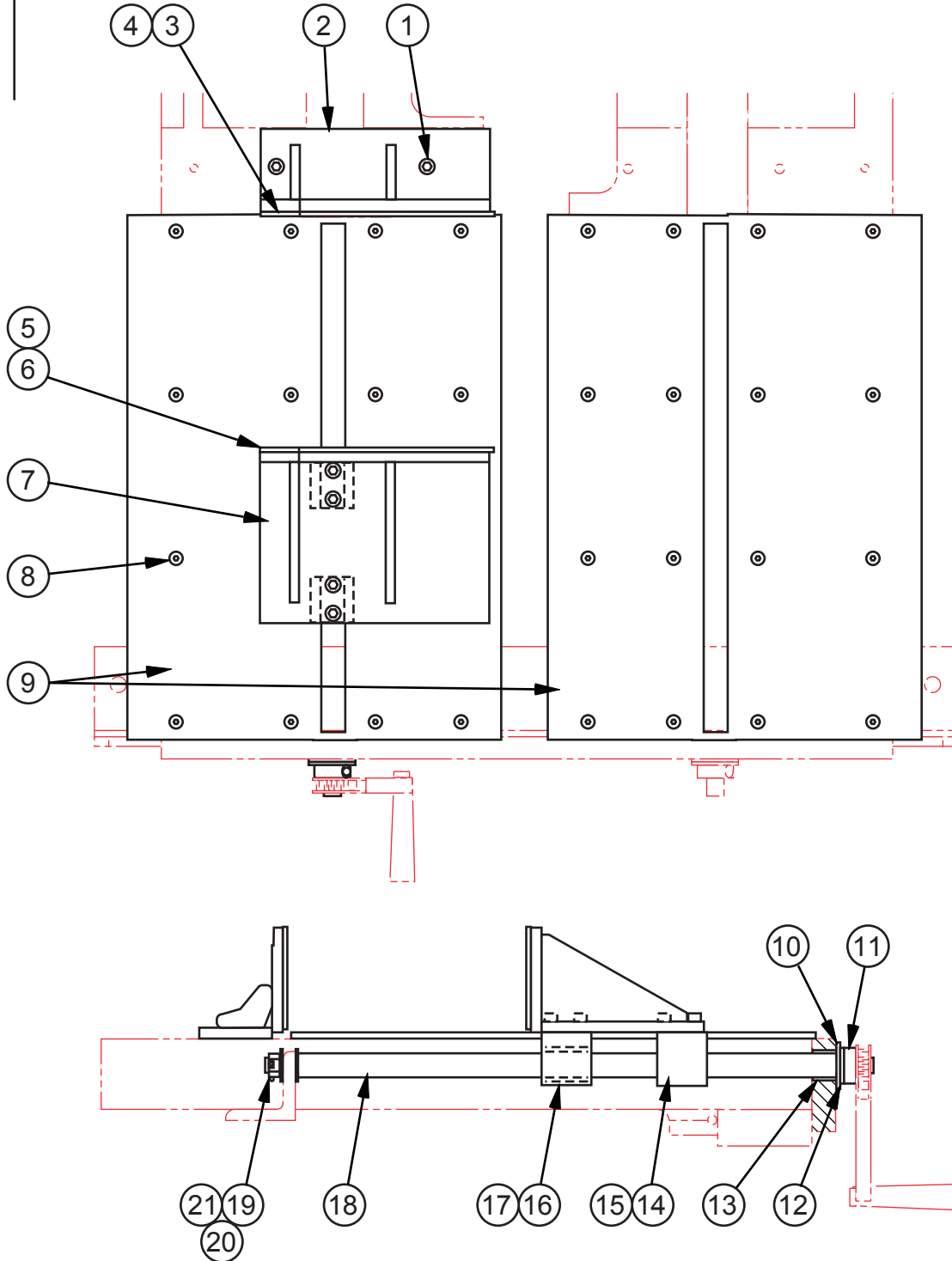
MODEL FIRST MACH. LAST MACH.
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VICE ASSEMBLY

WISE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	421635	Vise Assembly	
1	199905	. Screw, Flat Hd. Soc. M6-1.0 x 16	30
2	327234	. L.H. Movable Vise Jaw Weldment	1
3	327231	. Wear Plate	1
4	327237	. Vise Wear Plate	1
5	199905	. Screw, Flat Hd. Soc. M6-1.0 x 16	6
6	327232	. Wear Plate	1
7	225099	. Slide Bar	2
8	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	2
9	327233	. L.H. Fixed Vise Jaw Weldment	1
10	327235	. Vise Wear Plate	1
11	199905	. Screw, Flat Hd. Soc. M6-1.0 x 16	5
	199987	. Screw, Flat Hd. Soc. M6-1.0 x 10	1
12	1014122	. Vise Wear Plate	1
13	199905	. Screw, Flat Hd. Soc. M6-1.0 x 16	6
14	1014126	. Vise Screw Mounting Block	1
15	199911	. Screw, Soc. Hd. Cap M10-1.5 x 40	2
16	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	2
17	1014125	. R.H. Fixed Vise Jaw Weldment	1
18	225099	. Slide Bar	2
19	327232	. Wear Plate	1
20	1014121	. Vise Wear Plate	1
21	199905	. Screw, Flat Hd. Soc. M6-1.0 x 16	6
22	1014124	. R.H. Movable Vise Jaw Weldment	1
23	327231	. Wear Plate	1
24	199905	. Screw, Flat Hd. Soc. M6-1.0 x 16	30
25	126535	. Bronze Thrust Bearing	2
26	1013354	. Collar	2
27	199268	. Washer, Flat 3/4 S.A.E. Std.	2
28	005022	. Sleeve Bearing	2
29	225101	. T-Nut (Plain)	2
30	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	4
31	225100	. T-Nut 1-5 Acme Thread (L.H.)	2
32	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	4
33	327236	. Vise Screw 1-5 Acme Thread (L.H.)	2
34	199161	. Nut, Slotted Castellated 5/8-18NF	2
35	004248	. Spring Pin	2
36	199267	. Washer, Flat 5/8 S.A.E. Std.	4

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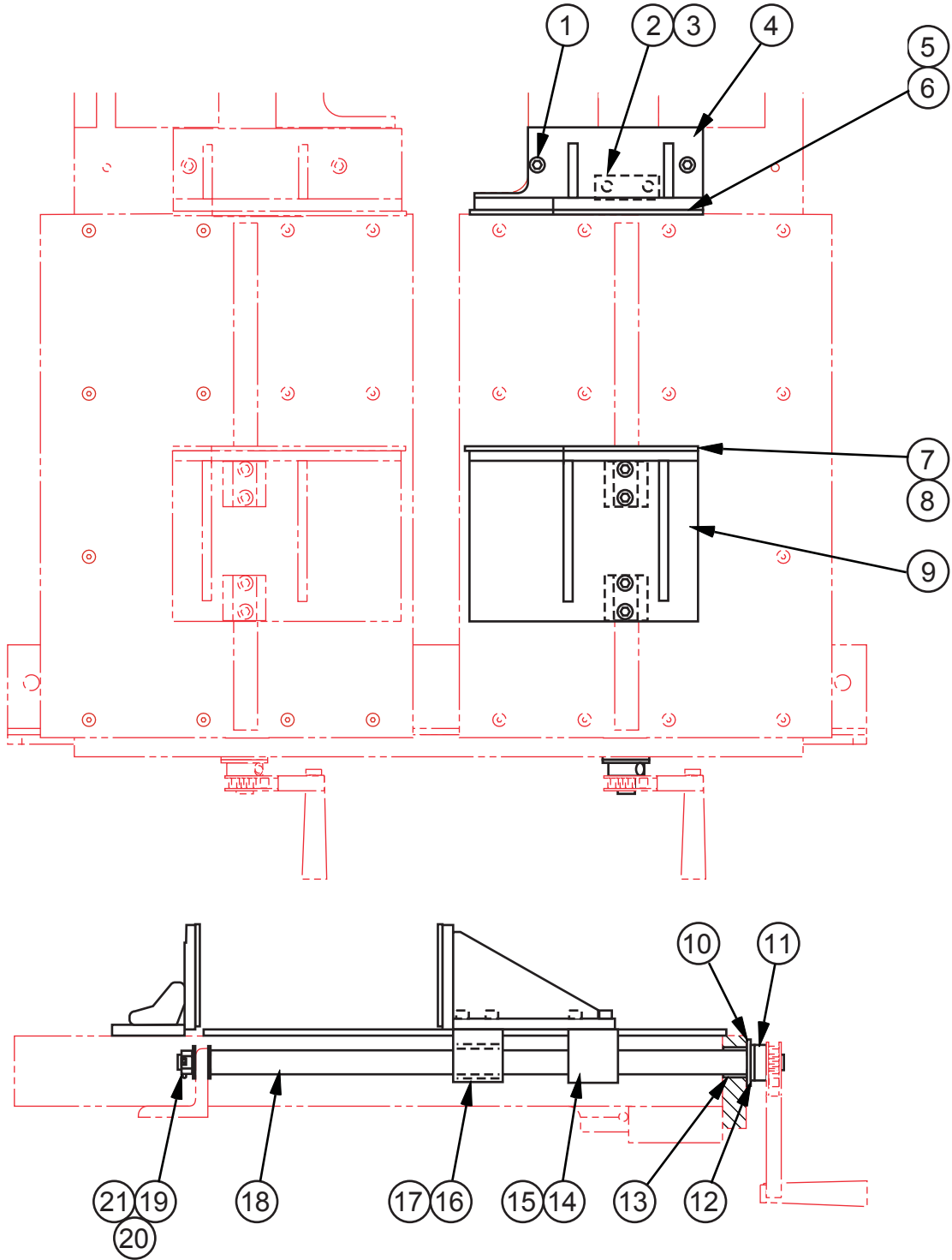
WISE ASSEMBLY (LEFT HAND)

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WISE ASSEMBLY
(Left Hand)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	421635	Vise Assembly (Left Hand)	
1	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	2
2	327233	. L.H. Fixed Vise Jaw Weldment	1
3	327235	. Vise Wear Plate	1
4	199905	. Screw, Flat Hd. Soc. M6-1.0 x 16	5
	199987	. Screw, Flat Hd. Soc. M6-1.0 x 10	1
5	327237	. Vise Wear Plate	1
6	199905	. Screw, Flat Hd. Soc. M6-1.0 x 16	6
7	327234	. L.H. Movable Vise Jaw Weldment	1
8	199905	. Screw, Flat Hd. Soc. M6-1.0 x 16	32
9	1014246	. Wear Plate	2
10	126535	. Bronze Thrust Bearing	2
11	1013354	. Collar	2
12	199268	. Washer, Flat 3/4 S.A.E. Std.	2
13	005022	. Sleeve Bearing	2
14	1014244	. T-Nut (Plain)	2
15	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	4
16	1014243	. T-Nut (With 1-5 Acme Thread L.H.)	2
17	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	4
18	327236	. Vise Screw (1-5 Acme Thread L.H.)	2
19	199161	. Nut, Slotted Castellated 5/8-18NF	2
20	004248	. Spring Pin	2
21	199267	. Washer, Flat 5/8 S.A.E. Std.	4

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MODEL FIRST MACH. LAST MACH.
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WISE ASSEMBLY (RIGHT HAND)

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WISE ASSEMBLY
(Right Hand)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	225303	Vise Assembly (Left Hand)	
1	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	2
2	1014126	. Vise Screw Mounting Block	1
3	199911	. Screw, Soc. Hd. Cap M10-1.5 x 40	2
4	1014125	. R.H. Fixed Vise Jaw Weldment	1
5	1014122	. Vise Wear Plate (If Supplied)	1
6	199905	. Screw, Flat Hd. Soc. M6-1.0 x 16	6
7	1014121	. Vise Wear Plate (If Supplied)	1
8	199905	. Screw, Flat Hd. Soc. M6-1.0 x 16	6
9	1014124	. R.H. Movable Vise Jaw Weldment	1
10	126535	. Bronze Thrust Bearing	2
11	1013354	. Collar	2
12	199268	. Washer, Flat 3/4 S.A.E. Std.	2
13	005022	. Sleeve Bearing	2
14	1014244	. T-Nut (Plain)	2
15	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	4
16	1014243	. T-Nut (With 1-5 Acme Thread L.H.)	2
17	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	4
18	327236	. Vise Screw (1-5 Acme Thread L.H.)	2
19	199161	. Nut, Slotted Castellated 5/8-18NF	2
20	004248	. Spring Pin	2
21	199267	. Washer, Flat 5/8 S.A.E. Std.	4