

Parts Manual



SAWING PRODUCTS

400AV

Serial No: 608-14101 to

Band Sawing Machine

MACHINE SPECIFICATIONS

MODEL SERIAL NO.

VOLTAGE CYCLE PHASE

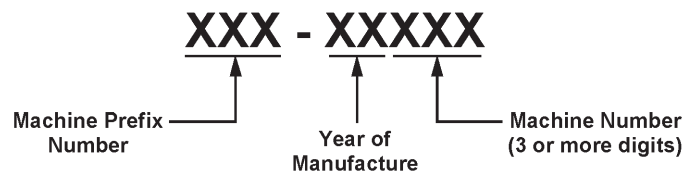
For your information and future reference, insert pertinent data concerning your machine in the spaces provided above. This information is printed on a label attached to the machine frame.

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



Continental Machines, Inc. - DoALL Sawing Products
5505 West 123rd Street
Savage, Mn 55378 U.S.A..

YOUR SERVICE REPRESENTATIVE:

PARTS MANUAL INDEX

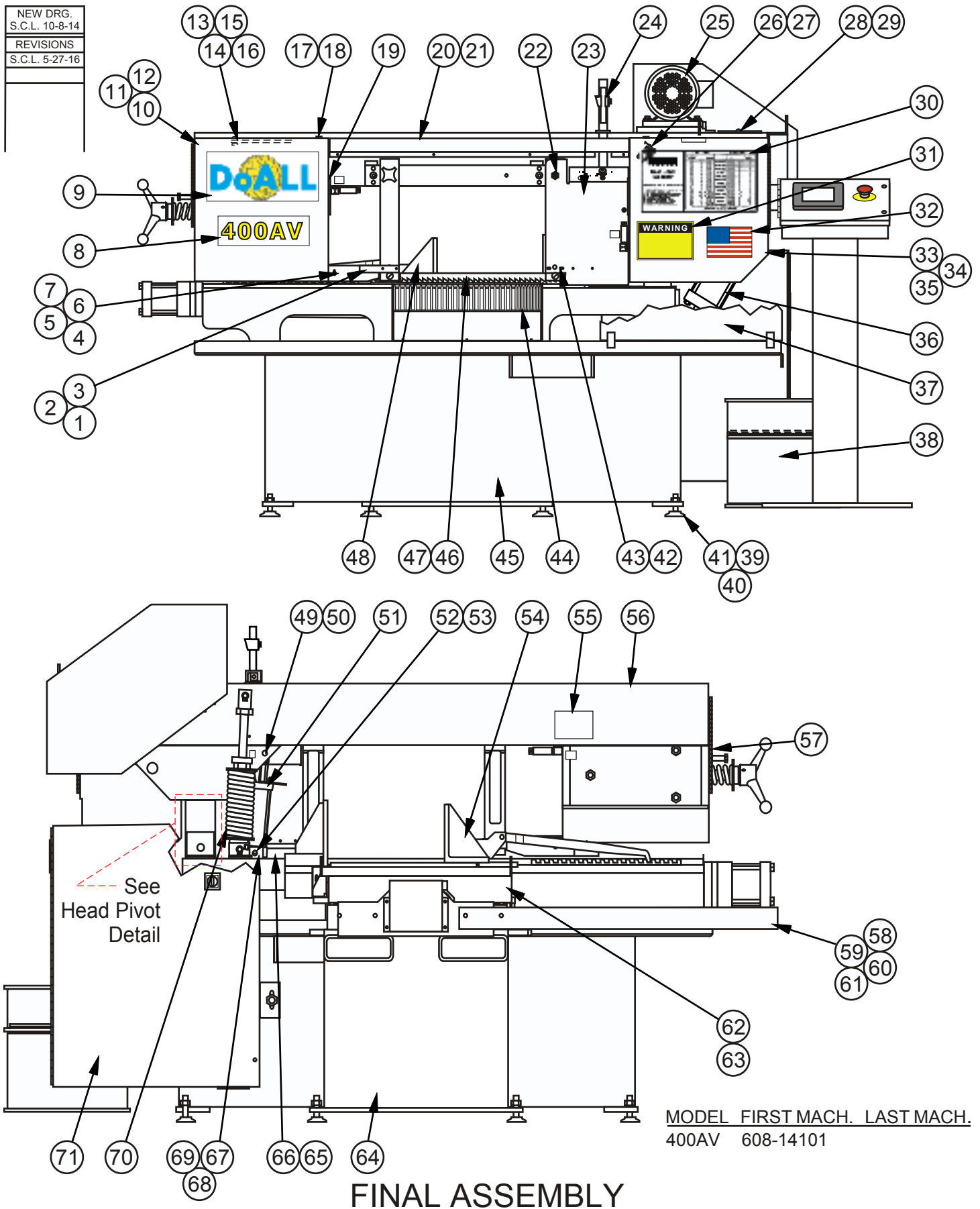
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FINAL ASSEMBLY

FINAL ASSEMBLY

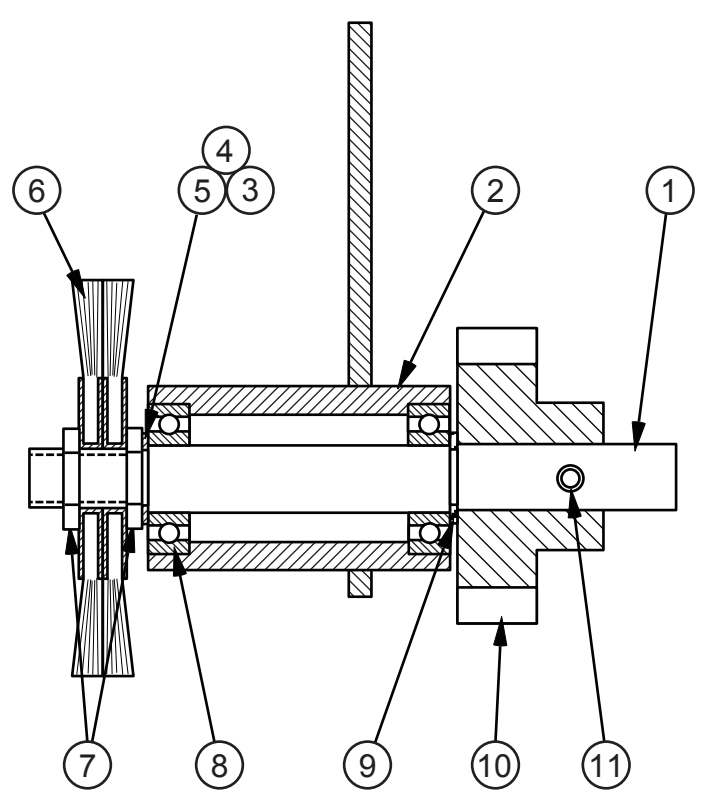
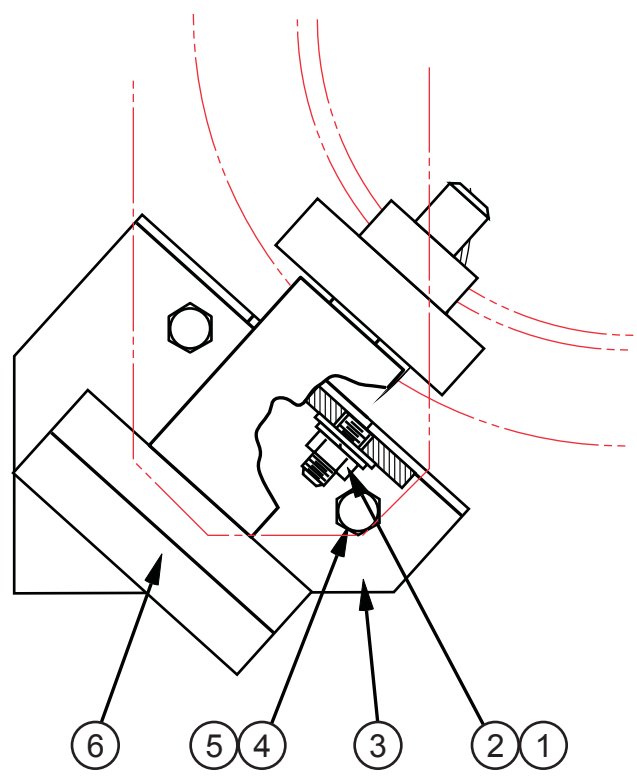
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Final Assembly		51	1013500	. Head Feed Control Assembly (See Detail)	1
1	320595	. L.H. Blade Guard Weldment	1	52	1008305	. Pin	1
2	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2	53	35-006426	. Retaining Ring	2
3	199258	. Washer, Flat #10 S.A.E. Std.	2	54	6000225	. Index Vise Assembly (See Detail)	1
4	1008854	. Shield	1	55	1012541	. Label (Machine Data)	2
5	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2	56	1014426	. Head Assembly (See Detail)	1
6	199258	. Washer, Flat #10 S.A.E. Std.	2	57	176072	. Escutcheon (Band Tension)	1
7	199530	. Nut, Hex. Self-Locking M5-0.8	2	58	226555	. Index Guard	1
8	1008682	. Decal (400AV)	1	59	199926	. Screw, Soc. Hd. Cap M8-1.25 x 25	4
9	416163	. Label (DoALL)	1	60	199941	. Nut, Hex. M8-1.25	4
10	1009128	. L.H. Door Weldment	1	61	199967	. Washer, Flat M8	4
11	199299	. Self Drilling Fastener M4.8 x 13	4		199968	. Washer, Lock M8	4
12	197022	. Nylon Edging	A.R.	62	6000334	. Infeed Work Support Weldment	1
13	175478	. Door Stop	1	63	199923	. Screw, Soc. Hd. Cap M6-1.0 x 10	3
14	199899	. Screw, Button Hd. Soc. M6-1.0 x 16	1	64*	6000303	. Index Table Assembly (See Detail)	1
15	199245	. Locknut M6-1.0	1	65	1009423	. R.H. Band Guard	1
16	199965	. Washer, Flat M6	1	66	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2
17	316583	. Spring Latch (Each Door)	2	67	320619	. Bracket	1
18	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	4	68	198161	. Screw, Hex. Hd. Cap M10-1.5 x 20	2
19	201569	. Pull Pocket	2	79	199346	. Washer, Lock M10	2
20	1008801	. Band Cover Weldment (Standard)	1	70	517499	. Counterbalance Spring Assembly (See Detail)	1
	1008802	. Band Cover Weldment (Mist Lubricator Option)	1	71		. Electrical Assembly (See Detail)	1
21	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	4				
22	199222	. Nut, Hex. Jam M12-1.75	1				
23	1011498	. Panel	1	64	6000226	. Index Table Assembly (See Detail)	1
24	1013087	. Work Height Assembly (See Detail)	1				
25	1009498	. Drive Assembly (See Detail)	1				
26	207716	. Band Wiper Assembly (See Detail)	1				
27	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2				
28	324759	. Bearing Cover	1				
29	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2				
30	1008687	. Saw Band Selector	1				
31	404478	. Escutcheon (Warning)	1				
32	201469	. Decal (American Flag)	1				
33	1009124	. R.H. Door Weldment	1				
34	199299	. Self Drilling Fastener M4.8 x 13	4				
35	197022	. Nylon Edging	A.R.				
36		. Pneumatic Assembly (See Detail)	1				
37	1011010	. Front Spalsh Guard Weldment	1				
38	1008849	. Flood Coolant Assembly (See Detail)	1				
	214935	. Mist Lubricator Assembly (Optional) (See Detail)	1				
	1008850	. Flood Coolant/Mist Lubricator Assembly (Optional) (See Detail)	1				
39	012420	. Foot Casting	4				
40	199253	. Screw, Hex. Hd. Cap M16-2.0 x 70	4				
41	199955	. Nut, Hex. Jam M16-2.0	4				
42	199974	. Screw, Button Hd. Soc. M5 x 0.8 x 10	2				
43	199258	. Washer, Flat #10 Std. S.A.E.	2				
44	1011185	. Discharge Chute Weldmwent	1				
45	6000057	. Base Weldment	1				
46	209790	. Saw Band (Imperial Bi-Metal Super Silencer)	1				
47	304525	. Saw Band Tag	1				
48		. Front Vise Detail (See Detail)	1				
49	175144	. Pin	1				
50	35-006426	. Retaining Ring	2				

*NOTE: Before Serial #608-15104:

Following Not Shown:

406872	. Instruction Tag	1
206698	. CE Label (Europa Only)	1
1012466	. Shipping Pallet and Hardware	1
416770	. Shipping Bracket	1
227399	. Documentation CD	1
207510	. Box of Extra Parts	1
207513	. Hex. Key (10 mm)	1
199246	. Screw, Button Hd. Soc. M6-1.0 x 12 (For Wear Plate When Shipping Bracket is Removed)	2

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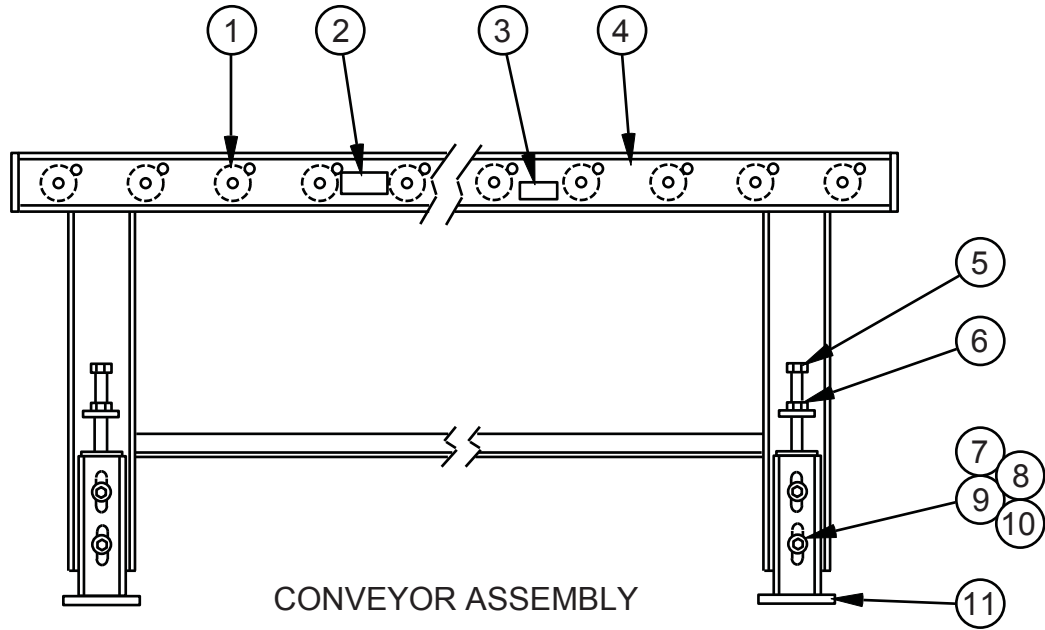
MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	
400AV	608-14101	

BAND BRUSH ASSEMBLY

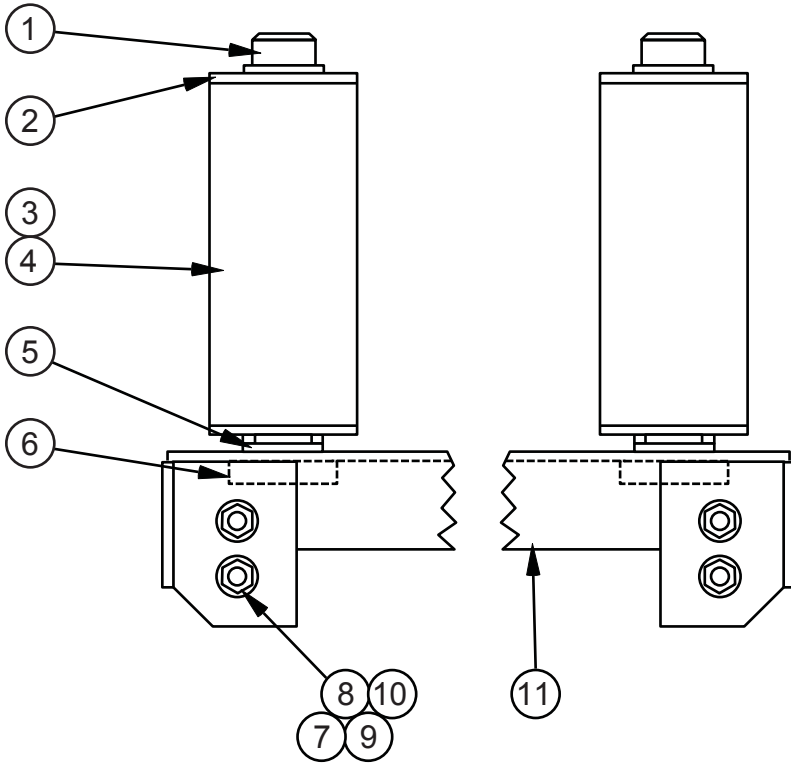
BAND BRUSH ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	417836M	Band Brush Assembly (Powered)	
1	199188	. Nut, Hex. M6-1.0	2
2	199579	. Washer, Flat M6 Wrought	4
3	320802	. Bracket Weldment	1
4	199899	. Screw, Button Hd. Soc. M6-1.0 x 16	2
5	199347	. Washer, Lock M6	4
6	320800	. Band Brush Assembly (See Detail)	1
Ref.	320800	. Band Brush Assembly	
1	209672	.. Shaft	1
2	320799	.. Bracket Weldment	1
3	208826	.. Retaining Ring	1
4	133470	.. Spacer (.0149)	A.R.
5	133471	.. Spacer (.0299)	A.R.
6	010983	.. Wire Brush	2
7	199222	.. Nut, Hex. Jam M12-1.75	2
8	207462	.. Bearing	2
9	35-009613	.. Retaining Ring (If Supplied)	1
10	320801	.. Pinion	1
11	004260	.. Spring Pin	1

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CONVEYOR ASSEMBLY



VERTICAL GUIDE ROLLER ASSEMBLY

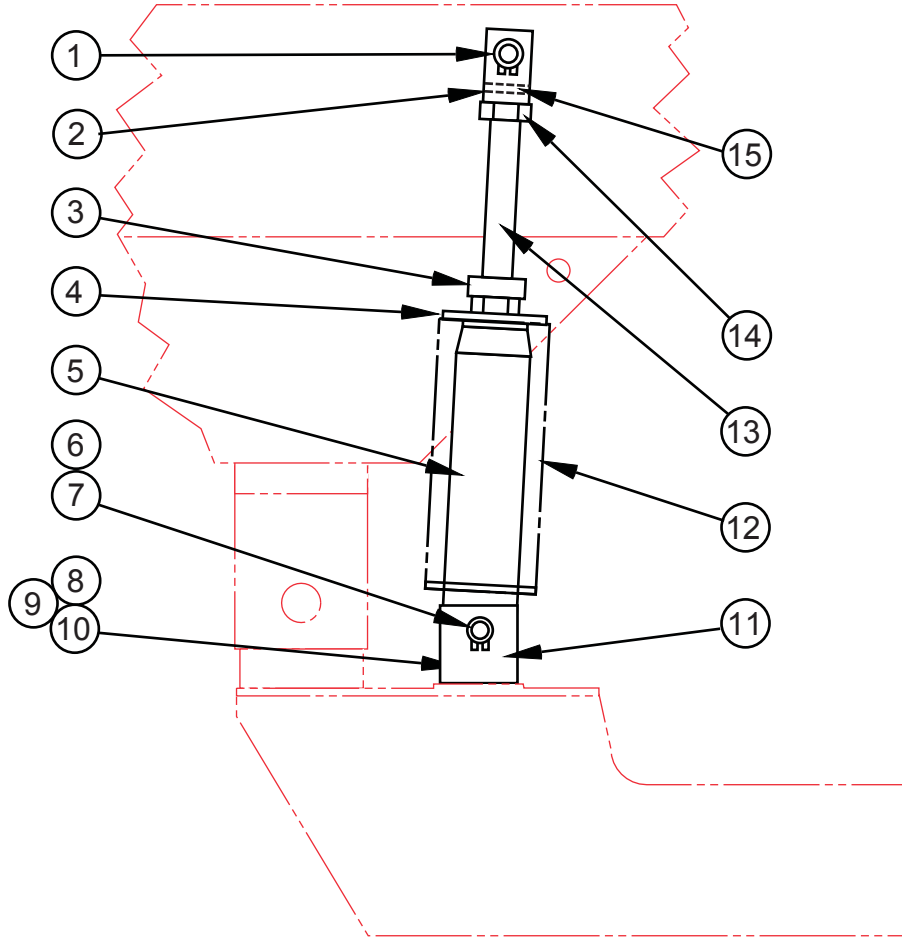
MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	
400AV	608-14101	

CONVEYOR ASSEMBLY (AND RELATED ITEMS)

CONVEYOR ASSEMBLY
(And Related Items)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	207709	5' Conveyor Assembly	
1	202786	. Roller	5
2	203025	. Label (DoALL Logo)	2
3	203035	. Label (Conveyor Capacity)	2
4	517488	. Frame Weldment	1
5	199288	. Screw, Hex. Hd. Cap M12-1.75 x 150	4
6	199933	. Nut, Hex. M12-1.75	4
7	199581	. Screw, Hex. Hd. Cap M12-1.75 x 35	8
8	199289	. Washer, Flat M12 Wrought	16
9	199345	. Washer, Lock M12	8
10	199933	. Nut, Hex. M12-1.75	8
11	417100	. Foot Weldment	4
Ref.	207710	10' Conveyor Assembly	
1	202786	. Roller	10
2	203025	. Label (DoALL Logo)	2
3	203035	. Label (Conveyor Capacity)	2
4	517489	. Frame Weldment	1
5	199288	. Screw, Hex. Hd. Cap M12-1.75 x 150	6
6	199933	. Nut, Hex. M12-1.75	6
7	199581	. Screw, Hex. Hd. Cap M12-1.75 x 35	12
8	199289	. Washer, Flat M12 Wrought	24
9	199345	. Washer, Lock M12	12
10	199933	. Nut, Hex. M12-1.75	12
11	417100	. Foot Weldment	6
		Optional Filler Plates (Not Shown):	
	217236	. Filler Plate (6.97 Long) (Optional)	1
	217233	. Filler Plate (9.25 Long) (Optional).....	A.R.
Ref.	517268	Vertical Guide Roller Assembly	
1	199295	. Screw, Hex. Hd. Cap M16-2.0 x 220	2
2	850900	. Roller End Bearing	4
3	206750	. Roller	2
4	206861	. Roller Shaft	2
5	199296	. Clevis Pin Washer	2
6	206893	. Square Nut M16-2.0	2
7	199975	. Screw, Hex. Hd. Cap M10-1.5 x 35	8
8	199346	. Washer, Lock M10	8
9	198976	. Washer, Flat M10	16
10	199939	. Nut, Hex. M10-1.5	8
11	516029	. Base Weldment	8

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MODEL 400S SHOWN.

MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	
400AV	608-14101	

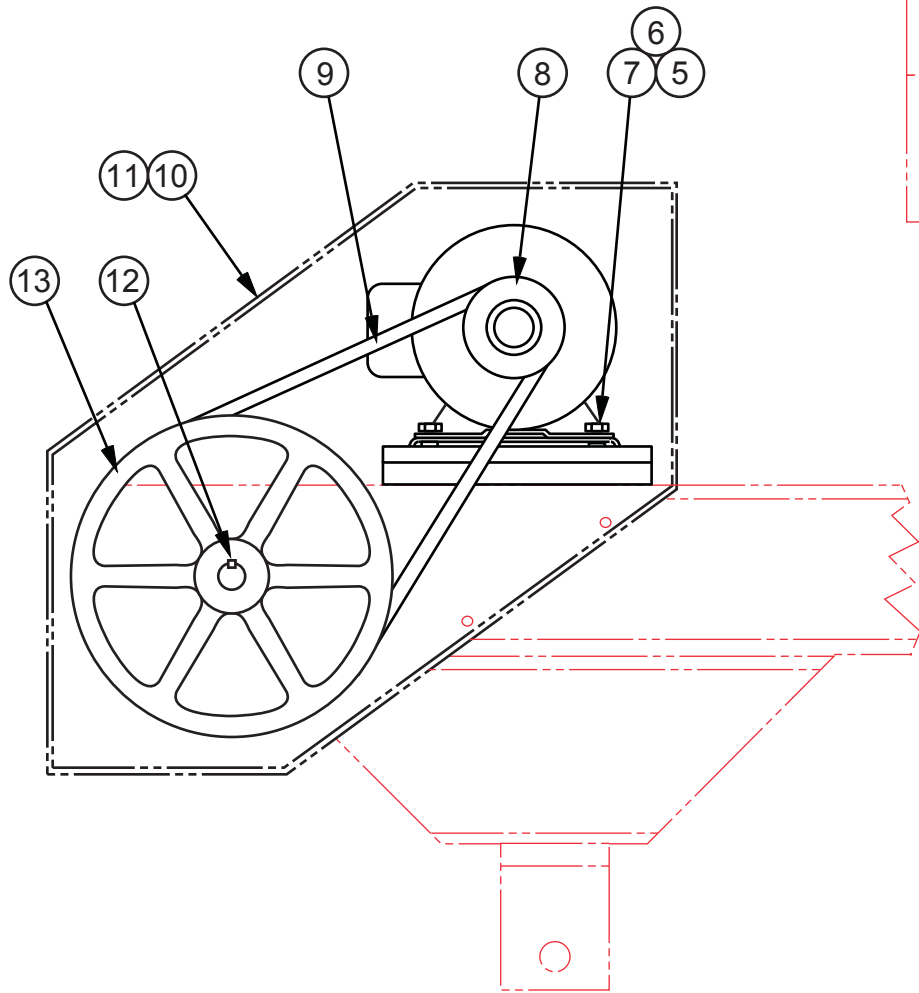
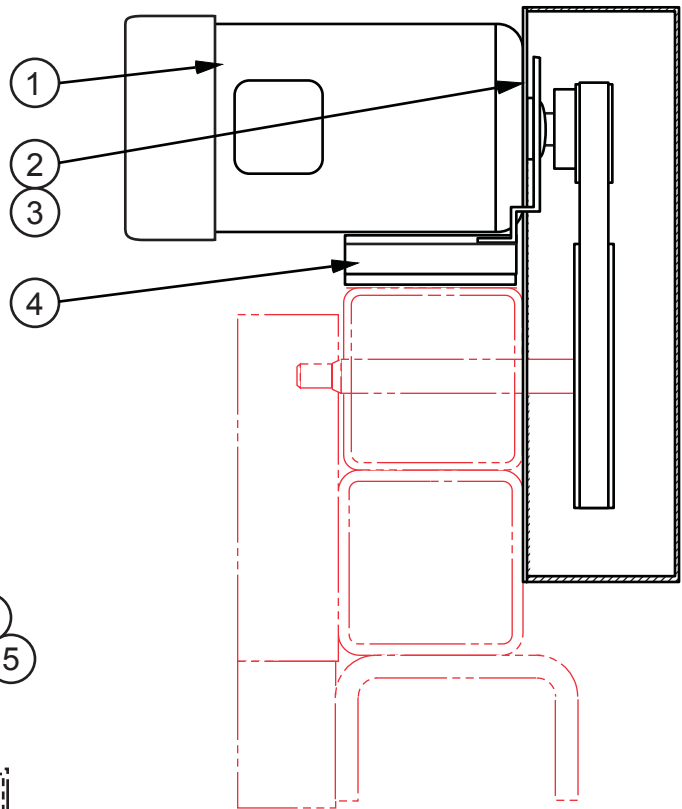
COUNTERBALANCE SPRING ASSEMBLY

COUNTERBALANCE SPRING ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	517499	Counterbalance Spring Assembly	
1	35-008688	. Retaining Ring	1
2*	178683	. Clevis	1
3*	201366	. Shaft Collar	1
4	179576	. Top Washer	1
5	318126	. Rod Guide Weldment	1
6	179579	. Pin	1
7	35-009613	. Retaining Ring	2
8	198161	. Screw, Hex. Hd. Cap M10-1.5 x 20	2
9	199346	. Washer, Lock M10	2
10	198976	. Washer, Flat M10	2
11	318127	. Bracket	1
12	178236	. Compression Spring	1
13*	179577	. Threaded Rod 3/4-10NC x 13-1/2	1
14*	199140	. Nut, Hex. Jam 3/4-10NC	2
15*	004261	. Spring Pin	1

*NOTE: Marked Items are Part of Assembly #326829 - Screw and Lug Assembly.

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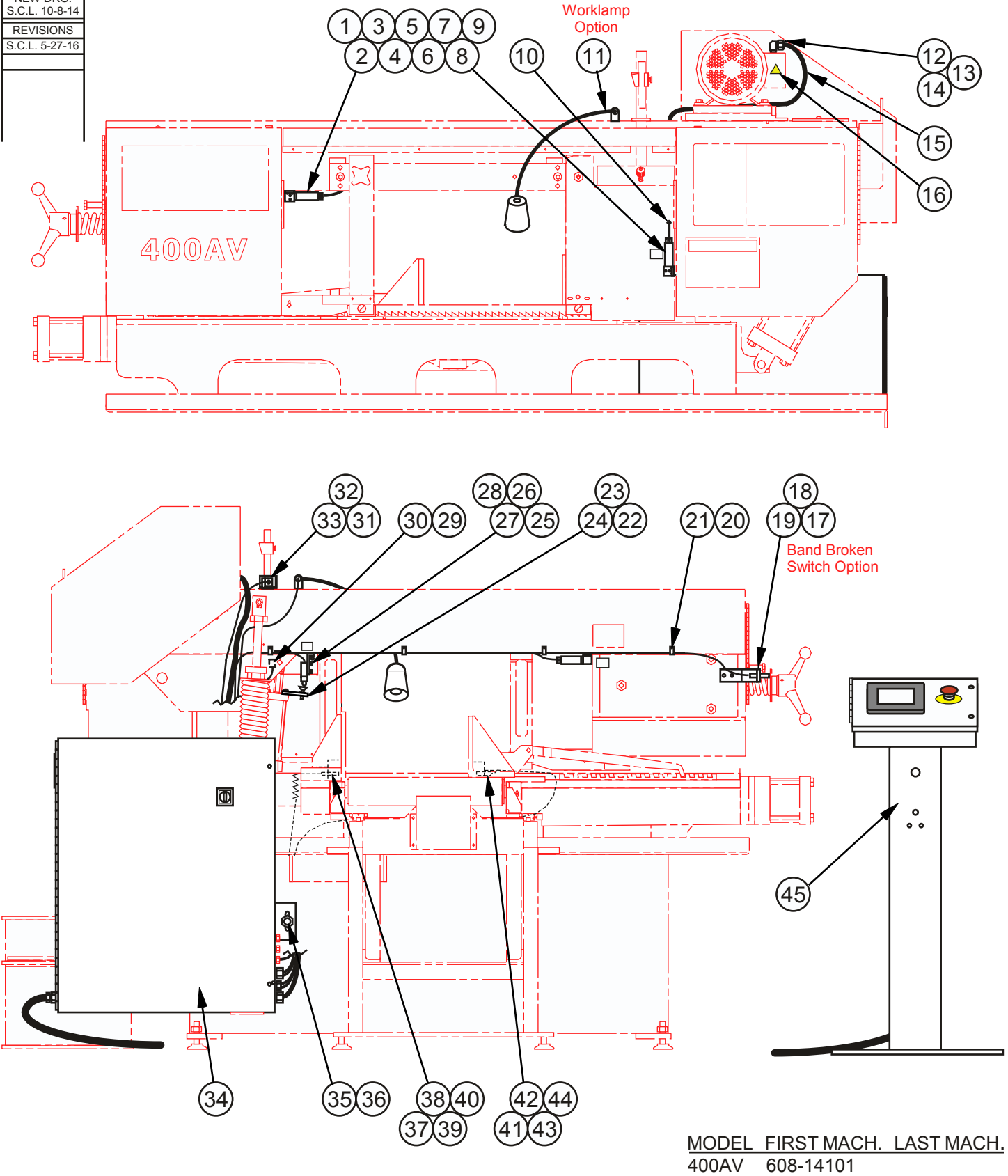
MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400AV	608-14101	

DRIVE ASSEMBLY

DRIVE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1009493	Drive Assembly	
1	209624	. Electric Motor	1
	209625	. Electric Motor (575V Only)	
2	1009176	. Cover Mounting Plate	1
3	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	4
4	420275	. Motor Mount Weldment	1
5	199239	. Screw, Hex. Hd. Cap M8-1.25 x 20	4
6	199968	. Washer, Lock M8	4
7	198574	. Washer, Flat M8 Wrought	4
8	219095	. Motor Pulley	1
9	209498	. V-Belt	1
10	1009175	. Cover Weldment	1
11	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	6
12	004443	. Key	1
13	1008792	. Spindle Pulley	1

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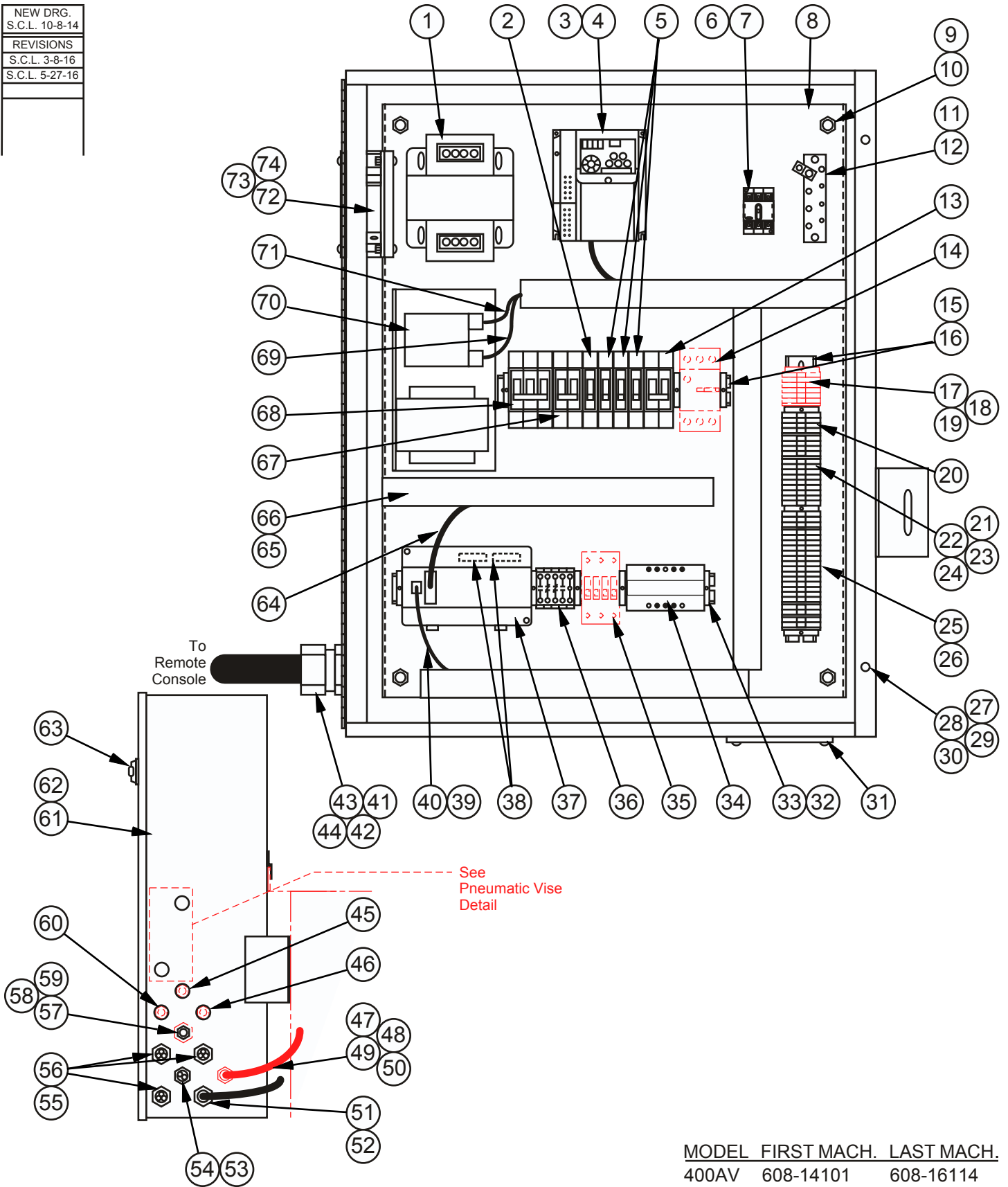


ELECTRICAL ASSEMBLY

ELECTRICAL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Electrical Assembly	
1	215624	. Limit Switch (Door Interlock)	2
2	199389	. Screw, Button Hd. Soc. M4-0.7 x 30	4
3		. Label (Prox. Switch No. - Specify)	2
4	215619	. Cord Grip Connector (.236-.472)	2
5	197332	. Electrical Cord (#18-2 Conductor)	A.R.
6	221855	. Interlock Key Bracket	2
7	199728	. Screw, Button Hd. Soc. M4-0.7 x 10	8
8	199214	. Nut, Hex. M4-0.7	4
9	199248	. Washer, Flat M4	A.R.
10	015780	. Rubber Grommet	1
11	220670	. Worklamp (Optional)	1
12	016160	. 90° Cord Grip Connector	1
13	014480	. Flange Washer	1
14	015607	. Bond Nut	1
15	176528	. Label (Electrical Hazard)	1
16	197218	. Electrical Cord (#14-4 Conductor)	A.R.
	197219	. Electrical Cord (#14-3 Conductor) (Single Phase Motors Only)	A.R.
17	215048	. Proximity Switch (Band Broken)	1
18	220256	. Mounting Bracket	1
19	199243	. Screw, Button Hd. Soc. M5-0.8 x 12	2
20	167329	. Nylon Clamp	4
21	199728	. Screw, Button Hd. Soc. M4-0.7 x 10	4
22	207503	. Actuator Bracket	1
23	207502	. Elevator Bolt M6-1.0 x 25	1
24	199232	. Nut, Hex. Jam M6-1.0	1
25*	176768	. Limit Switch (Head Down)	1
26	199439	. Screw, Button Hd. Soc. M4-0.7 x 25	2
27*	320597	. Bracket	1
28	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2
29	177054	. Solenoid DIN Connector	1
30	197344	. Electrical Cord (#18-3 Conductor)	A.R.
31	1013088	. Bracket	1
32	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2
33	215048	. Proximity Switch (Head Up)	1
34		. Electrical Control Box Assembly (See Detail)	1
35	199819	. Screw, Soc. Hd. Cap M8-1.25 x 16	1
36	199968	. Washer, Lock M8	1
37	226467	. Optical Receiver	1
38	225219	. Quick Disconnect Cable	1
39	227128	. Mounting Bracket	1
40	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	2
41	226466	. Optical Emitter	1
42	225219	. Quick Disconnect Cable	1
43	227103	. Mounting Bracket	1
44	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	2
45		. Remote Console Assembly (See Detail)	1
NOTE: Before Serial #608-15106:			
25	215048	. Proximity Switch (Head Down)	1
27	1014768	. Mounting Bracket	1

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	S.C.L. 5-27-16

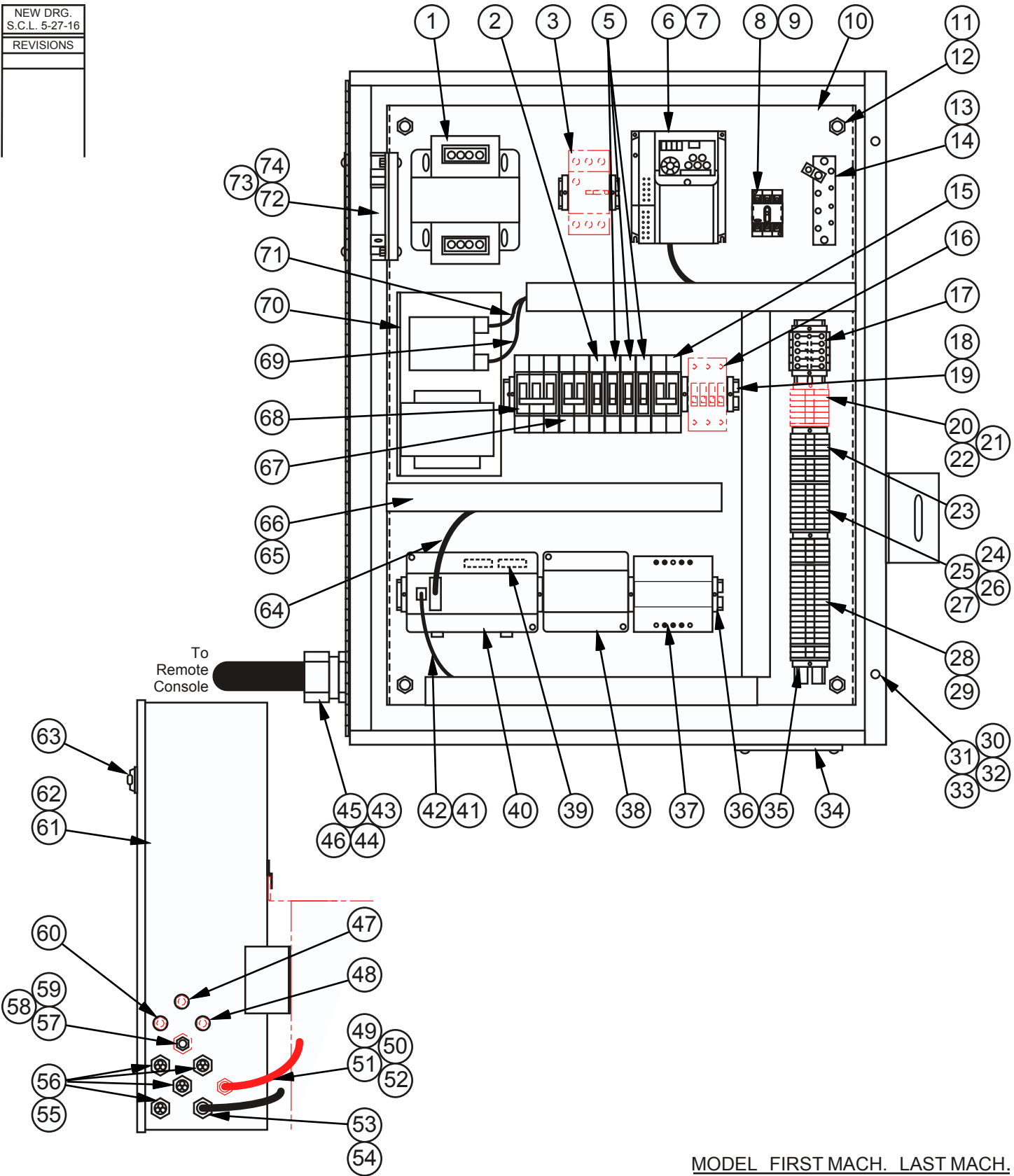


ELECTRICAL CONTROL BOX ASSEMBLY

ELECTRICAL CONTROL BOX ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Electrical Control Box Assembly		51	201687	. Cord Grip Connector (.545-.709)	1
1	320113	. Transformer (208V)	1	52	197218	. Electrical Cord (#14-4 Conductor)	A.R.
	322419	. Transformer (230V, 575V)	1	53	201696	. Cord Grip Connector (.394-.551)	1
	217753	. Transformer (400V)	1	54	1004153	. Cord Grip Connector (2 Hole Insert)	1
	320114	. Transformer (460V)	1	55	201687	. Cord Grip Connector (.545-.709)	3
2	420358	. Circuit Breaker	1	56	1004154	. Cord Grip Connector (3 Hole Insert)	3
3	1009580	. Variable Frequency Drive Module (208V, 230V, 575V)	1	57	201688	. Cord Grip Connector (.200-.394)	1
	1009581	. Variable Frequency Drive Module (400V, 460V)	1		201687	. Cord Grip Connector (.545-.709) (50 Hz Only)	1
4	1007728M	. Cable (#2)	1	58	197322	. Electrical Cord (#18-2 Conductor)	A.R.
5	420356	. Circuit Breaker	3		197218	. Electrical Cord (#14-4 Conductor) (50 Hz Only)	A.R.
6	1007434	. Disconnect Switch	1	59	007635	. Wire Terminal Ring #10 (50 Hz Only) ..	4
7	1007441	. Disconnect Switch Shaft	1	60	135106	. Hole Seal	1
8	226468	. Enclosure Panel	1		201686	. Cord Grip Connector (.157-.314) (Band Broken Switch Option)	1
9	199126	. Nut, Hex. 3/8-16NC	4	61	1014469	. Enclosure Weldment	1
10	199325	. Washer, Lock 3/8 Std.	4	62	203925	. Gasket Strip	A.R.
11	320740	. Grounding Bus	1	63	1007437	. Disconnect Switch Handle	1
12	139194	. Wire Terminal Lug	1	64	1007728M	. Cable (#2)	1
13	1007406	. Circuit Breaker	1	65	197208	. 1" Wiring Channel	A.R.
14	220642	. Motor Starter Protector (50 Hz Only) ...	1	66	197210	. 1" Wiring Channel Cover	A.R.
15	169674	. Mounting Channel	A.R.	67	1007403	. Circuit Breaker (208V, 230V, 575V)	1
16	200618	. End Stop	7		1007400	. Circuit Breaker (400V, 460V)	1
17	200615	. Terminal Block (575V Only)	6	68	1007425	. Circuit Breaker (208V, 230V, 575V)	1
18	200618	. End Stop (575V Only)	1		1007423	. Circuit Breaker (400V)	1
19	200617	. End Section (575V Only)	1		1007422	. Circuit Breaker (460V)	1
20	222284	. Terminal Block (Yellow)	4	69	226325	. Servo Motor I/O Cable (#3)	1
21	200615	. Terminal Block	12	70	226253	. Servo Motor Power Supply	1
22	200617	. End Section	3	71	226326	. Servo Motor Power Cable (#4)	1
23	202922	. Jumper Bar	2	72	208798	. Axial Fan	1
24	1009749	. Terminal Marker Set	1	73	208799	. Fan Cover	2
25	209033	. Terminal Block (Blue)	20	74	208800	. Fan Lead Wire	1
26	209034	. End Section	4				
27	207523	. Screw, Hex. hd. Slotted M6-1.0 x 20 ...	2			Following Not Shown:	
28	204153	. Nylon Washer	2		227219	. CB and MSP Schedule	1
29	204151	. Retaining Ring	2		1003427	. UL/cUL Label	1
30	207525	. Nut Rivet M6-1.0	2		007635	. Wire Terminal Ring #10	6
31	208799	. Fan Cover	1		207111	. Wire Terminal Locking Fork #8	5
32	169674	. Mounting Channel	A.R.		197339	. Wire, #14 Black (19 Strand)	A.R.
33	200618	. End Stop	5		197195	. Wire, #14 Green/Yellow (19 Strand) ...	A.R.
34	322568	. Power Supply	1		197197	. Wire, #16 Red (19 Strand)	A.R.
35	207206	. Contactor (50 Hz Only)	1		197325	. Wire, #16 White (19 Strand)	A.R.
36	207200	. Control Relay	1		197343	. Wire, #16 Green/Yellow (19 Strand)	A.R.
37	228119	. Programmed PLC Unit	1		197205	. Wire, #18 Blue (16 Strand)	A.R.
38	132310	. Resistor (1/4 Watt, 1kOhm)	2		1010770	. Step-Down Transformer (575V Only) ...	1
39	219360	. Ethernet Cable (#1)	1		014504	. 90° Sealtite Connector (575V Only)	1
40	222298	. D-Sub Connector Plug (25 Pin)	1		014411	. Flanged Washer (575V Only)	1
41	014685	. Sealtite Connector	1		005593	. Plastic Insulated Bushing (575V Only)..	1
42	014480	. Flange Washer	1		197156	. Sealtite Conduit 1/2 I.D. (575V Only) ...	A.R.
43	014772	. Plastic Insulated Bushing	1				
44	197158	. Sealtite Conduit 3/4 I.D.	A.R.				
45	135106	. Hole Seal	1				
	201688	. Cord Grip Connector (.200-.394) (Mist Lubricator Option)	1				
46	135106	. Hole Seal	1				
	201688	. Cord Grip Connector (.200-.394) (Worklight Option)	1				
47	014545	. Sealtite Connector (575V Only)	1				
48	014411	. Flanged Washer (575V Only)	1				
49	005593	. Plastic Insulated Bushing (575V Only) .1					
50	197156	. Sealtite Conduit 1/2 I.D. (575V Only) ...	A.R.				

NEW DRG.
S.C.L. 5-27-16
REVISIONS



MODEL FIRST MACH. LAST MACH.
400AV 608-16115

ELECTRICAL CONTROL BOX ASSEMBLY

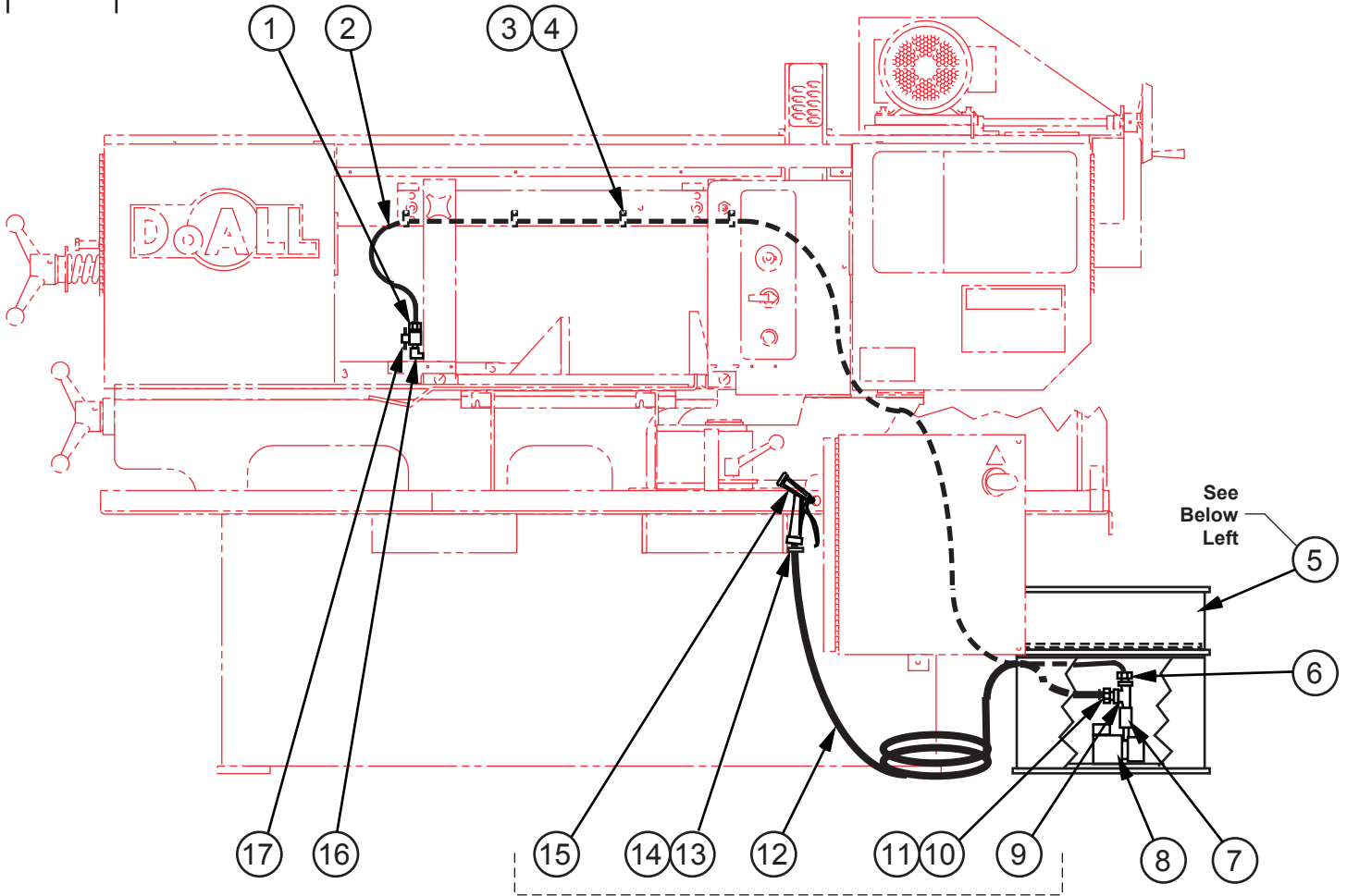
ELECTRICAL CONTROL BOX ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Electrical Control Box Assembly		53	201687	. Cord Grip Connector (.545-.709)	1
1	320113	. Transformer (208V)	1	54	197218	. Electrical Cord (#14-4 Conductor)	A.R.
	322419	. Transformer (230V, 575V)	1	55	201687	. Cord Grip Connector (.545-.709)	4
	217753	. Transformer (400V)	1	56	1004154	. Cord Grip Connector (3 Hole Insert)	4
	320114	. Transformer (460V)	1	57	201688	. Cord Grip Connector (.200-.394)	1
2	420358	. Circuit Breaker	1	201687	. Cord Grip Connector (.545-.709) (50 Hz Only)	1	
3	220642	. Motor Starter Protector (50 Hz Only) ...	1	58	197322	. Electrical Cord (#18-2 Conductor)	A.R.
5	420356	. Circuit Breaker	3	197218	. Electrical Cord (#14-4 Conductor) (50 Hz Only)	A.R.	
6	1009580	. Variable Frequency Drive Module (208V, 230V, 575V)	1	59	007635	. Wire Terminal Ring #10 (50 Hz Only) ..	4
	1009581	. Variable Frequency Drive Module (400V, 460V)	1	60	135106	. Hole Seal	1
7	1007728M	. Cable (#2)	1	201686	. Cord Grip Connector (.157-.314) (Band Broken Switch Option)	1	
8	1007434	. Disconnect Switch	1	61	1014469	. Enclosure Weldment	1
9	1007441	. Disconnect Switch Shaft	1	62	203925	. Gasket Strip	A.R.
10	226468	. Enclosure Panel	1	63	1007437	. Disconnect Switch Handle	1
11	199126	. Nut, Hex. 3/8-16NC	4	64	1007728M	. Cable (#2)	1
12	199325	. Washer, Lock 3/8 Std.	4	65	197208	. 1" Wiring Channel	A.R.
13	320740	. Grounding Bus	1	66	197210	. 1" Wiring Channel Cover	A.R.
14	139194	. Wire Terminal Lug	1	67	1007405	. Circuit Breaker (208V, 230V, 575V)	1
15	1007406	. Circuit Breaker	1	1007400	. Circuit Breaker (400V, 460V)	1	
16	207206	. Contactor (50 Hz Only)	1	68	1007425	. Circuit Breaker (208V, 230V, 575V)	1
17	207200	. Control Relay	1	1007423	. Circuit Breaker (400V)	1	
18	169674	. Mounting Channel	A.R.	1007422	. Circuit Breaker (460V)	1	
19	200618	. End Stop	3	69	226325	. Servo Motor I/O Cable (#3)	1
20	200615	. Terminal Block (575V Only)	6	70	226253	. Servo Motor Power Supply	1
21	200618	. End Stop (575V Only)	1	71	226326	. Servo Motor Power Cable (#4)	1
22	200617	. End Section (575V Only)	1	72	208798	. Axial Fan	1
23	222284	. Terminal Block (Yellow)	4	73	208799	. Fan Cover	2
24	200615	. Terminal Block	12	74	208800	. Fan Lead Wire	1
25	200617	. End Section	3				
26	202922	. Jumper Bar	2				
27	1009749	. Terminal Marker Set	1				
28	209033	. Terminal Block (Blue)	20				
29	209034	. End Section	4				
30	207523	. Screw, Hex. Hd. Slotted M6-1.0 x 20 ...	2				
31	204153	. Nylon Washer	2				
32	204151	. Retaining Ring	2				
33	207525	. Nut Rivet M6-1.0	2				
34	208799	. Fan Cover	1				
35	169674	. Mounting Channel	A.R.				
36	200618	. End Stop	9				
37	322568	. Power Supply	1				
38	1007727	. PLC Expansion Unit	1				
39	132310	. Resistor (1/4 Watt, 1kOhm)	2				
40	228955	. Programmed PLC Unit	1				
41	219360	. Ethernet Cable (#1)	1				
42	222298	. D-Sub Connector Plug (25 Pin)	1				
43	014685	. Sealtite Connector	1				
44	014480	. Flange Washer	1				
45	014772	. Plastic Insulated Bushing	1				
46	197158	. Sealtite Conduit 3/4 I.D.	A.R.				
47	135106	. Hole Seal	1				
	201688	. Cord Grip Connector (.200-.394) (Mist Lubricator Option)	1				
48	135106	. Hole Seal	1				
	201688	. Cord Grip Connector (.200-.394) (Worklight Option)	1				
49	014545	. Sealtite Connector (575V Only)	1				
50	014411	. Flanged Washer (575V Only)	1				
51	005593	. Plastic Insulated Bushing (575V Only) .1	1				
52	197156	. Sealtite Conduit 1/2 I.D. (575V Only) ...	A.R.				

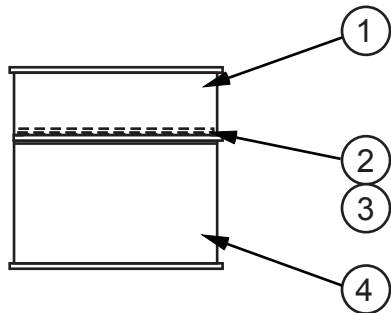
Following Not Shown:

228954	. CB and MSP Schedule	1
1003427	. UL/cUL Label	1
007635	. Wire Terminal Ring #10	6
207111	. Wire Terminal Locking Fork #8	5
197339	. Wire, #14 Black (19 Strand)	A.R.
197195	. Wire, #14 Green/Yellow (19 Strand)	A.R.
197197	. Wire, #16 Red (19 Strand)	A.R.
197325	. Wire, #16 White (19 Strand)	A.R.
197343	. Wire, #16 Green/Yellow (19 Strand)	A.R.
197205	. Wire, #18 Blue (16 Strand)	A.R.
1010770	. Step-Down Transformer (575V Only) ...	1
014504	. 90° Sealtite Connector (575V Only)	1
014411	. Flanged Washer (575V Only)	1
005593	. Plastic Insulated Bushing (575V Only)..	1
197156	. Sealtite Conduit 1/2 I.D. (575V Only) ...	A.R.

NEW DRG.
S.C.L. 3-22-10
REVISIONS
S.C.L. 10-8-14



FLUSHING HOSE ASSEMBLY
(OPTIONAL - 400M, 400S; STANDARD - 400A)



COOLANT RESERVOIR ASSEMBLY

MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	
400AV	608-14101	

FLOOD COOLANT ASSEMBLY

FLOOD COOLANT ASSEMBLY

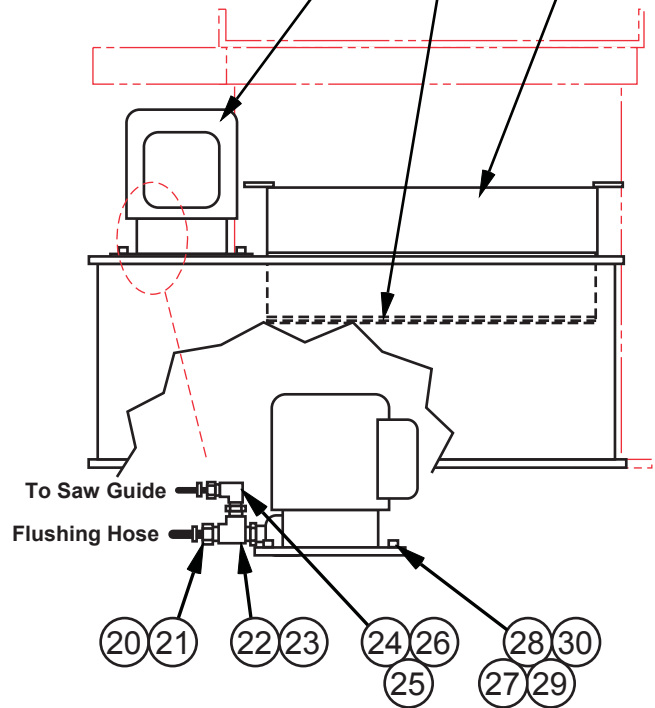
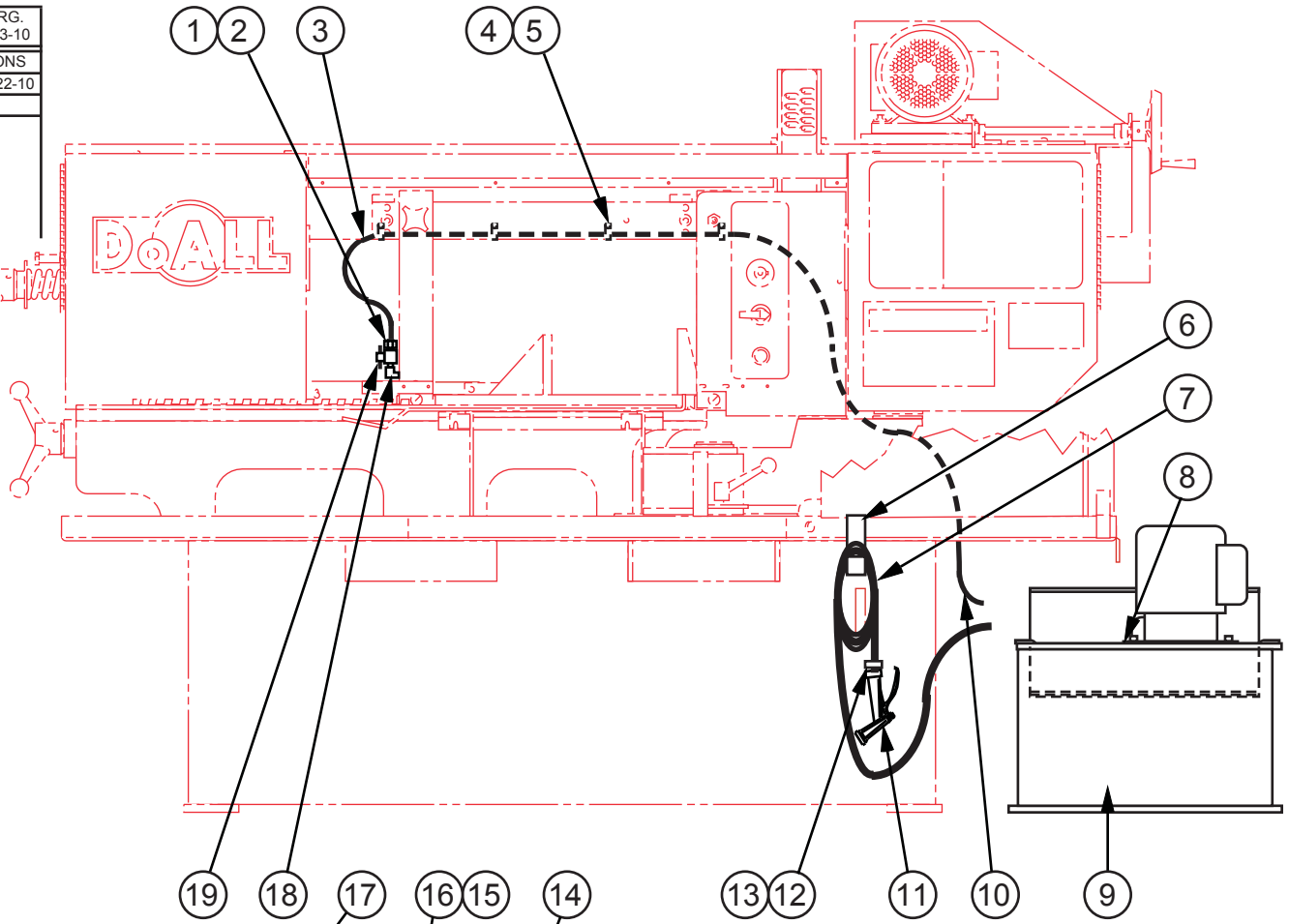
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1008849	Flood Coolant Assembly	
1	016001	. Barbed Insert	1
2	197144	. Plastic Tubing 1/4 I.D. (Clear)	A.R.
3	009955	. Tubing Clamp.....	A.R.
4	199974	. Screw, Button Hd. Soc.M5-0.8 x 10	A.R.
5	1007881	. Coolant Reservoir Assembly (See Detail)	1
6	103316	. Barbed Insert	1
7	204233	. Pipe Coupling (Brass)	1
8	110263	. Coolant Pump (110/120V, 50/60 Hz)	1
	136530	. Coolant Pump (220/240V, 50/60 Hz)	1
	172623	. Coolant Pump (CSA Approved)	1
9*	120857	. Service Tee (Brass)	1
10*	002004	. Barbed Insert	1
11*	017902	. Hose Clamp	1
12*	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
13*	176816	. Barbed Insert (Plastic)	1
14*	176827	. Hose Clamp	1
15*	176420	. Hoze Nozzle	1
16	5-027506	. 90° Street Elbow (Brass)	1
17	120241	. Valve	1

*NOTE: Part of Flushing Hose Assembly - #178639. (This Is Optional On 400M, 400S; Standard On 400A, 400AV)

Ref.	1007881	. Coolant Reservoir Assembly	
1	1007898	. . Chip Container	1
2	1007883	. . Screen/Filter Cover	1
3	1007882	. . Screen/Filter	1
4	1008539	. . Coolant Reservoir	1

Following Not Shown:
 214769 . Cutting Fluid (Power-Cut Concentrate; 1 Quart) 1

NEW DRG.
S.C.L. 6-3-10
REVISIONS
S.C.L. 2-22-10



MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-11186	
400S	597-11151	
400AV	608-14101	

FLOOD COOLANT ASSEMBLY (EUROPA ONLY)

**FLOOD COOLANT ASSEMBLY
(Europa Only)**

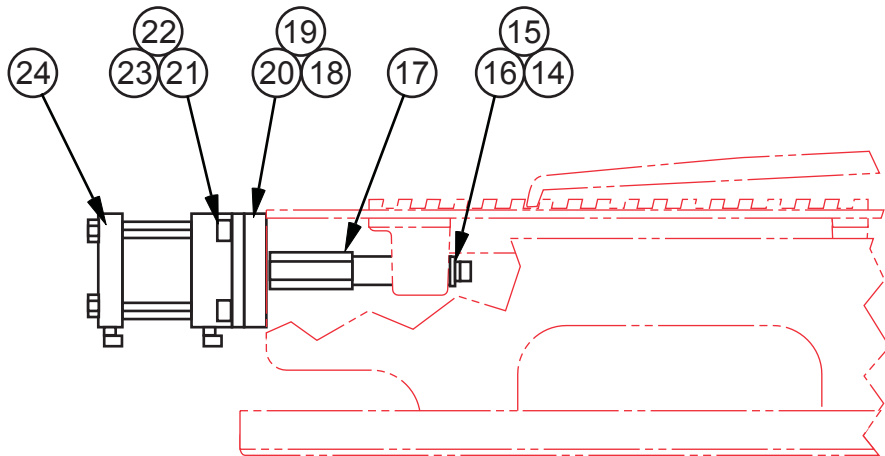
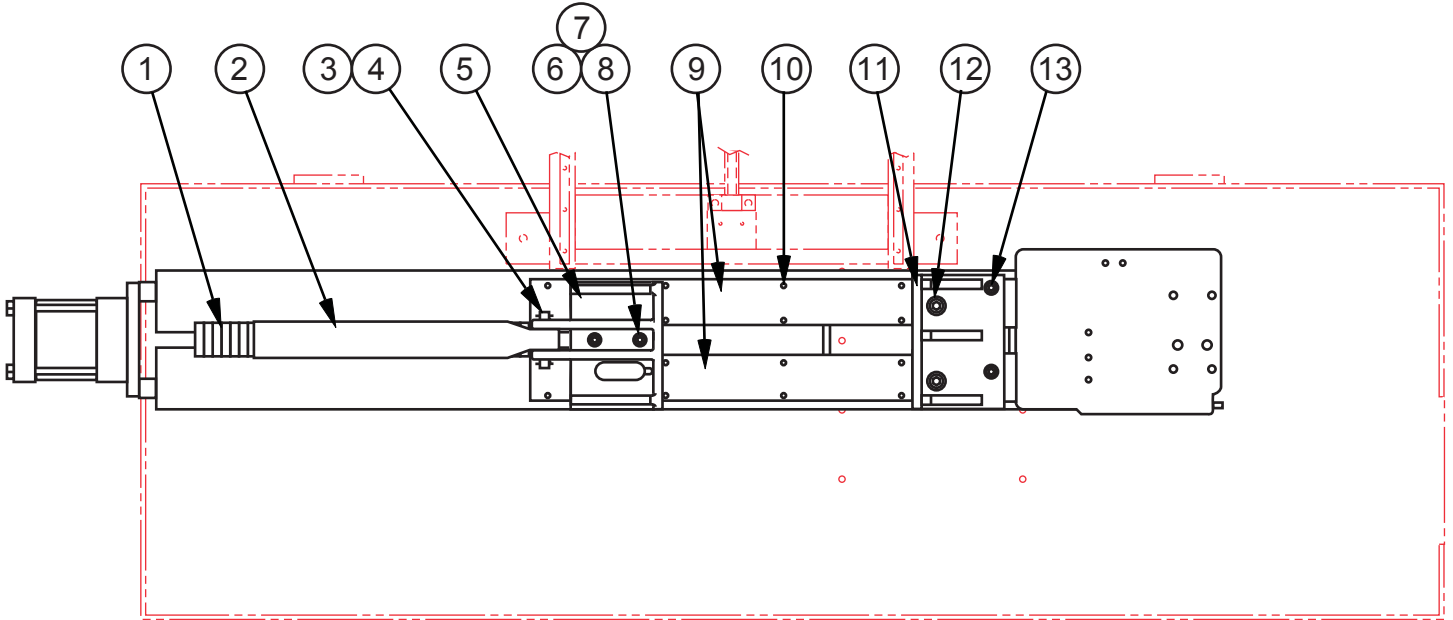
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1012934	Flood Coolant Assembly (Europa Only)	
1	016001	. Barbed Insert	1
2	1008570	. Hose Clamp	1
3	197095	. Plastic Tubing 1/4 I.D. (Clear-Reinforced)	A.R.
4	009955	. Tubing Clamp.....	A.R.
5	199974	. Screw, Button Hd. Soc.M5-0.8 x 10	A.R.
6*	316116	. Hook	1
7*	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
8	1012942	. Pump Mounting Plate	1
9	1007897	. Coolant Reservoir	1
10	197095	. Plastic Tubing 1/4 I.D. (Clear-Reinforced)	A.R.
11*	176420	. Hoze Nozzle	1
12*	176816	. Barbed Insert (Plastic)	1
13*	176827	. Hose Clamp	1
14	1011897	. Chip Container Weldment	1
15	1011859	. Screen/Filter Cover	1
16	1011858	. Screen/Filter	1
17	224711	. Coolant Pump (50 Hz)	1
18	5-027506	. 90° Street Elbow (Brass)	1
19	120241	. Shut-Off Valve	1
20	009667	. Barbed Insert	1
21	176827	. Hose Clamp	1
22	133540	. Service Tee	1
23	017535	. Reducer Bushing	1
24	017537	. Reducer Bushing	1
25	133439	. 90° Barbed Insert	1
26	1008570	. Hose Clamp	1
27	199993	. Screw, Soc. Hd. Cap M6-1.0 x 20	4
28	199347	. Washer, Lock M6	4
29	199965	. Washer, Flat M6	4
30	199188	. Nut, Hex. M6-1.0	4

*NOTE: Part of Optional Flushing Hose Assembly - #178639.

Following Not Shown:

214769	. Cutting Fluid (Power-Cut Concentrate; 1 Quart)	2
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NEW DRG. S.C.L. 10-8-14
REVISIONS



MODEL FIRST MACH. LAST MACH.
400AV 608-14101

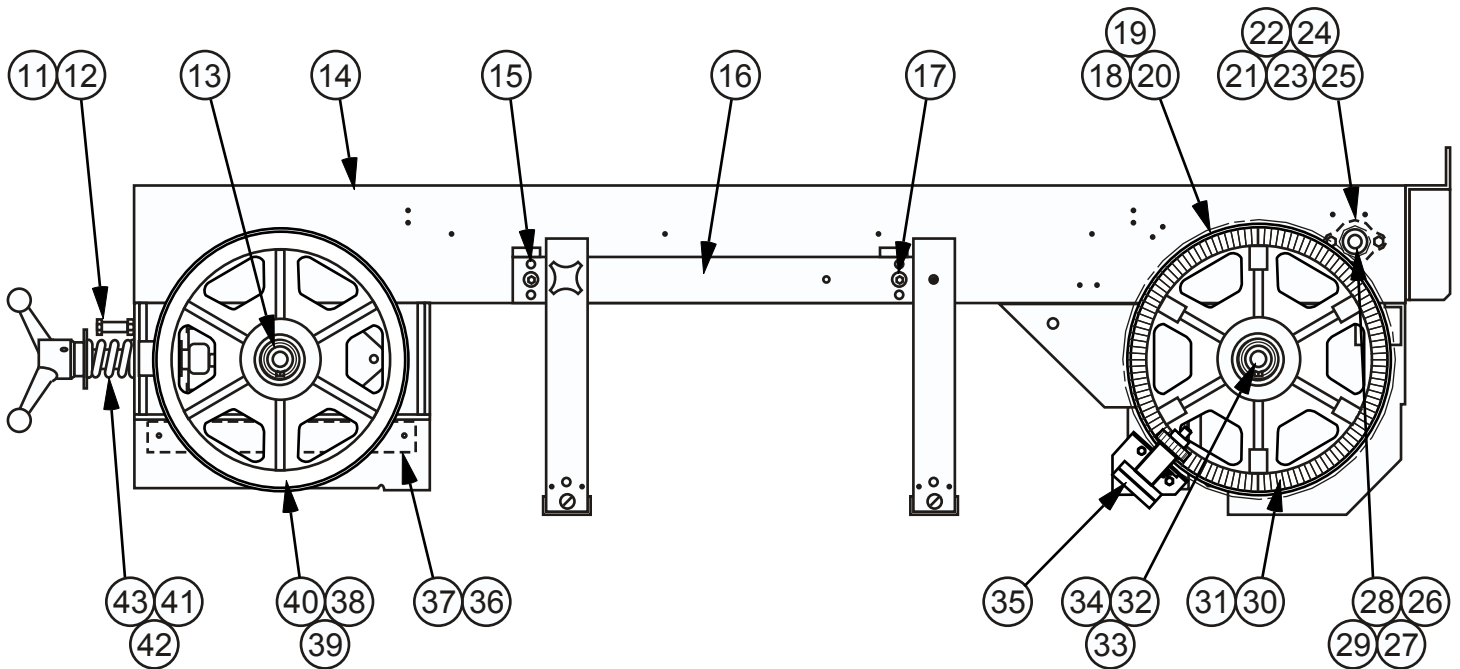
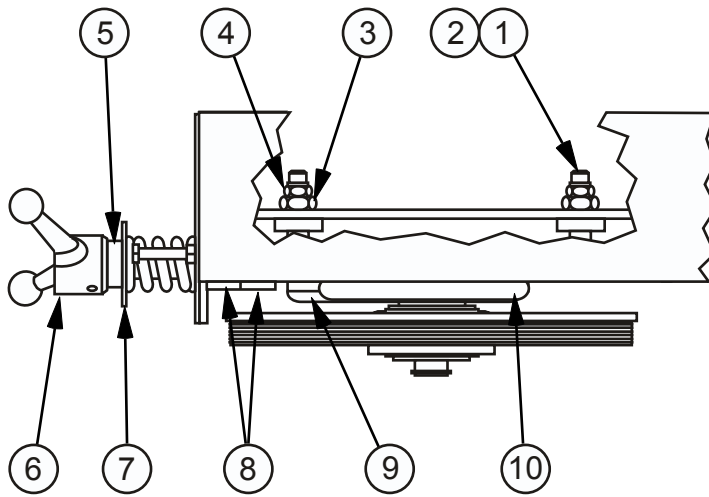
FRONT VISE DETAIL

PS - 3 - 306

FRONT VISE DETAIL

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
		Front Vise Detail	
1	1008176	. Rack	1
2	314884	. Pawl	1
3	179579	. Pin	1
4	35-009613	. Retaining Ring	2
5	226455	. Movable Jaw	1
6	226121	. Nut Tee (M10-1.5).....	2
7	199919	. Screw, Soc. Hd. Cap M10-1.5 x 35	2
8	199346	. Washer, Lock M10	2
9	1008175	. Wear Plate	2
10	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	16
11	6000227	. Fixed Vise Jaw Weldment	1
12	199978	. Screw, Soc. Hd. Cap M16-2.0 x 55	2
13	199904	. Screw, Soc. Hd. Cap M12-1.75 x 40	2
14	199051	. Screw, Soc. Hd. Cap M6-1.0 x 12	1
15	199254	. Washer, Lock M6 Hi-Collar	1
16	109993	. Washer	1
17	1008204	. Cylinder Adaptor	1
18	1008209	. Spacer	2
19	199911	. Screw, Soc. Hd. Cap M10-1.5 x 40	4
20	199346	. Washer, Lock M10	4
21	199911	. Screw, Soc. Hd. Cap M10-1.5 x 40	4
22	199346	. Washer, Lock M10	4
23	198976	. Washer, Flat M10	4
24	318130	. Pneumatic Vise Clamp Cylinder	1

NEW DRG.
S.C.L. 2-22-10
REVISIONS
S.C.L. 3-10-14
S.C.L. 10-8-14



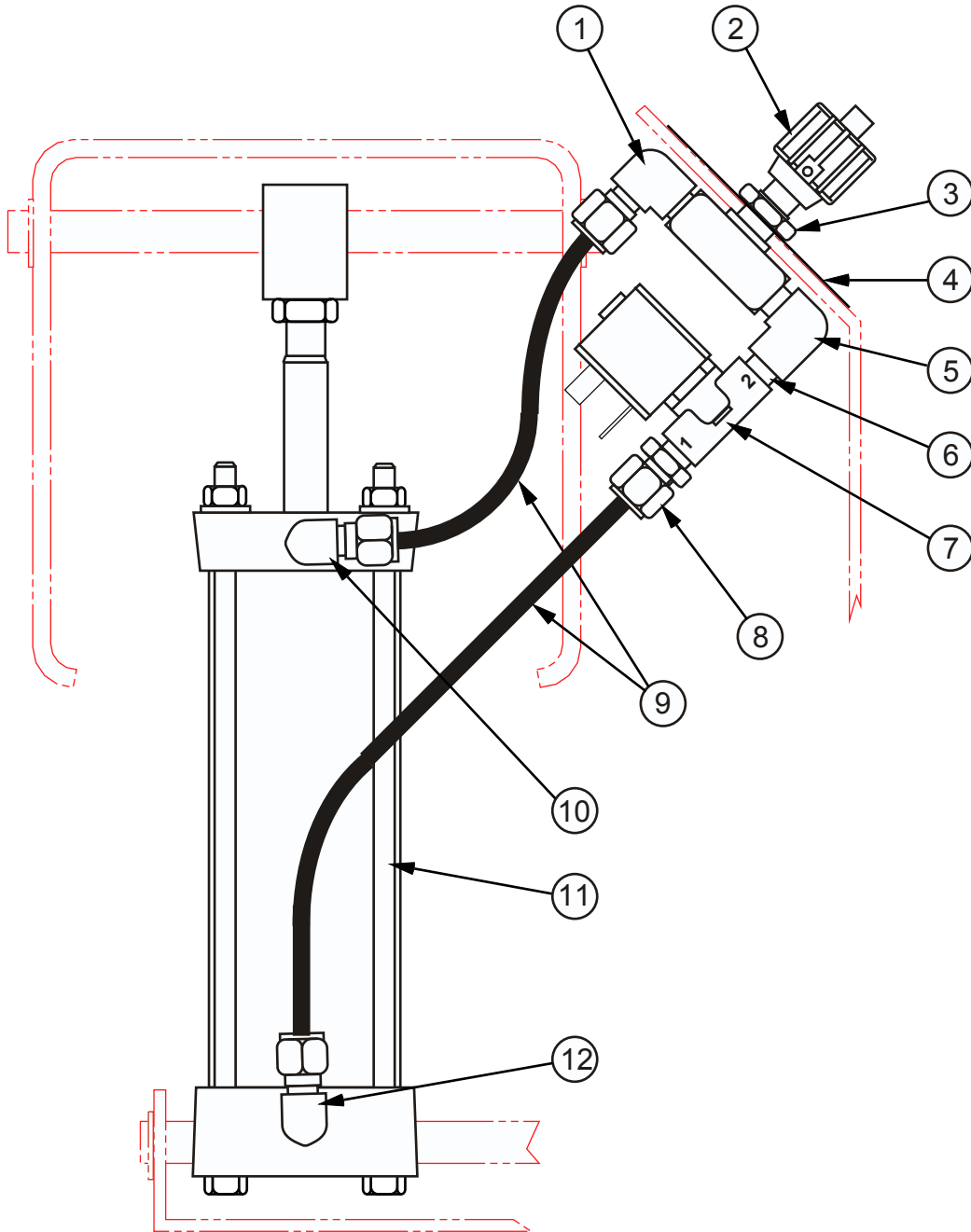
MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	
400AV	608-14101	

HEAD ASSEMBLY

HEAD ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
		Head Assembly	
1	199980	. Screw, Soc. Hd. Cap M10-1.5 x 80	3
2	199346	. Washer, Lock M10	3
3	199142	. Nut, Hex. Jam 3/4-16NF	3
4	005956	. Adjusting Screw 3/4-16NF x 2-5/16 (.42 Dia.)	3
5	108749	. Thrust Ball Bearing	1
6	1008019	. Band Tension Handle Assembly	1
	1008020	. . Handle	1
	1009977	. . Bandwheel Screw	1
	004275	. . Spring Pin	1
7	204138	. Washer	1
8	157703	. Rubber Bushing	2
9	513889	. Head Slide and Shaft Sub-Assembly	1
	316591	. . Idler Shaft	1
	199227	. . Screw, Soc. Set M10-1.5 x 16 (Cone Point)	1
	202383	. . Loctite Adhesive (#242)	A.R.
10	517542	. Head Casting	1
11	199238	. Screw, Hex. Hd. Cap M10-1.5 x 60	1
12	199939	. Nut, Hex. M10-1.5	1
13	204455	. Retaining Ring	1
14	1009195	. Head Weldment	1
15	199559	. Screw, Soc. Set M12-1.75 x 25 (Fine Thread)	4
16		. Saw Guide Arm Assembly (See Detail)	1
17	199918	. Screw, Soc. Hd. Cap M12-1.75 x 45	2
18	317088	. Bandwheel Assembly (Driver)	1
	505879	. . Bandwheel (Driver)	1
	137905	. . Ball Bearing	2
19	122652	. Shim (.010)	A.R.
20	122653	. Shim (.020)	A.R.
21	1008462	. Flange Bearing	2
22	198167	. Screw, Hex. Hd. Cap M8-1.25 x 40	2
23	199968	. Washer, Lock M8	2
24	199941	. Nut, Hex. M8 x 1.25	2
25	199967	. Washer, Flat M8	2
26	132475	. Pinion Gear	1
27	35-008688	. Retaining Ring	1
28	1008794	. Pinion Shaft	1
29	014214	. Key	1
30	1009188	. Door Support	1
31	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	5
32	320598	. Drive Shaft	1
33	199251	. Screw, Soc. Set M10-1.5 x 12 (Cone Point)	1
34	204455	. Retaining Ring	1
35	417836M	. Band Brush Assembly (Powered) (See Detail)	1
36	206885	. Bar (If Supplied)	1
37	199041	. Screw, Soc. Hd. Cap M5-0.8 x 20 (If Supplied)	2
38	176858	. Bandwheel Assembly (Idler)	1
	503489	. . Bandwheel (Idler)	1
	137905	. . Ball Bearing	2
39	122652	. Shim (.010)	A.R.
40	122653	. Shim (.020)	A.R.
41	108750	. Compression Spring	1
42	108748	. Tube	1
43	199306	. Washer, Flat 3/4 Wrought	1

NEW DRG. S.C.L. 7-22-11
REVISIONS
S.C.L. 10-8-14
S.C.L. 5-27-16



MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400AV	608-14101	

HEAD FEED CONTROL ASSEMBLY

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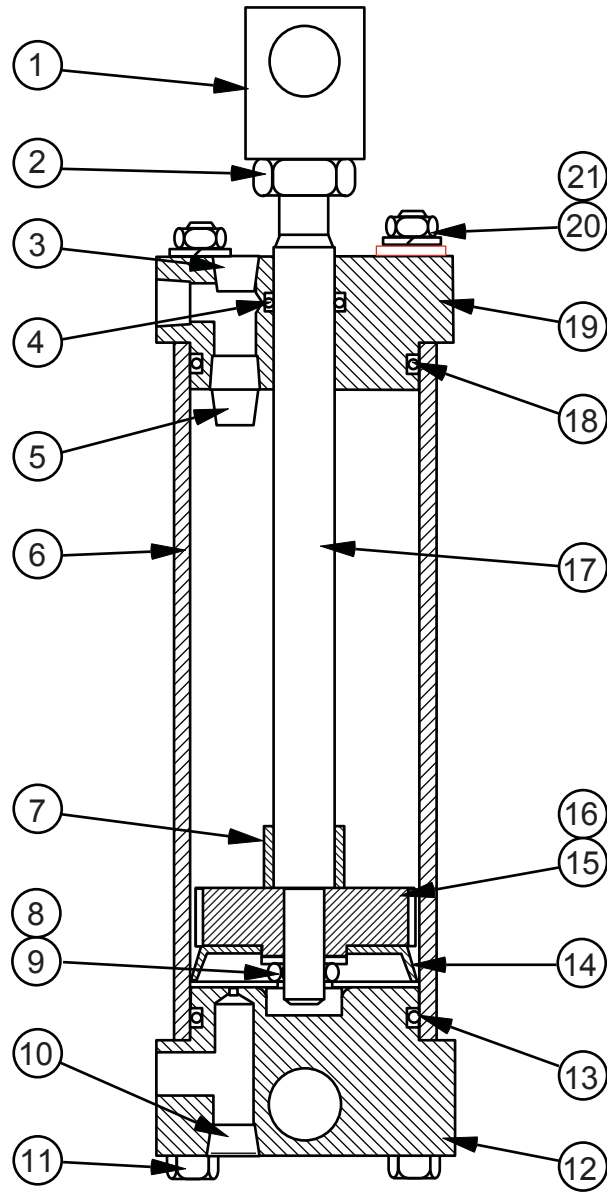
HEAD FEED CONTROL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1013500	Head Feed Control Assembly	
1	6-023510	. 90° Male Elbow (Brass)	1
2	201987	. Needle Valve	1
3	199134	. Nut, Hex. Jam 1/2-20NF	1
4	1011181	. Escutcheon	1
5	5-027506	. 90° Street Elbow	1
6	14-014528	. Close Nipple	1
7	224061	. Solenoid Valve (2-Way)	1
8	6-023509	. Male Connector (Brass)	1
9	197264	. Nylon Tubing 1/4 O.D.	A.R.
10	6-023510	. 90° Male Elbow (Brass)	1
11	416087	. Head Feed Cylinder Assembly (See Detail)	1
12	6-023510	. 90° Male Elbow (Brass)	1

Following Not Shown:

201030	. Transmission Fluid (ATF)	A.R.
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NEW DRG. S.C.L. 3-22-10
REVISIONS
S.C.L. 10-8-14



MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	
400AV	608-14101	

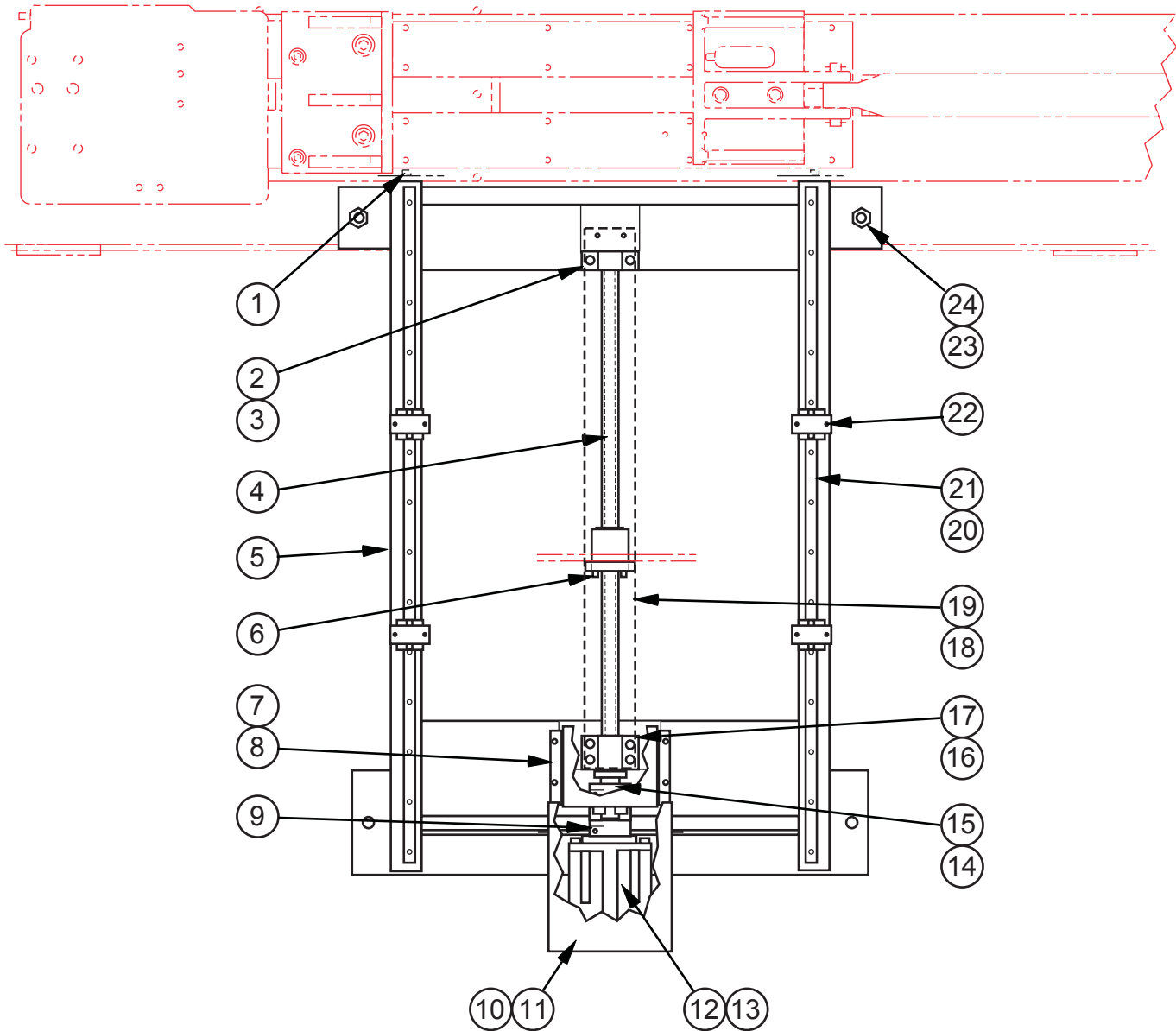
HEAD FEED CYLINDER ASSEMBLY

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HEAD FEED CYLINDER ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	416087	Head Feed Cylinder Assembly	
1	175273	. Lug	1
2	199130	. Nut, Hex. Jam 7/16-14NC	1
3	123333	. Pipe Plug	1
4	203799	. Quad Ring	1
5	14-014528	. Close Nipple	1
6	316346	. Cylinder	1
7	175586	. Spacer	1
8	013245	. Locknut 3/8-16NC	1
9	199302	. Washer, Flat 3/8 Wrought	1
10	261233	. Pipe Plug	1
11	175476	. Tie Rod	4
12	316349	. End Cap	1
13	001508	. O-Ring	1
14	204981	. Piston Seal Cup	1
15	319876	. Piston	1
16	202383	. Adhesive Sealant (Loctite #242-31 Threadlok)	A.R.
17	319533	. Rod	1
18	001508	. O-Ring	1
19	316348	. End Cap	1
20	199176	. Nut, Hex. 1/4-20NC	4
21	199321	. Washer, Lock 1/4 Std.	4

NEW DRG. S.C.L. 10-8-14
REVISIONS



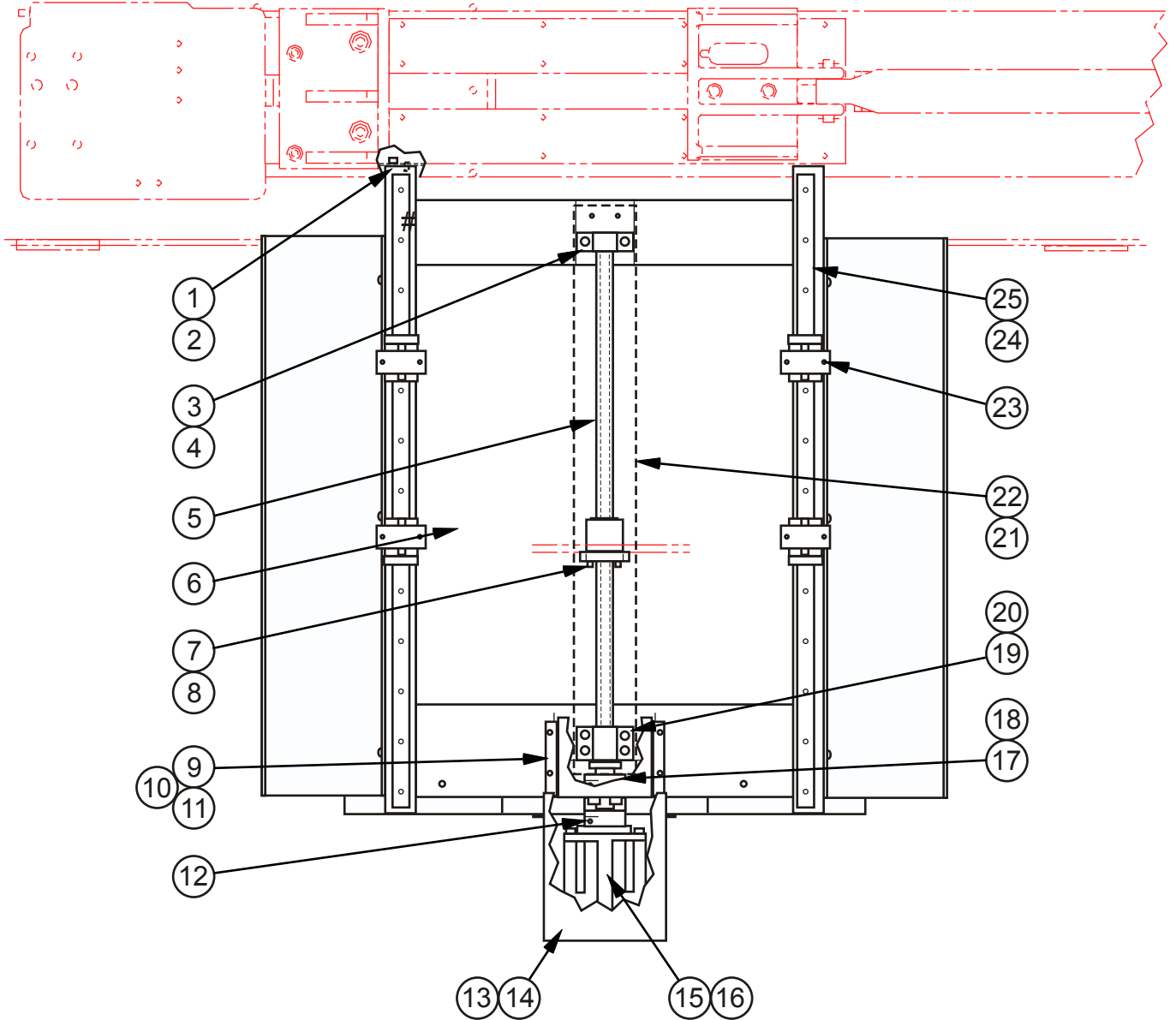
MODEL FIRST MACH. LAST MACH.
400AV 608-14101 608-15103

INDEX TABLE ASSEMBLY

INDEX TABLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	6000226	Index Table Assembly	
1	199680	. Screw, Soc. Hd. Cap M10-1.5 x 30	2
2	226463	. Ball Screw Support	1
3	199636	. Screw, Soc. Hd. Cap M6-1.0 x 40	2
4	226462	. Ball Screw and Nut	1
5	6000218	. Index Table Weldment	1
6	199993	. Screw, Soc. Hd. Cap M6-1.0 x 20	6
7	226427	. Coupler Cover	1
8	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	4
9	226458	. Spider Coupling Jaw (0.5)	1
10	6000219	. Servo Motor Cover Weldment	1
11	199450	. Screw, Soc. Hd. Cap M5-08 x 12	4
12	226252	. Index Servo Motor	1
13	199041	. Screw, Soc. Hd. Cap M5-0.8 x 20	4
14	226459	. Spider Coupling (Red)	1
15	226460	. Spider Coupling Jaw (12 mm)	1
16	226464	. Ball Screw Support	1
17	199636	. Screw, Soc. Hd. Cap M6-1.0 x 40	4
18	226426	. Ball Screw Guard	1
19	197409	. Cable Tie (Black)	1
20	226461	. Linear Guide Rail and Trucks	2
21	226554	. Screw, Soc. Hd. Cap M3-0.5 x 14	28
22	199996	. Screw, Soc. Hd. Cap M4-0.7 x 20	4
23	199088	. Screw, Soc. Set M12-1.75 x 80	2
24	197222	. Nut, Hex. Jam M12-1.75	2

NEW DRG.
S.C.L. 10-8-15
REVISIONS
S.C.L. 3-8-16
S.C.L. 5-27-16



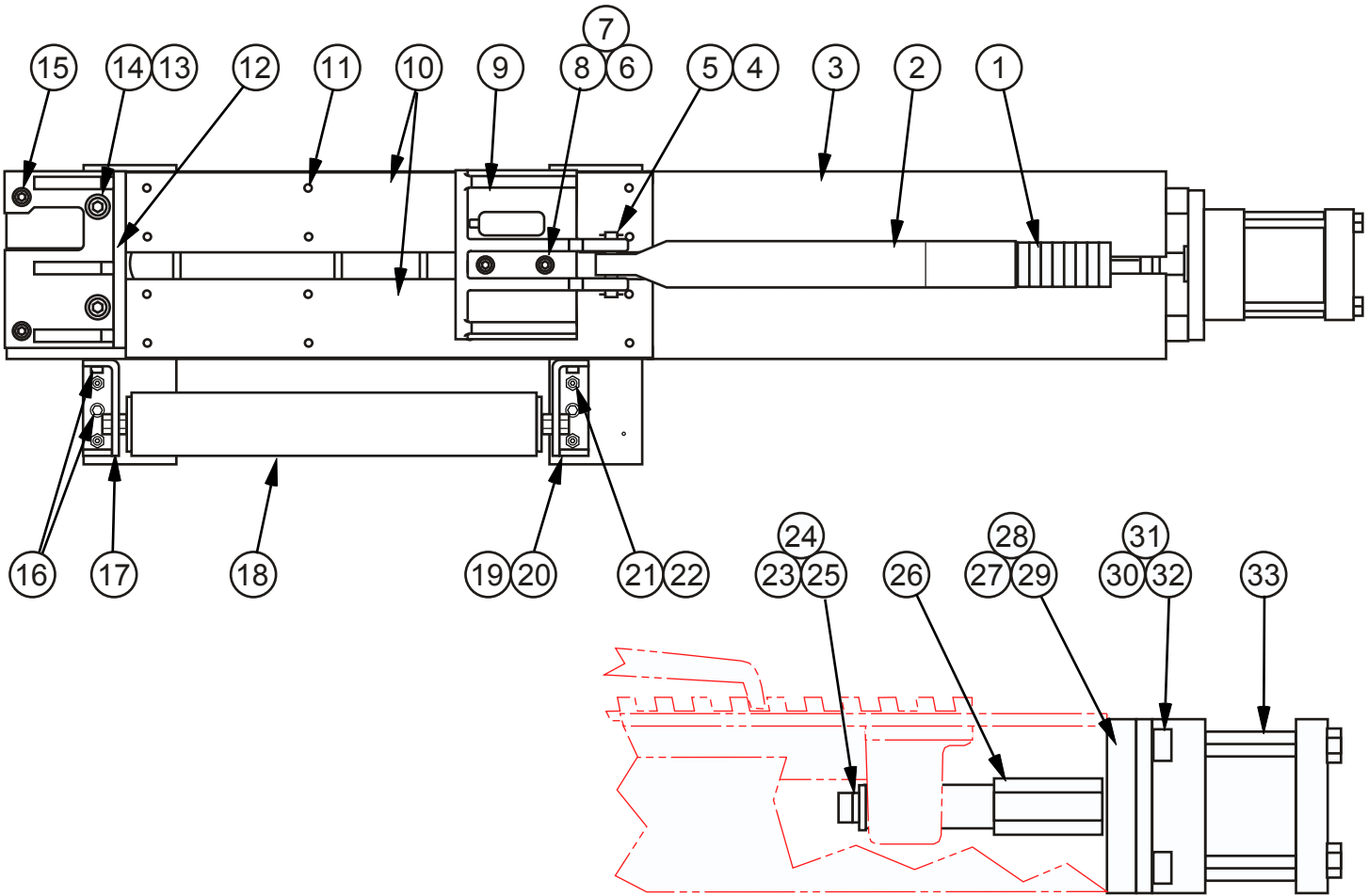
MODEL FIRST MACH. LAST MACH.
400AV 608-15104

INDEX TABLE ASSEMBLY

INDEX TABLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	6000303	Index Table Assembly	
1	199981	. Screw, Soc. Hd. Cap M8-1.25 x 30	2
2	14-000473	. Dowel Pin	2
3	226463	. Ball Screw Support	1
4	199636	. Screw, Soc. Hd. Cap M6-1.0 x 40	2
5	226462	. Ball Screw and Nut	1
6	6000302	. Index Table Weldment	1
7	199993	. Screw, Soc. Hd. Cap M6-1.0 x 20	6
8	226427	. Coupler Cover	1
9	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	4
10	226410	. Rivet Nut M6-1.0	2
11	226458	. Spider Coupling Jaw (0.5)	1
12	6000219	. Servo Motor Cover Weldment	1
13	199450	. Screw, Soc. Hd. Cap M5-08 x 12	4
14	228121	. Programmed Servo Motor	1
	228734	. Programmed Servo Motor (Serial # 608-15105 Only)	1
15	199041	. Screw, Soc. Hd. Cap M5-0.8 x 20	4
16	226459	. Spider Coupling (Red)	1
17	226460	. Spider Coupling Jaw (12 mm)	1
18	226464	. Ball Screw Support	1
19	199636	. Screw, Soc. Hd. Cap M6-1.0 x 40	4
20	226426	. Ball Screw Guard	1
21	197409	. Cable Tie (Black)	1
22	199041	. Screw, Soc. Hd. Cap M5-0.7 x 20	8
23	227007	. Linear Guide Rail and Trucks	2
24	226554	. Screw, Soc. Hd. Cap M3-0.5 x 14	26

NEW DRG. S.C.L. 10-8-14
REVISIONS
S.C.L. 5-27-16



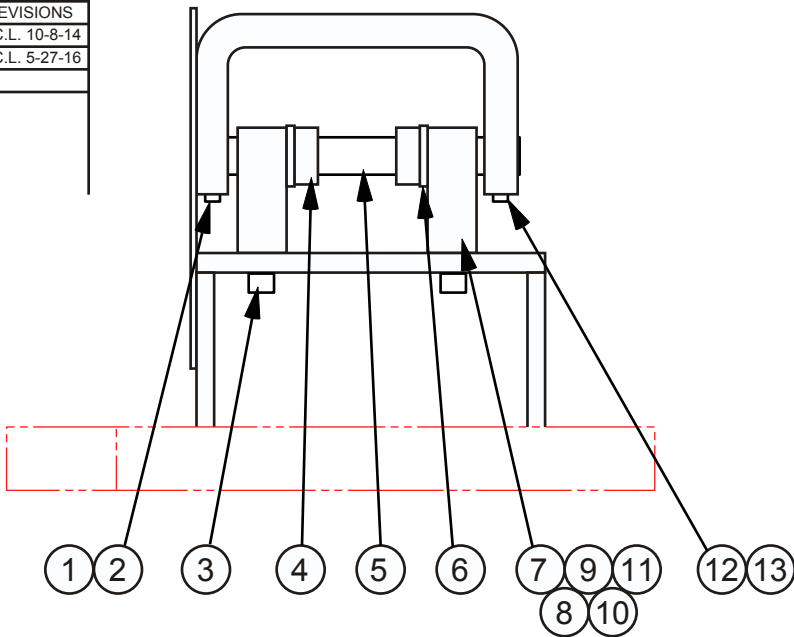
MODEL FIRST MACH. LAST MACH.
400AV 608-14101

INDEX VISE ASSEMBLY

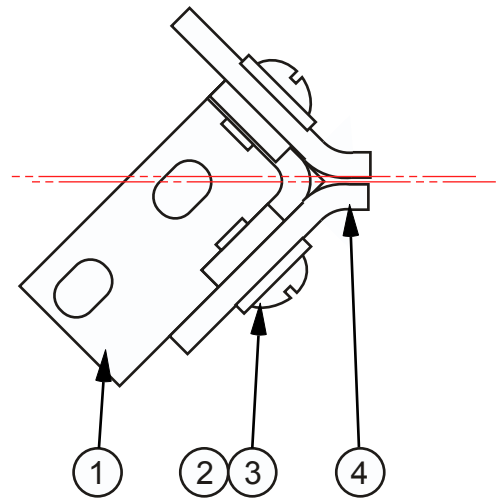
INDEX VISE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	6000225	Index Vise Assembly	
1	1008176	. Rack	1
2	314884	. Pawl	1
3	6000509	. Index Vise Carriage Weldment	1
4	179579	. Pin	1
5	35-009613	. Retaining Ring	2
6	226121	. T-Nut M10-1.5	2
7	199919	. Screw, Soc. Hd. Cap M10-1.5 x 35	2
8	199346	. Washer, Lock M10	2
9	226455	. Movable Jaw	1
10	1008175	. Wear Plate	2
11	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	16
12	6000224	. Fixed Vise Jaw Weldment	1
13	199978	. Screw, Soc. Hd. Cap M16-2.0 x 55	2
14	199063	. Washer, Lock M16	2
15	199904	. Screw, Soc. Hd. Cap M12-1.75 x 40	2
16	199903	. Screw, Soc. Hd. Cap M8-1.25 x 20	2
17*	228085	. R.H. Roller Mount	1
18	202786	. Roller	1
19*	228086	. L.H. Roller Mount	1
20	199903	. Screw, Soc. Hd. Cap M8-1.25 x 20	2
21	205186	. Screw, Soc. Set M8-1.25 x 20	4
22	199250	. Nut, Hex. Jam M8-1.25	4
23	199051	. Screw, Soc. Hd. Cap M6-1.0 x 12	1
24	199254	. Washer, Lock M6 Hi-Collar	1
25	109993	. Washer	1
26	1008204	. Cylinder Adaptor	1
27	1008209	. Spacer	2
28	199911	. Screw, Soc. Hd. Cap M10-1.5 x 40	4
29	199346	. Washer, Lock M10	4
30	199911	. Screw, Soc. Hd. Cap M10-1.5 x 40	4
31	199346	. Washer, Lock M10	4
32	198976	. Washer, Flat M10	4
33	318130	. Pneumatic Vise Clamp Cylinder	1
	*NOTE: Before Serial #608-15107:		
17	226430	. R.H. Roller Mount	1
19	226431	. L.H. Roller Mount	1

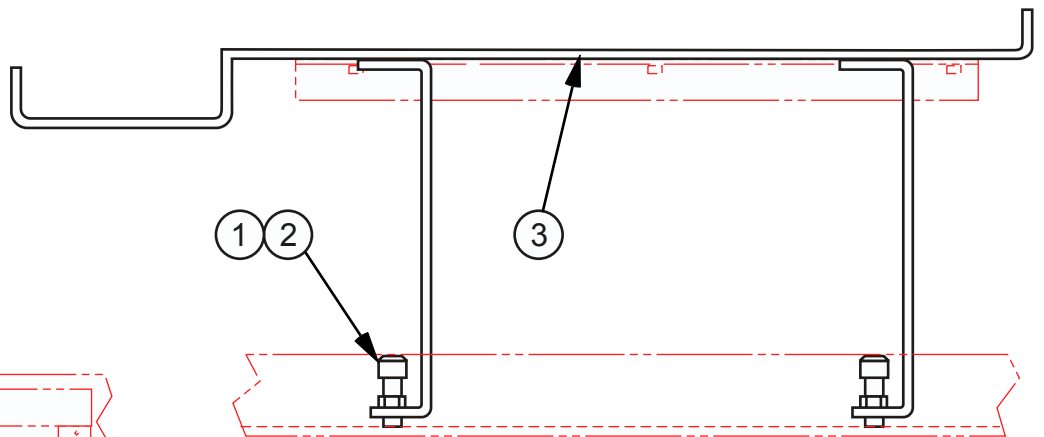
NEW DRG.
S.C.L. 2-22-10
REVISIONS
S.C.L. 10-8-14
S.C.L. 5-27-16



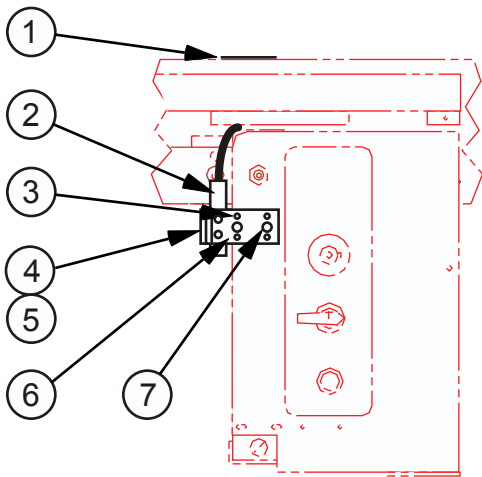
HEAD PIVOT DETAIL



BAND WIPER ASSEMBLY



DISCHARGE TRAY ASSEMBLY
(LARGE)
(OPTIONAL) (400S, 400M Only)



LASER LINE GENERATOR ASSEMBLY
(OPTIONAL)

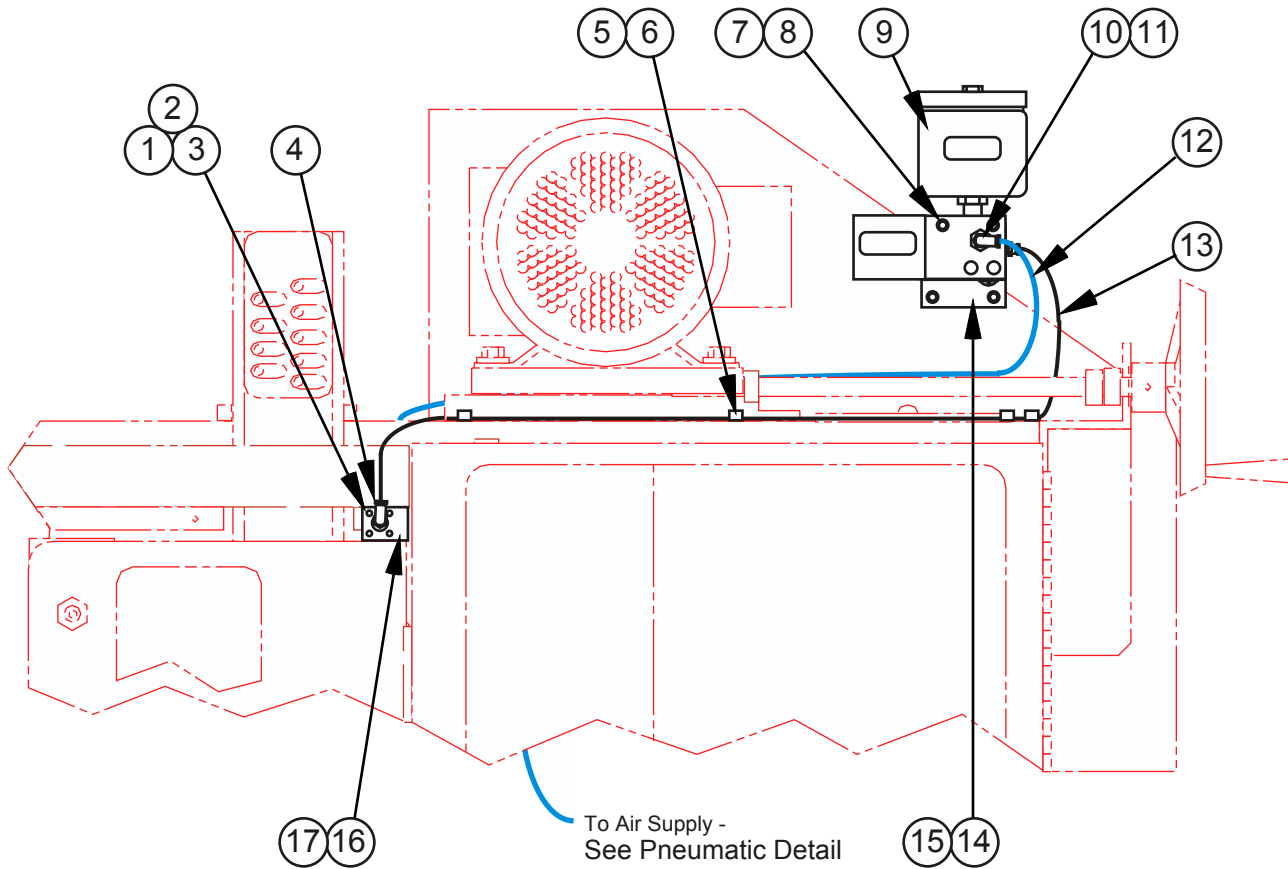
MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	
400AV	608-14101	

MISCELLANEOUS DETAILS

MISCELLANEOUS DETAILS

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Final Assembly (Head Pivot Detail)	
1	199251	. Screw, Soc. Set M10-1.5 x 12 (Cone Point)	1
2	175449	. Friction Plug	1
3	199680	. Screw, Soc. Hd. Cap M10-1.5 x 30	4
4	201915	. Shaft Collar	2
5	176727	. Pivot Shaft	1
6	126535	. Thrust Bearing (Bronze)	2
7	326124	. Bearing Block	2
	201914	. Sleeve Bearing (Press Fit)	2
8	176476	. Shim (.003)	A.R.
9	176477	. Shim (.005)	A.R.
10	176478	. Shim (.007)	A.R.
11	221783	. Shim (.0478)	A.R.
12	199045	. Screw, Soc. Set M10-1.5 x 16	1
13	175449	. Friction Plug	1
Ref.	207716	Band Wiper Assembly	
1	320621	. Bracket	1
2	199408	. Screw, Pan Hd. Slotted M4-0.7 x 10	4
3	109942	. Support	2
4	109941	. Wiper	2
Ref.	1009399	Discharge Tray Assembly (Large) (Optional) (400S, 400M Only)	
1	199680	. Screw, Soc. Hd. Cap M10-1.5 x 30	2
2	199976	. Nut, Hex. Jam M10-1.5	2
3	1008600	. Discharge Tray Weldment	1
Ref.	1010980M	Laser Line Generator Assembly (Optional)	
1	212884	. Label (Laser - Warning)	1
2	1010956	. Laser Line Generator	1
3	199914	. Screw, Soc. Set M5-0.8 x 10	4
4	1010818	. Laser Clamp Block	1
5	199041	. Screw, Soc. Hd. Cap M5-0.8 x 20	2
6	1010817	. Laser Mounting Bracket	1
7	199450	. Screw, Soc. Hd. Cap M5-0.8 x 12	2

NEW DRG. S.C.L. 2-22-10
REVISIONS
S.C.L. 10-8-14



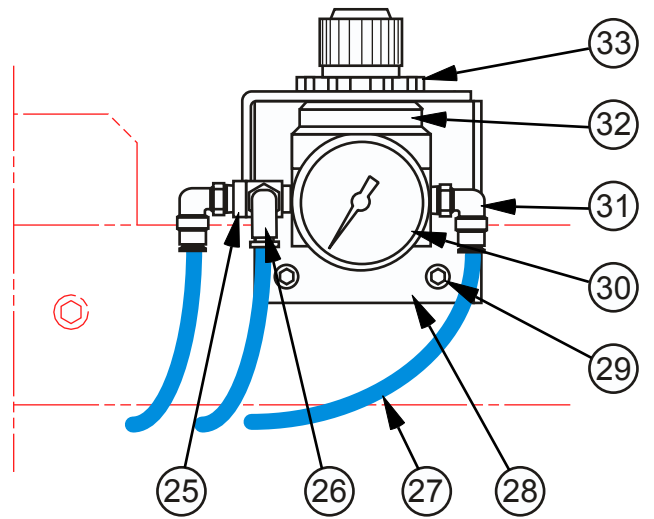
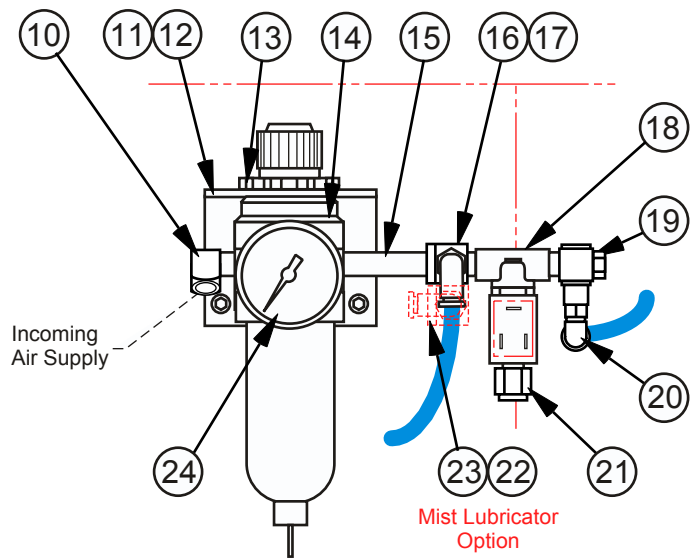
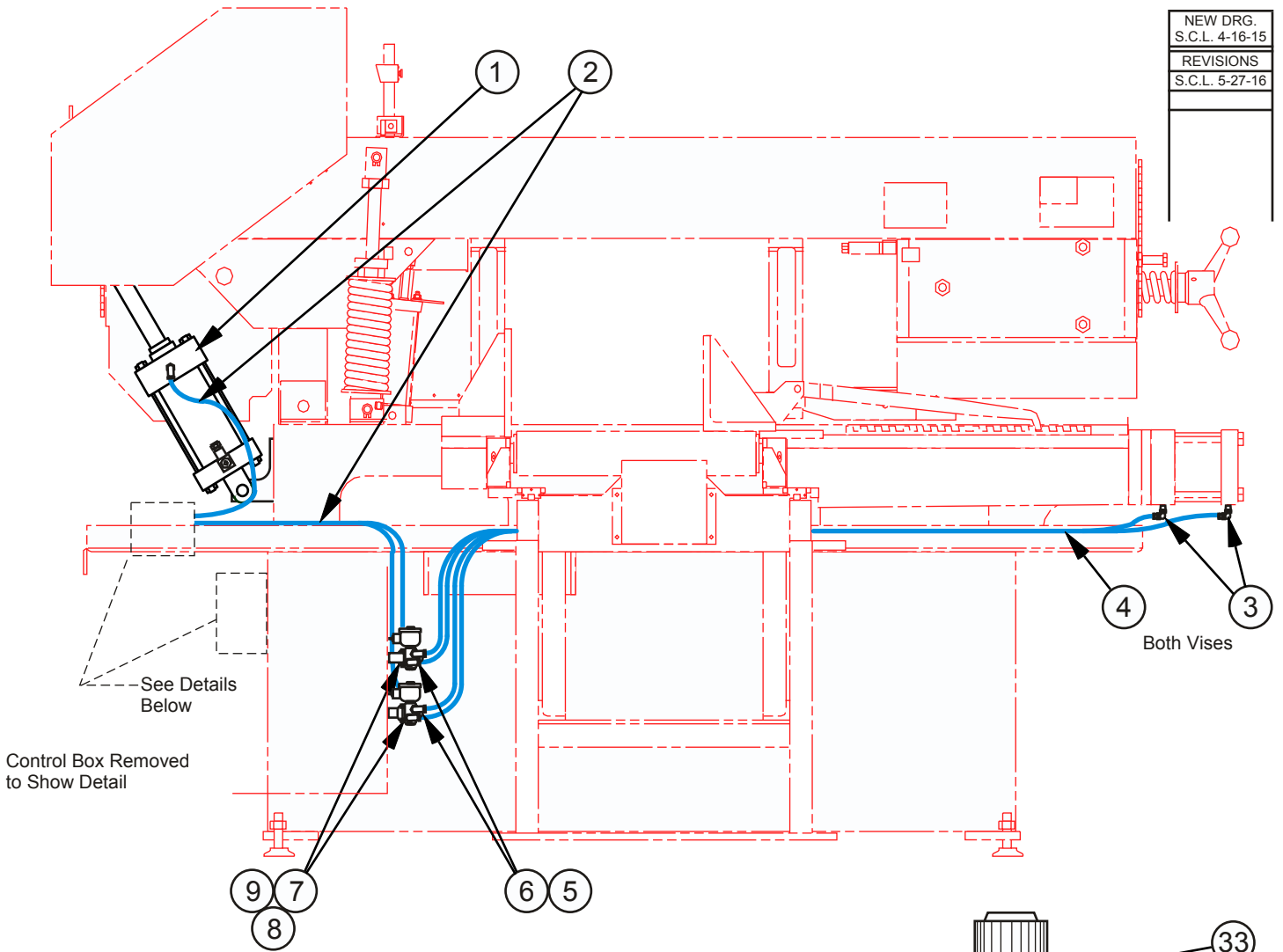
MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	
400AV	608-14101	

MIST LUBRICATOR ASSEMBLY

MIST LUBRICATOR ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	214935	Mist Lubricator Assembly	
1	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	4
2	199348	. Washer, Lock M5	4
3	199202	. Nut, Hex. M5-0.8	4
4	200135	. 90° Swivel Male Elbow	1
5	209458	. Clip Half	4
6	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	4
7	199824	. Screw, Soc. Hd. Cap M6-1.0 x 55	2
8	199188	. Nut, Hex. M6-1.0	2
9	208833	. Mist Lubricator (Includes Nozzle, Solenoid Valve, Tubing)	1
10	260426	. Reducer Bushing	1
11	200135	. 90° Swivel Male Elbow	1
12	197438	. Polyethelene Tubing 1/4 O.D. (Blue)	A.R.
13	197142	. Nylon Tubing 1/8 O.D.	A.R.
14	214906	. Bracket	1
15	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	2
16	1008707	. Nozzle Bracket	1
17	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2
Following Not Shown:			
	214124	. Heavy Duty Cutting Fluid (AL-2000)	A.R.

NEW DRG.
S.C.L. 4-16-15
REVISIONS
S.C.L. 5-27-16



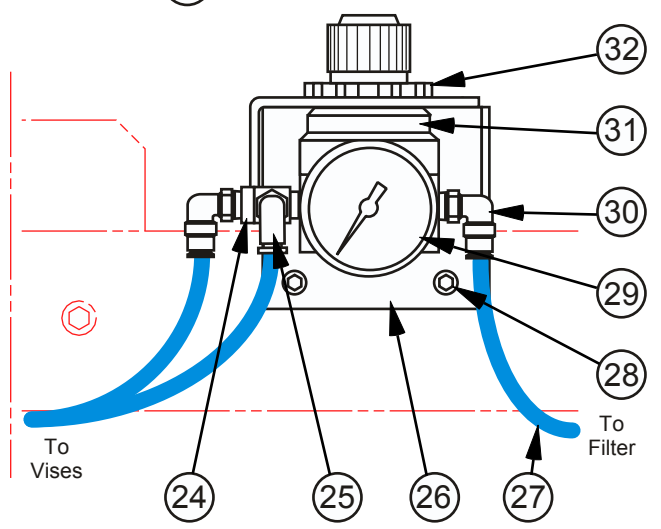
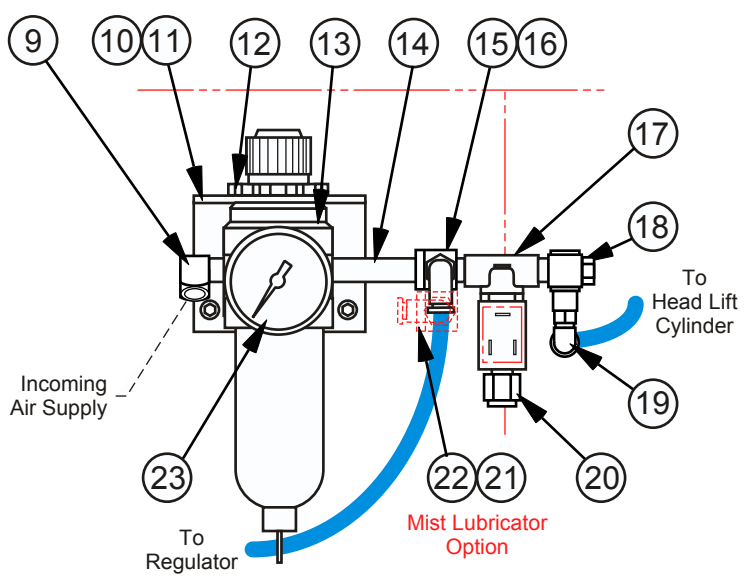
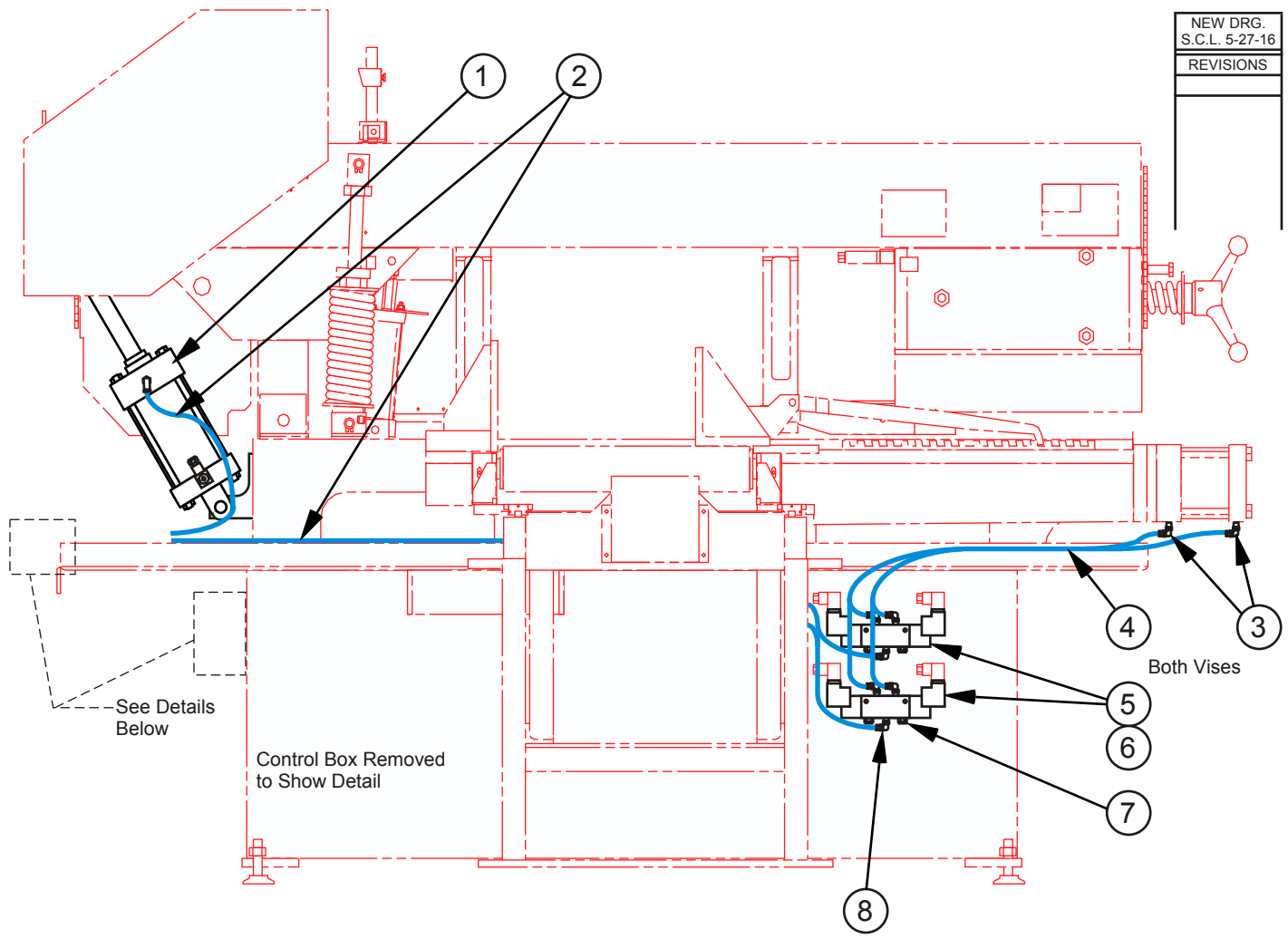
MODEL	FIRST MACH.	LAST MACH.
400AV	608-15101	608-16114

PNEUMATIC ASSEMBLY

PNEUMATIC ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
		Pneumatic Assembly	
1	224965	. Pneumatic Head Lift Assembly (See Detail)	1
2	197438	. Polyethelene Tubing 1/4 O.D. (Blue)	A.R.
3	200135	. 90° Swivel Male Elbow	4
4	197438	. Polyethelene Tubing 1/4 O.D. (Blue)	A.R.
5	200135	. 90° Swivel Male Elbow	4
6	260426	. Reducer Bushing	4
7	226470	. Solenoid Valve	2
8	260426	. Reducer Bushing	2
9	176811	. Vent Filter Breather	2
10	123835	. 90° Reducing Elbow	1
11	418046	. Regulator Mounting Bracket	1
12	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	2
13	206113	. Mounting Nut	1
14	206115	. Air Regulator/Filter	1
15	203144	. Pipe Nipple (Brass)	1
16	112043	. Street Tee	1
17	200135	. 90° Swivel Male Elbow	1
18	176829	. Solenoid Valve (3-Way)	1
19	203809	. Right Angle Flow Control valve	1
20	200135	. 90° Swivel Male Elbow	1
21	176811	. Vent Filter Breather	1
22	112043	. Street Tee (Mist Lubricator Option)	1
23	200135	. 90° Swivel Male Elbow (Mist Lubricator Option)	1
24	200137	. Gauge	1
25	112043	. Street Tee	1
26	200135	. 90° Swivel Male Elbow	2
27	197438	. Polyethelene Tubing 1/4 O.D. (Blue)	A.R.
28	418046	. Regulator Mounting Bracket	1
29	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	2
30	200137	. Gauge	1
31	200135	. 90° Swivel Male Elbow	1
32	206115	. Air Regulator	1
33	206113	. Mounting Nut	1
Following Not Shown:			
	176879	. Label (Air Supply Limits)	1

NEW DRG.
S.C.L. 5-27-16
REVISIONS



MODEL FIRST MACH. LAST MACH.
400AV 608-16115

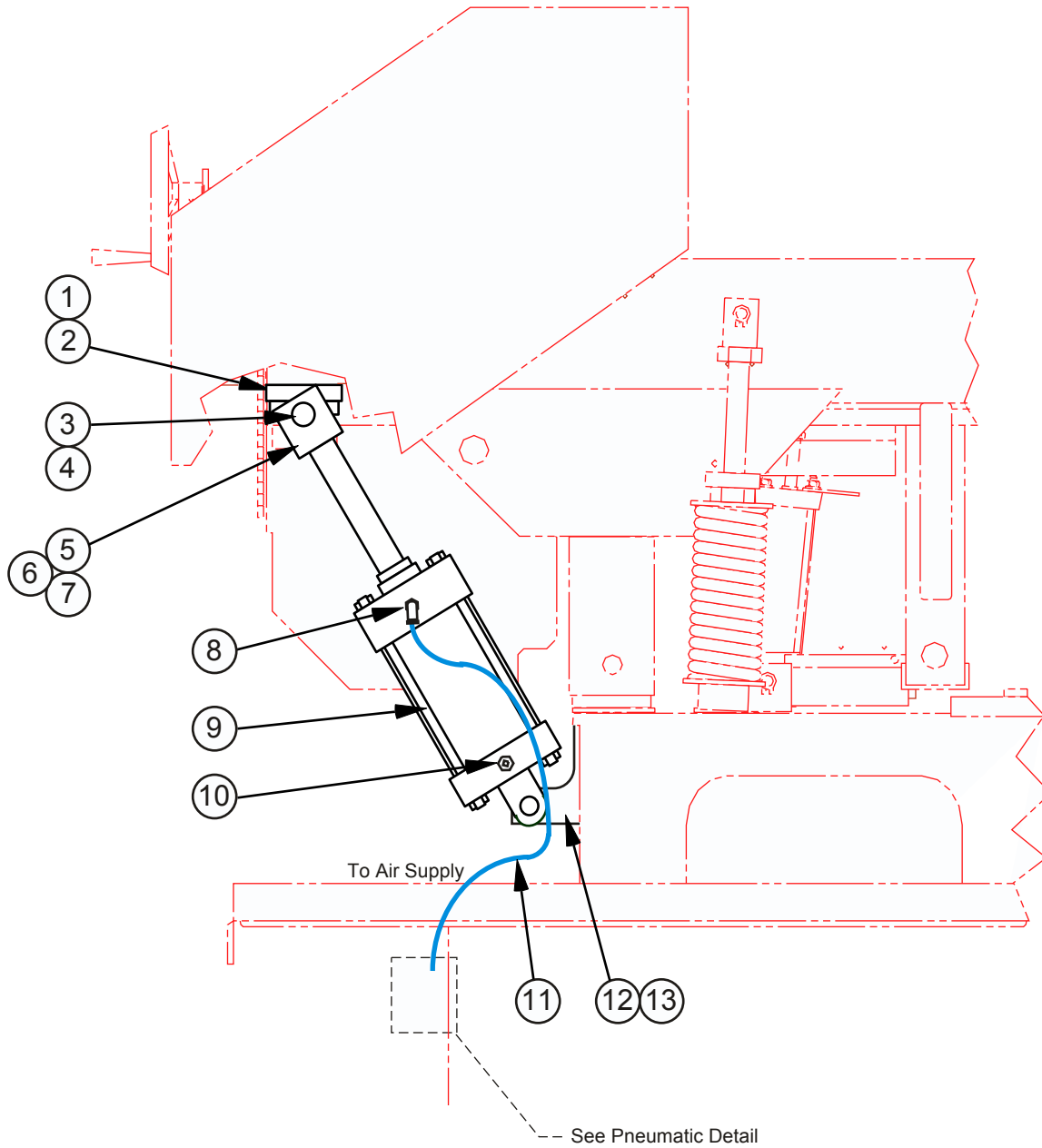
PNEUMATIC ASSEMBLY

PNEUMATIC ASSEMBLY

INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
		Pneumatic Assembly	
1	224965	. Pneumatic Head Lift Assembly (See Detail)	1
2	197438	. Polyethelene Tubing 1/4 O.D. (Blue)	A.R.
3	200135	. 90° Swivel Male Elbow	4
4	197438	. Polyethelene Tubing 1/4 O.D. (Blue)	A.R.
5	214390	. Solenoid Vavle (3 Position, 4 Way)	2
6	214846	. Screw, Soc. Hd. Cap M3-0.5 x 25	4
7	176811	. Vent Filter Breather	4
8	200135	. 90° Swivel Male Elbow	6
9	123835	. 90° Reducing Elbow	1
10	418046	. Regulator Mounting Bracket	1
11	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	2
12	206113	. Mounting Nut	1
13	206115	. Air Regulator/Filter	1
14	203144	. Pipe Nipple (Brass)	1
15	112043	. Street Tee	1
16	200135	. 90° Swivel Male Elbow	1
17	176829	. Solenoid Valve (3-Way)	1
18	203809	. Right Angle Flow Control valve	1
19	200135	. 90° Swivel Male Elbow	1
20	176811	. Vent Filter Breather	1
21	112043	. Street Tee (Mist Lubricator Option)	1
22	200135	. 90° Swivel Male Elbow (Mist Lubricator Option)	1
23	200137	. Gauge	1
24	112043	. Street Tee	1
25	200135	. 90° Swivel Male Elbow	2
26	418046	. Regulator Mounting Bracket	1
27	197438	. Polyethelene Tubing 1/4 O.D. (Blue)	A.R.
28	199246	. Screw, Button Hd. Soc. M6-1.0 x 12	2
29	200137	. Gauge	1
30	200135	. 90° Swivel Male Elbow	1
31	206115	. Air Regulator	1
32	206113	. Mounting Nut	1

Following Not Shown:
 176879 . Label (Air Supply Limits) (Near Air Filter) 1

NEW DRG. S.C.L. 7-22-11
REVISIONS
S.C.L. 10-8-14
S.C.L. 5-27-16



Electrical Enclosure
Removed To Show Detail.

MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400AV	608-14101	

PNEUMATIC HEAD LIFT ASSEMBLY

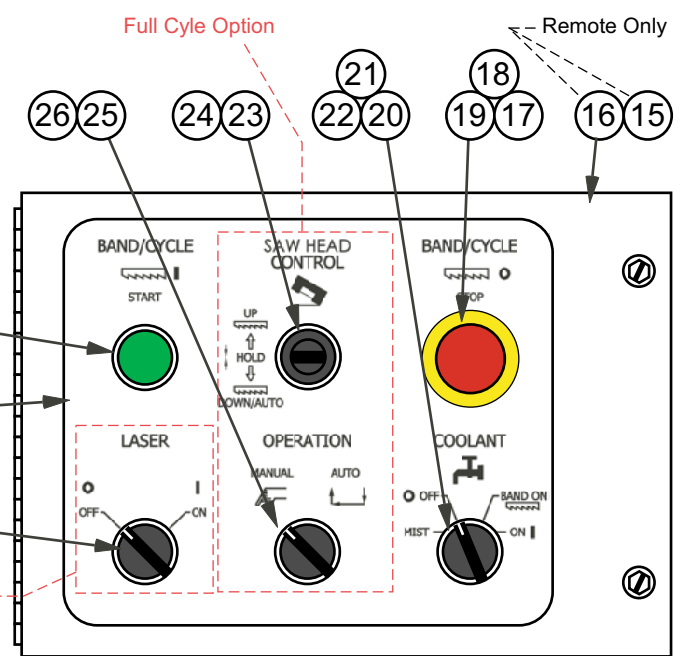
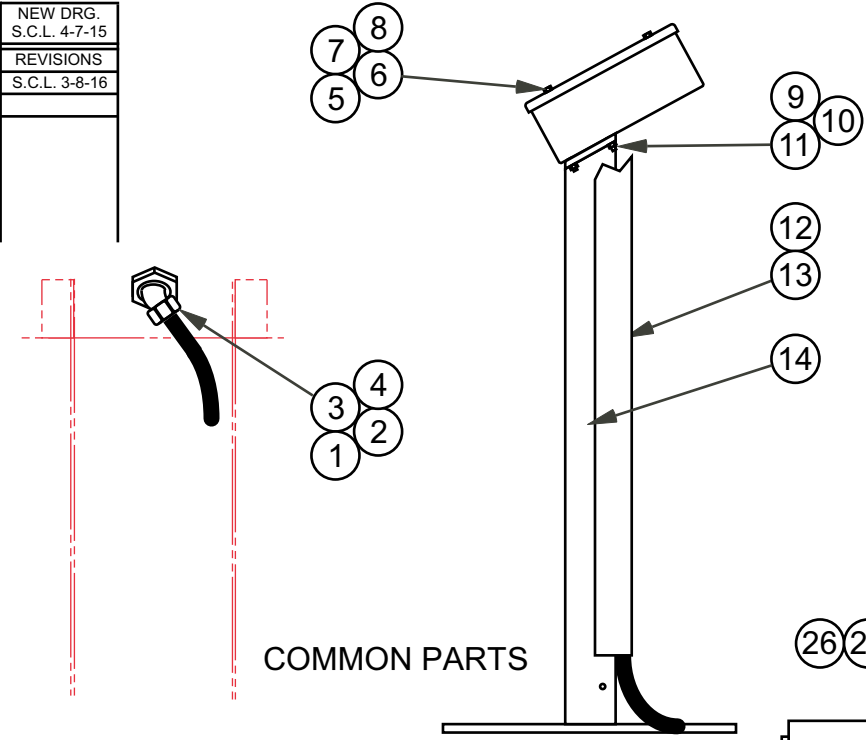
PNEUMATIC HEAD LIFT ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	224965	Pneumatic Head Lift Assembly	
1	179584	. Mounting Block Weldment	1
2	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25	2
3	179586	. Pin	1
4	35-007558	. Retaining Ring	2
5	316604	. Pivot Bracket	1
6	198186	. Screw, Hex. Hd. Cap 3/4-16NF x 1-1/4	1
7	202383	. Adhesive (Loctite #242-31 Threadlock)	A.R.
8	200135	. 90° Swivel Male Elbow	1
9	176228	. Pneumatic Head Lift Cylinder	1
10	176811	. Vent Filter Breather	1
11	197438	. Polyethylene Tubing 1/4 O.D. (Blue)	A.R.
12	1013882	. Cylinder Mount Bracket	1
13	199918	. Screw, Soc. Hd. Cap M12-1.75 x 45	2
Following Not Shown:			
	176880	. Tag (Attention - Air Pressure)	1

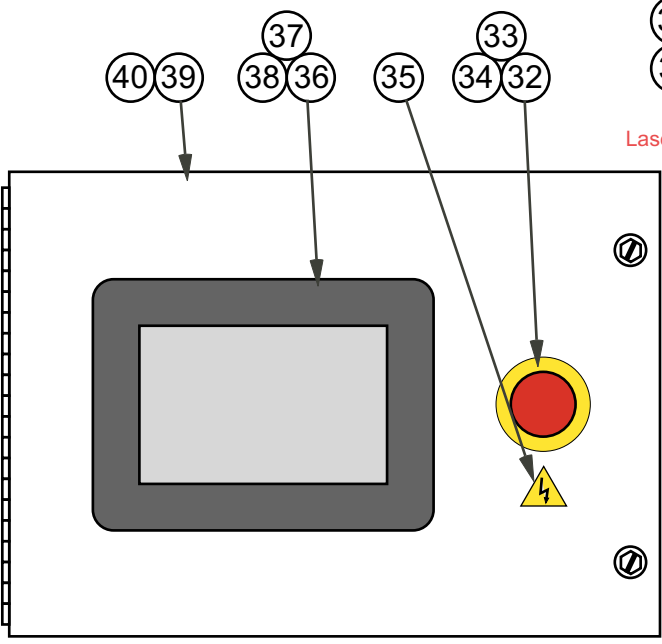
NEW DRG.
S.C.L. 4-7-15
REVISIONS
S.C.L. 3-8-16

NOTE: Remote Console started with the Following Serial Numbers:

MODEL	FIRST MACH.	LAST MACH.
400A	595-13126	
400M	596-13295	
400S	597-13260	
400AV	608-14101	



MODELS 400M, 400S ONLY
(Used for Both Machine Mounted or Remote Console)



MODELS 400A, 400AV ONLY

MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-10101	
400AV	608-14101	

REMOTE CONSOLE ASSEMBLY

REMOTE CONSOLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Remote Console Assembly	
1	014685	. 45° Sealite Connector	1
2	014480	. Flange Washer	1
3	014772	. Insulated Plastic Bushing	1
4	197158	. Sealite Conduit 3/4 I.D.	A.R.
5	207523	. Screw, Hex. Hd. Slotted M6-1.0 x 20	2
6	204153	. Nylon Washer	2
7	207525	. Rivet Nut M6-1.0	2
8	204151	. Retainer Ring	2
9	199202	. Nut, Hex. M5-0.8	4
10	199244	. Washer, Flat M5	4
11	199348	. Washer, Lock M5	4
12	1008739	. Back Cover	1
13	199969	. Screw, Button Hd. Soc. M6-1.0 x 10	4
14	1007745	. Consolet Weldment	1

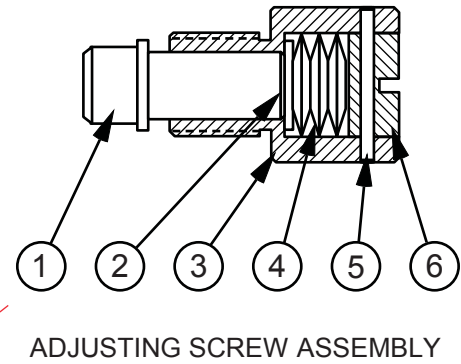
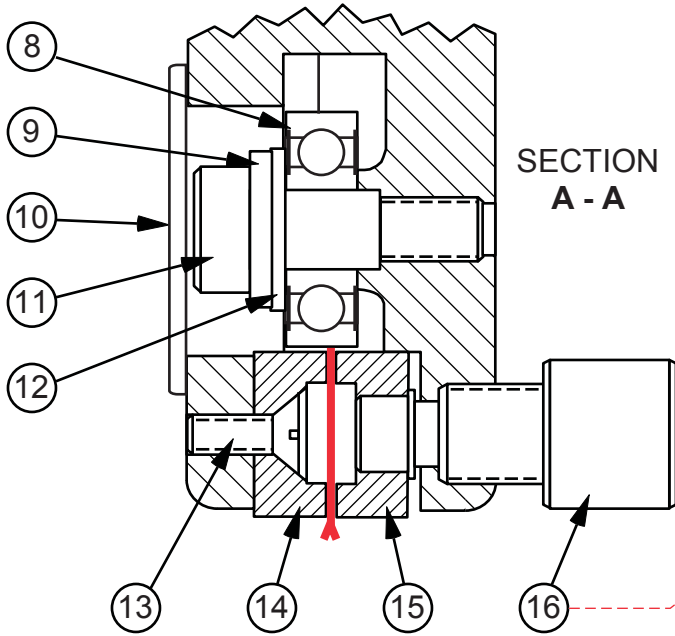
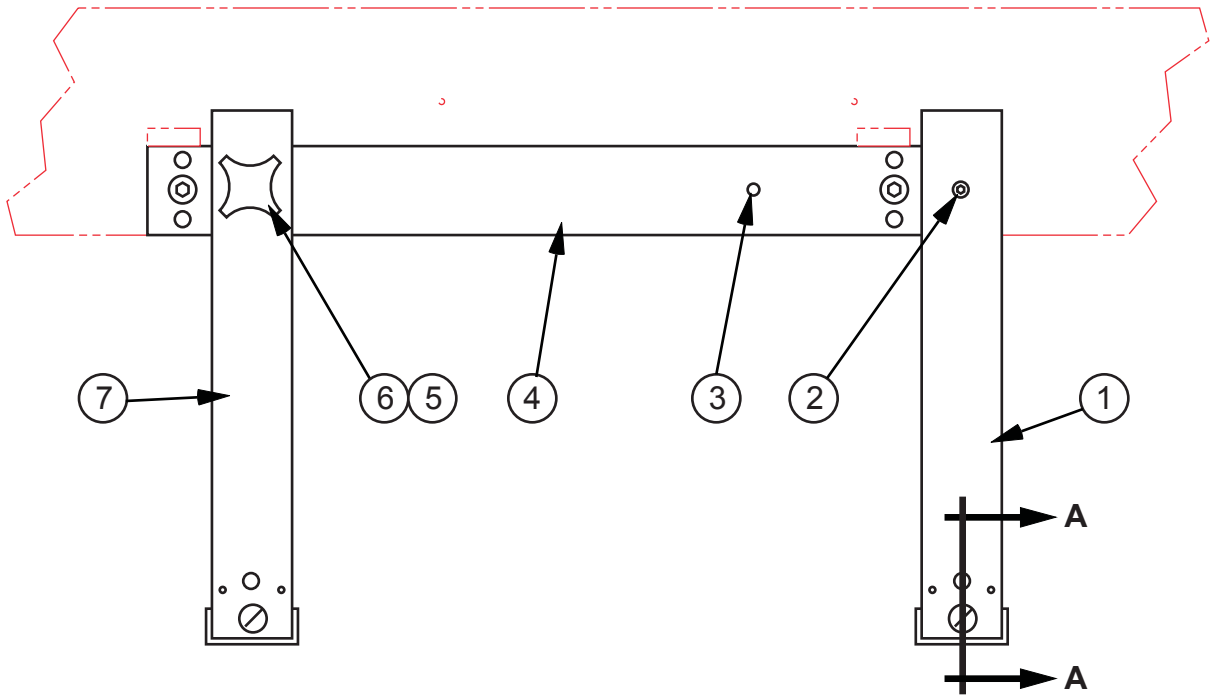
Ref.		Pushbutton Panel Detail (400M, 400S Only)	
15	1014454	. Enclosure Weldment	1
16	203925	. Gasket Strip	A.R.
17	207191	. Pushbutton Operator (Red Mushroom Head)	1
18	211501	. Contact Block (2-NC)	1
19	202902	. E-Stop Marker (Yellow)	1
20	207184	. Selector Switch (4 Position)	1
21	207186	. Contact Block (1-NC)	2
22	207187	. Contact Block (1-NO, 1-NC)	2
23*	207182	. Selector Switch (3 Position) (Full Cycle Option)	1
24*	211500	. Contact Block (2-NO)	2
25	207181	. Selector Switch (2 Position)	1
26	207185	. Contact Block (1-NO)	1
27	207190	. Pushbutton Operator (Green)	1
28	207185	. Contact Block (1-NO)	1
29	1008674	. Escutcheon	1
30	207181	. Selector Switch (2 Position)	1
31	207185	. Contact Block (1-NO)	1

*NOTE: Before Serial #596-11149 on 400M, #597-11136 on 400S; Order Full Cycle Switch Assembly - #224684 to Replace.

Ref.		Pushbutton Panel Detail (400A, 400AV Only)	
32	207191	. Pushbutton Operator (Red Mushroom Head)	1
33	211501	. Contact Block (2-NC)	1
34	202902	. E-Stop Marker (Yellow)	1
35	176528	. Label (Electrical Hazard)	1
36	224729	. Programmed Operator Workstation (400A)	1
**	228956	. Programmed Operator Workstation (400AV)	1
37	219360	. Ethernet Cable (#1)	1
38	222298	. D-Sub Connector Plug (25 Pin)	1
39	1007723	. Enclosure Weldment	1
40	203925	. Gasket Strip	A.R.

**NOTE: Before Serial #608-16115:
228120 . Programmed Operator Workstation (400AV) 1

NEW DRG.
S.C.L. 3-22-10
REVISIONS
S.C.L.11-11-11
S.C.L. 10-8-14



SAW GUIDE DETAIL - BOTH GUIDES

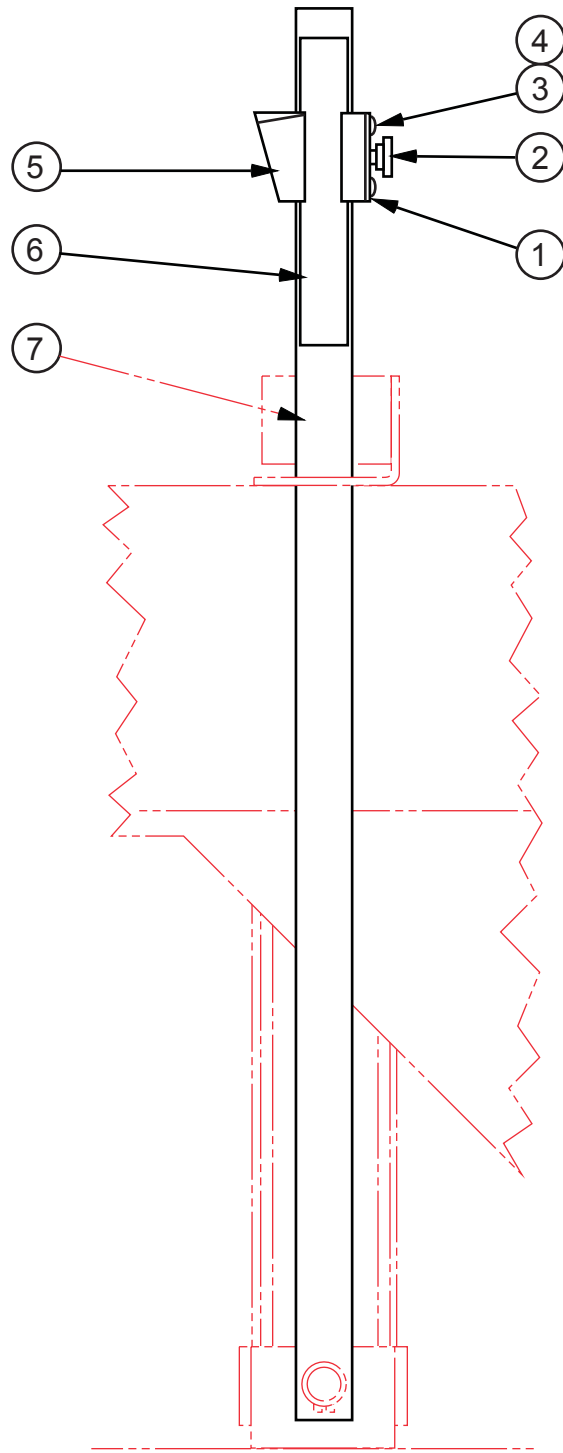
MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400M	596-10101	
400S	597-09101	
400AV	608-14101	

SAW GUIDE ARM ASSEMBLY

SAW GUIDE ARM ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	225521	Saw Guide Arm Assembly	
1	517255	. Saw Guide Arm	1
2	199237	. Screw, Soc. Set M12-1.75 x 25	1
3	004269	. Spring Pin	1
4	320590	. Mounting Bar	1
5	1008755	. Saw Guide Arm Lock Handwheel	1
6	175449	. Brass Plug	1
7	517255	. Saw Guide Arm	1
8	011529	. Ball Bearing	2
9	199346	. Washer, Lock M10	2
10	35-004528	. Plug Button	2
11	176077	. Screw, Soc. Hd. Shoulder M8-1.25 x 16 (10 mm Dia.)	2
12	198976	. Washer, Flat M10	2
13	198749	. Screw, Flat Hd. Mach. #10-24NC x 1/2	2
14	137158	. Insert Assembly (Fixed)	2
15	137155	. Insert Assembly (Adjustable)	2
16	124419	. Adjusting Screw Assembly (See Detail)	2
Ref.	124419	. Adjusting Screw Assembly	
1	124417	. . Plunger	1
2	199257	. . Washer, Flat #8 S.A.E. Std.	1
3	124418	. . Housing	1
4	104632	. . Belleville Washer	6
5	004217	. . Spring Pin	1
6	124033	. . Plug	1

NEW DRG. S.C.L. 7-22-11
REVISIONS
S.C.L. 10-8-14



MODEL	FIRST MACH.	LAST MACH.
400A	595-10101	
400AV	608-14101	

WORK HEIGHT ASSEMBLY

WORK HEIGHT ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	1012087	Work Height Assembly	
1	1013085	. Bracket	1
2	207520	. Thumb Screw	1
3	199974	. Screw, Button Hd. Soc. M5-0.8 x 10	2
4	199348	. Washer, Lock M5	2
5	207518	. Actuator	1
6	1013582	. Decal (Work Height Adjustment)	1
7	203766	. Wand	1