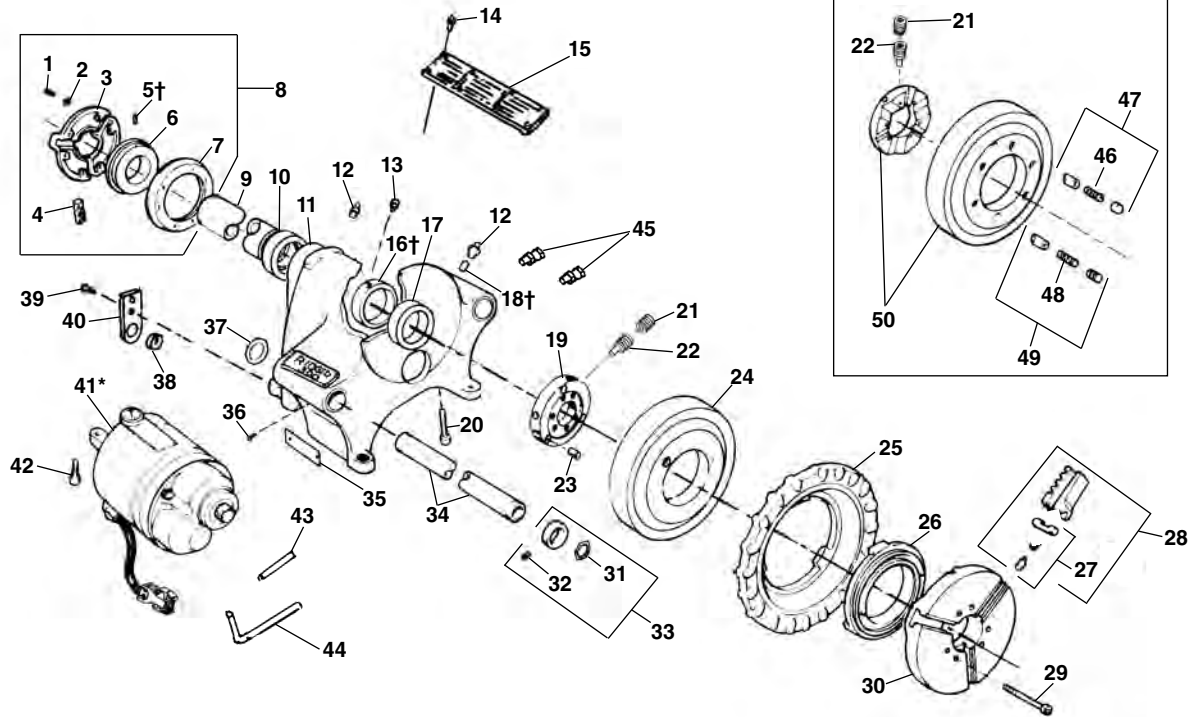


**Main Components**



**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

**For Information on Cutters, Die Heads and Reamers SEE INDEX**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	46790	Screw, 12 - 24 x 3/4" (6)	27	44715	Jaw Insert Set
2	40270	Lock Washer (6)		97365	Jaw Insert Set F/Coated Pipe
3	43735	Centering Head	28	44090	Chuck Jaw Set
	19346	Centering Head (Europe)	29	45295	Screw 5/16" - 18 x 2 3/4" (6)
4	46500	Rear Jaw (3)	30	43525	Cap
5†	45260	Step Pin (3)	31	44720	Snap Ring (2)
6	44095	Scroll	32	46050	Set Screw 1/4" - 18 x 1/4" (2)
7	43740	Back Plate	33	44725	Ring Assembly (2)
	19356	Back Plate (Europe)	34	44425	Support Bar (Incl. Ref. No. 37)
8	44165	Rear Centering Assembly	35	90392	FOR/OFF/REV Label
9	44100	Drive Shaft	36	45280	Screw #8 - 32 x 5/8" (2)
10	45335	Rear Bearing-Bronze	37	44525	Spring Ring (2)
11	42845	300 Body Assembly (Incl. Ref. No. 10, 11, 12, 13, 14, 15, 17, 18, 38, 39, 40)	38	46735	Cord Grommet
	19056	300A Body Assy.- Europe (Incl. Ref. No. 10, 11, 12, 13, 14, 15, 17, 18, 38, 39, 40, 43, 44, 45)	39	44735	Screw 1/4" - 20 x 5/8" (2)
	96805	300A Body Assy. (Incl. Ref. No. 10, 11, 12, 13, 14, 15, 17, 18, 38, 39, 40, 43, 44, 45)	40	45825	Strain Relief Plate
12	46860	Grease Fitting	41*	87740	3177 Motor 115V (300)
13	33785	Set Screw 5/16" - 24 x 1/4" (2)		87780	3277 Motor 230V (300)
14	85920	Pop Rivet (10)		96810	3181 Motor 115V (300A)
15	88690	Warning Plate		96975	3281 Motor 230V (300A)
16†	45345	Thrust Ring		61202	3177-CE Motor 115V (300CE)
17	45270	Front Bearing		61207	3277-CE Motor 230V (300CE)
18†	45310	Split Roll Pin		61192	3181-CE Motor 230V (300A CE)
19	30027	Drive Ring, Type II		61197	3281-CE Motor 115V (300A CE)
20	46035	Screw 5/16" - 18 x 1 3/4"	42	46745	Screw 3/8" - 16 x 1 1/4" (2)
21	45300	Set Screw 5/16" - 24 x 1/4" (2)	43	96850	Tubing (300A)
22	45265	Set Screw 5/16" - 24 x 1/2" (3)	44	96855	Tubing (300A)
23	30022	Drive Pin, Type II (3)	45	96860	Bulkhead Union (2) (300A)
24	30017	Ring Gear, Type II	46	44310	Drive Spring (3)
25	89150	Hand Wheel	47	91552	Drive Wedge Kit
26	43540	Scroll	48	45285	Pressure Spring (3)
			49	91557	Plunger Kit
			50	91562	Conversion Kit (Includes Ref. Nos. 19-24)

\* Refer to Motor Model No. for Component Parts

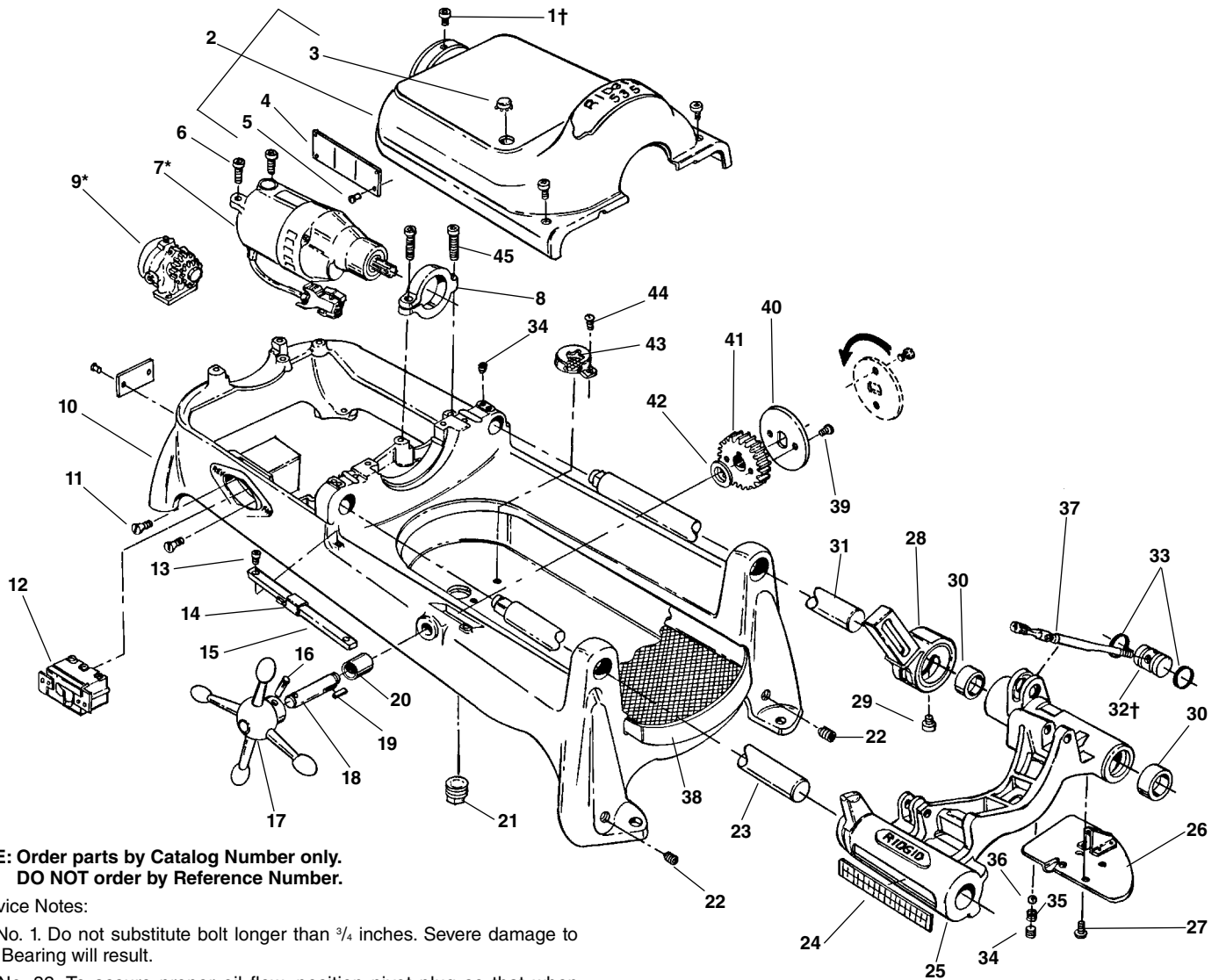
**Service Notes:**

†Ref. 5 Stop Pins are easily removed by pushing from inside to outside.

†Ref. 18 Before removing front bearing sleeve (Ref. No. 17), dowel pin and grease fitting must be pushed out from inside.

†Ref. 16 Position thrust ring so that offset screw holes are closer to chuck.

## Main Components – Early Style



**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

†Service Notes:

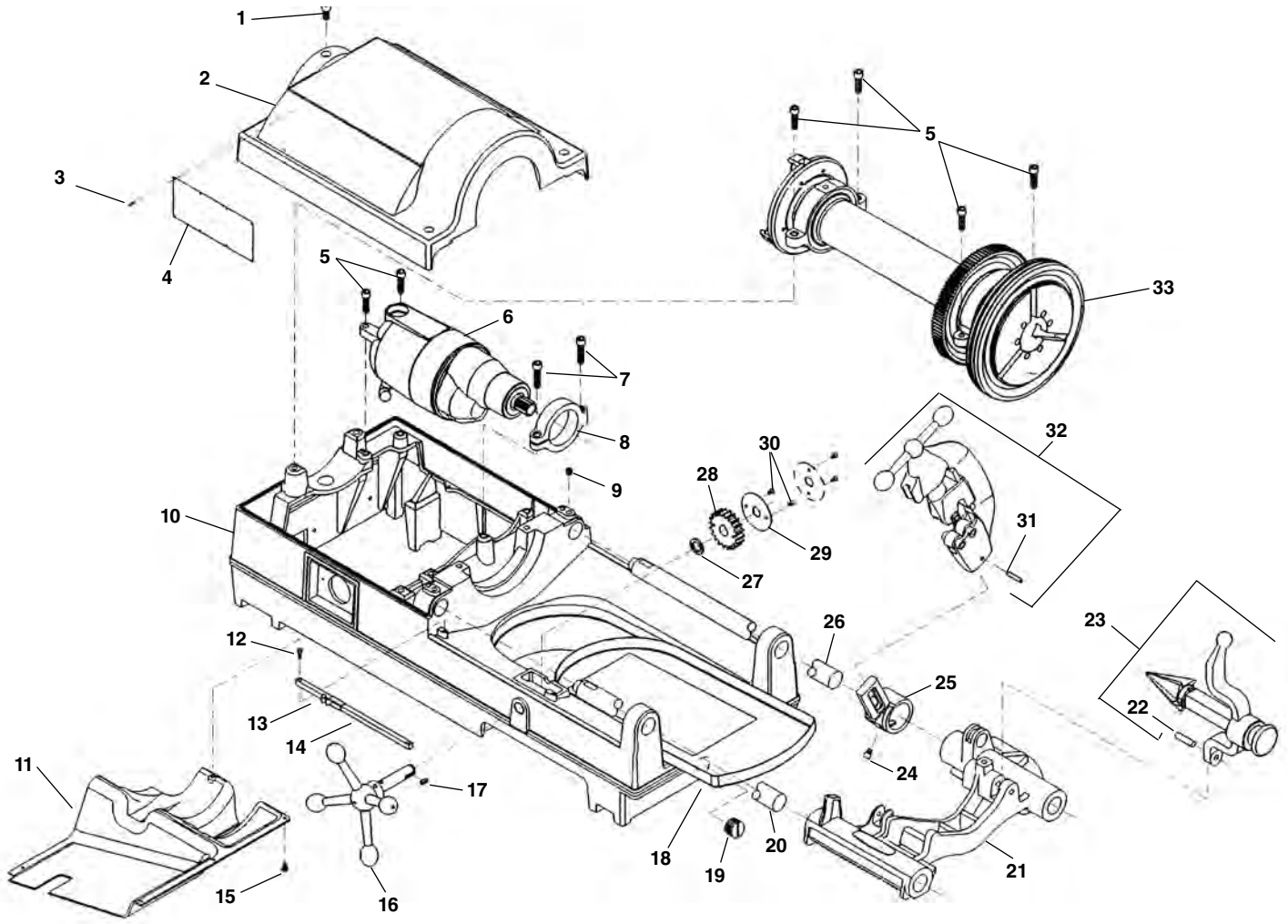
Ref. No. 1. Do not substitute bolt longer than  $\frac{3}{4}$  inches. Severe damage to Rear Bearing will result.

Ref. No. 32. To assure proper oil flow, position pivot plug so that when spout is in up position, oil flow hole is visible in carriage slot below spout.

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1†	46760	Screw $\frac{3}{8}$ " - 16 x $\frac{3}{4}$ " (3)	24	46370	Scale
2	43190	Cover (Incls. Ref. No. 3, 4, 5)	25	62057	Carriage Assy. (Includes Ref. Nos. 24, 26, 27, 28, 29, 30, 34, 35, 36)
3	89310	Plug Button	26	45195	Drip Plate
4	88690	Warning Plate	27	46270	Screw $\frac{1}{4}$ " - 20 x $\frac{1}{2}$ " Pan Head (4)
5	85920	Pop Rivet (8)	28	43690	Cutter Arm
6	46745	Screw $\frac{3}{8}$ " - 16 x $1\frac{1}{4}$ " (2)	29	44930	Screw, $\frac{5}{16}$ " x $\frac{9}{32}$ "
7*	88125	Motor Model 1177, 115V	30	46720	Oil Seal (2)
	88165	Motor Model 2377, 230V	31	45220	Support Bar - Rear
8	43795	Motor Bracket	32†	44340	Pivot Plug
9*	47195	Model A Oil Pump	33	44470	O-Ring (2)
10	43030	Base (Incls. Ref. No. 20, 21, 22, 44)	34	46800	Set Screw $\frac{3}{8}$ " - 16 x $\frac{3}{8}$ " (3)
11	45280	Screw #8-32 x $\frac{3}{8}$ " Flat Head (2)	35	46680	Spring
12	44505	Switch	36	46925	Ball
13	45615	Screw #10-32 x $\frac{1}{2}$ " Flat Head (2)	37	44495	Oil Spout Assembly
14	47110	Indicator Slide	38	43355	Chip Tray
15	47105	Indicator Bar	39	46785	Screw #10-32 x $\frac{3}{8}$ "
16	47165	Pin	40	47120	Lock Plate
17	46510	Handwheel	41	45430	Pinion
18	47115	Pinion Shaft	42	47145	Spacer
19	46930	Key $\frac{3}{16}$ " Square	43	46655	Filter
20	46540	Bushing	44	45420	Screw #10-24 x $\frac{3}{8}$ "
21	44485	Drain Plug	45	44220	Screw $\frac{3}{8}$ " - 16 x $1\frac{1}{2}$ "
22	42037	Set Screw $\frac{1}{2}$ " - 13 x $\frac{1}{2}$ " (4)			
23	45440	Support Bar - Front			

\*Refer to Motor Model No./Refer to Model "A" Oil Pump for Component Parts

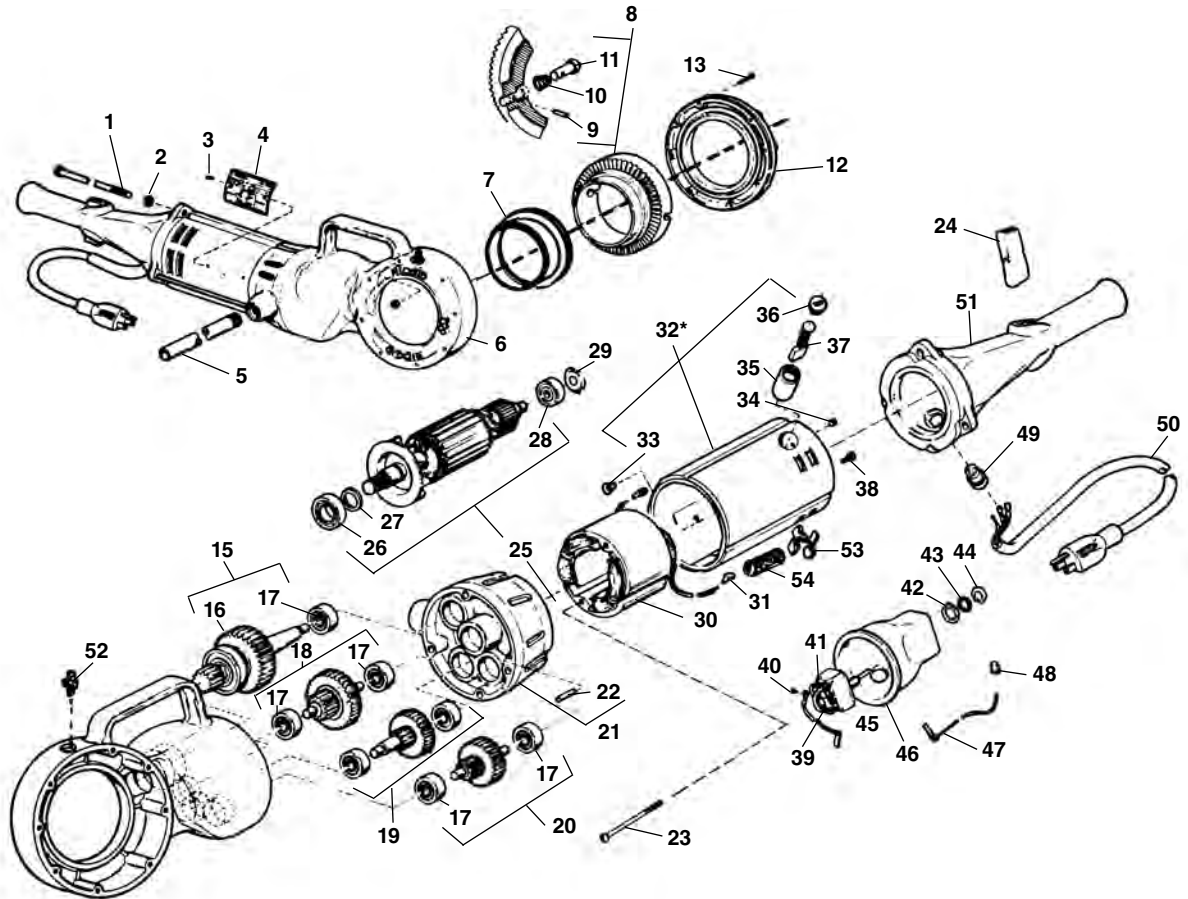
**Main Components**



**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	46760	Screw (3)	17	46930	Key 3/16" Sq. x 1/2"
2	62062	Top Cover	18	43355	Chip Tray
3	85920	Pop Rivet (8)	19	48337	Drain Plug
4	88690	Warning Plate	20	45440	Front Support Bar
5	46745	Screw	21	62057	Carriage Assembly
6	64447	1194 Motor, 115V, 36 RPM	22	47065	Hinge Pin
—	64452	1194 A Motor, 115V, 54 RPM	23	42365	341 Reamer Assembly
—	64457	2394 Motor, 230V, 36 RPM	24	44930	Stop Screw
7	44220	Screw (2)	25	43690	Cutter Arm
8	43795	Motor Bracket	26	45220	Rear Support Bar
9	46800	Set Screw (2)	27	47145	Spacer
10	61952	Base	28	45430	Pinion Gear
11	61947	Bottom Cover	29	47120	Lock Plate
12	45615	Screw (2)	30	46785	Screw 10 - 32 x 3/8" (2)
13	47110	Indicator Slide	31	47135	Stop Pin
14	47105	Indicator Bar	32	42390	820 Cutter Assembly
15	45420	Screw (5)	33	47585	Drive Shaft Assembly
16	46510	Handwheel			

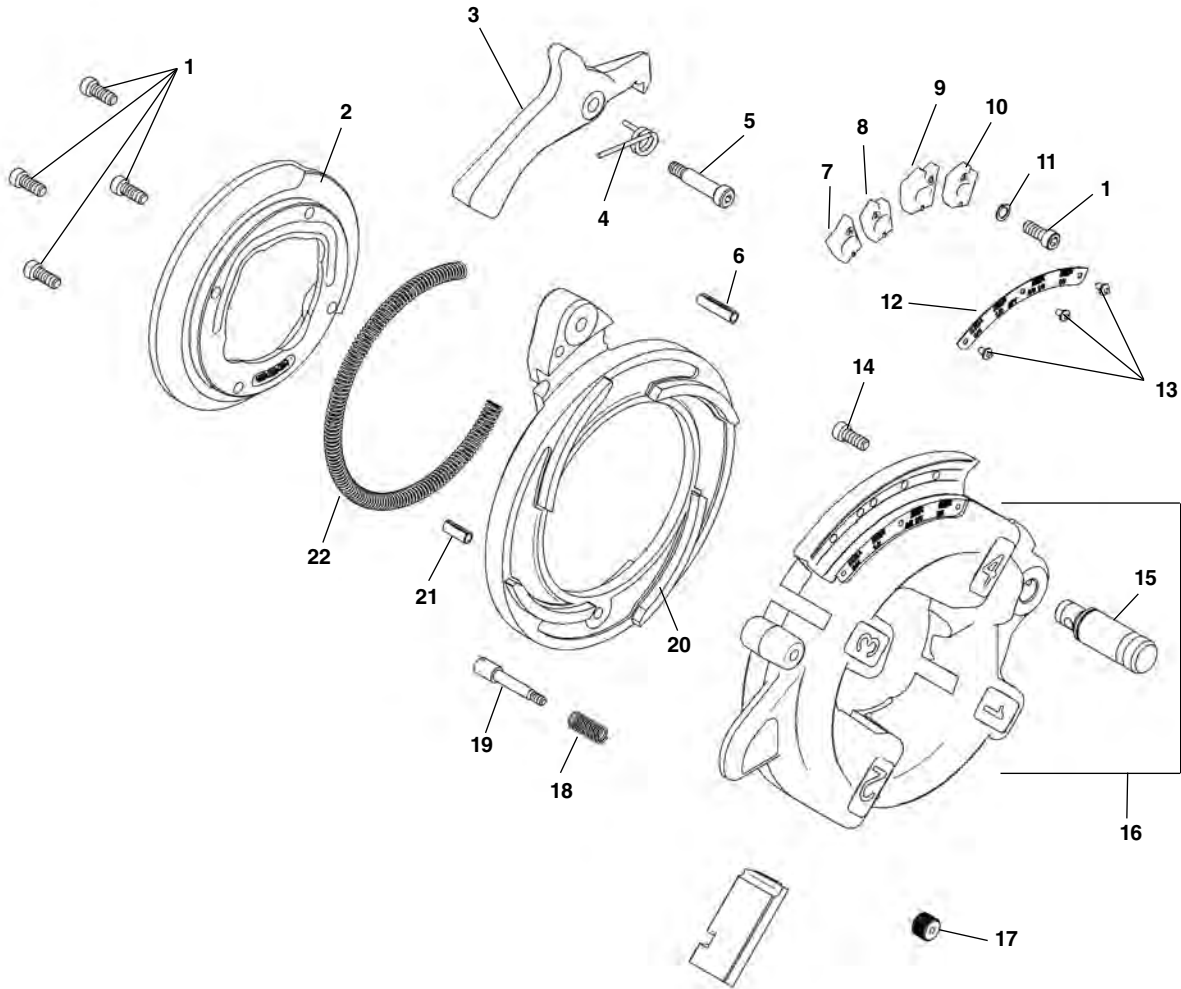
## Type 1



**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	44785	Tie Bolt (4)	28	44760	Bearing
2	40770	Lock Washer (4)	29	44790	Load Spring
3	85920	Pop Rivet (2)	30	44070	Field (115V) (Incl. Ref. No. 31)
4		Name Plate (115V) Name Plate (230V)		28922	Field (230V) (Incl. Ref. No. 31)
5	46615	Torque Arm	31	83895	Ring Tongue Terminal (2)
6	42970	Gear Case Assembly (Includes Ref. 7, 13, 14, 52)	32*		Motor Housing Assembly
7	44060	Bearing	33	44765	Lock Screw
8	43395	Face Gear Assembly	34	39770	Set Screw (2)
9	32475	Spring Pin (2)	35	44795	Brush Holder (2)
10	44915	Spring (2)	36	45660	Brush Cap (2)
11	44910	Adapter Pawl (2)	37	44815	Brush Assembly (2)
12	43345	Cover	38	45420	Ground Screw
13	46775	Screw (8)	39	44905	Switch
14	83890	Lock Nut (8)	40	46310	Screw (5)
15	44900	4th Gear Assembly	41	44890	Jumper (2)
16	76562	Bearing	42	75700	Lock Ring
17	45060	Bearing (7)	43	75695	Lock Washer (Internal Tooth)
18	44830	3rd Gear Assembly	44	46590	Lock Nut
19	44820	1st Gear Assembly	45	44880	Brush Lead (Blue)
20	44825	2nd Gear Assembly	46	43390	Switch Insulator
21	43335	Fan Housing Assembly	47	44885	Brush Lead (White)
22	45165	Dowel Pin	48	44635	Wire Nut
23	44555	Field Mtg. Screw (2)	49	46730	Cord Retainer
24	97260	Switch Button	50	89155	Service Cord (115V)
25	44055	Armature & Fan Assy. (115V)		44045	Service Cord (230V)
	44075	Armature & Fan Assy. (230V)	51	97255	Handle
26	44565	Bearing	52	46860	Grease Fitting
27	44430	Retaining Ring	53	41270	"X" Washer
			54	44755	Insulator Tube
			55	41620	Grease

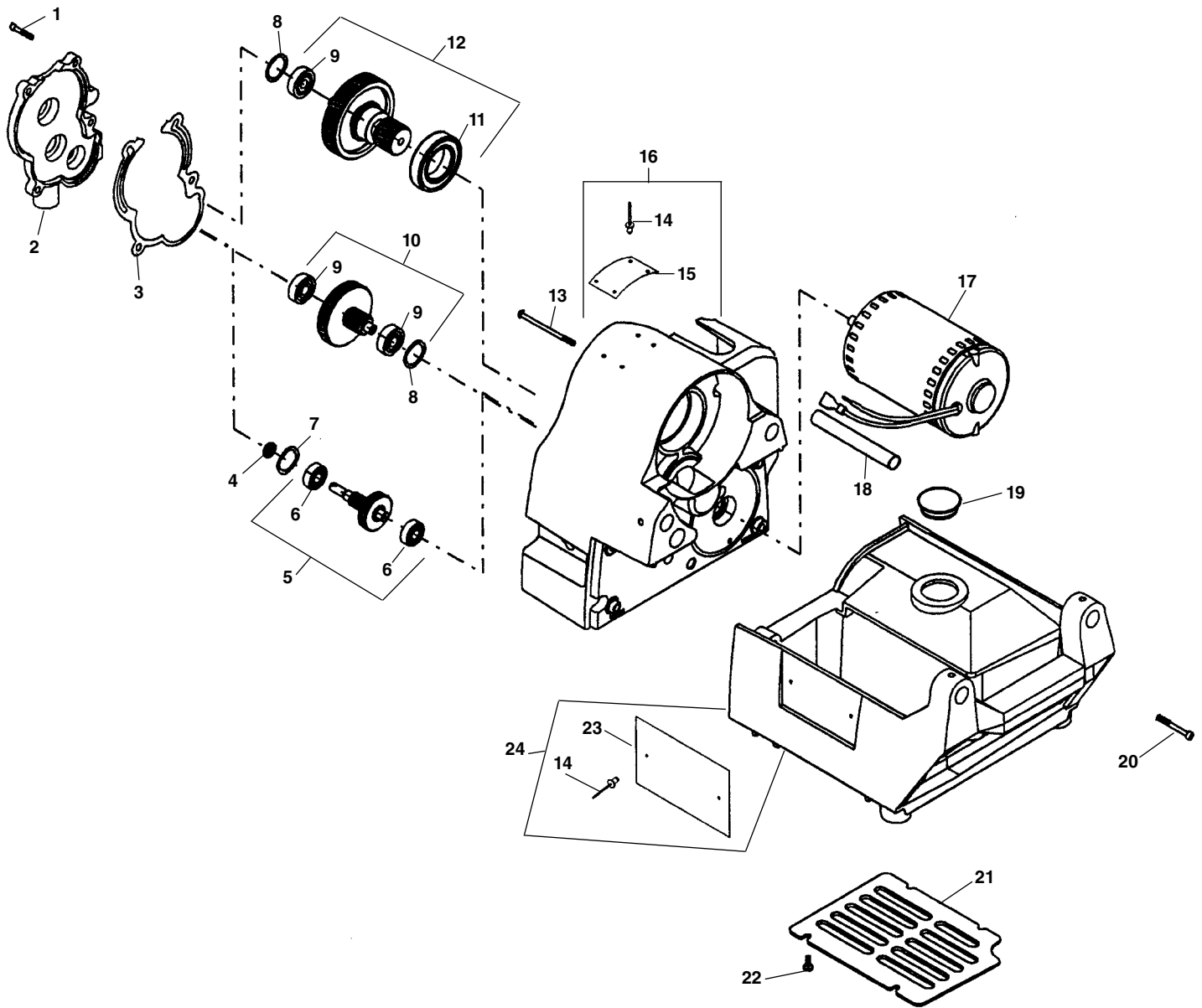
Note: \*Replace Type 1 Motor Housing with Type 2 components: 18676 Motor Housing, 27418 Warning Decal, 18486 Field Screws, 58542 Lock Washers, 18566 Sleeve, and Type 2 Field (27408 - 115V or 27413 - 230V). Does not include 44815 Motor Brushes.



**NOTE: Order parts by Catalog Number only.  
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Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
—	84537	816 Die Head 1/8" - 3/4"	11	44740	Split Lock Washer, 1/4" (4)
—	84532	817 Die Head 1" - 2"	12	92772	Size Plate 816 1/8" - 3/4"
1	40910	Screw, 1/4" - 20 x 3/4" S.H.C.S. (8)		92777	Size Plate 817 1" - 2"
2	92767	Retaining Ring	13	85920	Pop Rivet 3/32" (3)
3	92822	Handle	14	32145	Screw, 1/4" - 20 x 1/2" S.H.C.S.
4	92817	Spring	15	59832	Die Head Post
5	92812	Shoulder Bolt	16	92757	Die Head Body w/Post
6	92832	Roll Pin 1/4" x 5/8"	17	92802	Plunger Knob
7	92782	Adjusting Block 816/817 3/4", 2" Type A	18	92807	Plunger Spring
8	92782	Adjusting Block 816 1/2" Type B	19	92797	Plunger Shaft
	92782	Adjusting Block 817 1 1/2" Type A	20	92762	Cam Plate
9	92792	Adjusting Block 816 1/4", 3/8" Type C	21	58090	Roll Pin 1/4" x 1"
	92787	Adjusting Block 817 1 1/4" Type B	22	92827	Spring
10	92787	Adjusting Block 816/817 1/8", 1" Type B			

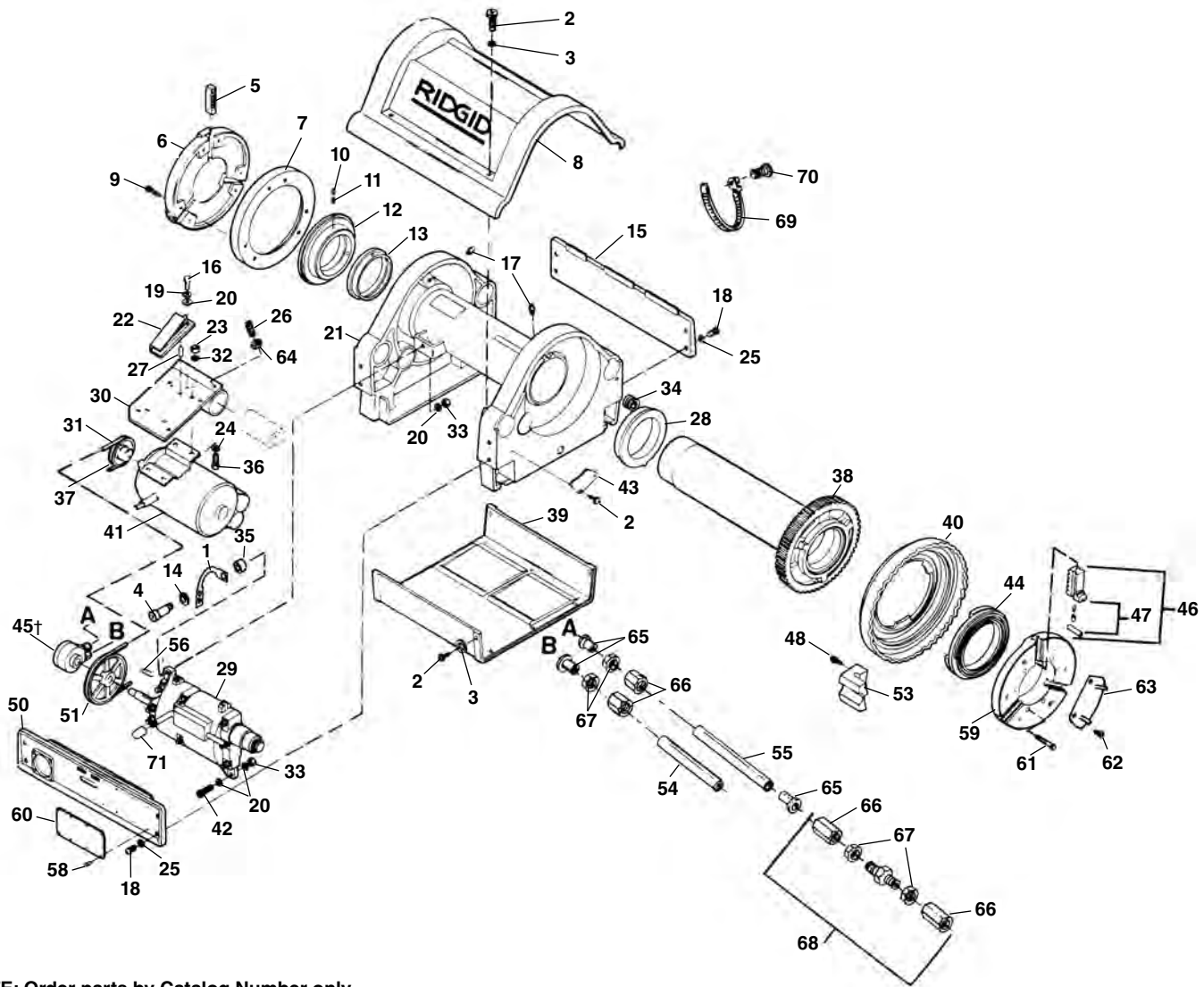
Drive Components



NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	40910	Screw 1/4" - 20 x 1/2" Soc. Hd. (4)	14	85920	Pop Rivet 3/32" (6)
2	69362	Gear Case Cover	15	69347	Warning Plate
3	69332	Gear Case Gasket	16	69227	Spindle Housing w/Spindle Bearings
4	96880	Seal	17	69222	Motor 115V
5	69207	1st Intermediate Gear Assembly		72362	Motor 230V
6	59147	Ball Bearing (2)		72402	Motor 100V
7	35365	Wave Spring	18	59342	Insulator Sleeve
8	68037	Wave Spring	19	69367	Brush Cover Plastic Plug
9	44760	Ball Bearing (3)	20	40657	Screw 1/4" - 20 x 1 1/2" Soc. Hd. (4)
10	69212	2nd Intermediate Gear Assembly	21	69252	Motor Cover
11	69277	Ball Bearing	22	79965	Screw #10 - 32 x 1/2" Pan Head (4)
12	69217	Main Drive Gear Assembly	23	69387	Name Plate
13	69402	Screw #10 - 32 x 4" Pan Head (2)	24	69242	Base

Main Drive Components



**NOTE: Order parts by Catalog Number only.  
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Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	33622	Pump Bracket	25	40930	Lock Washer 3/8" (8)	46	40087	Chuck Jaw Set
2	41597	Screw (12)	26	88265	Set Screw 3/8" - 16 x 1"	47	47517	Chuck Jaw Set Pl. Ctd. Pipe
3	41592	Washer (10)	27	88230	Roll Pin 1/4" x 9/16"	47	54212	Jaw Insert Set
4	33627	Screw	28	26767	Front Bearing	26247	26247	Jaw Insert Set F/Coated Pipe
5	32412	Centering Jaw Set	29	26362	Gear Box Assy.	48	27067	Self-Tapping Screw (2 Req. f/G.S.)
6	26537	Centering Head	30	27062	Motor Bracket	50	59722	Front Side Plate
7	26542	Back Plate	31	26832	V-Belt	51	26852	Gear Box Pulley
8	26477	Top Cover	32	40770	Lock Washer 5/16" (4)	53	26507	Pinch Point Cover Boss (2 Req. f/G.S.)
	46867	Die Head Decal (Not Shown)	33	27517	Lock Nut 5/16" - 18	54	27007	Inlet Hose
9	40910	Screw 1/4" - 20 x 3/4" (6)	34	47080	Grommet	55	26822	Output Hose
10	45300	Set Screw 5/16" - 24 x 1/4" (3)	35	33617	Spacer	56	27002	Key
11	45265	Set Screw 5/16" - 24 x 1/2" (3)	36	85910	Bolt 5/16" - 18 x 1 1/4"	58	85920	Rivets (8)
12	32407	Scroll	37	26857	Motor Pulley (60 Hz)	59	26332	Chuck Cap
13	26352	Rear Bearing		27082	Motor Pulley (50 Hz)	60	88690	Safety Plate
14	26307	Washer	38	26347	Drive Gear/Spindle Assy.	61	26522	Screw 5/16" - 24 x 2 1/4" (6)
15	26487	Rear Side Plate	39	26482	Bottom Cover	62	27242	Screw 10 - 32 (6)
16	32145	Screw 1/4" - 20 x 1/2"	40	26337	Handwheel	63	33612	Set of 3 Cover Plates
17	46860	Grease Fitting (2)	41	26237	Motor w/Capacitor 120V, 60 Hz	64	83545	Jam Nut 3/8" - 16
18	26997	Screw 3/8" - 16 x 3/4" (8)		27287	Motor w/Capacitor 110V, 50 Hz	65	35117	Tube Insert (3)
19	44740	Lock Washer 1/4"		26232	Motor w/Capacitor 240V, 60 Hz	66	40602	Compression Nut
20	96740	Washer 5/16"		27282	Motor w/Capacitor 220/240V, 50 Hz	67	40607	Ferrule
21	26357	Base	42	27037	Shoulder Bolt	68	26972	Union
22	26492	Belt Tensioner	43	27012	Pinion Guard	69	43552	Tie Down Strap
23	96730	Nut 5/16" - 18 (4)	44	26517	Scroll	70	45275	Screw 10 - 24 x 1/2"
24	27402	Washer 5/16" (4)	45†	27307	Oil Pump	71	27032	Shifter Knob