

INSTRUCTION MANUAL

FOR

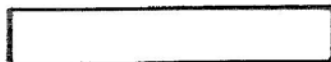
DA

DOUBLE END TENONER

AND PROFILE

BOOK NO. B866

It is our policy and that of our suppliers to review constantly the design and capacity of our products. With this in mind we would remind our customers that whilst the dimensions and performance data contained herein are current at the time of going to press, it is possible that, due to the incorporation of latest developments to enhance performance, dimensions and supplies may vary from those illustrated.



PLEASE INSERT SERIAL NUMBER OF MACHINE

Instruction Manual For

DA

Double End Tenoner and Profile

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FOR REPLACEMENT PARTS, TOOLS AND ACCESSORIES, CONTACT:-

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HEALTH & SAFETY

SAFETY OF WOODWORKING MACHINES

Woodworking machines can be dangerous if improperly used. The wide range of work of which they are capable, requires adequate safeguarding arrangements against possible hazards.

Many injuries to machinists are caused by carelessness or failure to use the guards provided or to adjust them correctly.

WADKIN LTD., supply machinery designed for maximum safety which they believe, as a result of thorough testing, minimizes the risks inevitable in their use. It is the user's responsibility to see that the following rules are complied with to ensure safety at work:

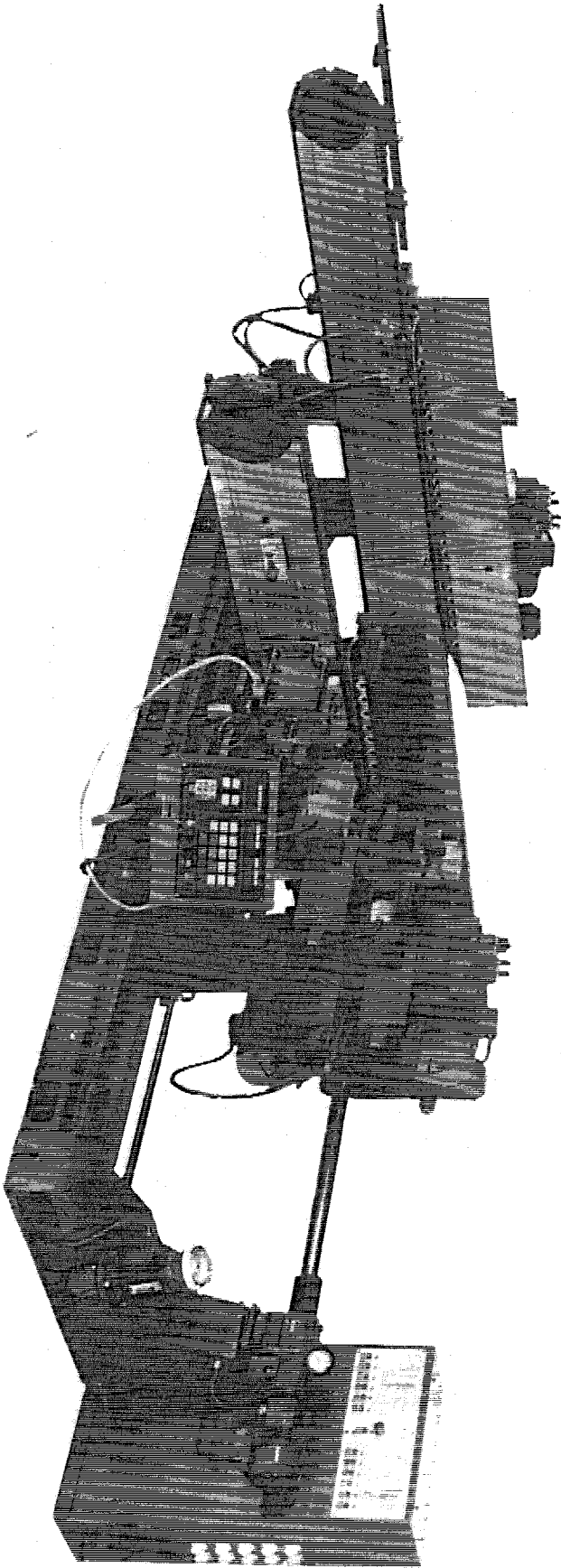
1. The operation of the machine should conform to the requirements of the Woodworking Machines Regulations 1974. All guards should be used and adjusted correctly.
2. Safe methods of working only should be adopted as given in the Health and Safety Work Booklet No.41, "Safety in the Use of Woodworking Machines", (obtainable from Her Majesty's Stationery Office) and as advised by Wadkin Ltd.
3. Only personnel trained in the safe use of a machine should operate it.
4. Before making adjustments or clearing chips, etc., the machine should be stopped and all movement should have ceased.
5. All tools and cutters must be securely fixed and the speed selected must be appropriate for the tooling.

SAFETY IS OUR WATCHWORD BUT THE USER MUST COMPLY WITH THE ABOVE RULES IN HIS OWN INTEREST. WE WOULD BE PLEASED TO ADVISE ON THE SAFE USE OF OUR PRODUCTS.

Safety

CAREFULLY READ INSTRUCTION MANUAL WITH PARTICULAR REFERENCE TO THE FOLLOWING INSTRUCTIONS:-

1. SLINGING, i.e. SAFE LIFTING LIMITS FOR SLINGS ETC.
2. INSTALLATION AND FOUNDATION, i.e. SAFE WORKING AREA OF MACHINE AND BOLT POSITIONS, ETC.
3. WIRING DETAILS, i.e. WIRING DIAGRAM AND INSTRUCTIONS FOR SAFE WIRING OF MACHINE.
4. MACHINE CONTROLS AND OPERATING INSTRUCTIONS.
5. SELECT CORRECT SPEED FOR CUTTER EQUIPMENT AND ENSURE CUTTERS ARE SECURELY LOCKED IN POSITION.
6. SET GUARDS CORRECTLY TO COVER CUTTER EQUIPMENT AS MUCH AS POSSIBLE.
7. NOTE START/STOP CONTROL POSITION AND ISOLATOR SWITCH POSITION (IF FITTED) BEFORE OPERATING MACHINE.
8. USE FEEDING DEVICES WHERE POSSIBLE.
9. REFER TO HEALTH AND SAFETY AT WORK BOOKLET No.41 (IN U.K.) FOR SAFETY IN THE USE OF WOODWORKING MACHINERY.
10. THIS MACHINE, WHEN UNDER WORKING CONDITIONS, MAY PRODUCE A NOISE LEVEL IN EXCESS OF 90 D.B. "WADKIN" PLC., WILL SUPPLY INFORMATION ON ACOUSTICAL ENCLOSURES ON REQUEST, AND WILL REQUIRE A WRITTEN UNDERTAKING THAT THE NECESSARY STEPS WILL BE TAKEN TO ENSURE THAT THE MACHINE IS ONLY USED IN COMPLIANCE WITH THE TERMS OF HEALTH AND SAFETY AT WORK -ACT 1974.



Double End Tenoner and Profile Machine Type DA

FIG. 1

BASIC MACHINE SPECIFICATIONS FOR DA

Max. Thickness of material admitted with idle pressures 250mm
 Max. Thickness of material admitted with driven pressures 130mm
 Max. distance across outside of chain tracks 1760mm or 1200mm if sound enclosures fitted.
 Max. distance across outside of chain track 2760mm or 2200mm if sound enclosures fitted.
 Max. distance across outside of chain track 3460mm or 2900mm if sound enclosures fitted.
 Min. distance across outside of chain tracks 150mm
 Feed drive from combined gearbox/variable speed unit to give speeds 3-18 metres/minute.

MODELS AVAILABLE

<u>MODEL</u>	<u>INFEED</u>	<u>NO. OF PITCHES</u>
DA48/A	500mm	48
DA56/A	900mm	56
DA64/A	1300mm	64
DA56/B	500mm	56
DA64/B	900mm	64
DA56/C	500mm	56
DA64/C	900mm	64
DA48/D	500mm	48
DA56/D	900mm	56
DA64/D	1300mm	64
DA56/E	350mm	56
DA64/E	750mm	64

HEADS AVAILABLE

'A' TYPE - DIRECT DRIVEN
 'B' TYPE - BELT DRIVEN
 'C' TYPE - DIRECT DRIVEN

'A' TYPE HEAD

OUTPUT - 3.7kw, 5.5kw or 7.5kw

SPINDLE SPEEDS	50 CYCLE	3000 RPM
	50 CYCLE HIGH FREQUENCY	6000 RPM
	60 CYCLE	3600 RPM
	60 CYCLE HIGH FREQUENCY	7200 RPM

SPINDLE DIAMETERS - 35mm, 30mm or 1¼"

'B' TYPE HEAD

OUTPUT - 3.7kw or 5.5kw

SPINDLE SPEEDS - 3000 and 6000 RPM
 4500 and 6000 RPM

SPINDLE DIAMETERS - 35mm, 30mm or 1¼"

'C' TYPE HEADS

OUTPUT - 4.5kw

'C' TYPE HEADS (Cont...)

SPINDLE SPEEDS - 50 CYCLE	3000 RPM
50 CYCLE HIGH FREQUENCY	6000 RPM
60 CYCLE	3600 RPM
60 CYCLE HIGH FREQUENCY	7200 RPM

SPINDLE DIAMETER - 35mm or 1 $\frac{1}{4}$ "

SCORERS AVAILABLEFOR USE WITH 'A' TYPE HEADS

S7 - Head mounted belt driven canting jump scorer 0.55kw with 30mm dia saw spindle having speed of 6000 rpm.

S9 - Head mounted tilting and pneumatically jump scorer 1.1kw - 3000 rpm with 30mm dia saw spindle.

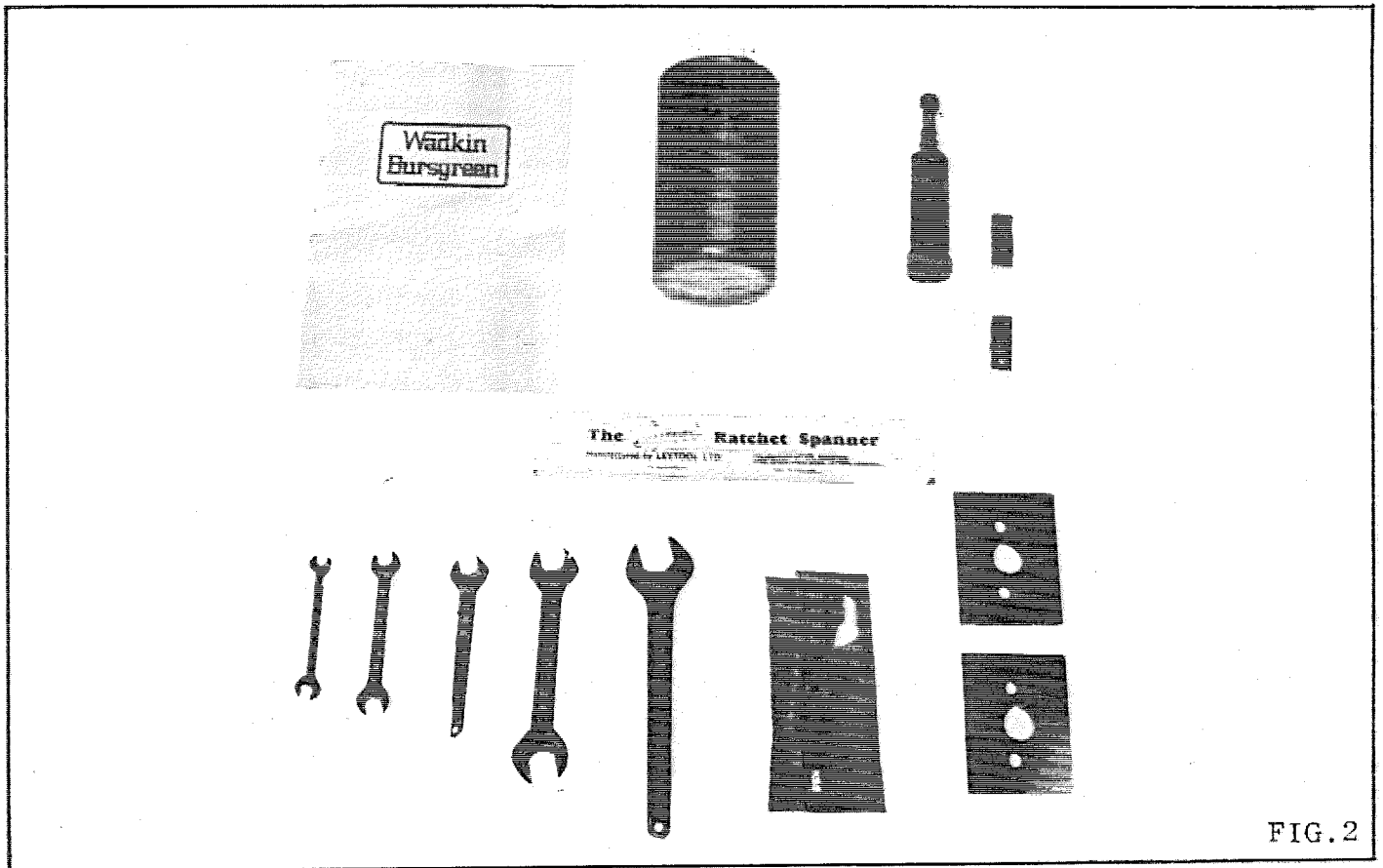
FOR USE WITH 'C' TYPE HEADS

S6 - Beam mounted belt driven non-canting jump scorer 0.55kw with 30mm dia saw spindle having speed of 6000 rpm.

S8 - Beam mounted direct driven non-tilting jump scorer 1.1kw 3000 rpm with 30mm dia saw spindle.

SECTION A

STANDARD ITEMS DESPATCHED WITH MACHINE



- 1 - Instruction Manual
- 1 - Ltr Shell Tellus 27 Oil - (Pneumatic Equipment)
- 1 - J E Adams Pom-Pom Gun No. 770151
- 2 - Shear Pins DL525
- 1 - 5/8" A/F Square Ratchet Lever
- 1 - Full set of Metric Open Ended Spanners 7,8,10,13 & 24 S/E,
17/19 D/E.
- 1 - Full set of Metric Hexagon Socket Wrenches in Pouch
- 2 - Top Pads DA5

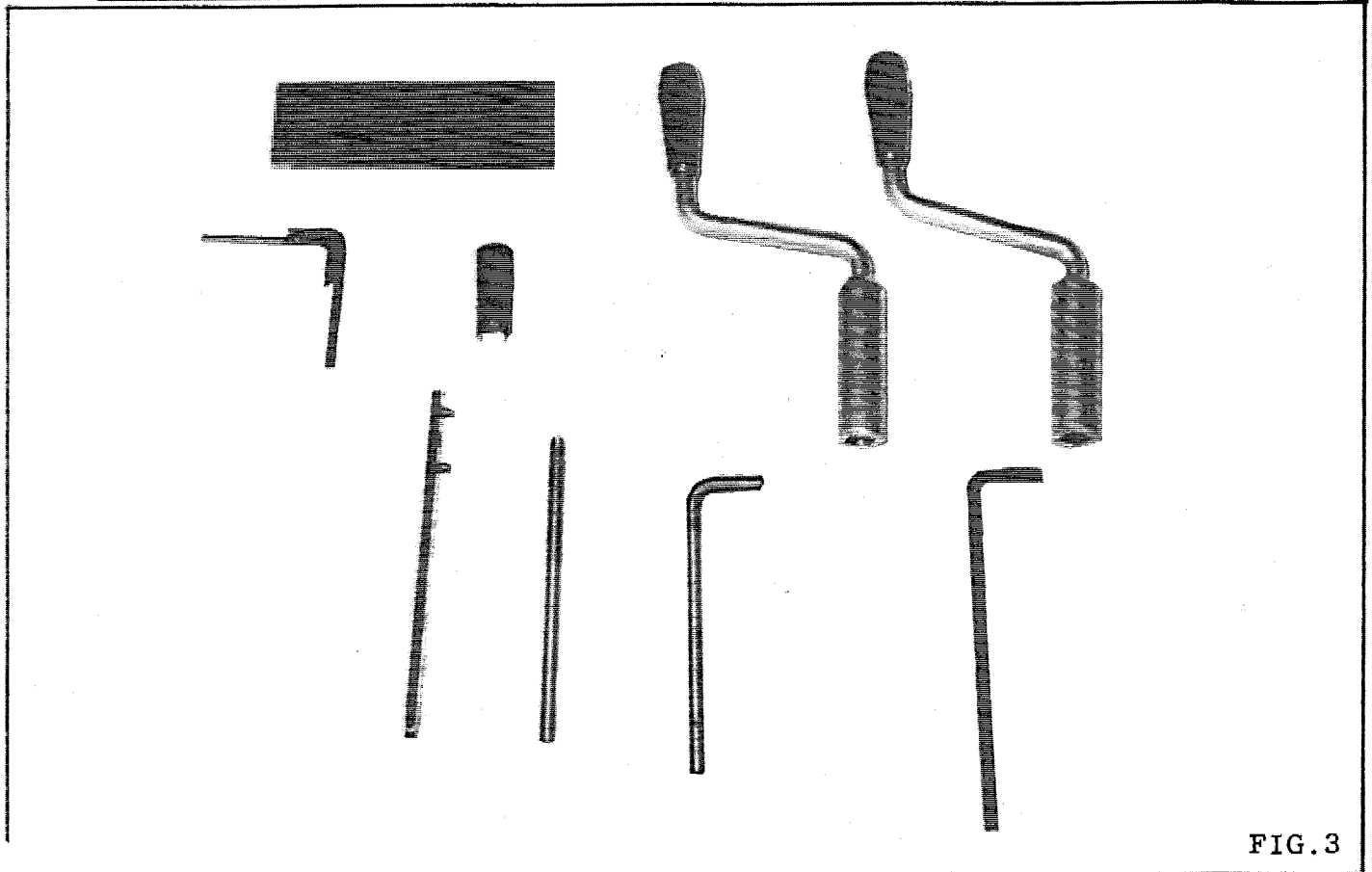
SECTION A (Cont..)STANDARD ITEMS DESPATCHED WITH MACHINE

FIG. 3

- 12 - Support Blocks DL726 - 1760 Capacity Bed
- 16 - Support Blocks DL726 - 2760 Capacity Bed
- 18 - Support Blocks DL726 - 3460 Capacity Bed
- 1 - 5/6mm Combined Hexagon Socket Wrench (when Flat Back Dogs
are supplied)
- 1 - Key for Disappearing Dogs 1079/509 (Supply only if Dogs are
fitted)
- 2 - Cranked Handles 1079/938
- 1 - Spanner for Scoring Saw 1079/667) Scoring Head when Fitted
- 1 - 3/8" Dia Toggle Bar)
- 1 - Toggle Bar 1079/1843 - 'B' Type Head when Fitted
- 1 - 8mm Allen Key - 'C' Type Head when Fitted

SECTION A (Cont..)

STANDARD ITEMS DESPATCH WITH MACHINE

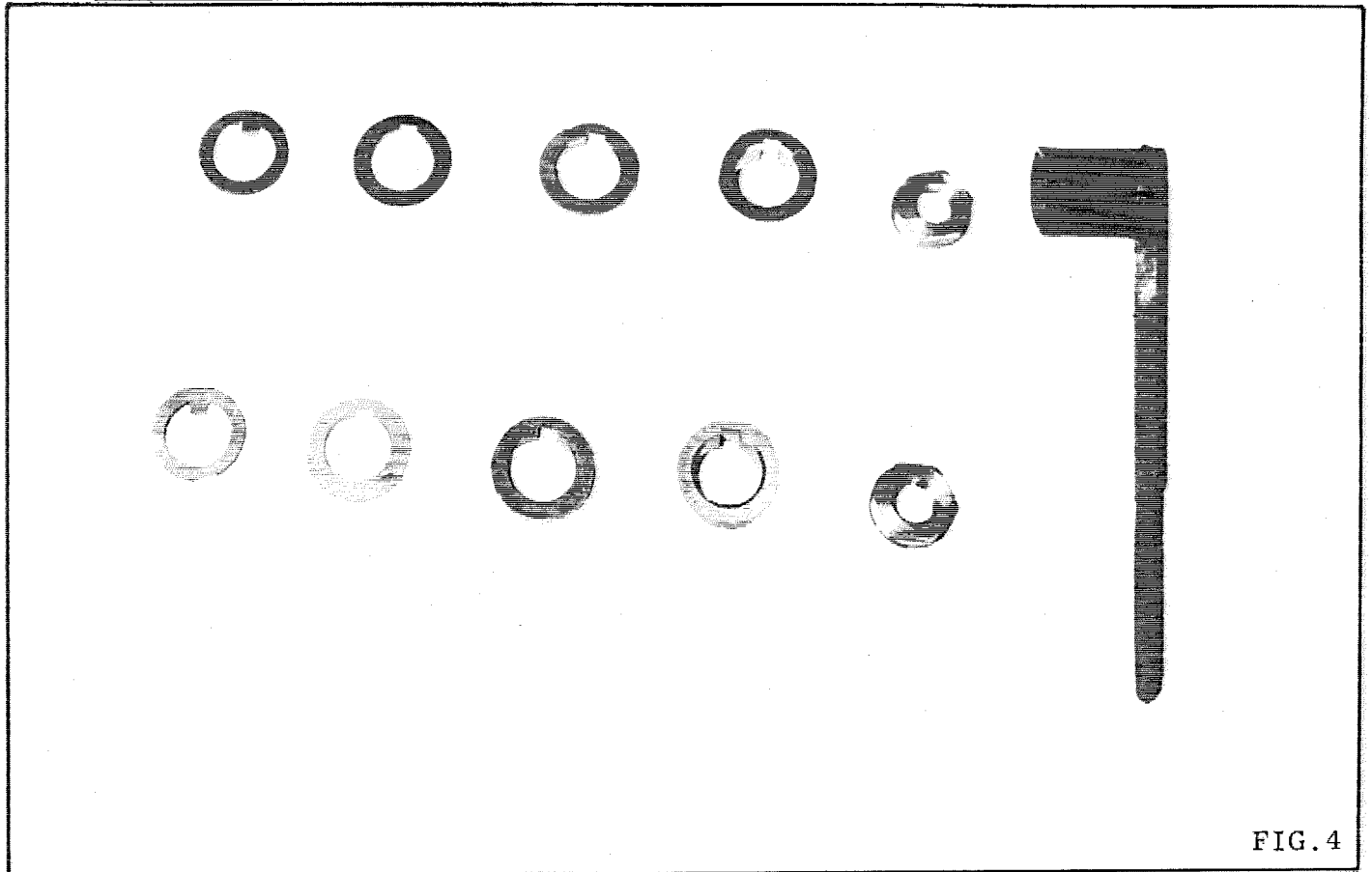


FIG. 4

35mm Spindle

- 2 - Washers for Spindle 1079/757
- 4 - 6mm Thick Spacing Washers
1079/969
- 4 - 12mm Thick Spacing Washers
1079/1234
- 4 - 25mm Thick Spacing Washers
1079/1235
- 2 - Spindle Nuts 1079/756
- 1 - Spanner for Spindle Nut QT66

40mm Spindle

- 4 - 6mm Thick Spacing Washers
1079/981
- 4 - 12mm Thick Spacing Washers
1079/1236
- 4 - 25mm Thick Spacing Washers
1079/1237
- 2 - Spindle Nuts 1079/1781
- 1 - Spanner for Spindle Nut QT66

1 1/4" Spindle

- 2 - Washers for Spindle
1079/762
- 4 - 1/4" Thick Spacing Washers
1079/967
- 4 - 1/2" Thick Spacing Washers
1079/1230
- 4 - 1" Thick Spacing Washers
1079/1231
- 2 - Spindle Nuts 1079/756
- 1 - Spanner for Spindle Nut
QT66

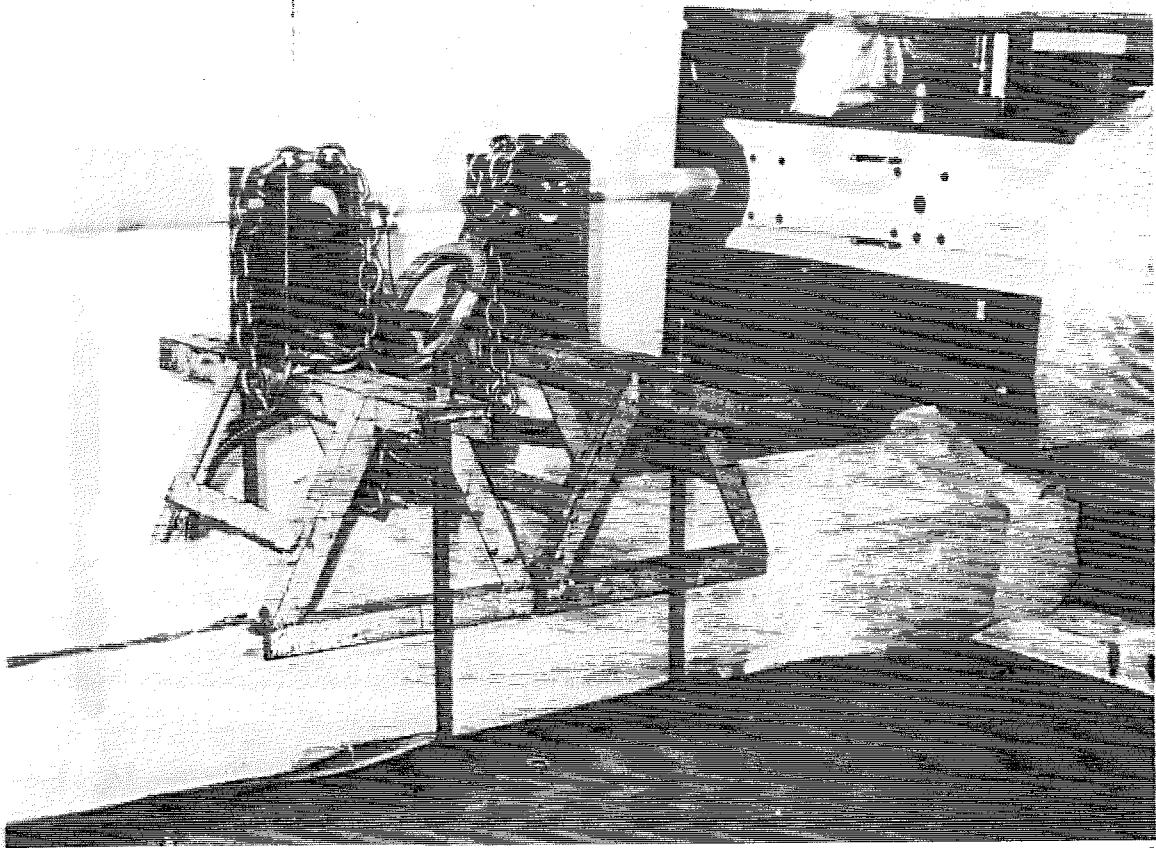


FIG. 5

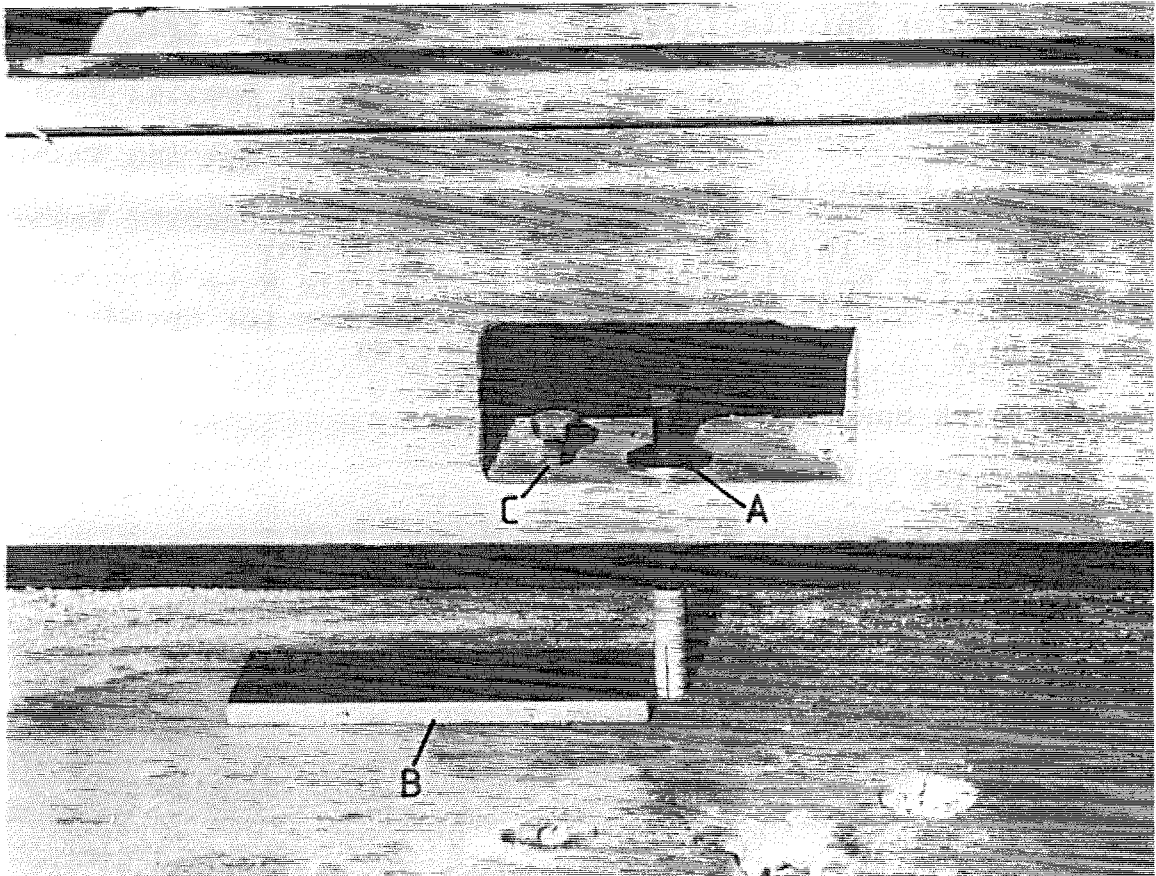


FIG. 6

SECTION BINSTALLATIONSLINGING

Secure lifting gear to the cradles supplies and move machine into position FIG.5.

IMPORTANT: DO NOT WALK OR STAND UNDER MACHINE DURING SLINGING OPERATION.

NOTE: Upon completion of slinging the cradles should be returned to Bursgreen (Durham), Division of Wadkin PLC, for credit.

CLEANING

Clean protective coating from all bright parts by applying a cloth soaked in paraffin, turpentine or other solvent.

MARKING OUT

Mark out floor, using foundation plan enclosed with machine and drill to suit 16mm ragbolts. These are not supplied with the machine but are available on request at additional charge.

LEVELLING

- 1 Refer to SLINGING and move machine into position, ensuring all holes in machine base locate on 16mm ragbolts "A" FIG.6 .
- 2 Fit steel packing pieces "B" beneath levelling screws "C" in the base of the machine, FIG.6.
- 3 Level bed using levelling screws, screwing them down on to packing pieces. Bed should be within 0.1mm per 1000mm (0.001" in 10").
IMPORTANT: ALWAYS USE AN ENGINEERS'S SPIRIT LEVEL, FIG.7.
- 4 Fully tighten all the 16mm ragbolts protruding through holes in machine base and re-check levelling, adjust if necessary.

RE-ASSEMBLY OF MACHINEDA56 MACHINES WITHOUT DRIVEN TOP PRESSURES (HOME OR EXPORT MARKET)

The following parts are removed, front idle sprockets, front and rear chain beam guards, to re-assemble proceed as follows:-

Front Idle Sprockets (This operation applies to both chain beams)

- 1 Release 8mm allen screws with long arm hexagon wrench "A" FIG.8 (supplied), in either side of each chain beam. Turn cam "B" to release chain tension.
- 2 Fit front idle sprocket "C" FIG.9.
- 3 Complete chain track as shown FIG.10.
- 4 Re-tension chain track by cam and locking with 8mm allen screws. (Correct tension is achieved when idle sprockets oscillates when track is running).
- 5 Fit front and rear chain beam guards.

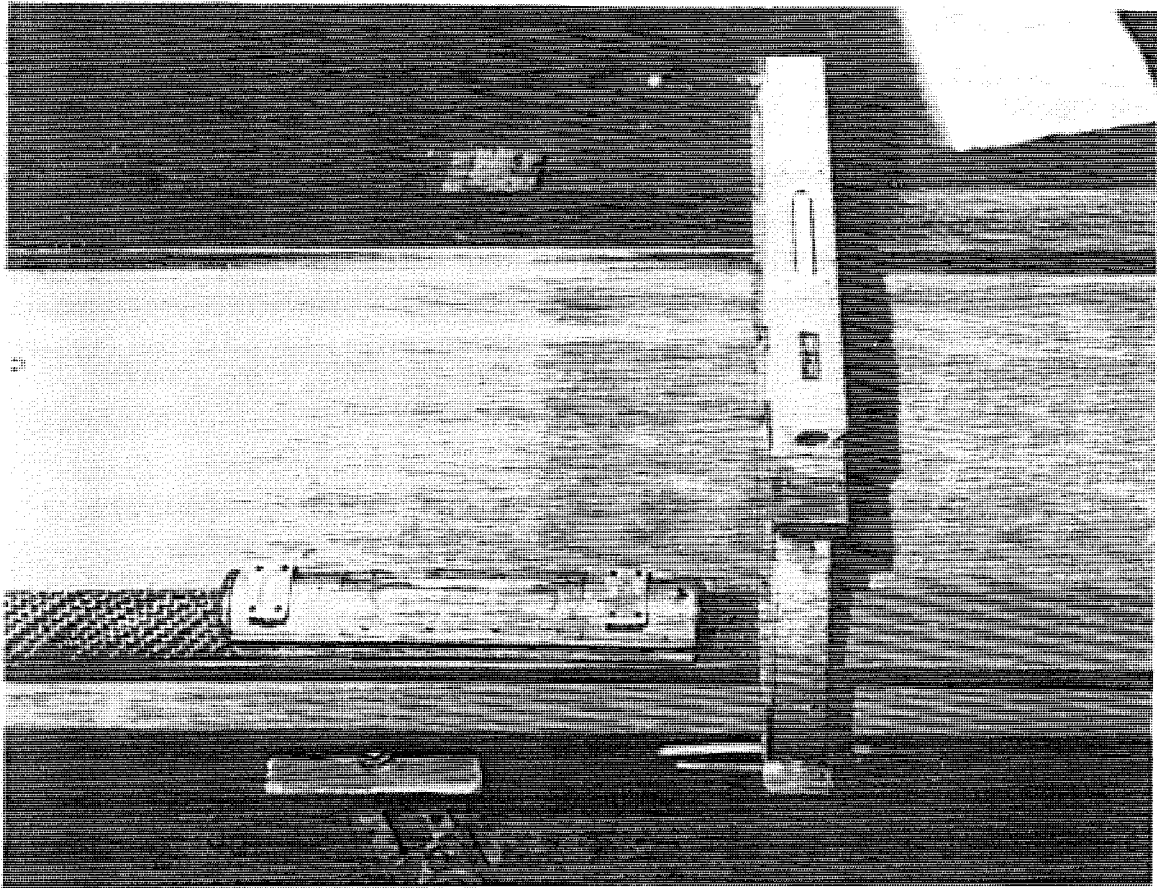


FIG. 7

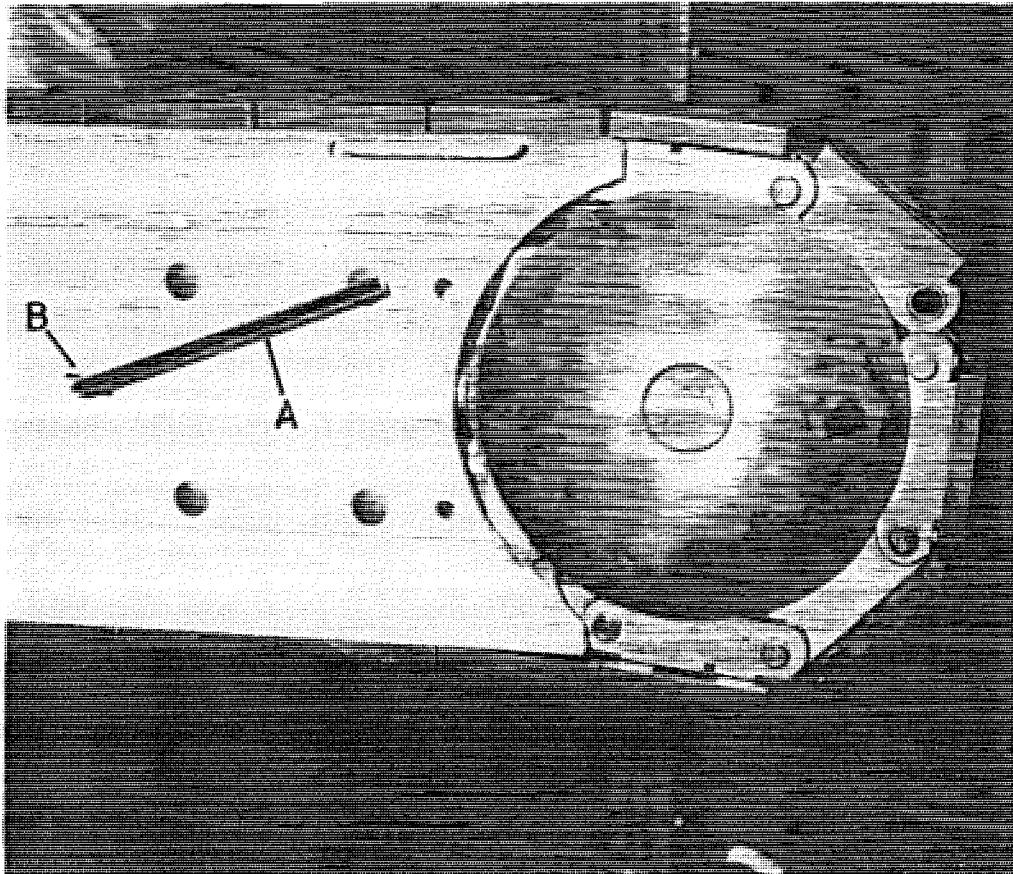


FIG. 8

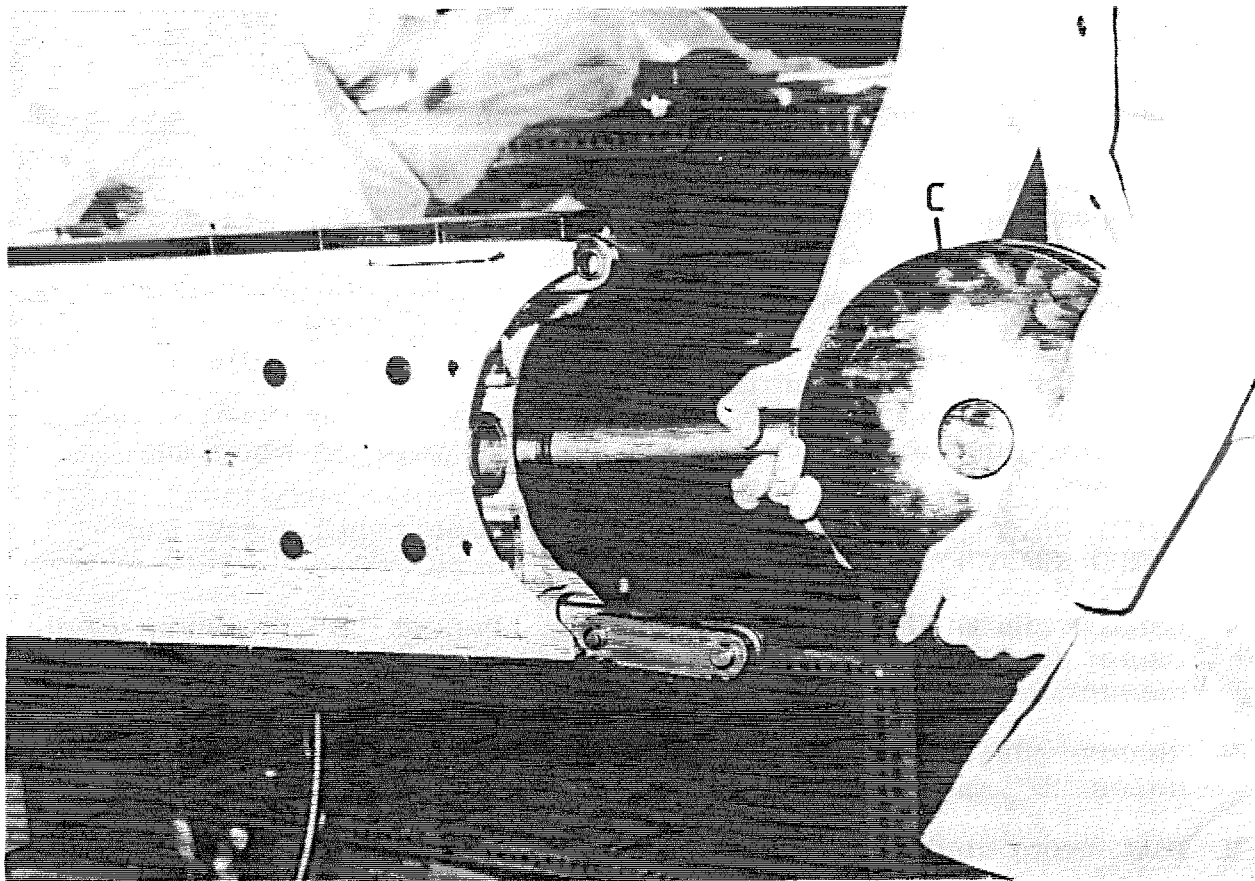


FIG. 9

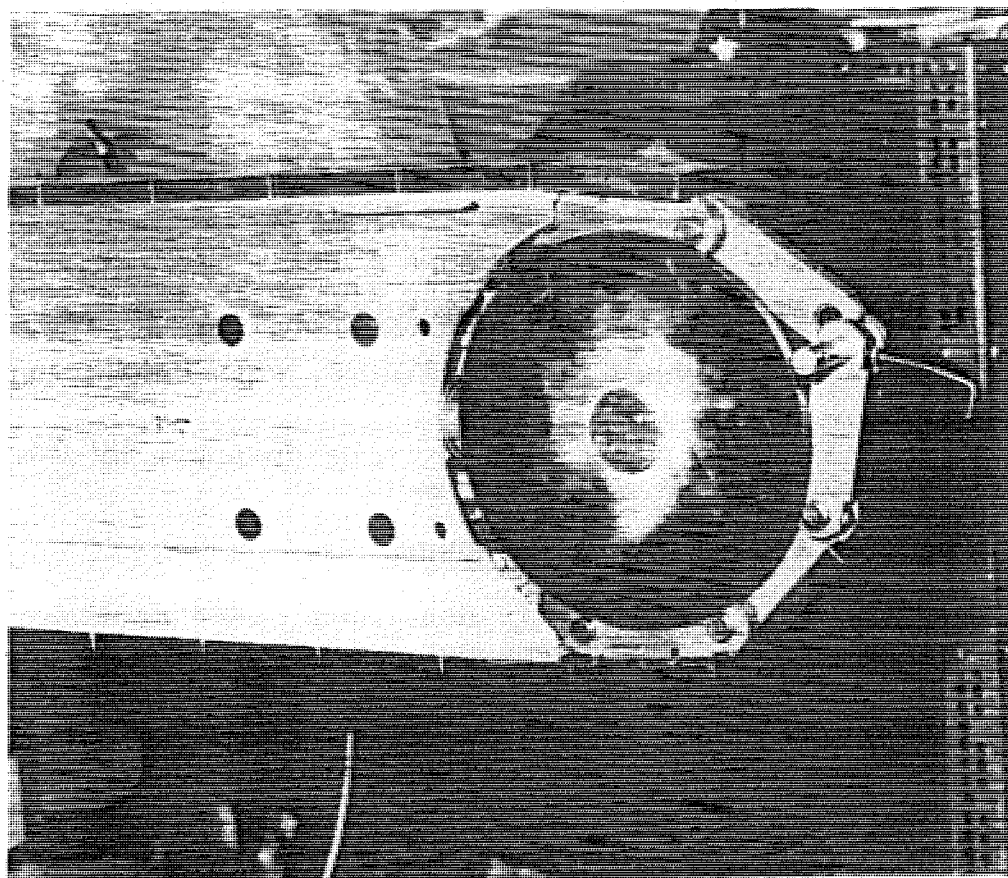


FIG. 10

SECTION B (Cont..)RE-ASSEMBLY OF MACHINESDA64 MACHINES WITHOUT DRIVEN TOP PRESSURES (HOME OR EXPORT MARKET)

The following parts are removed, chain beams, front and rear chain beam guards, to re-assemble, proceed as follows:-

Fixed and Adjustable Columns

- 1 Place sling around chain beam "A" FIG.11, then lift into a position near to mounting bracket "B".
- 2 Connect junction block "C" to 8mm air pipe in mounting bracket "B".
NOTE: On adjustable column connect electrical wires for 'FEED SWITCH' operation.
- 3 Locate chain beam "A" to mounting bracket "B" by means of taper dowel in hole "D" and secure with M10 locknut and washer.
- 4 Secure chain beam by 4 - M12 fixing studs "E" fitted through holes "F" and secured with M12 nuts and washers.
- 5 Fit front and rear chain beam guards.

Re-Assembly of Backshaft - 64 Pitch only

NOTE: CHECK BACKSHAFT IS CLEAN AND FREE FROM BURRS.

The backshaft should be re-fitted as follows:-

- 1 Insert backshaft "G" FIG.12 through 2 chain beam driving sprockets ensuring keys in driving sprocket locate in keyway of backshaft and locate in backshaft coupling "H" FIG.13.
- 2 Secure shearkey in coupling "H" FIG.13, with socket capscrew "J".
- 3 Secure backshaft in fixed beam driving sprocket by 8mm socket capscrew fitted to driving sprocket.

MACHINES FITTED WITH AUXILIARY COLUMNS

Follow instruction as previously described (DA64 machines) at the same time locate taper dowel and 3 studs on chain beam into auxiliary column secure with nuts and washers (supplied with machine).

MACHINE WITH CHAIN BEAM TIES

Fit chain beam tie "K" FIG.14 from auxiliary column to chain beam.

NOTE: CARE MUST BE TAKEN WHEN SECURING TIES NOT TO DISTORT CHAIN BEAM.

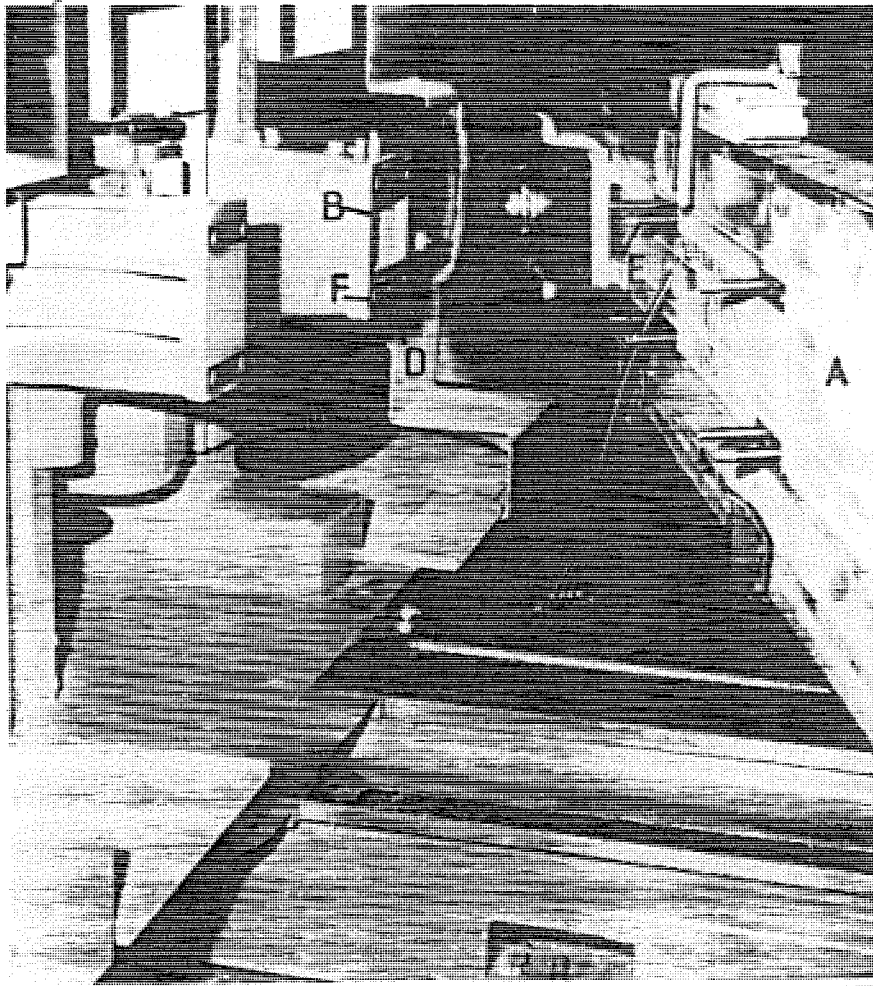


FIG. 11

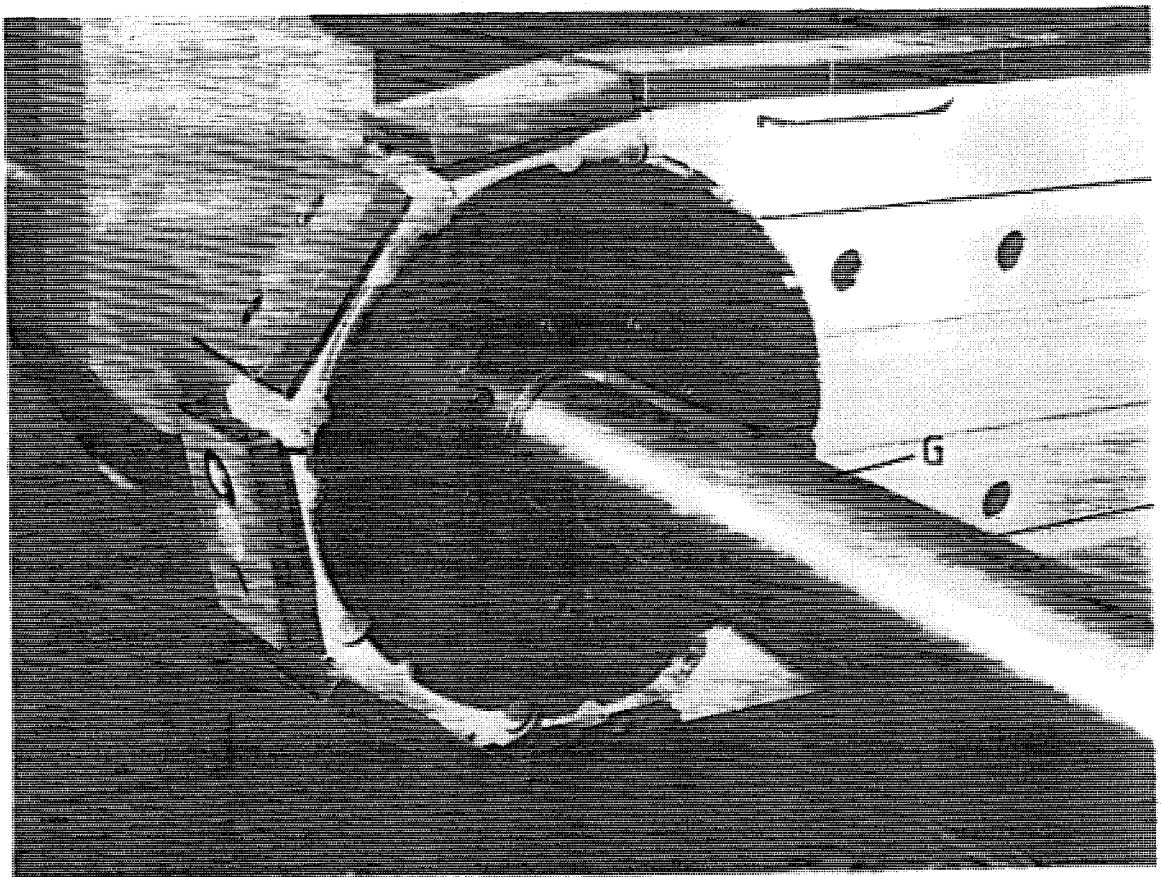


FIG. 12

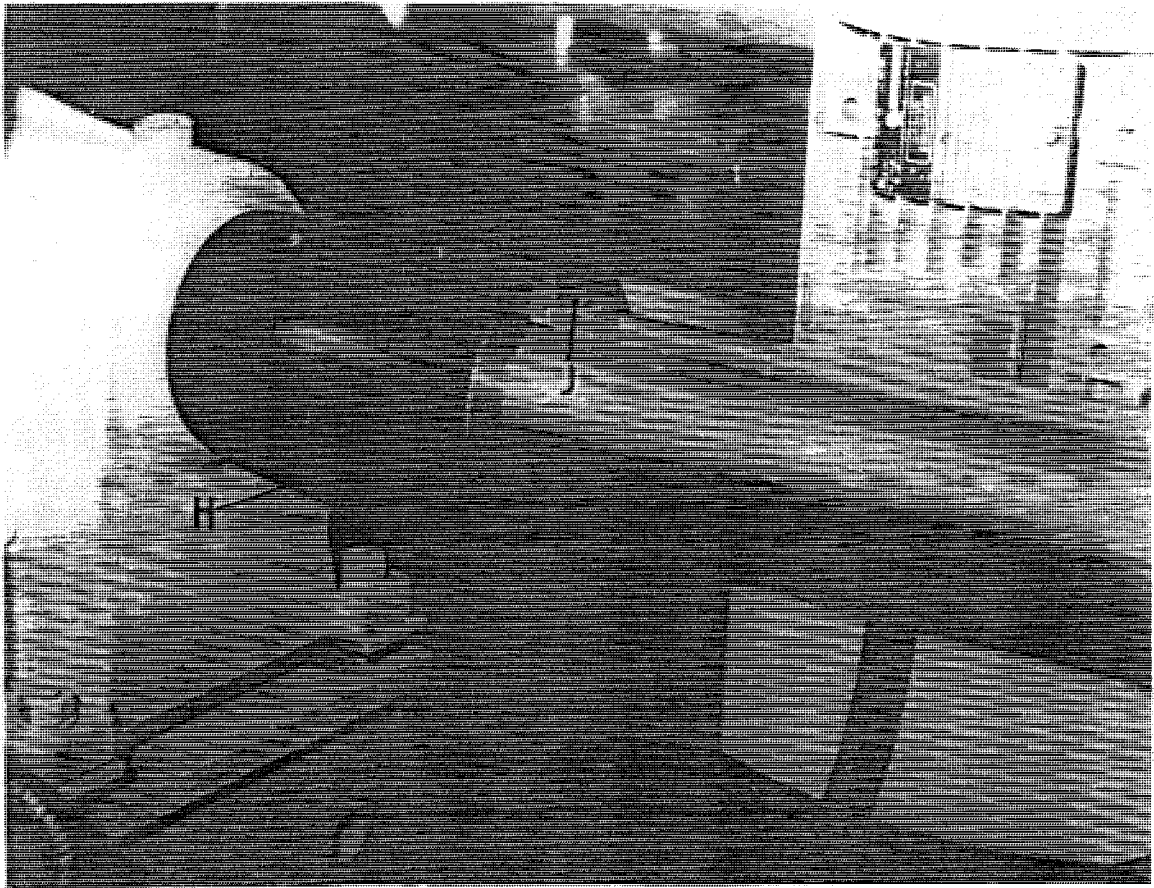


FIG. 13

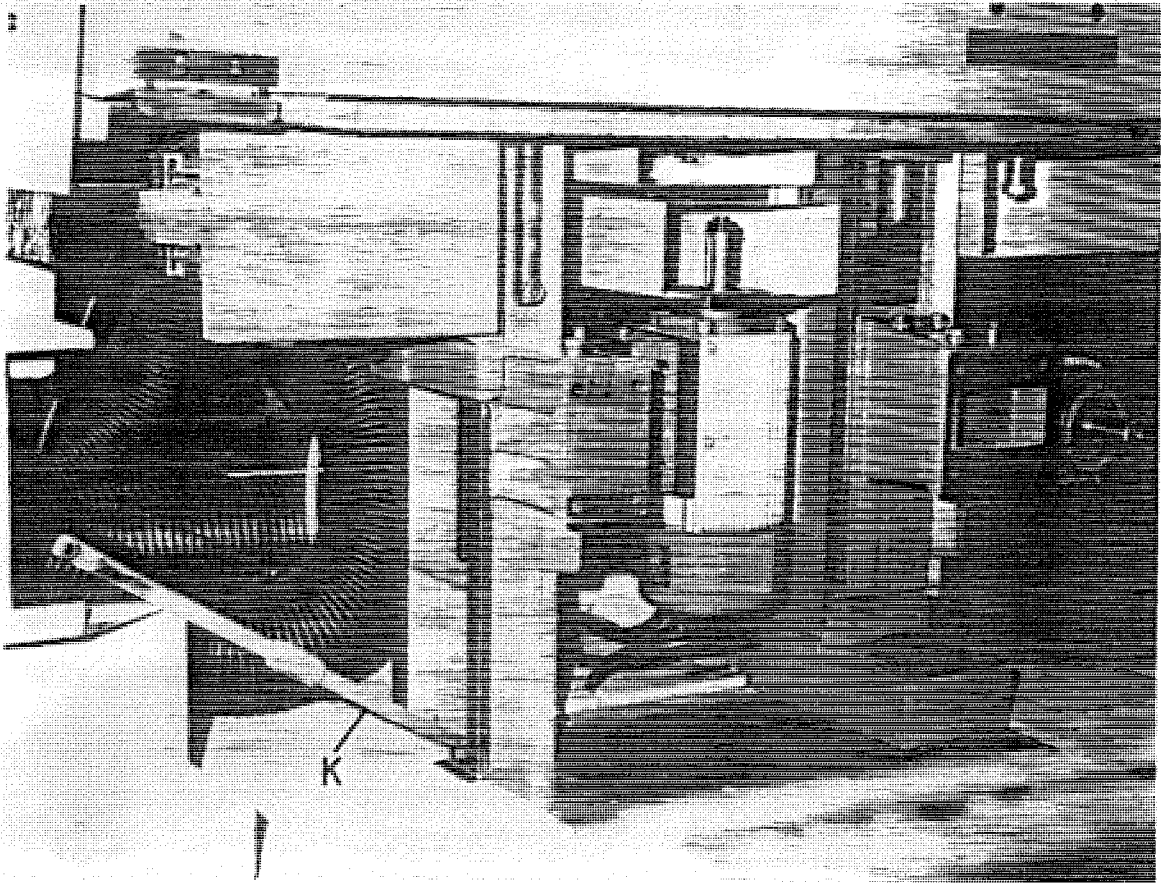


FIG. 14

SECTION B (Cont..)RE-ASSEMBLY OF MACHINESMACHINES FITTED WITH DRIVEN TOP PRESSURES - 64 pitch only

Assembly is the same as for machines with non-driven pressures with difference being as follows:-

- 1 When fitting each chain beam the spline pressure drive shaft "L" FIG.15 must locate together to enable a sliding fit.
- 2 The chain beams can then be secured as previously described in machines without non-driven top pressures.

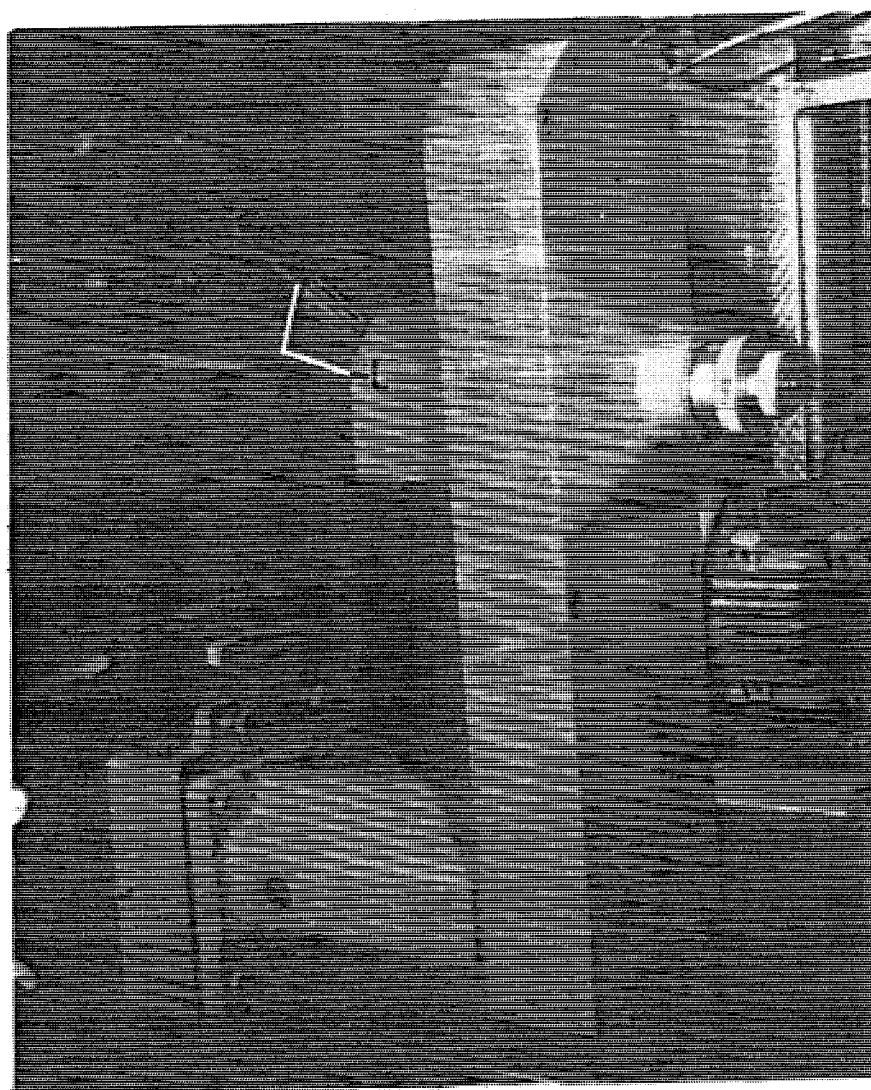


FIG.15

SECTION CPREPARATION FOR OPERATION

- 1 The machine must be connected at point "A" FIG.16, to a compressed 'air' supply.
This is for air cleaning of the tracks and operation of jump scorers or relishers if fitted.
Check the bottles "B" to ensure that they have not been cracked or damaged during transit.
Check that oil is up to level mark "C" and if necessary remove filler plug "D" and top up using correct grade of oil. (See lubricant charts).
Oil drip rate should be approximately 15 second intervals, pressure is regulated by knob "E", adjust until a pressure of 5.7 kg/cm³ (80 lbs/sq in) is shown on guage "F".

NOTE: DRIP ONLY OPERATES WHEN TRACKS ARE RUNNING.

- 2 Lubrication of backshaft is through the bracket for main drive shaft "G" FIG.17, on adjustable chain beam by means of a drip rated lubricator bottle "H". Full bottle and set drip rate until a thin film of oil is seen on backshaft.

NOTE: THIS ONLY APPLIES ON MACHINE NOS. 82100 to 84135.

- 3 It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting.

APPLICATION	A P P R O V E D L U B R I C A N T S					
	Castrol	BP	Shell	Esso	Texaco/ Caltex	Wadkin
Pneumatic Lubricators	Hyspin AWS32	Energol HL32	Tellus 37	Nuto N32	Rando Oil 320	L1
General Lubricators	Magna 68	Energol HP68	Vitrea 68	Nuray	Uka Oil P68	L4

ELECTRICAL DETAILS

The motors and control panel have been wired in before despatch. All that is required is to connect the power supply to the isolating switch. Points to note when connecting power supply:-

- 1 Check that the electrical supply details on the machine nameplate correspond to the supply.
- 2 Check that the main fuses are correct.
- 3 Connect the incoming supply leads to the appropriate terminals on main isolating switch.
- 4 Check that all connections are sound.
- 5 Check that the adjustable headstock moves in the correct direction.
- 6 If direction of traverse is incorrect, change any two of the wires on the incoming supply. All the other movements will be found to be correct when the traverse is correct.

NOTE: WIRING DIAGRAMS ARE SENT WITH INSTRUCTION MANUAL AND ALSO INSIDE CONTROL CABINET.

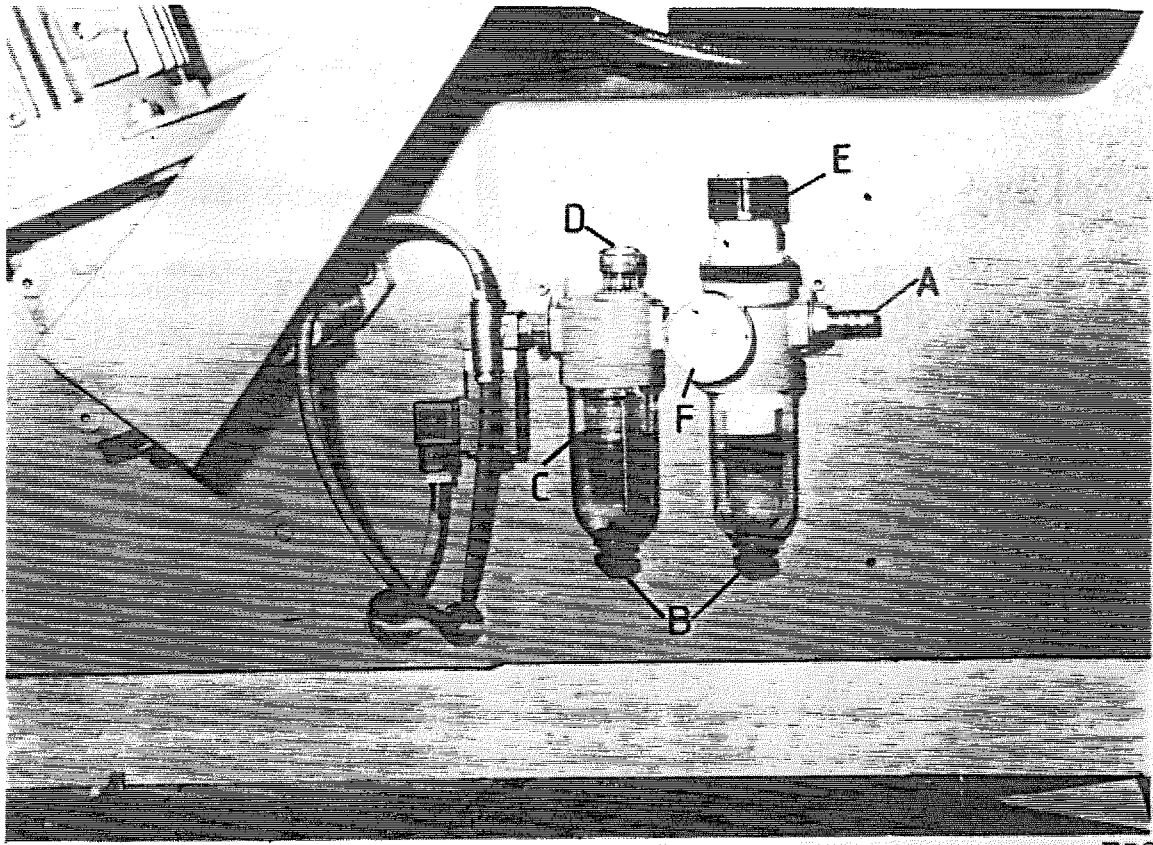


FIG. 16

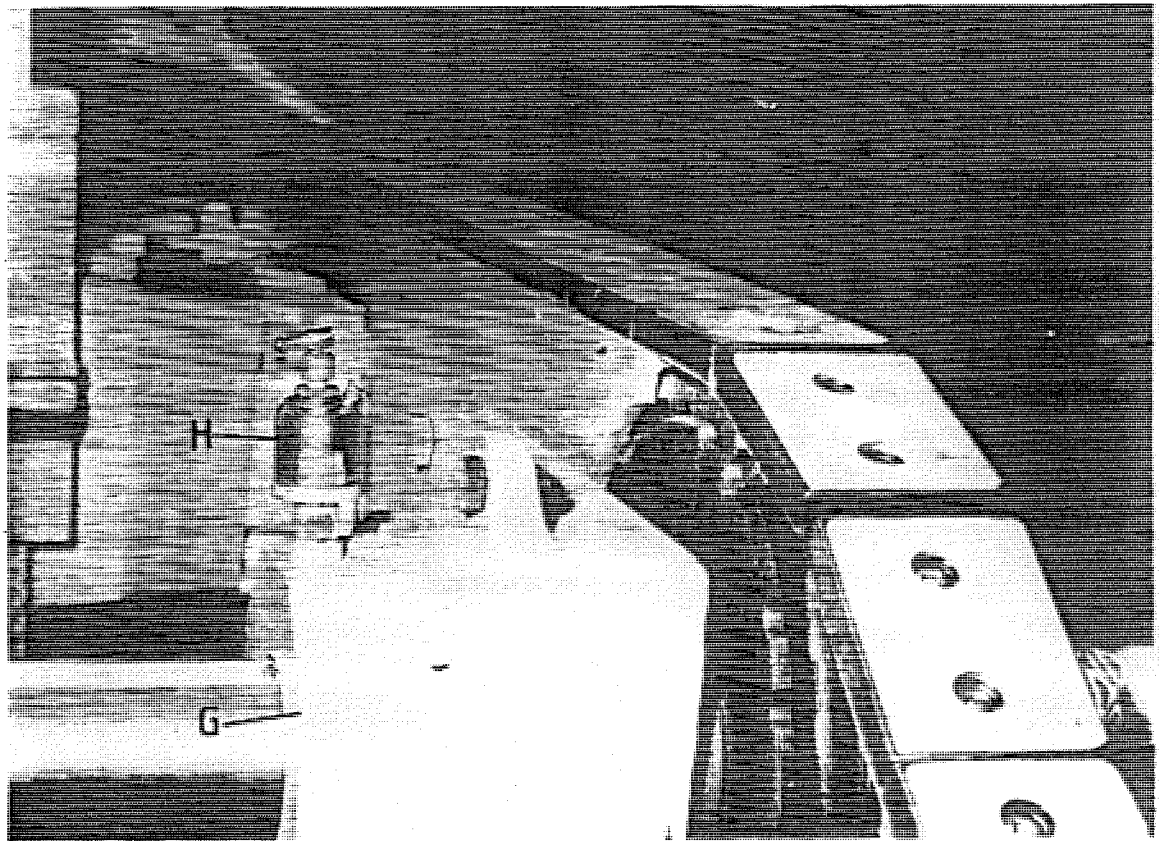


FIG. 17

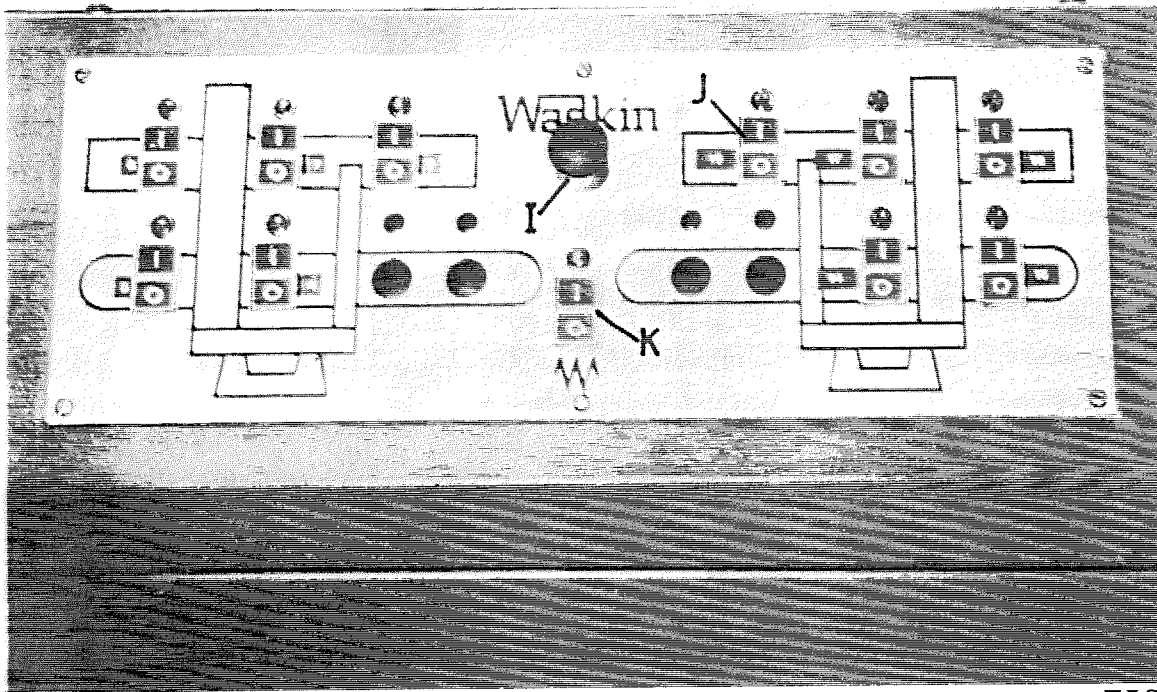


FIG. 18

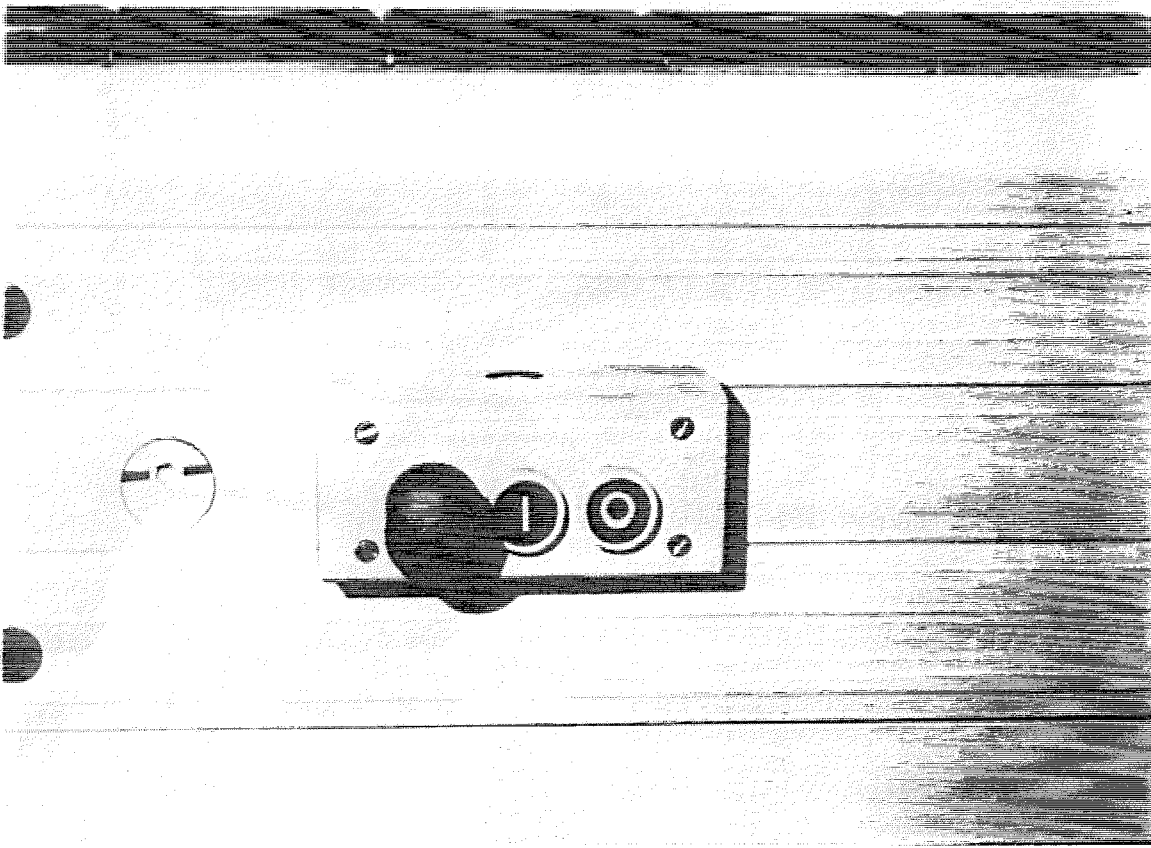


FIG. 19

SECTION C (Cont...)CONTROLSMASTER STOP

A MASTER STOP button "I" FIG.18 is located in the centre of the control console panel, also additional MASTER STOP buttons are situated on traverse chain beam FIG.19 and on the pedestrian control unit FIG.20. In addition a safety trip wire FIG.21 at the rear of the machine actuates a switch in the stop circuit.

NOTE: Depression of any of the MASTER STOP buttons shuts down all electrics. The MASTER STOP buttons automatically stay in the OFF position until released. MASTER STOP buttons on control console and traverse chain beam are released by pulling button and MASTER STOP button on pedestrian control unit is released by turning in a clockwise direction.

START/STOP

Individual head START/STOP push buttons "J" FIG.18 are mounted on control console. Each push button shows an orange indication light when head is running.

FEED START/STOP

A FEED START/STOP button "K" FIG.18 is mounted on the control console. For convenience and additional set of push buttons are mounted on the traverse chain beam FIG.19. For quicker setting up use pedestrian control unit FIG.20 which includes inching (jogging) facilities in both the forward and reverse moves.

FORWARD/REVERSE

Head FORWARD/REVERSE switches "L" FIG.22 are mounted on the side of control console.

ISOLATOR SWITCH

Machine can be isolated electrically by the ISOLATOR SWITCH FIG.23 fitted to the rear of the control console. The ISOLATOR SWITCH should be used for safety during maintenance or machine down time.

TRAVERSE SWITCH

A TRAVERSE SWITCH "M" FIG.24 is fitted adjacent to the traverse motor "N" which is located on the plinth "O". Operation of the switch is as follows:-

- 1 Switch in the centre stops the traverse.
- 2 Switch deflected either right or left traverses the column assembly as required.

NOTE: When the switch is released it returns to the centre stop position. A limit switch fitted on the moving saddle stops the beam approximately 30mm from the farthest possible traverse position at either end of the bed.

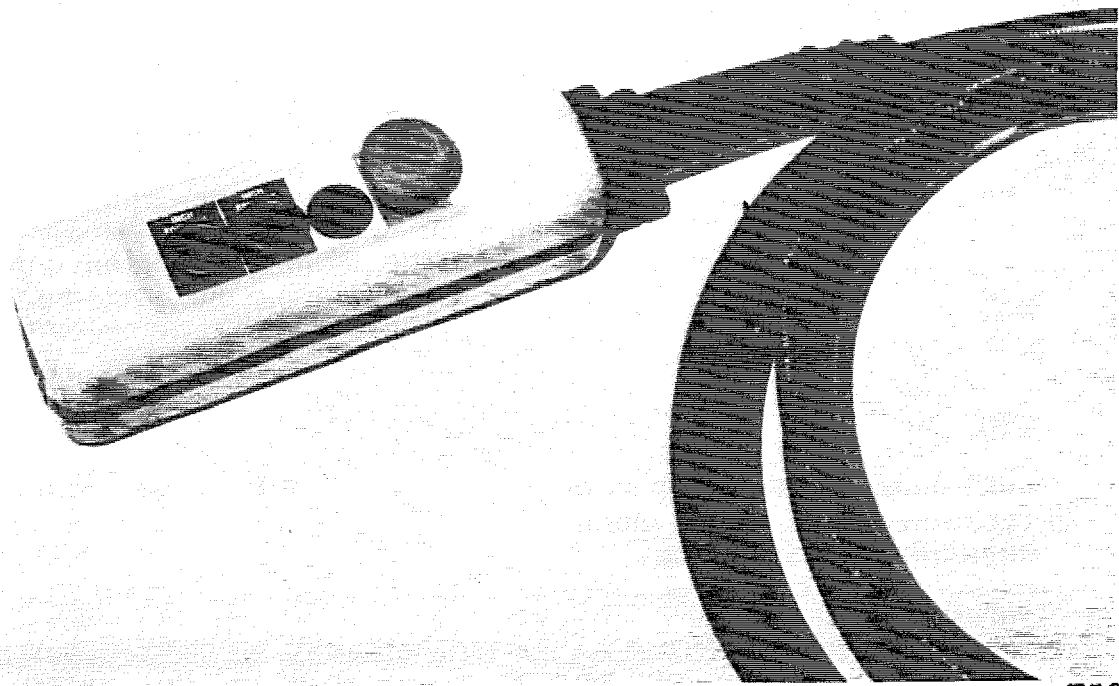


FIG. 20

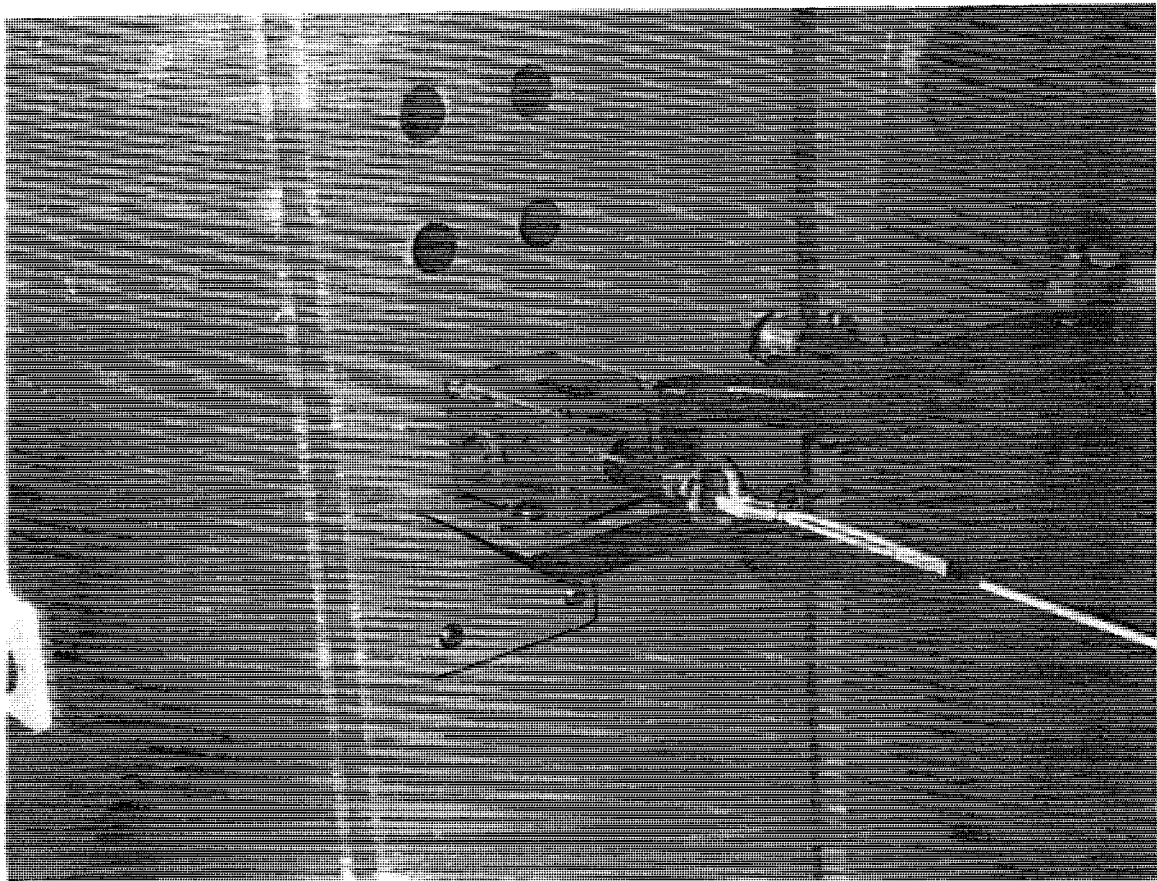


FIG. 21

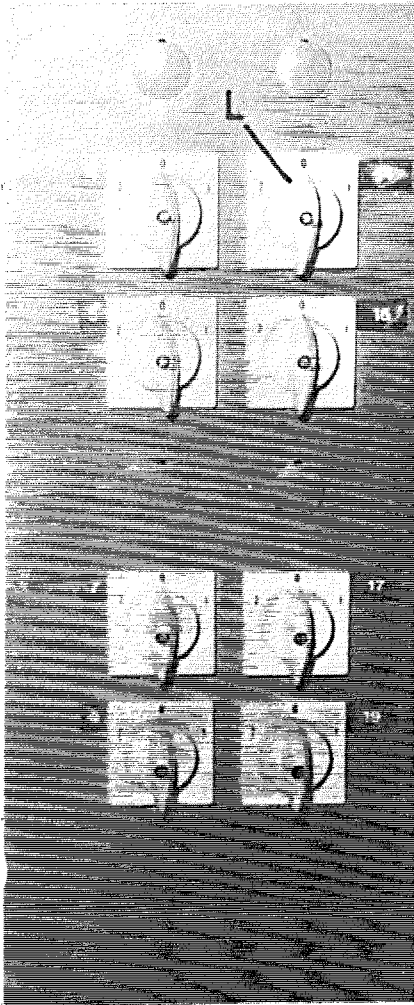


FIG. 22

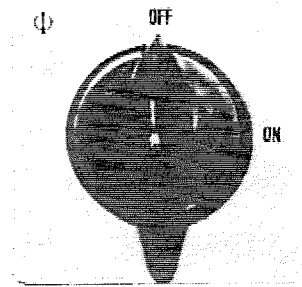


FIG. 23

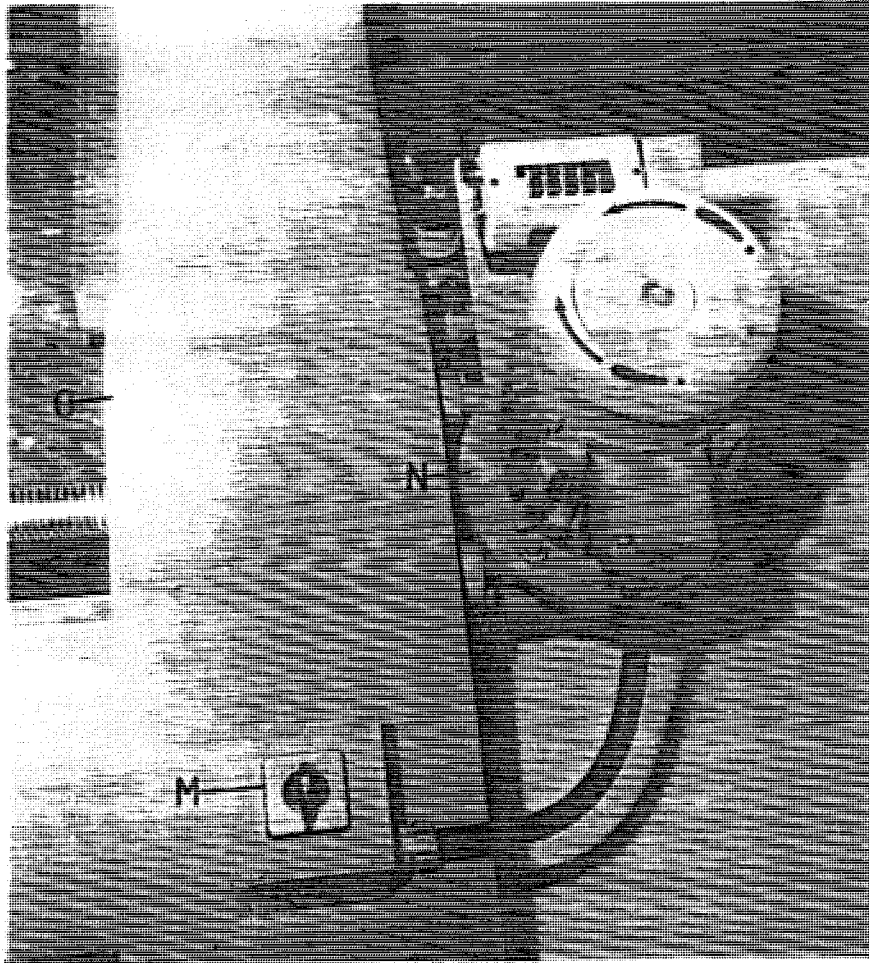


FIG. 24

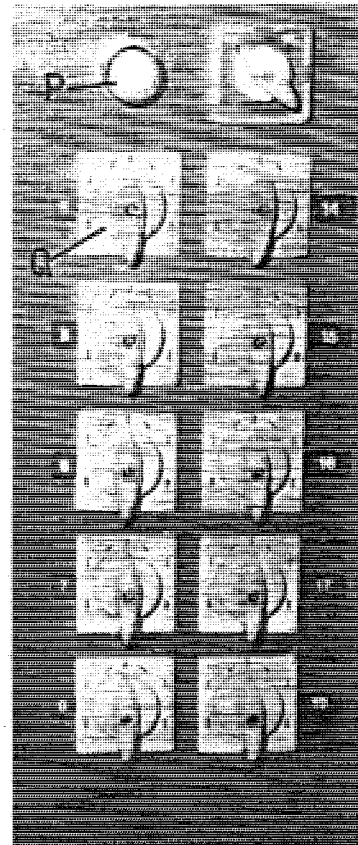


FIG. 25

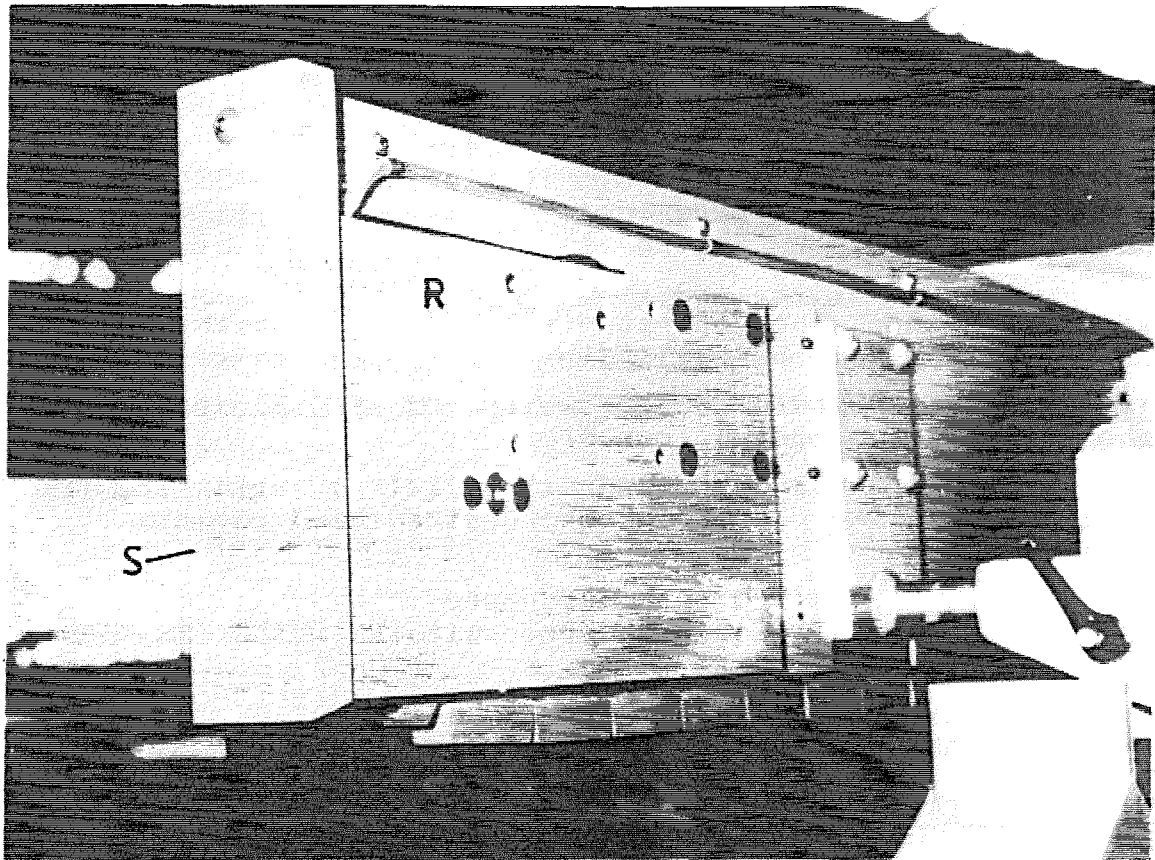


FIG. 26

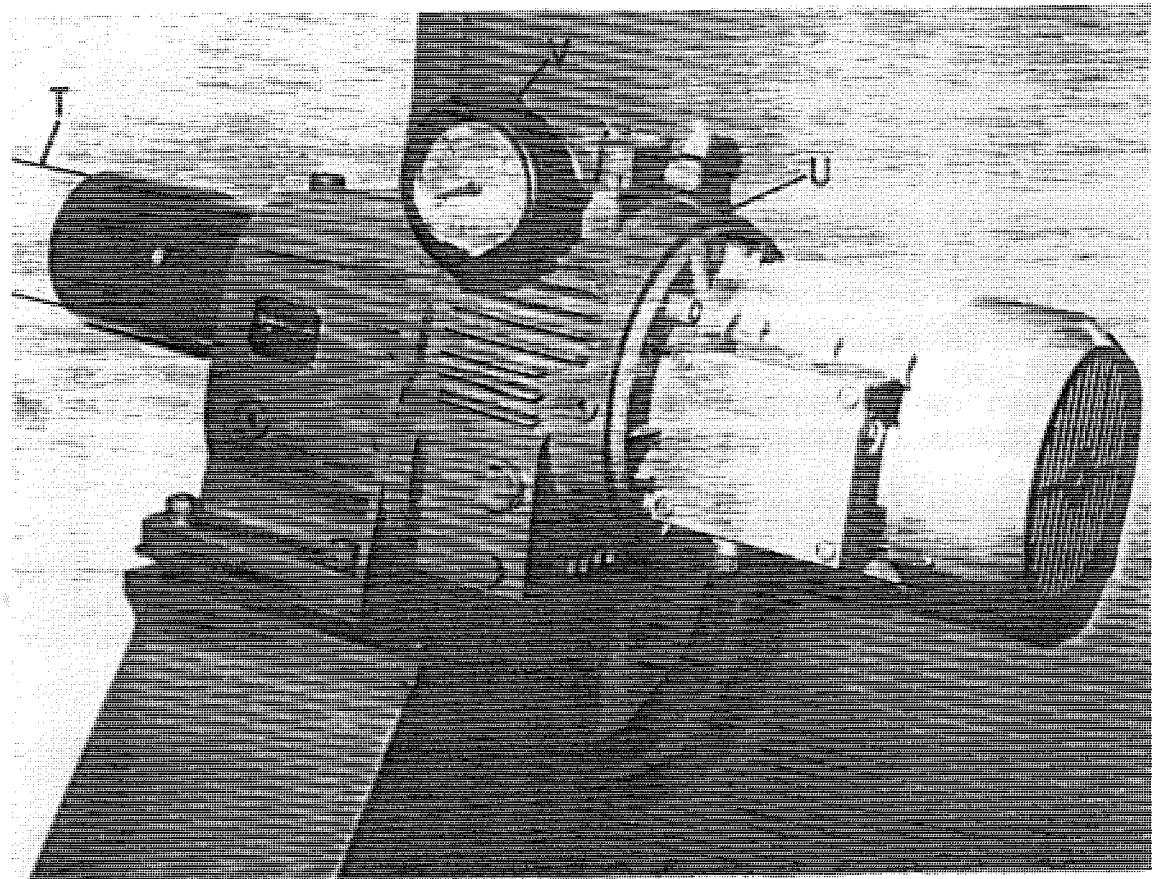


FIG. 27

SECTION C (Cont..)CONTROLSFREQUENCY CHANGER

A FREQUENCY CHANGER may be fitted to give a speed of 6000 rpm on direct drive heads (TYPE A & C). Individual head START/STOP push buttons are the same as previously described. A FREQUENCY CHANGER push button "P" FIG.25 is situated on the side of control console.

NOTE: This button when operated in conjunction with individual SPEED/DIRECTION switches will give high speeds to selected heads. Individual head SPEED/DIRECTION switch "Q" FIG.25 are situated on the side of the control console.

NOTE: Each switch can be moved either left or right from the central OFF position depending on required head rotation direction.

Switch in position I for standard speed.
Switch in position II for high speed with FREQUENCY CHANGER button operated.

IMPORTANT: WHEN USING FREQUENCY CHANGER IT MUST BE SWITCHED ON BEFORE ANY HEAD UNITS ARE STARTED.

TOP PRESSURE LIMIT SWITCHES

A limit switch is situated inside infeed end of each top pressure beam "R" FIG.26 these are actuated when an oversize piece of timber is fed into the machine and hits the flaptrip "S", which stops the circuit. This is to prevent jam up situations and protects both operator and machine.

FEED UNIT

The chain beams are driven via a 75mm (3in) diameter shaft "T" FIG.27, through a variable speed drive unit "U" and a close coupled reduction gearbox. A combined tachometer and handwheel "V" operates the feed change mechanism and provides variable feed speeds of 3-18 metres per minute (10-60 feet per minute).

The drive units are filled with lubricating for life oil prior to despatch from our works.

IMPORTANT: AN ADJUSTMENT OF SPEED OF THE DRIVE SHOULD ONLY TAKE PLACE WHEN THE DRIVE IS RUNNING, NEVER WHEN IT IS STATIONARY. IN THE EVENT OF ADJUSTMENT TAKING PLACE WHILST STAND STILL, THE DRIVE SHOULD BE CAREFULLY RE-STARTED WITHOUT LOAD.

MECHANICAL DIGITAL READOUT

A MECHANICAL DIGITAL READOUT "W" FIG.28, is fitted to the plinth, behind traverse motor, this permits accurate setting of the moving beam. To datum readout, it is necessary to depress lever and press push buttons below the relevant numbers. (Not applicable to machines with electrical beam positioning).

IMPORTANT SAFETY DIRECTIVES

- 1 Oversize timber limit "STOP" switches are fitted into top pressure beams to ensure incorrect thickness of stock does not foul machine.
- 2 Ensure that all tools and cutters are securely fixed and the speed selected is appropriate for the tooling.

SECTION C (Cont..)IMPORTANT SAFETY DIRECTIVES (Continued)

- 3 Ensure that all guards are adjusted correctly to give maximum protection from rotating cutter equipment.
- 4 Ensure that all heads are running before feeding any timber into the machine.
- 5 Ensure that all heads are rotating in the correct direction.
- 6 Ensure that the feed speed is correct for the work required.
- 7 Ensure that the pressures and fence are set correctly.
- 8 Master "STOP" buttons are fitted in convenient positions enabling the operator to "STOP" the machine immediately in case of emergency.
- 9 A safety "STOP" trip wire is fitted to the outfeed end of the machine enabling the operator to "STOP" the machine immediately in case of emergency.

STARTING

Before starting it is essential to ensure that all cutters are tight and secure in the respective cutterblocks and the latter are securely locked on the spindle and that the pressures and fence are set correctly.

- 1 Select correct head rotational direction for each head in use as previously described in controls.
- 2 Turn isolator switch fitted on rear of electrical control console to the "ON" position.
- 3 Start each head - See controls.
- 4 Start feed tracks - See controls.
- 5 The machine is now ready for operation. Carry out work, pushing material securely against the dogs (if in use) then feed material into machine using fence as a guide.

STOPPING

- 1 The feed motor and each head can be stopped individually by the appropriate "STOP" push button on electrical control console. It should also be noted that the feed motor can also be controlled from separate push buttons located on moveable beam and pedestrian control.
- 2 Depression of the "MASTER STOP" switches located in the centre of electrical control console, moveable chain beam and pedestrian control shuts down all electrics.

NOTE: The "MASTER STOP" button automatically stays in the "OFF" position until released. "MASTER STOP" buttons on the control console and traverse chain beam are released by pulling button and "MASTER STOP" button on pedestrian control unit is released by turning in a clockwise direction.

- 3 The machine can be isolated electrically by the "ISOLATOR SWITCH" located to the rear of the electrical control console.

IMPORTANT: THIS SWITCH SHOULD ALWAYS BE USED TO ENSURE SAFETY DURING MAINTENANCE OR MACHINE DOWN TIME.

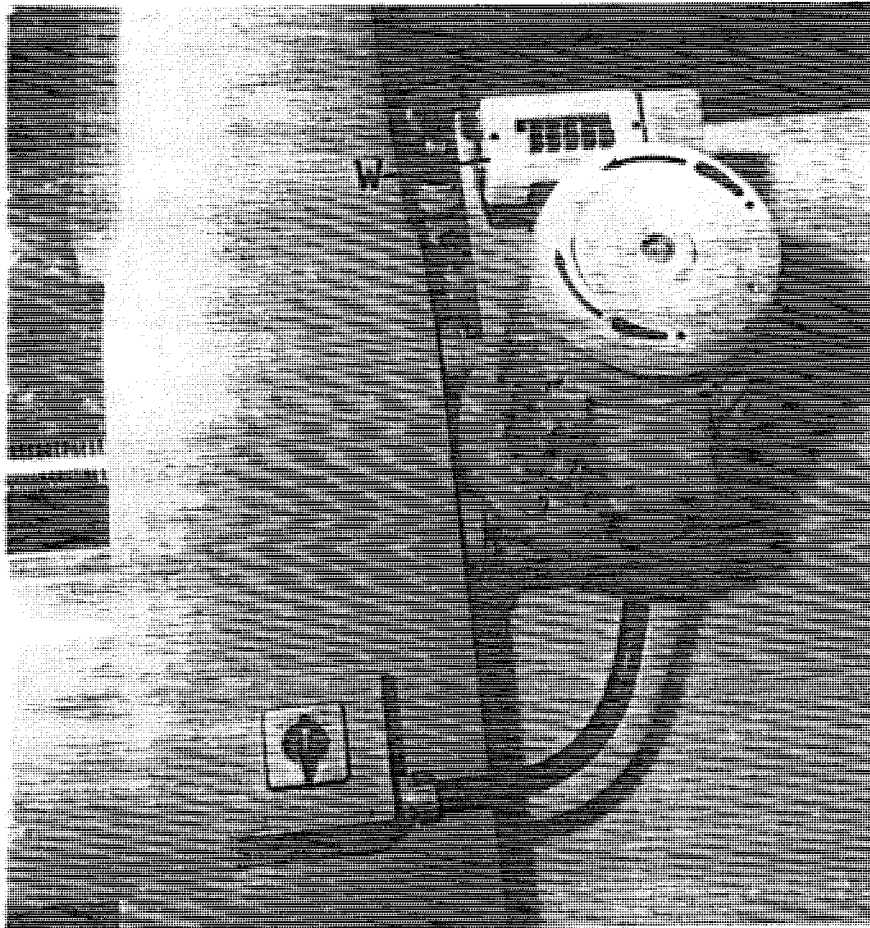


FIG. 28

SECTION DADJUSTMENTSVERTICAL ADJUSTMENT OF CATERPILLAR OR VEE BELT TOP PRESSURES

To vertical adjust pressure, proceed as follows:-

- 1 Loosen locking handle "G" FIG.32. (Where applicable).
- 2 Adjust pressure beam vertically by screw "A" FIG.27 with cranked handle (supplied with machine) in conjunction with digital readout "B". Relock locking handle "G". (Where applicable)

LATERAL ADJUSTMENT OF CATERPILLAR OR VEE BELT TOP PRESSURES (EXTRA)

Lateral adjustment of pressure is through inside of chain beam. To adjust, proceed as follows:-

- 1 Loosen locking handle "C" FIG.30.
- 2 Insert crank handle "D" FIG.31 (supplied with machine) into hole "E" in top pressure beam "F" and adjust to required position. Relock locking handle "C".

NOTE: ON MACHINES WITH AUXILIARY COLUMNS LOOSEN LOCKING HANDLE "G" FIG.32 ON COLUMNS ALSO.

CLUTCH DRIVE - DRIVEN TOP PRESSURES ONLY

Drive to each top pressures is through a friction clutch controlled by handwheels "H" FIG.33. This feature compensates for the feed speed differential between tracks and top pressures. Drive to each top pressure can be completely disengaged by removing pressure from the friction clutch by means of the handwheels "H".

COLUMN TRAVERSE ADJUSTMENT WHEN MECHANICAL DIGITAL READOUT IS FITTED.

The power traverse to the adjustable beam is provided by means of a rotating screw "J" FIG.35 and a fixed nut driven by a 1.5kw (2hp) Squirrel Cage Induction Motor "K" and a reduction gearbox "L". Control of traverse to adjustable beam is by the traverse switch, (see controls). At approximately 30mm from end of maximum and minimum settings the power traverse is automatically switched off. Final positioning should be carried out manually by handwheel "I". One complete turn of leadscrew being equivalent to 6mm ($\frac{1}{4}$ ") horizontal movement. Mechanical digital readout helps setting up.

NOTE: THIS SECTION DOES NOT APPLY WHEN MACHINES ARE FITTED WITH ELECTRONIC BEAM POSITIONING.

ELECTRONIC BEAM POSITIONING (EXTRA)

Machines fitted with ELECTRONIC BEAM POSITIONING FIG. are as previously described except BEAM POSITIONING replaces MECHANICAL DIGITAL READOUT. Operating instructions are as follows:-

When power is switched on it will be noted that all previous memory locations have been erased and display will read as follows:-

"PROGRAMME" - ZERO, "PROGRAMME NO." - 1, "POSITION" - ZERO

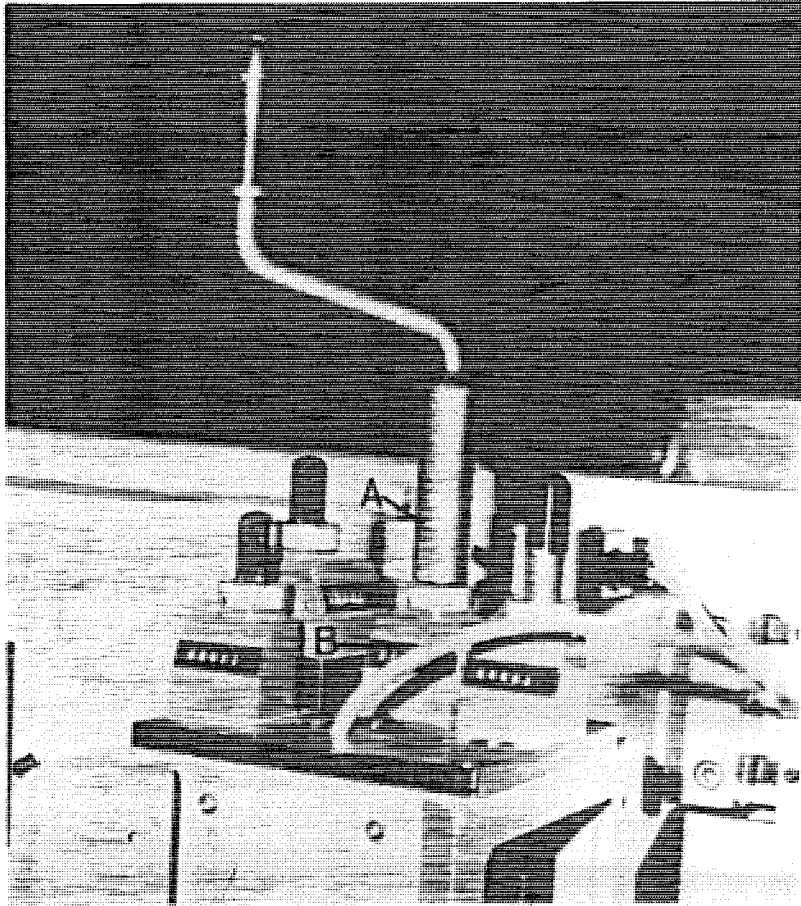


FIG. 29

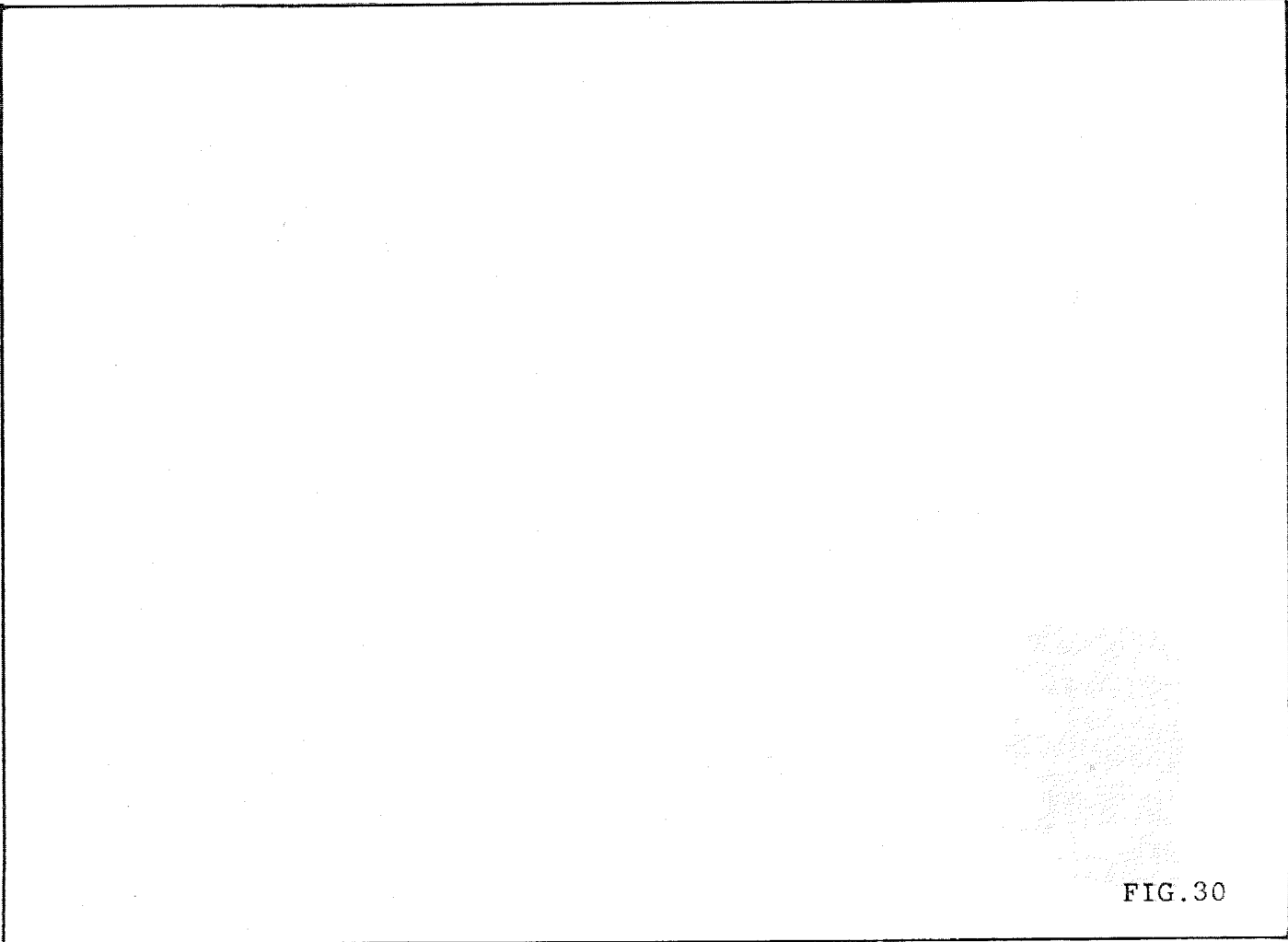


FIG. 30

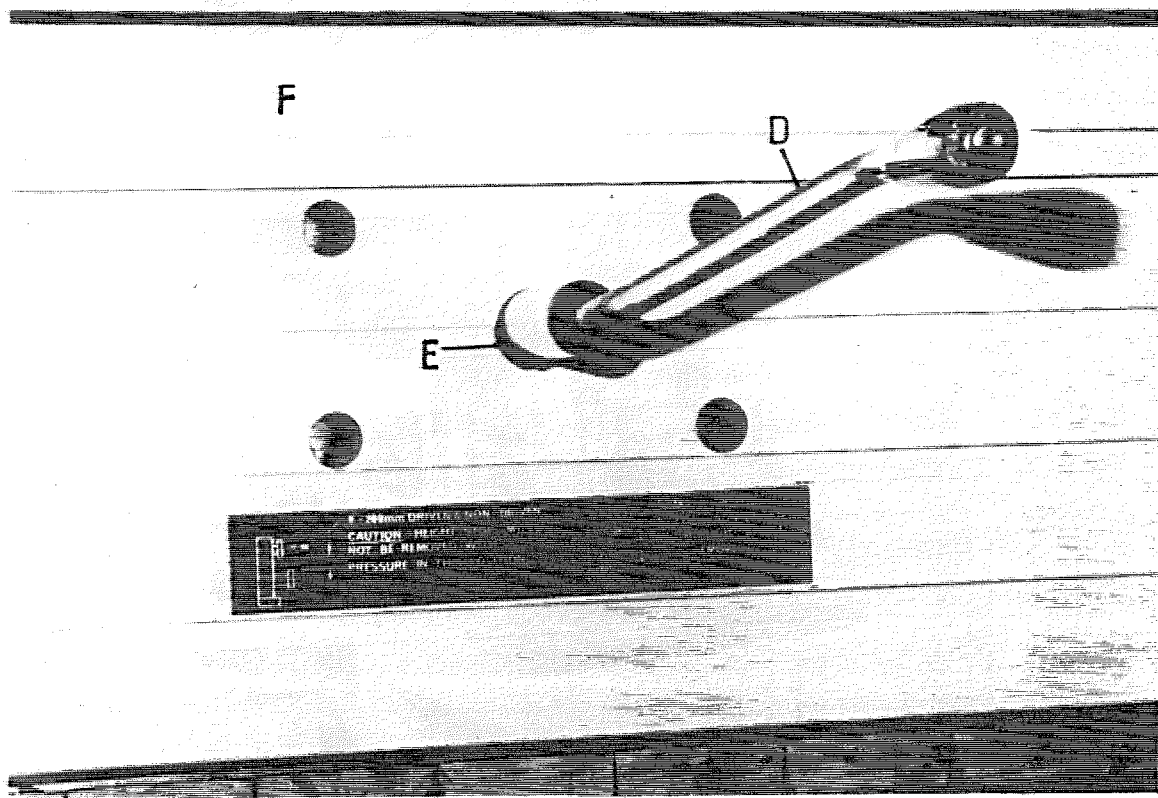


FIG. 31

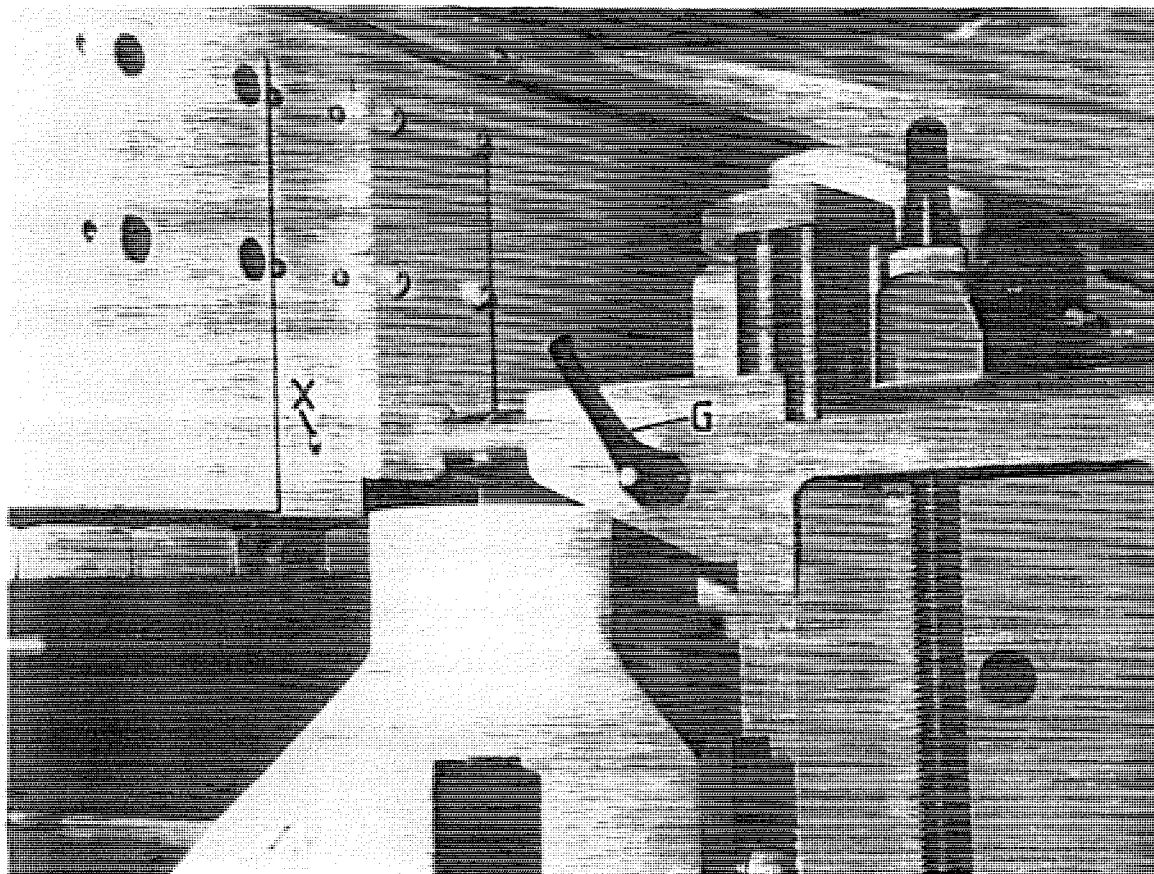


FIG. 32

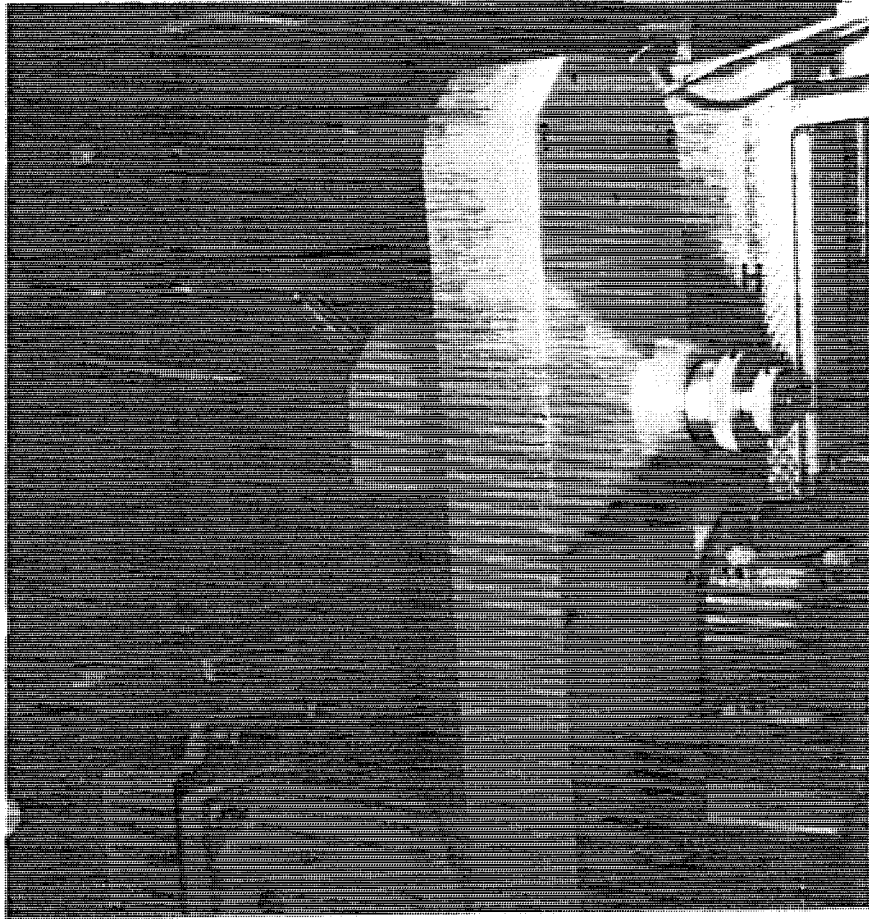


FIG. 33

FIG. 34

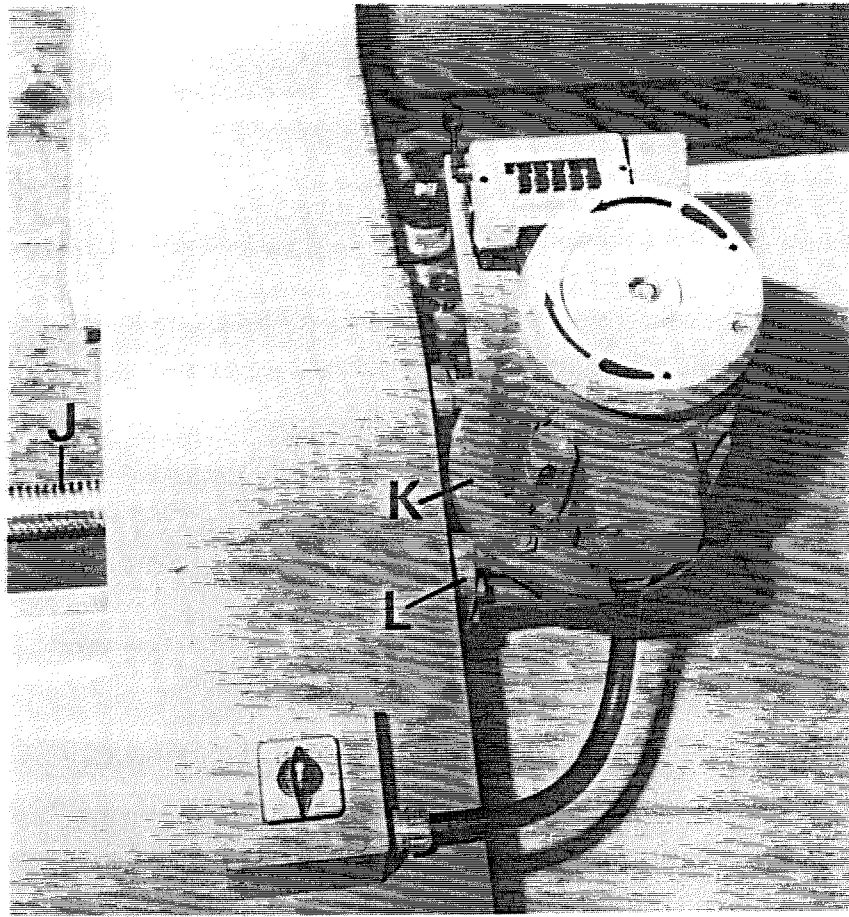


FIG. 35

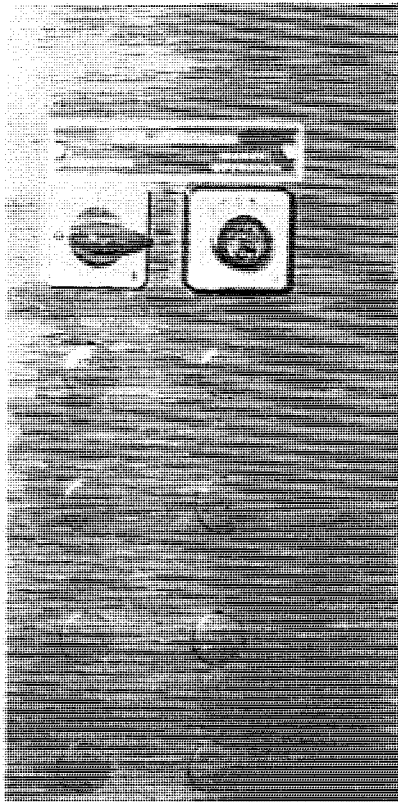


FIG. 36

SECTION D (Cont..)ADJUSTMENTSELECTRONIC BEAM POSITIONING (EXTRA) (Continued)

The "DATUM" LED light will be on, meaning machine cannot be used until DATUM "POSITION" has been entered.

All above are applicable irrespective of key position. To enter a programme, proceed as follows:-

- 1 Key must be switched to "PROG" position before entering a programme.
- 2 Measure workpiece.
- 3 Press "DATUM" key pad, then enter size by pressing numerical key pads as displaying figures in the "POSITION" window.

NOTE: All dimensions are shown in millimetres and tenths of millimetre.

There are 9 programmable positions (ie desired beam movement from the initial "DATUM" position) which can be entered.

These can be entered as follows:-

- 1 Press "ENTER" key pad whereupon the "DATUM" LED Light will be extinguished.

NOTE: 1 will be displayed in the "PROGRAMME NO." window as described in the first section of these instruction.

- 2 Using numeric key pads, enter beam position required which will be displayed in the "PROGRAMME" window. Programme 1 is now complete.

To enter further programmes, proceed as follows:-

- 1 Press "PROGRAMME NO." key pad and using numeric key pad, select the programme number required which will be displayed in the "PROGRAMME NO." window.
- 2 Press "ENTER" key pad and using numeric key pads enter new required beam positioning which will be displayed in the "PROGRAMME" window.

Further beam positions can be entered by using above procedure.

To operate machine, proceeds as follows:-

- 1 Stop feed.
- 2 Turn key to "POSITION" position.
- 3 Press "PROGRAMME NO." key pad then using numeric key pads, select required programme number.
- 4 Press "POSITION" key pad, so moving beam to required pre-programme position.

NOTE: Beam may search up to 3 times to obtain programmed position.

- 5 Turn key to "LOCK" position.

NOTE: With key in "LOCK" position the beam cannot be accidentally moved from pre-set position.

To move beam manually, proceed as follows:-

- 1 Ensure "DATUM" has been programmed.
- 2 Turn key to "RUN" position.

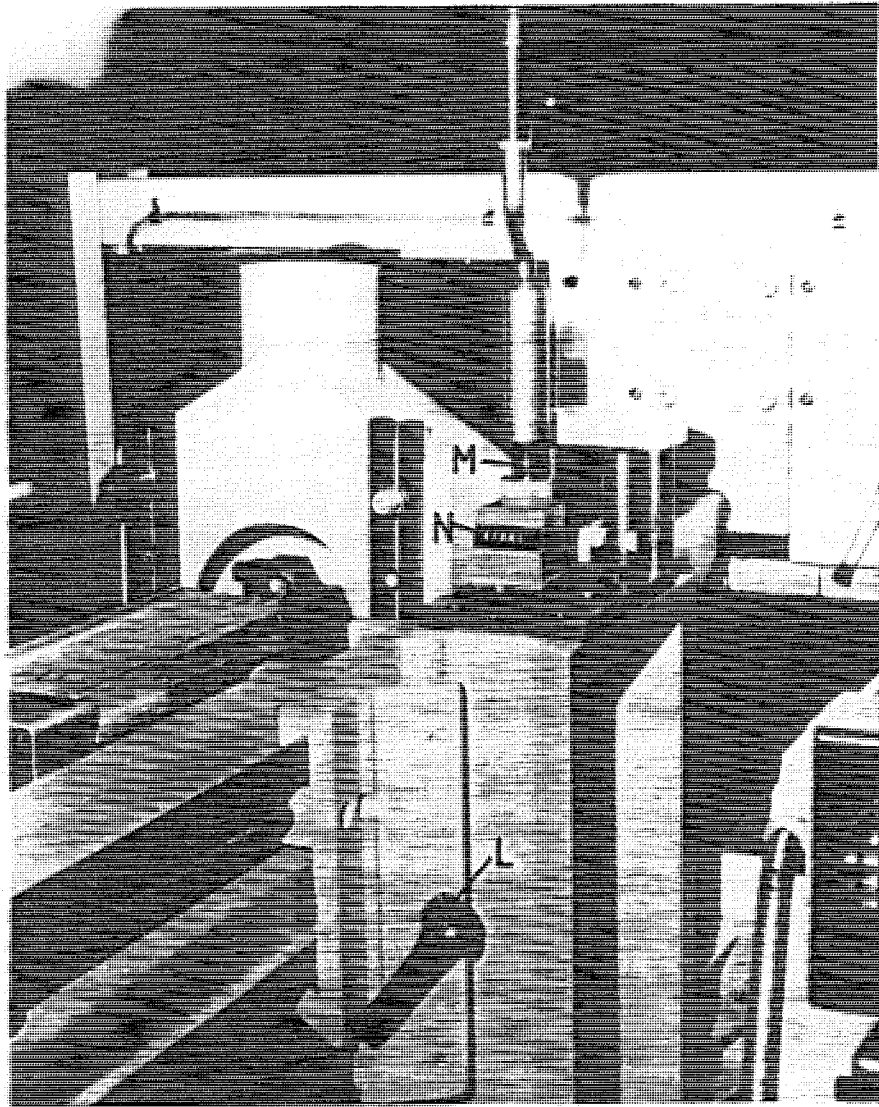


FIG. 37

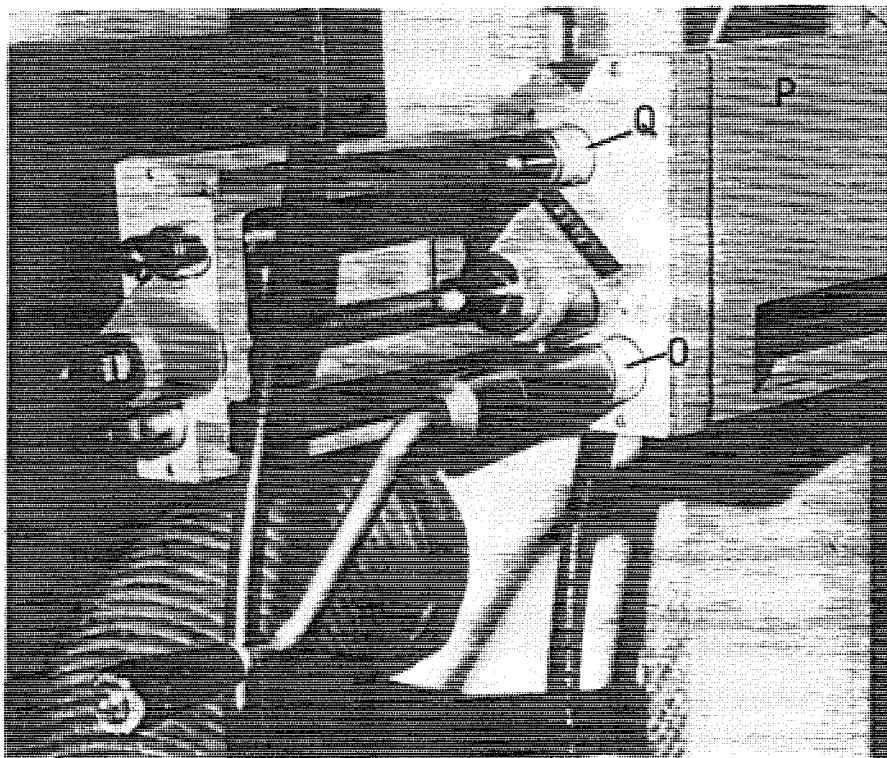


FIG. 38

SECTION D (Cont..)ADJUSTMENTSELECTRONIC BEAM POSITIONING (EXTRA) (Continued)

- 3 Move beam to required position by means of the 2 key pads indicated by arrow symbols.
- 4 When set in required position, turn key to "LOCK" position.

Operation of "START", "MASTER STOP" and "PROGRAMMED STOP", is as follows:-

- 1 "START" button lights up when operated, so connecting power to beam traverse motor.
- 2 "MASTER STOP" disconnects power traverse from traverse motor only.
- 3 "PROGRAMME STOP" indicated by O symbol, stops microprocessor programme.

NOTE: If beam traverse has been stopped "MASTER STOPS", "TRIPWIRE", "TRAVERSE LIMIT SWITCHES" or by "STARTING FEED" during a programmed positioning movement, the the "PROGRAMME STOP" will light up.

To commence positioning operate the "MAINS ON" button then press "POSITION" key pads, whereupon the beam will continue to the pre-programmed position.

- 4 In case of microprocessor failure the beam may still be operated by removing the constant single phase supply to microprocessor and operating the key switch "K" FIG.36 located on side of control console.

NOTE: When machine is despatched key is packed inside of control console.

IMPORTANT: NEVER LEAVE KEY IN SWITCH.

HEAD ADJUSTMENTS

NOTE: ENSURE LOCKS ARE FREE BEFORE MAKING ADJUSTMENTS.

VERTICAL ADJUSTMENT OF "A", "B" and "C" TYPE HEADS

Set each head vertically by loosening locking handle "L" FIG.37 and position head by vertical adjustment screw "M" in conjunction with digital readout "N". Relock locking handle "L".

CANTING ADJUSTMENT OF "A" TYPE HEAD

Set head at required angle by loosening locking screw "O" FIG.38 canting head unit "P" to required angle by canting screw "Q", in conjunction with the canting scale fitted to the motor mounting boss and micro adjustment scale fitted to canting screw. Relock locking screw "O".

CANTING ADJUSTMENT OF "B" and "C" TYPE HEADS

To set head to required angle manually support unit "R" FIG.39, then loosen 2 - 12mm locking nuts "S" which are situated at the rear of the head canting boss. Move head assembly to required angle using the canting scale "T". Relock 2 - 12mm locknuts.

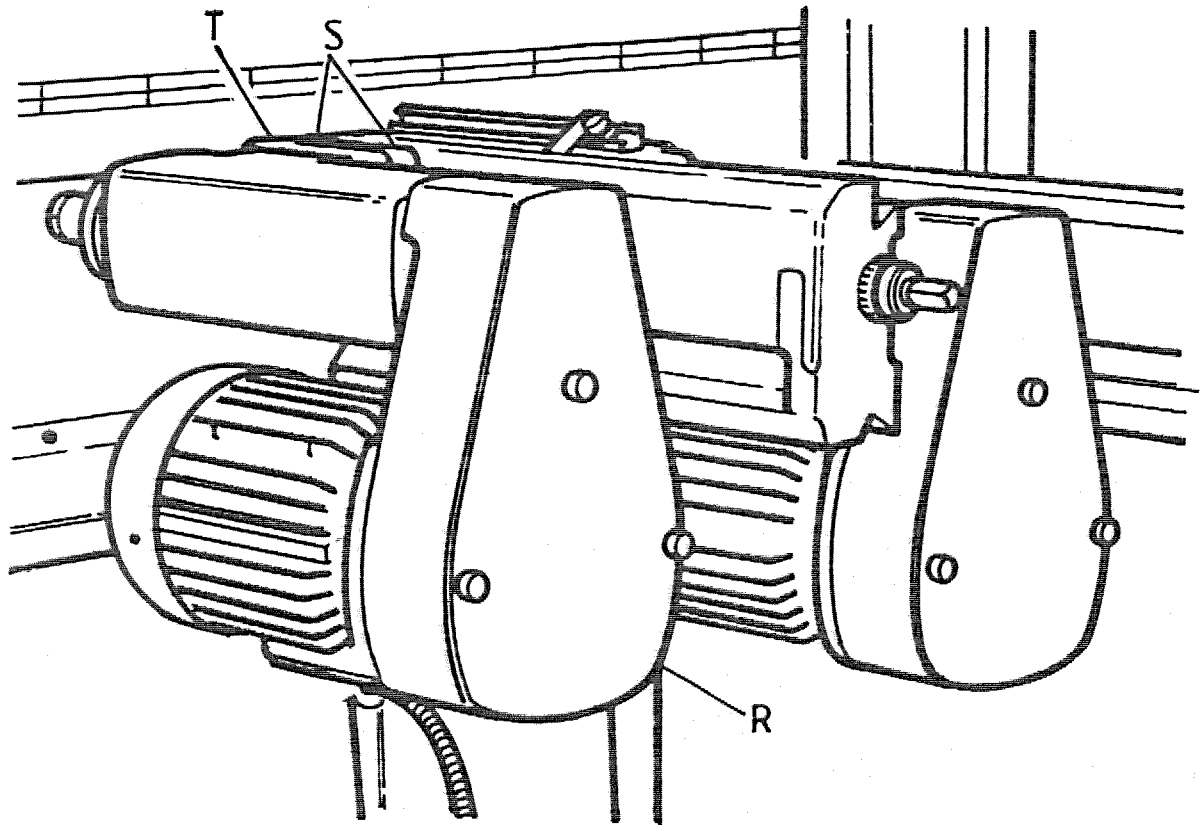


FIG. 39

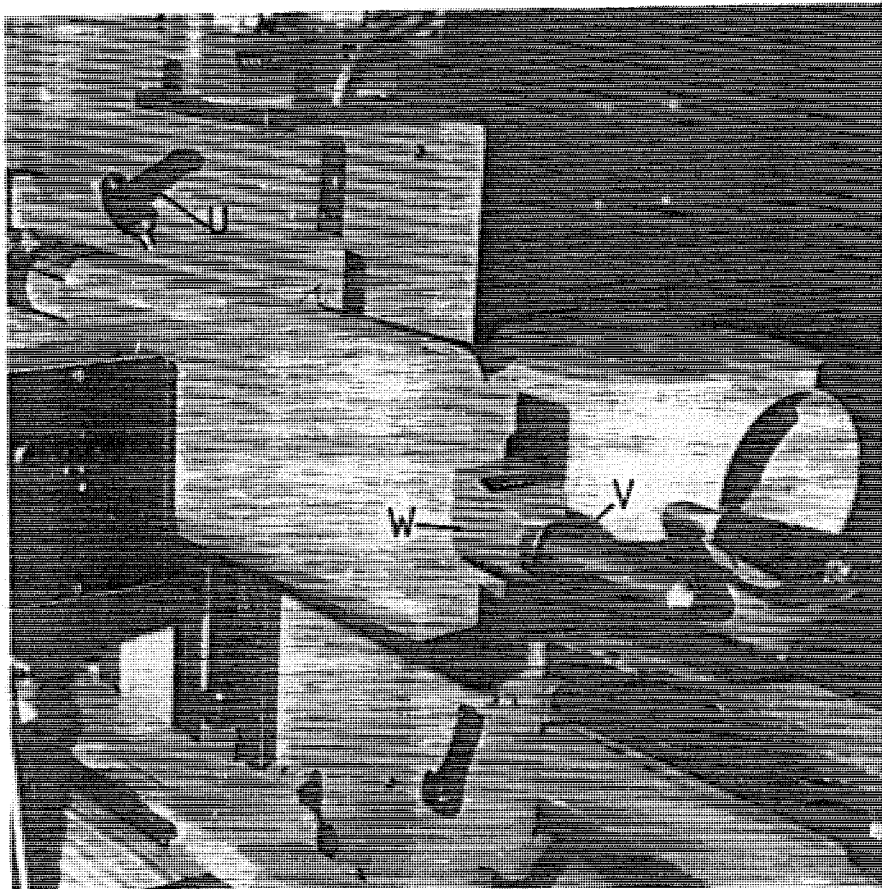


FIG. 40

ADJUSTMENTS (Cont..)HEAD ADJUSTMENTS (Cont..)LATERAL ADJUSTMENTS OF "A", "B" and "C" TYPE HEADS

Set head at required lateral position by loosening locking handle "U" FIG.40, adjusting head laterally to required position by means of screw "V" in conjunction with digital readout "W". Relock locking handle "U".

BELT REPLACEMENT OR SPEED CHANGING ON "B" TYPE HEAD

Each belt driven head is fitted with two stepped pulleys to give alternative speeds of 3000rpm and 6000rpm, or 4500rpm and 6000 rpm.

- 1 Isolate machine electrically.
- 2 Remove 3 - button head screws "A" FIG.41, securing belt cover plate "B" to head.
- 3 Remove belt cover plate "B".
- 4 Loosen 3 - hexagon head nuts "C" at the rear of head pulley housing "D".
- 5 Locate 10mm toggle bar (supplied with machine) in motor mounting boss at point "E" and move motor about elongated slots "F" to release tension on pulleys "G" and "H".
- 6 Fit belts on pulleys "G" and "H" to give required spindle speed.

NOTE: Belt is shown on the high speed pulleys "G" and "H" in illustration.

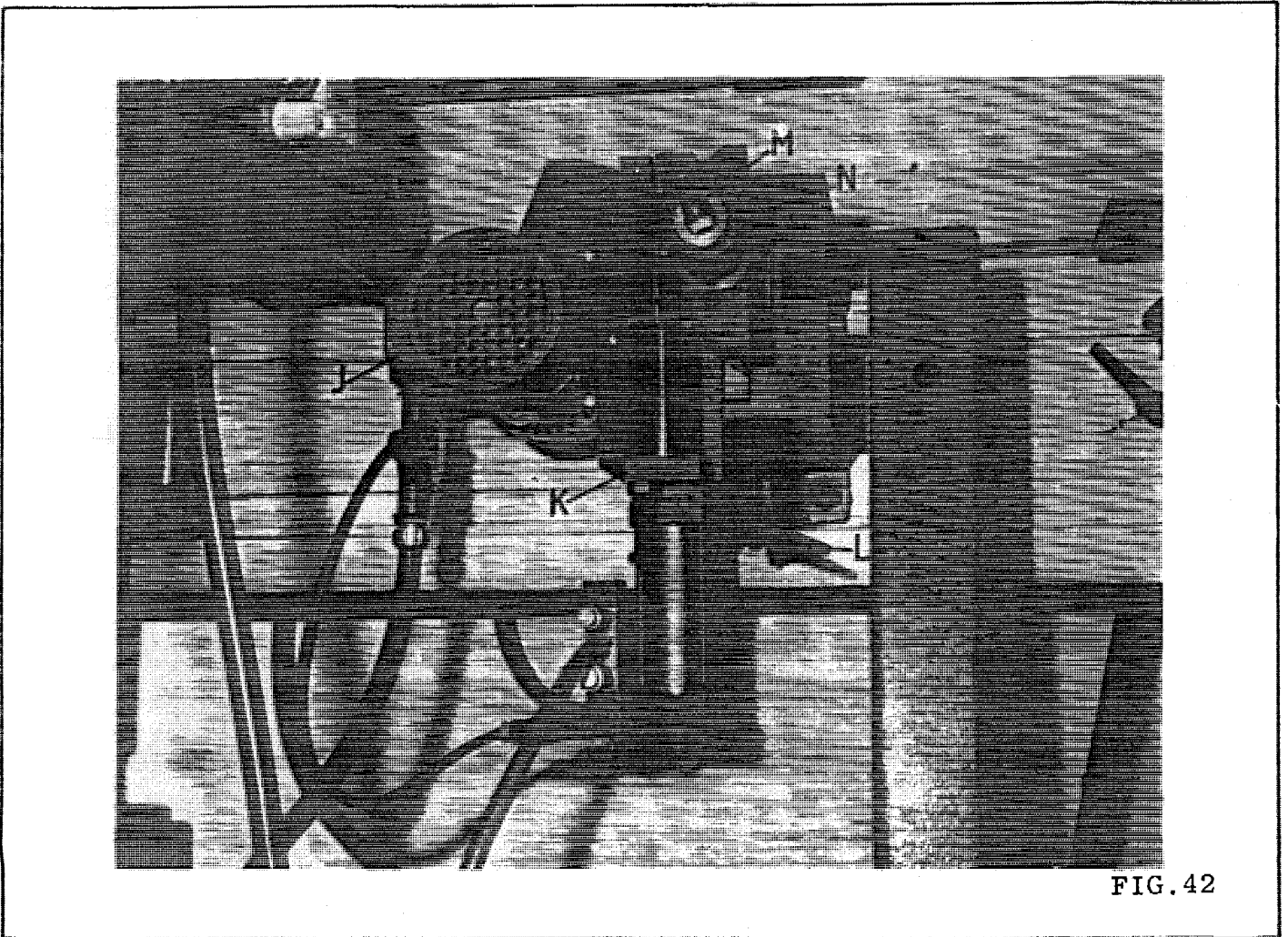
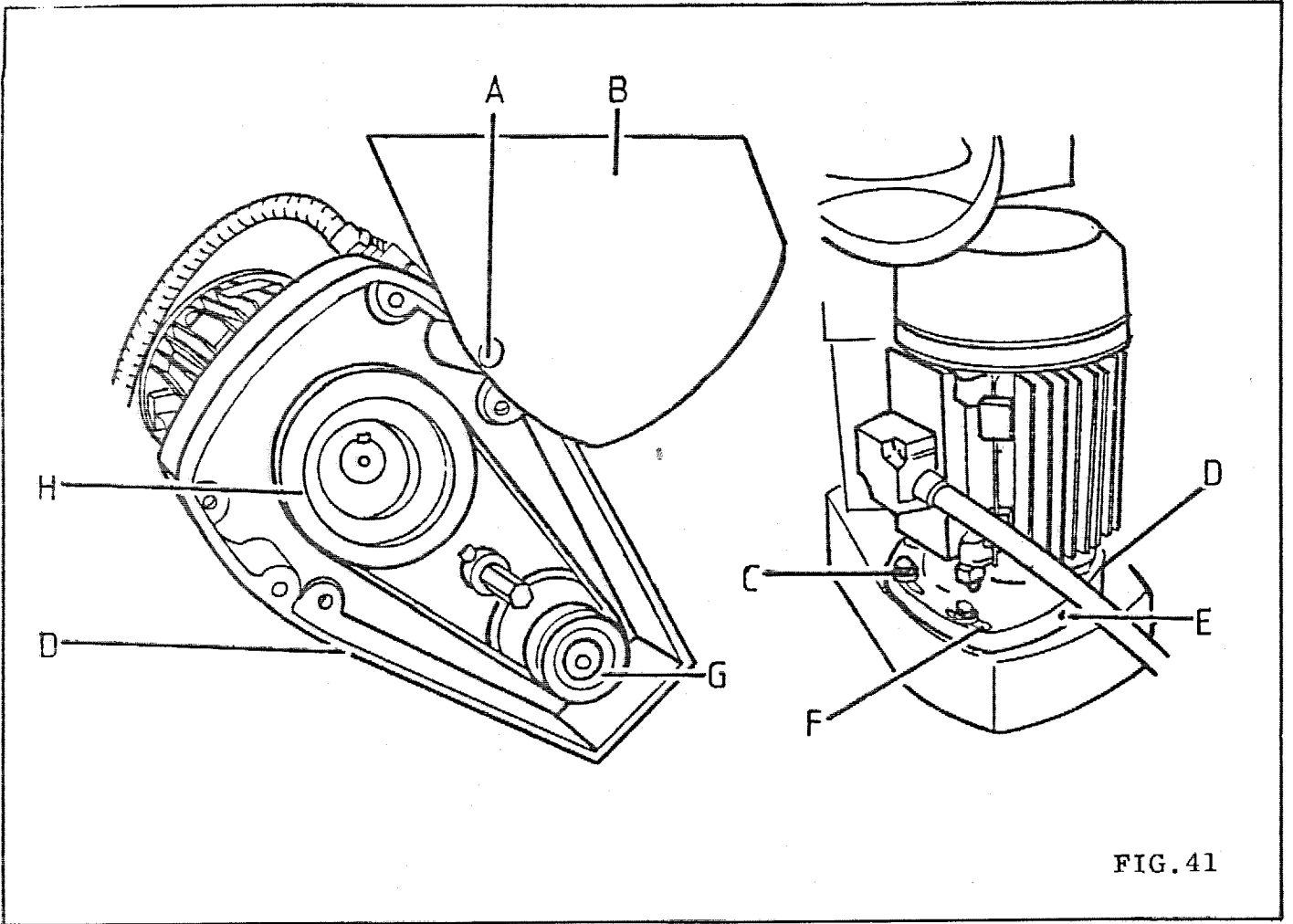
- 7 Apply tension to the belt by moving the motor with the toggle bar (located in motor mounting boss).
Correct belt tension is when the belt deflection is approximately 10mm under slight finger pressure.
- 8 When belt tension is correct relock 3 - hexagon head nuts "C".
- 9 Replace belt cover plate " " and secure with the 3 - button head screws "A".

BEAM MOUNTED NON-CANTING JUMP SCORER (WHEN FITTED)

The scoring saw unit "J" FIG.42 is mounted on a mounting slide "K". Lateral adjustment is made by loosening locking handle "L" and adjusting head to required position by means of screw "M" in conjunction with digital readout "N". Relock locking handle "L".

HEAD MOUNTED CANTING JUMP SCORER (WHEN FITTED)

The scoring saw unit " " FIG.43, is mounted onto a "A" type head " " by means of jump scorer tie bracket. Therefore the scoring saw moves in unison with the main head (refer to page for "A" type head adjustments). For finer adjustment, loosen locking handle " " and adjust by means of screw " " in conjunction with digital readout " ". Relock locking handles " ".



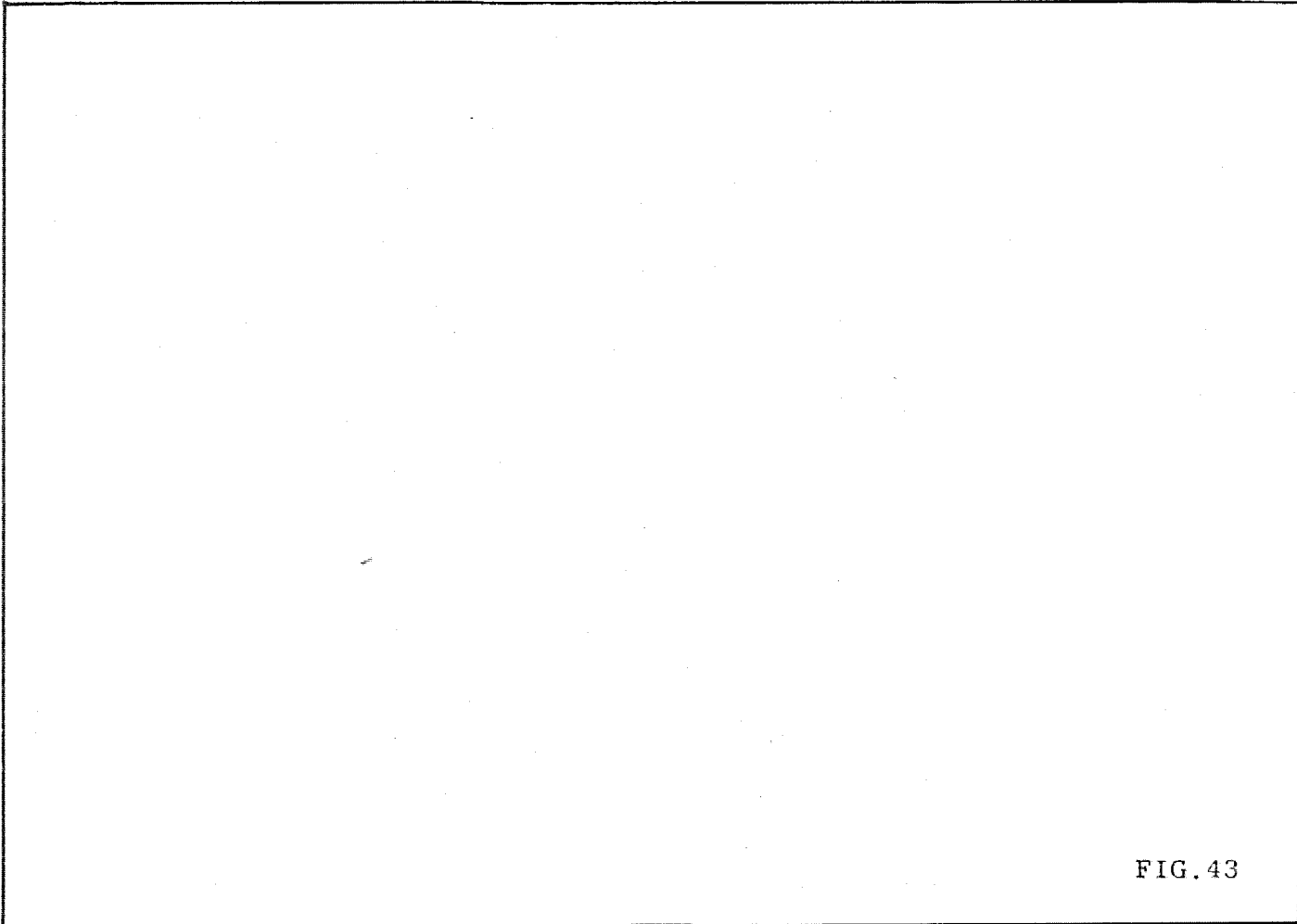


FIG. 43

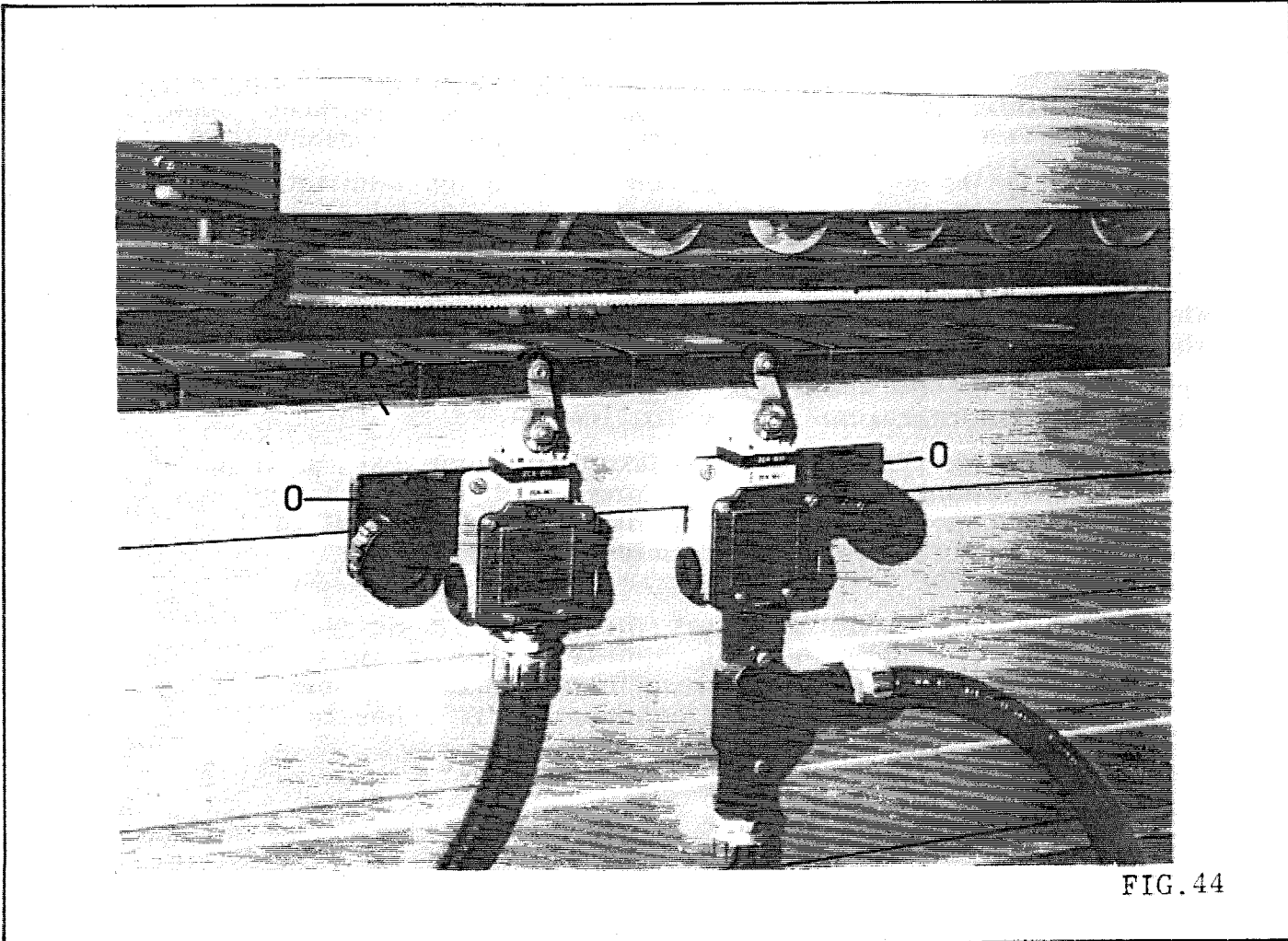


FIG. 44

SECTION D (Cont..)ADJUSTMENTSLIMIT SWITCHES ON CHAIN BEAM FOR JUMP SCORERS

Two limit switches "O" FIG.44 are fitted to chain beam "P" to activate jump scorers. Operation is as follows:-

- 1 Panel depresses first and second limit switches.
- 2 Scorer jumps when end of panel releases first limit switch.
- 3 Scorer returns to normal station when end of panel releases second limit switch.

DOGS

Various types of dogs (EXTRA) are available for specific types of work, eg:-

Disappearing Dogs	}	Panels
Core Stock Dogs		
Flat Back Dogs	}	Joinery
Finger Dogs		

NOTE: Core Stock Dogs specially for overhanging veneers and laminates.

Finger Dogs available in two heights (75mm or 125mm) specially suitable for various heights of work where break out is not a problem.

Further information on the above dogs is available on request.

Chain tracks are bored out to take dogs at 400mm as standard (tracks can be bored out to take dogs at 200mm at extra cost). To set number of dogs required, proceed as follows:-

- 1 Core Stock, Flat Back and Finger Dogs not required, should be removed with 6mm allen key (supplied with machine).
- 2 Disappearing dogs not required, should be secured below level of chain track with special key (supplied with machine). Place key over square of dog, depress and give half turn to secure dog below track. To release dogs reverse procedure.

When crosscutting narrow board etc., feed against front of dogs, when feeding large panels feed against rear of dogs (back dog).

Drive to pressures should be adjusted to suit various operations. Adjusting instructions are as follows:-

- 1 When feeding timber against front of dogs (ie, with dogs pushing timber) the drive to pressures should be released by loosening knurled locking handwheels "Q" FIG.45, then releasing drive by knurled handwheels "R". Relock handwheels "Q".
- 2 When feeding timber against the back of dogs (back dogging) the drive to the pressures should be set to positive by loosening the knurled locking handwheels "Q", setting positive drive by knurled handwheels "R" then relocking handwheels "Q".

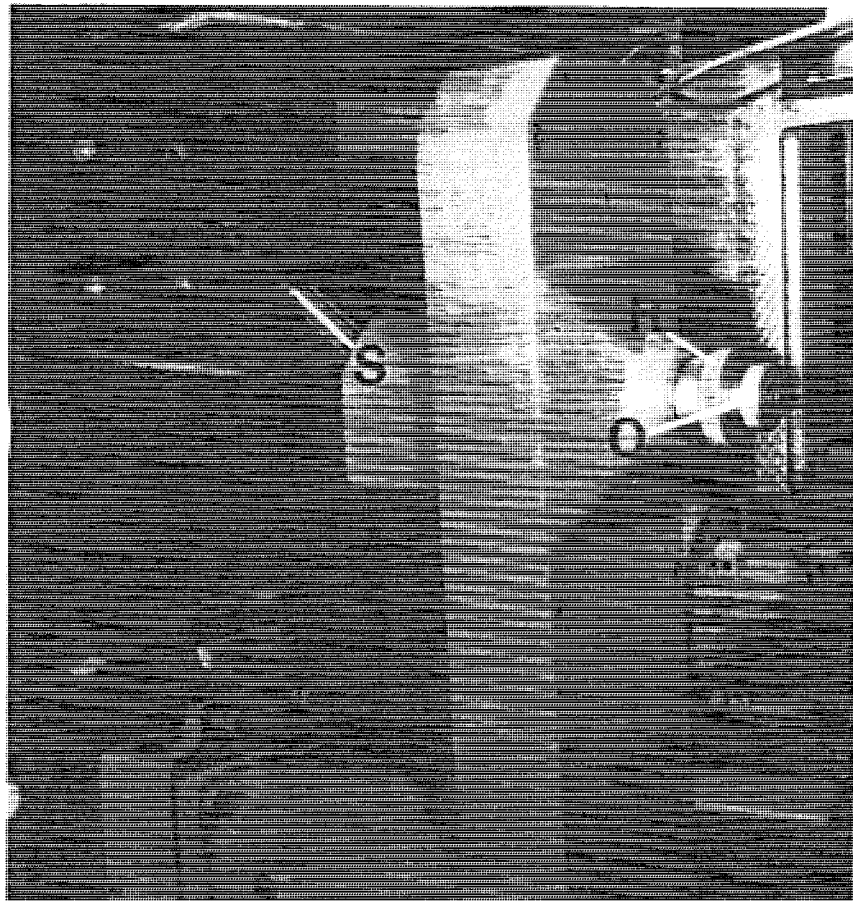


FIG. 45

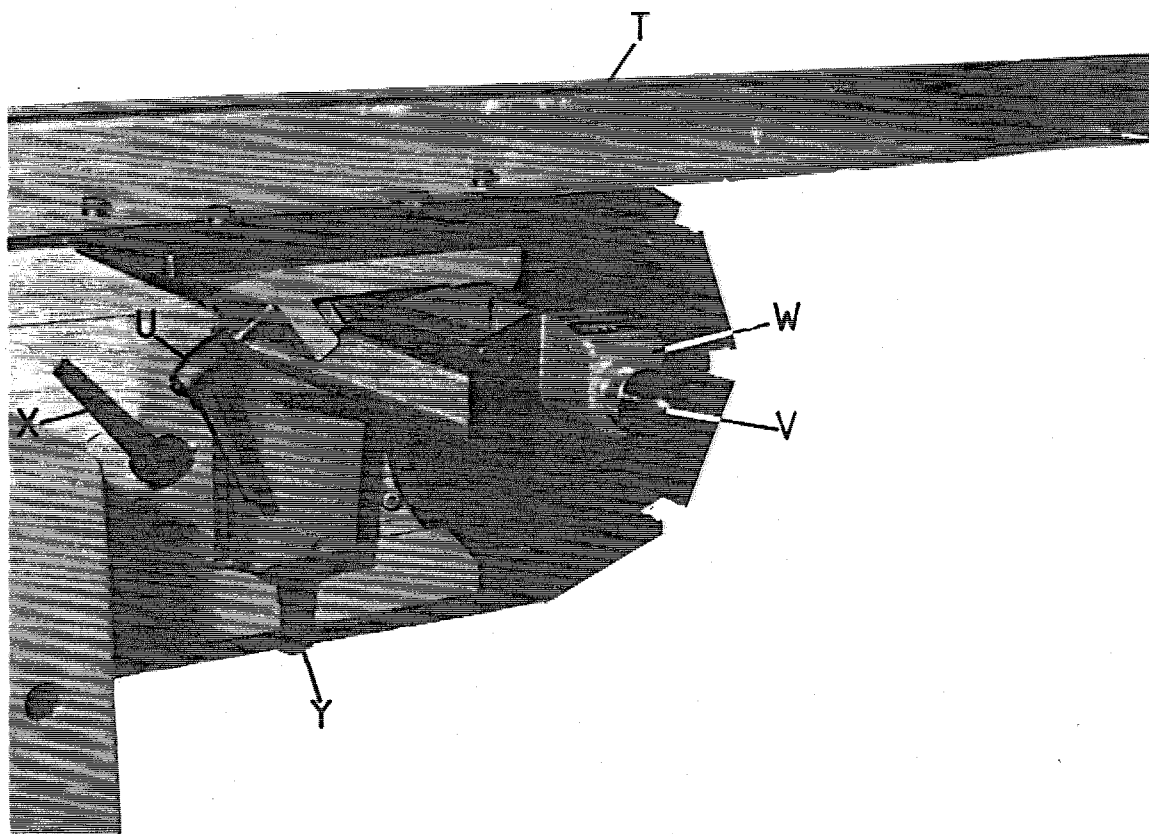


FIG. 46

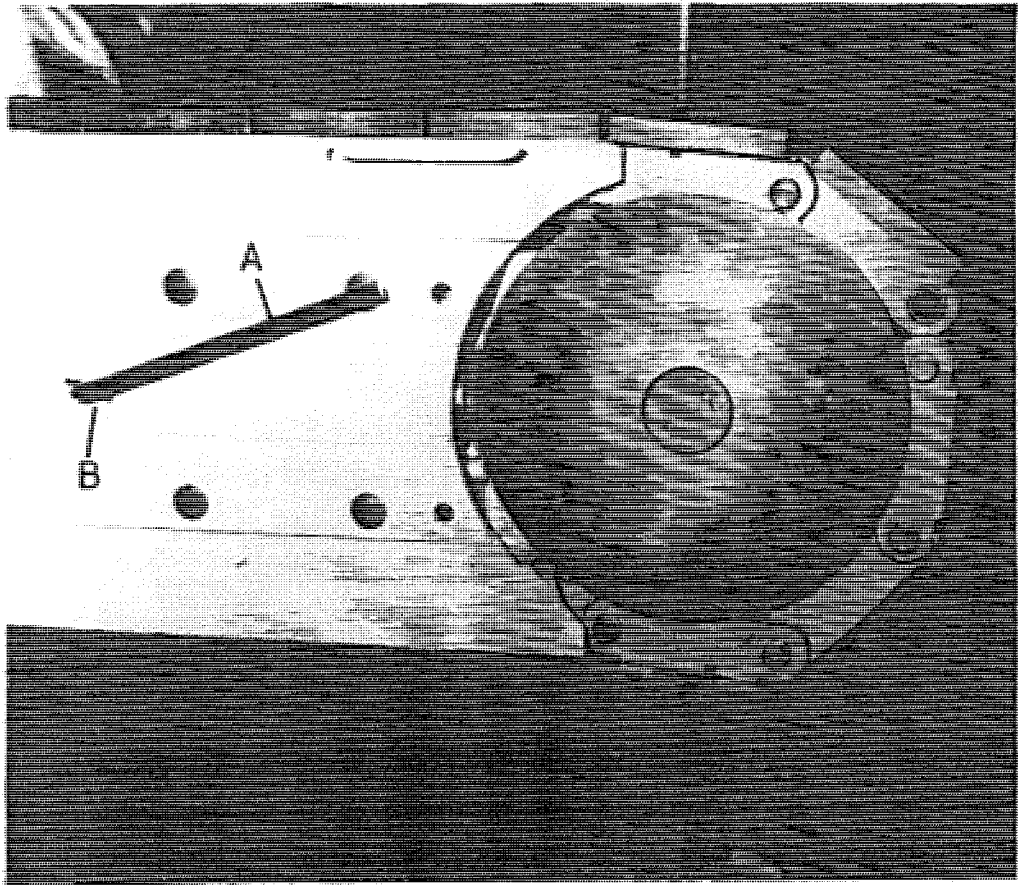


FIG. 47

SECTION D (Cont..)ADJUSTMENTSDOGS Continued

- 3 When feeding timber with all dogs removed or secured below track the pressures should be set to minimum driving position by loosening the knurled locking handwheels "Q", turning knurled handwheels "R" until drive can be stopped by gripping drive shafts "S" with hand. When set relock handwheels "Q".

FENCE

Set fence "T" FIG.46 to guide the timber into the machine. Loosen lateral locking handle "U", set fence laterally by screw "V" in conjunction with digital readout "W". Relock handle "U".

Loosen vertical locking handle "X", set fence vertically by screw "Y". Relock handle "X".

The standard fence can be reversed to form a Core Guage Fence when feeding panels with overhanging veneers.

NOTE: Optional fence arrangements (EXTRA) are available for specific types of work:-

SWING AWAY FENCE
LONG FENCE

Further information on the above fences is available on request.

TENSIONING OF CHAIN TRACK

Check tension of track by running and check for oscillation of idle sprockets at front of machine. If tension required, proceed as follows:-

- 1 Release 8mm allen screws with long arm hexagon wrench "A" FIG.47 (supplied) in either side of each beam.
- 2 Turn cam "B" to retension chain beam.
- 3 When correct tension is reached relock 8mm allen screws.

SECTION ELUBRICATION

The undermentioned lubrication schedule must be followed to ensure long working life of all machine parts.

WEEKLY

- 1 Oil head screws, top pressure screws and slideways for heads and pressures.
- 2 Top up pneumatic lubricator bottle through plug until oil reaches correct level shown by indicator mark on the side of bottle.
- 3 Top up lubricator bottle for backshaft through filler plug.

The Variable Speed Drive Unit, Reduction Gearbox, Traverse Drive and all Motors are lubricated for life and should not require any further attention.

APPLICATION	A P P R O V E D L U B R I C A N T S					
	Castrol	BP	Shell	Esso	Texaco/ Caltex	Wadkin
Pneumatic Lubricators	Hyspin AWS 32	Energol HL32	Tellus 37	Nuto N32	Rando Oil 320	L1
General Lubricators	Magna 68	Energol HP68	Vitrea 68	Nuray	Ursa Oil P68	L4

NOTE: POINT 3 ONLY APPLIES FROM MACHINE NO. 82100 to 84135.

- 4 Lubricate Caterpillar pressures through grease nipple "X" FIG.32, 2 shots.

SECTION FGENERAL MAINTENANCETOP PRESSURE BELT TENSION ADJUSTMENT

- 1 Release set screw "A" FIG.48 and unfasten four hexagon nuts "B" and slide universal joint carrier about the elongated slots "C".
- 2 a) Vee belt pressures:- The correct belt tension is when the belt in the bottom centre of the pressure beam is tensioned up to be covered by approximately 3mm (1/8") of roller.
b) Caterpillar pressures:- The correct tension is when the pressure pads are taut to approximately 3mm (1/8").
- 3 When the belt is correctly tensioned, relock the four nuts "B" and reset the set screws "A".
- 4 Use the same procedure to adjust the tension of the belt on the opposite pressure beam.

BELT REPLACEMENT OR SPEED CHANGING ON "B" TYPE HEADS (WHEN FITTED)

Each belt driven head is fitted with two stepped pulleys to give alternative speeds of 3000rpm or 6000rpm, or 4500rpm and 6000rpm.

To change belt on each head for required speed, proceed as follows:-

- 1 Isolate machine electrically.
- 2 Remove 3 - button head screws "D" FIG.45 securing belt cover plate to head.
- 3 Remove belt cover plate "E".
- 4 Loosen 3 hexagon head nuts "F" at the rear of head pulley housing "G".
- 5 Locate 10mm toggle bar (supplied with machine) in motor mounting boss at point "H" and move motor about elongated slots "I" to release tension on pulley "J" and "K".
- 6 Fit belt on pulleys "J" and "K" to give required spindle speed.
NOTE: Belt is shown on the high speed pulleys "J" and "K" in illustration.
- 7 Apply tension to the belt by moving the motor with the toggle bar (located in motor mounting boss). Correct belt tension is when the belt deflection is approximately 10mm under slight finger pressure.
- 8 When belt tension is correct relock 3 hexagon head nuts "F".
- 9 Replace belt cover plate "E" and secure with the 3 - button head screws "D".

TENSIONING OR REPLACING BELTS ON S6 AND S7 SCORERS (WHEN FITTED)

- 1 To tension belts on scorers, proceed as follows:-
a) Loosen countersunk socket capscrew with allen key "L" (supplied) FIG.50.
b) Loosen 3 screws "M" and remove cover for access to belt.

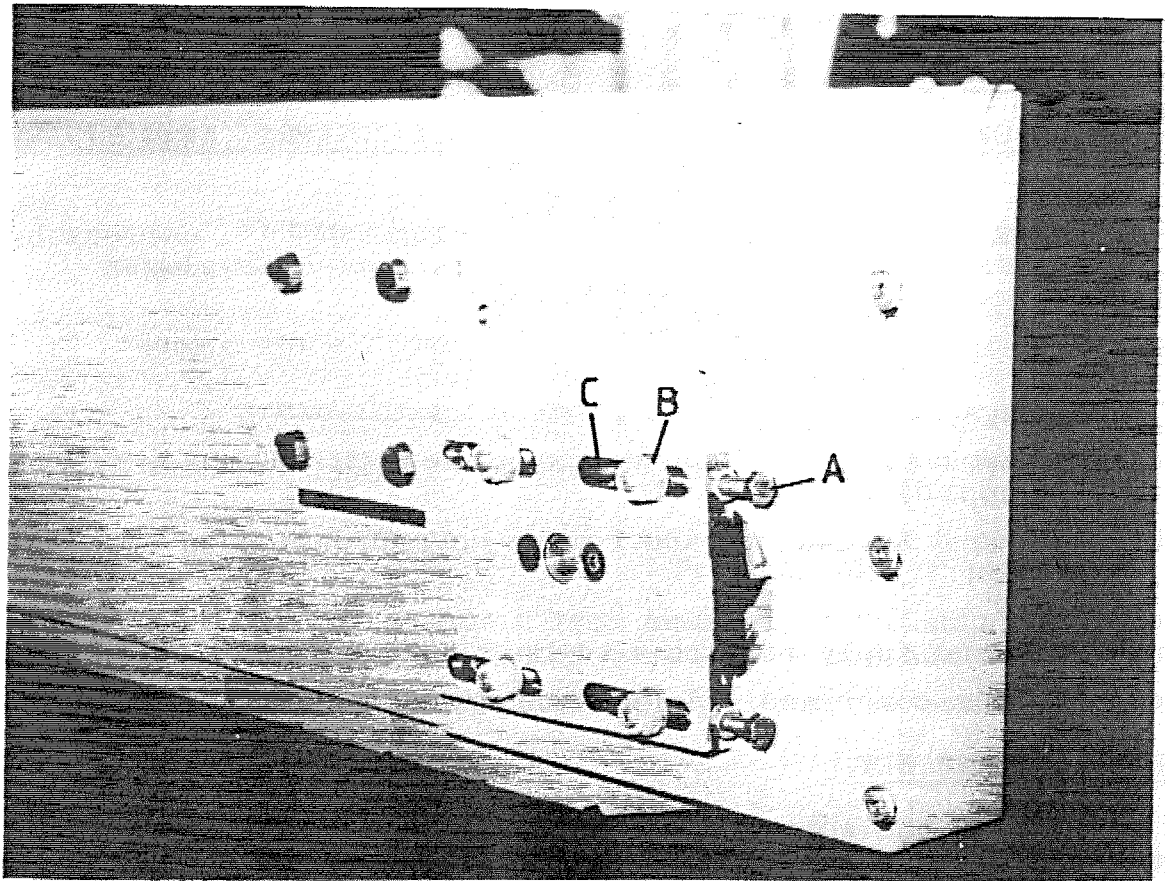


FIG. 48

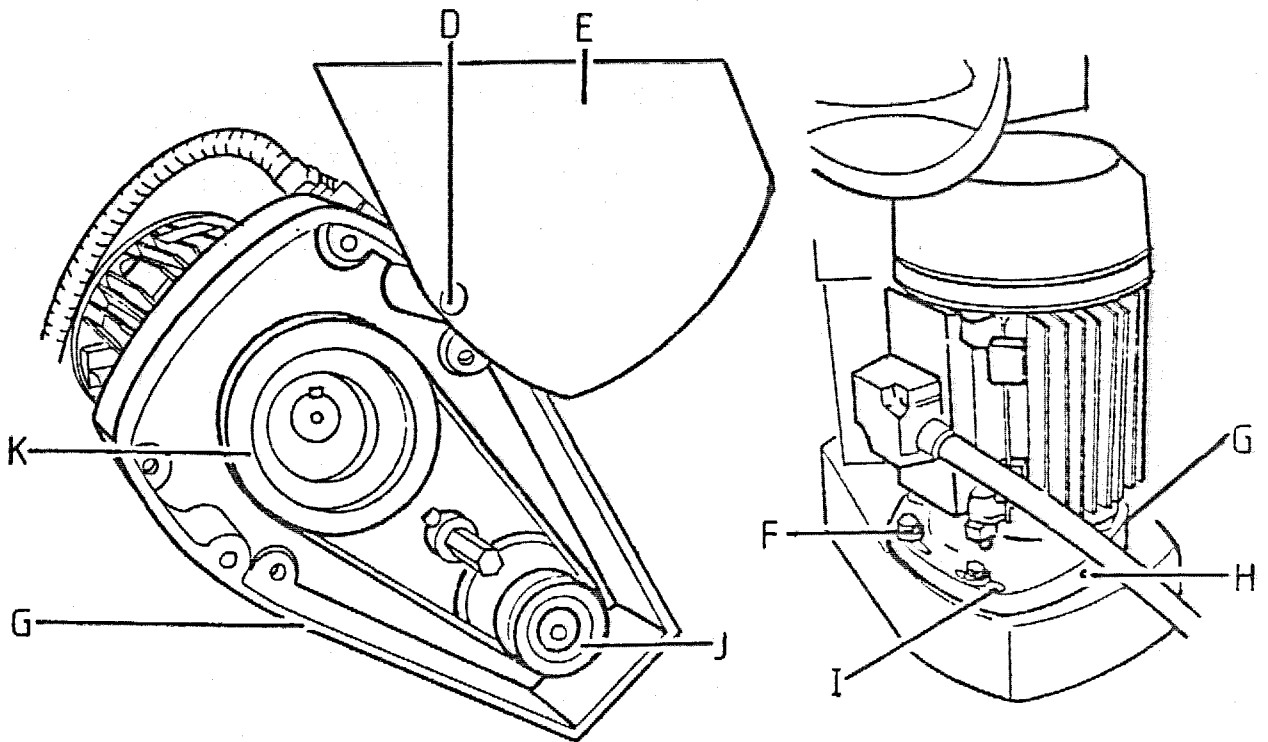


FIG. 49

SECTION F (Cont..)GENERAL MAINTENANCETENSIONING OR REPLACING BELTS ON S6 and S7 SCORERS (WHEN FITTED)
Continued

- 1 c) Apply tension to the belt by turning cam "N". Correct belt tension is when the belt deflection is 5mm under slight finger pressure.
- d) Replace cover and relock countersunk socket screw.
- 2 To change belts on scorers, proceed as follows:-
 - a) Loosen countersunk socket capscrew with allen key "L" (supplied) FIG.50.
 - b) Loosen 3 screws "M" and remove cover for access to belt.
 - c) Turn cam "N" to release belt tension on pulleys. Fit new belt and apply tension to belt as previously described.
 - d) Replace cover and relock countersunk socket screw.

BACKSHAFT SHEAR KEY

The drive from the worm reduction box to the backshaft "A" FIG.51 is through a shear key "B" located in the coupling "C". This key prevents overload on the drive assembly. In the event of an overload the shear key can be removed by inserting a 8mm allen key in the hexagon socket capscrew "D". Replace with a new key.

SETTING DISAPPEARING DOGS FOR SQUARENESS

The disappearing dogs are preset for squareness at these works. If adjustment becomes necessary, proceed as follows:-

- 1 Place a large machine square with stock to fence and blade across the tracks FIG.52.
- 2 By means of FEED BUTTON START/STOP (see control section). Bring a pair of dogs up to blade of square as shown.
NOTE: Each pair of dogs should be up to blade during check. Fixed dogs are fitted to one track and adjustable dogs to the other.
- 3 Align out of square dogs by loosening the button head socket screw in the adjustable dog then slide diagonally until it touches the machine square and so line up with the opposite track. When set relock button head screw.
- 4 Dogs not being used can be secured below the track by depressing dog with key supplied then giving half a turn.

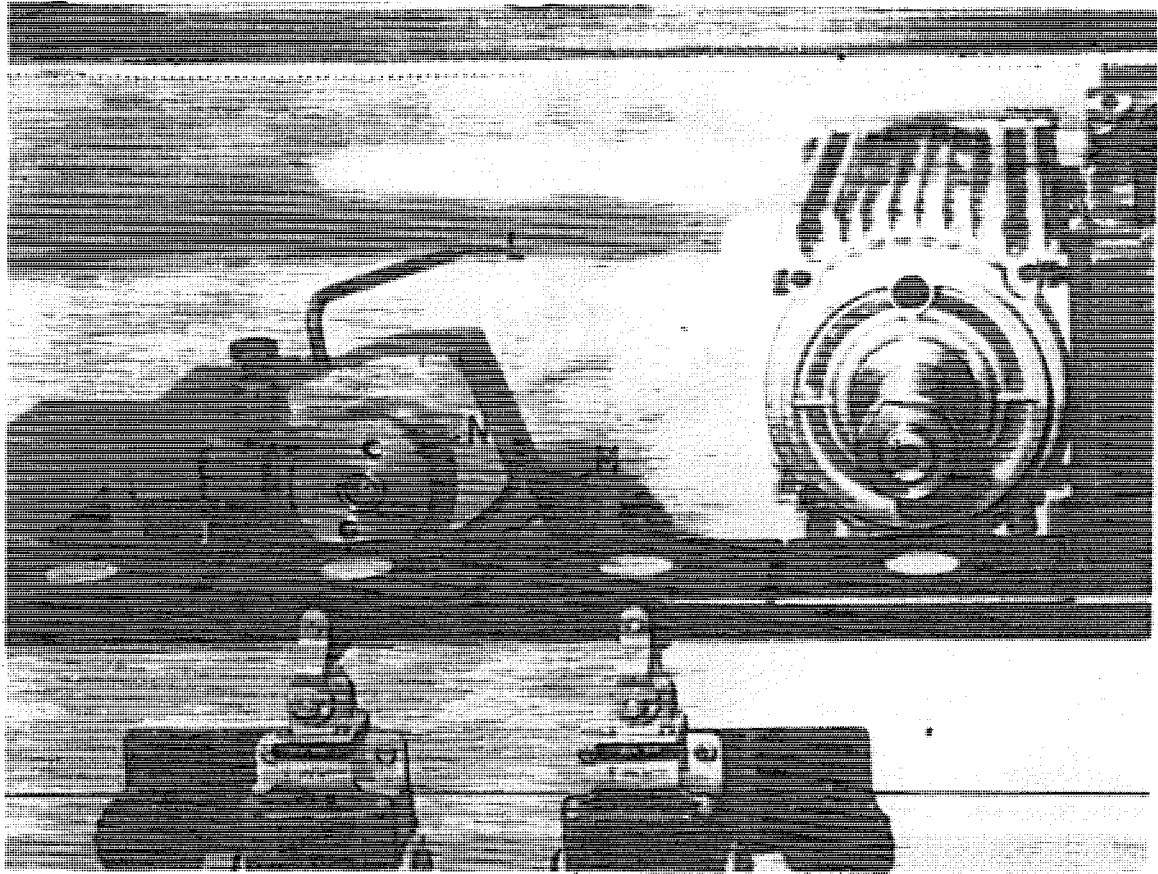


FIG. 50

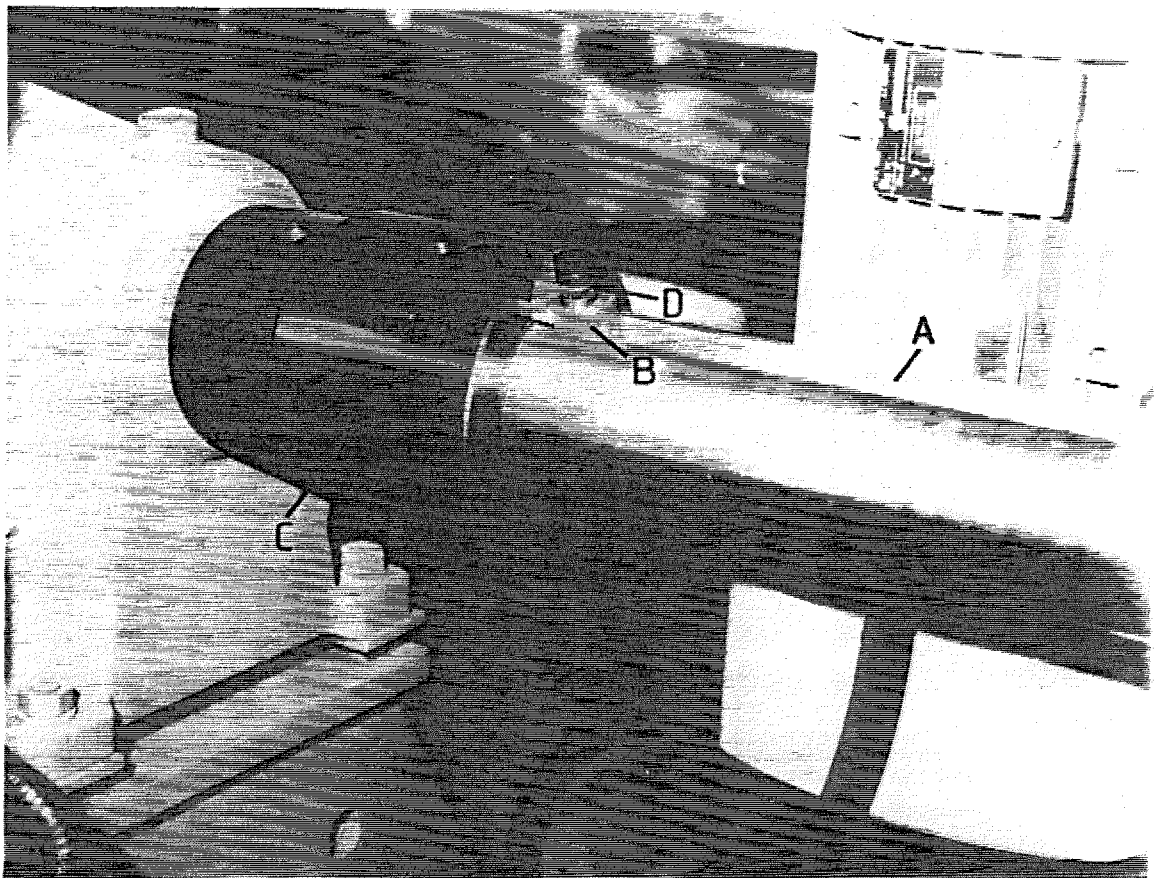


FIG. 51

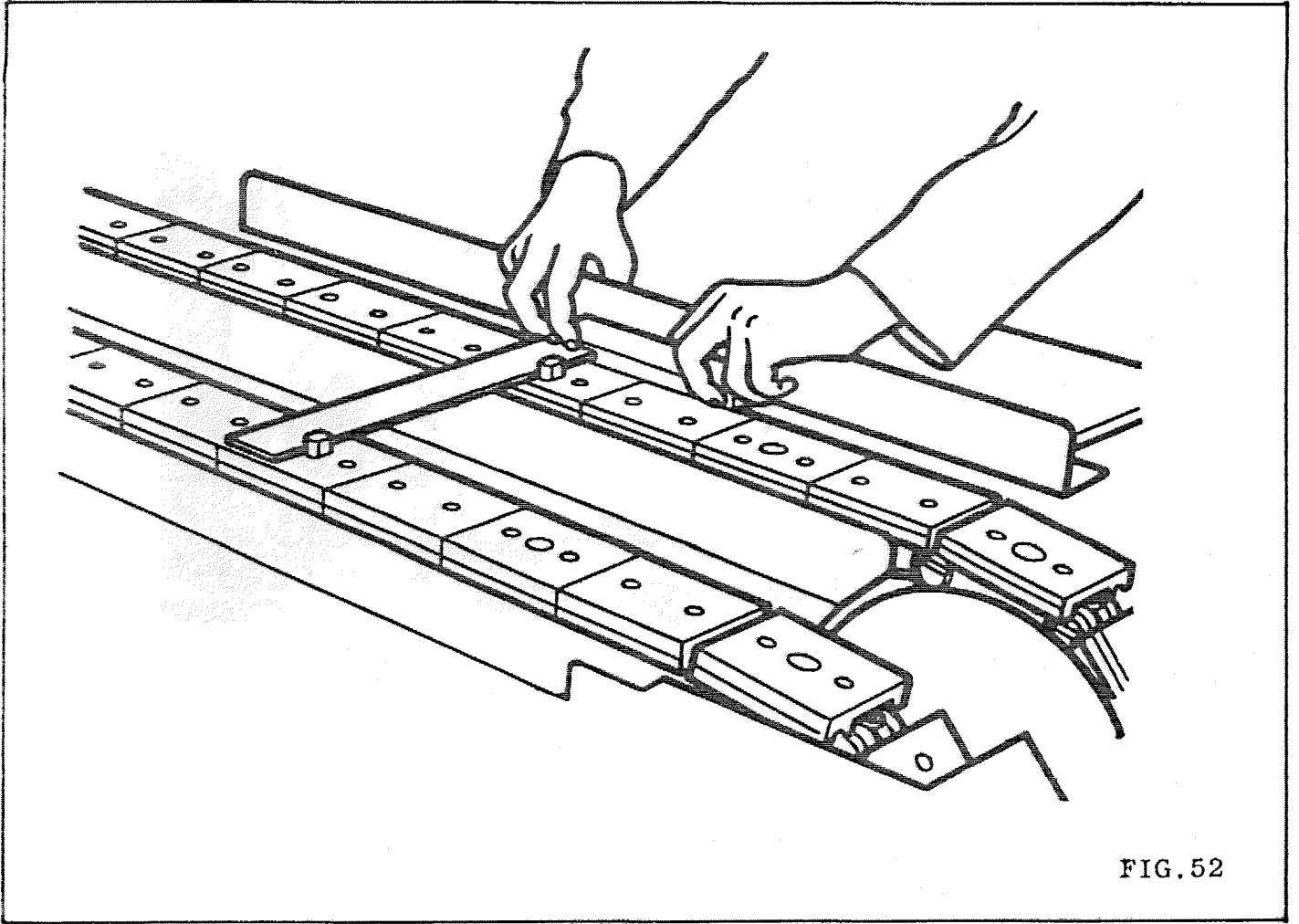


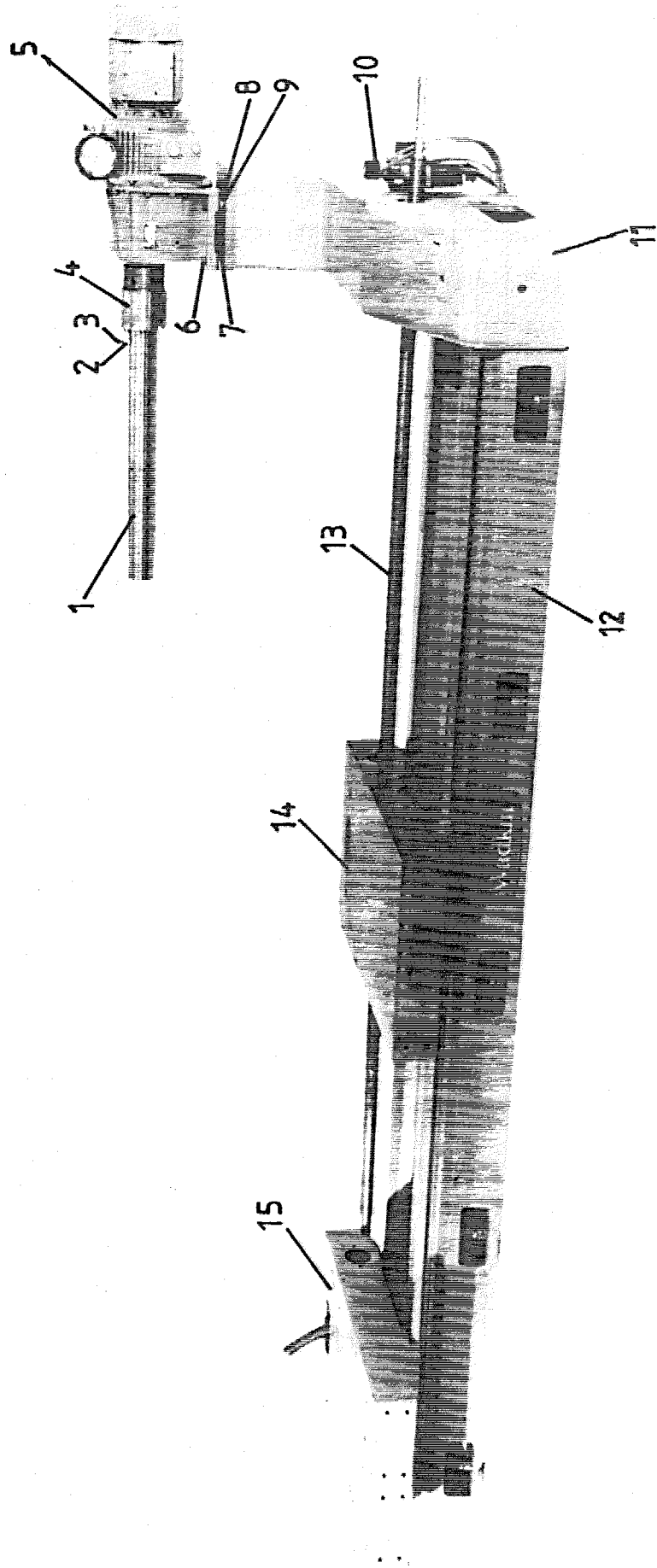
FIG. 52



ILLUSTRATED PARTS LIST

ASSEMBLY:- BED ASSEMBLY

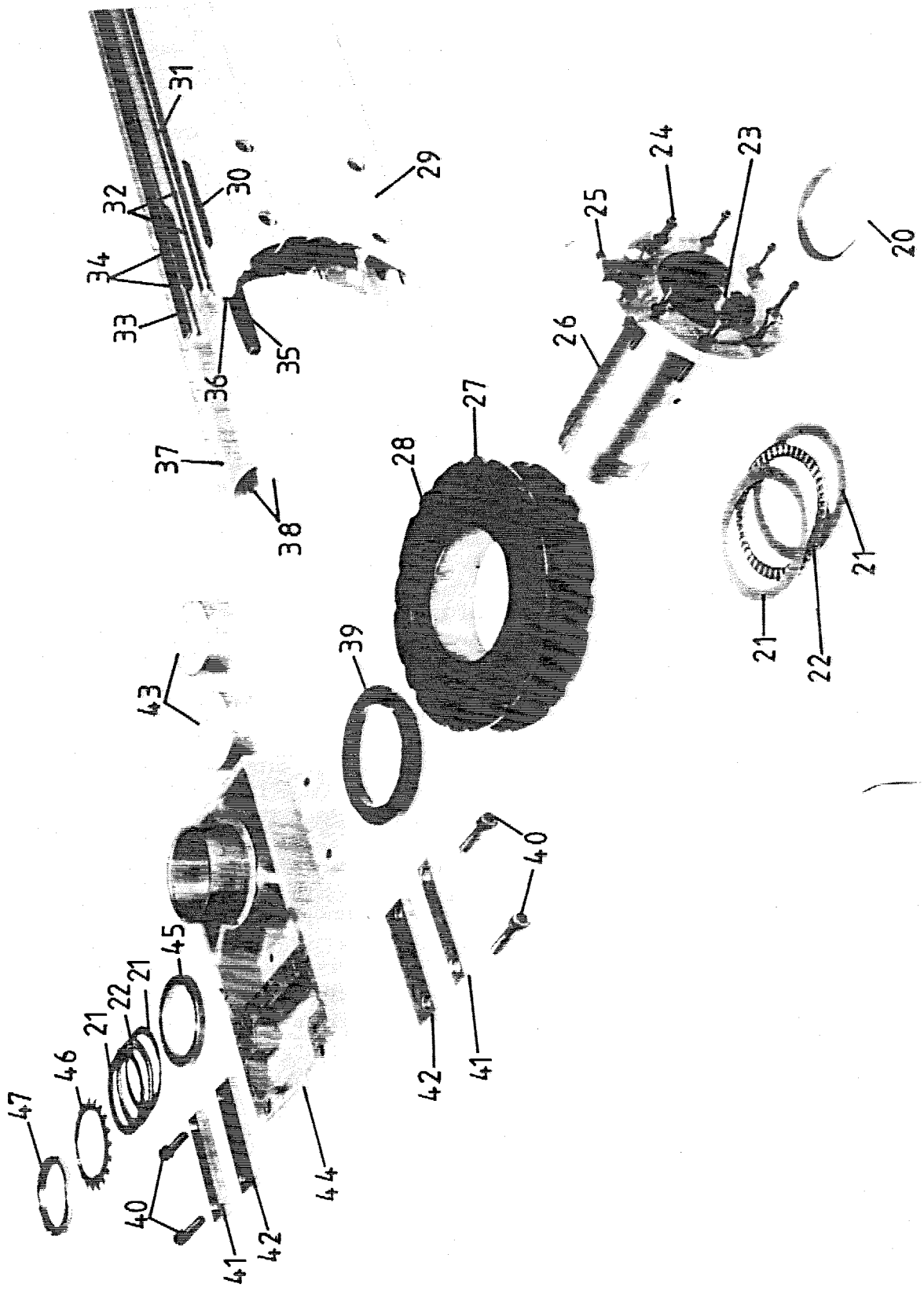
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
1	DL627	1	1760 Capacity Backshaft
	DL534	1	2760 Capacity Backshaft
	DL535	1	3460 Capacity Backshaft
2	DL525	1	Shear Key
3	K05-25-188	1	M8 x 25 Long Socket Capscrew
4	DL806	1	Backshaft Coupling
5		1	Simplatroll Unit Type:- 11.602.05.16.0.1.5kw to give 3-18 m/min at 50 hz complete with Indicator Handwheel in position H2
		1	Simplatroll Unit Type:- 11.602.05.16.0.1.5kw to give 10-60 ft/min at 60 hz complete with Indicator Handwheel in position H2
		1	Simplatroll Unit Type:- 11.602.05.20.0.2.2kw to give 6-35 m/min at 50 hz complete with Indicator Handwheel in position 2
6		4	M12 Nuts
7	DL927	2	Drive Jacking Plates
8	DL804	4	Studs for Drive Unit
9	DL930	4	Washers for Drive Unit
10		1	Vitaliser Unit
11	DA34	1	Plinth for Feed Drive
12	DL555	1	1760 Capacity Bed
	DL552	1	2760 Capacity Bed
	DL564	1	3460 Capacity Bed
13	1079/1708	1	1760 Capacity Traverse Screw
	DL906	1	2760 Capacity Traverse Screw
	1079/1701	1	3460 Capacity Traverse Screw
14	DA2	1	Adjustable Saddle (See page 64 for exploded views)
15	DA100	1	Fixed Saddle (See page 62 for exploded views)



Wadkin Bursgreen

ILLUSTRATED PARTS LIST

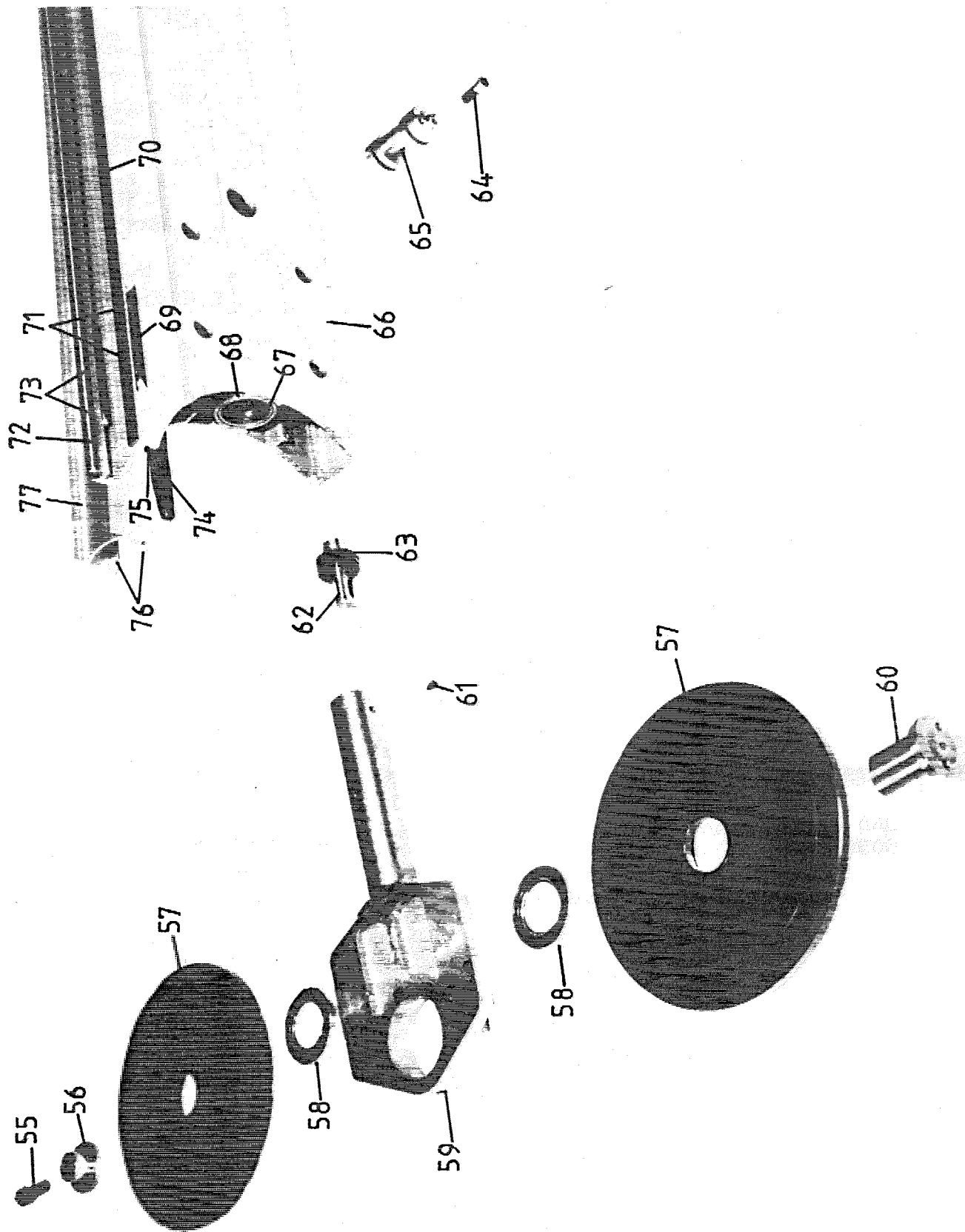
ASSEMBLY:- DRIVE SPROCKET ASSEMBLY			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
20	DL38	1	Spacer for Hub
21	K06-10-263	4	Ina Thrust Washer AS-85110
22	K06-10-223	2	Ina Bearing AXK-85110
23	DL528	1	Adjustable Backshaft Key
	DA190	1	Fixed Backshaft Key
24	K05-25-175	8	M6 x 65 Long Socket Capscrew
25	K05-26-127	2	M8 x 16 Long Socket Set Screws
26	DA30	1	Hub for Feed Drive Chain
27	DA31	1	Feed Driving Sprocket
28	K05-25-230	1	M12 x 25 Long Socket Capscrew
29	DA266	1	Right Hand 48 Pitch Chain Beam
	DA267	1	Left Hand 48 Pitch Chain Beam
	DA268	1	Right Hand 56 Pitch Chain Beam
	DA269	1	Left Hand 56 Pitch Chain Beam
	DA270	1	Right Hand 64 Pitch Chain Beam
	DA271	1	Left Hand 64 Pitch Chain Beam
30	DA262	2	Top Action Guide
31	DA168	1	Guide Bar for 48 Pitch Chain Beam
	DA72	1	Guide Bar for 56 Pitch Chain Beam
	DA73	1	Guide Bar for 64 Pitch Chain Beam
32		2	M4 x 12 Long Socket Capscrews
33	DA263	1	Slide Strip for 48 Pitch Chain Beam
	DA264	1	Slide Strip for 56 Pitch Chain Beam
	DA265	1	Slide Strip for 64 Pitch Chain Beam
34		2	M4 x 10 Long Countersunk Head Screws
35	DA187	1	Central Chordal Action Guide
36	K05-25-144	2	M5 x 16 Long Socket Capscrews
37	DA74	1	Return Guide 48 Pitch Chain Beam
	DA75	1	Return Guide 56 Pitch Chain Beam
	DA76	1	Return Guide 64 Pitch Chain Beam
38	DA27	2	Chain Return Strip 48 Pitch Chain Beam
	DA70	2	Chain Return Strip 56 Pitch Chain Beam
	DA71	2	Chain Return Strip 64 Pitch Chain Beam
39	DL15	1	Clamp Ring for Drive Sprocket
40	K05-25-235	4	M12 x 50 Long Socket Capscrews
41	DA84	2	Key for Backshaft Bearing Bracket
42	DA85	2	Clamp Plate for Bearing Bracket
43	K30-05-274	2	Glacier Bushes MB 85 40 DX
44	DA63	1	Bearing Bracket for Backshaft
45	K30-74-310	1	Oil Seal SN70/85/8
46	MB17	1	85 Dia Tab Lock Washer
47	K05-27-218	1	M85 x 1.5 Chamfer Notched Nut





ILLUSTRATED PARTS LIST

ASSEMBLY:- IDLE SPROCKET ASSEMBLY			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
55	K05-25-231	1	M12 x 30 Long Socket Capscrew
56	1079/16	1	Idle Sprocket Locking Cap
57	DA64	2	Idle Sprocket
58	K06-01-129	2	6008-2RS Bearings
59	DA65	1	Sprung Jockey Arm
60	1079/15	1	Idle Sprocket Spindle
61		1	M8 x 12 Long Dog Point Screw
62	DA67	1	Plunger for Idle Sprocket
63		5	40 x 16.3 x 2.00 Din Disc Springs
64	DA69	2	Lock Screw for Cam
65	DA68	1	Cam for Idle Sprocket
66	DA266	1	Right Hand 48 Pitch Chain Beam
	DA267	1	Left Hand 48 Pitch Chain Beam
	DA268	1	Right Hand 56 Pitch Chain Beam
	DA269	1	Left Hand 56 Pitch Chain Beam
	DA270	1	Right Hand 64 Pitch Chain Beam
	DA271	1	Left Hand 64 Pitch Chain Beam
67	K05-22-445	2	1½" x 2" x 1½" Long Oilite Bushes
68	DA66	1	Sleeve for Idle Sprocket
69	DA262	2	Top Action Guide
70	DA263	1	Slide Strip for 48 Pitch Chain Beam
	DA264	1	Slide Strip for 56 Pitch Chain Beam
	DA265	1	Slide Strip for 64 Pitch Chain Beam
71		2	M4 x 10 Long Countersunk Head Screws
72	DA168	1	Guide Bar for 48 Pitch Chain Beam
	DA72	1	Guide Bar for 56 Pitch Chain Beam
	DA73	1	Guide Bar for 64 Pitch Chain Beam
73		2	M4 x 12 Long Socket Capscrews
74	DA187	1	Central Chordal Action Guide
75	K05-25-144	2	M5 x 16 Long Socket Capscrews
76	DA27	2	Chain Return Strips 48 Pitch Chain Beam
	DA70	2	Chain Return Strips 56 Pitch Chain Beam
	DA71	2	Chain Return Strips 64 Pitch Chain Beam
77	DA74	1	Return Guide 48 Pitch Chain Beam
	DA75	1	Return Guide 56 Pitch Chain Beam
	DA76	1	Return Guide 64 Pitch Chain Beam

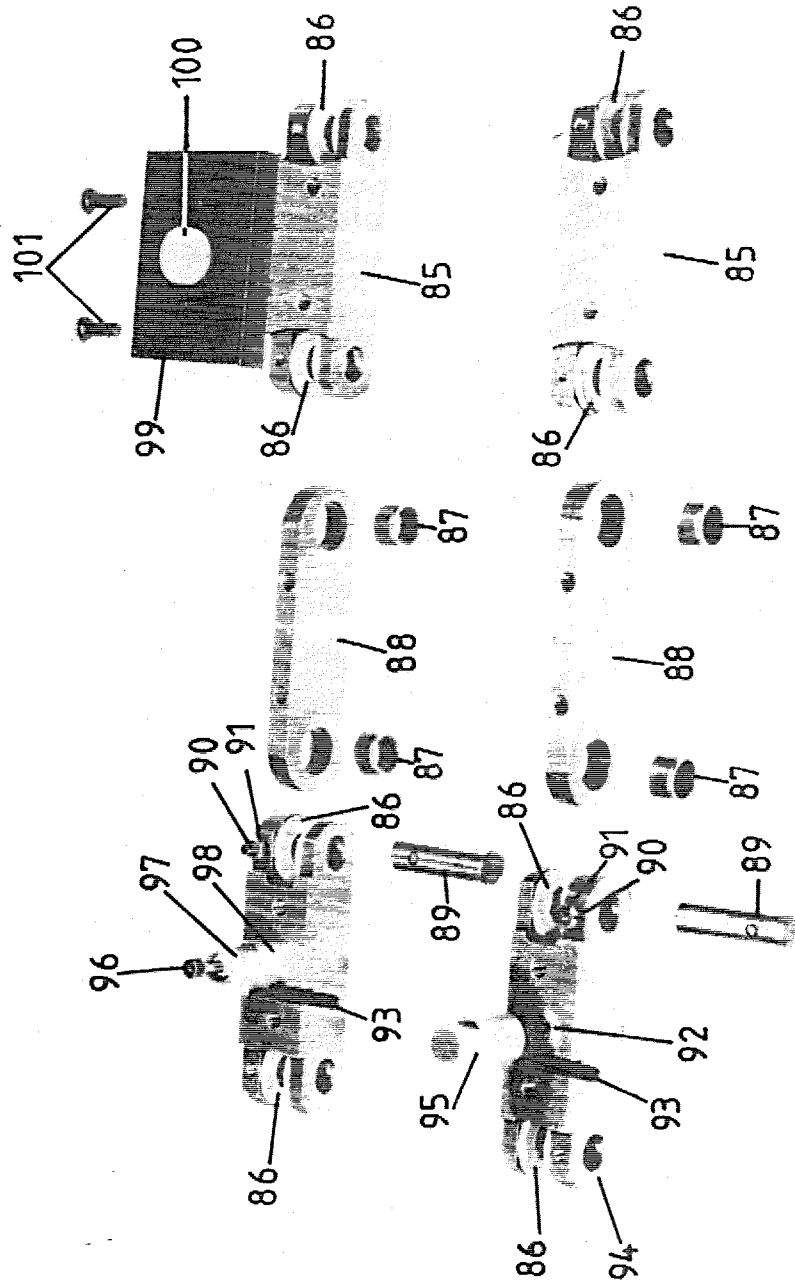




ILLUSTRATED PARTS LIST

ASSEMBLY:- CHAIN TRACK ASSEMBLY

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
85	DA234		Plain Chain Link (State Quantity Required)
86	DA17		Sealing Washer (State Quantity Required)
87	F-1612		Needle Roller Bearing (State Quantity Required)
88	DA4		Mail Chain Link (State Quantity Required)
89	DA21		Chain Axle (State Quantity Required)
90			M6 x 16 Long Cup Point Hexagon Socket Set Screw (State Quantity Required)
91			M6 Locknuts (State Quantity Required)
92	1079/190		Plug for Disappearing Dog (State Quantity Required)
	ETS93		Compression Spring (State Quantity Required)
	1079/233		Spring Seating for Dog (State Quantity Required)
93			8 Dia Steel Ball (State Quantity Required)
			6 Dia x 32 Long Groverlok Dowel (State Quantity Required)
94	DA3		Dog Chain Link RH (State Quantity Required)
	DA237		Dog Chain Link LH (State Quantity Required)
95	1079/400		Fixed Disappearing Dog (State Quantity Required)
96	1079/606		Lock Screw for Disappearing Dog (State Quantity Required)
97	1079/402		Head for Adjustable Disappearing Dog (State Quantity Required)
98	1079/401		Body for Adjustable Disappearing Dog (State Quantity Required)
99	DA5 Assembly		Guide Pad (State Quantity Required)
100	6099		Blanking Plugs (State Quantity Required)
101			M8 x 20 Long Nylok Socket Button Head Screw (State Quantity Required)





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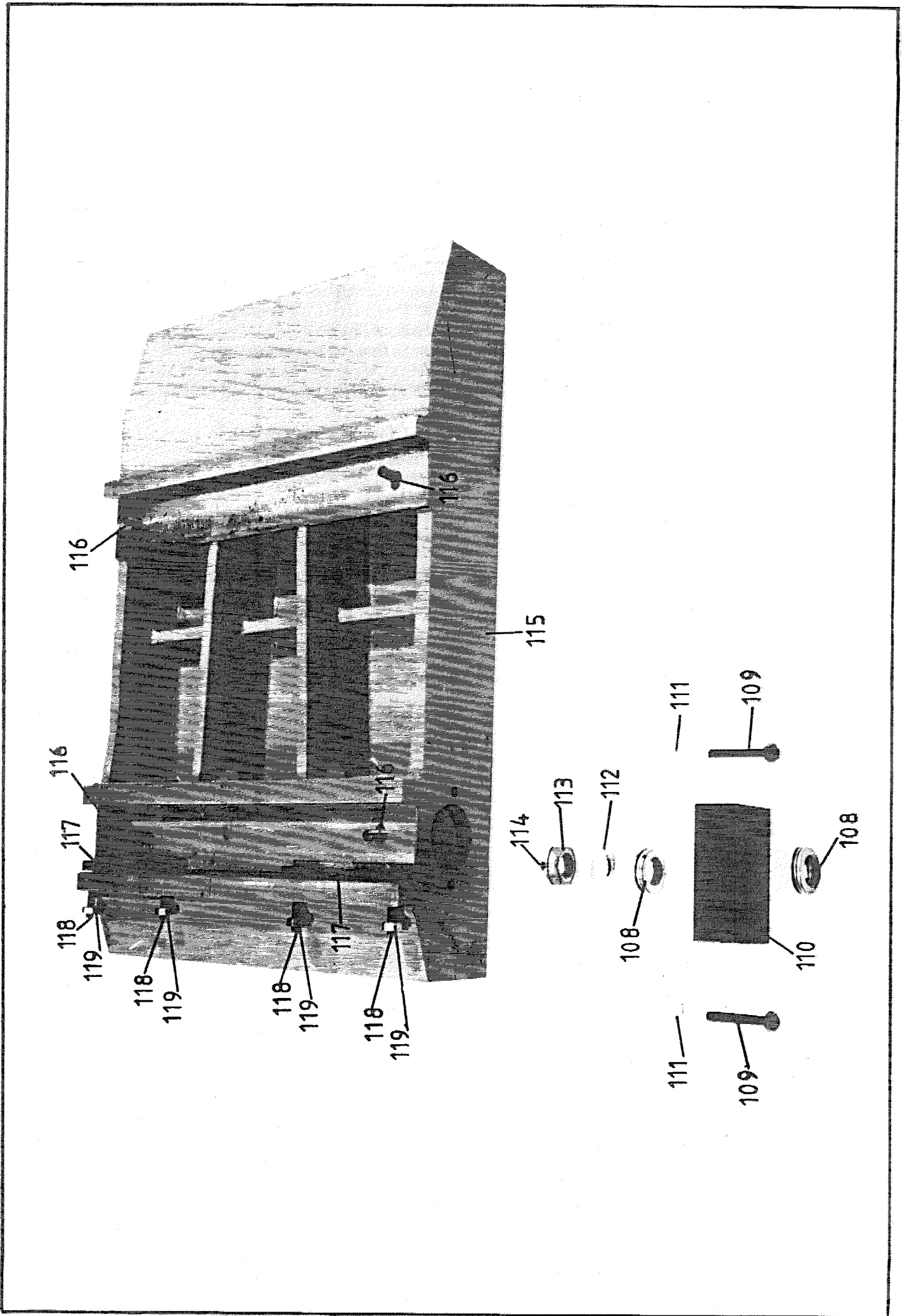
**ILLUSTRATED
PARTS
LIST**

ASSEMBLY:- FIXED SADDLE

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
108	K06-04-134	2	51105 Thrust Bearings
109	K05-25-535	2	M10 x 50 Long Hexagon Head Bolts
110	LP-16	1	Bearing Block
111	K05-28-104	2	10mm Washers
112	DL-527	1	Washer For Thrust Bearing
113	1079/430	1	Locknut for Traverse Screw
114	K05-25-327	1	M6 x 25 Long Countersunk Allan Screw
115	DA-100	1	Fixed Saddle
116	K05-25-232	4	M12 x 35 Long Socket Capscrews
117	DA-58	1	Gib for Fixed Saddle
118		4	M10 x 30 Long Full Dog Point Grubscrews
119	K05-27-110	4	M10 Thin Nuts

- ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE
NUMBER WHEN ORDERING SPARES



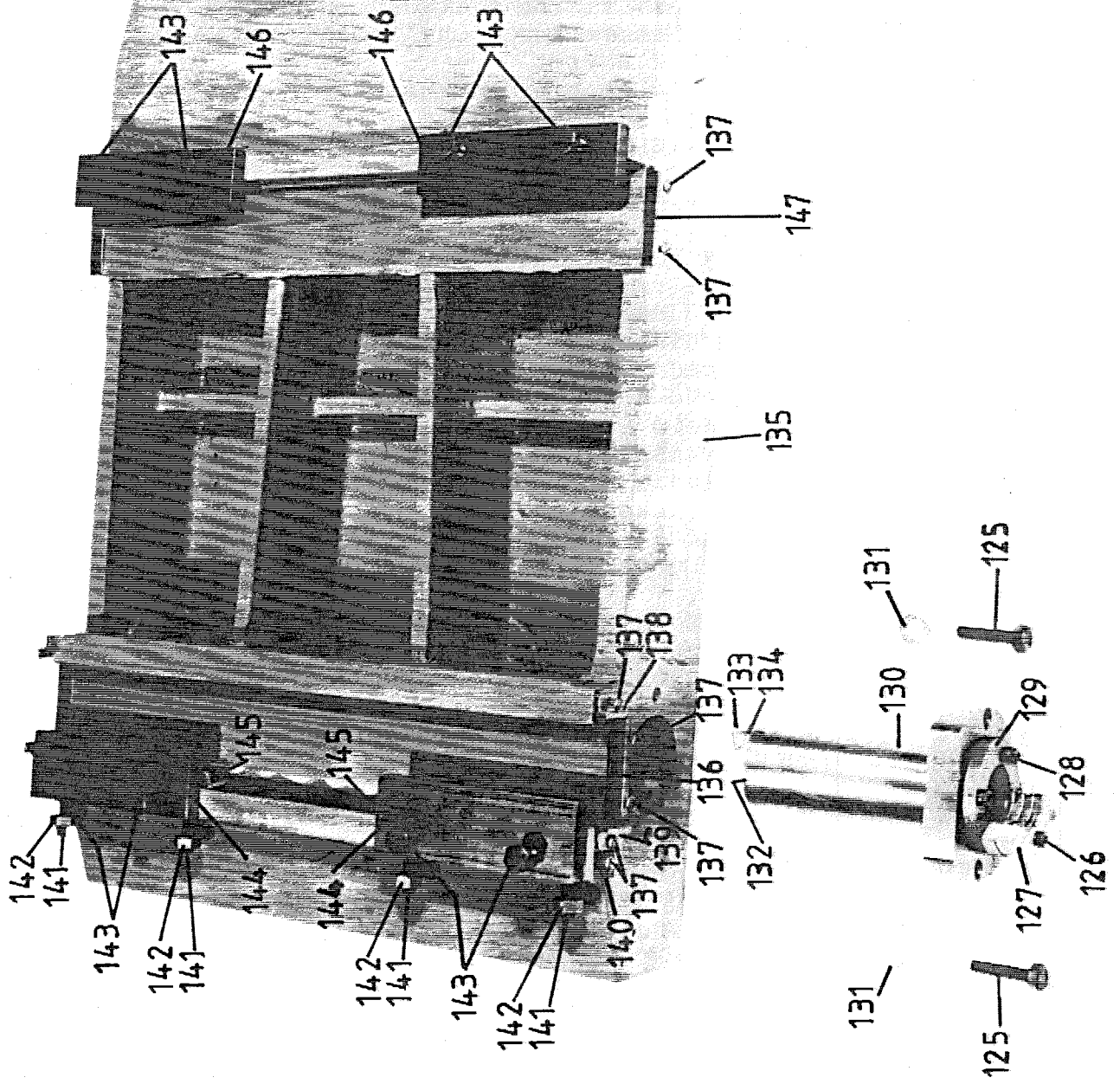


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**ILLUSTRATED
PARTS
LIST**

ASSEMBLY:- ADJUSTABLE SADDLE

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
125	K05-25-533	2	M10 x 40 Long Hexagon Head Bolts
126		1	M6 x 40 Long Socket Capscrew
127	LP-227	1	Outer Traverse Wiper
128		2	M6 x 25 Long Socket Capscrews
129	DA-94	1	Retaining Plate for Traverse Nut
130	DA-92	1	Housing for Traverse Nut
131	K05-28-104	2	10mm Washers
132	DA-93	1	Traverse Nut (Inside DA-92)
133		1	M5 x 25 Long Socket Capscrew
134	DA-261	1	Inner Traverse Wiper
135	DA-2	1	Adjustable Saddle
136	DA-384	1	Adjustable Saddle Top Wiper LH
	DA-385	1	Adjustable Saddle Top Wiper RH
137		14	M5 x 10 Long Cheese Head Screws
138	DA-386	1	Adjustable Saddle Side Wiper LH
	DA-387	1	Adjustable Saddle Side Wiper RH
139	1079/1352	2	Gib Wipers
140	DA-102	2	Bed Wiper Mounting Plate
141	K05-26-631	4	M10 x 30 Long Cone Point Grubscrews
142	K05-27-110	4	M10 Thin Nuts
143	K05-25-530	8	M10 x 30 Long Hexagon Head Bolts
144	DL-20	2	Lip Plate (Rear)
145	DA-57	2	Gib for Adjustable Saddle
146	DL-19	2	Lip Plate (Front)
147	1079-1353	2	Bed Wiper



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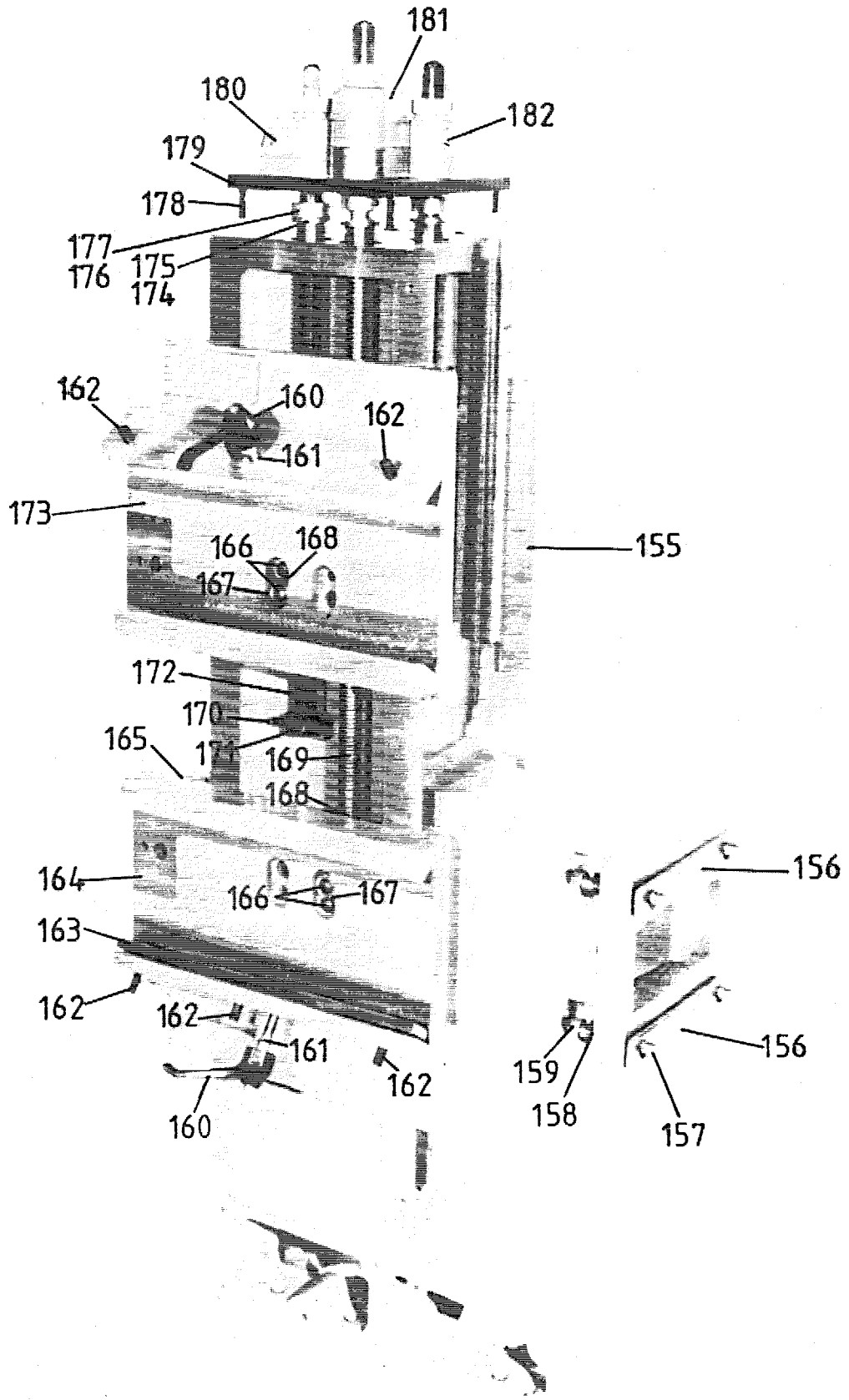
ILLUSTRATED PARTS LIST

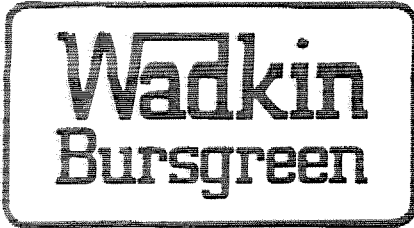
ASSEMBLY:- MAIN COLUMN

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
155	DA-1	1	Main Column
156	DA-82	2	Main Column Keys
157	DA-227	4	Beam Fixing Studs
158	DL-930	4	Washers for Chain Beam
159		4	M12 Nuts
160	K51-27-191	2 per	M10 Locking Handles
			Backslide
161	K05-26-266	2 per	M10 x 45 Long Studs
			Backslide
162	K05-26-139	4 per	M10 x 20 Long Socket Set Screws
			Backslide
163	1079/307	1 per	Cross Slide Gib Strip
			Backslide
164	DA-360		Backslide RH
165	1079/306	1 per	Rise and Fall Gib Strip
			Backslide
166		2 per	M8 x 20 Long Button Heads
			Backslide
167	1041/88	1 per	Washer
			Backslide
168	1079/1636	1 per	Backslide Nut
			Backslide
169	DA-89	1 per	Bottom Rise and Fall Screw
			Btm Head
170		2 per	M8 x 8 Long Socket Set Screws
			Top Head
171	1079/681	1 per	Stop for Rise and Fall Screw
			Top Head
172	DA-88	1 per	Top Rise and Fall Screw
			Top Head
173	DA-359		Backslide RH
174	K06-10-356	2 per	Thrust Washer XWA203501
			Screw
175	K06-10-355	1 per	Thrust Race XRK203502
			Screw
176	DA-80	1 per	Thrust Collar for Rise and Fall Screw
			Screw
177		1 per	5 Dia x 32 Long Groverlok Dowel
			Screw
178	K05-25-189	4	M8 x 30 Long Socket Capscrews
179	DA-95	1	Top Plate
180	K51-09-126	1 per	KB-7519 Counter, Rotation 1 (Metric)
			Top Head
	K51-09-129	1 per	LB-7519 Counter, Rotation 1 (Imperial)
			Top Head
181	K51-09-127	1 per	KF-7519 Counter, Rotation 2 (Metric)
			Btm Head
	K51-09-131	1 per	LF-7519 Counter, Rotation 2 (Imperial)

- ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE
NUMBER WHEN ORDERING SPARES





ILLUSTRATED PARTS LIST

ASSEMBLY:- MAIN COLUMN (Continued)			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
182	K51-09-126	1 per	KB-7519 Counter, Rotation 1 (Metric) Top Pressure
	K51-09-129	1 per	LB-7519 Counter, Rotation 1 (Imperial) Top Pressure

- ITEM NOT ILLUSTRATED

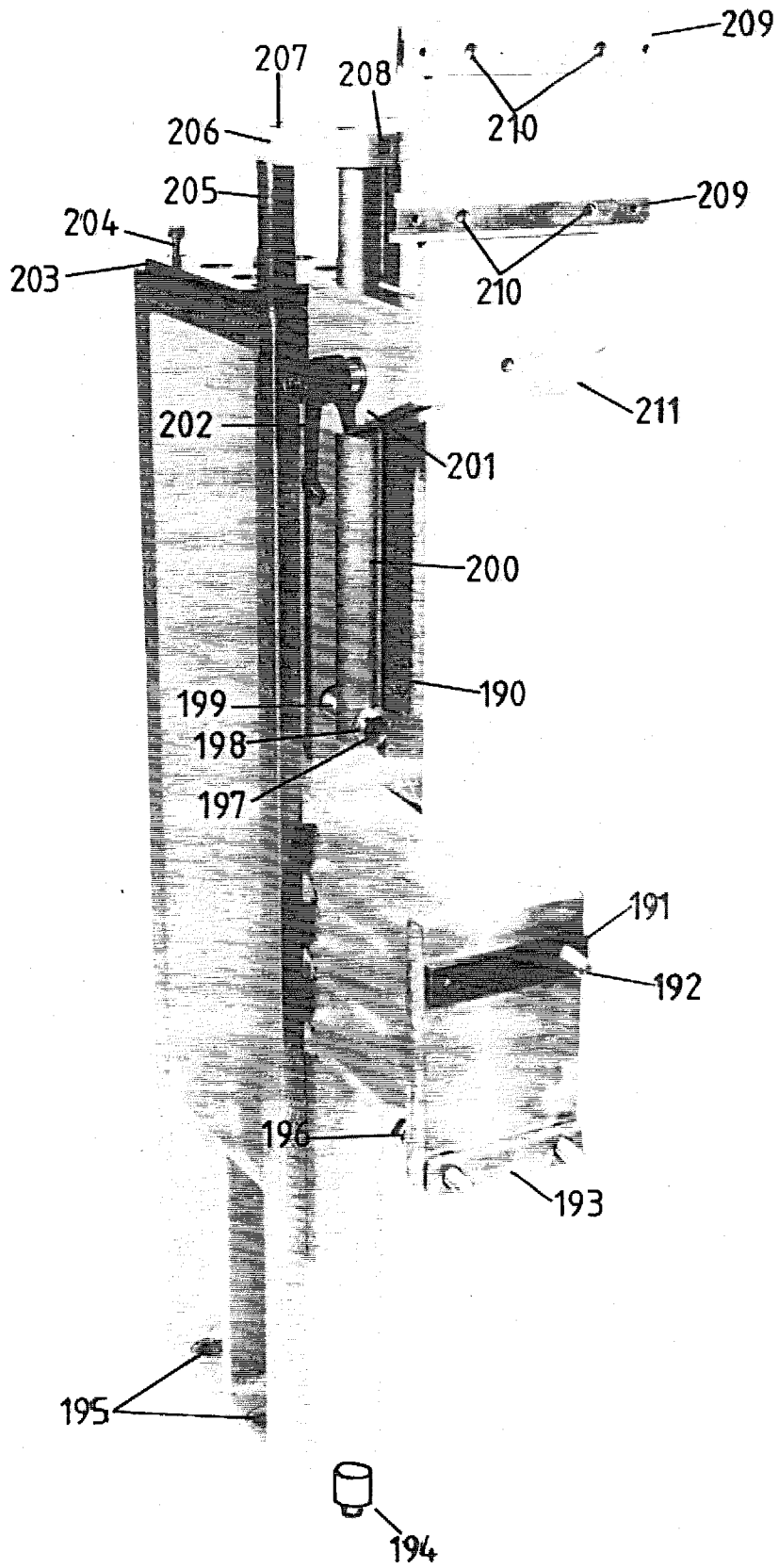
* PLEASE QUOTE PART & MACHINE
NUMBER WHEN ORDERING SPARES



ILLUSTRATED PARTS LIST

ASSEMBLY:- AUXILIARY COLUMN

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
190	DA-10	1	Auxiliary Column
191	DA-431	1	Top Auxiliary Column Key
192	DA-227	3	Beam Fixing Studs
193	DA-83	1	Bottom Auxiliary Column Key
194	DA-450	2	Auxiliary Column Jacking Blocks
195		4	M12 x 40 Long Socket Capscrews
196	K05-27-104	3	M12 Nuts
197	K05-27-217	1	M10 X 65 Long Socket Capscrew
198	1041/126	1	Locknut
199	1079/984	1	Adjuster for Locking Post
200	DA-171	1	Top Pressure Locking Post
201	DA-388	1	Top Pressure Locking Bracket RH
	DA-389	1	Top Pressure Locking Bracket LH
	DA-390	1	Top Pressure Locking Bracket RH
	DA-391	1	Top Pressure Locking Bracket LH
202	K51-27-190	1	M12 Locking Handle
203	DA-194	1	Top Plate for Column
204	K05-25-187	4	M8 x 25 Long Socket Capscrews
205	DA-453	2	Top Pressure Support Spacers
206	1079/641	1	Top Pressure Support Pad
207	K05-25-268	2	M10 x 120 Long Socket Capscrews
208	K05-26-137	1	M10 x 12 Long Socket Set Screw
209	DA-197	2	Keys for Top Pressure Support
210		4	M10 x 30 Long Button Heads
211	DA-131	1	Top Pressure Locking Shaft
	K51-09-126	1 per	KB-7519 Counter, Rotation 1 (Metric)
		Top Head	
	K51-09-129	1 per	LB-7519 Counter, Rotation 1 (Imperial)
		Top Head	
	K06-10-356	2 Per	Thrust Washers XWA203501
		Screw	
	K06-10-355	1 per	Thrust Race XRK203502
		Screw	
	DA-80	1 per	5 Dia x 32 Long Socket Capscrew
		Screw	
	DA-195	1 per	Top Rise and Fall Screw
		Top Head	
	DA-196	1 per	Bottom Rise and Fall Screw
		Btm Head	

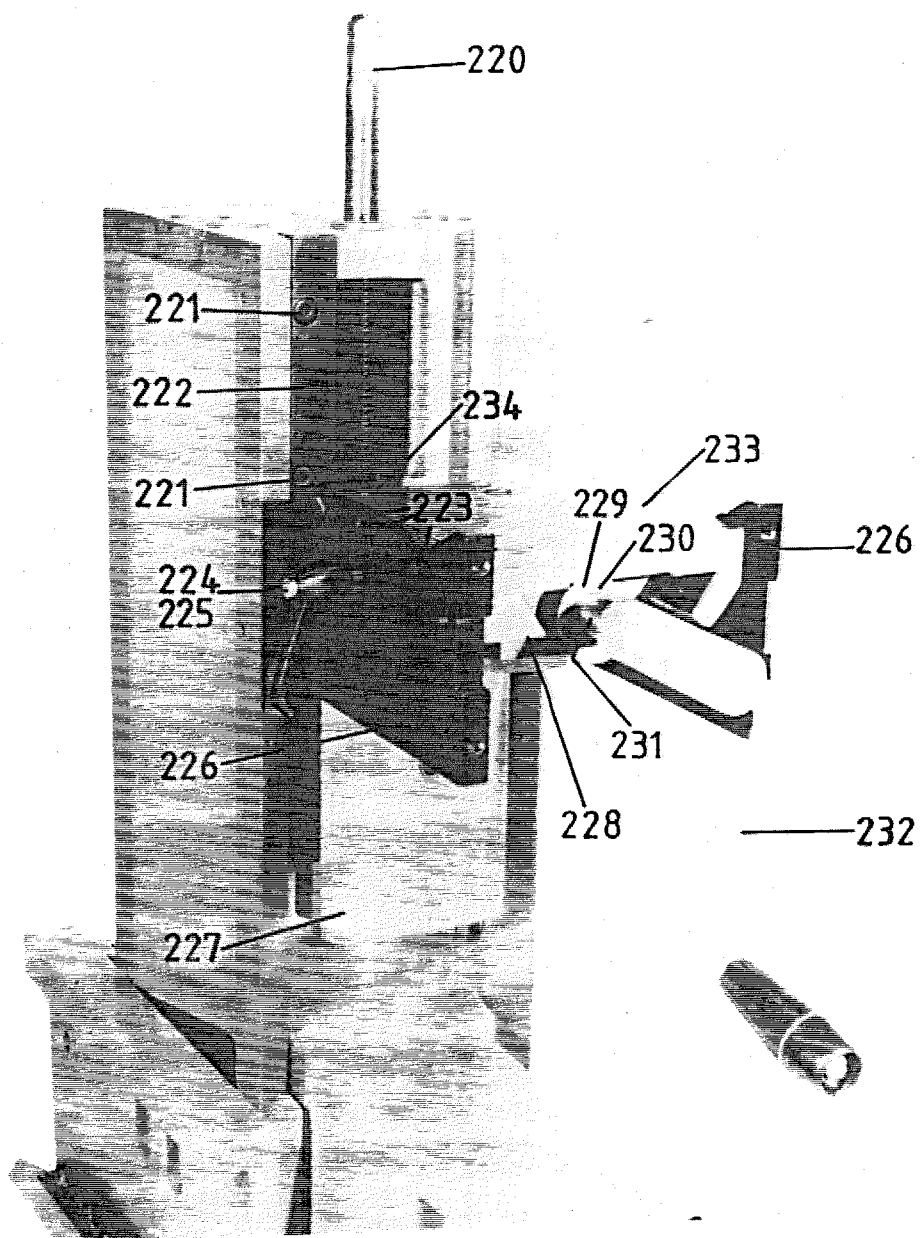


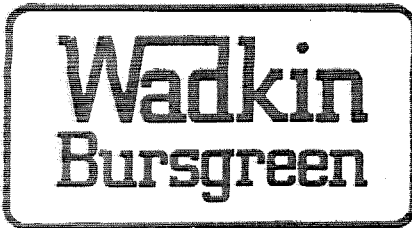


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**ILLUSTRATED
PARTS
LIST**

ASSEMBLY:- TOP PRESSURE LATERAL ADJUSTMENT			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
220	DA-28	1	Pressure Rise and Fall Screw
221	K05-25-189	4	M8 x 30 Long Socket Capscrews
222	DA-52	1	Gib for Pressure Rise and Fall
223	K05-25-187	6	M8 x 20 Long Socket Capscrews
224		2	M8 Locking Handle
225		2	M8 x 35 Long Studs
226	DA-11	1	Side Plate for Lateral Adjustment (LH)
	DA-12	1	Side Plate for Lateral Adjustment (RH)
227	DA-139	1	Top Pressure Adjusting Bracket
228	DA-49	1	Gib for Lateral Adjustment
229	1079/597	1	Slide Nut
230	1079/595	2	Screw Collars
231	DA-29	1	Lateral Adjusting Screw
232	1079/938	1	Cranked Handle
233	DA-145	1	Slide for Top Pressure Lateral Adjustment
234	DA-140	1	Rise and Fall Nut



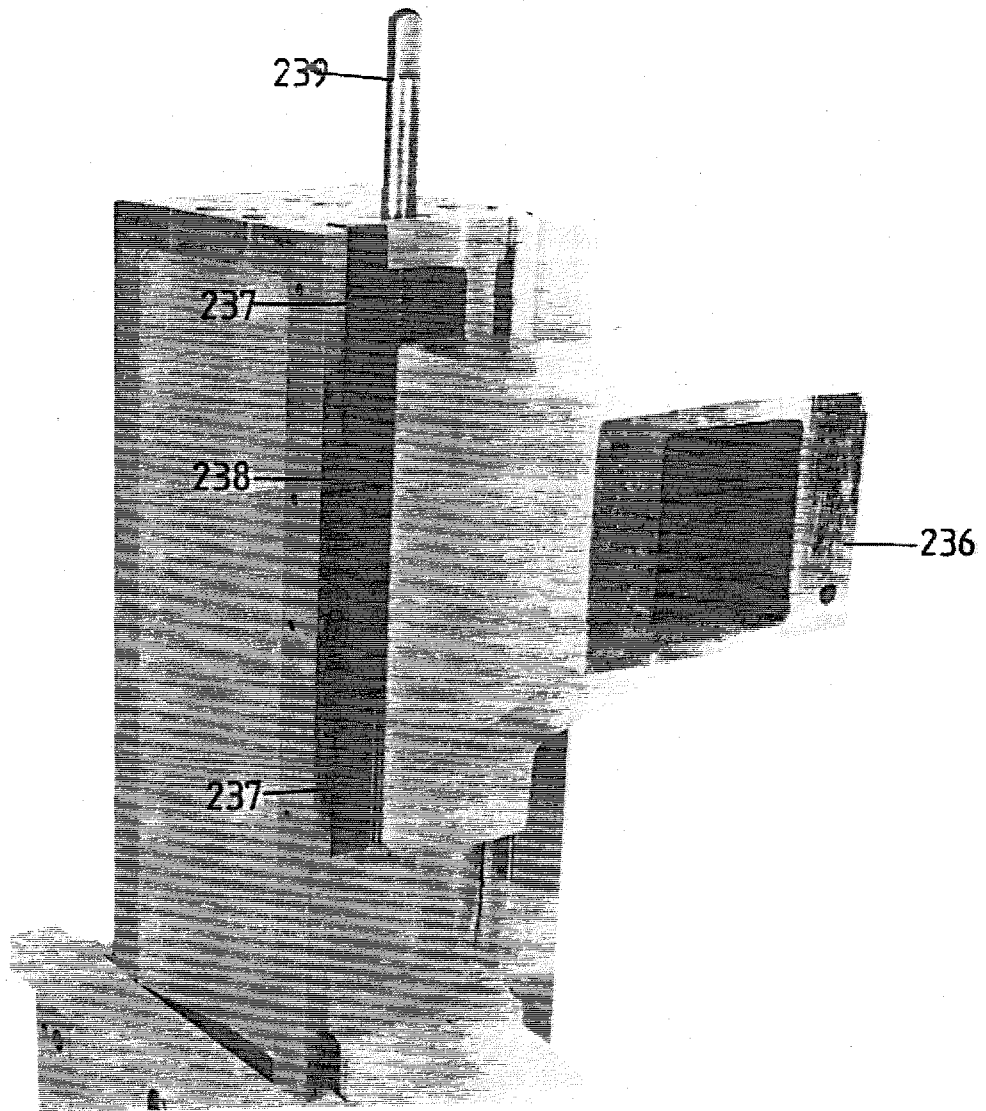


**ILLUSTRATED
PARTS
LIST**

ASSEMBLY:- TOP PRESSURE FIXING WITHOUT LATERAL ADJUSTMENT			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
236	DA-7	1	Top Pressure Bracket
237	K05-25-189	4	M8 x 30 Long Socket Capscrews
238	DA-52	1	Gib for Pressure Rise and Fall
239	DA-28	1	Pressure Rise and Fall Screw

- ITEM NOT ILLUSTRATED

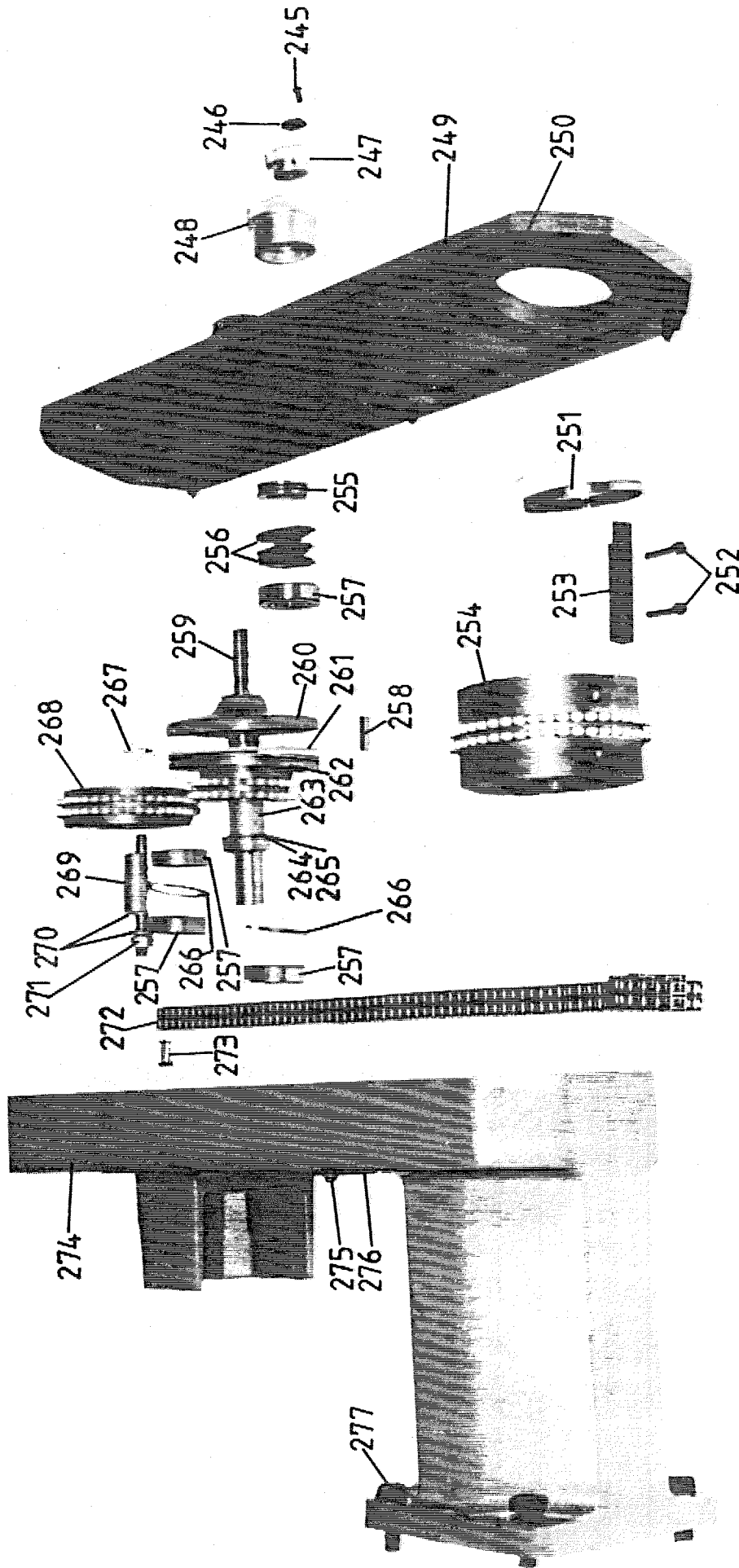
* PLEASE QUOTE PART & MACHINE
NUMBER WHEN ORDERING SPARES





ILLUSTRATED PARTS LIST

ASSEMBLY:- DRIVE TO TOP PRESSURES			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
245		1	M6 x 12 Long Button Head
246	1073/136	1	Washer
247	1079/136	1	Top Pressure Drive Adjusting Nut LH Beam
	1079/1629	1	Top Pressure Drive Adjusting Nut RH Beam
248	1079/137	1	Top Pressure Drive Locknut LH Beam
	1079/1630	1	Top Pressure Drive Locknut RH Beam
249	DL-563	1	Cover for Top Pressure Drive
250	K05-25-186	6	M8 x 16 Long Socket Capscrews
251	K51-55-173	1	Oil Seal SN70/85/8
252	K05-25-167	2	M6 x 25 Long Socket Capscrew
253	DL-36	1	Key for Drive Sprocket
254	DL-809	1	Sprocket for Drive
255	K06-04-190	1	Thrust Bearing ZKL-51105
256	K51-73-253	6	25 I/D x 50 O/D x 1.5 Thick Disc Springs
257	K06-01-207	4	Bearings 6205-2RS
258	K51-20-109	1	8 x 7 x 30 Long Key
259	1079/107	1	Top Pressure Drive Shaft Left Hand Beam
	1079/1631	1	Top Pressure Drive Shaft Right Hand Beam
260	1079/110	1	Clutch Plate
261	1079/108	1	Clutch Pad
262	DL-21	1	Sprocket for Clutch Shaft
263	K51-05-120	1	25 I/D x 30 O/D x 30 Long Bronze Bush
264	K06-10-254	2	Thrust Washer AS-2542
265	K06-10-213	1	Bearing AXK-2542
266	K51-10-206	2	Internal Circlip 7000-052
267	K51-10-407	1	Seeger External Circlip 25mm
268	DL-22	1	Sprocket for Idler
269	DL-24	1	Eccentric Shaft for Chain Idler Adjustment
270	K05-28-105	2	12mm Washers
271	K05-27-104	1	M12 Nut
272	K51-08-103	1 length	R & C Duplex Chain No. 114038 3/8" Pitch x 145 Pitches Long
273	K51-08-160	1	No. 26 Chain Connecting Link No.114038
274	DL-563	1	Housing for Top Pressure Drive
275		2	M8 x 12 Long Pan Heads
276	DL-41	1	Cover for Top Pressure Housing
277	K05-25-545	4	M12 x 35 Long Hexagon Head Bolts

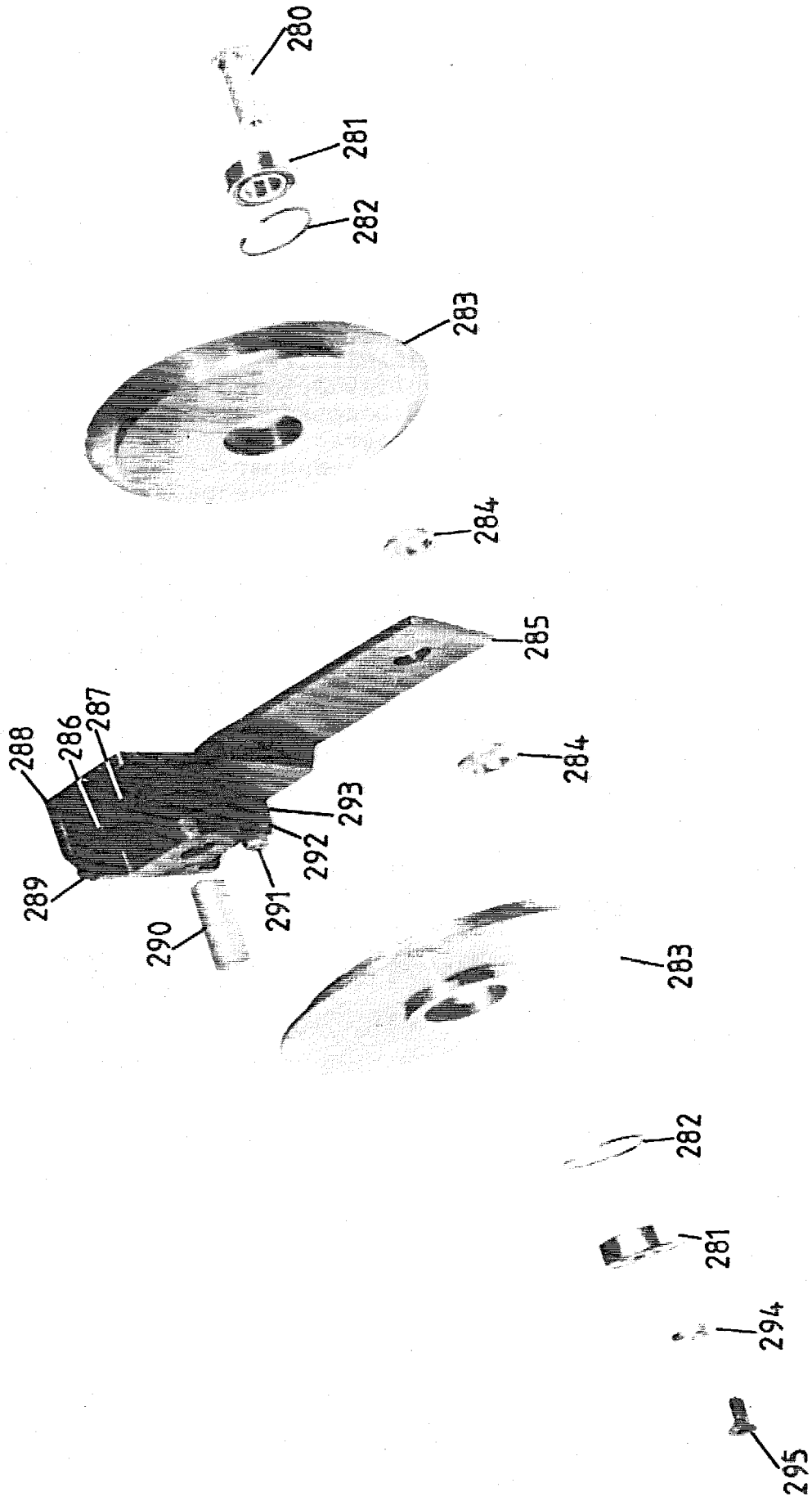




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**ILLUSTRATED
PARTS
LIST**

ASSEMBLY:- ROLLER PRESSURES - FRONT			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
280	DA-301	1	Bearing Pin for Pulley
281	K06-01-121	2	Bearings 6004-2RS
282	K51-10-204	2	Internal Circlip 7000-042
283	DA-295	2	Pressure Pulley
284	DA-304	2	Bearing Distance Pieces
285	DA-296	1	Pivot Arm for Split Pulley Left Hand
	DA-297	1	Pivot Arm for Split Pulley Right Hand
286	K05-25-169	1	M6 x 35 Long Socket Capscrew
287	K05-25-192	1	M8 x 45 Long Socket Capscrew
288	DA-298	1	Pivot Bracket for Split Pulley Left Hand
	DA-299	1	Pivot Bracket for Split Pulley Right Hand
289		1	M8 x 16 Long Hexagon Head Bolt
290	DA-300	1	Pivot Pin for Pulley
291	K05-27-148	1	M8 Aerotight Nut
292	DA-308	1	Stop for Pulley
293	K05-26-238	1	M8 x 50 Long Stud
294	T5-391	1	Washer for Pulley
295	K05-25-325	1	M6 x 16 Countersunk Allen Screw

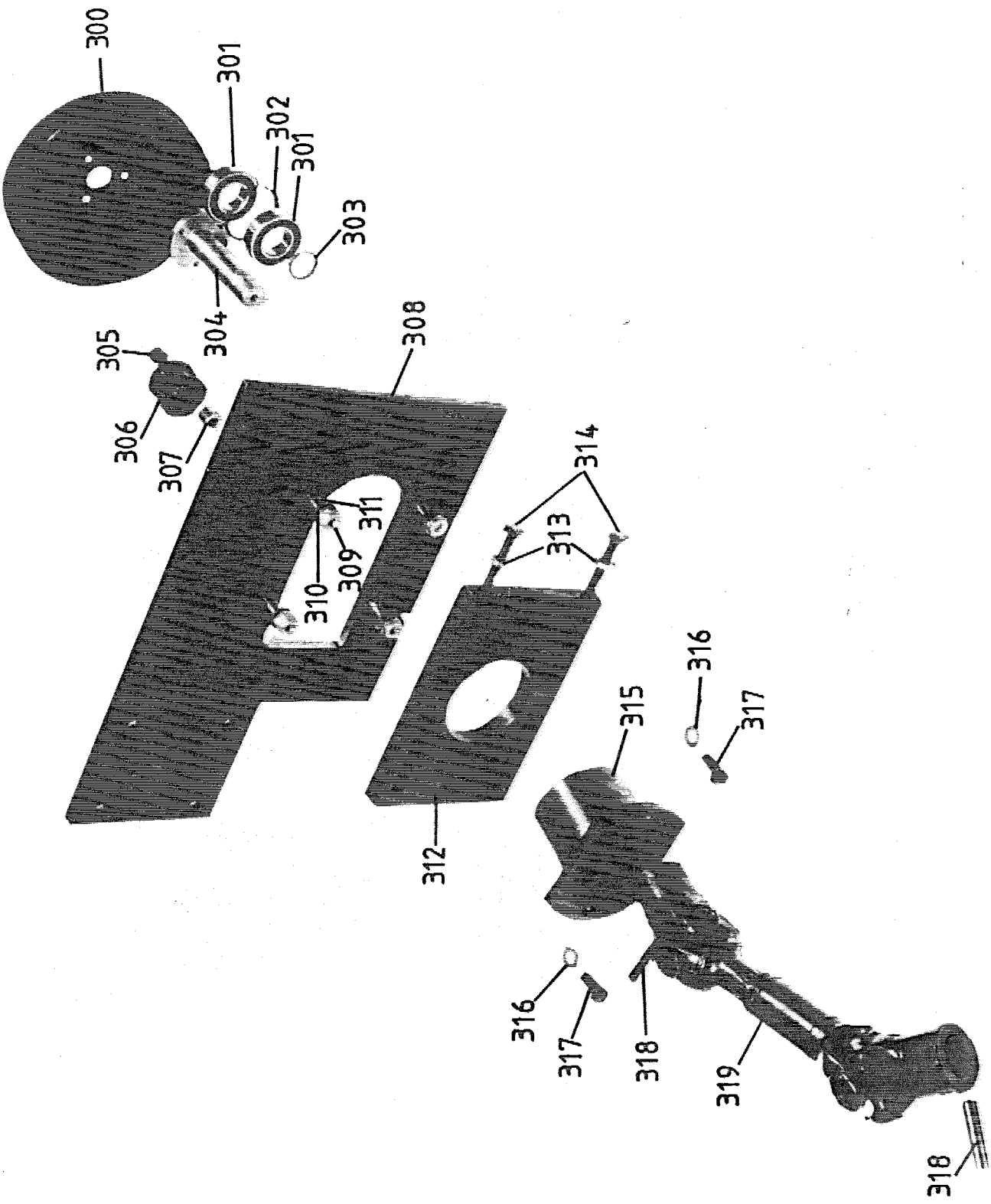


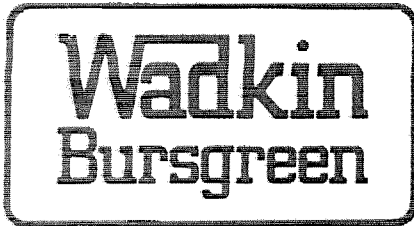


ILLUSTRATED PARTS LIST

ASSEMBLY:- ROLLER PRESSURES - REAR

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
300	DL-6	1	Pressure Pulley
301	K06-01-207	2	Bearing 6205-2RS
302	K51-10-206	1	Internal Circlip 7000-052
303	K51-10-407	1	External Circlip 7100-025
304	LP-73	1	Rear Pulley Spindle
305		1	M8 x 35 Long Socket Capscrew
306	DA-20	1	Idle Roller
307	DA-77	1	Idle Roller Spacer
308	DA-26	1	Rear Plate for Top Pressures
309	K05-27-152	4	M10 Aerotight Nuts
310	K05-28-104	4	10mm Washers
311	K05-26-265	4	M10 x 40 Long Studs
312	LP-74	1	Tension Bracket
313		2	M8 Nuts
314		2	M8 x 60 Long Hexagon Head Bolts
315	DA-105	1	Rear Pulley Housing
316		2	8mm Washers
317		2	M8 x 16 Long Hexagon Head Bolts
318		2	8 x 40 Long Groverlok Dowels
319	K51-70-101	1	Elbe Drive Shaft No.0106142





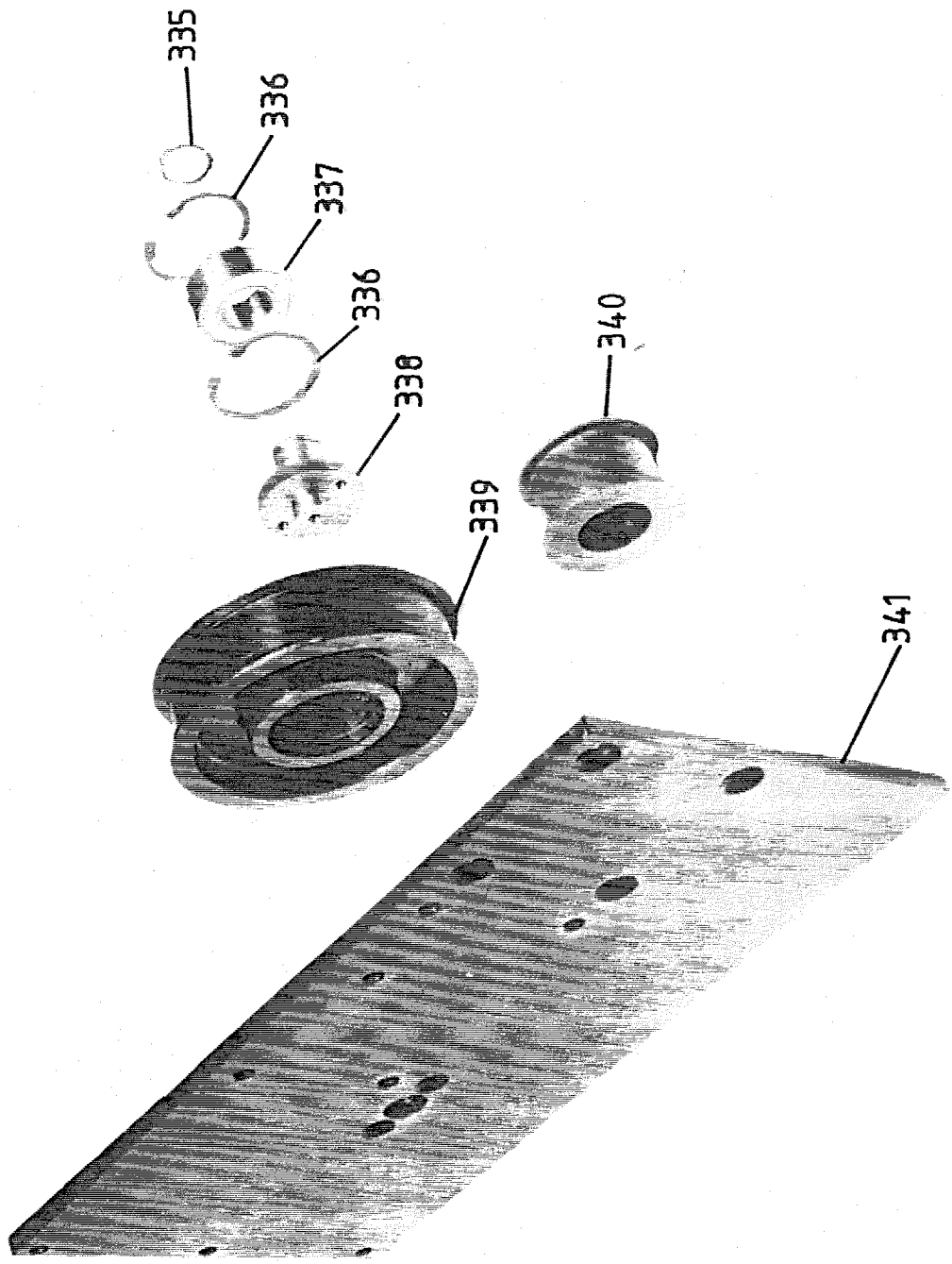
ILLUSTRATED PARTS LIST

ASSEMBLY:- CATERPILLAR PRESSURES - FRONT

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
335	K51-10-408	1	External Circlip 7100-030
336	K51-10-207	2	Internal Circlip 7000-062
337	K06-01-217	1	Bearing 6206-24W
338	1079/1981	1	Spindle for Chainwheel
339	1079/1965	1	Pressure Chainwheel
340	LP-322	1	Idle Pulley
341	LP-253	1	Front Support Plate Right Hand
	LP-254	1	Front Support Plate Left Hand
342		2	M8 x 20 Long Countersunk Allen Screws
-	DA-77	1	Idle Pulley Distance Piece (Used on item 340)
-		1	M8 x 35 Long Socket Capscrew (Used on item 340)

- ITEM NOT ILLUSTRATED

* PLEASE QUOTE PART & MACHINE
NUMBER WHEN ORDERING SPARES





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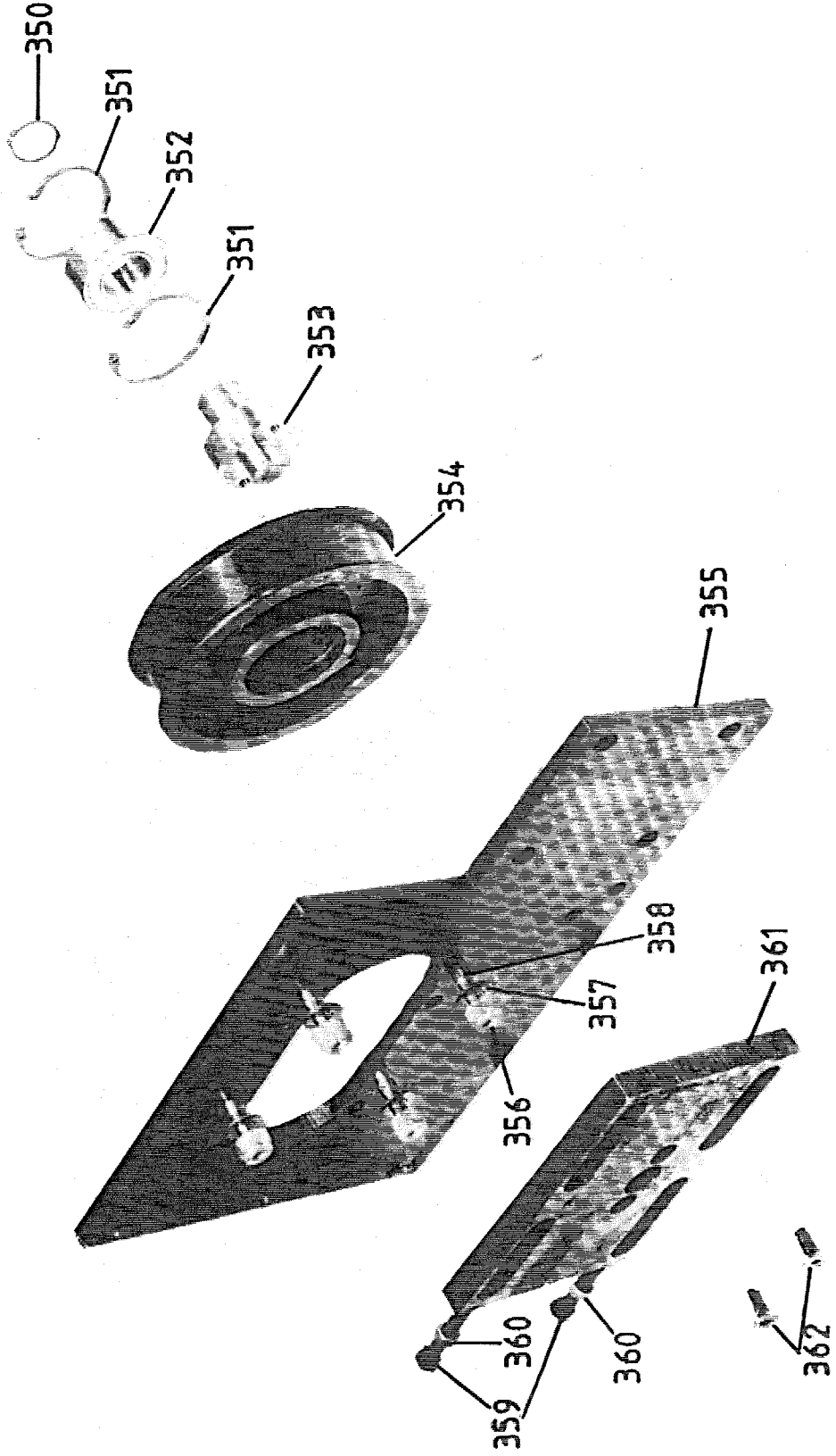
**ILLUSTRATED
PARTS
LIST**

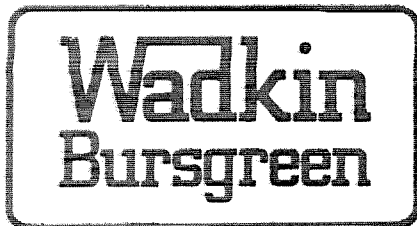
ASSEMBLY:- CATERPILLAR PRESSURES - REAR

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
350	K51-10-408	1	External Circlip 7100-030
351	K51-10-207	2	Internal Circlips 7000-062
352	K06-01-217	1	Bearing 6206-24W
353	LP-252	1	Spindle for Pressure
354	1079/1965	1	Pressure Chainwheel
355	DA-26	1	Plate for Top Pressure
356	K05-27-152	4	M10 Aerotight Nuts
357	K05-28-104	4	10mm Washers
358	K05-26-265	4	M10 x 40 Long Studs
359		2	M8 x 60 Long Hexagon Head Bolts
360		2	M8 Nuts
361	LP-250	1	Tension Bracket
362		2	M8 x 25 Long Countersunk Allen Screws

- ITEM NOT ILLUSTRATED

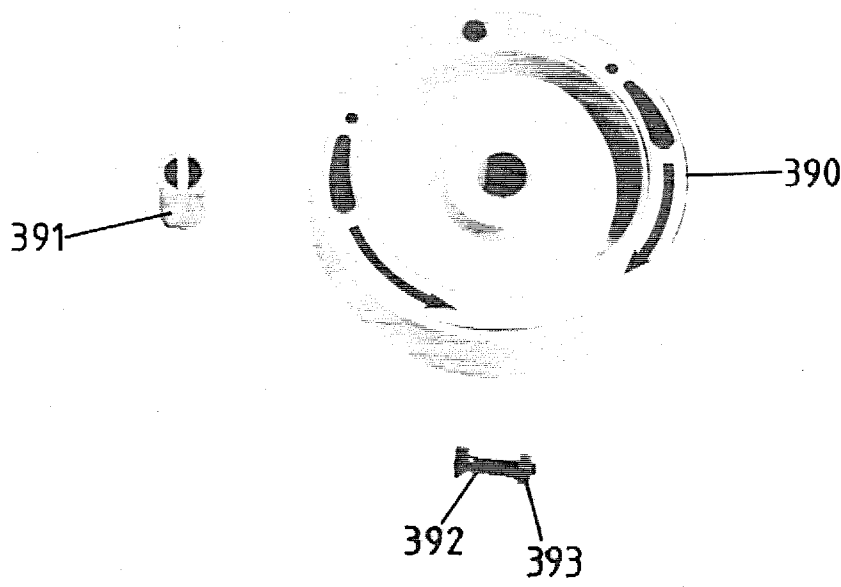
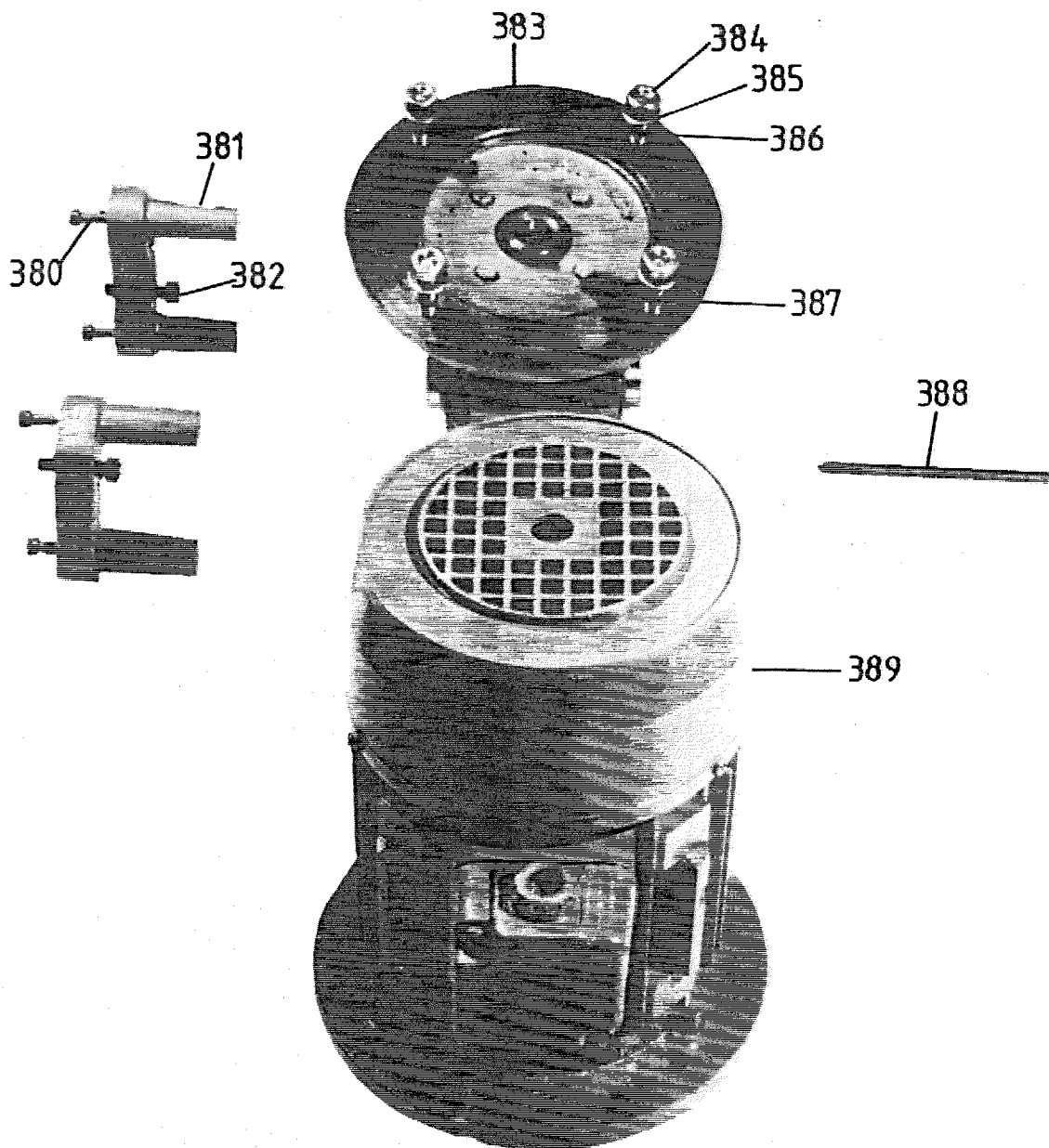
* PLEASE QUOTE PART & MACHINE
NUMBER WHEN ORDERING SPARES





ILLUSTRATED PARTS LIST

ASSEMBLY:- TRAVERSE			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
380	K05-25-174	4	M6 x 60 Long Socket Capscrews
381	1079/1886	2	Traverse Gearbox Adaptors
382	K05-25-190	4	M8 x 35 Long Socket Capscrews
383	K51-86-103	1	David Brown GCAS-162 Type Radicon Worm Reduction Gear Unit. Ratio 10:1 Input Flange to suit D80 Frame Motor.
384	K05-27-103	4	M10 Full Nuts
385	K05-28-104	4	10mm Washers
386	K05-26-264	2	M10 x 35 Long Studs
387	K05-26-265	2	M10 x 40 Long Studs
388	K51-20-108	1	6 x 6 x 130 Long Feather Key
389		1	D80B Frame, 0.75kw, 50 Cycle, 1500rpm Cont. Rated Flange Mounted
		1	D80B Frame, 1kw, 60 Cycle, 1800rpm, Cont. Rated Flange Mounted
390	D-S-286	1	150 Dia Handwheel
391	1079/1310	1	Bush for Traverse Handwheel
392	K05-25-167	1	M6 x 25 Long Socket Capscrew
393	K05-27-101	1	M6 Nut

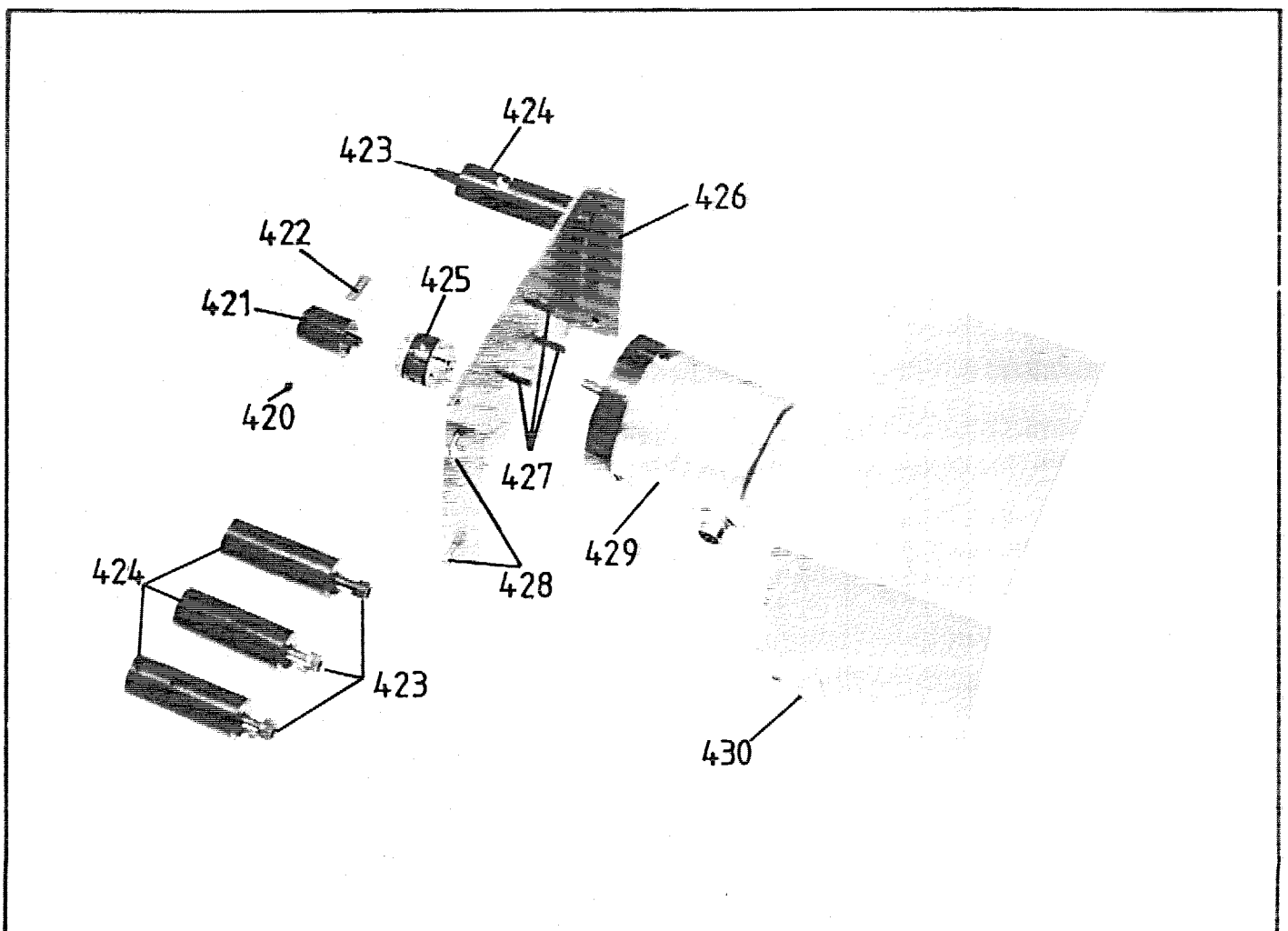
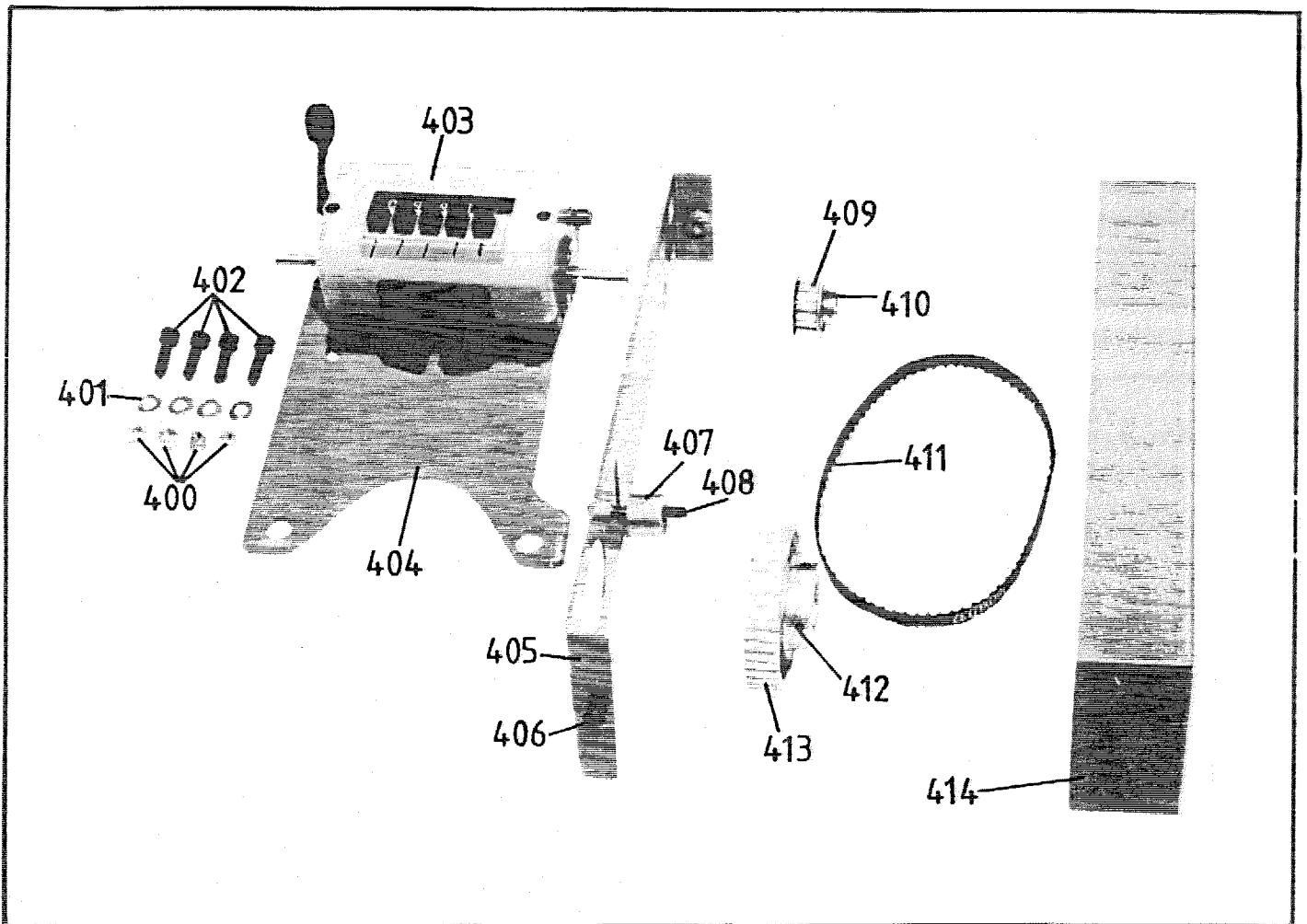




ILLUSTRATED PARTS LIST

ASSEMBLY:- MECHANICAL DIGITAL READOUT			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
400		4	M6 Aerotight Nuts
401	K05-28-102	4	6mm Washers
402	K05-25-165	4	M6 x 16 Long Socket Capscrews
403	K51-09-103	1	Mechanical Digital Readout-Metric Right Hand
	K51-09-102	1	Mechanical Digital Readout-Metric Left Hand
	K51-09-105	1	Mechanical Digital Readout-Imperial Right Hand
	K51-09-104	1	Mechanical Digital Readout-Imperial Left Hand
404	DA-316	1	Counter Mounting Plate
405	1079/2496	1	Counter Guard Back Plate
406		2	M5 x 10 Socket Button Heads
407	1026/51	1	Spacer for Back Plate
408	K05-25-169	1	M6 x 35 Long Socket Capscrew
409	1079/1153	1	Top Pulley for Counter
410		2	M4 x 6 Long Socket Set Screws
411	K51-04-552	1	Timing Belt 220XL037
412		2	M4 x 8 Long Socket Set Screws
413	1079/2484	1	Bottom Pulley for Counter
414	1079/2495	1	Counter Guard

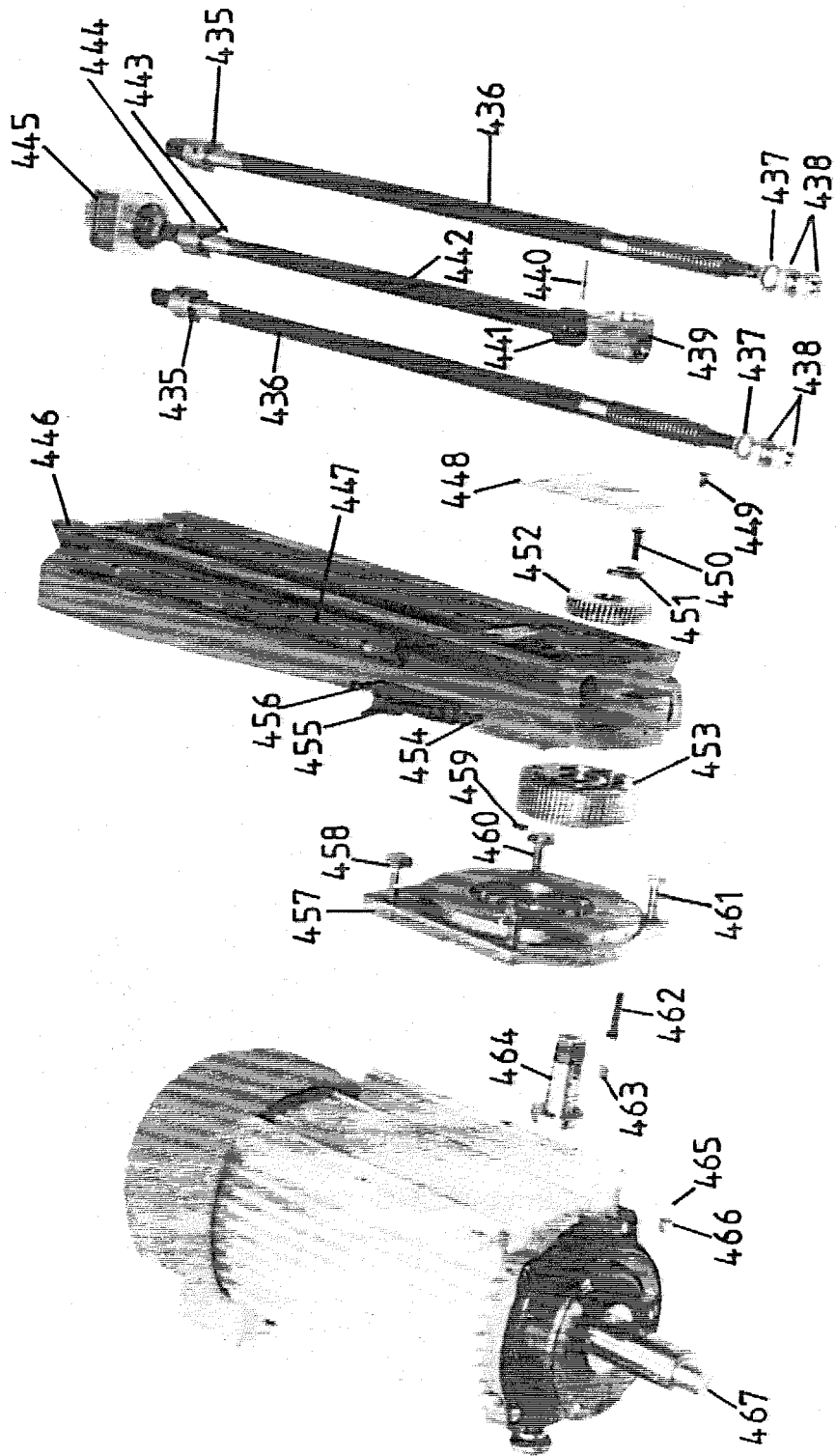
ASSEMBLY:- ELECTRONIC BEAM POSITIONING			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
420		1	M5 x 5 Long Socket Set Screw
421	LP-96	1	Traverse Gearbox Adaptor
422		1	6 Dia x 12 Long Precision Ground Dowel
423	K05-25-176	4	M6 x 70 Long Socket Capscrews
424	DA-193	4	Mounting Plate Spacers
425		1	Uni-Lat Coupling Ref A032c-D06-D06
426	DA-232	1	Encoder Mounting Plate
427		3	M4 x 10 Long Socket Capscrews
428		4	M4 x 12 Long Pan Heads
429		1	120 Pulse/Rev Encoder
430	DA-233	1	Encoder Guard



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ILLUSTRATED PARTS LIST

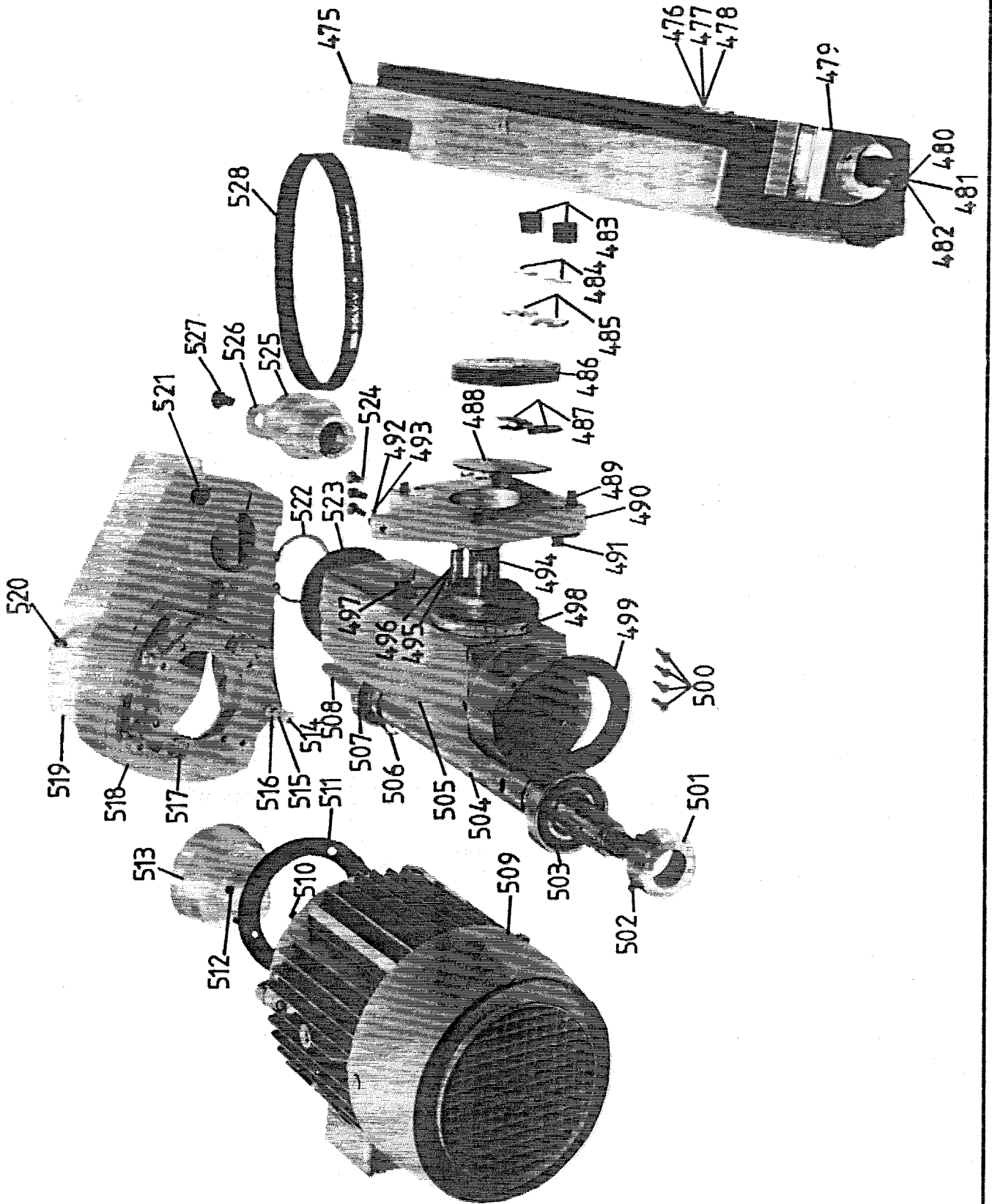
ASSEMBLY:- 'A' TYPE HEAD			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
435	1079/887	2	Square Ends
436	WE-742	2	Wormshaft
437	K51-11-106	2	½" Whit Washers
438	K05-10-107	4	½" Whit Locknuts
439	1079/1849	1	Nut for Horizontal Adjustment
440		1	5 Dia x 32 Long Groverlok Dowel
441	1079/294	1	Thrust Collar
442	1079/1807	1	Horizontal Traverse Screw
443	K06-04-131	1	ZKL-51104 Thrust Bearing
444	1079/1804	1	Locking Collar
445	K51-09-128	1	KN-7419 Counter, Rotation 4 (Metric)
	K51-09-130	1	LN-7419 Counter, Rotation 4 (Imperial)
446	1079/463	1	Intermediate Slide (Left Hand)
	1079/464	1	Intermediate Slide (Right Hand)
447	1079/307	1	Cross Slide Gib Strip
448	WE-674	1	Cover for Slide
449	K05-03-306	4	¼" Whit x ½" Long Countersunk Allen Screws
450		1	5/16" Whit x 5/8" Long Countersunk Socket Screw
451	1079/878	1	Washer for Pivot Pin
452	WE-653	1	Left Hand Wormwheel
	WE-663	1	Right Hand Wormwheel
453	1079/673	1	Wormwheel
454		2	M6 x 16 Long Countersunk Button Heads
455	1079/1012	1	Left Hand Bracket for Head Stop
	1079/1213	1	Right Hand Bracket for Head Stop
456		2	6 Dia x 20 Long Fluted Dowels
457	1079/672	1	Pivot Mounting for Motor
458	1079/1014	1	Fixed Stop Bolt
459		1	M6 x 16 Long Socket Grubscrew
460	1079/1013	1	Adjustable Stop Bolt
461	K05-05-178	2	3/8" Whit x 1½" Hexagon Head Bolt
462		6	5/16" Whit x 1¼" Long Socket Capscrews
463	K51-20-153	1	¼" x ¼" x ½" Long Feather Key
464	1079/886	1	Pivot Block
	1079/897	1	Pivot Block
465	K51-11-104	4	3/8" Whit Washers
466	K05-10-602	4	3/8" Whit Aerotight Nuts
467		1	'A' Type Motor (See Motor Plate when Ordering and State Spindle Dia)





ILLUSTRATED PARTS LIST

ASSEMBLY:- 'B' TYPE HEAD			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
475	1079/1730	1	Horizontal Slide Right Hand
	1079/1731	1	Horizontal Slide Left Hand
476		1	5 Dia x 32 Long Groverlok Dowel
477	1079/294	1	Thrust Collar
478	1079/1732	1	Cross Slide Nut
479	K51-09-128	1	KN-7519 Counter, Rotation 4 (Metric)
	K51-09-130	1	LN-7519 Counter, Rotation 4 (Imperial)
480	K06-04-131	2	Thrust Bearing ZKL-51104
481	1079/1105	1	Locking Collar
482	1079/1713	1	Traverse Screw
483	1079/358	2	Head Locking Nuts
484		2	12mm Brass Washers
485	1026/22	2	Washers
486	1079/149	1	Head Clamp
487		4	No.10 Bellville Washers
488	1079/148	1	Friction Plate
489	K05-25-211	4	M10 x 35 Long Socket Capscrews
490	1079/1934	1	Pitch Plate with Stops Right Hand
	1079/1935	1	Pitch Plate with Stops Left Hand
491	K05-26-139	4	M10 x 20 Long Socket Set Screws
492	K05-27-102	2	M8 Full Nuts
493	K05-25-518	2	M8 x 30 Long Hexagon Headbolts
494	1079-150	2	Head Locking Stud
495	1079/936	1	Head Stop Peg
496	K05-27-112	1	M16 Locknut
497		1	M16 x 20 Long Hexagon Head Bolt
498	1079/391	1	Scale for Canting
499	DL-81	1	End Cap for Spindle with Relisher
	DL-727	1	End Cap for Spindle without Relisher
500	K05-25-325	4	M6 x 16 Long Countersunk Allen Screws for DL81
	K05-25-326	4	M6 x 20 Long Countersunk Allen Screws for DL727
501	DL-133	1	Locknut for Cutter Spindle with Relishers
	1079/753	1	Spindle Shoulder nut without Relishers
	1079-1667	1	Spindle Shoulder Nut for 40mm Dia Spindles
502	K05-26-125	2	M8 x 10 Socket Grubscrew for 1079/753 or 1079/1667
503	K06-01-229	1	Bearing 6208-2RS
504		1	'B' Type Spindle (State Spindle Dia and Usable Length)
505	DL-109	1	Spindle Housing
506	K51-88-804	1	Pre-load Washer EPL.54
507	K06-01-222	1	Bearing 6207-2RS
508	K51-20-120	1	Feather Key
509		1	'B' Type Motor (See Motor Plate when Ordering)
510	K05-25-187	4	M8 x 20 Long Socket Capscrews
511	1079/754	1	Distance Plate (7.5hp Motor Only)





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**ILLUSTRATED
PARTS
LIST**

ASSEMBLY:- 'B' TYPE HEAD (Continued)

FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
512	K05-26-136	2	M10 x 10 Long Socket Grubscrews
513	1079/302	1	Motor Pulley 3000/6000rpm 50 & 60 Cycle
	1079/908	1	Motor Pulley 4500/6000rpm 50 & 60 Cycle
514		3	M10 Aerotight Nuts
515	1079/710	3	Studs for Motor Adjusting Plate
516	1079/711	3	Washers for Motor Adjusting Plate
517	1079/292	1	Head Motor Adjusting Plate
518	1079/296	1	Head Motor Support Bracket
519	1079/366	1	Cover for Motor Support Bracket
520		3	M8 x 35 Long Socket Button Heads
521	K05-25-238	1	M12 x 65 Long Socket Capscrew
522	K51-10-411	1	External Circlip 7100-070
523	1079/350	1	Pivot Boss for Motor Support
524	K05-25-234	3	M8 x 25 Long Countersunk Allen Screws
525	1079/303	1	Spindle Pulley 3000/6000rpm 50 & 60 Cycle
	1079/909	1	Spindle Pulley 4500/6000rpm 50 & 60 Cycle
	DL-286	1	Spindle Pulley 4500/6000rpm 60 Cycle
526	1079/309	1	Spindle Pulley Clamp Washer
527		1	M12 x 35 Long Countersunk Allen Screw
528	K51-04-505	1	Poly-'V'-Belt 260-J10



ILLUSTRATED PARTS LIST

ASSEMBLY:- 'C' TYPE HEAD			
FIG ITEM	PART NO. *	UNITS PER ASSEMBLY	DESCRIPTION
535	1079/1730	1	Horizontal Slide Right Hand
	1079/1731	1	Horizontal Slide Left Hand
536		1	5 Dia x 32 Long Groverlok Dowel
537	1079/294	1	Thrust Collar
538	1079/1732	1	Cross Slide Nut
539	K51-09-128	1	KN-7519 Counter, Rotation 4 (Metric)
	K51-09-130	1	LN-7519 Counter, Rotation 4 (Imperial)
540	K06-04-131	2	Thrust Bearing ZKL-51104
541	1079/1105	1	Locking Collar
542	1079/1713	1	Traverse Screw
543	1079/358	2	Head Locking Nuts
544		2	12mm Brass Washers
545	1026/22	2	Washers
546	1079/149	1	Head Clamp Plate
547		4	No.10 Bellville Washers
548	1079/148	1	Friction Plate
549	K05-25-211	4	M10 x 35 Long Socket Capscrews
550	1079/1934	1	Pitch Plate with Stops Right Hand
	1079/1935	1	Pitch Plate with Stops Left Hand
551	K05-27-102	2	M8 Full Nuts
552	K05-25-518	2	M8 x 30 Long Hexagon Head Bolts
553	K05-26-139	4	M10 x 20 Long Socket Set Screws
554	K05-25-333	6	M8 x 20 Long Countersunk Allen Screws
555	DL-844	1	Stop Screw
556	DL-845	1	Motor Plate
557		2	M12 x 60 Long Socket Capscrews
558	DL-531	2	Motor Shoes
559			'C' Type Motor 4kw (See Motor Plate when Ordering and State Spindle Dia)

