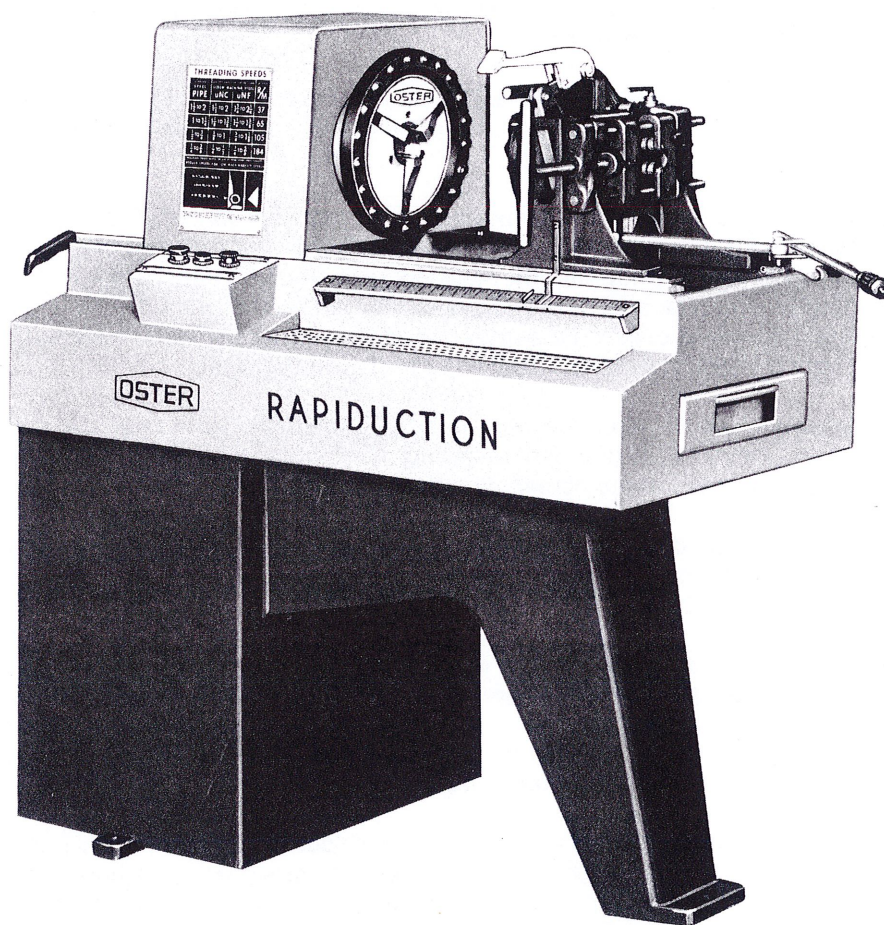


ASSEMBLY, OPERATION and SERVICE MANUAL for

OSTER**792****"RAPIDUCTION"**

SEE PAGE 2 FOR OPERATOR SAFETY INSTRUCTIONS

NOTE: PROMPT shipment of all machine spare parts will be made. In plant, telegraphic service operates continuously. We suggest you wire emergency spare parts orders.

WHEN ORDERING SPARE PARTS, SPECIFY PRE-FIX LETTERS AND SERIAL NUMBER OF YOUR MACHINE. For price information, refer to OSTER POWER THREADER PRICE LIST.



Superior Threading

www.ostermfg.com

PH: 888-416-7837

989-729-1160

OPERATOR SAFETY INSTRUCTIONS

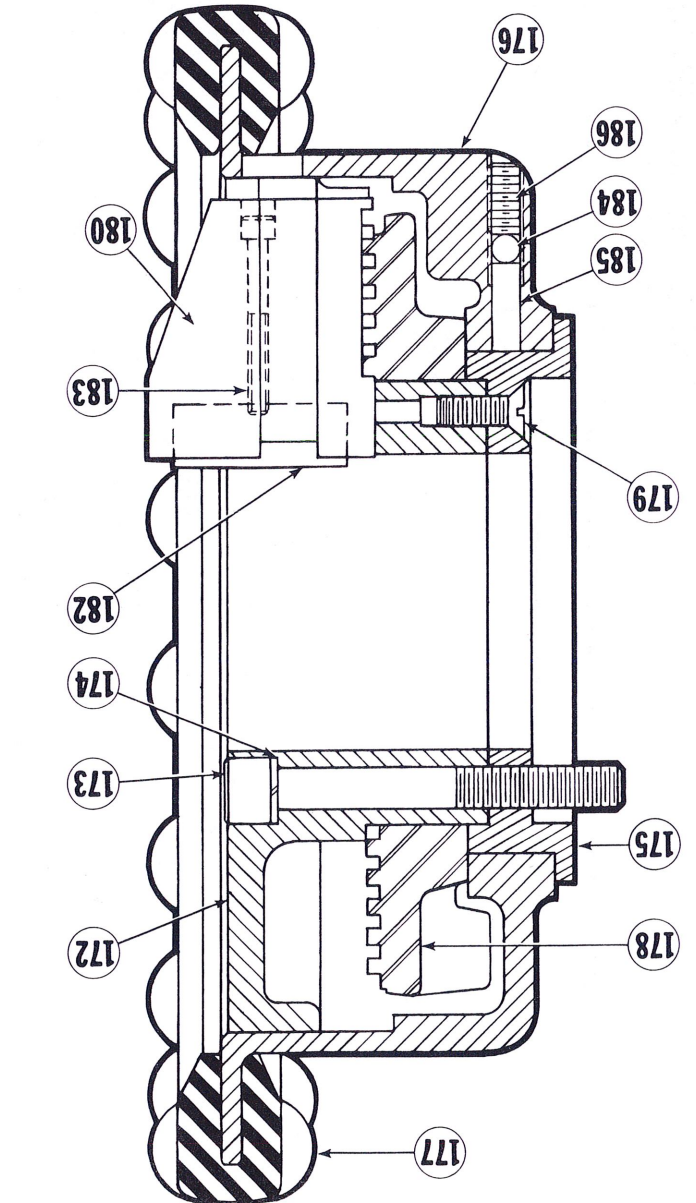
Metalworking equipment is designed to change the shape of workpieces by removing, displacing, or joining metal. Accomplishing these functions requires a combination of high electrical or mechanical power inputs, high speeds, sharp tools, and numerous moving components including in some cases, the workpiece itself. Failure to observe certain basic safety habits in the presence of these elements or incorrect usage of the equipment may result in a crippling or fatal injury to the operator or bystanders.

Although every effort has been made to design and construct safe, dependable equipment, it is impossible to foresee all circumstances under which the equipment may be utilized or to anticipate all possible combinations of factors which may trigger an accident. It is therefore imperative that the equipment operator, as well as all others engaged in any phase of set-up or maintenance of the unit consider safety-first an important part of his job.

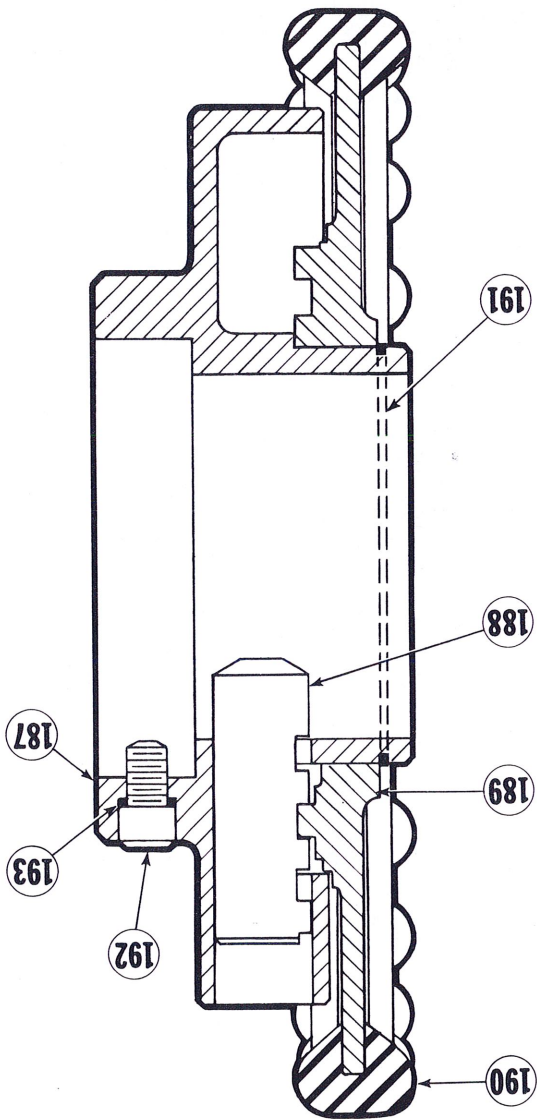
The following general safety considerations are offered as an aid to users of metalworking equipment to assist them in becoming safety oriented.

1. **READ THE INSTRUCTION BOOK** before attempting to lift, move, operate, or perform maintenance on any piece of equipment! Become intimately familiar with all equipment controls; their locations, their operation, their effect on equipment functions. Keep the operator's instruction book in a clean location immediately adjacent to the equipment for quick reference!
2. **BEFORE ATTEMPTING TO START THE EQUIPMENT**, inspect all areas around and adjacent to movable parts for possible obstructions; tools, rags, crating remnants, etc! Be certain that all guards, covers, doors, etc. are in proper place prior to beginning operation.
3. **PRACTICE GOOD HOUSEKEEPING**: maintain an area adjacent to - NOT ON - the equipment for tool and/or cutter storage. Remove all oil or coolant spills and potential trip points from the operating areas around the equipment to prevent slipping or falling into the working zone. Remove chip accumulations as required to assure adequate operating clearance for all components. Do not stand on equipment elements not intended for the purpose. Maintain a maximum clear area around the equipment for unobstructed movement of the operator. Perform preventive maintenance at intervals specified in instruction book.
4. Avoid wearing loose clothing, long hair, neckties, etc. when operating equipment as these can easily become entangled in moving parts. It is highly recommended that safety glasses be worn at all times. Safety shoes are likewise recommended. Avoid horseplay around the equipment.
5. Do not attempt to operate equipment if you are ill or excessively fatigued. Shut-off equipment immediately if any malfunction occurs or appears imminent. Report any unsafe equipment or condition promptly in order that correction can be made.
6. Bystanders should stay well away from the equipment so as not to distract the operator or accidentally move a control element. Avoid talking to the operator while equipment is in operation.
7. Tools, workpiece, vises, dies, etc. must be securely clamped before equipment is operated under power. Clamping members must not be released during equipment operating cycle.
8. Razor-sharp edges, flying chips, and extremely hot surfaces can result from the metalworking operation. At no time during the work cycle should the operator reach into or across the working zone of the equipment or touch the tool and workpiece. Serious cuts and/or burns may result. The operator must remain alert for pinch points created by moving slides, carriages, or workpieces and must be prepared to stop the equipment at any time in the event of work slippage or tool breakage.
9. When changing set-up, performing maintenance work, cleaning equipment, etc., it is recommended that main power supply or supplies (electrical, air, etc.) be shut off to avoid accidental operation and possible resultant injury. This is particularly important in the event more than one person is involved in such duties.
10. Only authorized personnel should attempt to diagnose and repair equipment control and power system (s). Serious or fatal injuries can result from tampering with electrical or fluid power system without adequate instructions!
11. **IMPORTANT!** No piece of equipment can be made absolutely fool-proof. No safety device yet invented can replace the good judgment and common sense of an alert operator. Treat the equipment with utmost respect. **REMEMBER! - SAFETY IS EVERYONE'S BUSINESS!**

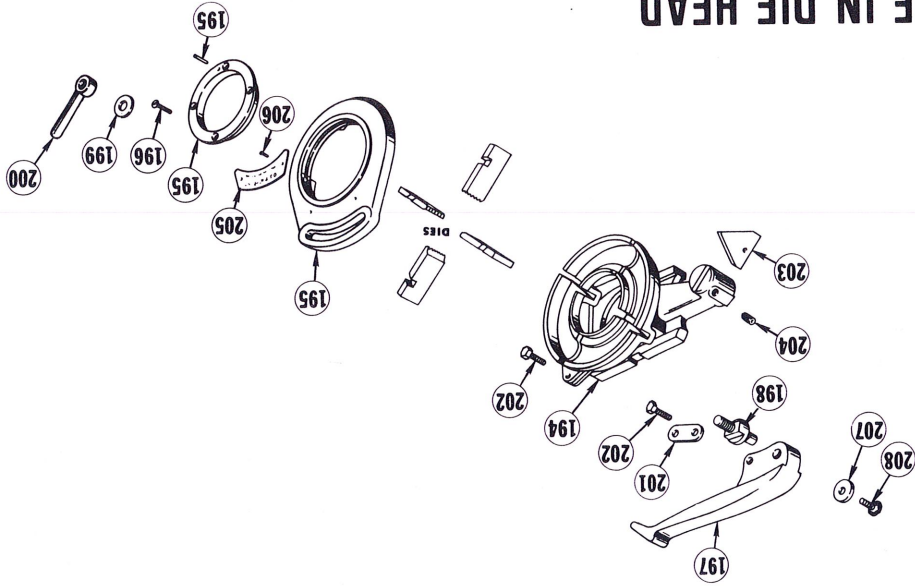
WRENCHLESS CHUCK ASSEMBLY No. 02946

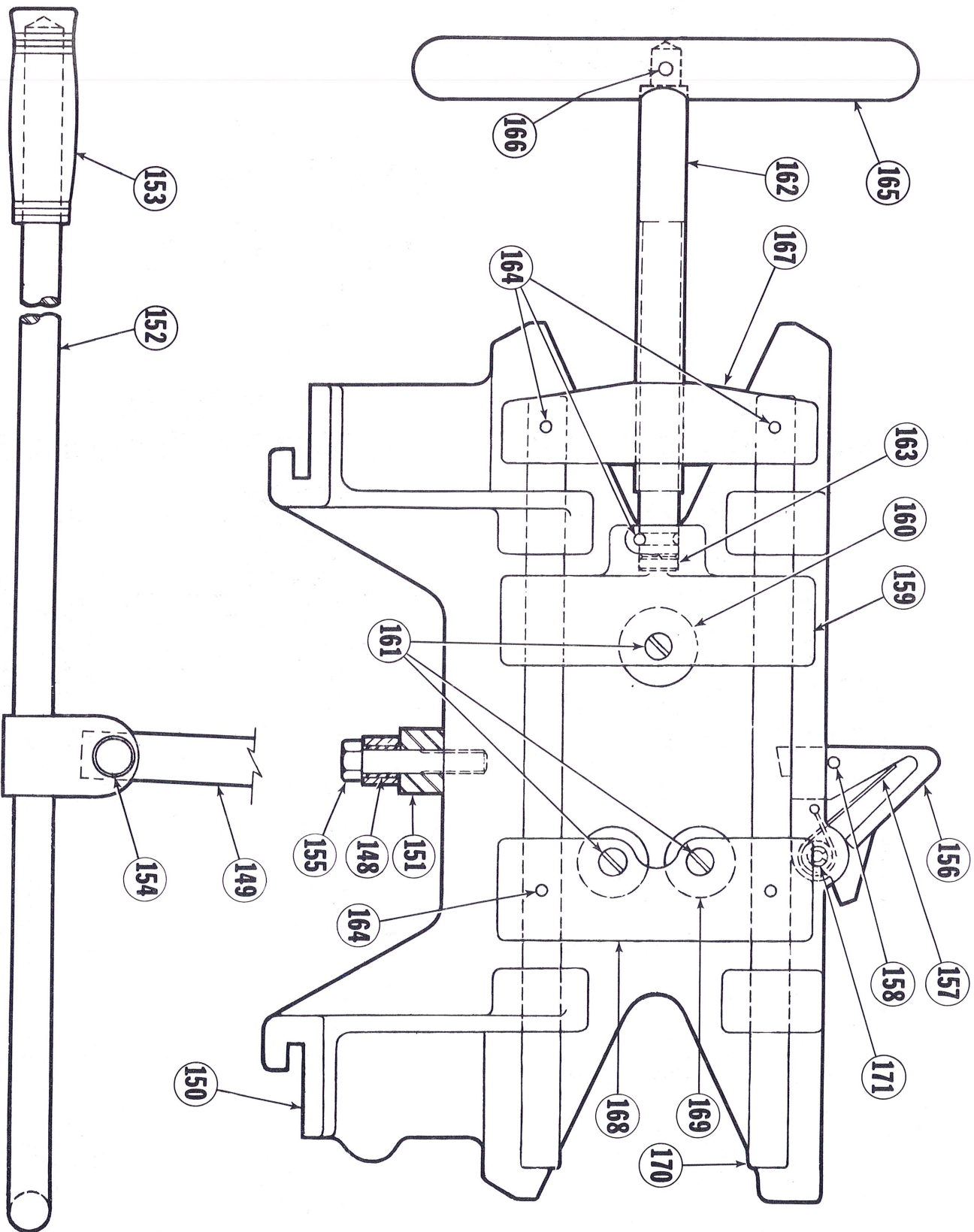


CENTERING CHUCK ASSEMBLY No. 02915



02887 SLIDE IN DIE HEAD





TOP VIEW - LEVER & LINK
CARRIAGE ASSEMBLY

**OPERATOR: READ THESE INSTRUCTIONS BEFORE OPERATING
THIS MACHINE FOR THE FIRST TIME**

SETTING UP MACHINE BEFORE USING

UNCRATING

Before disposing of crates make sure that any small boxes attached to the crate are not thrown away. These boxes may contain wrenches, tools, and other loose parts belonging to the machine. Skids should be left under the machine until moved to its permanent location. Location of the machine should be on a floor offering the greatest rigidity possible. On upper floors place near a wall or supporting pillar. Place a spirit level across ways to make sure machine is level.

CLEANING MACHINE

A thoroughly clean machine is essential for good performance. To clean, use kerosene or any similar cleaning solution, and remove all protective grease. **DO NOT USE AIR HOSE.**

ELECTRIC POWER AND MOTOR

Connect motor leads to power supply in accordance with specifications on motor and control units.

COOLANT SYSTEM

The pump is mounted on the motor plate and driven by a "V" belt from the motor and the volume of oil delivered to the head is controlled by a valve located in oil line. Fill the sump of the machine with 5 gallons of a good sulphur base oil, Oster "Bestoil."

THREADED SAMPLES

The random sample threads shipped with your machine were cut in your machine.

LUBRICATION

Make sure that all bearing surfaces have been well oiled.

1. **MOTOR:** Follow instructions of motor manufacturer.
2. **COOLANT PUMP:** Mounted on motor plate in base of machine.
3. **SLIDING SURFACES, BEDWAYS AND DIE HEAD:** Lubricate daily with machine oil.
4. **GEAR CASE:** Check periodically, to see that oil is up to proper level in oil level gage. **GEAR CASE (HEADSTOCK) - -**

1. Remove pipe plug front lower right hand corner of gear case and drain oil after first 100 hours of operation. Refill (fill plug just above oil level gage) with 1½ quarts SAE 20 motor oil or equivalent. Keep oil level to center of gage.
5. **GEAR BOX:** Check oil level.
GEAR BOX - - (4 SPEED TRANSMISSION--
 1. Gear box has been provided with an oil level plug. (Remove back cover to expose gear box.) Remove plug to check. Additional oil can be added by pressure type oil can through this hole or gear box must be removed and oil added through plug on top of gear box. Use SAE 40 oil.

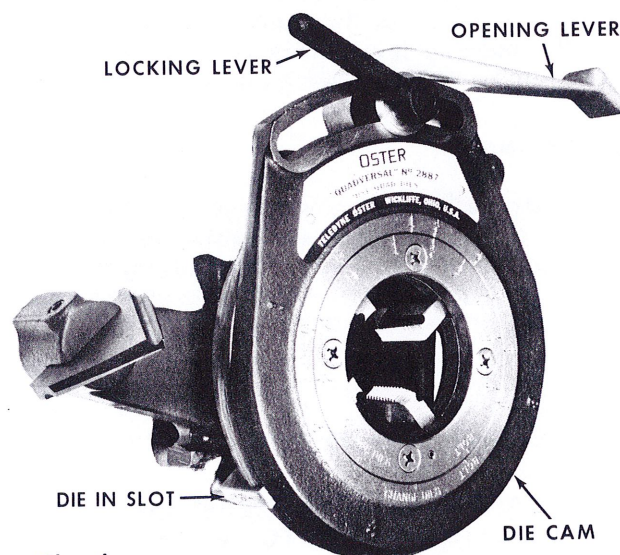


Fig. 1.

SETTING-UP DIE-HEAD - See Fig. 1.

1. **TO INSERT DIES IN HEAD:**
 - A. Loosen the locking lever that secures the locking bolt.
 - B. Raise opening lever.
 - C. Rotate die cam until "Change Dies" marks are together.
 - D. Clean die slots with chip brush.
 - E. Insert dies in slots with numbers corresponding to the number stamped on each die (1-2-3-4)
2. **SET HEAD TO SIZE:**
 - A. Lower opening lever.
 - B. Rotate die cam until corresponding marks on cam and washer for pipe size desired are together. For bolts set the die-head

so that the bolt mark BOLT stamped on the die cam coincides with the mark BOLT stamped on the washer.

C. Tighten locking lever.

3. Threads may be cut oversize or undersize by setting the size mark slightly off from the corresponding mark.

4. TO REMOVE DIES:

- Remove chips from bore of head.
- Loosen locking lever.
- Raise opening lever.
- Rotate cam until "Change Dies" marks are together.
- Remove dies.

ALWAYS CLEAN DIE SLOTS FREE FROM CHIPS; ALWAYS WIPE OFF DIES BEFORE INSERTING THEM; NEVER HAMMER THE DIES INTO OR OUT OF DIE SLOTS!

Die head is quick opening. When correct thread length has been cut the head is opened by raising the opening lever. This is done while pipe is rotating -- DO NOT back off die head.

CHUCKING:

1. Load pipe through spindle from rear of machine. Close rear centering chuck lightly on pipe. The three guides are a means of supporting the pipe and do not drive. For long lengths use an Oster 03447 pipe rest stand as outboard support.

2. Close front chuck firmly turning hand wheel counter-clockwise. **BE SURE THAT ALL THREE JAWS ARE BEARING ON PIPE.**

IMPORTANT: THE WRENCHLESS CHUCK REQUIRES NO HAMMERING TO CLOSE OR OPEN. THE GRIPPING ACTION OF THE JAWS INCREASES AS THE THREADING LOAD INCREASES.

3. Release pipe by rotating both chucks in opposite direction away from operator.

CHANGING WRENCHLESS

CHUCK JAW INSERTS - See Fig. 2.

You are able to change Chuck Jaw Inserts WITHOUT REMOVING FRONT CHUCK.

You will notice a notch in the rear side of the front Chuck Handwheel. By revolving the Handwheel, you can line up the notch for each (3)

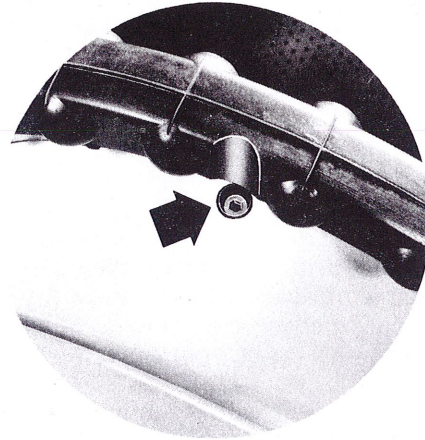


Fig. 2.

Chuck Jaw. Insert a 5/32 Allen Wrench, remove Old Insert and replace with new Insert.

REAMING:

Slide Die-Head to a position, which will allow the reamer to enter the inside of the pipe. Then move carriage forward with the carriage lever, guiding the reamer until it is centered. Then ream by applying pressure to carriage lever.

THREAD LENGTH GAGE: - See Fig. 3.

With pipe centered in the throats of the dies, set Thread Length Gage so that leading edge of pointer on carriage lines up with graduation for the same size pipe to be threaded.

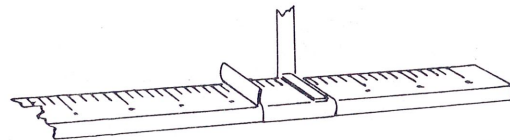


Fig. 3.

TO GAGE MISCELLANEOUS LENGTHS (Up To 12-1/2" Long)

With the use of graduated scale bar attached to machine it is possible to thread miscellaneous lengths up to 12-1/2". Slide Thread Length Gage to far left when using scale.

THREADING:

1. Select desired spindle speed from speed chart mounted on operator's side of Head Stock Cover. Shift gear shift lever at rear of machine, so that proper speed appears in opening. If gears do not engage easily, set selector switch to jog and jog machine by momentarily pressing START button.

With gear shift lever set at the desired speed, press START button (making sure selector switch is reset to RUN), which will start the motor. To stop machine press STOP button.

Turn on cutting oil and make sure a good flow of oil is obtained at the point where actual threading takes place.

2. With die-head opening lever in down (closed) position, run carriage forward until the pipe enters the throat of the dies, being careful not to jam the dies on the pipe.

3. Set the thread length gage so that the graduation for size pipe to be threaded is in line with leading edge of pointer.

4. Start dies on pipe by applying steady pressure on carriage lever until the dies take hold. Then release the pressure and the dies will feed themselves on the pipe.

5. When edge of pointer reaches raised lip of thread length gage, raise die-head opening lever and move carriage back clear of pipe. AT COMPLETION OF CUT, OPEN THE DIE-HEAD WHILE THE PIPE IS REVOLVING.

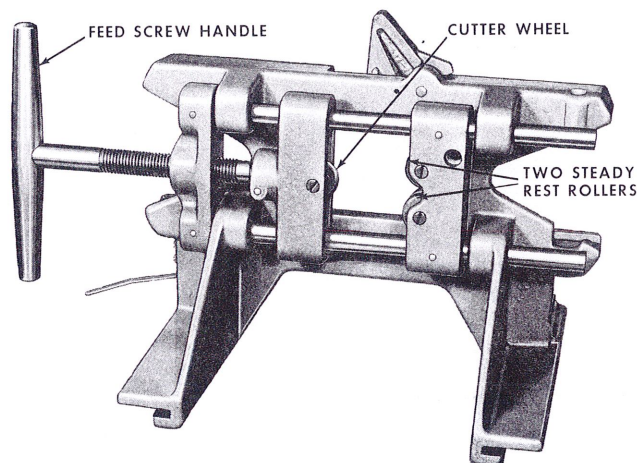


Fig. 4.

CUTTING OFF - See Fig. 4.

1. Push die-head to rear of carriage so that pipe will pass through opening in carriage.

2. Turn feed screw handle so that rollers and cutter wheel will allow pipe to pass through. Move carriage forward to position for cutting off desired length of pipe. NOTE: Do not cut into threads with roller type cut off.

3. Turn feed screw steadily until pipe is cut off.

4. Back off the cutting wheel and rollers. Move the carriage back to end of the bed unit.

EXTRA EQUIPMENT

No. 02913 Mono Type Heads (for Symbol Quad Dies)

The Mono type die head is graduated for one size only. Once the dies have been inserted and set to size, there is no further set-up required. Simply select the head for the size to be threaded and insert head in slots provided in carriage. Like all Oster die heads, you can cut over or undersize threads by setting the size mark slightly off the corresponding mark.

To order specify:

1. No. 02913 Die Head
2. Pipe or Bolt
3. Size
4. Order dies as required for each die head.

No. 65529 Nipple Chuck (British #65530) - enables you to make close and short nipples (Standard is 1/2 to 2" pipe - specify if 1/8, 1/4, or 3/8 is also required.)

No. 03447 Stock Support Stand - 4" capacity minimum height 33", maximum height 44".

MAINTENANCE

1. Lubrication -- See section under "Lubrication" for instructions.
2. Die-Heads
 - A. When changing dies be sure and clean out die slots before inserting new dies.
 - B. NEVER hammer dies in or out of die slots.
3. CARE OF DIES -- Good threads cannot be cut with dull dies. Therefore, make sure the dies are kept sufficiently sharp at all times. Do not back-off the dies from threads; this will quickly dull dies. Always use a good supply of Oster Bestoil on dies when threading.
4. Clean sump and sump screen at regular intervals. At least once a month. Be sure that sump is well filled with Oster Bestoil.
5. Remove chip basket and empty chips before the basket gets so full that it is difficult to handle.
6. Replace roller cut off when the edge begins to turn over. Continued use of a worn out cutter requires greatly increased labor to cut off.

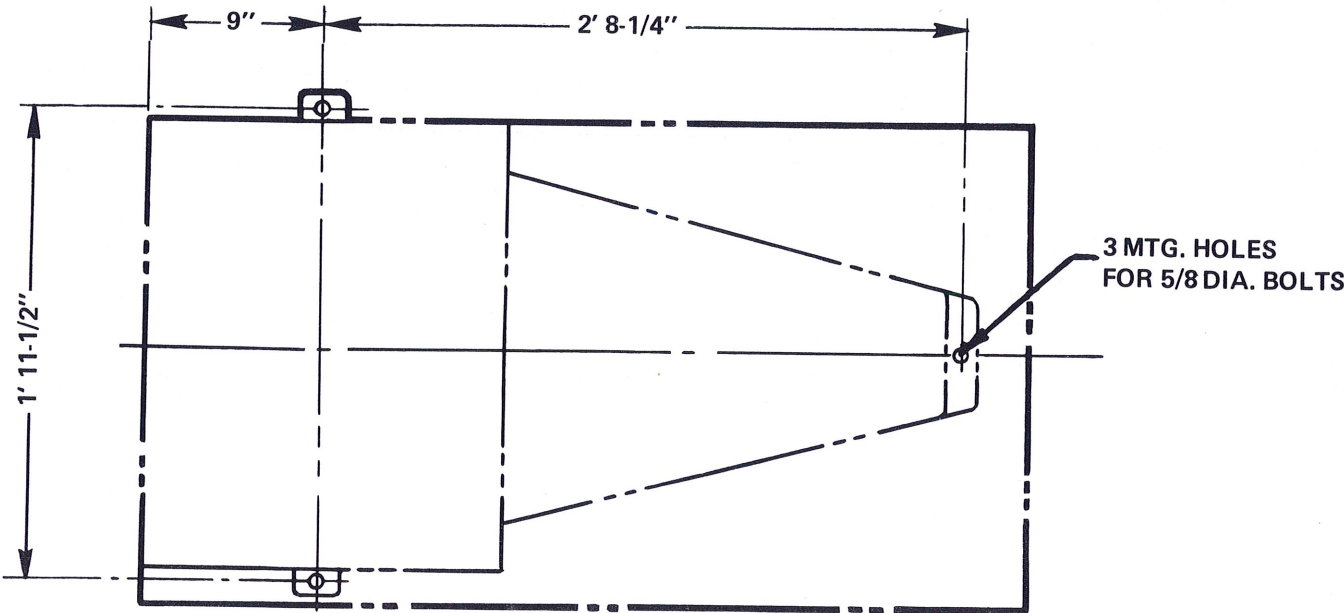
OSTER 792 OPERATION

SPECIFICATIONS

| | |
|--|--|
| Catalog Number | 792 |
| Pipe Range | 1/8" to 2" |
| Bolt Range | 1/4" to 1-1/2" N.F., 1/4" to 2" N.C. |
| Standard Spindle Speeds | 37/65/105/184 |
| Spindle Motor -- H.P. | 3 |
| Spindle Motor -- R.P.M. | 1800 |
| Coolant Pump | #03395 Reversible Vane Type |
| Spindle Bore | 2-1/2" |
| Front Chuck | Wrenchless |
| Rear Chuck | Self-Centering 3 Jaw Universal |
| Electric Controls -- Standard | Magnetic Reversing Starter and Push Button Station |
| Maximum length threaded at one setting | 12-1/2" |
| Maximum Carriage travel | 13" |
| Type of Die-Head | Radial |
| Number of Dies per set -- H. S. Steel | 4 |
| Type of Cut-off | Roller -- Self Centering |
| Height to Center Line of Spindle | 40" |
| Net Weight, Machine complete (pounds) | 900 |
| Crated Weight, Machine complete (pounds) | 1200 |

TO ORDER DIES, SPECIFY THE FOLLOWING:

1. Symbol QUAD (if dies other than QUAD ordered with machine, specify symbol stamped on side of die segments)
2. Pipe or NC Bolt or NF Bolt
3. Size



OUTLINE & FOUNDATION PLAN

| REF. No. | PART No. | QUAN-TITY | ITEM |
|------------------------------|----------|-----------|--|
| <u>BASE & GUARD UNIT</u> | | | |
| 1 | 79019 | 1 | BASE |
| 2 | 79053 | 1 | TRANSMISSION DOOR |
| 3 | 97216 | 5 | SCREW 1/2-20 NC x 1/2 LG RD HD MACH |
| 4 | 78045 | 1 | OIL PAN STRAINER |
| 5 | 79054 | 1 | MOTOR COMPARTMENT DOOR |
| 6 | 78269 | 4 | DOOR LATCHES #49-11-0 |
| 7 | 79055 | 1 | CHIP BASKET |
| 9 | 97092 | 2 | SCREW 3/8-16 NC x 7/8 LG HEX HD CAP |
| 10 | 97097 | 2 | SCREW 3/8-16 NC x 1 1/2 LG HEX HD CAP |
| 11 | 97320 | 2 | SET SCREW 3/8-16 NC x 3 LG SQ HD |
| 12 | 97239 | 2 | 3/8-16 NC STD HEX NUT |
| 13 | 97458 | 4 | LOCKWASHER AM STD 3/8 LIGHT SEC |
| 14 | 97447 | 4 | 3/8 SAE STD PLAIN WASHER |
| 15 | 79061 | 1 | TRANSMISSION MTG PLATE |
| 16 | 79063 | 2 | TRANSMISSION SUPPORT ROD |
| 17 | 97314 | 2 | SET SCREW 1/2-20 NC x 5/8 LG CUP PT SQ HD |
| 18 | 79064 | 2 | ROD SUPPORT WASHER |
| 19 | 97362 | 2 | SCREW 3/8-16 NC x 1" LG FLAT HD MACH |
| 20 | 79070 | 1 | MOTOR SUPPORT SHAFT |
| 21 | 97458 | 10 | LOCKWASHER 3/8 AM STD |
| 23 | 97179 | 1 | SCREW 5/16-18 NC x 1/2 LG SOC HD CAP |
| 22 | 97239 | 10 | NUT 3/8-16 NC STD HEX |
| 24 | 79065 | 2 | SUB BASE |
| 25 | 97146 | 4 | SCREW 7/16-14 NC x 1 3/4" LG SOC HD CAP |
| 26 | 97465 | 4 | LOCKWASHER 7/16 (.078 x .125 SEC) CLASS HC |
| 27 | 97277 | 2 | TAPER DRAW PIN |
| 28 | 97239 | 2 | HEX NUT 3/8-16 NC |
| 29 | 95029 | 2 | DOWEL PIN #P-123 |
| 30 | 97636 | 1 | STREET ELL 3/8 x 45 DEGREE |
| 31 | 58011 | 1 | OIL SUCTION SCREEN |
| 32 | 79067 | 1 | EXTENSION ARM |
| 33 | 97175 | 1 | 1/2-20 NC x 1 1/2 LG SOC HD CAP SCR |
| 34 | 79068 | 1 | SPEED PLATE HOLDER |
| 8 | 79058 | 1 | MOTOR MTG PLATE ASS'Y |
| 35 | 97684 | 1 | KEY WOODRUFF #406 AMER STD |
| 36 | 79069 | 1 | BRASS SHOE |
| 37 | 97004 | 1 | SET SCR 1/2-20 NC x 3/8 LG CUP PT |
| 38 | 79072 | 1 | EXTENSION ARM HOUSING |
| 39 | 97381 | 3 | SCR RD HD SELF TAPPING TYPE "Z" "P-K" #14 x 3/4 LG |
| 40 | 97457 | 3 | LOCKWASHER 1/2 AM STD (LIGHT SEC) |
| 41 | 79074 | 1 | TRANSMISSION ARM |
| 42 | 97174 | 1 | SCR SOC HD CAP 1/2-20 NC x 1" LG |
| 43 | 97076 | 1 | HEADSTOCK COVER PLATE (REAR) |
| 44 | 97307 | 3 | SCR TRUSS HD MACH 1/2-20 NC x 1/2 LG |
| 45 | 67030 | 1 | SERIAL NUMBER PLATE |
| 46 | 97386 | 4 | SCR TYPE "O" #2 x 3/16 LG "P-K" TYPE "U" |
| 46 | 79078 | 1 | HOUSING PLATE |
| 47 | 97386 | 2 | SCR #2 x 3/16 LG "P-K" TYPE "U" |
| 47 | 79080 | 1 | HEADSTOCK COVER PLATE (FRONT) |
| 48 | 79081 | 1 | HEADSTOCK COVER |
| 49 | 97307 | 5 | SCR TRUSS HD MACH 1/2-20 NC x 1/2 LG |
| 49 | 79079 | 1 | PLUG BUTTON |
| 50 | 79082 | 1 | CARR LEVER PIVOT BEARING |
| 51 | 97183 | 2 | SCR SOC HD CAP 5/16-18 NC x 1" LG |
| 52 | 79083 | 1 | OIL GUARD |
| 53 | 79086 | 1 | GUARD |
| 54 | 79089 | 1 | SPEED PLATE |
| 55 | 79090 | 1 | THREADING SPEED PLATE |
| 56 | 97386 | 8 | PLATE SCR #2 x 3/16 LG "P-K" TYPE "U" |
| 56 | 58014 | 1 | BED WAY L.H. & R.H. |
| 131 | 97447 | 2 | PLAIN WASHER 3/8 STD SAE |
| 131 | 79077 | 1 | IDLER GUARD |
| 132 | 97376 | 2 | SCR #10-24 x 3/8 LG RD HD SELF TAPPING P-K TYPE "F" PLATED |
| <u>HEADSTOCK UNIT</u> | | | |
| 57 | 58272 | 2 | SPINDLE BEARING CUP |
| 58 | 58271 | 2 | SPINDLE BEARING CONE |
| 59 | 58041 | 1 | SPINDLE BEARING HOUSING |
| 60 | 58042 | 1 | "O" RING 1866-39 |
| 61 | 58043 | 1 | SHIM |
| 62 | 97181 | 12 | SCR 5/16-18 NC x 3/4 LG SOC HD CAP |
| 63 | 58044 | 1 | SPINDLE BEARING HOUSING |
| 64 | 58045 | 1 | SHIM |
| 66 | 79264 | 2 | BALL BEARING FAFNIR #7206W-SU (PAIR REQ'D) |
| 67 | 79268 | 1 | LOCKWASHER MRC #W-06 |
| 68 | 79266 | 1 | LOCK NUT MRC #N-06 |
| 69 | 79274 | 1 | BEARING CLOSURE |
| 70 | 97184 | 4 | SCR 5/16-18 NC x 1 1/2 LG SOC HD CAP |
| 71 | 79276 | 1 | SHIM |
| 72 | 58048 | 1 | BALL BEARING #205 KD |
| 65 | 58072 | 1 | "O" RING "BUCKEYE" LINEAR #11-258 |
| 73 | 79267 | 1 | LOCKWASHER MRC #W-05 |
| 74 | 79265 | 1 | LOCK NUT MRC #N-05 |
| 75 | 97527 | 1 | EXPANSION PLUG "HUBBARD SPRING CO." CODE #1035 |
| 76 | 79109 | 1 | GEAR CASE COVER PLATE |
| 77 | 58066 | 1 | COVER GASKET |
| 78 | 97350 | 4 | SCR 3/8-16 NC x 3/4 LG FLAT HD MACH |
| 79 | 97119 | 4 | SCR 1/2-13 NC x 1 3/4 LG HEX HD CAP |
| 80 | 97588 | 1 | DRAIN PLUG 1/2 LISLE MAGNETIC SQ HD #402KF |
| 81 | 95002 | 1 | KEY (WORM SHAFT) #K-26 |
| 82 | 97584 | 1 | PIPE PLUG 3/8 STD HEX C'SUNK HDLESS |
| 83 | 79250 | 1 | PLUG OIL GAGE #4040 STYLE BW-GITS BROS. |
| 84 | 79118 | 1 | GEAR CASE |
| 85 | 58035 | 1 | SPINDLE WITH WORM GEAR 562-24 |
| 86 | 79114 | 1 | WORM SHAFT |
| 87 | 79289 | 1 | SHIM .010 |
| | 79290 | 1 | SHIM .015 |
| | 79291 | 1 | SHIM .020 |
| 88 | 79119 | 1 | OILER WITH HANGER 792149 |
| 89 | 97206 | 2 | RD HD MACH SCR #10-24 NC x 1/2 LG |

| REF. No. | PART No. | QUAN- TITY | ITEM | | | | | | | | | | | | | | | |
|--|----------|------------|--|------|----------|--------|-----|------|------|-----|-----|------|-----|-----|------|-----|-----|------|
| <u>DRIVE, CONTROL & PUMP UNIT</u> | | | | | | | | | | | | | | | | | | |
| 91 | 79329 | 1 | MOTOR SHEAVE #D-2525 | | | | | | | | | | | | | | | |
| 92 | 79011 | 1 | TRANSMISSION SHEAVE | | | | | | | | | | | | | | | |
| 93 | 79273 | 2 | "V" BELT #A-43 (MATCHED SET) | | | | | | | | | | | | | | | |
| 94 | 03395 | 1 | COOLANT PUMP | | | | | | | | | | | | | | | |
| 95 | 79012 | 1 | PUMP SHEAVE (DRIVEN) | | | | | | | | | | | | | | | |
| 96 | 79331 | 1 | "V" BELT | | | | | | | | | | | | | | | |
| 97 | 79014 | 1 | TRANSMISSION | | | | | | | | | | | | | | | |
| 98 | 79013 | 1 | PUMP SHEAVE (DRIVER) | | | | | | | | | | | | | | | |
| 90 | 90058 | 1 | MOTOR 3 HP 1800 RPM 3 PH 60 CY, 230/460 or 200 V, GEN. PURPOSE OPEN DRIP PROOF-FRAME #182T. MOTOR 575 V. (SAME DESCRIPTION AS ABOVE) | | | | | | | | | | | | | | | |
| | 90052 | | SCREW (NAMEPLATE) #4 x 3/16 LG P-K TYPE "U" | | | | | | | | | | | | | | | |
| | 97387 | 4 | DRIVE SCR | | | | | | | | | | | | | | | |
| 99 | 97097 | 4 | MTR MTG SCR 3/8-16 NC x 1½ LG HEX HD CAP SCR | | | | | | | | | | | | | | | |
| 100 | 97447 | 4 | PLAIN WASHER 3/8 SAE STD | | | | | | | | | | | | | | | |
| 101 | 97458 | 4 | LOCKWASHER 3/8 STD (MED. SECTION) | | | | | | | | | | | | | | | |
| 102 | 97241 | 4 | FIN HEX NUT 3/8-16 NC | | | | | | | | | | | | | | | |
| | 97010 | 2 | CUP PT SET SCR 5/16-18 NC x ½ LG | | | | | | | | | | | | | | | |
| | 97017 | 1 | CUP PT SET SCR ½-20 NC x 3/8 LG | | | | | | | | | | | | | | | |
| 103 | 97088 | 4 | PUMP MTG SCR 5/16-18 NC x 2½ LG HEX HD CAP SCR | | | | | | | | | | | | | | | |
| 104 | 97463 | 4 | LOCKWASHER 5/16 STD (MED. SECTION) | | | | | | | | | | | | | | | |
| 105 | 97235 | 4 | FINISHED HEX NUT 5/16-18 NC | | | | | | | | | | | | | | | |
| 109 | 79015 | 1 | OIL LEVEL PLATE | | | | | | | | | | | | | | | |
| | 97385 | 2 | PLATE SCR #2 x 1/8 LG P-K TYPE "U" | | | | | | | | | | | | | | | |
| 106 | 97120 | 4 | HEX HD CAP SCR ½-13 NC x 2" LG | | | | | | | | | | | | | | | |
| 107 | 97467 | 4 | LOCKWASHER ½ STD (MED. SECTION) | | | | | | | | | | | | | | | |
| 108 | 79284 | 1 | SHIM .010 | | | | | | | | | | | | | | | |
| | 79285 | 1 | SHIM .020 | | | | | | | | | | | | | | | |
| | 79286 | 1 | SHIM .050 | | | | | | | | | | | | | | | |
| | 79287 | 1 | SHIM .060 | | | | | | | | | | | | | | | |
| | 79238 | 1 | STARTER "A-B" BUL. #705-SIZE "O" - 3 PH SER. "K" STYLE "RT" W/120V CONTROL TRANSFORMER FOR 200 OR 230/460 OR 575 VOLT - NEMA 1 ENCL. COIL - "A"-B" #70A86 | | | | | | | | | | | | | | | |
| | 58241 | 2 | HEATERS (SEE CHART) | | | | | | | | | | | | | | | |
| | | 3 | | | | | | | | | | | | | | | | |
| | | | <table><tr><th>VOLT</th><th>F1. AMPS</th><th>HEATER</th></tr><tr><td>200</td><td>10.8</td><td>N-30</td></tr><tr><td>230</td><td>9.4</td><td>N-31</td></tr><tr><td>460</td><td>4.7</td><td>N-24</td></tr><tr><td>575</td><td>3.6</td><td>N-21</td></tr></table> | VOLT | F1. AMPS | HEATER | 200 | 10.8 | N-30 | 230 | 9.4 | N-31 | 460 | 4.7 | N-24 | 575 | 3.6 | N-21 |
| VOLT | F1. AMPS | HEATER | | | | | | | | | | | | | | | | |
| 200 | 10.8 | N-30 | | | | | | | | | | | | | | | | |
| 230 | 9.4 | N-31 | | | | | | | | | | | | | | | | |
| 460 | 4.7 | N-24 | | | | | | | | | | | | | | | | |
| 575 | 3.6 | N-21 | | | | | | | | | | | | | | | | |
| | 79243 | | LOCKWASHER ½ STD (MED. SECTION) | | | | | | | | | | | | | | | |
| | 79244 | | PUSHBUTTON CONTROL STA. "CUTLER-HAMMER" | | | | | | | | | | | | | | | |
| | 79241 | | CONTACT BLOCK #10250T1 | | | | | | | | | | | | | | | |
| | 78247 | 1 | OPERATOR "START" P.B. #10250T2517 | | | | | | | | | | | | | | | |
| | 78249 | 1 | OPERATOR "STOP" P.B. #10250T122 | | | | | | | | | | | | | | | |
| | 78246 | 1 | OPERATOR "REV." P.B. #10250T103 | | | | | | | | | | | | | | | |
| | 78251 | 1 | LEGEND "RUN-SAFE-JOG" #10250TM70 | | | | | | | | | | | | | | | |
| | 78252 | 1 | LEGEND "STOP" #10250TM34 | | | | | | | | | | | | | | | |
| | 78250 | 1 | LEGEND "REV." #10250TM30 | | | | | | | | | | | | | | | |
| 111 | 79292 | 1 | P.B. COVER | | | | | | | | | | | | | | | |
| 112 | 79294 | 1 | P.B. GASKET | | | | | | | | | | | | | | | |
| 113 | 97203 | 4 | RD HD MACH SCR #10-32 NF x 3/4 LG | | | | | | | | | | | | | | | |
| | 97216 | 3 | RD HD MACH SCR ½-20 NC x ½ LG | | | | | | | | | | | | | | | |
| | 97233 | 3 | HEX NUT ½-20 NC FINISHED | | | | | | | | | | | | | | | |
| 115 | 79270 | 1 | (V-BELT)SHEAVE TYPE "D1" 3V-3.35 O.D.-4 GROOVE W/1 SH BUSHING WITH 1" BORE & STD KEYSEAT, SOCKET HD CAP SCR ½-20 NC x 2½ LG | | | | | | | | | | | | | | | |
| 117 | 97177 | 3 | LOCKWASHER ½ STD (MED. SECTION) | | | | | | | | | | | | | | | |
| 118 | 97462 | 3 | (V-BELT) SHEAVE TYPE "A1" 3V-6.00 O.D. 4 GROOVE W/1 SK BUSHING WITH 1" BORE & STD KEYSEAT, HEX HD CAP SCREWS - 5/16-18 NC x 2 LG | | | | | | | | | | | | | | | |
| 119 | 79269 | 1 | LOCKWASHERS 5/16 STD (MED. SECTION) | | | | | | | | | | | | | | | |
| | | | V BELT - CAT. #3V500 SIZE 3V (MATCHED SET) | | | | | | | | | | | | | | | |
| 121 | 97087 | 3 | IDLER LINK | | | | | | | | | | | | | | | |
| 122 | 97463 | 3 | HEX HD CAP SCREW 5/8-11 x 2½ LG | | | | | | | | | | | | | | | |
| 123 | 96025 | 4 | HEX JAM NUT - 5/8-11 FINISHED | | | | | | | | | | | | | | | |
| 124 | 79017 | 1 | IDLER BEARING | | | | | | | | | | | | | | | |
| 125 | 97130 | 1 | CUP PT SOC SET SCREW 5/16-18 x 3/8" LG | | | | | | | | | | | | | | | |
| 126 | 79249 | 1 | | | | | | | | | | | | | | | | |
| 127 | 79018 | 1 | | | | | | | | | | | | | | | | |
| 130 | 97008 | 1 | | | | | | | | | | | | | | | | |
| <u>NO. 02915 REAR CENTERING CHUCK UNIT</u> | | | | | | | | | | | | | | | | | | |
| 187 | 79128 | 1 | CENTERING CHUCK BODY | | | | | | | | | | | | | | | |
| 188 | 65260 | 1 SET | CENTERING CHUCK GUIDE (3 PER SET) | | | | | | | | | | | | | | | |
| 189 | 65261 | 1 | CENTERING CHUCK SCROLL | | | | | | | | | | | | | | | |
| 190 | 65262 | 1 | CENTERING CHUCK HANDWHEEL TIRE | | | | | | | | | | | | | | | |
| 191 | 65263 | 1 | RETAINING RING "SPIROLOX" #RS-312 | | | | | | | | | | | | | | | |
| 192 | 97179 | 3 | 5/16-18 NC x ½ LG SOC HD CAP SCREW | | | | | | | | | | | | | | | |
| 193 | 97469 | 3 | 5/16 LOCKWASHER HC (.047 x .078 SEC) | | | | | | | | | | | | | | | |
| <u>THREAD LENGTH GAGE UNIT</u> | | | | | | | | | | | | | | | | | | |
| 142 | 79129 | 1 | LINEAR GAGE | | | | | | | | | | | | | | | |
| 143 | 79132 | 2 | LINEAR GAGE MTG PAD | | | | | | | | | | | | | | | |
| 144 | 97216 | 6 | SCREW ½-20 NC x ½ RD HD | | | | | | | | | | | | | | | |
| 145 | 65227 | 1 | THREAD LENGTH GAGE | | | | | | | | | | | | | | | |
| 147 | 97206 | 2 | SCREW #10-24 NC x ½ LG RD HD MACH | | | | | | | | | | | | | | | |
| 146 | 79133 | 1 | GAGE POINTER | | | | | | | | | | | | | | | |
| <u>SLIDE-OUT CARRIAGE & CUT-OFF UNIT</u> | | | | | | | | | | | | | | | | | | |
| 148 | 65073 | 1 | SPACER BUTTED SPLIT STEEL SPACER .500/.510 OD x .380/.390 ID x .583/.603" LG | | | | | | | | | | | | | | | |
| 149 | 58094 | 1 | CARRIAGE LEVER LINK | | | | | | | | | | | | | | | |
| 150 | 58093 | 1 | CARRIAGE | | | | | | | | | | | | | | | |
| 151 | 58095 | 1 | SPACER | | | | | | | | | | | | | | | |
| 152 | 65425 | 1 | CARRIAGE LEVER & YOKE ASSEMBLY | | | | | | | | | | | | | | | |
| 153 | 31046 | 1 | LEVER GRIP | | | | | | | | | | | | | | | |
| 154 | 65074 | 1 | YOKE PIN ASSEMBLY | | | | | | | | | | | | | | | |
| 155 | 97100 | 1 | PIVOT SCREW 3/8-16 NC x 2" LG HEX HEAD CAP SCR | | | | | | | | | | | | | | | |
| 156 | 58079 | 1 | DIE HEAD CENTERING LATCH | | | | | | | | | | | | | | | |
| 157 | 58081 | 1 | LATCH SPRING | | | | | | | | | | | | | | | |
| 158 | 97403 | 1 | ROLL PIN 3/16 DIA x 7/8 LG #59-040-187-0875 | | | | | | | | | | | | | | | |

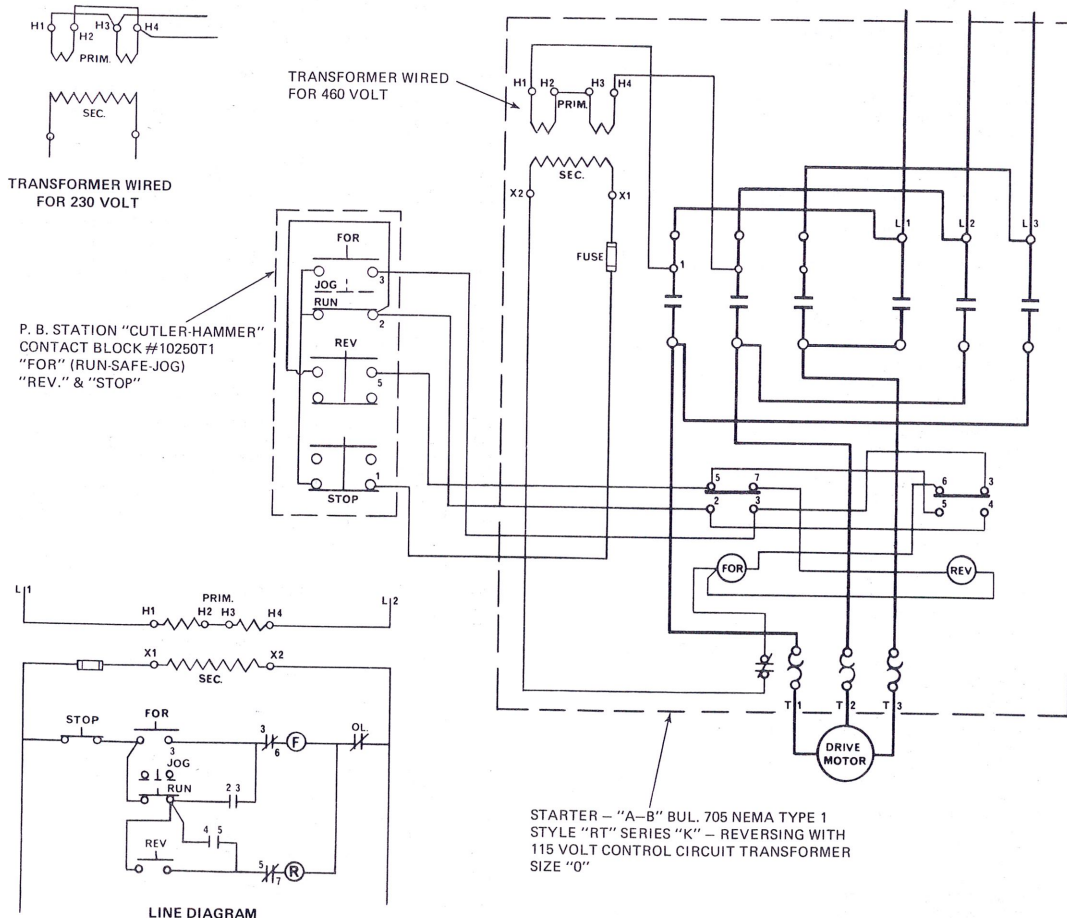
NOTE: WHEN ORDERING SPARE PARTS, SPECIFY PRE-FIX LETTERS AND SERIAL NUMBER OF YOUR MACHINE.

| REF. No. | PART No. | QUAN- TITY | ITEM |
|--|----------|------------|--|
| 159 | 58082 | 1 | CUT-OFF WHEEL SUPPORT |
| 160 | 65496 | 1 | CUT-OFF WHEEL (PACKED 6 TO A CARTON) |
| 161 | 65256 | 3 | PIN |
| 162 | 58084 | 1 | CUT-OFF FEED SCREW |
| 163 | 58085 | 1 | THRUST BEARING |
| 164 | 97406 | 5 | RETAINING PIN 3/16 DIA x 1 1/2 LG #59-040-187-1500 |
| 165 | 58086 | 1 | FEED SCREW HANDLE |
| 166 | 97408 | 1 | HANDLE PIN 1/2 x 1" #59-048-250-1000 |
| 167 | 58087 | 1 | FEED SCREW NUT |
| 168 | 58089 | 1 | ROLLER SUPPORT |
| 169 | 58091 | 2 | STEADY REST ROLL |
| 170 | 58092 | 2 | SUPPORT ROD |
| 171 | 97411 | 1 | ROLL PIN #59-062-312-1750 |
| NO. 02946 "WRENCHLESS" CHUCK UNIT | | | |
| 172 | 65268 | 1 | CHUCK BODY |
| 173 | 79141 | 3 | SCREWS 3/8-16 NC x 3 LG SOC HD CAP |
| 174 | 97470 | 3 | LOCKWASHER 3/8 (.078 x .125 SEC) CLASS HC |
| 175 | 65436 | 1 | RETAINING PLATE |
| 176 | 79127 | 1 | HANDWHEEL |
| 177 | 65273 | 1 | HANDWHEEL TIRE |
| 178 | 65443 | 1 | SCROLL |
| 179 | 97341 | 2 | SCREW 1/2-20 NC x 3/4 LG FLAT HD MACH |
| 180 | 65459 | 1 SET | CHUCK JAWS WITH INSERTS (3 PER SET) |
| 182 | 65454 | 1 SET | CHUCK JAW INSERTS (3 PER SET) |
| 183 | 97168 | 3 | SCREW (INSERT) #10-32 NF x 1 1/2 LG SOC HD CAP |
| 184 | 97520 | 1 | 1/2 STEEL BALL |
| 185 | 79126 | 1 | RUBBER CORD |
| 186 | 97049 | 2 | FLAT PT SET SCR 5/16-18 NC x 5/8 LG "NYLOK" |
| NO. 02887 "QUADVERSAL" DIE HEAD | | | |
| 194 | 89067 | 1 | DIE HEAD BODY |
| 195 | 89070 | 1 | DIE CAM & WASHER ASSEMBLY |
| 196 | 97285 | 4 | FLAT HD MACH SCR PHILLIPS RECESSED 1/2-20 x 1 LG |
| 197 | 89056 | 1 | OPENING LEVER |
| 198 | 89281 | 1 | OPENING LEVER FULCRUM |
| 199 | 89020 | 1 | FULCRUM SETTING WASHER |
| 200 | 89031 | 1 | LOCKING LEVER |
| 201 | 89044 | 1 | OPENING LINK |
| 202 | 89045 | 2 | LINK SCREW |
| 203 | 96337 | 1 | REAMER |
| 204 | 97020 | 1 | SOC SET SCR 3/8-16 NC x 3/4 LG (CUP PT) |
| 205 | 89069 | 1 | NAME PLATE |

| REF. No. | PART No. | QUAN- TITY | ITEM |
|-------------------------------------|----------|------------|---|
| 206 | 97387 | 2 | DRIVE SCR P-K TYPE "U" #4 x 3/16 LG |
| 207 | 97444 | 1 | WASHER 1/2" PLAIN WROUGHT STEEL - BLACK OXIDE |
| 208 | 97069 | 1 | HEX HD CAP SCR 1/2-20 NC x 3/8 LG BLACK OXIDE |
| PIPING UNIT SUMP TO PUMP | | | |
| 79251 * | 1 | 1 | OIL HOSE 5/8 I.D. 61/64 O.D. x 20 LG "GATES" |
| 97710 | 1 | 1 | OIL RESISTANT SINGLE BRAID TYPE #19B |
| 97611 | 1 | 1 | NIPPLE 3/8 STD. 5 1/2 LG. TH'D ONE END |
| 97639 | 1 | 1 | 90 DEGREE ELBOW 3/8 PIPE TH'D |
| 97616 | 1 | 1 | 3/8 - CLOSE NIPPLE |
| 97638 | 1 | 1 | 90 DEGREE REDUCING ELBOW 3/8 NPT - 1/2 NPT |
| 97711 | 2 | 1 | CLOSE NIPPLE 1/2 NPT |
| | | | HOSE CLAMP - WORM DRIVE TYPE #12 - 1/2 to 1 1/2 DIA |
| PUMP TO BASE | | | |
| 97638 | 1 | 1 | CLOSE NIPPLE 1/2 NPT |
| 97616 | 1 | 1 | REDUCER 3/8 NPT - 1/2 NPT |
| 97649 | 1 | 1 | NIPPLE 3/8 STD PIPE x 2 LG TH'D ONE END |
| 79251 * | 1 | 1 | OIL HOSE 5/8 I.D. x 61/64 O.D. x 25 LG. "GATES" |
| 97711 | 2 | 1 | OIL RESISTANT SINGLE BRAID TYPE 19B |
| | | | HOSE CLAMP-WORM DRIVE TYPE #12 1/2 to 1 1/2 DIA |
| BASE TO DIE HEAD | | | |
| 79251 * | 1 | 1 | OIL HOSE 5/8 I.D. x 61/64 O.D. x 4 1/2 LG "GATES" |
| 97649 | 3 | 1 | OIL RESISTANT SINGLE BRAID TYPE 19B |
| 97592 | 1 | 1 | NIPPLE 3/8 STD PIPE x 2 LG TH'D ONE END |
| 58118 | 1 | 1 | TEE 3/8 NPT |
| 97522 | 1 | 1 | OIL CHECK VALVE BODY |
| 97711 | 4 | 1 | STEEL BALL 1/2 DIA |
| 79330 | 1 | 1 | HOSE CLAMP - WORM DRIVE TYPE #12 1/2 to 1 1/2 DIA |
| 97599 | 2 | 1 | COMPRESSION SPRING "LEE CAT. #LC-042F-2-MUSIC |
| 79251 * | 1 | 1 | WIRE .420 O.D. x .042 WIRE DIA x 5/8 FREL LG |
| 97639 | 2 | 1 | 90 DEGREE STREET ELBOW 3/8 NPT |
| 97592 | 1 | 1 | OIL HOSE 5/8 I.D. 61/64 O.D. x 26 3/4 LG "GATES" |
| 79260 | 1 | 1 | OIL RESISTANT SINGLE BRAID TYPW 19B |
| 58124 | 1 | 1 | CLOSE NIPPLE 3/8 NPT (1-IN CARR.) |
| | | | TEE 3/8 NPT |
| | | | SHUT-OFF COCK 3/8" "GAS SERVICE" BRASS WITH |
| | | | CHECK & LEVER HANDLE |
| | | | OIL OUTLET SPOUT |

* SPECIFY 79251 HOSE LENGTH WHEN ORDERING

NOTE: WHEN ORDERING SPARE PARTS, SPECIFY PRE-FIX LETTERS AND SERIAL NUMBER OF YOUR MACHINE.



WIRING DIAGRAM

FRONT VIEW

