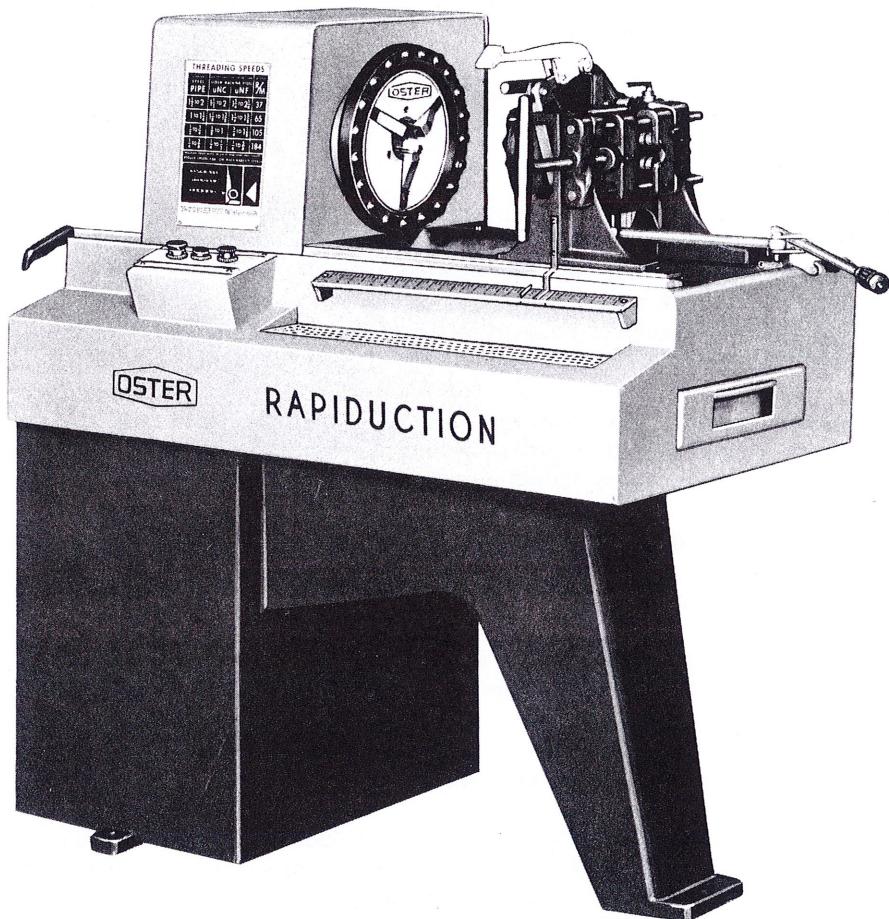


# ASSEMBLY, OPERATION and SERVICE MANUAL for



792

"RAPIDURATION"



**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](http://www.ostermfg.com)

PH: 888-416-7837

989-729-1160

# OPERATOR SAFETY INSTRUCTIONS

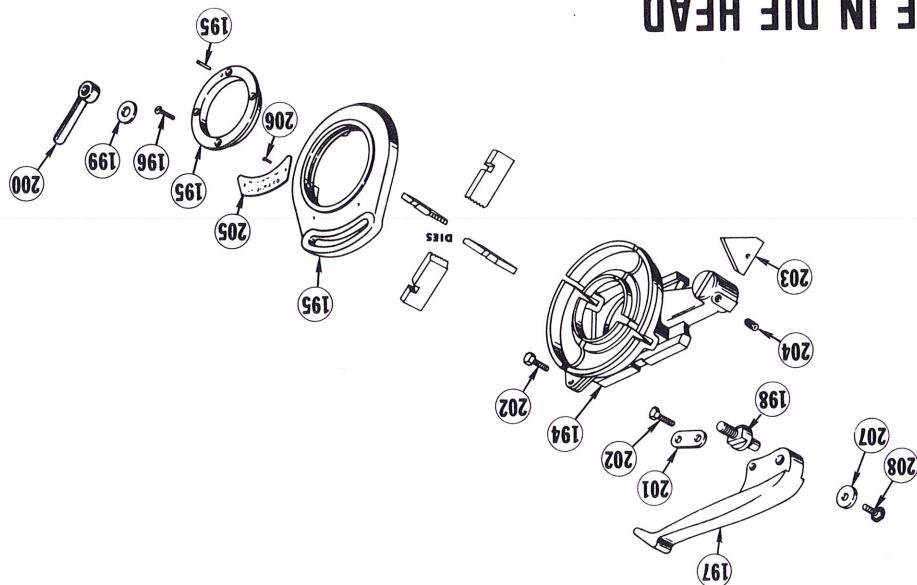
Metalworking equipment is designed to change the shape of workpieces by removing, displacing, or joining metal. Accomplishing these functions requires a combination of high electrical or mechanical power inputs, high speeds, sharp tools, and numerous moving components including in some cases, the workpiece 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.

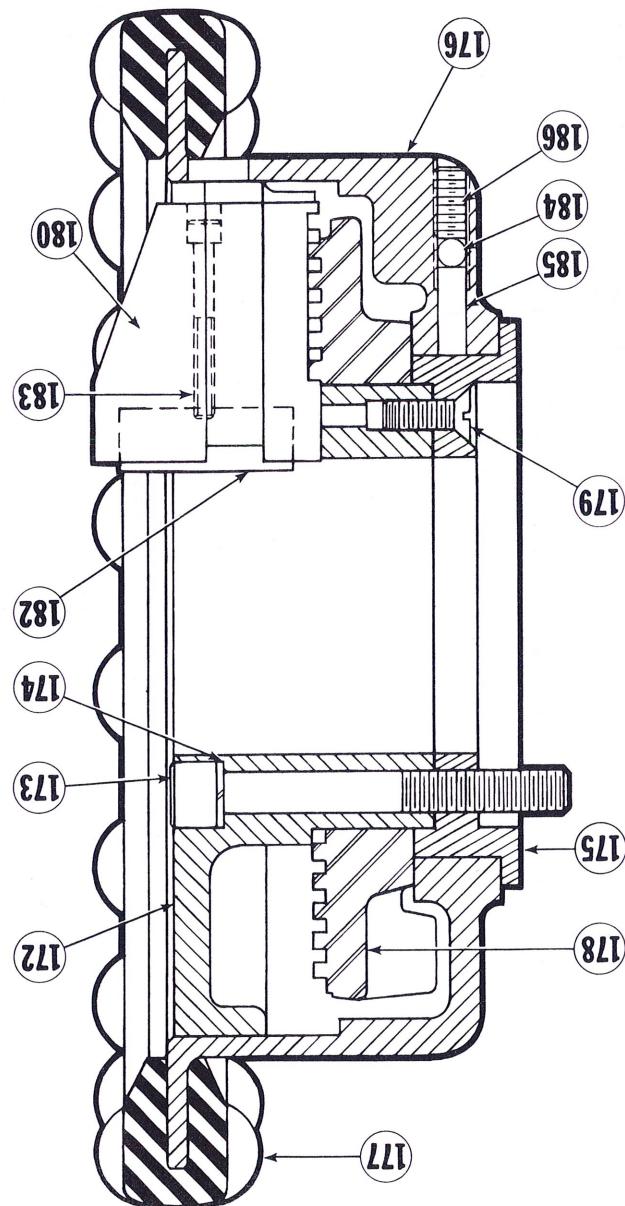
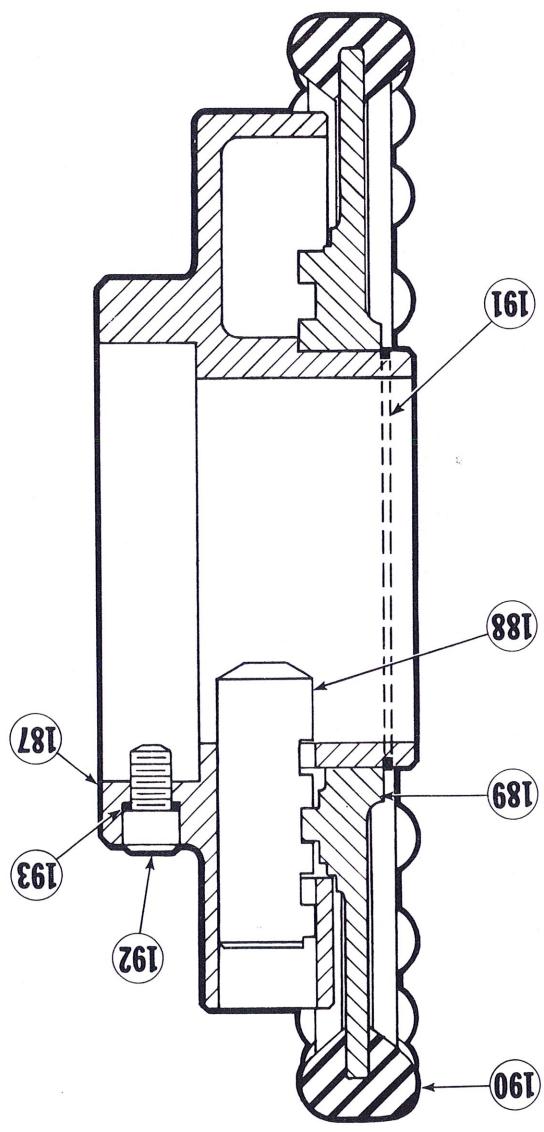
1. READ THE INSTRUCTION BOOK before attempting to lift, move, operate, or perform maintenance on any piece of equipment! Become intimately familiar with all equipment controls; their locations, their operation, their effect on equipment functions. Keep the operator's instruction book in a clean location 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!**

02887 SLIDE IN DIE HEAD



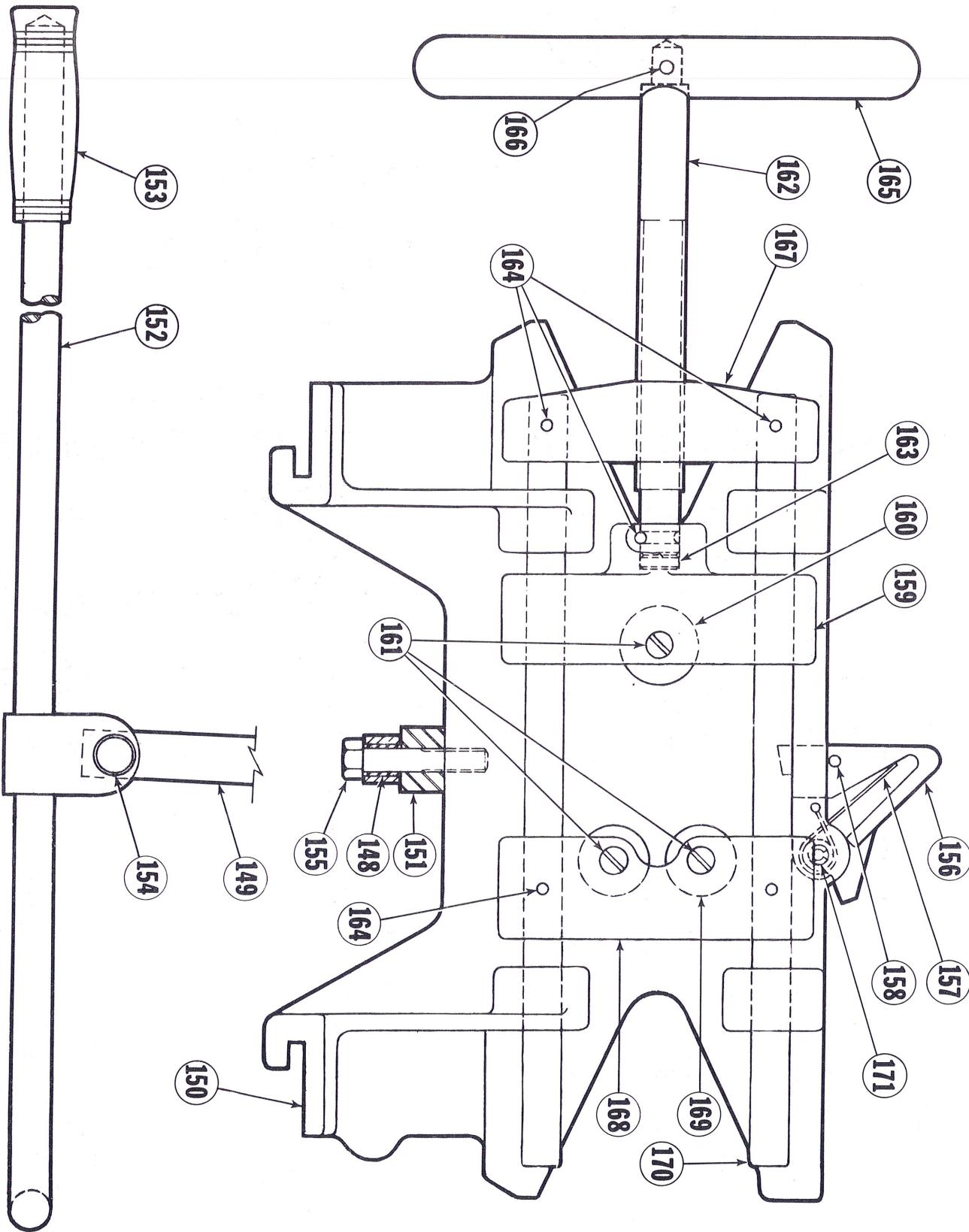
**CENTREING CHUCK ASSEMBLY**

No. 02946



**CARRIAGE ASSEMBLY**

TOP VIEW - LEVER & LINK



**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.

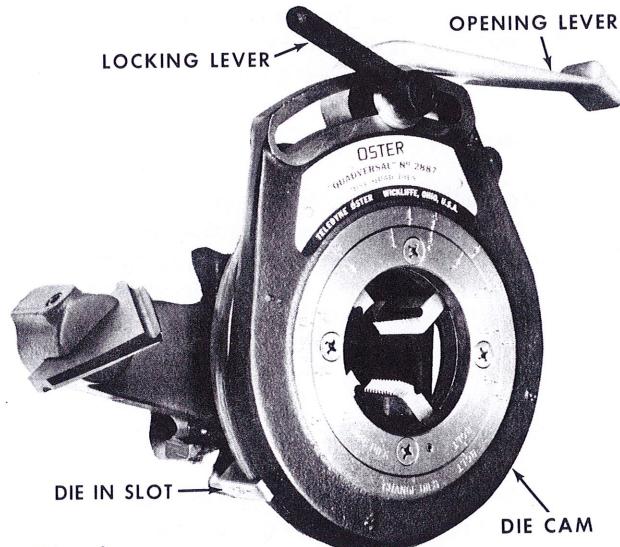
**GEAR CASE (HEADSTOCK) --**

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:**

- Loosen the locking lever that secures the locking bolt.
- Raise opening lever.
- Rotate die cam until "Change Dies" marks are together.
- Clean die slots with chip brush.
- Insert dies in slots with numbers corresponding to the number stamped on each die (1-2-3-4)

#### **2. SET HEAD TO SIZE:**

- Lower opening lever.
- 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:

- A. Remove chips from bore of head.
- B. Loosen locking lever.
- C. Raise opening lever.
- D. Rotate cam until "Change Dies" marks are together.
- E. 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)

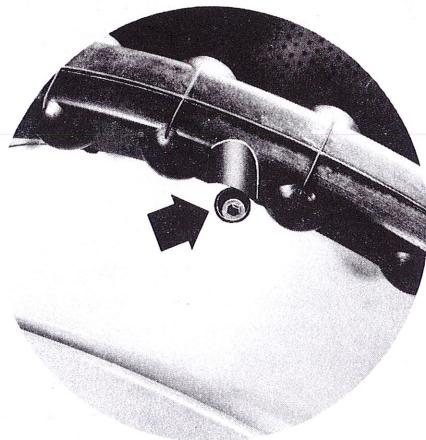


Fig. 2.

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.

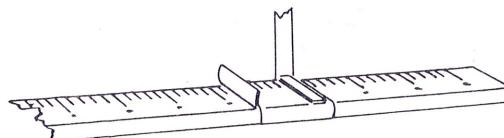


Fig. 3.

#### 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.

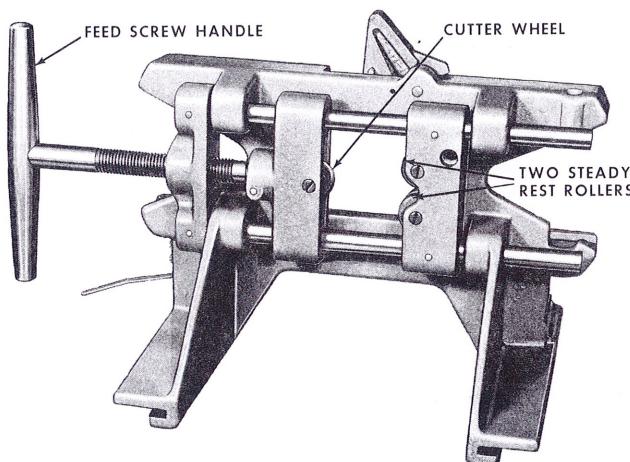


Fig. 4.

#### 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

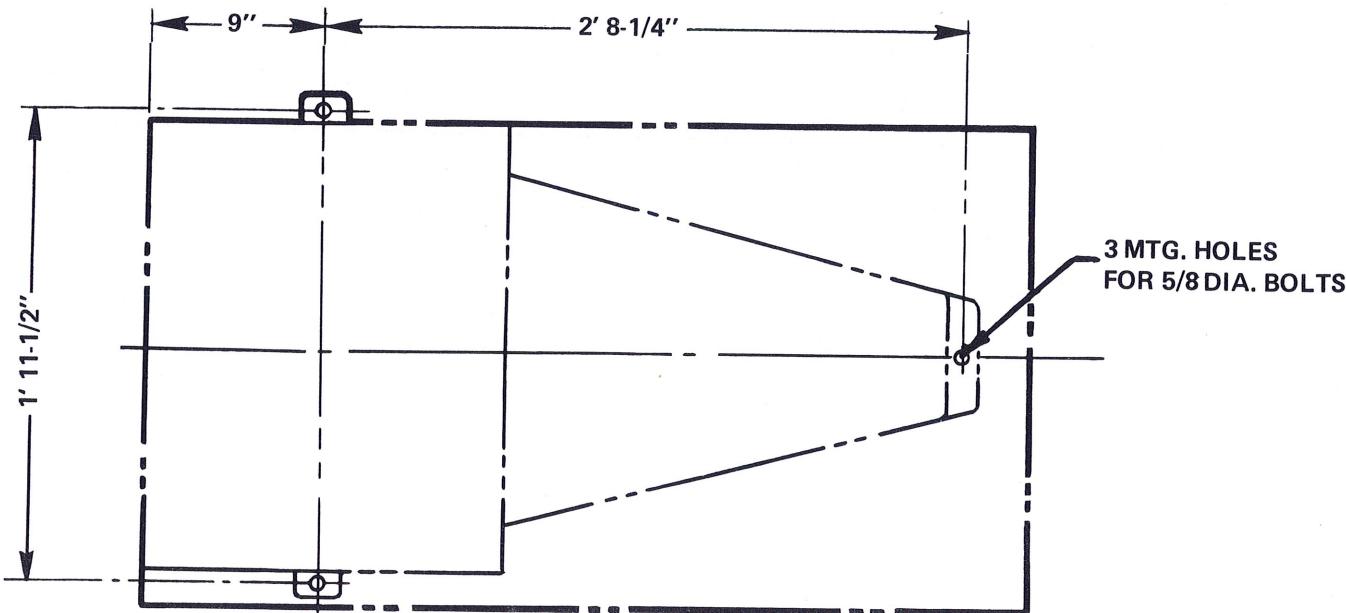
1. Lubrication -- See section under "Lubrication" for instructions.
2. Die-Heads
  - A. When changing dies be sure and clean out die slots before inserting new dies.
  - B. NEVER hammer dies in or out of die slots.
3. CARE OF DIES -- Good threads cannot be cut with dull dies. Therefore, make sure the 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.

## 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 &amp; GUARD UNIT</u>			
1	79019	1	BASE
2	79053	1	TRANSMISSION DOOR
3	97216	5	SCREW $\frac{1}{2}$ -20 NC x $\frac{1}{2}$ 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 $\frac{1}{2}$ 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 $\frac{1}{2}$ -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 $\frac{1}{2}$ 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	79277	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	$\frac{1}{2}$ -20 NC x 1 $\frac{1}{2}$ 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 $\frac{1}{2}$ -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 $\frac{1}{2}$ AM STD (LIGHT SEC)
41	79074	1	TRANSMISSION ARM
42	97174	1	SCR SOC HD CAP $\frac{1}{2}$ -20 NC x 1" LG
43	79076	1	HEADSTOCK COVER PLATE (REAR)
44	97307	3	SCR TRUSS HD MACH $\frac{1}{2}$ -20 NC x $\frac{1}{2}$ LG
45	67030	1	SERIAL NUMBER PLATE
	97386	4	SCR TYPE "O" #2 x 3/16 LG "P-K" TYPE "U"
46	79078	1	HOUSING PLATE
	97386	2	SCR #2 x 3/16 LG "P-K" TYPE "U"
47	79080	1	HEADSTOCK COVER PLATE (FRONT)
48	79081	1	HEADSTOCK COVER
	97307	5	SCR TRUSS HD MACH $\frac{1}{2}$ -20 NC x $\frac{1}{2}$ 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
	97386	8	PLATE SCR #2 x 3/16 LG "P-K" TYPE "U"
56	58014	1	BED WAY L.H. & R.H.
	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 "P" 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 $\frac{1}{2}$ 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 $\frac{1}{2}$ -13 NC x 1 3/4 LG HEX HD CAP
80	97588	1	DRAIN PLUG $\frac{1}{2}$ 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 $\frac{1}{2}$ LG

REF. No.	PART No.	QUAN- TITY	ITEM
<u>DRIVE, CONTROL &amp; 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.
	90052	1	MOTOR 575 V. (SAME DESCRIPTION AS ABOVE)
	97387	4	SCREW (NAMEPLATE) #4 x 3/16 LG P-K TYPE "U"
			DRIVE SCR
99	97097	4	MTR MTG SCR 3/8-16 NC x 1 $\frac{1}{2}$ 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 $\frac{1}{2}$ LG
	97017	1	CUP PT SET SCR $\frac{1}{2}$ -20 NC x 3/8 LG
103	97088	4	PUMP MTG SCR 5/16-18 NC x 2 $\frac{1}{2}$ 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 $\frac{1}{2}$ -13 NC x 2" LG
107	97467	4	LOCKWASHER $\frac{1}{2}$ 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 "0" - 3 PH SER. "H" STYLE "RT" W/120V CONTROL TRANSFORMER FOR 200 OR 230/460 OR 575 VOLT - NEMA 1 ENCL.
	58241	2	COIL - "A"-L" #70A86
		HEATERS (SEE CHART)	
VOLT	F1. AMPS	HEATER	
79243	200	10.8	N-30
79244	230	9.4	N-31
79241	460	4.7	N-24
	575	3.6	N-21
97462	3	LOCKWASHER $\frac{1}{2}$ STD (MED. SECTION)	
110	78248	1	PUSHBUTTON CONTROL STA. "CUTLER-HAMMER"
	78249	1	CONTACT BLOCK #10250T
	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
	79294	1	P.B. GASKET
113	97203	4	RD HD MACH SCR #10-32 NF x 3/4 LG
	79216	3	RD HD MACH SCR $\frac{1}{2}$ -20 NC x $\frac{1}{2}$ LG
	79233	3	HEX NUT $\frac{1}{2}$ -20 NC FINISHED
115	79270	1	(V-BELT) SHEAVE TYPE "D" 3-3.35 O.D.-4 GROOVE W/1 SH. BUSHING WITH 1" BORE & STD KEYSEAT.
	97087	3	SOCKET HD CAP SCR $\frac{1}{2}$ -20 NC x 2 $\frac{1}{2}$ LG
	97462	3	LOCKWASHER $\frac{1}{2}$ STD (MED. SECTION)
117	97177	3	(V-BELT) SHEAVE TYPE "A" 3V-6.00 O.D. 4 GROOVE W/1 SK BUSHING WITH 1" BORE STD KEYSEAT.
	97208	3	HEX HD CAP SCREWS 5/16-18 NC x 2 LG
	79269	1	LOCKWASHERS 5/16 STD (MED. SECTION)
	97087	3	V BELT - CAT. #3V500 SIZE 3V (MATCHED SET)
121	97087	3	IDLER LINK
122	97463	3	HEX HD CAP SCREW 5/8-11 x 2 $\frac{1}{2}$ LG
123	96025	4	LOCKWASHERS 5/16 STD (MED. SECTION)
124	79017	1	HEX JAM NUT - 5/8-11 FINISHED
125	97130	1	IDLER BEARING
126	97249	1	CUP PT SOC SET SCREW 5/16-18 x 3/8" LG
127	79018	1	CUP PT SOC SET SCREW 5/16-18 x 3/8" LG
130	97008	1	CUP PT SOC SET SCREW 5/16-18 x 3/8" LG
<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 $\frac{1}{2}$ 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 $\frac{1}{2}$ -20 NC x $\frac{1}{2}$ RD HD
145	65227	1	THREAD LENGTH GAGE
147	97206	2	SCREW #10-24 NC x $\frac{1}{2}$ LG RD HD MACH
146	79133	1	GAGE POINTER
<u>SLIDE-OUT CARRIAGE &amp; CUT-OFF UNIT</u>			
148	65073	1	SPACER BUTTED SPLIT STEEL SPACER .500/.510 OD x .380/.390 ID x .583/.603" LG
	58094	1	CARRIAGE LEVER LINK
	58093	1	CARRIAGE
	58095	1	SPACER
	65425	1	CARRIAGE LEVER & YOKE ASSEMBLY
	31046	1	LEVER GRIP
	65074	1	YOKE PIN ASSEMBLY
	97100	1	PIVOT SCREW 3/8-16 NC x 2" LG HEX HEAD CAP SCR
	58079	1	DIE HEAD CENTERING IATCH
	58081	1	LATCH SPRING
	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.

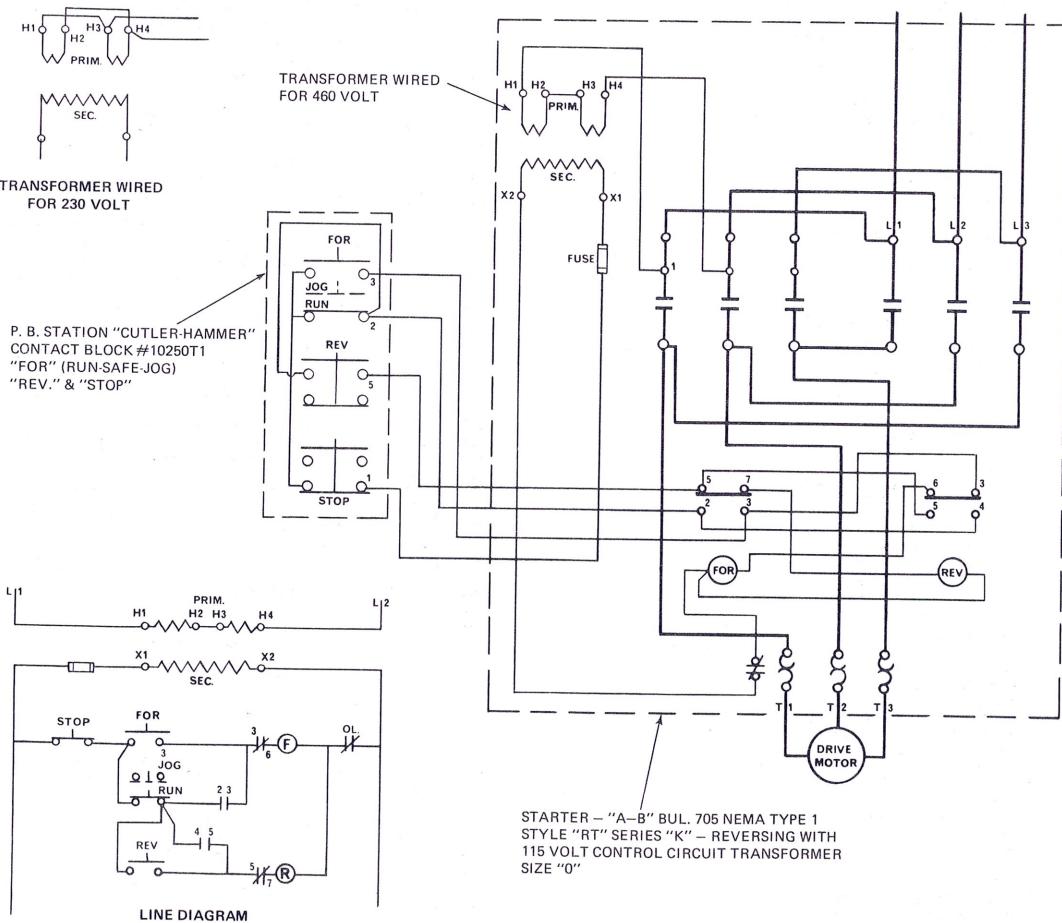
**OSTER** **792** **PARTS**

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 $\frac{1}{2}$ LC #59-040-187-1500
165	58086	1	FEED SCREW HANDLE
166	97408	1	HANDLE PIN $\frac{1}{8}$ 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
			<u>NO. 02946 "WRENCHLESS" CHUCK UNIT</u>
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 $\frac{1}{8}$ -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 $\frac{1}{2}$ LG SOC HD CAP
184	97520	1	$\frac{1}{8}$ STEEL BALL
185	97126	1	RUBBER CORD
186	97049	2	FLAT PT SET SCR 5/16-18 NC x 5/8 LG "NYLOK"
			<u>NO. 02887 "QUADVERSAL" DIE HEAD</u>
194	89067	1	DIE HEAD BODY
195	89070	1	DIE CAM & WASHER ASSEMBLY
196	97285	4	FLAT HD MACH SCR PHILLIPS RECESSED $\frac{1}{8}$ -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 $\frac{1}{8}$ " PLAIN WROUGHT STEEL - BLACK OXIDE
208	97069	1	HEX HD CAP SCR $\frac{1}{8}$ -20 NC x 3/8 LG BLACK OXIDE
			<u>PIPING UNIT</u>
			<u>SUMP TO PUMP</u>
79251 *	1		OIL HOSE 5/8 I.D. 61/64 O.D. x 20 LG "GATES"
			OIL RESISTANT SINGLE BRAID TYPE #19B
97710	1		NIPPLE 3/8 STD. 5 $\frac{1}{2}$ LC. TH'D ONE END
97611	1		90 DEGREE ELBOW 3/8 PIPE TH'D
97639	1		3/8 - CLOSE NIPPLE
97616	1		90 DEGREE REDUCING ELBOW 3/8 NPT - $\frac{1}{2}$ NPT
97638	1		CLOSE NIPPLE $\frac{1}{2}$ NPT
97711	2		HOSE CLAMP - WORM DRIVE TYPE #12 $\frac{1}{2}$ to 1 $\frac{1}{2}$ DIA
			<u>PUMP TO BASE</u>
97638	1		CLOSE NIPPLE $\frac{1}{2}$ NPT
97616	1		REDUCER 3/8 NPT - $\frac{1}{2}$ NPT
97649	1		NIPPLE 3/8 STD PIPE x 2 LG TH'D ONE END
79251 *	1		OIL HOSE 5/8 I.D. x 61/64 O.D. x 25 LG. "GATES"
			OIL RESISTANT SINGLE BRAID TYPE 19B
97711	2		HOSE CLAMP - WORM DRIVE TYPE #12 $\frac{1}{2}$ TO 1 $\frac{1}{2}$ DIA
			<u>BASE TO DIE HEAD</u>
79251 *	1		OIL HOSE 5/8 I.D. x 61/64 O.D. x 4 $\frac{1}{2}$ LG "GATES"
			OIL RESISTANT SINGLE BRAID TYPE 19B
97649	3		NIPPLE 3/8 STD PIPE x 2 LG TH'D ONE END
97592	1		TEE 3/8 NPT
58118	1		OIL CHECK VALVE BODY
97522	1		STEEL BALL $\frac{1}{8}$ DIA
97711	4		HOSE CLAMP - WORM DRIVE TYPE #12 $\frac{1}{2}$ TO 1 $\frac{1}{2}$ DIA
79330	1		COMPRESSION SPRING "LEE CAT." #LC-042F-2-MUSIC
97599	2		WIRE .420 O.D. x .042 WIRE DIA x 5/8 FREL LG
79251 *	1		90 DEGREE STREET ELBOW 3/8 NPT
97639	2		OIL HOSE 5/8 I.D. 61/64 O.D. x 26 3/4 LG "GATES"
			OIL RESISTANT SINGLE BRAID TYPW 19B
97592	1		CLOSE NIPPLE 3/8 NPT ( 1-IN CARR. )
79260	1		TEE 3/8 NPT
			SHUT-OFF COCK 3/8" "GAS SERVICE" BRASS WITH
			CHECK & LEVER HANDLE
58124	1		OIL OUTLET SPOUT

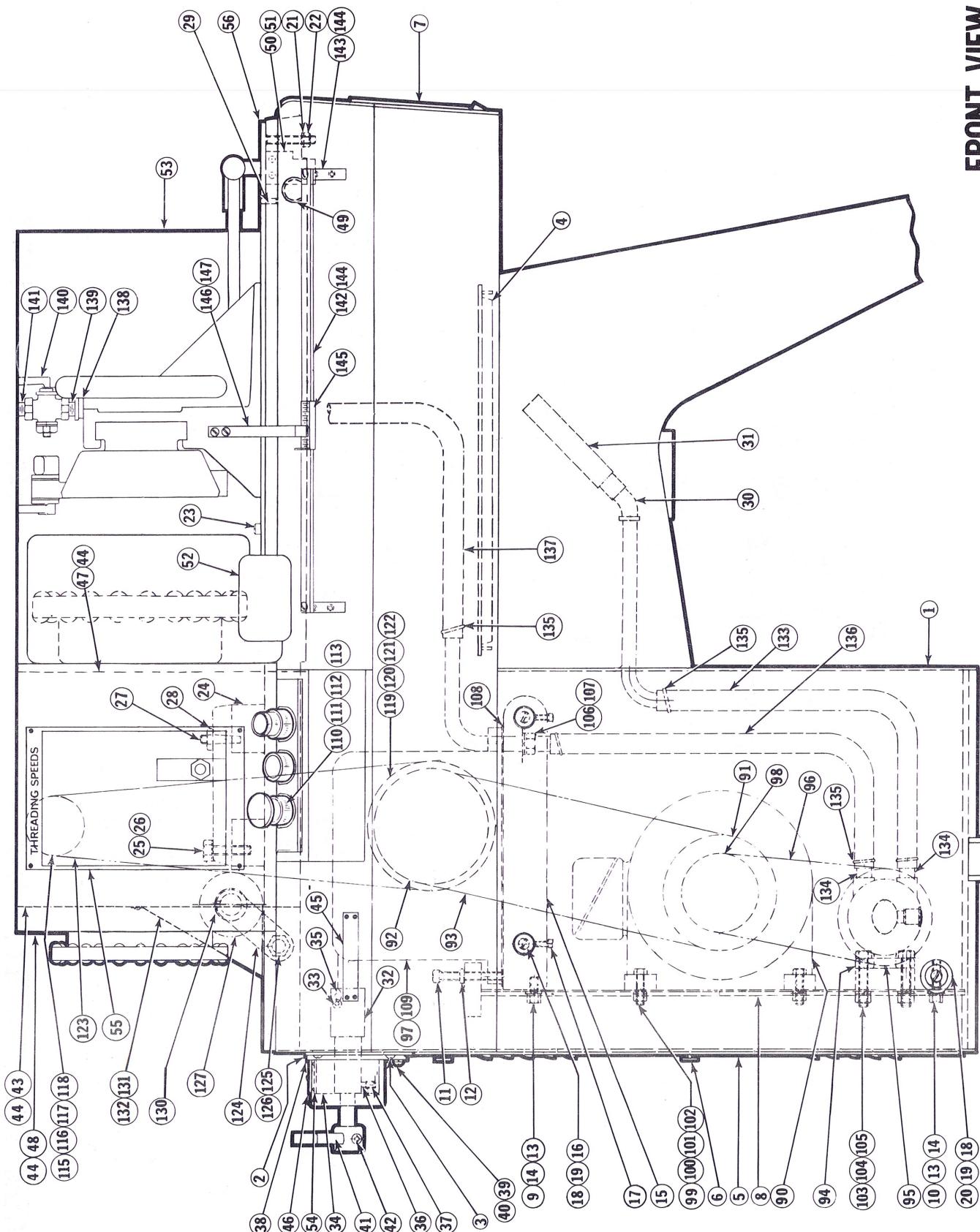
\* SPECIFY 79251 HOSE LENGTH WHEN ORDERING

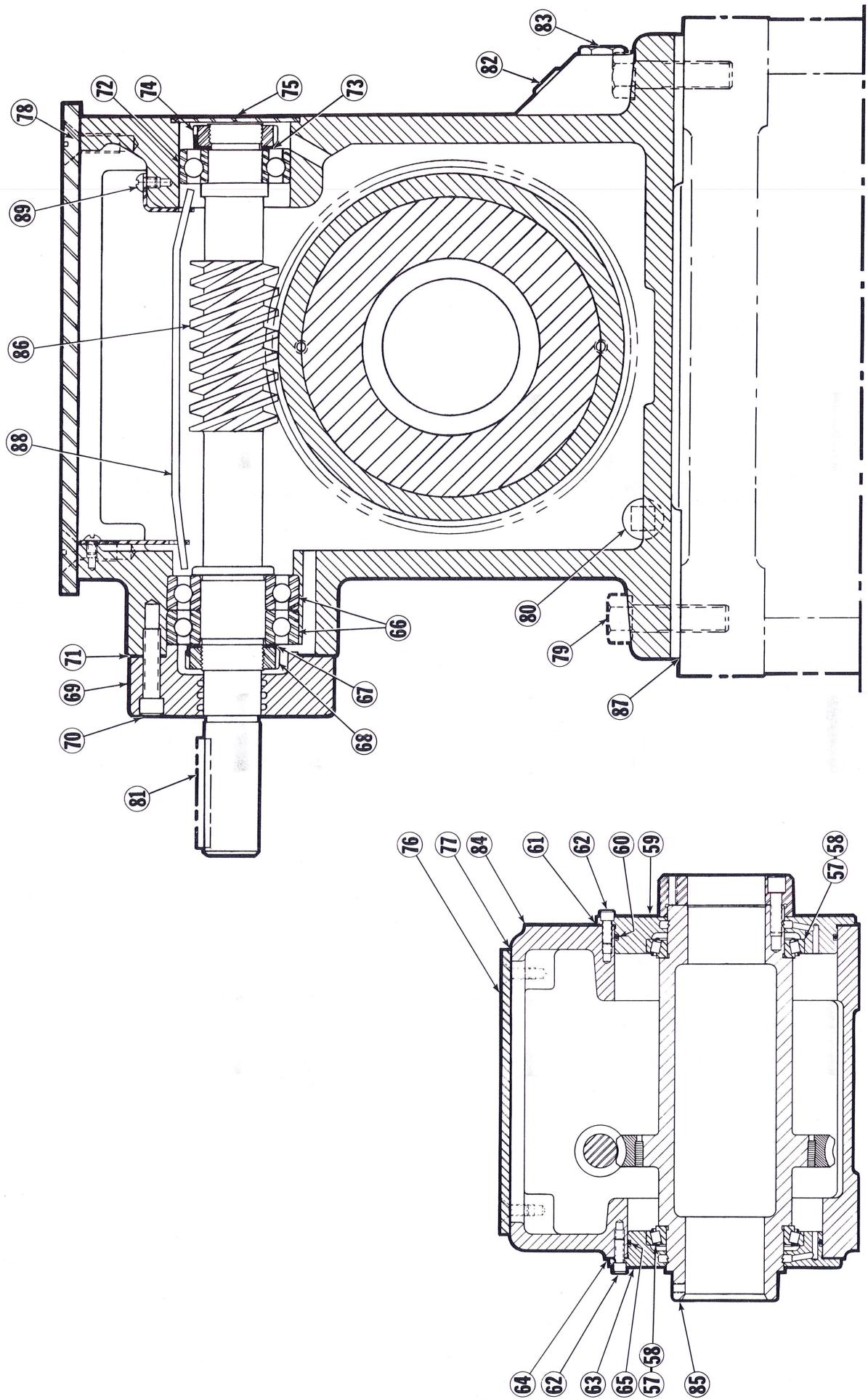
**NOTE: WHEN ORDERING SPARE PARTS, SPECIFY PRE-FIX LETTERS AND SERIAL NUMBER OF YOUR MACHINE.**



**WIRING DIAGRAM**

FRONT VIEW





HEAD STOCK ASSEMBLY - NO. 1

HEADSTOCK ASSEMBLY - NO. 2