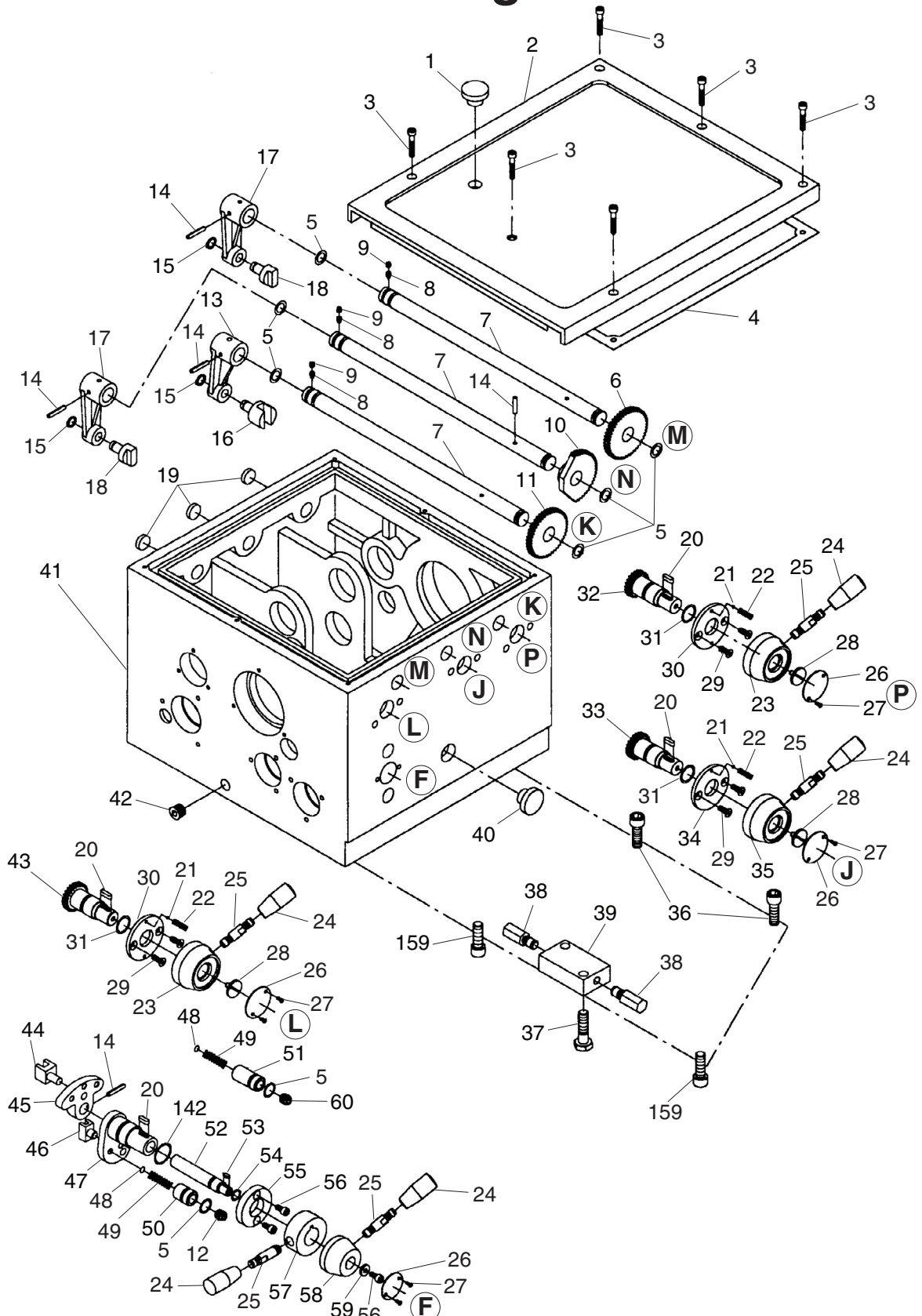


SECTION 9: PARTS

Headstock Shifting Breakdown



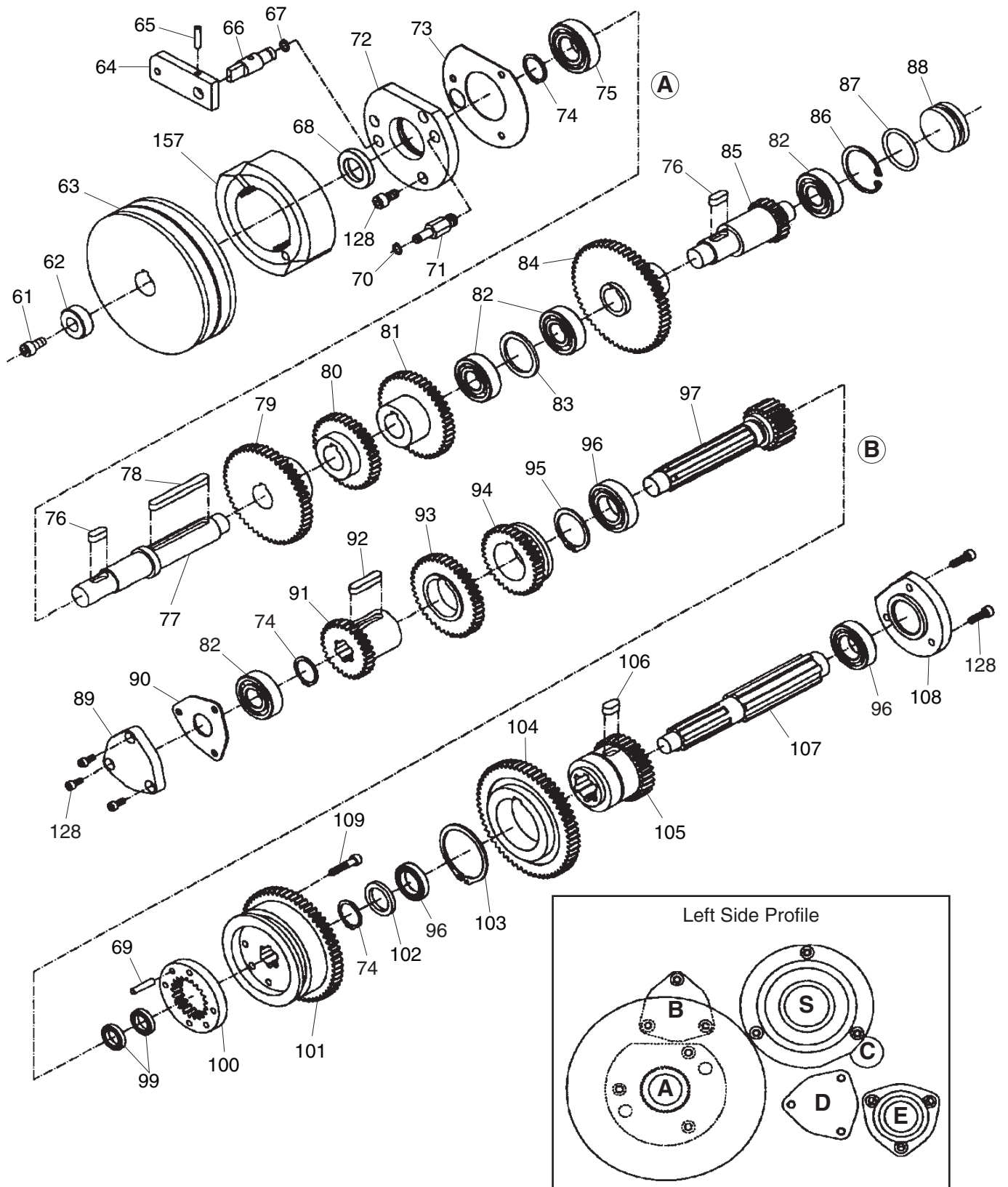
Headstock Shifting Parts List

REF	PART #	DESCRIPTION
1	P0554Z0001	OIL FILL PLUG
2	P0554Z0002	HEADSTOCK COVER
3	PSB06M	CAP SCREW M6-1 X 25
4	P0554Z0004	GASKET
5	P05090251	O-RING 14 X 2.65
6	P0554Z0006	GEAR 38T
7	P0554Z0007	SHAFT
8	PSS01M	SET SCREW M6-1 X 10
9	PN01M	HEX NUT M6-1
10	P0554Z0010	GEAR 48T
11	P0554Z0011	GEAR 43T
12	P0554Z0012	SPECIAL SET SCREW
13	P0554Z0013	SHIFT ARM
14	PRP05M	ROLL PIN 5 X 30
15	PR03M	EXT RETAINING RING 12MM
16	P0554Z0016	SHIFT FORK
17	P0554Z0017	SHIFT ARM
18	P0554Z0018	GEAR SHIFTER
19	P0554Z0019	CASTING PLUG
20	PK08M	KEY 5 X 5 X 16
21	P0554Z0021	STEEL BALL 8MM
22	P0554Z0022	COMPRESSION SPRING
23	P0554Z0023	HANDLE HUB
24	P0554Z0024	HANDLE KNOB
25	P0554Z0025	HANDLE LEVER
26	P0554Z0026	LEVER NAME PLATE
27	PS12M	PHLP HD SCR M3-.5 X 6
28	P0554Z0028	HUB SCREW
29	PFH02M	FLAT HD SCR M6-1 X 12
30	P0554Z0030	END CAP
31	P5960083	O-RING 19 X 2.65

REF	PART #	DESCRIPTION
32	P0554Z0032	GEAR SHAFT 22T
33	P0554Z0033	GEAR SHAFT 17T
34	P0554Z0034	END CAP
35	P0554Z0035	HANDLE HUB
36	PSB92M	CAP SCREW M12-1.75 X 40
37	P0554Z0037	ALIGNMENT BOLT M10-1.5 X 40
38	P0554Z0038	SPECIAL ALIGNMENT BOLT
39	P0554Z0039	ALIGNMENT BLOCK
40	P0554Z0040	OIL SIGHT GLASS
41	P0554Z0041	HEADSTOCK CASTING
42	P0554Z0042	OIL DRAIN PLUG
43	P0554Z0043	GEAR SHAFT 27T
44	P0554Z0044	SHIFT FORK
45	P0554Z0045	SHIFT CRANK
46	P0554Z0046	SHIFT FORK
47	P0554Z0047	SHIFT CRANK
48	P0554Z0048	STEEL BALL 10MM
49	P0554Z0049	COMPRESSION SPRING
50	P0554Z0050	SHAFT
51	P0554Z0051	SHAFT
52	P0554Z0052	SHAFT
53	PK05M	KEY 4 X 4 X 10
54	P0554Z0054	O-RING 10.6 X 2.65
55	P0554Z0055	END CAP
56	PSB26M	CAP SCREW M6-1 X 12
57	P0554Z0057	HANDLE HUB
58	P0554Z0058	HANDLE HUB
59	P0554Z0059	SPECIAL FLAT WASHER
60	P0554Z0060	SPECIAL SET SCREW
142	P0554Z0142	O-RING 25 X 2.65
159	PSB111M	CAP SCREW M12-1.75 X 35



Headstock Gearing Breakdown



Headstock Gearing Parts List

REF	PART #	DESCRIPTION
61	PSB11M	CAP SCREW M8-1.25 X 16
62	P0554Z0062	SPECIAL FLAT WASHER
63	P0554Z0063	PULLEY
64	P0554Z0064	BRAKE BLOCK
65	P0554Z0065	PIN 5 X 16
66	P0554Z0066	SHAFT
67	PR03M	EXT RETAINING RING 12MM
68	P0554Z0068	SPACER SD25 X 45 X 7
69	P0554Z0069	PIN 6 X 26
70	PR39M	EXT RETAINING RING 8MM
71	P0554Z0071	SHAFT
72	P0554Z0072	END CAP
73	P0554Z0073	GASKET
74	PR11M	EXT RETAINING RING 25MM
75	P0554Z0075	BALL BEARING 6205/P5
76	PK107M	KEY 8 X 8 X 20
77	P0554Z0077	SHAFT
78	P0554Z0078	KEY 8 X 8 X 72
79	P0554Z0079	GEAR 50T
80	P0554Z0080	GEAR 37T
81	P0554Z0081	GEAR 43T
82	P0554Z0082	BALL BEARING 6204/P5
83	P0554Z0083	SPACER
84	P0554Z0084	GEAR 57T
85	P0554Z0085	GEAR SHAFT 20T

REF	PART #	DESCRIPTION
86	PR25M	INT RETAINING RING 47MM
87	P0554Z0087	O-RING 40 X 2.65
88	P0554Z0088	CASTING PLUG
89	P0554Z0089	END CAP
90	P0554Z0090	GASKET
91	P0554Z0091	GEAR SHAFT 28T
92	PK121M	KEY 8 X 8 X 38
93	P0554Z0093	GEAR 41T
94	P0554Z0094	GEAR 34T
95	PR68M	EXT RETAINING RING 40MM
96	P0554Z0096	BALL BEARING 6005/P5
97	P0554Z0097	GEAR SHAFT 21T
99	P0554Z0099	BALL BEARING 61803/P5
100	P0554Z0100	GEAR 21T
101	P0554Z0101	GEAR 58T
102	P0554Z0102	SPACER
103	PR78M	EXT RETAINING RING 55MM
104	P0554Z0104	GEAR 59T
105	P0554Z0105	GEAR 31T
106	PK122M	KEY 10 X 10 X 18
107	P0554Z0107	SPLINE SHAFT
108	P0554Z0108	END CAP
109	PSB48M	CAP SCREW M6-1 X 35
128	PSB27M	CAP SCREW M6-1 X 14
157	P0554Z0157	BREAK SHOE ASSEMBLY



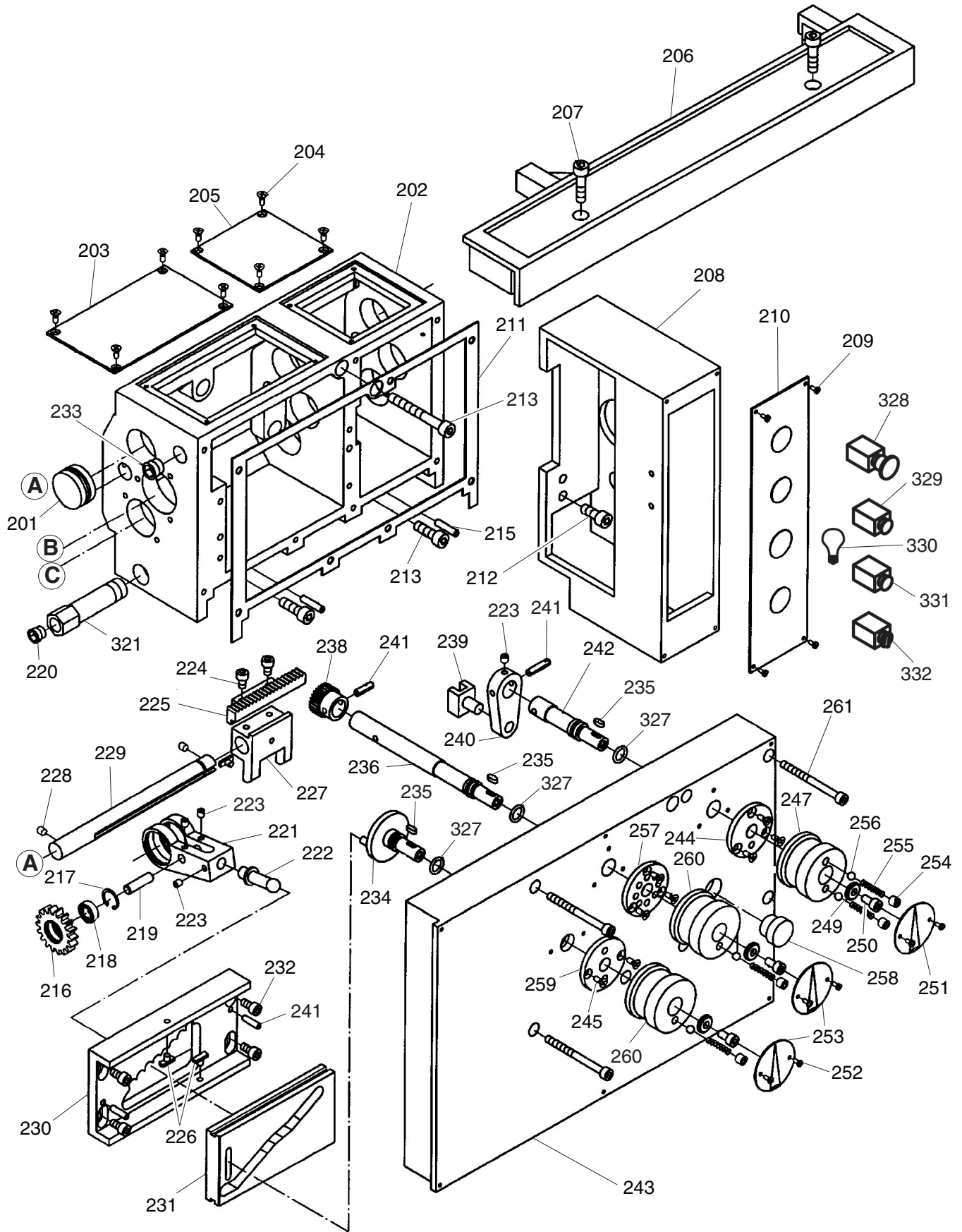
Headstock Spindle Parts List

REF	PART #	DESCRIPTION
61	PSB11M	CAP SCREW M8-1.25 X 16
74	PR11M	EXT RETAINING RING 25MM
82	P0554Z0082	BALL BEARING 6204/P5
89	P0554Z0089	END CAP
90	P0554Z0090	GASKET
95	PR68M	EXT RETAINING RING 40MM
96	P0554Z0096	BALL BEARING 6005/P5
103	PR78M	EXT RETAINING RING 55MM
110	PSB01M	CAP SCREW M6-1 X 16
111	P0554Z0111	END CAP
112	P0554Z0112	GASKET
113	PSB33M	CAP SCREW M5-.8 X 12
114	P0554Z0114	LOCK COLLAR
115	P0554Z0115	TAP. ROLLER BEARING 32011/P5
116	P0554Z0116	GEAR 38T
117	P0554Z0117	LOCK COLLAR
118	P0554Z0118	GEAR 59T
119	PSB15M	CAP SCREW M5-.8 X 20
120	P0554Z0120	GEAR 87T
121	P0554Z0121	BUSHING
122	P0554Z0122	TAP. ROLLER BEARING 30212/P5
123	P0554Z0123	GASKET
124	P0554Z0124	END CAP
125	PSB06M	CAP SCREW M6-1 X 25
126	PK42M	KEY 6 X 6 X 30
127	PK123M	KEY 10 X 10 X 55
128	PSB27M	CAP SCREW M6-1 X 14
129	P0554Z0129	COMPRESSION SPRING

REF	PART #	DESCRIPTION
130	P0554Z0130	BEVELED PIN
131	P0554Z0131	CAMLOCK
132	P0554Z0132	SPINDLE
133	PR09M	EXT RETAINING RING 20MM
134	P0554Z0134	SPACER
135	P0554Z0135	GEAR 32T
136	PR77M	EXT RETAINING RING 37MM
137	P0554Z0137	GEAR 32T
138	PK08M	KEY 5 X 5 X 16
139	P0554Z0139	GEAR SHAFT 32T
140	PSS04M	SET SCREW M6-1 X 12
141	P0554Z0141	SHAFT
142	P0554Z0142	O-RING 25 X 2.65
143	PK42M	KEY 6 X 6 X 30
144	P0554Z0144	GEAR 42T
145	P0554Z0145	SPACER
146	P0554Z0146	GEAR 32T
147	PK49M	KEY 6 X 6 X 55
148	P0554Z0148	GEAR 32T
149	P0554Z0149	BALL BEARING 6004/P5
150	P0554Z0150	CASTING PLUG
151	P0554Z0151	SHAFT
152	P0554Z0152	GEAR 38T
153	P0554Z0153	SPLINE SHAFT
154	P0554Z0154	GASKET
155	P0554Z0155	END CAP
156	P0554Z0156	SPACER
158	P0554Z0158	COLLAR



Gearbox Shifting Breakdown



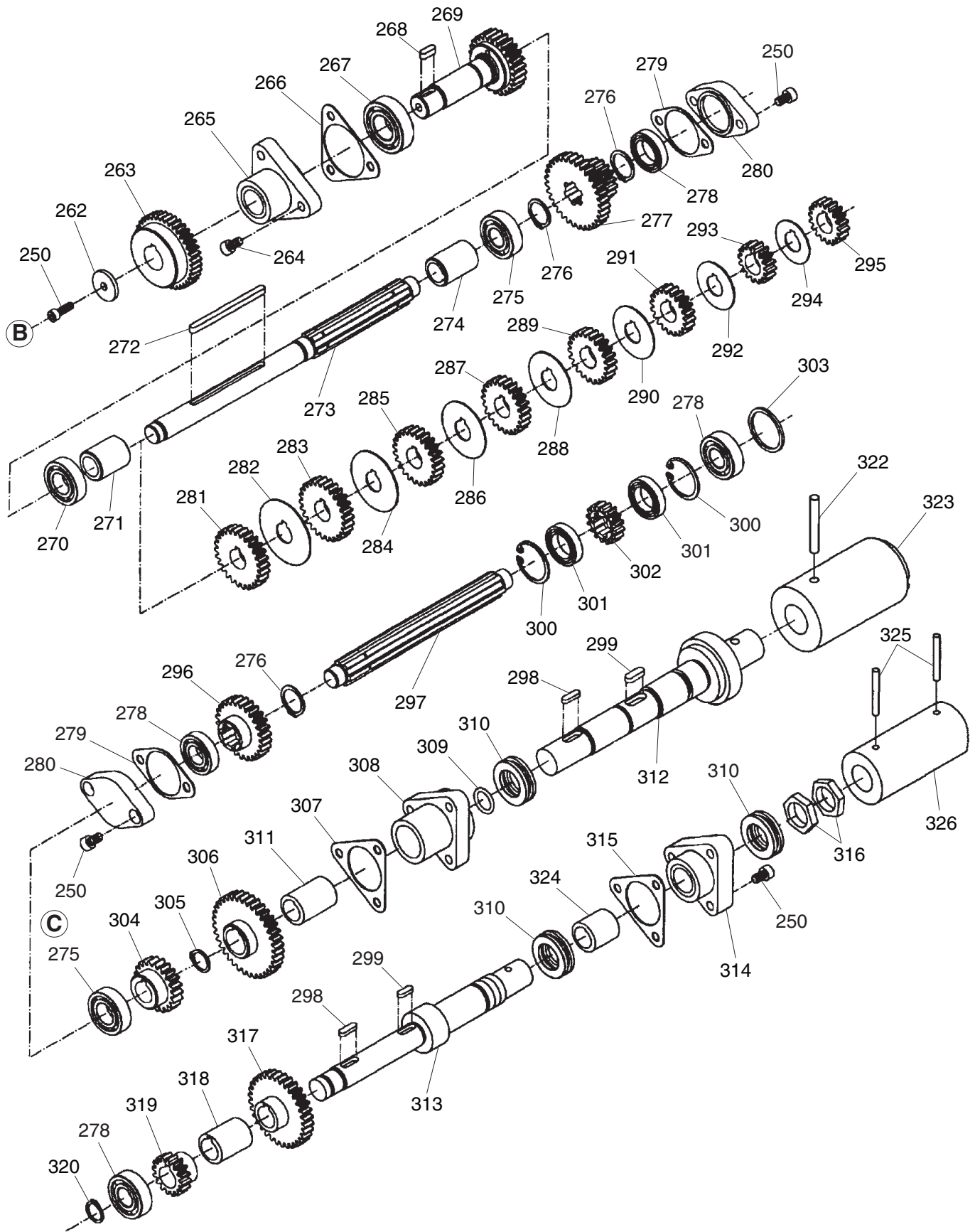
Gearbox Shifting Parts List

REF	PART #	DESCRIPTION
201	P0554Z0201	CASTING PLUG
202	P0554Z0202	GEARBOX CASTING
203	P0554Z0203	TOP LEFT GEARBOX COVER
204	PFH19M	FLAT HD SCR M4-.7 X 10
205	P0554Z0205	TOP RIGHT GEARBOX COVER
206	P0554Z0206	TOP FRONT GEARBOX COVER
207	PSB40M	CAP SCREW M8-1.25 X 35
208	P0554Z0208	CONTROL PANEL HOUSING
209	PS12M	PHLP HD SCR M3-.5 X 6
210	P0554Z0210	CONTROL PANEL FRONT COVER
211	P0554Z0211	GASKET
212	PSB12M	CAP SCREW M8-1.25 X 40
213	PSB31M	CAP SCREW M8-1.25 X 25
215	P0554Z0215	PIN 5 X 28
216	P0554Z0216	GEAR 16T
217	PR79M	INT RETAINING RING 19MM
218	P0554Z0218	BALL BEARING 619/8/P5
219	P0554Z0219	SHAFT
220	P0554Z0220	OIL DRAIN PLUG
221	P0554Z0221	SHIFTER
222	P0554Z0222	SHAFT
223	PSS03M	SET SCREW M6-1 X 8
224	PSB02M	CAP SCREW M6-1 X 20
225	P0554Z0225	RACK
226	P0554Z0226	SHIFT KEY
227	P0554Z0227	SHIFT FORK
228	PSS03M	SET SCREW M6-1 X 8
229	P0554Z0229	SHAFT
230	P0554Z0230	LOCATING PLATE
231	P0554Z0231	CONTROL PLATE
232	PSB26M	CAP SCREW M6-1 X 12
233	P0554Z0233	OIL FILL PLUG

REF	PART #	DESCRIPTION
234	P0554Z0234	SHIFT HUB
235	PK05M	KEY 4 X 4 X 10
236	P0554Z0236	SHAFT
238	P0554Z0238	GEAR SHAFT 26T
239	P0554Z0239	SHIFT FORK
240	P0554Z0240	SHIFT ARM
241	P0554Z0241	PIN 5 X 20
242	P0554Z0242	SHAFT
243	P0554Z0243	GEARBOX FRONT COVER
244	P0554Z0244	LOCATING DISK
245	PFH07M	FLAT HD SCR M5-.8 X 10
247	P0554Z0247	SHIFT HUB
249	P0554Z0249	SPECIAL WASHER
250	PSB01M	CAP SCREW M6-1 X 16
251	P0554Z0251	INDICATOR DISK
252	PS12M	PHLP HD SCR M3-.5 X 6
253	P0554Z0253	INDICATOR DISK
254	PSS20M	SET SCREW M8-1.25 X 8
255	P0554Z0255	COMPRESSION SPRING
256	P0554Z0256	STEEL BALL 6.5MM
257	P0554Z0257	LOCATING DISK
258	P0554Z0258	OIL SIGHT GLASS
259	P0554Z0259	LOCATING DISK
260	P0554Z0260	SHIFT HUB
261	PSB48M	CAP SCREW M6-1 X 35
321	P0554Z0321	OIL DRAIN PIPE
327	P0554Z0327	SPECIAL O-RING
328	P0554Z0328	STOP BUTTON ASSEMBLY
329	P0554Z0329	JOG BUTTON ASSEMBLY
330	P0554Z0330	110V POWER LAMP BULB
331	P0554Z0331	POWER LAMP ASSEMBLY
332	P0554Z0332	COOLANT SWITCH ASSEMBLY



Gearbox Gearing Breakdown



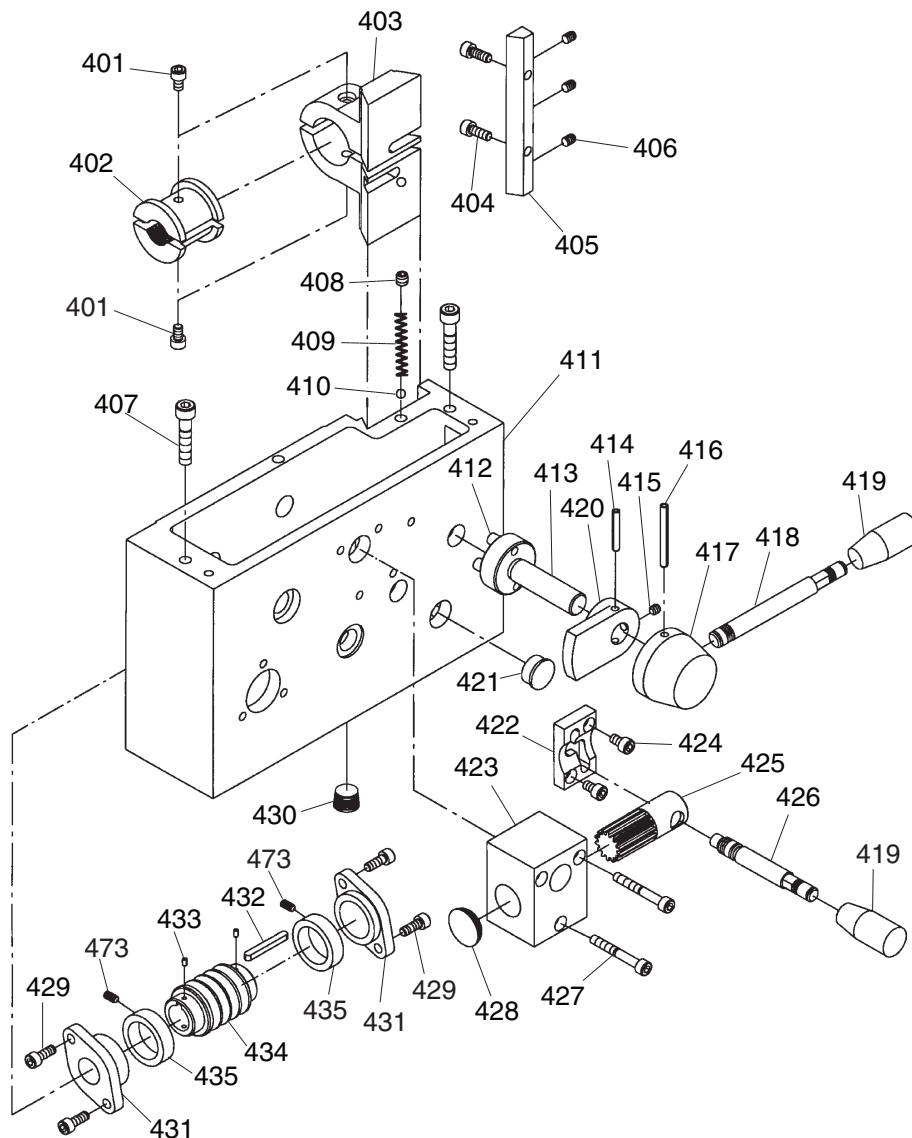
Gearbox Gearing Parts List

REF	PART #	DESCRIPTION
250	PSB01M	CAP SCREW M6-1 X 16
262	P0554Z0262	SPECIAL FLAT WASHER
263	P0554Z0263	GEAR 52T
264	PSB02M	CAP SCREW M6-1 X 20
265	P0554Z0265	END CAP
266	P0554Z0266	GASKET
267	P0554Z0149	BALL BEARING 6004/P5
268	PK19M	KEY 5 X 5 X 14
269	P0554Z0269	GEAR SHAFT
270	P0554Z0270	BALL BEARING 16002/P5
271	P0554Z0271	SHAFT COLLAR
272	PK120M	KEY 5 X 5 X 75
273	P0554Z0273	SHAFT
274	P0554Z0274	SHAFT COLLAR
275	P0554Z0275	BALL BEARING 6003/P5
276	PR09M	EXT RETAINING RING 20MM
277	P0554Z0277	GEAR 16T/32T
278	P0554Z0278	BALL BEARING 6202/P5
279	P0554Z0279	GASKET
280	P0554Z0280	END CAP
281	P0554Z0281	GEAR 28T
282	P0554Z0282	GEAR WASHER
283	P0554Z0283	GEAR 26T
284	P0554Z0284	GEAR WASHER
285	P0554Z0285	GEAR 24T
286	P0554Z0286	GEAR WASHER
287	P0554Z0287	GEAR 23T
288	P0554Z0288	GEAR WASHER
289	P0554Z0289	GEAR 22T
290	P0554Z0290	GEAR WASHER
291	P0554Z0291	GEAR 20T
292	P0554Z0292	GEAR WASHER
293	P0554Z0293	GEAR 18T

REF	PART #	DESCRIPTION
294	P0554Z0294	GEAR WASHER
295	P0554Z0295	GEAR 16T
296	P0554Z0296	GEAR 26T
297	P0554Z0297	SPLINE SHAFT
298	PK19M	KEY 5 X 5 X 14
299	PK101M	KEY 6 X 6 X 14
300	PR29M	INT RETAINING RING 32MM
301	P0554Z0301	BALL BEARING 61804/P5
302	P0554Z0302	GEAR 16T
303	P0554Z0303	SPACER
304	P0554Z0304	GEAR 21T
305	PR05M	EXT RETAINING RING 15MM
306	P0554Z0306	GEAR 26T
307	P0554Z0307	GASKET
308	P0554Z0308	END CAP
309	P40021104B	O-RING 15 X 2.65
310	P0554Z0310	BALL BEARING 8104/P5
311	P0554Z0311	COLLAR
312	P0554Z0312	SHAFT
313	P0554Z0313	SHAFT
314	P0554Z0314	END CAP
315	P0554Z0315	GASKET
316	P0554Z0316	SPECIAL HEX NUT
317	P0554Z0317	GEAR 32T
318	P0554Z0318	COLLAR
319	P0554Z0319	GEAR 16T
320	PR07M	EXT RETAINING RING 18MM
322	P0554Z0322	PIN 5 X 40
323	P0554Z0323	SHAFT SLEEVE
324	P0554Z0324	COLLAR
325	P0554Z0325	PIN 4 X 30
326	P0554Z0326	SHAFT SLEEVE



Apron Controls

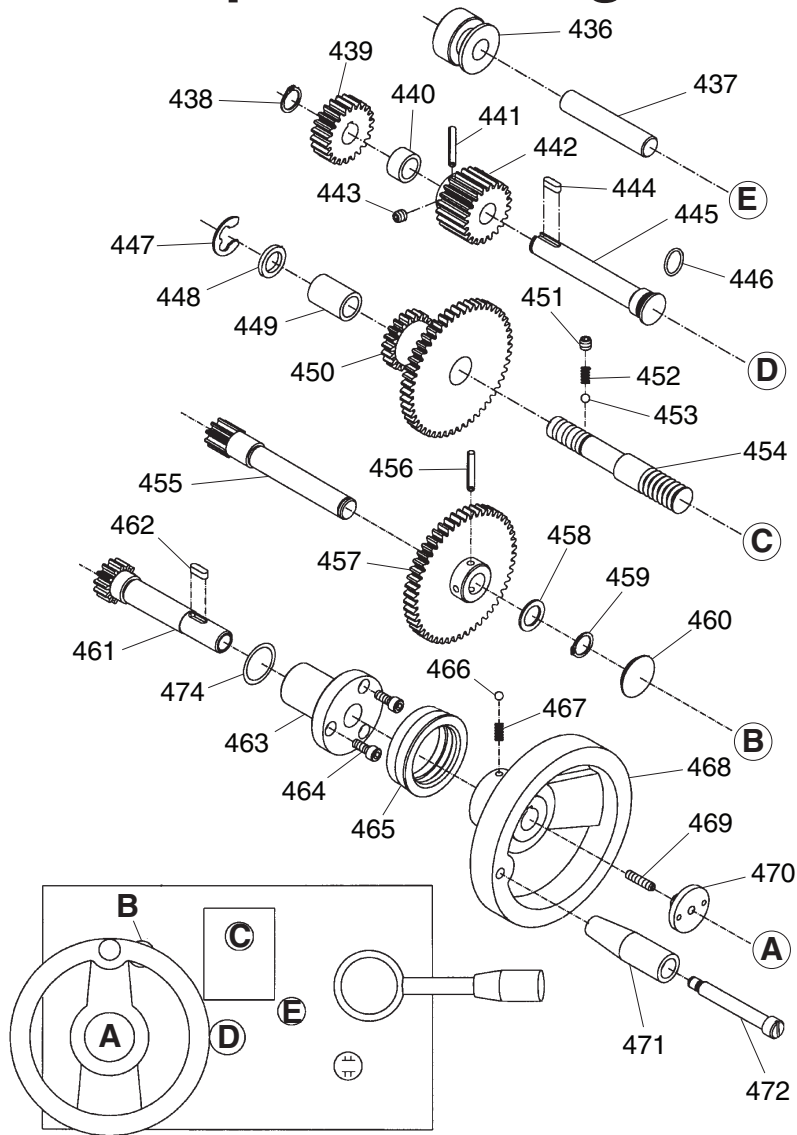


REF	PART #	DESCRIPTION
401	PSB04M	CAP SCREW M6-1 X 10
402	P0554Z0402	HALF-NUT ASSEMBLY
403	P0554Z0403	HALF-NUT BRACKET
404	PSB01M	CAP SCREW M6-1 X 16
405	P0554Z0405	HALF-NUT GIB
406	PSS01M	SET SCREW M6-1 X 10
407	PSB12M	CAP SCREW M8-1.25 X 40
408	PSS20M	SET SCREW M8-1.25 X 8
409	P0554Z0409	COMPRESSION SPRING
410	P0554Z0410	STEEL BALL 6MM
411	P0554Z0411	APRON CASTING
412	P0554Z0412	SPECIAL PIN
413	P0554Z0413	HALF-NUT CAM
414	P0554Z0414	PIN 5 X 35
415	PSS02M	SET SCREW M6-1 X 6
416	P0554Z0416	PIN 5 X 50
417	P0554Z0417	HANDLE HUB
418	P0554Z0418	HANDLE LEVER
419	P0554Z0419	HANDLE KNOB
420	P0554Z0420	SAFETY CATCH
421	P0554Z0421	OIL SIGHT GLASS
422	P0554Z0422	BRACKET
423	P0554Z0423	BLOCK
424	PSB26M	CAP SCREW M6-1 X 12
425	P0554Z0425	SPLINE SHAFT
426	P0554Z0426	HANDLE LEVER
427	PSB30M	CAP SCREW M6-1 X 45
428	P0554Z0428	PLUG
429	PSB01M	CAP SCREW M6-1 X 16
430	P0554Z0430	OIL DRAIN PLUG
431	P0554Z0431	END CAP
432	PK119M	KEY 5 X 5 X 56
433	P0554Z0433	PIN 3 X 5
434	P0554Z0434	WORM
435	P0554Z0435	LOCK COLLAR
473	PSS05M	SET SCREW M5-.8 X 10

REF	PART #	DESCRIPTION
419	P0554Z0419	HANDLE KNOB
420	P0554Z0420	SAFETY CATCH
421	P0554Z0421	OIL SIGHT GLASS
422	P0554Z0422	BRACKET
423	P0554Z0423	BLOCK
424	PSB26M	CAP SCREW M6-1 X 12
425	P0554Z0425	SPLINE SHAFT
426	P0554Z0426	HANDLE LEVER
427	PSB30M	CAP SCREW M6-1 X 45
428	P0554Z0428	PLUG
429	PSB01M	CAP SCREW M6-1 X 16
430	P0554Z0430	OIL DRAIN PLUG
431	P0554Z0431	END CAP
432	PK119M	KEY 5 X 5 X 56
433	P0554Z0433	PIN 3 X 5
434	P0554Z0434	WORM
435	P0554Z0435	LOCK COLLAR
473	PSS05M	SET SCREW M5-.8 X 10



Apron Gearing

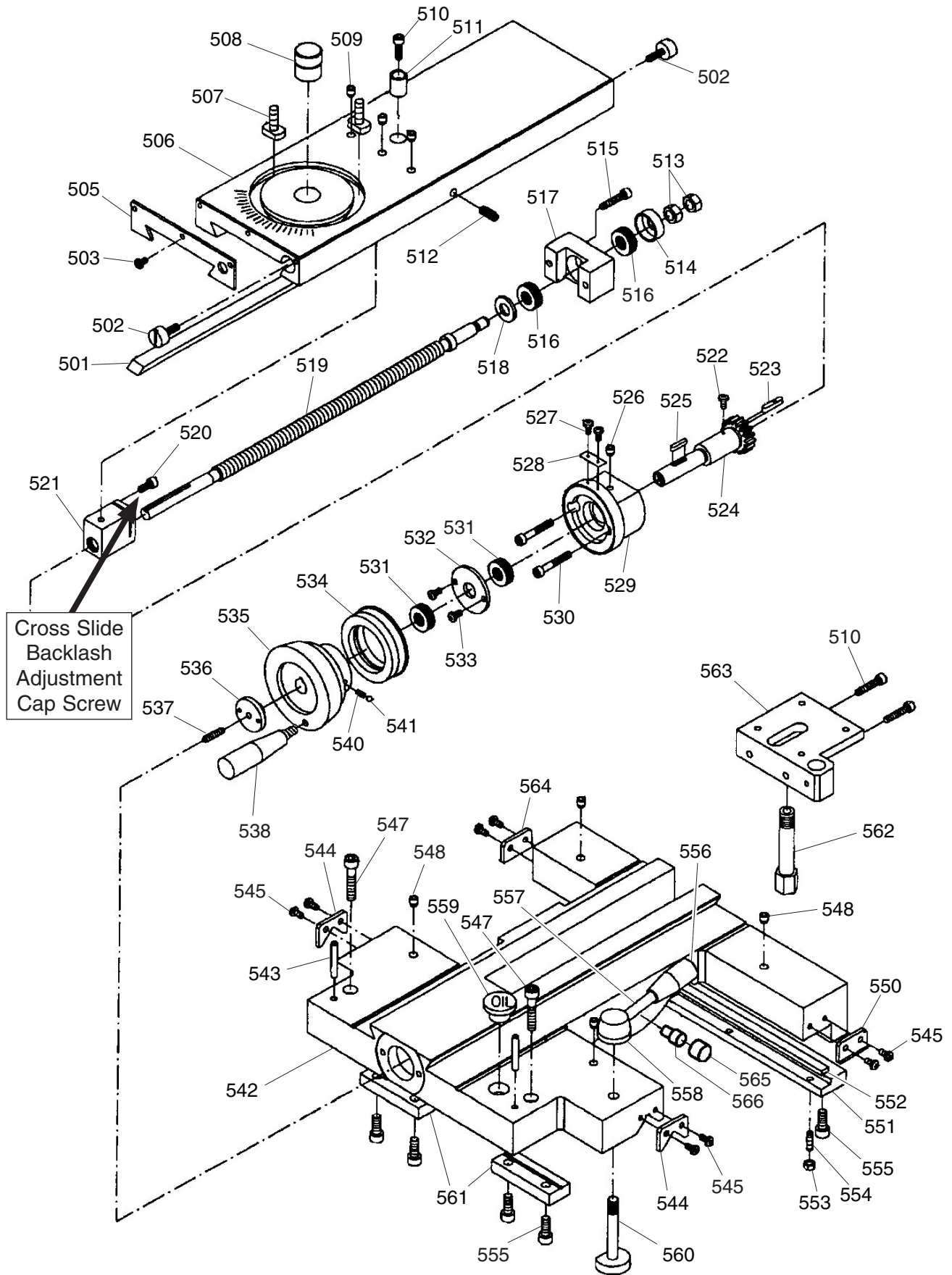


REF	PART #	DESCRIPTION
436	P0554Z0436	BUSHING
437	P0554Z0437	SHAFT
438	PR06M	EXT RETAINING RING 16MM
439	P0554Z0439	GEAR 22T
440	P0554Z0440	COLLAR
441	P0554Z0441	PIN 5 X 35
442	P0554Z0442	GEAR 24T
443	PSS02M	SET SCREW M6-1 X 6
444	PK20M	KEY 5 X 5 X 15
445	P0554Z0445	SHAFT
446	P0554Z0446	O-RING 17 X 1.8
447	PEC12M	E-CLIP 12MM
448	P0554Z0448	BUSHING
449	P0554Z0449	SLEEVE
450	P0554Z0450	CLUSTER GEAR 50T/20T
451	PSS20M	SET SCREW M8-1.25 X 8
452	P0554Z0452	COMPRESSION SPRING
453	P0554Z0410	STEEL BALL 6MM
454	P0554Z0454	SHAFT

REF	PART #	DESCRIPTION
455	P0554Z0455	SHAFT
456	P0554Z0456	PIN 5 X 30
457	P0554Z0457	GEAR 50T
458	P0554Z0458	SPACER
459	PR06M	EXT RETAINING RING 16MM
460	P0554Z0460	PLUG
461	P0554Z0461	GEAR SHAFT 18T
462	PK20M	KEY 5 X 5 X 15
463	P0554Z0463	WHEEL FLANGE
464	PSB01M	CAP SCREW M6-1 X 16
465	P0554Z0465	GRADUATED DIAL
466	P0554Z0410	STEEL BALL 6MM
467	P0554Z0467	COMPRESSION SPRING
468	P0554Z0468	HANDWHEEL
469	PSS12M	SET SCREW M6-1 X 25
470	P0554Z0470	HANDWHEEL SCREW
471	P0554Z0471	HANDLE
472	P0554Z0472	HANDLE SCREW
474	P05094038	O-RING 25.8 X 3.55



Saddle & Cross Slide Breakdown



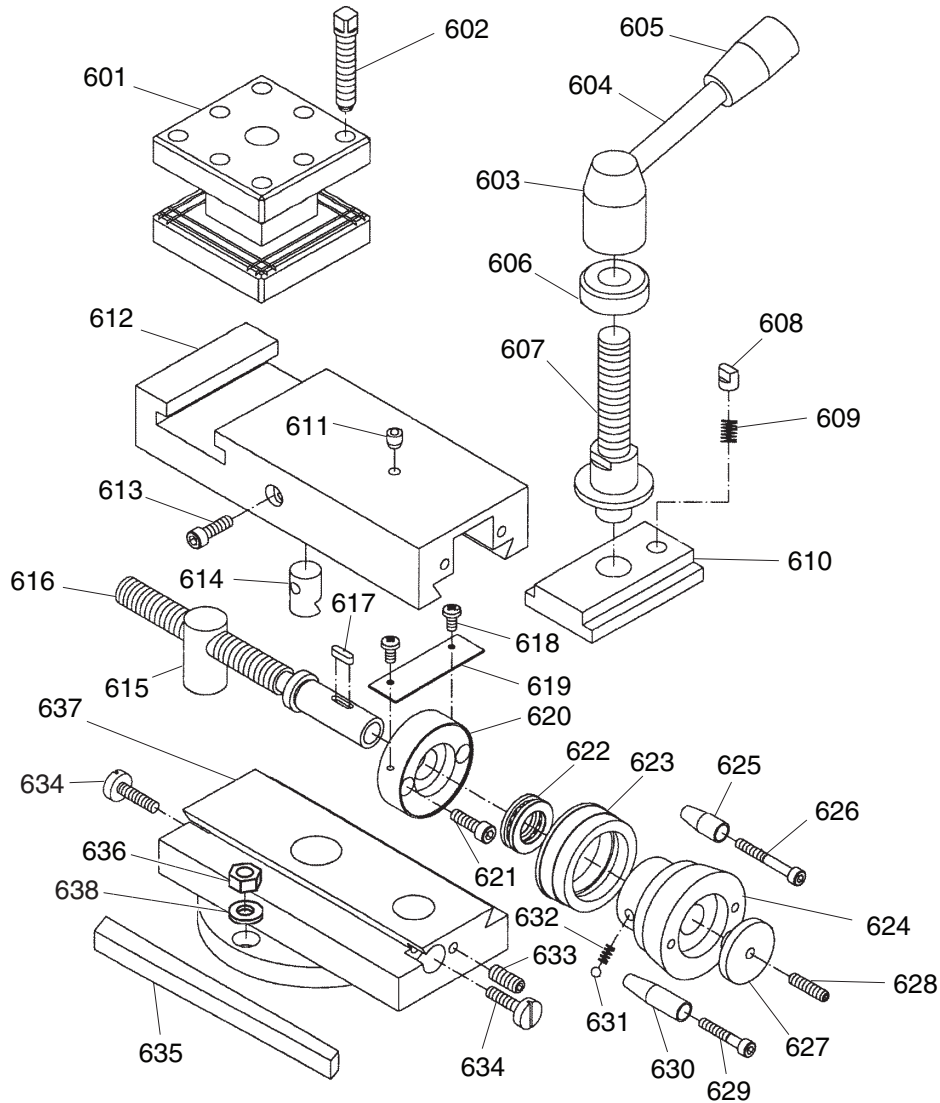
Saddle & Cross Slide Parts List

REF	PART #	DESCRIPTION
501	P0554Z0501	CROSS SLIDE GIB
502	P0554Z0502	GIB ADJUSTMENT SCREW
503	PS09M	PHLP HD SCR M5-.8 X 10
505	P0554Z0505	WIPER PLATE
506	P0554Z0506	CROSS SLIDE BODY
507	P0554Z0507	T-BOLT
508	P0554Z0508	HUB
509	P0554Z0509	BALL OILER 8MM
510	PSB02M	CAP SCREW M6-1 X 20
511	P0554Z0511	SLEEVE
512	PSS20M	SET SCREW M8-1.25 X 8
513	PN02M	HEX NUT M10-1.5
514	P0554Z0514	BEARING CAP
515	PSB07M	CAP SCREW M6-1 X 30
516	P8101	THRUST BEARING 8101
517	P0554Z0517	BLOCK
518	P0554Z0518	SPACER
519	P0554Z0519	CROSS SLIDE LEADSCREW
520	PSB26M	CAP SCREW M6-1 X 12
521	P0554Z0521	LEADSCREW NUT
522	PS49M	PHLP HD SCR M3-.5 X 5
523	PK23M	KEY 5 X 5 X 25
524	P0554Z0524	GEAR SHAFT 20T
525	PK48M	KEY 4 X 4 X 20
526	P0554Z0526	BALL OILER 6MM
527	PS12M	PHLP HD SCR M3-.5 X 6
528	P0554Z0528	INDEX PLATE
529	P0554Z0529	BEARING HOUSING
530	PSB29M	CAP SCREW M6-1 X 40
531	P8102	THRUST BEARING 8102
532	P0554Z0532	END CAP

REF	PART #	DESCRIPTION
533	PS09M	PHLP HD SCR M5-.8 X 10
534	P0554Z0534	GRADUATED DIAL
535	P0554Z0535	HANDWHEEL
536	P0554Z0536	HANDWHEEL SCREW
537	PSS12M	SET SCREW M6-1 X 25
538	P0554Z0538	HANDLE
540	P0554Z0540	COMPRESSION SPRING
541	P0554Z0410	STEEL BALL 6MM
542	P0554Z0542	SADDLE
543	P0554Z0543	PIN 6 X 40
544	P0554Z0544	WIPER PLATE
545	PS09M	PHLP HD SCR M5-.8 X 10
547	PSB45M	CAP SCREW M8-1.25 X 45
548	P0554Z0509	BALL OILER 8MM
550	P0554Z0550	WIPER PLATE
551	P0554Z0551	REAR PRESSURE PLATE
552	P0554Z0552	SADDLE GIB
553	PLN03M	LOCK NUT M6-1
554	PSS25M	SET SCREW M6-1 X 20
555	PSB14M	CAP SCREW M8-1.25 X 20
556	P0554Z0556	HANDLE KNOB M10-1.5
557	P0554Z0557	HANDLE LEVER
558	P0554Z0558	HANDLE HUB
559	P0554Z0559	OIL FILL CAP
560	P0554Z0560	LOCK STUD
561	P0554Z0561	FRONT PRESSURE PLATE
562	P0554Z0562	STRAIN RELIEF
563	P0554Z0563	LAMP BRACKET
564	P0554Z0564	WIPER PLATE
565	P0554Z0565	SPECIAL PIN
566	P0554Z0566	SLEEVE



Compound Slide & Tool Post

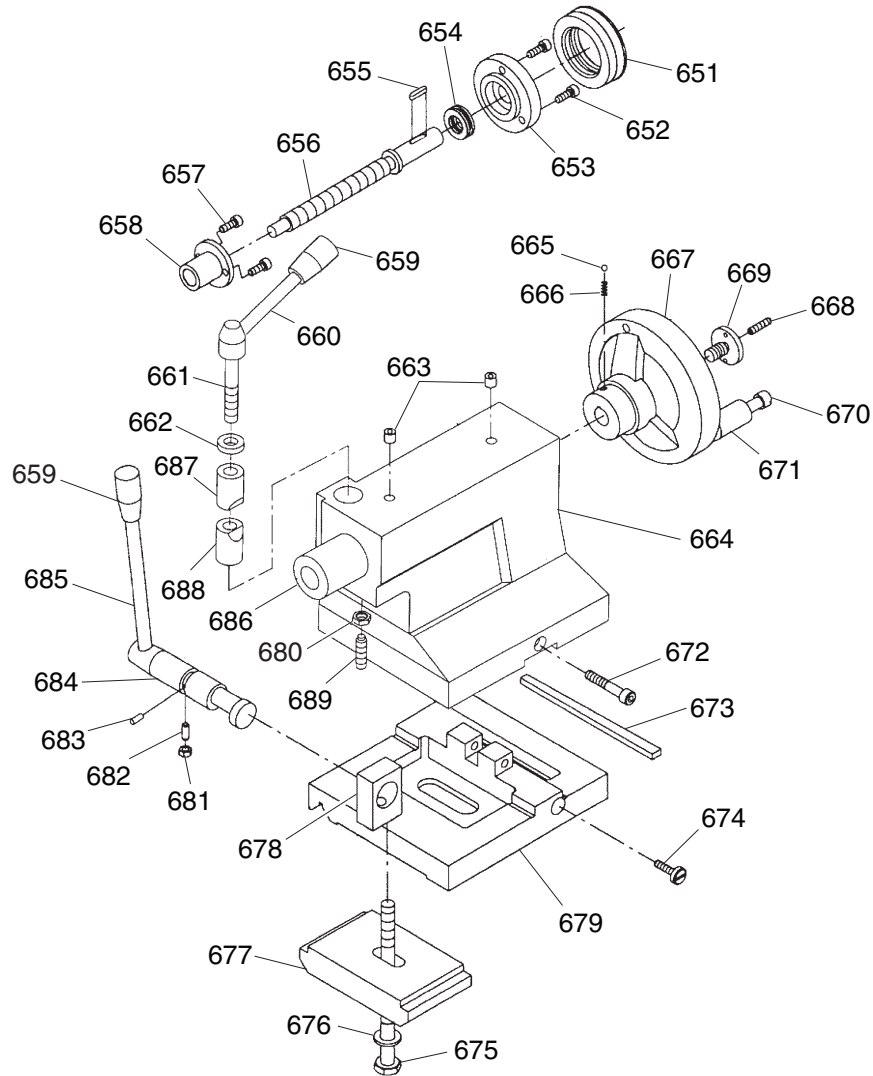


REF	PART #	DESCRIPTION
601	P0554Z0601	TOOL POST BASE
602	P0554Z0602	TOOL POST LOCK SCREW
603	P0554Z0603	HANDLE HUB
604	P0554Z0604	HANDLE LEVER
605	P0554Z0605	HANDLE KNOB
606	P0554Z0606	SPACER
607	P0554Z0607	TOOL POST STUD
608	P0554Z0608	TOOL POST POSITION PIN
609	P0554Z0609	COMPRESSION SPRING
610	P0554Z0610	CLAMP BAR
611	P0554Z0509	BALL OILER 8MM
612	P0554Z0612	COMPOUND SLIDE
613	PSB02M	CAP SCREW M6-1 X 20
614	P0554Z0614	POSITIONING PIN
615	P0554Z0615	LEADSCREW NUT
616	P0554Z0616	COMPOUND SLIDE LEADSCREW
617	PK134M	KEY 4 X 4 X 14
618	PS12M	PHLP HD SCR M3-.5 X 6
619	P0554Z0619	INDEX PLATE

REF	PART #	DESCRIPTION
620	P0554Z0620	BEARING HOUSING
621	PSB02M	CAP SCREW M6-1 X 20
622	P8103	THRUST BEARING 8103
623	P0554Z0623	GRADUATED DIAL
624	P0554Z0624	HANDWHEEL
625	P0554Z0625	HANDLE
626	PSB38M	CAP SCREW M5-.8 X 25
627	P0554Z0627	HANDWHEEL SCREW
628	PSS12M	SET SCREW M6-1 X 25
629	PSB78M	CAP SCREW M5-.8 X 40
630	P0554Z0630	HANDLE
631	P0554Z0410	STEEL BALL 6MM
632	P0554Z0632	COMPRESSION SPRING
633	PSS11M	SET SCREW M6-1 X 16
634	P0554Z0634	GIB ADJUSTMENT SCREW
635	P0554Z0635	COMPOUND SLIDE GIB
636	PN03M	HEX NUT M8-1.25
637	P0554Z0637	SWIVEL SLIDE
638	PW01M	FLAT WASHER 8MM



Tailstock

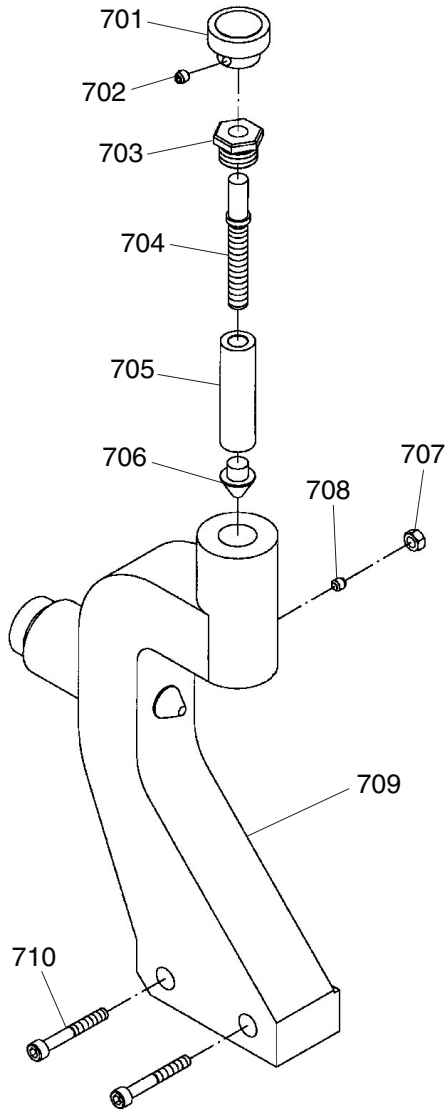


REF	PART #	DESCRIPTION
651	P0554Z0651	GRADUATED DIAL
652	PSB02M	CAP SCREW M6-1 X 20
653	P0554Z0653	BEARING HOUSING
654	P8103	THRUST BEARING 8103
655	PK48M	KEY 4 X 4 X 20
656	P0554Z0656	TAILSTOCK LEADSCREW
657	PSB01M	CAP SCREW M6-1 X 16
658	P0554Z0658	LEADSCREW NUT
659	P0554Z0659	HANDLE KNOB
660	P0554Z0660	HANDLE LEVER
661	P0554Z0661	HANDLE BOLT
662	P0554Z0662	SPACER
663	P0554Z0663	BALL OILER 10MM
664	P0554Z0664	TAILSTOCK CASTING
665	P0554Z0410	STEEL BALL 6MM
666	P0554Z0666	COMPRESSION SPRING
667	P0554Z0667	HANDWHEEL
668	PSS28M	SET SCREW M6-1 X 30
669	P0554Z0669	HANDWHEEL SCREW
670	P0554Z0670	HANDLE SCREW

REF	PART #	DESCRIPTION
671	P0554Z0671	HANDLE
672	PSB128M	CAP SCREW M8-1.25 X 70
673	P0554Z0673	TAILSTOCK GIB
674	P0554Z0674	GIB ADJUSTMENT SCREW
675	PB140M	HEX BOLT M12-1.75 X 70
676	PW06M	FLAT WASHER 12MM
677	P0554Z0677	CLAMP PLATE
678	P0554Z0678	BLOCK
679	P0554Z0679	TAILSTOCK BASE
680	PN02M	HEX NUT M10-1.5
681	PN01M	HEX NUT M6-1
682	PSS11M	SET SCREW M6-1 X 16
683	P0554Z0683	PIN 5 X 10
684	P0554Z0684	ECCENTRIC SHAFT
685	P0554Z0685	LOCK LEVER
686	P0554Z0686	TAILSTOCK QUILL
687	P0554Z0687	UPPER CLAMPING SLEEVE
688	P0554Z0688	LOWER CLAMPING SLEEVE
689	PSS95M	SET SCREW M10-1.5 X 40

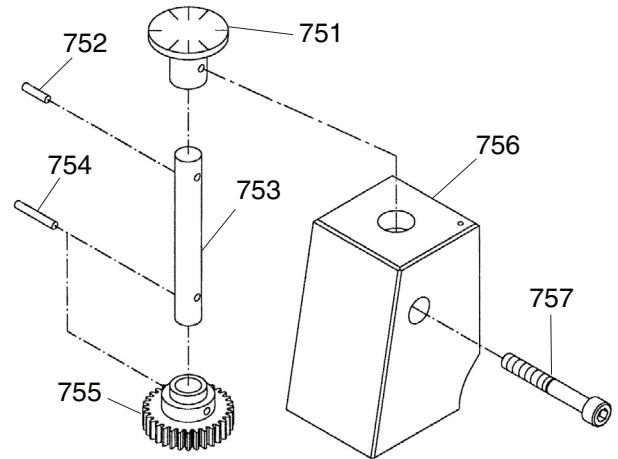


Follow Rest



REF	PART #	DESCRIPTION
701	P0554Z0701	ADJUSTMENT KNOB
702	PSS02M	SET SCREW M6-1 X 6
703	P0554Z0703	BUSHING
704	P0554Z0704	SPECIAL SCREW
705	P0554Z0705	SLEEVE
706	P0554Z0706	BRASS FINGER
707	PN01M	HEX NUT M6-1
708	PSS02M	SET SCREW M6-1 X 6
709	P0554Z0709	FOLLOW REST CASTING
710	PSB30M	CAP SCREW M6-1 X 45

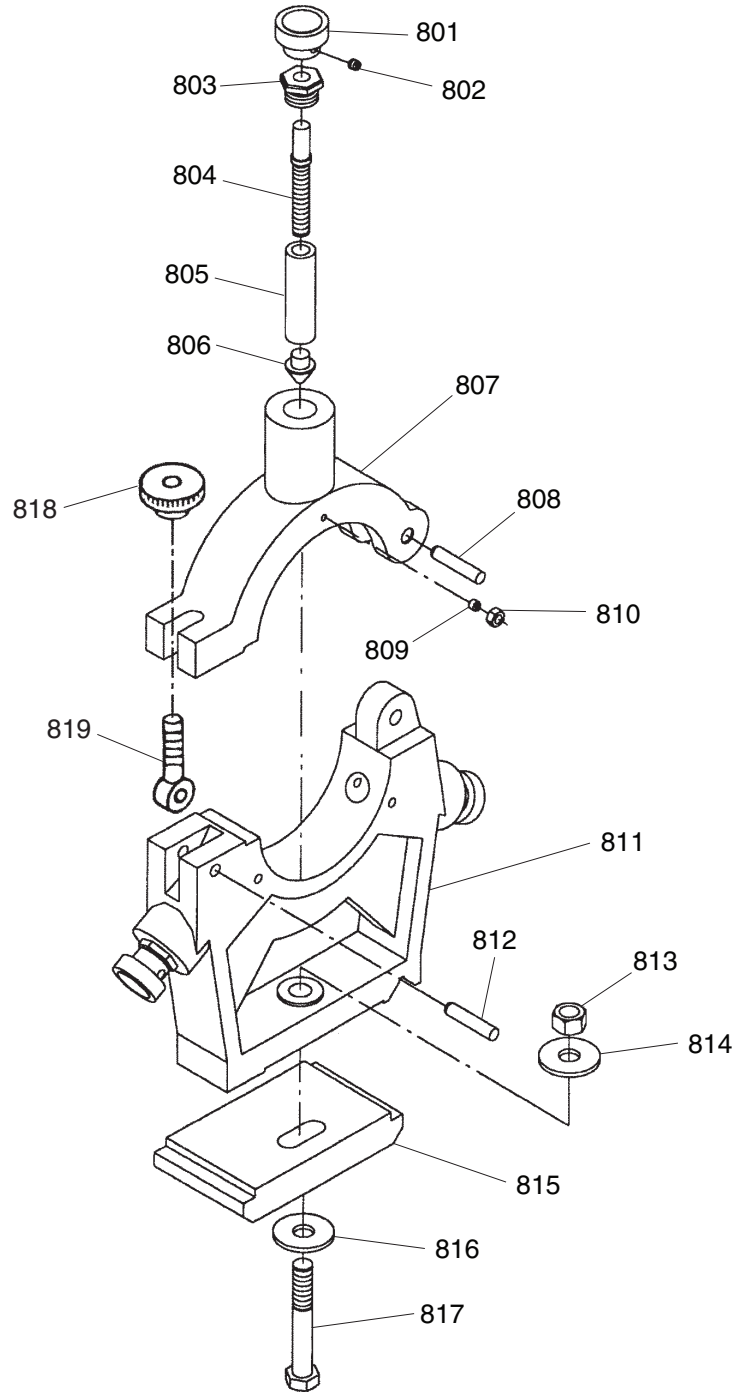
Thread Dial



REF	PART #	DESCRIPTION
751	P0554Z0751	DIAL
752	P0554Z0752	PIN 3 X 12
753	P0554Z0753	SHAFT
754	P0554Z0754	PIN 3 X 20
755	P0554Z0755	GEAR 32T
756	P0554Z0756	THREAD DIAL BODY
757	PSB30M	CAP SCREW M6-1 X 45



Steady Rest

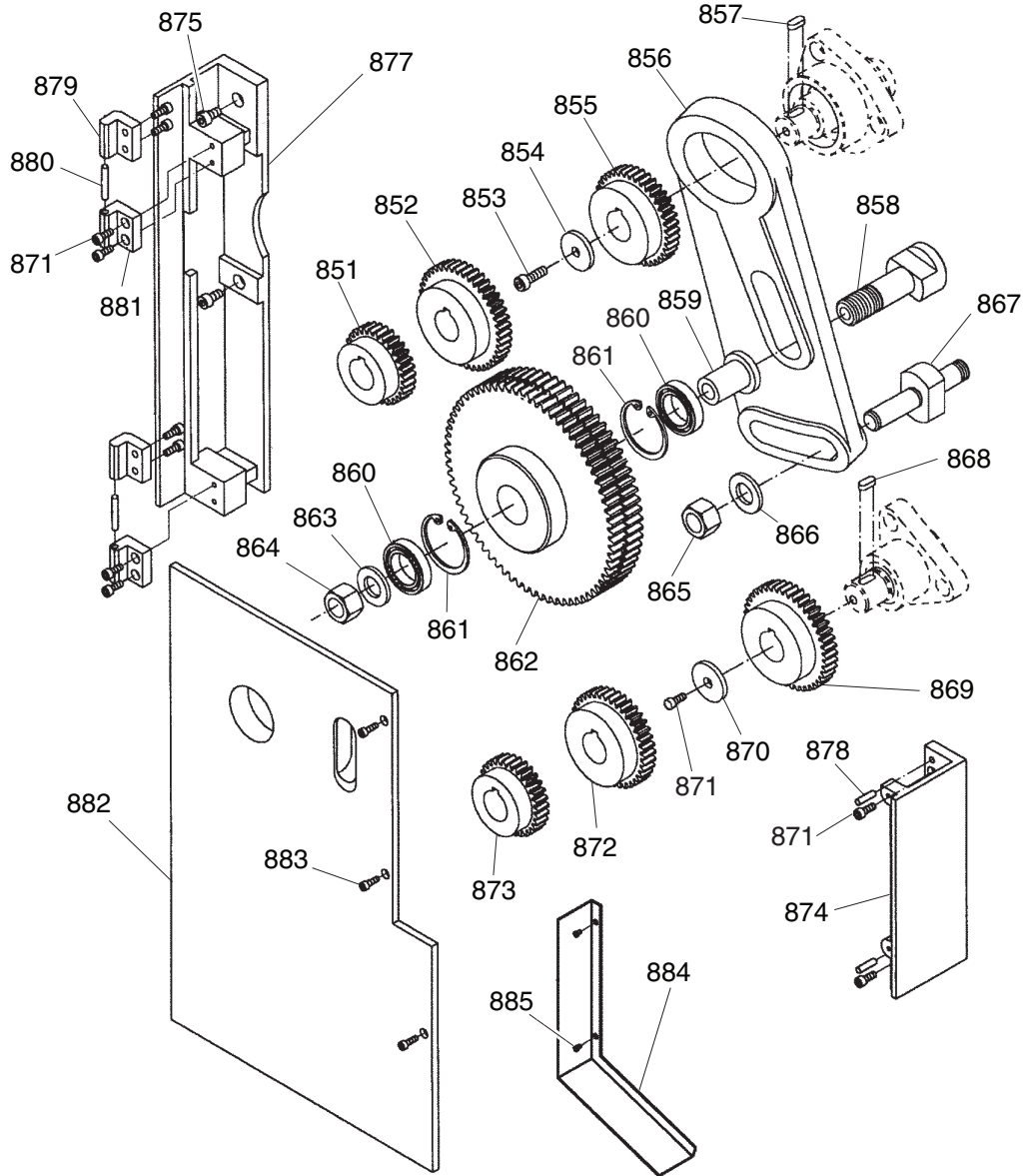


REF	PART #	DESCRIPTION
801	P0554Z0701	ADJUSTMENT KNOB
802	PSS02M	SET SCREW M6-1 X 6
803	P0554Z0803	BUSHING
804	P0554Z0804	ADJUSTMENT SCREW
805	P0554Z0805	SLEEVE
806	P0554Z0706	BRASS FINGER
807	P0554Z0807	UPPER STEADY REST CASTING
808	P0554Z0808	PIN 8 X 40
809	PSS25M	SET SCREW M6-1 X 20
810	PN01M	HEX NUT M6-1

REF	PART #	DESCRIPTION
811	P0554Z0811	LOWER STEADY REST CASTING
812	P0554Z0812	LOCK PIN
813	PN09M	HEX NUT M12-1.75
814	PW06M	FLAT WASHER 12MM
815	P0554Z0815	CLAMP PLATE
816	PW06M	FLAT WASHER 12MM
817	PB141M	HEX BOLT M12-1.75 X 80
818	P0554Z0818	KNURLED KNOB
819	P0554Z0819	LOCK BOLT



Change & End Gears

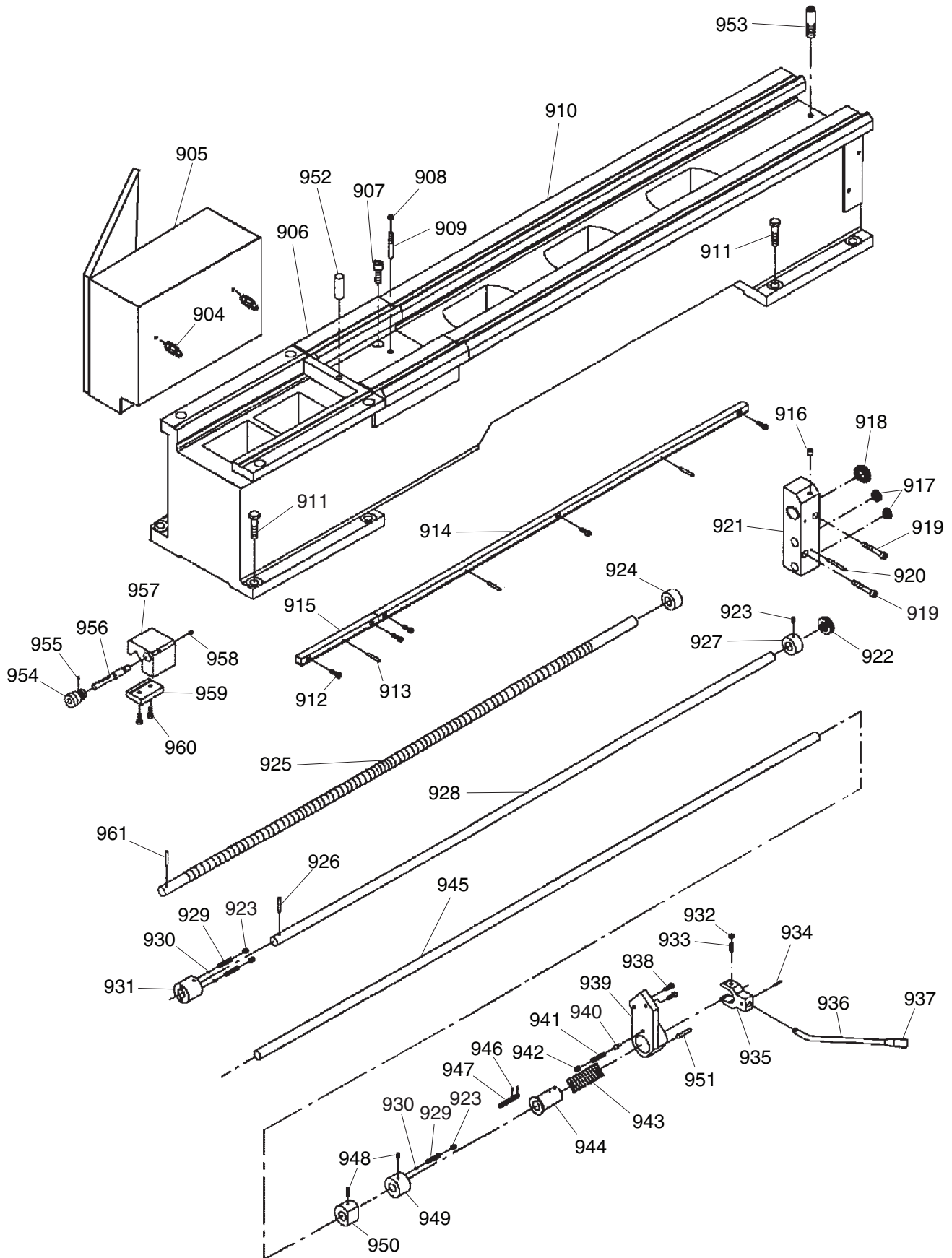


REF	PART #	DESCRIPTION
851	P0554Z0851	GEAR 30T
852	P0554Z0852	GEAR 40T
853	PSB24M	CAP SCREW M5-.8 X 16
854	P0554Z0854	SPECIAL WASHER
855	P0554Z0855	GEAR 25T
856	P0554Z0856	PIVOT ARM
857	PK19M	KEY 5 X 5 X 14
858	P0554Z0858	THREADED SHAFT
859	P0554Z0859	SLEEVE
860	P6103ZZ	BALL BEARING 6103ZZ
861	PR21M	INT RETAINING RING 35MM
862	P0554Z0862	GEAR 120T/127T
863	PW04M	FLAT WASHER 10MM
864	PN02M	HEX NUT M10-1.5
865	PN09M	HEX NUT M12-1.75
866	PW06M	FLAT WASHER 12MM
867	P0554Z0867	THREADED STUD

REF	PART #	DESCRIPTION
868	PK19M	KEY 5 X 5 X 14
869	P0554Z0869	GEAR 50T
870	P0554Z0870	SPECIAL FLAT WASHER
871	PSB01M	CAP SCREW M6-1 X 16
872	P0554Z0872	GEAR 32T
873	P0554Z0873	GEAR 40T
874	P0554Z0874	FRONT COVER
875	PSB02M	CAP SCREW M6-1 X 20
877	P0554Z0877	DOOR BRACKET
878	P0554Z0878	PIN 6 X 25
879	P0554Z0879	UPPER HINGE
880	P0554Z0880	HINGE PIN
881	P0554Z0881	LOWER HINGE
882	P0554Z0882	SIDE DOOR
883	PSB50M	CAP SCREW M5-.8 X 10
884	P0554Z0884	BRACKET
885	PS03M	PHLP HD SCR M6-1 X 8



Bed & Shaft Breakdown



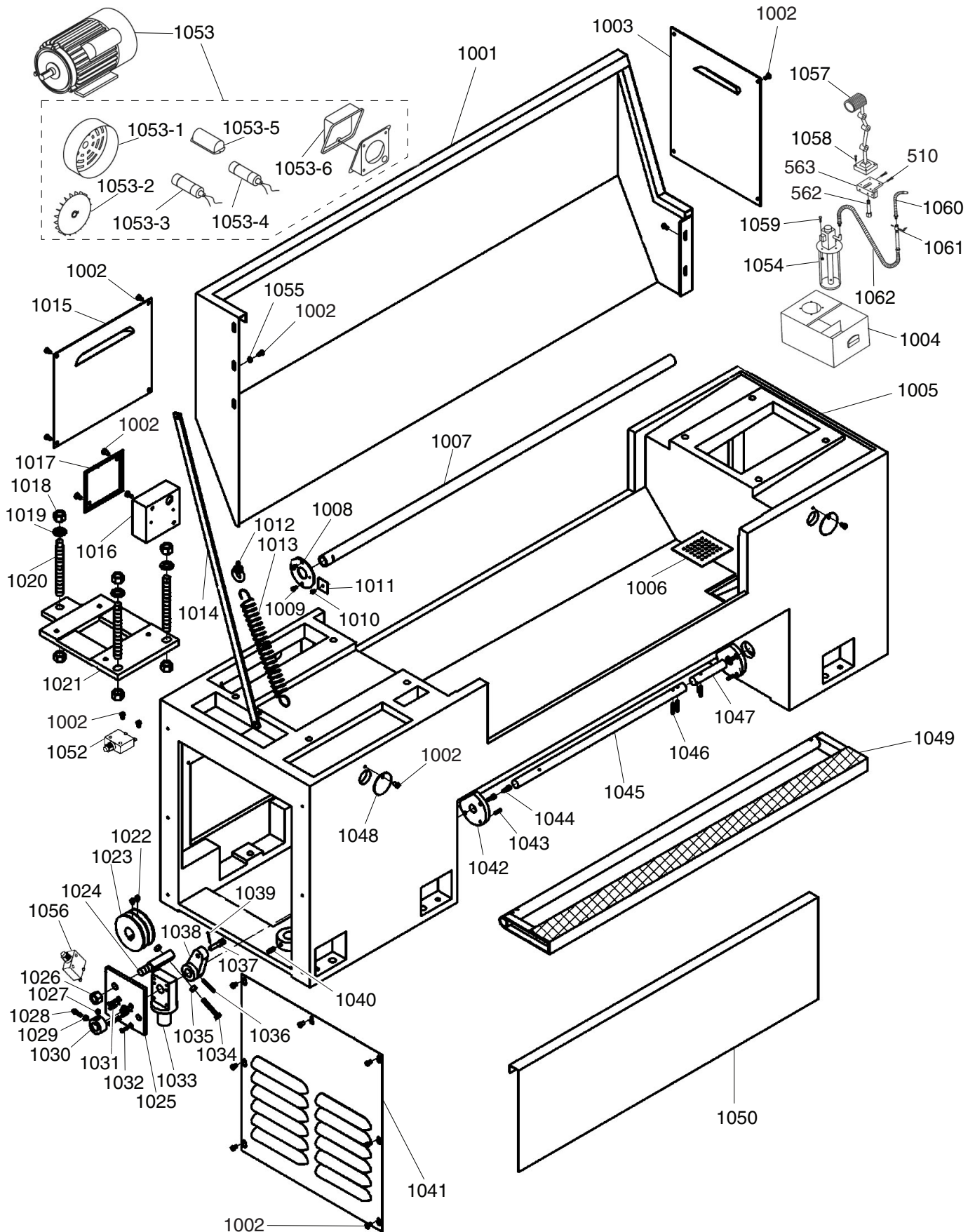
Bed & Shaft Parts List

REF	PART #	DESCRIPTION
904	P0554Z0904	THREADED STUD
905	P0554Z0905	ELECTRICAL BOX
906	P0554Z0906	GAP
907	PSB47M	CAP SCREW M10-1.5 X 40
908	PN03M	HEX NUT M8-1.25
909	P0554Z0909	THREADED PIN M8-1.25
910	P0554Z0910	BED
911	PB51M	HEX BOLT M16-2 X 50
912	PSB06M	CAP SCREW M6-1 X 25
913	P0554Z0913	PIN 6 X 35
914	P0554Z0914	LONG RACK
915	P0554Z0915	SHORT RACK
916	P0554Z0663	BALL OILER 10MM
917	P0554Z0917	PLUG
918	P0554Z0918	PLUG
919	PSB60M	CAP SCREW M8-1.25 X 55
920	P0554Z0920	PIN 8 X 55
921	P0554Z0921	END BRACKET
922	P8104	THRUST BEARING 8104
923	PSS16M	SET SCREW M8-1.25 X 10
924	P0554Z0924	LEADSCREW END BUSHING
925	P0554Z0925	LONGITUDINAL LEADSCREW 7/8-8 X 52
926	P0554Z0926	PIN 5 X 40
927	P0554Z0927	LOCK COLLAR
928	P0554Z0928	FEED ROD
929	P0554Z0929	COMPRESSION SPRING
930	P0554Z0410	STEEL BALL 6MM
931	P0554Z0931	CLUTCH
932	PN01M	HEX NUT M6-1

REF	PART #	DESCRIPTION
933	PSS25M	SET SCREW M6-1 X 20
934	P0554Z0934	PIN 3 X 20
935	P0554Z0935	CONTROL FORK
936	P0554Z0936	CONTROL HANDLE
937	P0554Z0556	HANDLE KNOB M10-1.5
938	PSB01M	CAP SCREW M6-1 X 16
939	P0554Z0939	CONTROL BRACKET
940	P0554Z0410	STEEL BALL 6MM
941	P0554Z0941	COMPRESSION SPRING
942	PSS20M	SET SCREW M8-1.25 X 8
943	P0554Z0943	COMPRESSION SPRING
944	P0554Z0944	SLEEVE
945	P0554Z0945	CONTROL ROD
946	PSS45M	SET SCREW M3-.5 X 6
947	PK24M	KEY 5 X 5 X 37
948	PSS06M	SET SCREW M8-1.25 X 16
949	P0554Z0949	LOCK COLLAR
950	P0554Z0950	SHIFT COLLAR
951	PSS11M	SET SCREW M6-1 X 16
952	P0554Z0952	PIN 16 X 40
953	P0554Z0953	STOP STUD M12-1.75 X 40
954	P0554Z0954	GRADUATED DIAL
955	P0554Z0955	PIN 3 X 6
956	P0554Z0956	SHAFT
957	P0554Z0957	BRACKET
958	PSS01M	SET SCREW M6-1 X 10
959	P0554Z0959	CLAMP PLATE
960	PSB02M	CAP SCREW M6-1 X 20
961	P0554Z0961	SHEAR PIN 5 X 40



Stand & Brake Breakdown



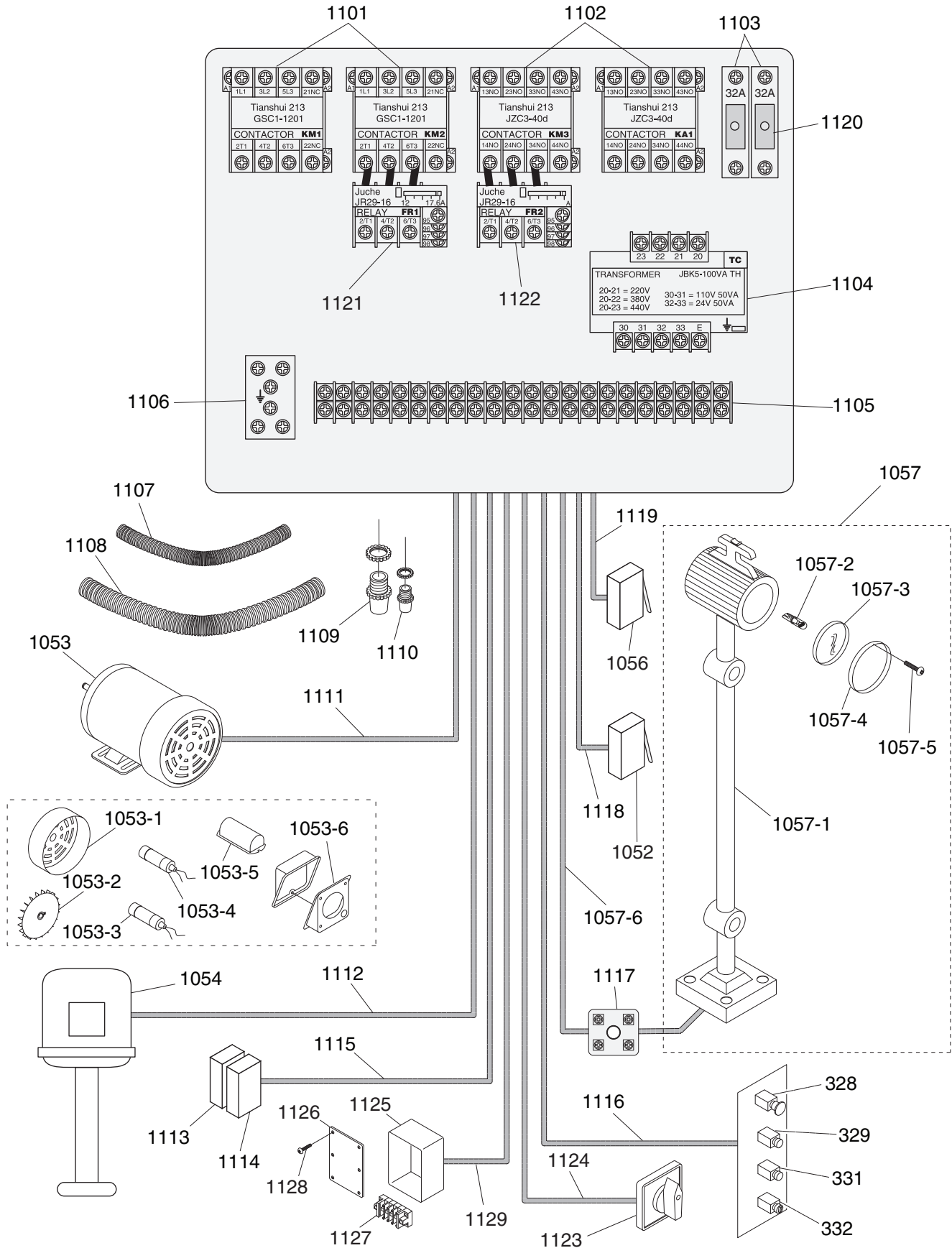
Stand & Brake Parts List

REF	PART #	DESCRIPTION
510	PSB02M	CAP SCREW M6-1 X 20
562	P0554Z0562	STRAIN RELIEF
563	P0554Z0563	LAMP BRACKET
1001	P0554Z1001	SPLASH GUARD
1002	PS68M	PHLP HD SCR M6-1 X 10
1003	P0554Z1003	RIGHT SIDE COVER
1004	P0554Z1004	COOLANT TANK
1005	P0554Z1005	BED STAND
1006	P0554Z1006	COOLANT SCREEN
1007	P0554Z1007	WIRE CONDUIT
1008	P0554Z1008	WIRE CONDUIT SUPPORT
1009	P0554Z1009	PLHP HD SCR M5-.8 X 80
1010	P0554Z1010	PLHP HD SCR M5-.8 X 80
1011	P0554Z1011	LOCKING PLATE
1012	P0554Z1012	EYE BOLT M8-1.25 X 30
1013	P0554Z1013	TENSION SPRING
1014	P0554Z1014	CONNECTING BAR
1015	P0554Z1015	REAR MOTOR COVER
1016	P0554Z1016	TERMINAL BOX
1017	P0554Z1017	TERMINAL BOX COVER
1018	PN13M	HEX NUT M16-2
1019	P0554Z1019	SPECIAL FLAT WASHER 16MM
1020	P0554Z1020	MOTOR BOLT
1021	P0554Z1021	MOTOR MOUNT
1022	PSS14M	SET SCREW M8-1.25 X 12
1023	P0554Z1023	MOTOR PULLEY
1024	P0554Z1024	END ROD SUPPORT
1025	P0554Z1025	MOUNTING PLATE
1026	PN13M	HEX NUT M16-2
1027	PSS16M	SET SCREW M8-1.25 X 10
1028	P0554Z1028	ROD SUPPORT
1029	PN01M	HEX NUT M6-1
1030	P0554Z1030	END NAIL SUPPORT
1031	P0554Z1031	PIN 5 X 20
1032	PS06M	PHLP HD SCR M5-.8 X 20

REF	PART #	DESCRIPTION
1033	P0554Z1033	ADJUSTMENT BRACKET
1034	PS88M	PHLP HD SCR M8-1.25 X 50
1035	PN03M	HEX NUT M8-1.25
1036	P0554Z1036	PIN 5 X 40
1037	P0554Z1037	CONNECTING SHAFT
1038	P0554Z1038	FORK
1039	P0554Z1039	PIN 2 X 20
1040	PSS19M	SET SCREW M8-1.25 X 30
1041	P0554Z1041	LEFT SIDE COVER
1042	P0554Z1042	BRAKE SHAFT SUPPORT
1043	P0554Z1043	PIN 5 X 20
1044	PSB01M	CAP SCREW M6-1 X 16
1045	P0554Z1045	BRAKE SHAFT LONG
1046	P0554Z1046	PIN 5 X 30
1047	P0554Z1047	BRAKE SHAFT SHORT
1048	P0554Z1048	LIFTING HOLE COVER
1049	P0554Z1049	BRAKE PEDAL
1050	P0554Z1050	COOLANT TRAY COVER
1052	P0554Z1052	SIDE DOOR SWITCH
1053	P0554Z1053	MOTOR 3HP 220V 1PH
1053-1	P0554Z1053-1	MOTOR FAN COVER
1053-2	P0554Z1053-2	MOTOR FAN
1053-3	P0554Z1053-3	S CAPACITOR 150M 250V 3" X 2"
1053-4	P0554Z1053-4	R CAPACITOR 30M 500V 3" X 2"
1053-5	P0554Z1053-5	CAPACITOR COVER
1053-6	P0554Z1053-6	MOTOR WIRING JUNCTION BOX
1054	P0554Z1054	COOLANT PUMP 40W 220V 1PH
1055	PW03M	FLAT WASHER 6MM
1056	P0554Z1056	KILL SWITCH
1057	P0554Z1057	HALOGEN LAMP ASSEMBLY
1058	PS15M	PHLP HD SCR M6-1 X 14
1059	PSB31M	CAP SCREW M8-1.25 X 25
1060	P0554Z1060	COOLANT NOZZLE
1061	P0554Z1061	COOLANT ON/OFF VALVE
1062	P0554Z1062	COOLANT TANK HOSE



Electrical Breakdown



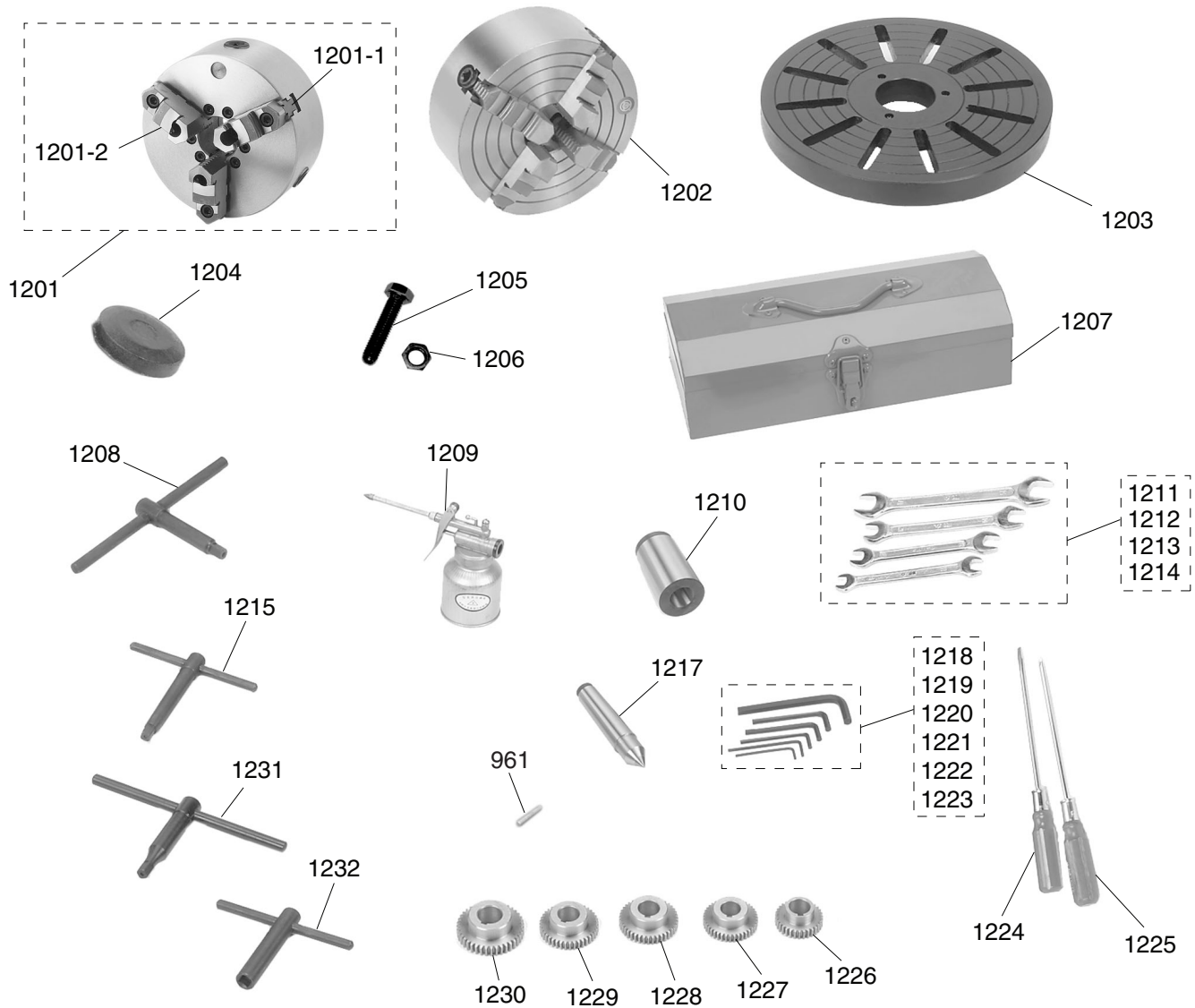
Electrical Parts List

REF	PART #	DESCRIPTION
328	P0554Z0328	STOP BUTTON ASSEMBLY
329	P0554Z0329	JOG BUTTON ASSEMBLY
331	P0554Z0331	POWER LAMP ASSEMBLY
332	P0554Z0332	COOLANT SWITCH ASSEMBLY
1052	P0554Z1052	SIDE DOOR SWITCH
1053	P0554Z1053	MOTOR 3HP 220V 1PH
1053-1	P0554Z1053-1	MOTOR FAN COVER
1053-2	P0554Z1053-2	MOTOR FAN
1053-3	P0554Z1053-3	S CAPACITOR 150M 250V 3" X 2"
1053-4	P0554Z1053-4	R CAPACITOR 30M 500V 3" X 2"
1053-5	P0554Z1053-5	CAPACITOR COVER
1053-6	P0554Z1053-6	MOTOR WIRING JUNCTION BOX
1054	P0554Z1054	COOLANT PUMP 40W 220V 1PH
1056	P0554Z1056	KILL SWITCH
1057	P0554Z1057	HALOGEN LAMP ASSEMBLY
1057-1	P0554Z1057-1	LAMP BODY
1057-2	P0554Z1057-2	HALOGEN BULB 24V
1057-3	P0554Z1057-3	BULB COVER
1057-4	P0554Z1057-4	BULB COVER RETAINER
1057-5	PS55M	PHLP HD SCR M3-.5 X 10
1057-6	P0554Z1057-6	LAMP BODY CORD
1101	P0554Z1101	CONTACTOR TIAN GSC1-1201 220V
1102	P0554Z1102	CONTACTOR TIAN JZC3-40D 220V
1103	P0554Z1103	FUSE HOLDER
1104	P0554Z1104	TRANSFORMER JBK5-100VATH

REF	PART #	DESCRIPTION
1105	P0554Z1105	TERMINAL BLOCK 22-POST
1106	P0554Z1106	GROUNDING BLOCK
1107	P0554Z1107	CORD COVER SMALL
1108	P0554Z1108	CORD COVER LARGE
1109	P0554Z1109	STRAIN RELIEF LARGE
1110	P0554Z1110	STRAIN RELIEF SMALL
1111	P0554Z1111	MAIN MOTOR CORD
1112	P0554Z1112	PUMP MOTOR CORD
1113	P0554Z1113	SPINDLE SWITCH
1114	P0554Z1114	SPINDLE SWITCH
1115	P0554Z1115	SPINDLE SWITCH CORD
1116	P0554Z1116	CONTROL PANEL CORD
1117	P0554Z1117	CERAMIC TERMINAL BLOCK 2C
1118	P0554Z1118	SIDE DOOR SWITCH CORD
1119	P0554Z1119	BRAKE SWITCH CORD
1120	P0554Z1120	32A FUSE
1121	P0554Z1121	OL RELAY JUCHE JR29-16 12-17.6A
1122	P0554Z1122	OL RELAY JUCHE JR29-16 0.35-0.52A
1123	P0554Z1123	MAIN POWER SWITCH
1124	P0554Z1124	MAIN POWER SWITCH CORD
1125	P0554Z1125	POWER TERMINAL BOX
1126	P0554Z1126	POWER TERMINAL BOX COVER
1127	P0554Z1127	TERMINAL BLOCK 8-POST
1128	P0554Z1128	PHLP HD SCR M8-1.25 X 25
1129	P0554Z1129	POWER CORD



Accessories

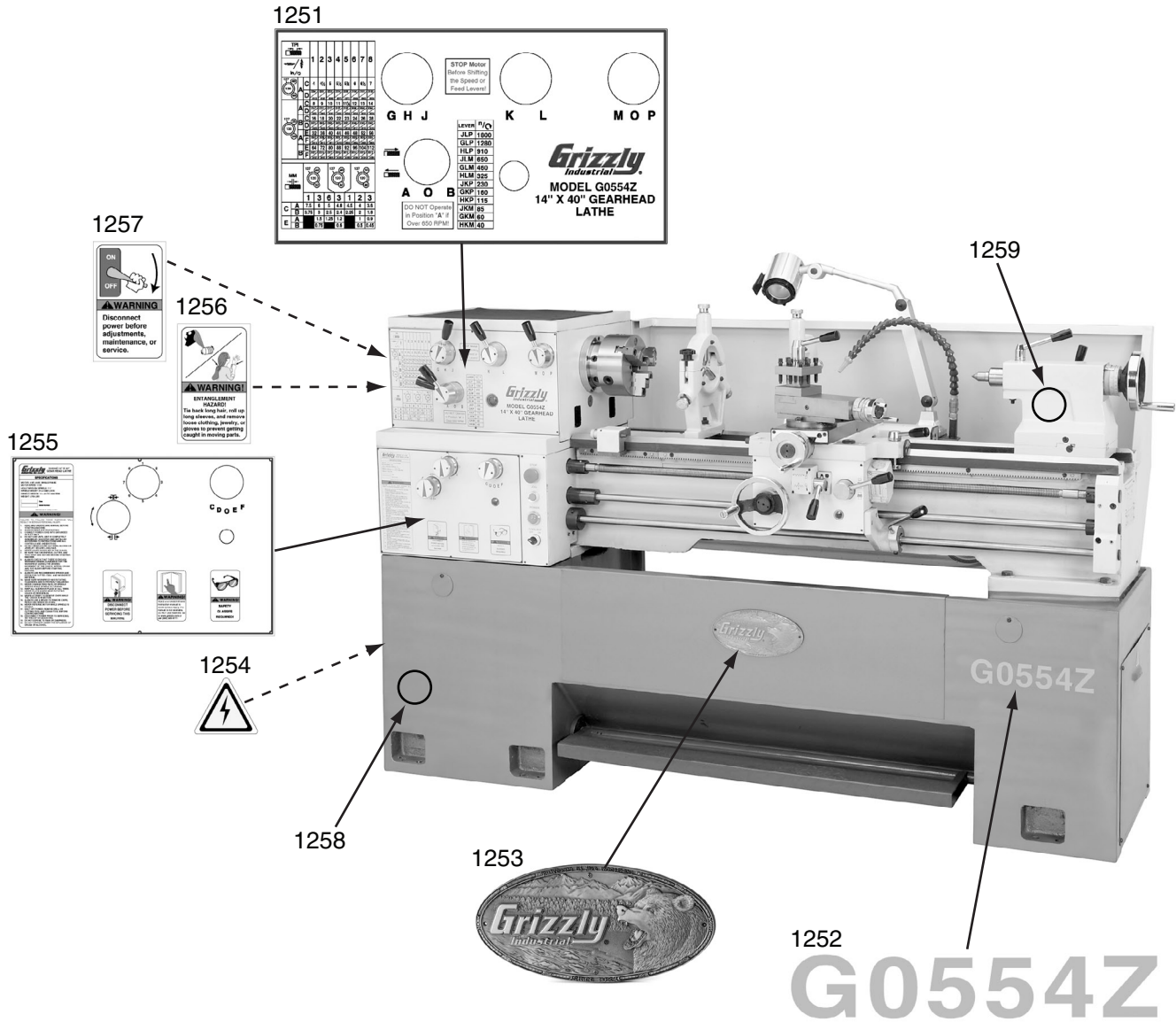


REF	PART #	DESCRIPTION
961	P0554Z0961	SHEAR PIN 5 X 40
1201	P0554Z1201	3-JAW CHUCK ASSEMBLY 6"
1201-1	P0554Z1201-1	3-JAW BOTTOM (QTY 1)
1201-2	P0554Z1201-2	3-JAW TOP (QTY 1)
1202	P0554Z1202	4-JAW CHUCK ASSEMBLY 8"
1203	P0554Z1203	FACEPLATE 12
1204	P0554Z1204	FOOT PAD
1205	P0554Z1205	LEVELING BOLT M12-1.75 X 50
1206	P0554Z1206	THIN HEX NUT M12-1.75
1207	P0554Z1207	TOOLBOX
1208	P0554Z1208	4-JAW CHUCK KEY
1209	P0554Z1209	OIL CAN
1210	P0554Z1210	TAPERED SLEEVE MT#5-MT#3
1211	P0554Z1211	WRENCH 9/11
1212	PWR1012	WRENCH 10/12
1213	PWR1214	WRENCH 12/14
1214	PWR1417	WRENCH 14/17

REF	PART #	DESCRIPTION
1215	P0554Z1215	SPINDLE LOCK KEY
1217	P0554Z1217	DEAD CENTER MT#3
1218	PAW02.5M	HEX WRENCH 2.5MM
1219	PAW03M	HEX WRENCH 3MM
1220	PAW04M	HEX WRENCH 4MM
1221	PAW05M	HEX WRENCH 5MM
1222	PAW06M	HEX WRENCH 6MM
1223	PAW08M	HEX WRENCH 8MM
1224	PSDF2	SCREWDRIVER FLAT #2
1225	PSDP2	SCREWDRIVER PHILLIPS #2
1226	P0554Z1226	CHANGE GEAR 30T
1227	P0554Z1227	CHANGE GEAR 32T
1228	P0554Z1228	CHANGE GEAR 35T
1229	P0554Z1229	CHANGE GEAR 40T
1230	P0554Z1230	CHANGE GEAR 48T
1231	P0554Z1231	3-JAW CHUCK KEY
1232	P0554Z1232	4-WAY TOOL POST WRENCH



Label Placement



REF	PART #	DESCRIPTION
1251	P0554Z1251	LATHE CONFIGURATION LABEL
1252	P0554Z1252	MODEL NUMBER LABEL
1253	G8589	GRIZZLY OVAL NAMEPLATE
1254	PLABEL-14	ELECTRICITY LABEL
1255	P0554Z1255	MACHINE ID LABEL

REF	PART #	DESCRIPTION
1256	PLABEL-55	ENTANGLEMENT HAZARD LABEL
1257	PLABEL-53	DISCONNECT WARNING LABEL
1258	PPAINT-1	GRIZZLY GREEN TOUCH-UP PAINT
1259	PPAINT-11	GRIZZLY PUTTY TOUCH-UP PAINT

WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.

