

Parts Manual



SAWING PRODUCTS

3613-V3

Serial No: 568-04101 to

Band Sawing Machine

MACHINE SPECIFICATIONS

MODEL SERIAL NO.

VOLTAGE CYCLE PHASE

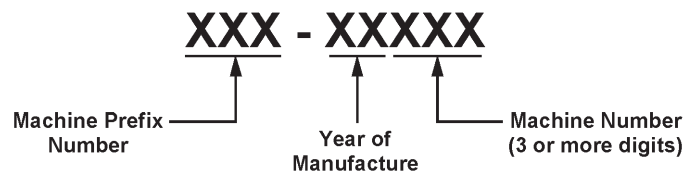
For your information and future reference, insert pertinent data concerning your machine in the spaces provided above. This information is printed on a label or stamped on a plate attached to the machine frame.

Always specify model and serial numbers on all parts orders and correspondence concerning your machine. This will help avoid unnecessary delays and inconvenience during processing.

The specifications contained herein were in effect at the time this manual was approved for printing. The DoALL Company, whose policy is one of continuous product improvement, reserves the right to change specifications or design at any time without notice and without incurring obligations.

How to read your serial number:

Example: 500-001234



For Sales, Parts and Service, call 1-888-362-5572.



DoALL SAWING PRODUCTS
2375B TOUHY AVENUE
ELK GROVE, ILLINOIS 60007 U.S.A.

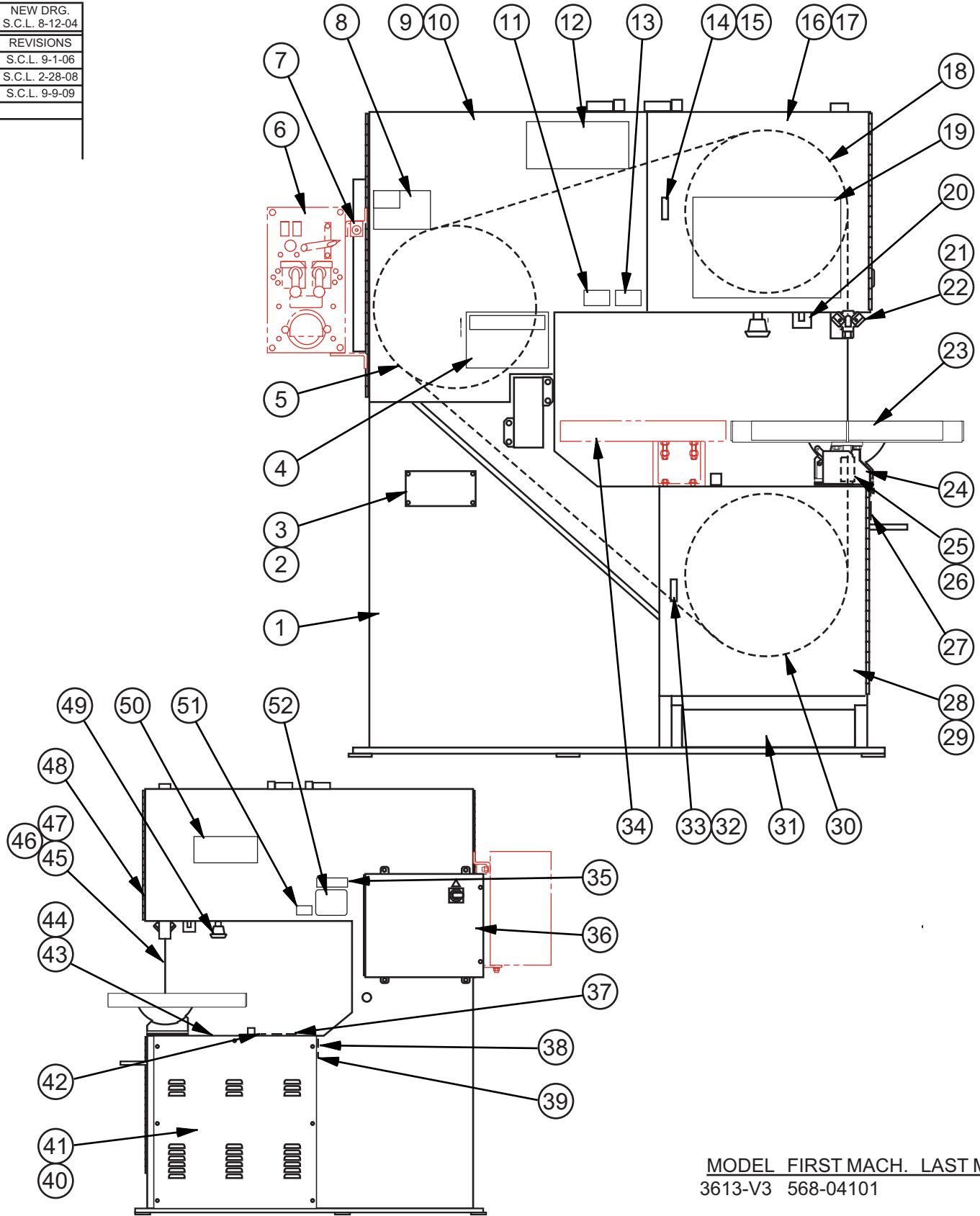
YOUR SERVICE REPRESENTATIVE:

Fiche No. A-11 Model 3613-V3 Serial No. 568-04101 to _____

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*Denotes Attachment or Optional Equipment.

NEW DRG.
S.C.L. 8-12-04
REVISIONS
S.C.L. 9-1-06
S.C.L. 2-28-08
S.C.L. 9-9-09



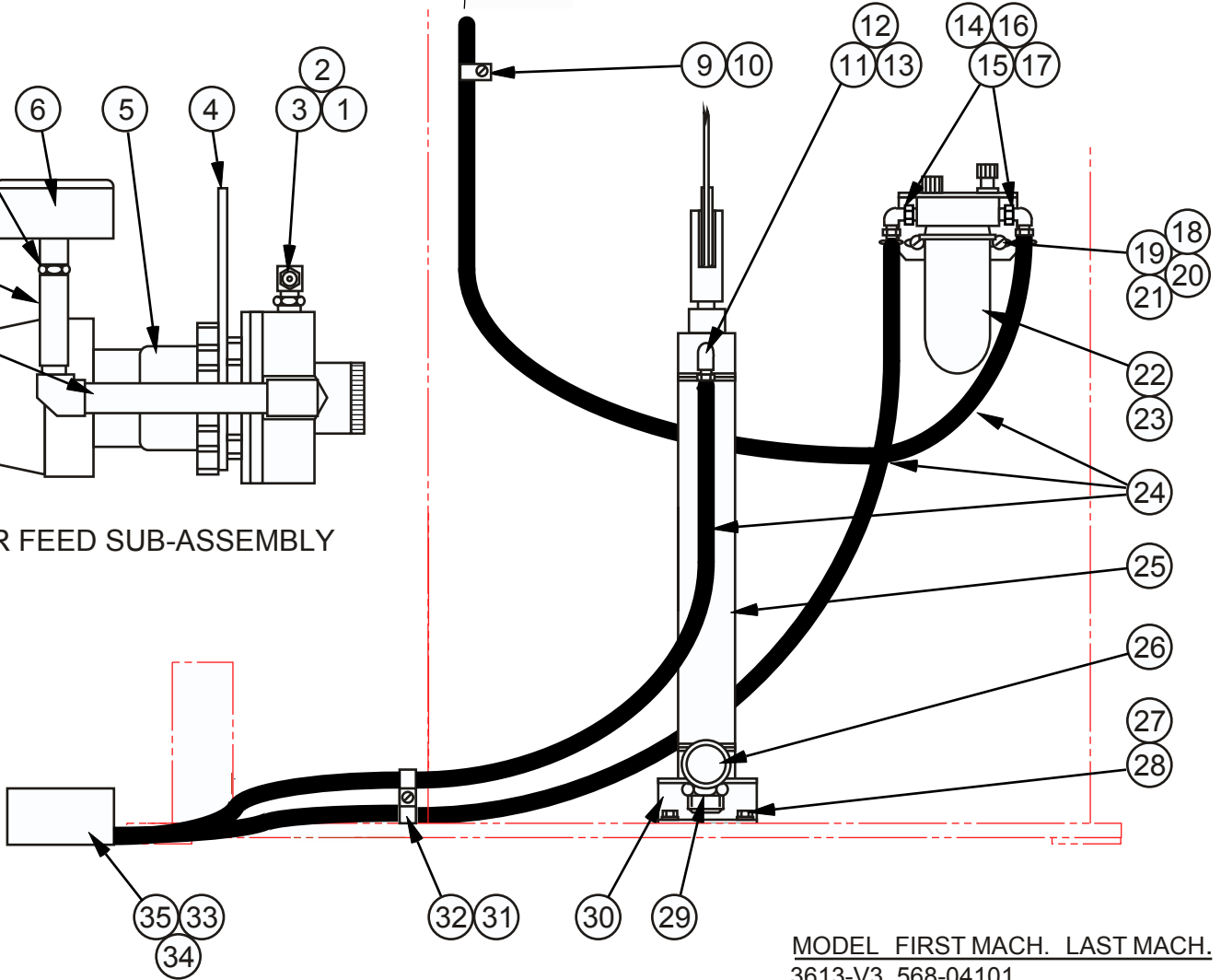
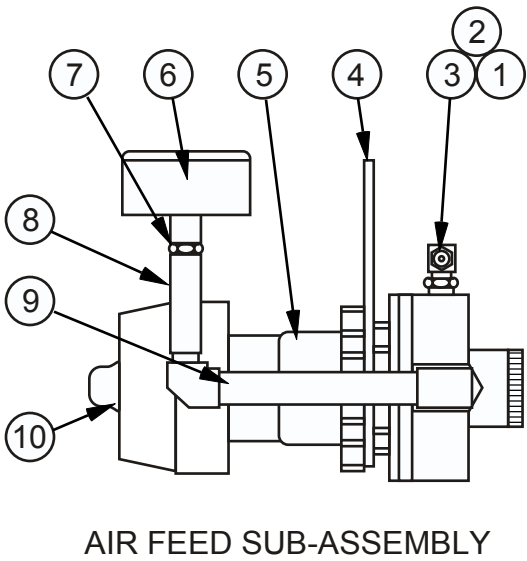
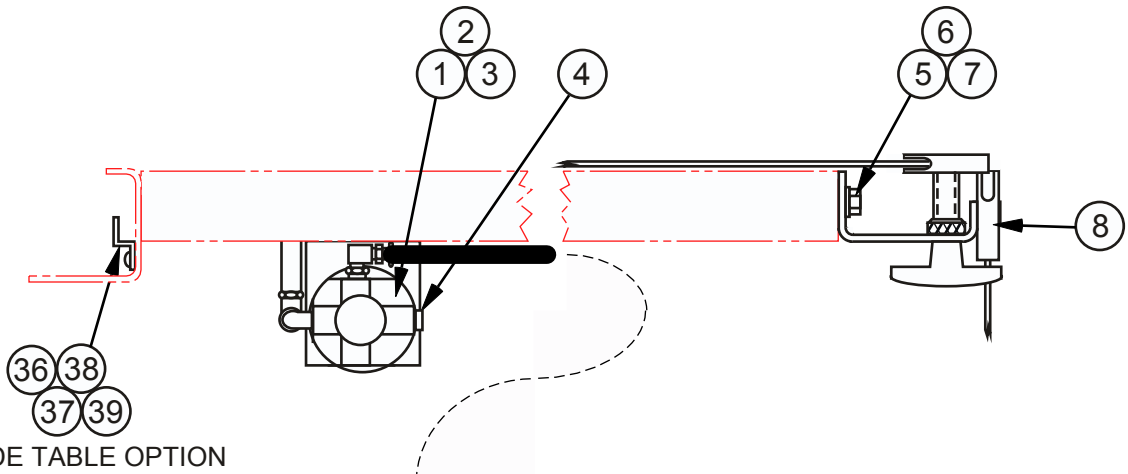
MODEL FIRST MACH. LAST MACH.
3613-V3 568-04101

FINAL ASSEMBLY

FINAL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	290215	Final Assembly		39	133195	. Grommet (Small)	1
1*	521630	. Frame Weldment	1	40	420945	. Rear Drive Cover	1
2	221564	. Cover	1	41	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13	7
3	198349	. Screw, Button Hd. Soc. 1/4-20NC x 1/2	4	42	015780	. Grommet	1
4	404476	. Escutcheon (Warning)	1	43	420954	. Top Drive Cover	1
5	521622	. Idler Bandwheel Assembly (Third Wheel) (See Detail)	1	44	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13	6
6		. DBW-15 Butt welder Assembly (Optional) (See Separate Manual)	1	45*	221228	. Saw Band (1/2" Silencer Bi-Metal)	1
7	221216	. Welder Mounting Bracket Assembly (For Optional Butt welder) (See Detail)	1	46	304525	. Saw Band Tag	1
8	201469	. Decal (American Flag)	1	47	222563	. Tag (Installation Instructions)	1
9*	521740	. L.H. Upper Door Weldment	1	48	216862	. Plastic Cover (No Post Elevating Handwheel Option)	1
10	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13	8	49	009400	. Knob Assembly	1
11	136902	. Escutcheon (Caution) (English)	1	50	221780	. Label (DoALL)	1
	139493	. Escutcheon (Caution) (International) ...	1	51	206698	. CE Label	1
12	221780	. Label (DoALL)	1	52	1012541	. Label (Machine Specifications)	1
13	145882	. Escutcheon (Caution) (English)	1	Following Not Shown:			
	149667	. Escutcheon (Caution) (International) ...	1	221218		. Documentation CD	1
14	172762	. Door Latch	1	222564		. Box of Extra Parts	1
15	198853	. Screw, Rd. Hd. Mach. #8-32NC x 3/8 ..	2	222559		. . Saw Guide Insert Pack (1/4" to 3/8" Bands)	1
16	420957	. R.H. Upper Door Weldment	1	003939		. . Saw Guide Insert (1/2")	4
17	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13	6	010853		. . Wrench (For Table Tilt)	1
18	520279	. Head Assembly (See Detail)	1	199568		. . Hex. Key (Saw Guides)	1
19	515907	. Job Selector	1	406871		. Instruction Tag	1
20	007038	. Escutcheon (Band Tension) (Inch/English)	1	1012715		. Pallet	1
	131423	. Escutcheon (Band Tension) (Metric/ International)	1	100666		. Escutcheon (DoALL CSA)	1
21	028081	. Saw Guide Assembly (Upper) (See Detail)	1	144059		. Escutcheon (Electrical Warning-French for CSA)	1
22	018500	. Upper Saw Guide Holding Screw	2	*NOTE: Also See Extra Work Height Assembly If Applicable.			
23		. Table and Trunnion Assembly (See Detail)	1				
24	221612	. Guard Assembly (Chip Baffle) (See Detail)	1				
	222896	. Guard Assembly (Glide or HMD Table Options)	1				
25	028082	. Saw Guide Assembly (Lower) (See Detail)	1				
26	198246	. Screw, Soc. Hd. Cap 1/4-20NC x 1-3/4	2				
27	172654	. Escutcheon (Caution Hi/Low) (English)	1				
	172655	. Escutcheon (Caution Hi/Low) (Internat'l)	1				
28	521609	. Lower Door Weldment	1				
29	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13	6				
30		. Drive Assembly (See Detail)	1				
31	404522	. Chip Box Weldment (Standard)	1				
	414621	. Chip Box Assembly (Dust Spout Option)	1				
32	172762	. Door Latch	1				
33	198853	. Screw, Rd. Hd. Mach. #8-32NC x 3/8 ..	2				
34		. Secondary Table Assembly (Optional) (See Detail)	1				
35	222562	. Label (1-888-DoALL)	1				
36		. Electrical Assembly (See Detail)	1				
37	006291	. Plug Button (No Secondary Table)	4				
38	203271	. Grommet (Large)	1				

NEW DRG.
S.C.L. 2-25-04
REVISIONS
S.C.L. 2-11-08
S.C.L. 8-3-09
S.C.L. 8-25-11
S.C.L. 7-8-13



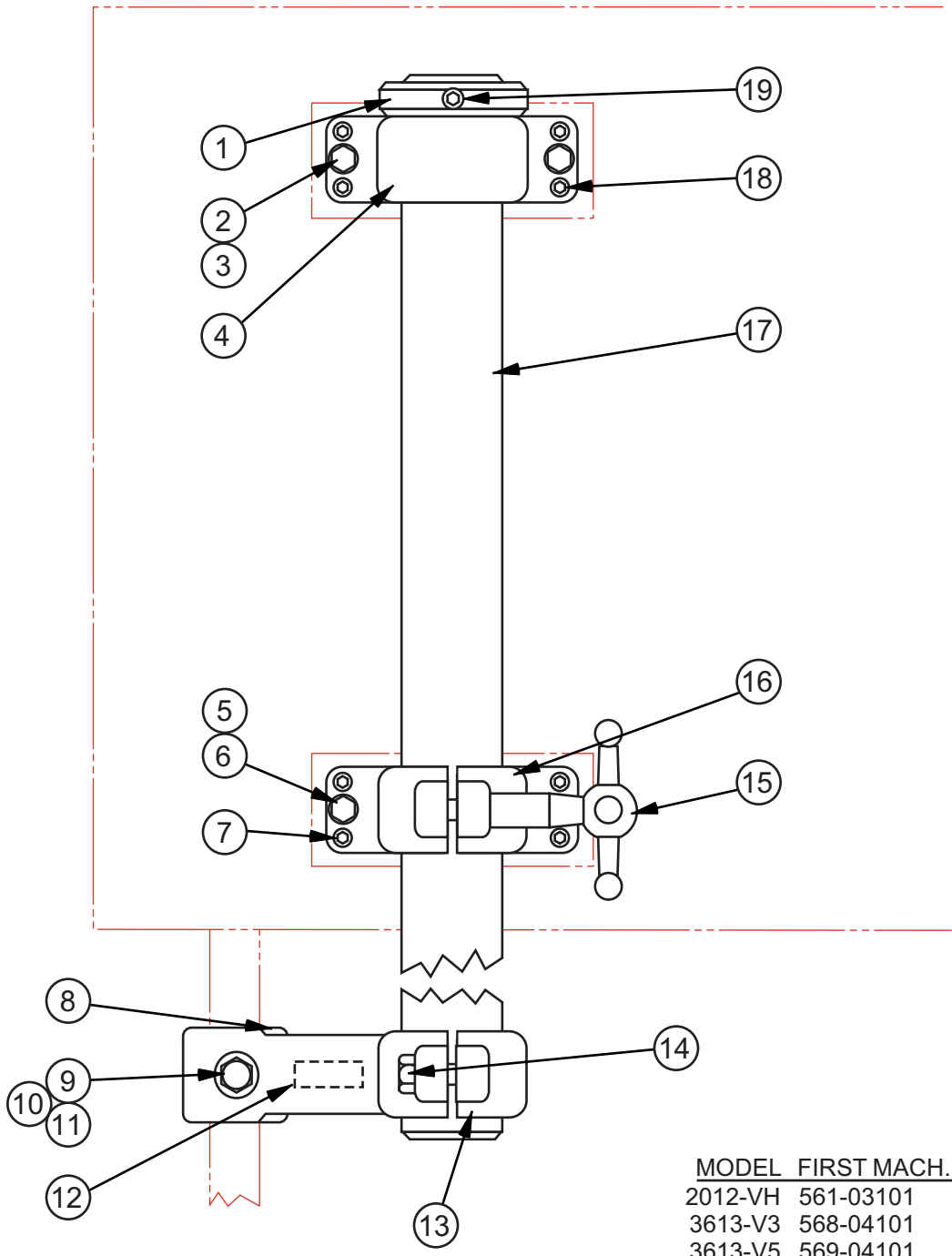
MODEL	FIRST MACH.	LAST MACH.
3613-V3	568-04101	
3613-V5	569-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	
2613-V3	589-09101	

AIR FEED ASSEMBLY

AIR FEED ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY.
Ref.	513087	Air Feed Assembly	
Ref.	517986	Air Feed Assembly (With Glide Table Option) (20" Machines)	
Ref.	221718	Air Feed Assembly (With Glide Table Option) (36" Machines)	
1	416813	. Air Feed Sub-Assembly (See Detail)	1
2	198008	. Screw, Hex. Hd. Cap 1/4-20NC x 3/4	2
3	199321	. Washer, Lock 1/4 Std.	2
4	203604	. Pipe Plug (Brass) (If Supplied)	1
5	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	3
6	199325	. Washer, Lock 3/8 Std.	3
7	34-005414	. Spacer Washer	3
8	420866	. Carrier and Cable Assembly (Air Feed) (See Detail)	1
9	115652	. Tubing Clamp	1
10	199484	. Screw, Pan Hd. Self-Tap 1/4-20NC x 1/2	1
11	008254	. 90° Street Elbow (Brass)	1
12	002004	. Barbed Insert	1
13	35-006888	. Hose Clamp	2
14	203221	. Reducer Bushing (Brass)	2
15	008254	. 90° Street Elbow (Brass)	2
16	002004	. Barbed Insert	2
17	35-006888	. Hose Clamp	2
18	198896	. Screw, Rd. Hd. Mach. 1/4-20NC x 5/8	2
19	199374	. Washer, Lock 1/4 Shakeproof Ext.	2
20	199260	. Washer, Flat 1/4 S.A.E. Std.	2
21	199115	. Nut, Hex. 1/4-20NC	2
22	145883	. Oil-Fog Lubricator (Includes Bracket)	1
23	138445	. Oil (ASTM 315)	A.R.
24	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
25	172794	. Air Cylinder	1
26	169631	. Air Filter	1
27	198006	. Screw, Hex. Hd. Cap 1/4-20NC x 1/2 (20" Machines)	4
	198045	. Screw, Hex. Hd. Cap 3/8-16NC x 7/8 (36" Machines)	4
28	199321	. Washer, Lock 1/4 Std. (20" Machines)	4
	199325	. Washer, Lock 3/8 Std. (36" Machines)	4
29	199147	. Nut, Hex. Jam 1-14NF	1
30	325663	. Cylinder Mounting Bracket (20" Machines)	1
	326102	. Cylinder Mounting Bracket (36" Machines)	1
31	115652	. Tubing Clamp	2
32	199484	. Screw, Pan Hd. Self-Tap 1/4-20NC x 1/2	1
33	172793	. Foot Valve	1
34	172792	. Guard	1
35	128179	. Barbed Insert	2
For Machines with Glide Table Option:			
36	209139	. Chain Support (13")	3
37	209140	. Chain Support (2")	1
38	199649	. Screw, Button Hd. Soc. #10-24NC x 1/4	8
39	199320	. Washer, Lock #10 Std.	8
Following Not Shown:			
	5-013007	. Work Holding Jaw Assembly (See Detail)	1
Ref.	416813	. Air Feed Sub-Assembly	
1	203219	. Reducer Bushing (Brass)	1
2	5-027506	. 90° Street Elbow (Brass)	1
3	128179	. Barbed Insert	1
4	315365	. Bracket	1
5	125674	. Regulating Valve	1
6	35-009530	. Gauge	1
7	203219	. Reducer Bushing (Brass)	1
8	204233	. Pipe Coupling (Brass)	1
9	203482	. Pipe Nipple (4") (Brass)	1
10	008254	. 90° Street Elbow (Brass)	2

NEW DRG.
S.C.L. 2-25-04
REVISIONS
S.C.L. 4-4-07
S.C.L. 2-11-08
S.C.L. 9-9-09



MODEL	FIRST MACH.	LAST MACH.
2012-VH	561-03101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	
2012-D12	584-08101	
2613-V3	589-09101	

AUXILIARY POST SUPPORT ASSEMBLY (EXTRA WORK HEIGHT)

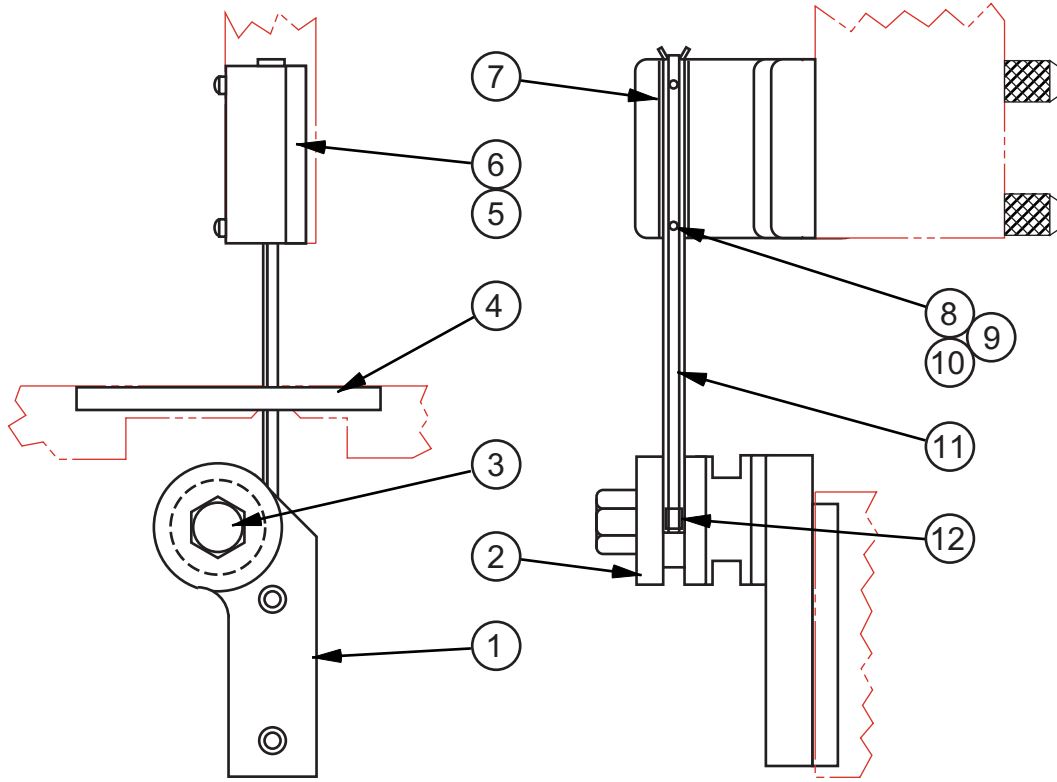
C - 2 - 118 CM - 2 - 132

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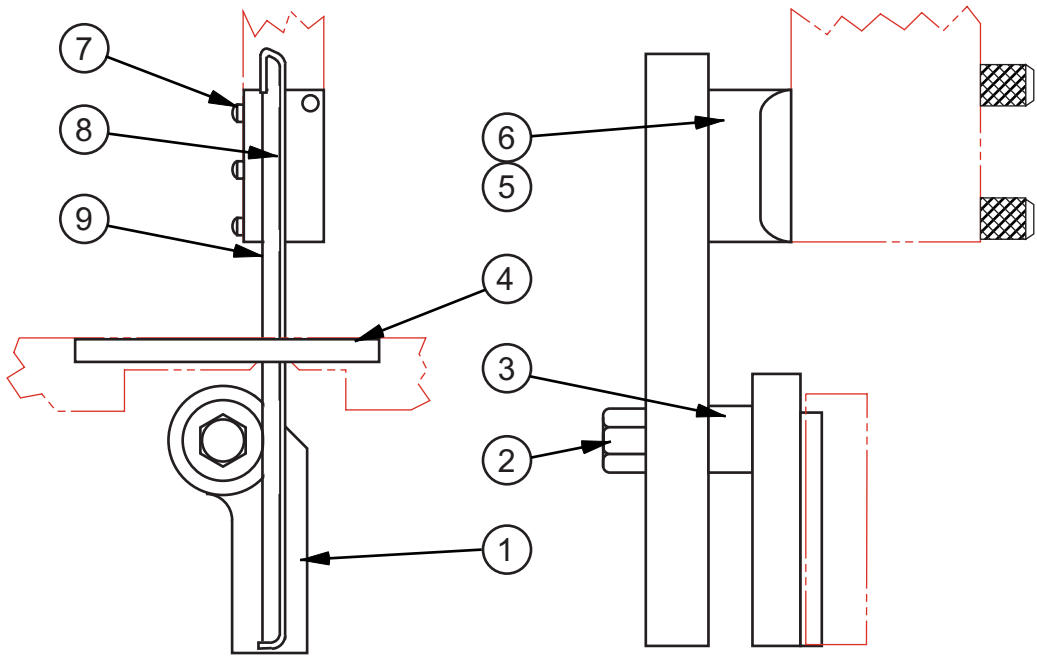
AUXILIARY POST SUPPORT ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	506149	Auxiliary Post Support Assembly	
1	13-001423	. Post Collar	1
2	198048	. Screw, Hex. Hd. Cap 3/8-16NC x 1-1/2	2
3	199325	. Washer, Lock 3/8 Std.	2
4	032463	. Upper Post Guide	1
5	198048	. Screw, Hex. Hd. Cap 3/8-16NC x 1-1/2	2
6	199325	. Washer, Lock 3/8 Std.	2
7	198439	. Screw, Soc. Set 5/16-18NC x 3/4	4
8	13-001309	. Back-Up Pad	1
9	13-001419	. Back-Up Pad Screw 1/2-13NC x 4-1/8	1
10	199132	. Nut, Hex. Jam 1/2-13NC	1
11	35-009616	. Retaining Ring	1
12	203551	. Escutcheon (Remove Bracket)	1
13	024337	. Support Arm	1
14	198067	. Screw, Hex. Hd. Cap 1/2-13NC x 1-1/2	1
15	007629	. Starwheel Assembly	1
	6-001103	. . Starwheel	1
	004261	. . Spring Pin	1
	13-001422	. . Post Clamp Screw	1
16	032462	. Lower Post Guide	1
17	305659	. Auxiliary Post (24" Work Height)	1
	305660	. Auxiliary Post (30" Work Height)	1
18	198439	. Screw, Soc. Set 5/16-18NC x 3/4	4
19	198450	. Screw, Soc. Set 3/8-16NC x 5/8	1

NEW DRG.
S.C.L. 9-25-97
REVISIONS
S.C.L. 6-28-01
S.C.L. 2-20-04
S.C.L. 2-11-08



BAND FILING ASSEMBLY



BAND POLISHING ASSEMBLY

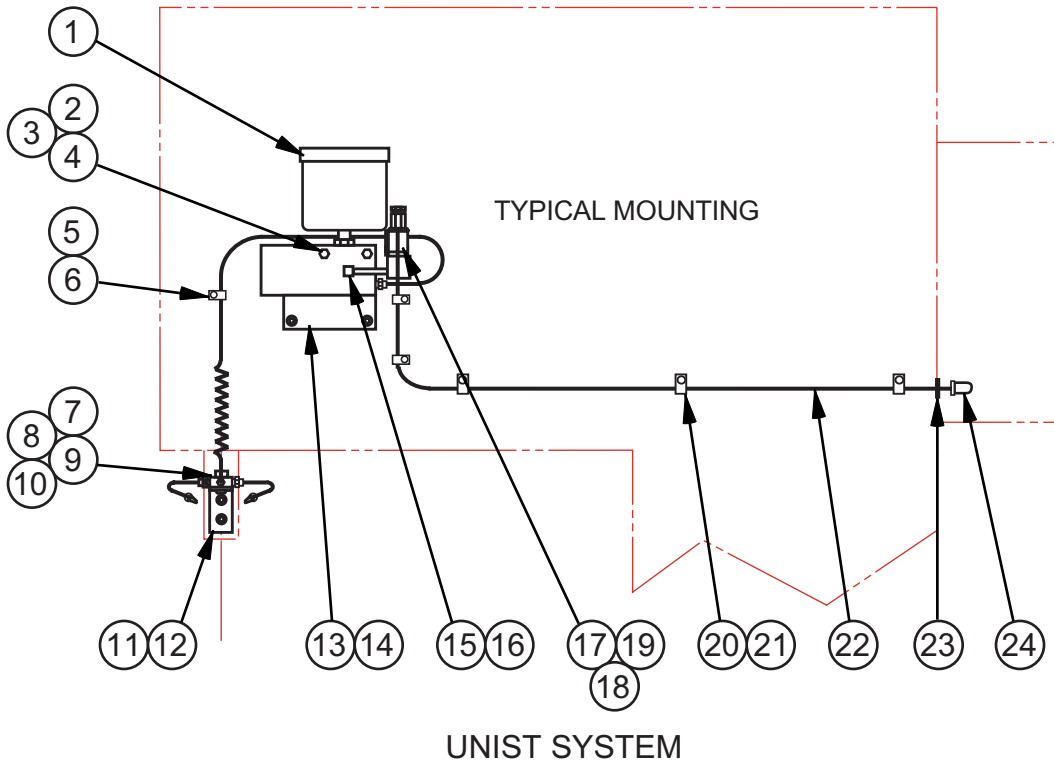
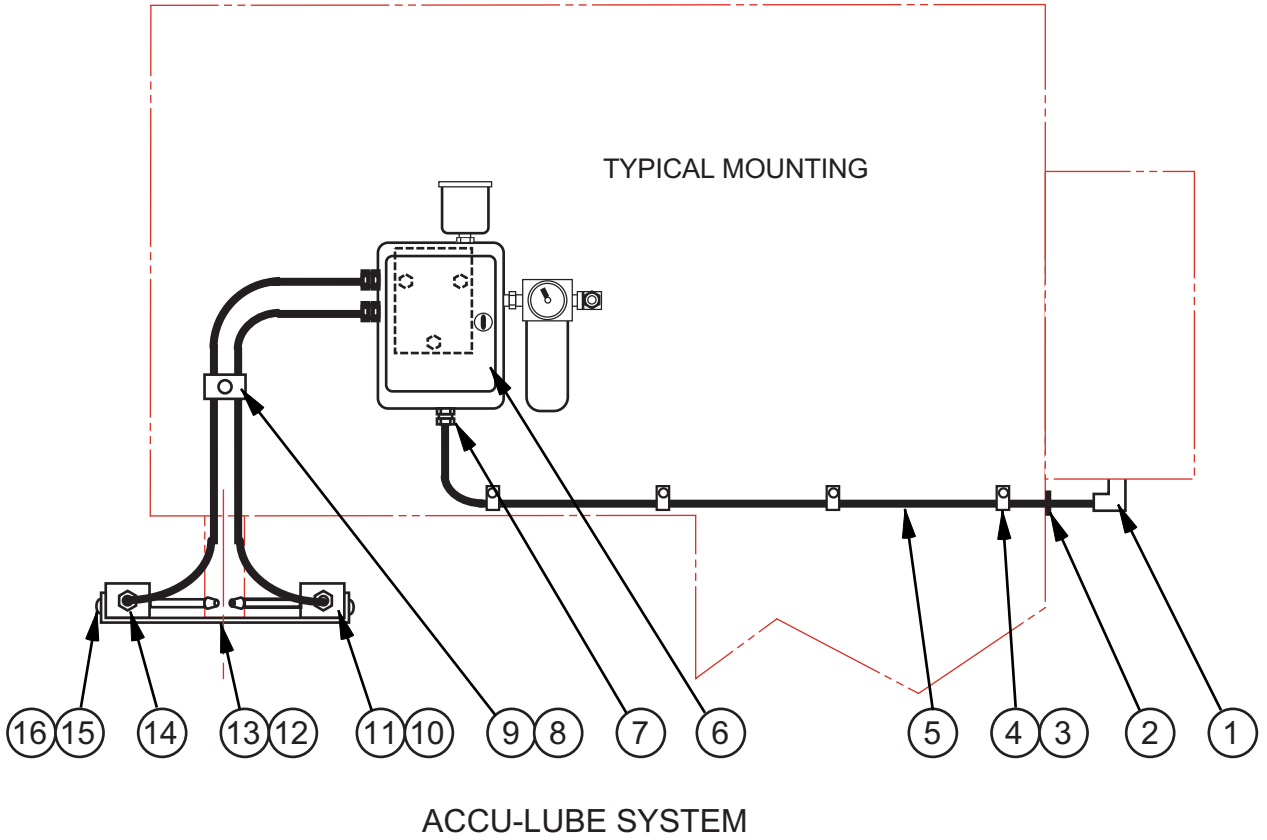
**BAND FILING ASSEMBLY
BAND POLISHING ASSEMBLY**

**BAND FILING ASSEMBLY
 BAND POLISHING ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	044780	Band Filing Assembly (Short Guides, 26" Table)	
Ref.	111948	Band Filing Assembly (Long Guides, 26" Table)	
Ref.	404994	Band Filing Assembly (Short Guides, 30" Table)	
Ref.	132773	Band Filing Assembly (Long Guides, 30" Table)	
1	001371	. Adaptor	1
2	34-009312	. File Guide Back-Up	1
3	34-009001	. File Guide Back-Up Screw	1
4	317592	. Center Plate (Oval) (26" Table)	1
	010627	. Center Plate (Round) (26" Table)	1
	120128	. Center Plate (Round) (30" Table)	1
5	027487	. 1/4" File Guide Assembly (Short Guides)	1
	027490	. 1/4" File Guide Assembly (Long Guides)	1
	027488	. 3/8" File Guide Assembly (Short Guides)	1
	027491	. 3/8" File Guide Assembly (Long Guides)	1
	027489	. 1/2" File Guide Assembly (Short Guides)	1
	027492	. 1/2" File Guide Assembly (Long Guides)	1
6	027417	. . Bracket (1/4", Short Guides)	1
	027418	. . Bracket (1/4", Long Guides)	1
	027420	. . Bracket (3/8", Short Guides)	1
	027421	. . Bracket (3/8", Long Guides)	1
	027419	. . Bracket (1/2", Short Guides)	1
	027422	. . Bracket (1/2", Long Guides)	1
7	6-009307	. . Insert (1/4", Short Guides)	1
	6-009303	. . Insert (1/4", Long Guides)	1
	6-009301	. . Insert (3/8", Short Guides)	1
	6-009305	. . Insert (3/8", Long Guides)	1
	6-009309	. . Insert (1/2", Short Guides)	1
	6-009311	. . Insert (1/2", Long Guides)	1
8	198922	. . Screw, Rd. Hd. Mach. #4-40NC x 5/8 (1/4" File Guides)	2
	198699	. . Screw, Fill. Hd. Mach. #10-24NC x 5/8 (3/8" & 1/2" File Guides)	2
9	199315	. . Washer, Lock #4 Std. (1/4" File Guides)	2
	199319	. . Washer, Lock #10 Std. (3/8" & 1/2" File Guides)	2
10	6-009314	. . Washer (1/4" File Guides) (Between File Guide & Insert)	2
	6-009313	. . Washer (3/8" & 1/2" File Guides) (Between File Guide & Insert)	2
11	6-009308	. . File Guide (1/4", Short Guides)	1
	6-009304	. . File Guide (1/4", Long Guides)	1
	6-009302	. . File Guide (3/8", Short Guides)	1
	6-009306	. . File Guide (3/8", Long Guides)	1
	6-009310	. . File Guide (1/2", Short Guides)	1
	6-009312	. . File Guide (1/2", Long Guides)	1
12	34-009313	. . Guide Plate (1/4", Long Guides Only)	2
13	34-009402	. . Pin (1/4", Long Guides Only)	2
Ref.	201220	Band Polishing Assembly (26" Table)	
Ref.	106957	Band Polishing Assembly (30" Table)	
1	001371	. Adaptor	1
2	34-009001	. Back-Up Screw	1
3	34-010402	. Guide Back-Up	1
4*	318034	. Center Plate (Oval) (26" Table) (Not Shown)	1
	010570	. Center Plate (Round) (30" Table) (Not Shown)	1
5	016686	. Band Polishing Sub-Assembly	1
6	027412	. . Bracket	1
7	198696	. . Screw, Fill. Hd. Mach. #10-24NC x 3/8	3
8	34-010504	. . Back-Up Cloth	1
	136889	. . Adhesive	A.R.
9	6-010301	. . Back-Up Plate	1

*NOTE: Some 26" Tables will have the Round Center Plate Used on 30" Tables.

NEW DRG.
S.C.L. 5-1-00
REVISIONS
S.C.L. 2-25-04
S.C.L. 8-16-06
S.C.L. 2-8-08



BAND LUBRICATOR ASSEMBLY

C - 8 - 30 CM - 8 - 52 Z - 8 - 26

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BAND LUBRICATOR ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	520296	Band Lubricator Assembly (Accu-Lube System)	
1	320570	. 90° Cord Grip Connector (.125-.375)	1
2	133195	. Grommet	1
3	009955	. Tubing Clamp	4
4	199484	. Screw, Rd. Hd. Self-Tap 1/4-20NC x 1/2	4
5	197332	. Electrical Cord (#18-2 Conductor)	A.R.
6	204206	. Applicator Unit (Includes Hoses, Nozzles, etc.)	1
7	015139	. Cord Grip Connector (.250-.375)	1
8	313336	. Double Support	1
9	198276	. Screw, Soc. Hd. Cap 3/8-16NC x 1/2	1
10	216855	. Block	2
11	309004	. Male Connector	2
12	324404	. Mounting Bracket	1
13	198353	. Screw, Flat Hd. Soc. #6-32NC x 3/8	2
14	016001	. Barbed Insert	2
15	198207	. Screw, Soc. Hd. Cap #6-32NC x 3/8	4
16	199256	. Washer, Flat #6 S.A.E. Std.	4

Following Not Shown and Mounted on or Near the Control Box:

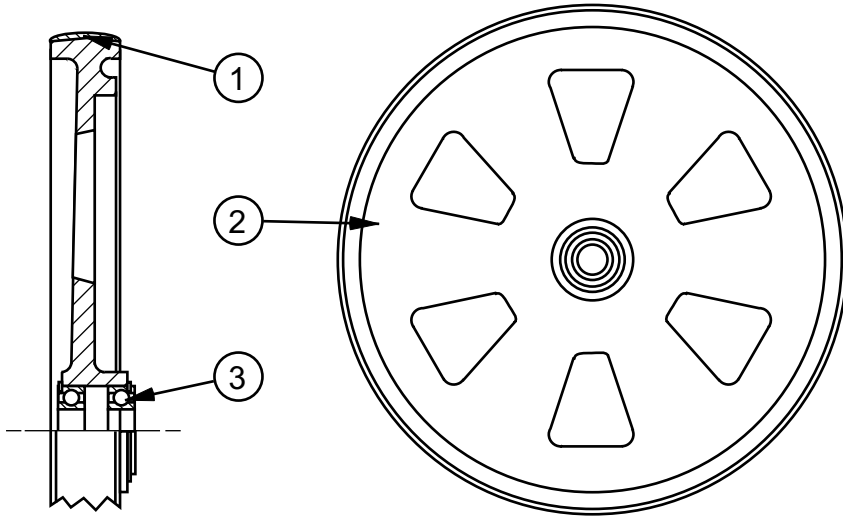
211111	. Selector Switch (2 Position)	1
217373	. Escutcheon (Mist Lube)	1

Ref.	1002498	Band Lubricator Assembly (Unist System)	
1	217359	. Applicator Unit (Includes Hose)	1
2	198015	. Screw, Hex. Hd. Cap 1/4-20NC x 2-1/4	2
3	199115	. Nut, Hex. 1/4-20NC	2
4	199321	. Washer, Lock 1/4 Std.	2
5	209458	. Hose Clamp (Half)	1
6	198321	. Screw, Button Hd. Soc. #10-24NC x 3/8	1
7	215821	. Nozzle Splitter	1
8	198360	. Screw, Button Hd. Soc. 1/4-20NC x 7/8	1
9	199114	. Nut, Hex. Jam 1/4-20NC	1
10	199321	. Washer, Lock 1/4 Std.	1
11	215917	. Mounting Bracket	1
12	198366	. Screw, Button Hd. Soc. 1/4-20NC x 3/8	2
13	214906	. Mounting Bracket	1
14	198366	. Screw, Button Hd. Soc. 1/4-20NC x 3/8	2
15	5-027506	. 90° Street Elbow	1
16	203144	. Pipe Nipple (Brass)	1
17	176829	. Solenoid Valve (3-Way)	1
18	177054	. Solenoid Plug Connector Kit	1
19	176811	. Vent Filter Breather	1
20	009955	. Tubing Clamp	5
21	198366	. Screw, Button Hd. Soc. 1/4-20NC x 3/8	5
22	197344	. Electrical Cord (#18-3 Conductor)	A.R.
23	133195	. Grommet (If Supplied)	1
24	201688	. Cord Grip Connector (.200-.394)	1

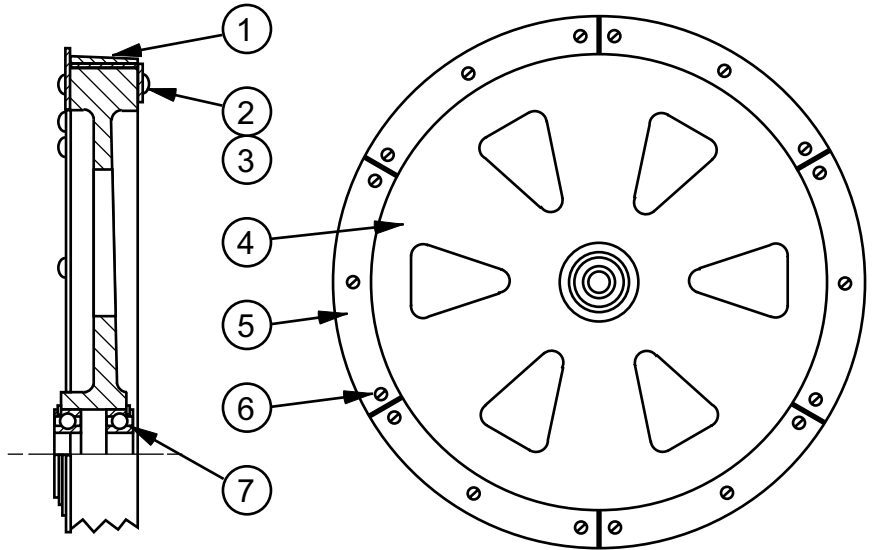
Following Not Shown and Mounted on or Near the Control Box on Selected Models:

211111	. Selector Switch (2 Position) (Includes Contact Blocks)	1
217373	. Escutcheon (Mist Lube)	1

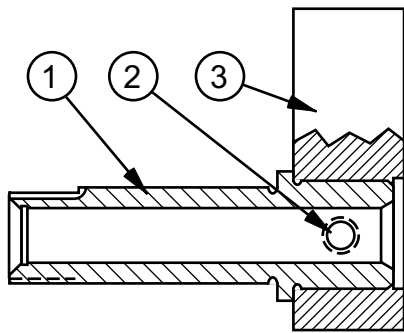
NEW DRG.
S.C.L. 2-25-04
REVISIONS
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S.C.L. 2-11-08



CROWNED BANDWHEELS



FLANGED BANDWHEELS



WHEEL HINGE ASSEMBLY

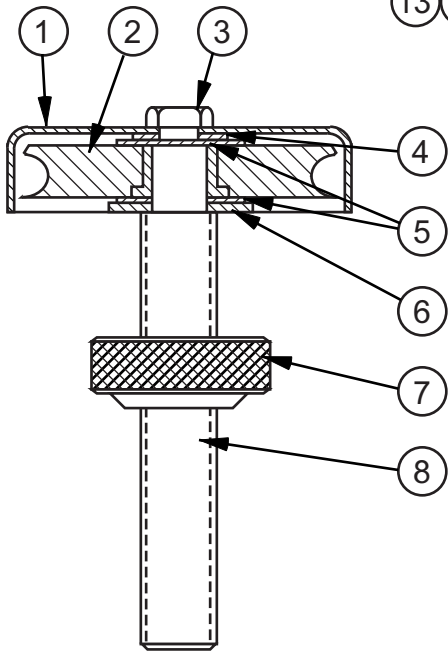
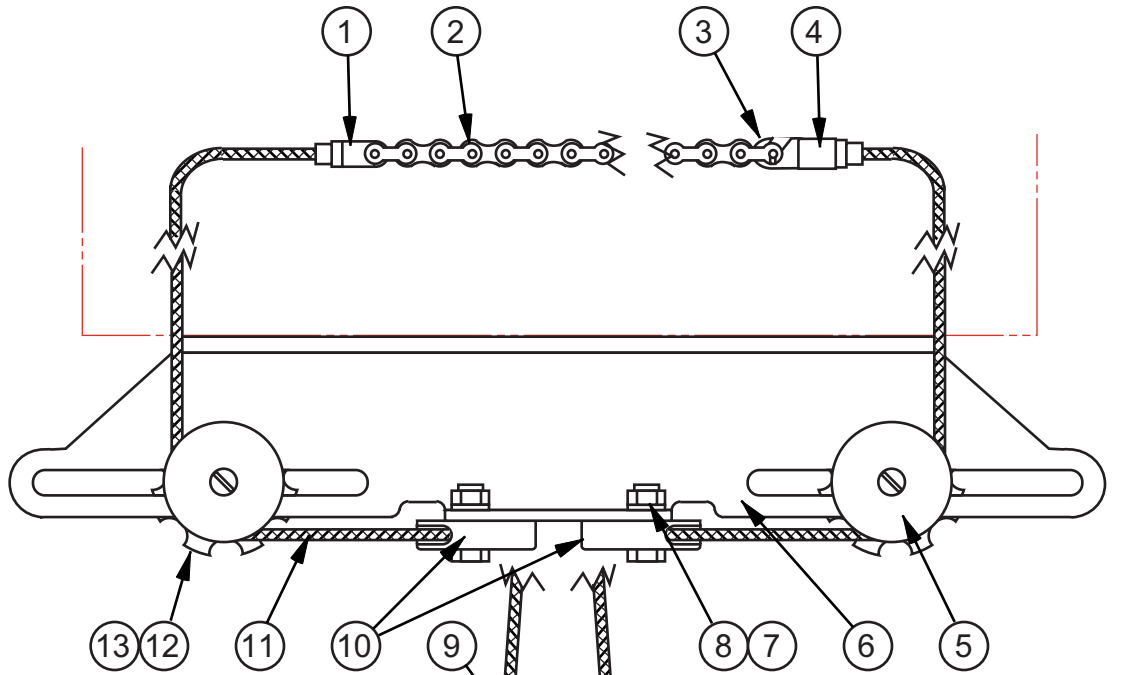
MODEL	FIRST MACH.	LAST MACH.
2012-VH	561-03101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	
2012-D12	584-08101	

BANDWHEEL ASSEMBLIES

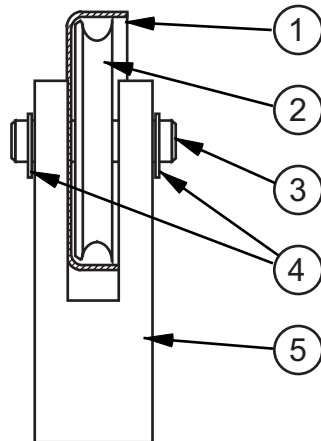
BANDWHEEL ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
<u>CROWNED BANDWHEELS</u>			
Ref.	402598	Bandwheel Assembly (Upper and Idler)	
Ref.	039712	Bandwheel Assembly (Lower)	
1	125357	. Tire	1
2	402597	. Bandwheel (Upper and Idler)	1
	402599	. Bandwheel (Lower)	1
3	5-001508	. Ball Bearing (Upper and Idler Bandwheels Only)	2
<u>FLANGED BANDWHEELS</u>			
Ref.	406558	Bandwheel Assembly (Upper and Idler)	
Ref.	408945	Bandwheel Assembly (Lower)	
1	305030	. Tire And Rim Assembly	1
2	004675	. Retainer	4
3	198000	. Screw, Hex. Hd. Cap #10-24NC x 3/8	8
4	406458	. Bandwheel (Upper and Idler)	1
	408875	. Bandwheel (Lower)	1
5	304732	. Flange Segment	6
6	198000	. Screw, Hex. Hd. Cap #10-24NC x 3/8	18
7	5-001508	. Ball Bearing (Upper and Idler Bandwheels Only)	2
Ref.	302346	Wheel Hinge Assembly	
1	5-001424	. Axis Stud	1
2	198423	. Screw, Soc. Set 1/4-20NC x 5/16	1
3	120624	. Block	1

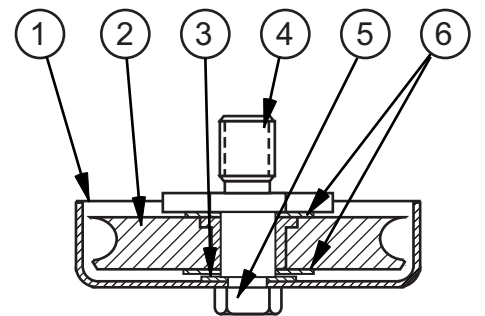
NEW DRG.
S.C.L. 2-25-04
REVISIONS
S.C.L. 2-11-08



HORIZONTAL PULLEY ASSEMBLY



EQUALIZER PULLEY ASSEMBLY



VERTICAL PULLEY ASSEMBLY

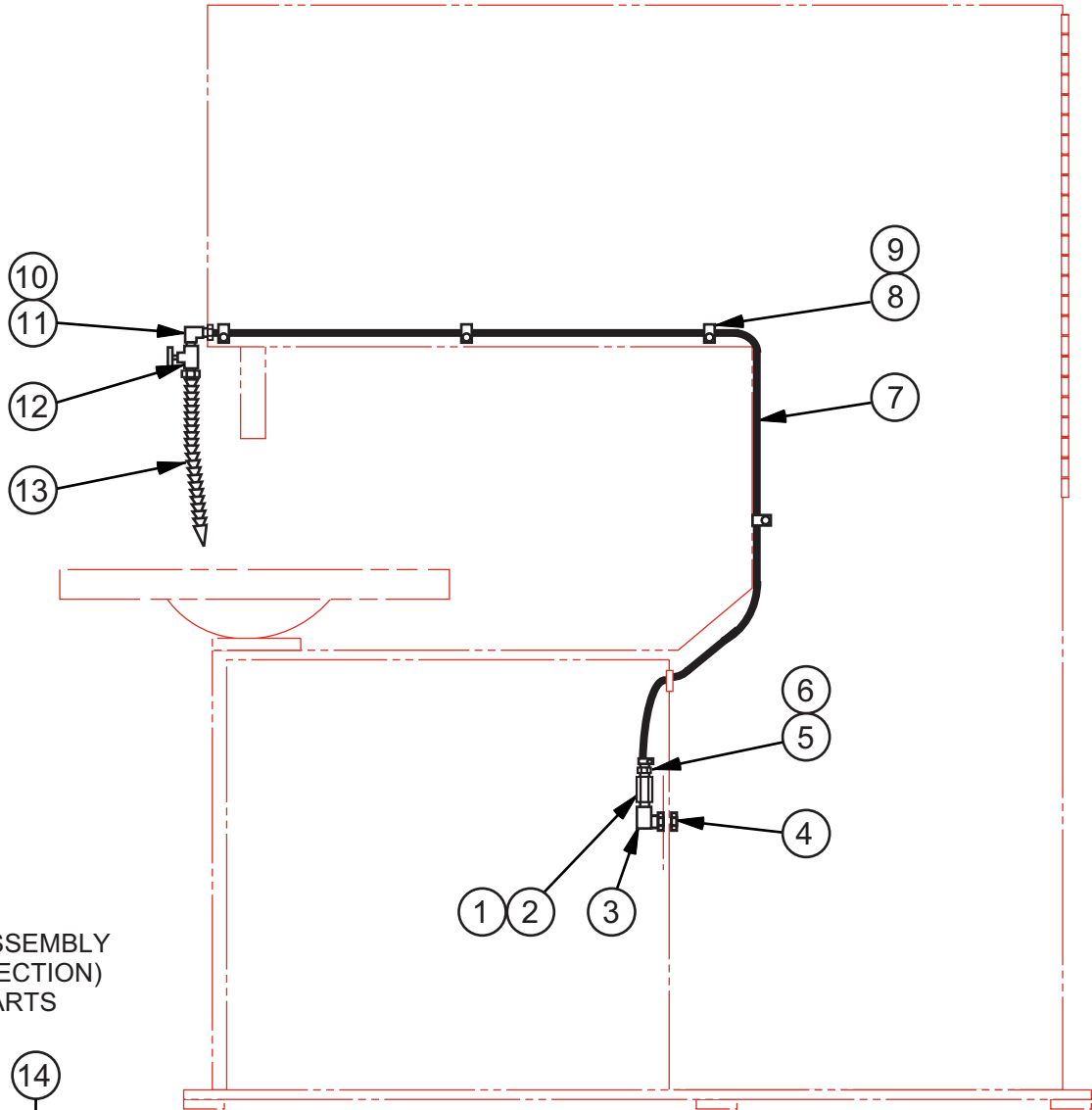
MODEL	FIRST MACH.	LAST MACH.
3613-V3	568-04101	
3613-V5	569-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	

CARRIER AND CABLE ASSEMBLY (AIR FEED)

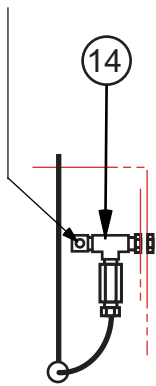
CARRIER and CABLE ASSEMBLY
(Air Feed)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY.
Ref.	420866	Carrier and Cable Assembly	
1	5-013417	. Cable Clamp Housing	1
2	35-005011	. Power Feed Chain Assembly	1
	6-013501	.. Power Feed Chain	1
	5-013419	.. Cable Clamp Eye	1
	199546	.. Rivet (3/16 x 7/16)	1
3	5-013418	. Cable Clamp Hook	1
4	5-013417	. Cable Clamp Housing	1
5	35-006395	. Horizontal Pulley Assembly (See Detail)	2
6	521571	. Cable Carrier	1
7	199127	. Nut, Hex. Jam 3/8-16NC	2
8	199325	. Washer, Lock 3/8 Std.	2
9	315362	. Equalizer Pulley Assembly (See Detail)	1
10	35-006396	. Vertical Pulley Assembly (See Detail)	2
11	35-005288	. Power Feed Cord	1
12	34-013106	. Handwheel	2
13	199266	. Washer, Flat 1/2 S.A.E. Std.	2
Ref.	35-006395	. Horizontal Pulley Assembly	
1	34-013301	.. Cap	1
2	204986	.. Pulley	1
3	198005	.. Screw, Hex. Hd. Cap 1/4-20NC x 3/8	1
4	199376	.. Washer, Lock 1/4 Shakeproof	1
5	5-013309	.. Pulley Spacer	2
6	199302	.. Washer, Flat 3/8 Wrought	1
7	34-013418	.. Thumb Nut	1
8	35-006398	.. Pulley Screw	1
Ref.	315362	. Equalizer Pulley Assembly	
1	34-013311	.. Cap	1
2	204986	.. Pulley	1
3	003275	.. Pulley Axis	1
4	003276	.. Retaining Ring	2
5	172795	.. Clevis	1
Ref.	35-006396	. Vertical Pulley Assembly	
1	34-013301	.. Cap	1
2	204986	.. Pulley	1
3	199374	.. Washer, Lock 1/4 Shakeproof.	1
4	204985	.. Pulley Stud	1
5	198005	.. Screw, Hex. Hd. Cap 1/4-20NC x 3/8	1
6	5-013309	.. Pulley Spacer	2

NEW DRG. S.C.L. 7-2-04
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S.C.L. 9-11-07
S.C.L. 2-27-08
S.C.L. 9-9-09



SEE AIR TABLE ASSEMBLY
(SHOP AIR CONNECTION)
FOR MORE PARTS



WHEN AIR TABLE IS
ALSO SUPPLIED

MODEL	FIRST MACH.	LAST MACH.
3613-1	577-04101	
3613-V3	568-04101	
3613-V5	569-04101	

CHIP BLOWER ASSEMBLY (AND RELATED ITEMS)

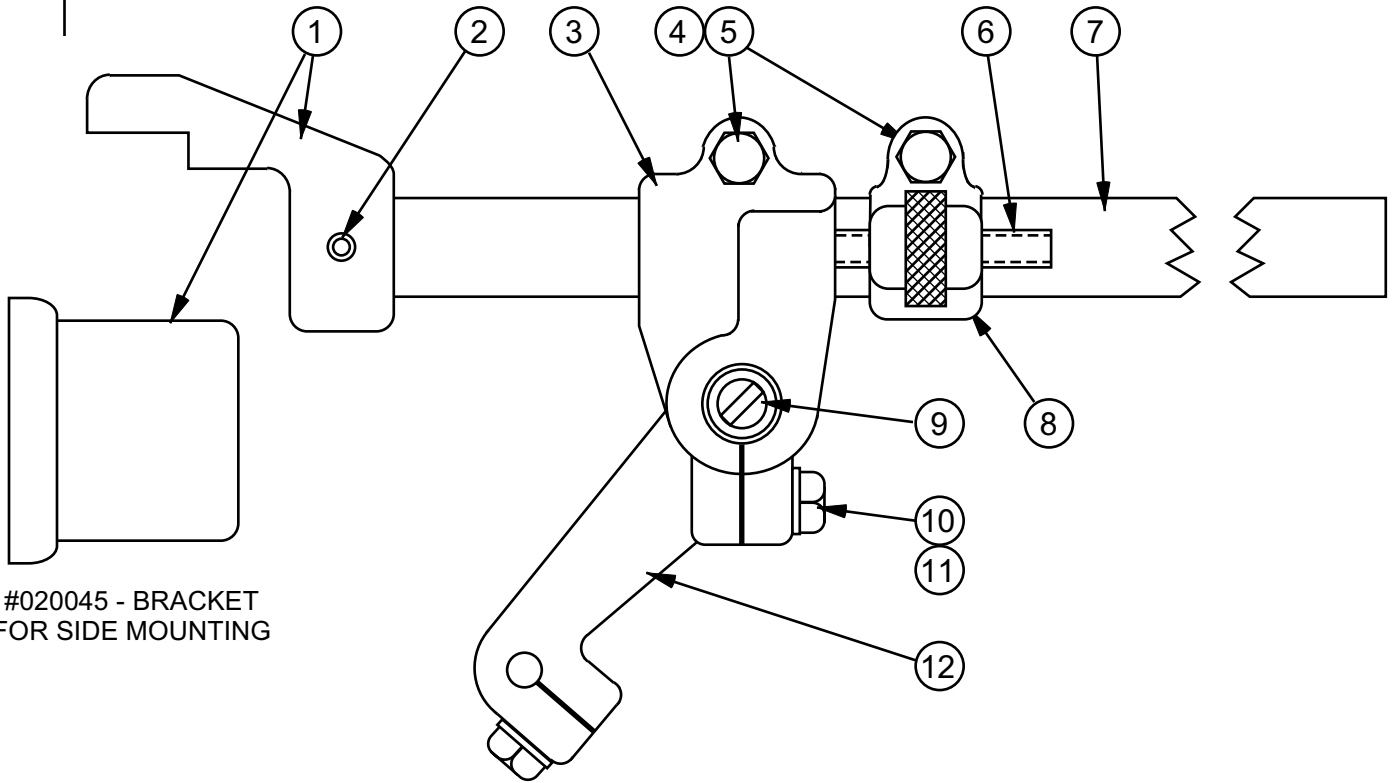
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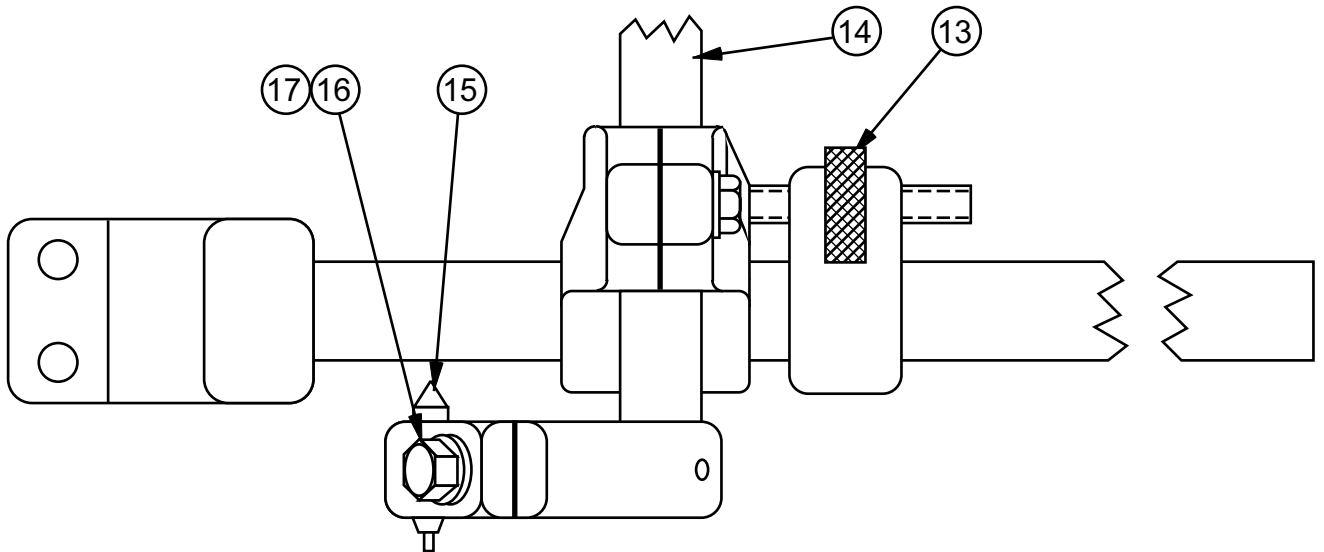
**CHIP BLOWER ASSEMBLY
(And Related Items)**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	206235	Chip Blower Assembly	
Ref.	211181	Chip Blower Assembly (w/Sliding Air Table Option)	
1	319526	. Orifice (.038) (Brass)	1
2	201746	. Close Nipple (Brass)	1
3	008254	. 90° Street Elbow	1
4	203818	. Anchor Connector	1
5	002004	. Barbed Insert	1
6	35-006888	. Hose Clamp	1
7	197094	. Neoprene Hose 11/16 O.D.	A.R.
8	115652	. Tubing Clamp	3
9	198366	. Screw, Button Hd. Soc. 1/4-20NC x 3/8	3
10	123041	. 90° Street Elbow	1
11	128179	. Barbed Insert	1
12	120241	. Valve	1
13	172530	. Coolant And Air Hose	1
	172529	. . Connector	1
	197322	. . Segmented Hose (Specify Length)	A.R.
	172528	. . Nozzle	1
	203271	. Grommet (Not Shown)	1
	When Air Table is Also Supplied:		
14	120857	. Service Tee (Brass)	1
	Following Not Shown and Used When Air Compressor Option is Supplied:		
	168156	. Air Compressor (1/8 H.P.)	1
	168614	. Air Compressor (1/4 H.P.)	1
	198026	. Screw, Hex. Hd. Cap 5/16-18NC x 5/8	4
	199323	. Washer, Lock 5/16 Std.	4
	016160	. 90° Cord Grip Connector (.500-.625)	1
	197218	. Electrical Cord (#14-4 Conductor)	A.R.

NEW DRG.
S.C.L. 9-24-97
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S.C.L. 2-11-08



#020045 - BRACKET
FOR SIDE MOUNTING



DISC CUTTER ASSEMBLY

C - 10 - 2 CM - 9 - 1 Z - 9 - 4

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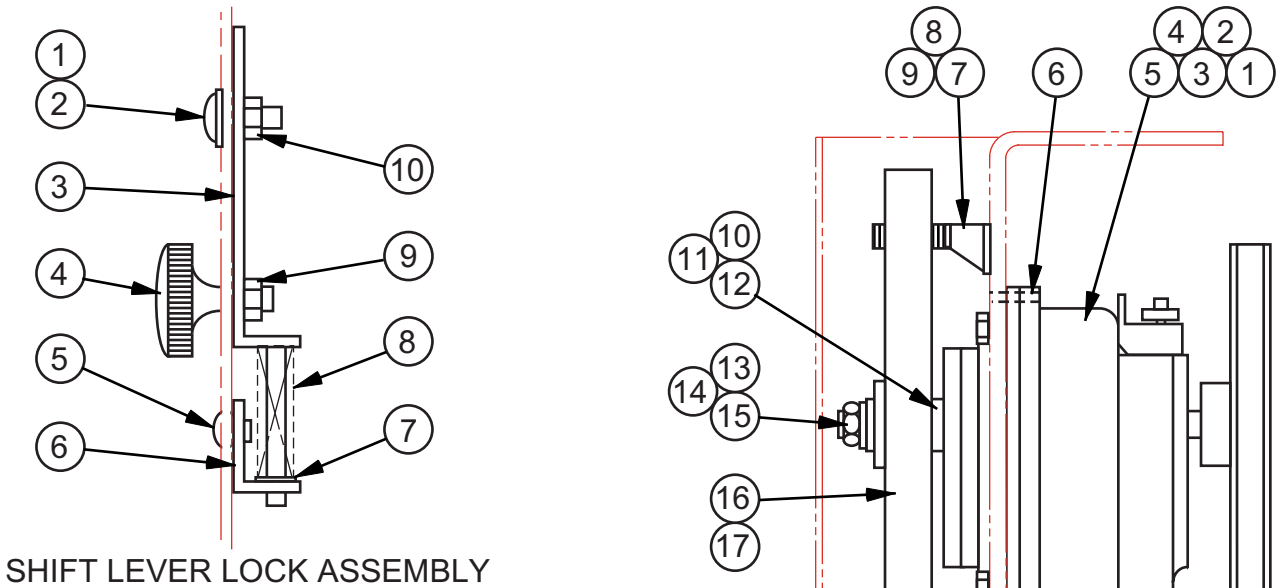
DISC CUTTER ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	402080	Disc Cutter Assembly (Rear Mounted)	
Ref.	040044	Disc Cutter Assembly (Side Mounted)	
1	039019	. Bracket (Rear Mounted)	1
	020045	. Bracket (Side Mounted)	1
2	004276	. Spring Pin (Rear Mounted)	1
	004275	. Spring Pin (Side Mounted)	1
3	35-003400	. Radius Arm Clamp	1
4	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
5	199325	. Washer, Lock 3/8 Std.	2
6	219409	. Adjustment Rod (w/ #202383 Adhesive)	1
7	35-003399	. Radius Arm	1
8	5-015109	. Adjustment Housing	1
9	004261	. Spring Pin	1
10	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	1
11	199325	. Washer, Lock 3/8 Std.	1
12	35-003402	. Center Pin Clamp	1
13	5-015412	. Adjustment Wheel	1
14	35-003401	. Center Adjusting Tube	1
15	5-015415	. Center Pin	1
16	198029	. Screw, Hex. Hd. Cap 5/16-18NC x 1	1
17	199323	. Washer, Lock 5/16 Std.	1

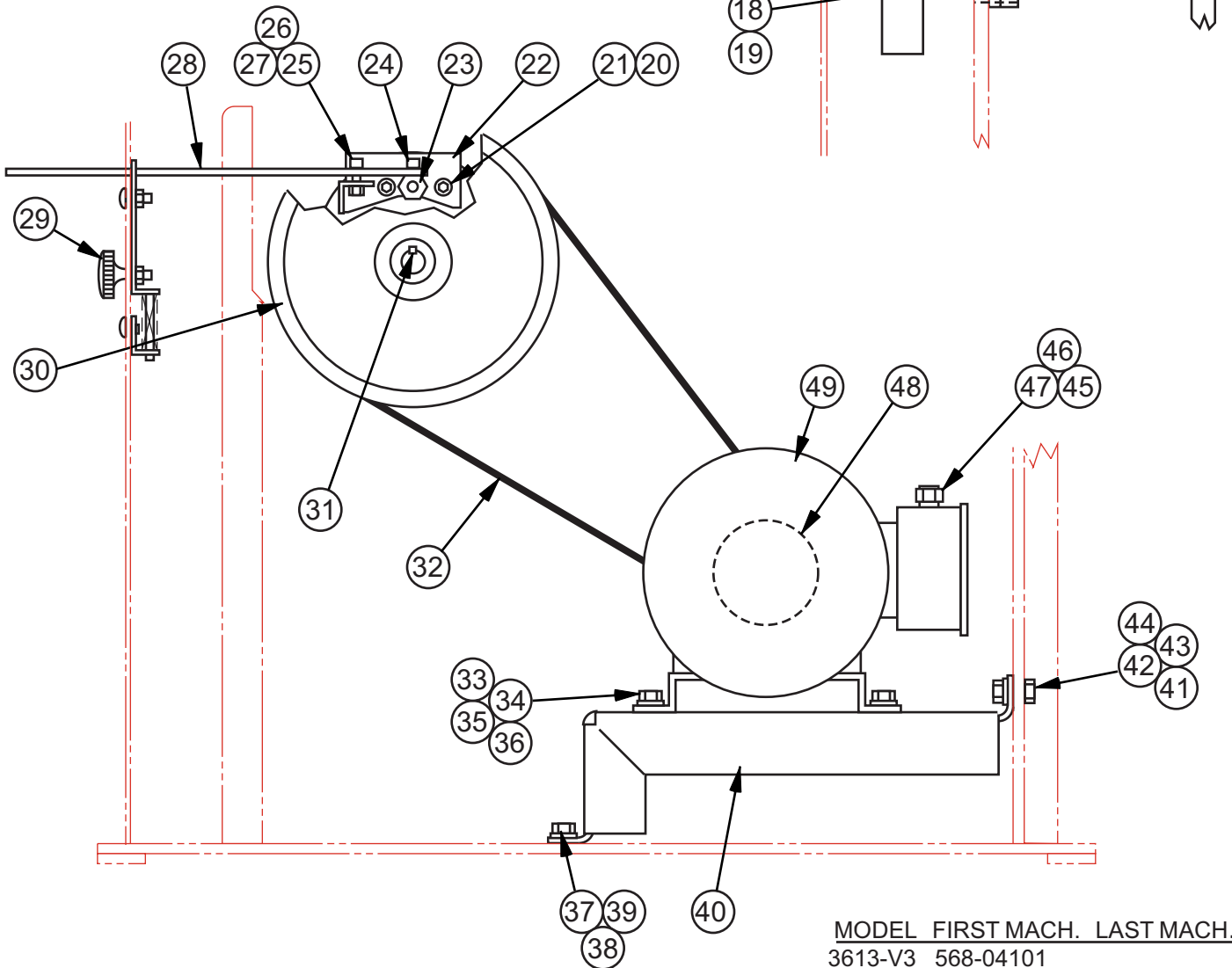
Following Not Shown and Used For Mounting to the Post:

198029	. Screw, Hex. Hd. Cap 5/16-18NC x 1 (Rear Mounted)	2
198031	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/2 (Side Mounted)	2
199262	. Washer, Flat 5/16 S.A.E. Std.	2
199323	. Washer, Lock 5/16 Std.	2
131797	. Cloth Bag	1
34-020308	. Wrench (If Supplied)	1

NEW DRG.	S.C.L. 2-25-04
REVISIONS	
S.C.L. 2-14-08	
S.C.L. 8-3-09	



SHIFT LEVER LOCK ASSEMBLY



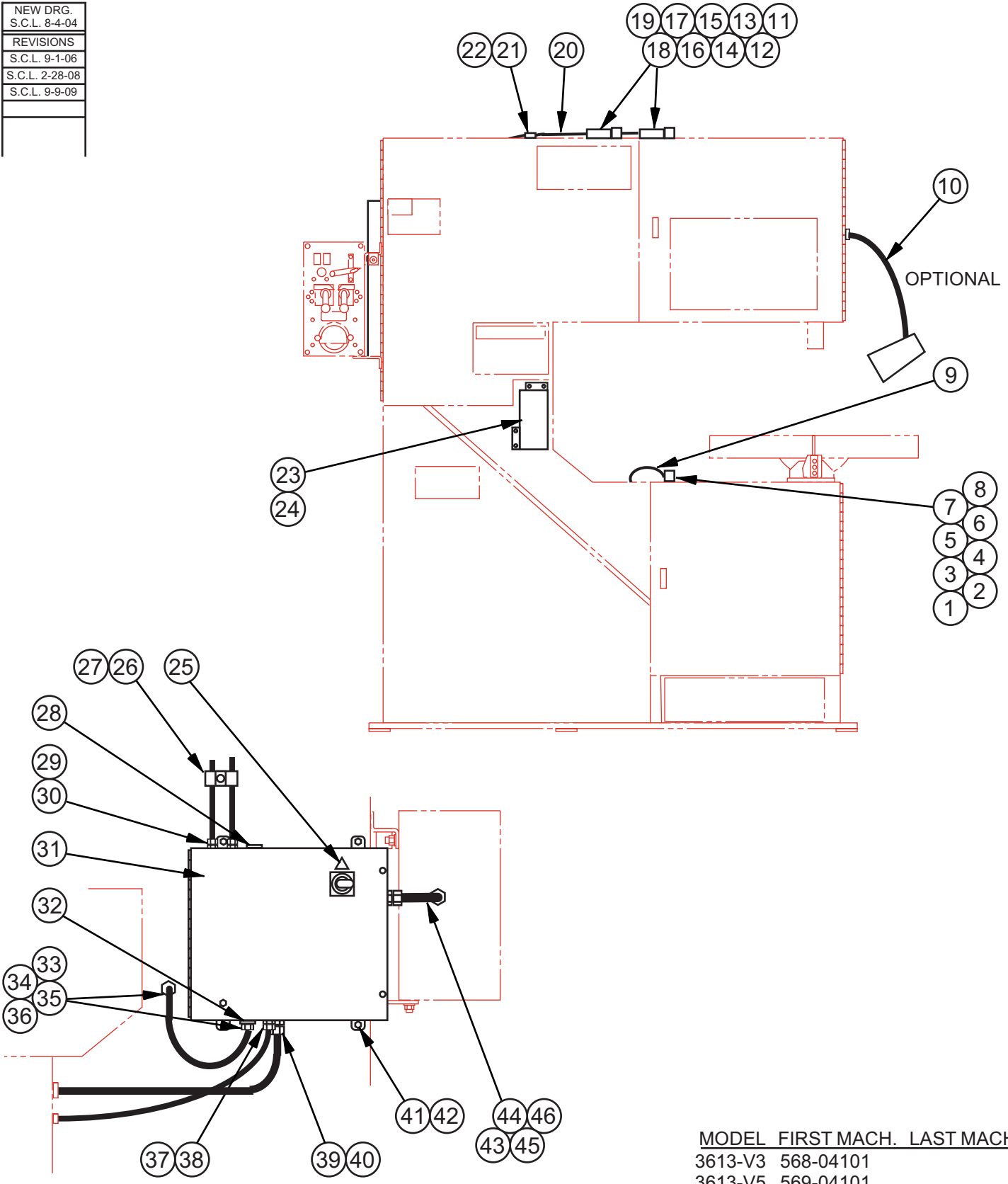
DRIVE ASSEMBLY

MODEL FIRST MACH. LAST MACH.
 3613-V3 568-04101
 2013-V3 572-04101

DRIVE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	211859	Drive Assembly	
1	506827	. Transmission Assembly (See Detail)	1
2	133570	. Shim (.005)	A.R.
3	133571	. Shim (.008)	A.R.
4	133572	. Shim (.010)	A.R.
5	133573	. Shim (.020)	A.R.
6	260380	. Dowel Pin	2
7	016664	. Brush Holder Weldment	1
8	016684	. Wheel Brush	1
9	199020	. Screw, Pan Hd. Mach. 1/4-20NC x 1/2	2
10	133316	. Spacer (.014/.016)	A.R.
11	133317	. Spacer (.028/.032)	A.R.
12	133318	. Spacer (.127/.143)	A.R.
13	199140	. Nut, Hex. Jam 3/4-10NC	1
14	199378	. Washer, Lock 3/4 Shakeproof Ext.	1
15	199268	. Washer, Flat 3/4 S.A.E. Std.	1
16	039712	. Bandwheel Assembly (See Detail)	1
17	5-004604	. Woodruff Key	1
18	198031	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/2	4
19	199323	. Washer, Lock 5/16 Std.	4
20	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2	2
21	199321	. Washer, Lock 1/4 Std.	2
22	315179	. Shift Arm Mounting Bracket	1
23	172399	. Adaptor	1
24	174055	. Screw, Soc. Hd. Shoulder 1/4-20NC x 3/8	1
25	120796	. Screw, Soc. Hd. Shoulder 1/4-20NC x 3/8	1
26	199321	. Washer, Lock 1/4 Std.	1
27	199176	. Nut, Hex. 1/4-20NC	1
28	314674	. Shift Lever	1
29	207684	. Shift Lever Lock Assembly (Manual) (See Detail)	1
	315351	. Shift Lock Assembly (110/120V, 50/60Hz) (Electrical) (Optional) (See Detail)	1
30	220219	. Pulley	1
31	7-001345	. Key	1
32	209500	. V-Belt	1
33	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	4
34	199325	. Washer, Lock 3/8 Std.	4
35	199264	. Washer, Flat 3/8 S.A.E. Std.	4
36	199126	. Nut, Hex. 3/8-16NC	4
37	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	3
38	199325	. Washer, Lock 3/8 Std.	3
39	199264	. Washer, Flat 3/8 S.A.E. Std.	3
40	518413	. Base Plate Weldment	1
41	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
42	199325	. Washer, Lock 3/8 Std.	2
43	199264	. Washer, Flat 3/8 S.A.E. Std.	2
44	199126	. Nut, Hex. 3/8-16NC	2
45	015619	. Cord Grip Connector	1
46	014480	. Flange Washer	1
47	015607	. Bond Nut	1
48	220218	. Motor Pulley	1
49	209624	. Electric Motor	1
	209625	. Electric Motor (575V Only)	1
Ref.	207684	. Shift Lever Lock Assembly (Manual)	
1	198368	. . Screw, Button Hd. Soc. 1/4-20NC x 3/4	1
2	199260	. . Washer, Flat 1/4 S.A.E. Std.	1
3	320835	. . Slide Plate and Pin Weldment	1
4	014910	. . Thumbscrew	1
5	198321	. . Screw, Button Hd. Soc. #10-24NC x 3/8	1
6	207682	. . Spring Support Bracket	1
7	199260	. . Washer, Flat 1/4 S.A.E. Std.	1
8	134024	. . Compression Spring	1
9	016809	. . Self-Locking Nut 5/16-18NC	1
10	100902	. . Self-Locking Nut 1/4-20NC	1

NEW DRG.
S.C.L. 8-4-04
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S.C.L. 9-1-06
S.C.L. 2-28-08
S.C.L. 9-9-09



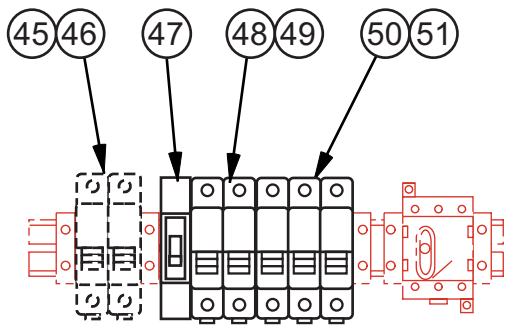
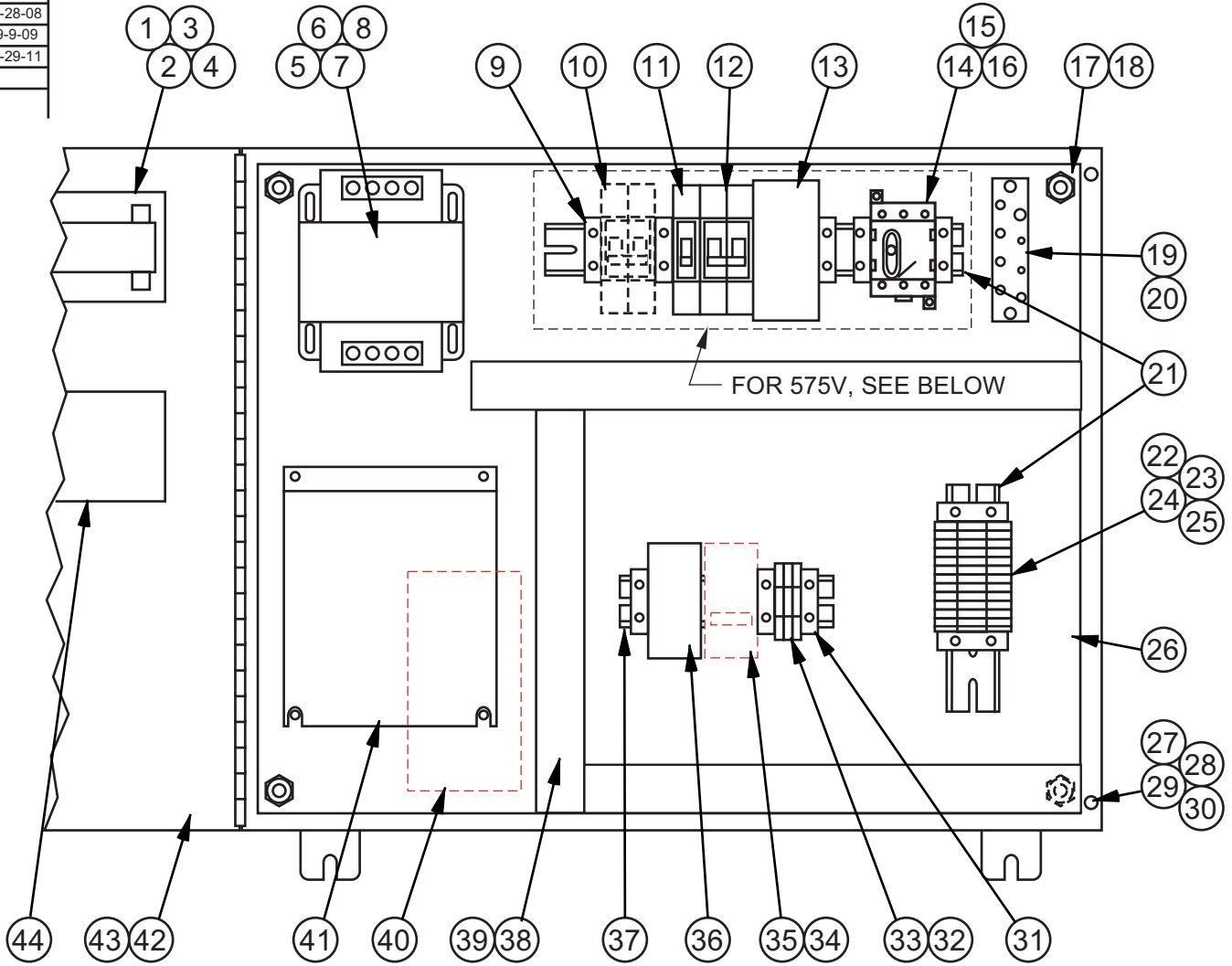
MODEL FIRST MACH. LAST MACH.
 3613-V3 568-04101
 3613-V5 569-04101

ELECTRICAL ASSEMBLY

ELECTRICAL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Electrical Assembly	
1	215624	. Limit Switch (Door Interlock)	1
2	199683	. Screw, Soc. Hd. Cap #6-32NC x 1-1/4	2
3	222553	. Shim (10 Ga.) (Limit Switch)	A.R.
4	215619	. Cord Grip Connector (.236-.472)	1
5	221854	. Mounting Bracket	1
6	221855	. Shim (.032)	1
7	198210	. Screw, Soc. Hd. Cap #8-32NC x 3/8	2
8	198220	. Screw, Soc. Hd. Cap #10-24NC x 1/2	2
9	197332	. Electrical Cord (#18-2 Conductor)	A.R.
10	220670	. Worklamp Assembly (Optional) (See Detail)	1
11	215624	. Limit Switch (Door Interlock)	2
12	199683	. Screw, Soc. Hd. Cap #6-32NC x 1-1/4	4
13	199273	. Washer, Flat #6 S.A.E. Std.	A.R.
14	222553	. Shim (10 Ga.) (Limit Switch)	A.R.
15	215619	. Cord Grip Connector (.236-.472)	2
16	221854	. Mounting Bracket	2
17	221855	. Shim (.032)	1
18	198210	. Screw, Soc. Hd. Cap #8-32NC x 3/8	4
19	198220	. Screw, Soc. Hd. Cap #10-24NC x 1/2	4
20	197332	. Electrical Cord (#18-2 Conductor)	A.R.
21	009955	. Hose Clip	2
22	198346	. Screw, Button Hd. Soc. #8-32NC x 3/8	1
23		. Pushbutton Box Assembly (See Detail)	1
24	198349	. Screw, Button Hd. Soc. 1/4-20NC x 1/2	4
25	176528	. Label (Electrical Hazard)	1
26	009955	. Hose Clip	2
27	198346	. Screw, Button Hd. Soc. #8-32NC x 3/8	1
28	135106	. Hole Seal	1
29	201688	. Cord Grip Connector (.200-.394)	2
30	197332	. Electrical Cord (#18-2 Conductor)	A.R.
31		. Electrical Control Box Assembly (See Detail)	1
32	135106	. Hole Seal	1
33	014545	. Sealtite Connector	2
34	014411	. Flange Washer	2
35	019543	. Bond Nut	2
36	197156	. Sealtite Conduit 1/2 I.D.	A.R.
37	201688	. Cord Grip Connector (.200-.394)	1
38	197332	. Electrical Cord (#18-2 Conductor)	A.R.
39	201687	. Cord Grip Connector (.545-.709)	2
40	197218	. Electrical Cord (#14-4 Conductor)	A.R.
41	198027	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4	4
42	199323	. Washer, Lock 5/16 Std.	4
43	014545	. Sealtite Connector (Buttwelder Option)	2
44	014411	. Flange Washer (Buttwelder Option)	2
45	019543	. Bond Nut (Buttwelder Option)	2
46	197156	. Sealtite Conduit 1/2 I.D. (Buttwelder Option)	A.R.

NEW DRG.
S.C.L. 7-21-04
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S.C.L. 2-28-08
S.C.L. 9-9-09
S.C.L. 9-29-11



FOR 575V MACHINES

MODEL FIRST MACH. LAST MACH.
3613-V3 568-04101

ELECTRICAL CONTROL BOX ASSEMBLY

ELECTRICAL CONTROL BOX ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Electrical Control Box Assembly		40	221312	. Dynamic Brake Module (575V Only) (If Supplied)	1
1	208728	. Mounting Bracket	2				
2*	1003545	. Resistor (60 Ohm) (208V, 220V, 230V)	1	41	1009580	. Variable Speed Controller (208V, 220V, 230V)	1
	1003546	. Resistor (250 Ohm) (400V, 460V)	1		1009581	. Variable Speed Controller (Mitsubishi) (400V, 460V)	1
	1003547	. Resistor (350 Ohm) (575V)	1		1001718	. Variable Speed Controller (Mitsubishi) (575V)	1
3	208719	. Resistor Cover	1		222877	. Line Reactor (575V Only) (If Supplied)	1
4	107777	. Plastic Push Rivet	2	42	517348	. Enclosure Weldment	1
5	319088	. Transformer (208V)	1	43	203925	. Gasket Strip	A.R.
	319087	. Transformer (220V, 230V, 460V, 575V)	1	44	221381	. Fuse/Overload Schedule	1
	217752	. Transformer (400V)	1				
6	199202	. Nut, Hex. M5-0.8	4				
7	199348	. Washer, Lock M5	4				
8	169674	. Mounting Channel	A.R.				
9	200618	. End Stop	3				
10	1007405	. Circuit Breaker (Buttwelder Option)	1	45	215212	. Fuse Block	2
11	420355	. Circuit Breaker	1	46	203614	. Fuse (8 Amp)	2
12	1007398	. Circuit Breaker (208V, 220V, 230V)	1	47	420355	. Circuit Breaker	1
	1007397	. Circuit Breaker (400V)	1	48	215212	. Fuse Block	2
	1007572	. Circuit Breaker (460V)	1	49	206701	. Fuse (.5 Amp)	2
13	220648	. Motor Starter Protector (208V, 220V, 230V)	1	50	215213	. Fuse Block (#220646 - Motor Starter Protector Before Serial #568-04105)	1
	220647	. Motor Starter Protector (400V, 460V)	1	51	203613	. Fuse (10 Amp)	3
14**	1007434	. Disconnect Switch	1				
15**	1007441	. Disconnect Switch Shaft	1				
16**	1007437	. Disconnect Switch Handle	1				
17	199126	. Nut, Hex. 3/8-16NC	4				
18	199325	. Washer, Lock 3/8 Std.	4				
19	320740	. Grounding Bus	1				
20	141639	. Wire Terminal Lug	1				
21	169674	. Mounting Channel	A.R.				
22	200615	. Terminal Block (Gray)	12				
23	200617	. End Section	2				
24	200618	. End Stop	2				
25	200994	. Terminal Block Marker Set	A.R.				
26	520141	. Control Panel	1				
27	207525	. Rivet Nut M6-1.0	2	2	207786	. Resistor (40 Ohm) (208V, 220V, 230V)	1
28	207523	. Screw, Hex. Hd. Slotted M6-1.0 x 20	2		219330	. Resistor (160 Ohm) (400V, 460V)	1
29	204153	. Nylon Washer	2				
30	204151	. Retainer	2				
31	200618	. End Stop	3				
32	200615	. Terminal Block (Gray)	3				
33	200617	. End Section	1				
34	220233	. Control Relay (575V Only) (If Supplied)	1				
35	220234	. Suppressor (575V Only) (If Supplied)	1				
36	207200	. Control Relay	1				
37	169674	. Mounting Channel	A.R.				
38	197208	. 1" Wiring Channel	A.R.				
39	197210	. 1" Wiring Channel Cover	A.R.				

For 575V Machines:

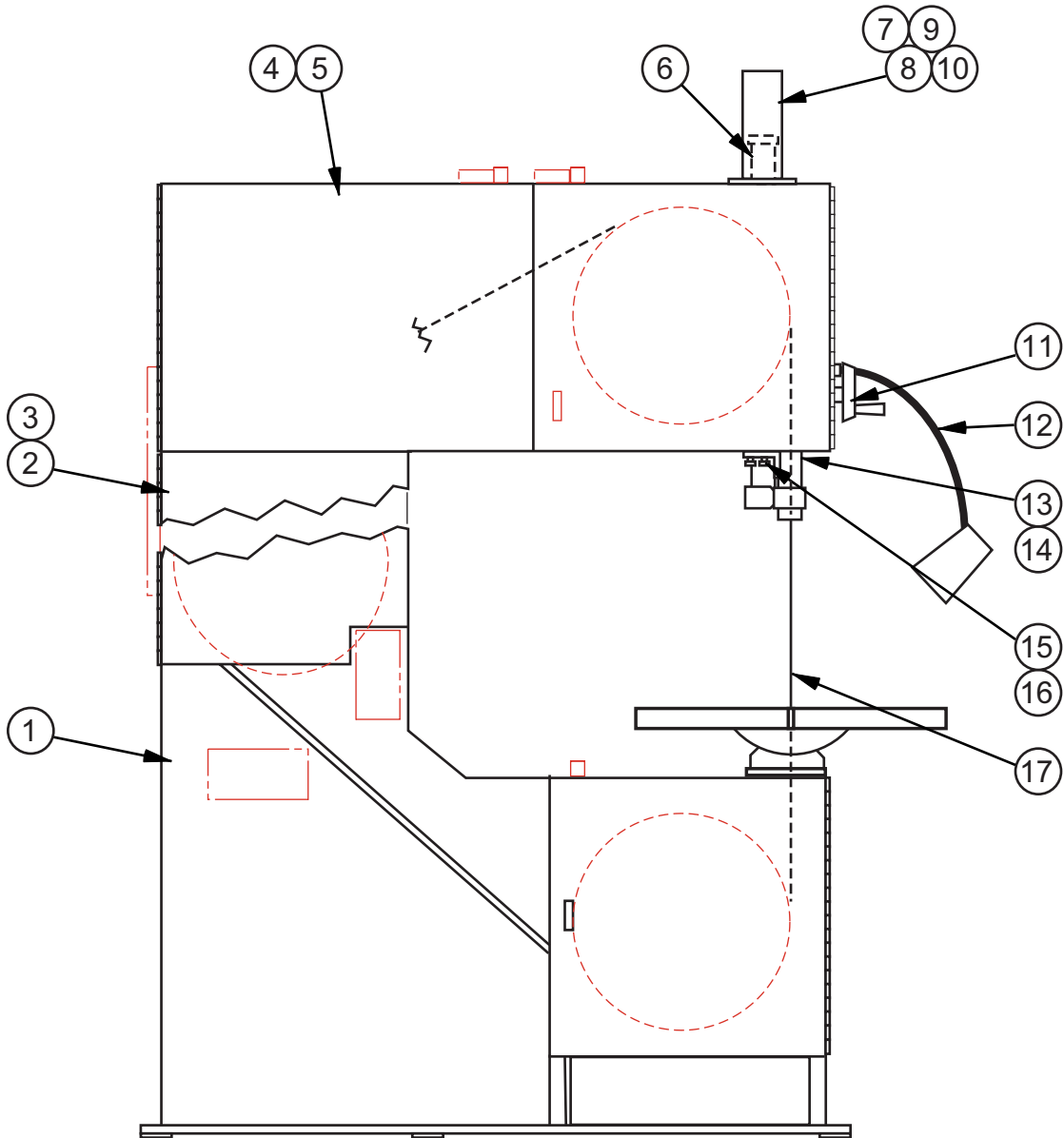
Following Not Shown:

***NOTE: For Non-Mitsubishi VFDs:**

****NOTE: Before Serial #568-09158:**

Order Disconnect Switch Service Kit - #1007668.
Otherwise, Use Part Numbers Listed.

NEW DRG. S.C.L. 7-8-04
REVISIONS
S.C.L. 9-1-06
S.C.L. 2-27-08
S.C.L. 9-9-09



MODEL FIRST MACH. LAST MACH.

3613-1 577-04101

3613-V3 568-04101

3613-V5 569-04101

3612-VH 570-04101

EXTRA WORK HEIGHT ASSEMBLY

C - 2 - 121 CM - 2 - 134

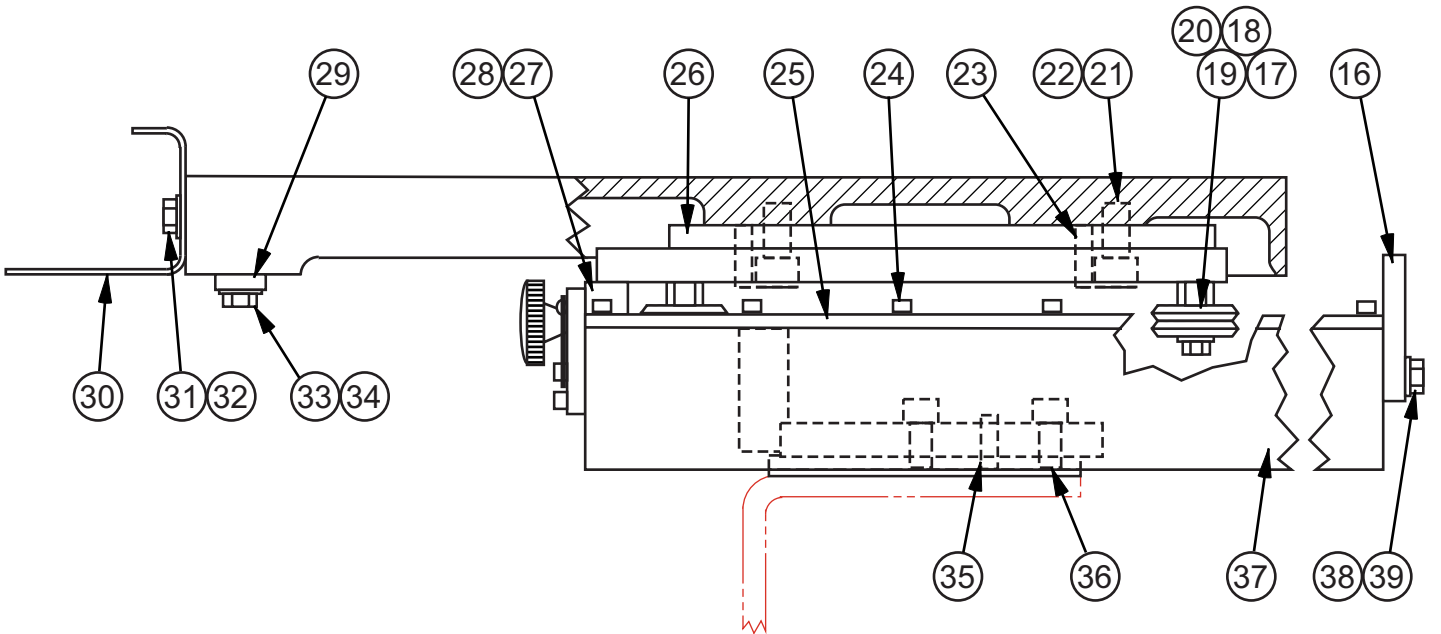
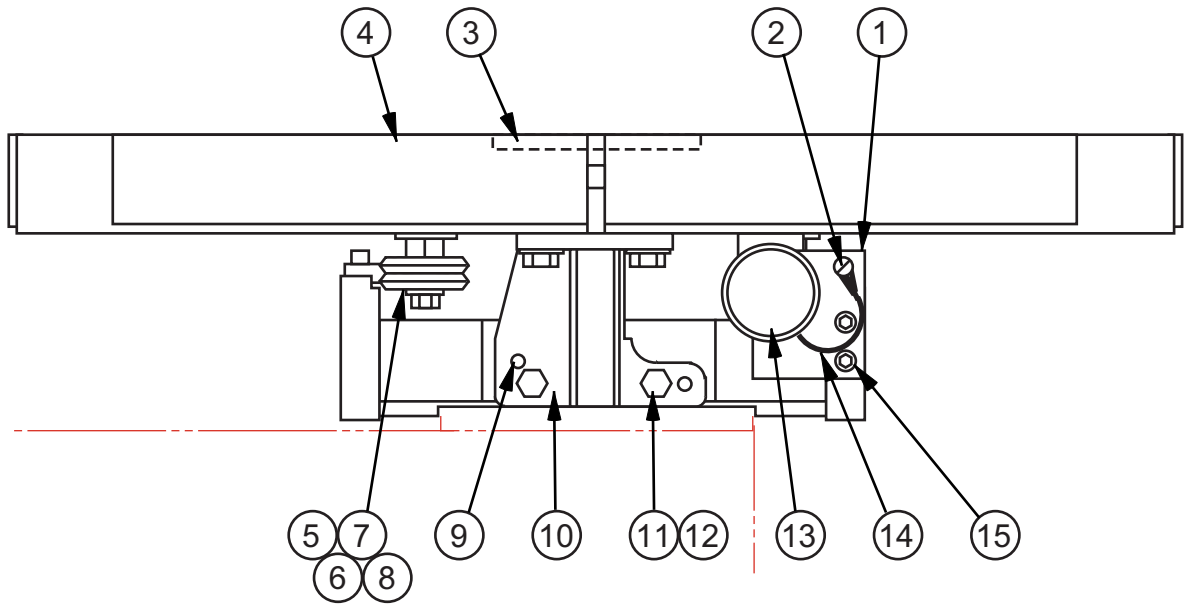
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EXTRA WORK HEIGHT ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	221234	19" Work Height Assembly (3619-1, 3619-V3, 3619-V5)	
Ref.	221195	18" Work Height Assembly (3618-VH)	
Ref.	221235	25" Work Height Assembly (3625-1, 3625-V3, 3625-V5)	
Ref.	221196	24" Work Height Assembly (3624-VH)	
Ref.	221236	31" Work Height Assembly (3631-1, 3631-V3, 3631-V5)	
Ref.	221197	30" Work Height Assembly (3630-VH)	
1	521631	. Frame Weldment (18" and 19" Work Heights)	1
	521632	. Frame Weldment (24" and 25" Work Heights)	1
	521633	. Frame Weldment (30" and 31" Work Heights)	1
2	420983	. Door Weldment (18" and 19" Work Heights)	1
	521638	. Door Weldment (24" and 25" Work Heights)	1
	521639	. Door Weldment (30" and 31" Work Heights)	1
3	199299	. Screw, Hex. Hd. Self-Drill M4.8 x 13	A.R.
4	420959	. Door Weldment	1
5	199299	. Screw, Hex. Hd. Self-Drill M4.8 x 13	6
6	506149	. Auxiliary Post Support Assembly (Work Heights Over 19") (See Detail)	1
7	326507	. Post Screw Cover Weldment (Work Heights Over 19")	1
8	198007	. Screw, Hex. Hd. Cap 1/4-20NC x 5/8	4
9	199321	. Washer, Lock 1/4 Std.	4
10	199115	. Nut, Hex. 1/4-20NC	4
11	407860	. Post Elevating Handwheel Assembly (18" and 19" Work Heights) (See Detail)	1
	407729	. Post Elevating Handwheel Assembly (24" and 25" Work Heights) (See Detail)	1
	407618	. Post Elevating Handwheel Assembly (30" and 31" Work Heights) (See Detail)	1
12	220671	. Worklamp Assembly (Optional) (See Detail)	1
13	306436	. Saw Band Guard Assembly (18" and 19" Work Heights)	1
	306312	. Saw Band Guard Assembly (24" and 25" Work Heights)	1
	305508	. Saw Band Guard Assembly (30" and 31" Work Heights)	1
	316926	. . Guard Weldment (18" and 19" Work Heights)	1
	316927	. . Guard Weldment (24" and 25" Work Heights)	1
	316923	. . Guard Weldment (30" and 31" Work Heights)	1
	316934	. . Guard Slide Cover	1
	133372	. . Thumb Screw	1
14	105304	. Spring Pin (Work Heights Up To 25" Only)	1
	004269	. Spring Pin (30" and 31" Work Heights Only)	1
15*	325695	. Guard Slide (Post) (6-5/8")	1
*	325696	. Guard Slide (Post) (12-5/8")	1
*	325697	. Guard Slide (Post) (18-5/8")	1
16	133372	. Thumb Screw	2
17	221229	. Saw Band (Super Silencer) (18" and 19" Work Heights)	1
	221230	. Saw Band (Super Silencer) (24" and 25" Work Heights)	1
	221231	. Saw Band (Super Silencer) (30" and 31" Work Heights)	1

*NOTE: Use These Interchangeable Guard Slides When Applicable.
 Use The Guard Slide That Will Cover Exposed Saw Band Completely.

NEW DRG.
S.C.L. 2-25-04
REVISIONS
S.C.L. 9-9-07
S.C.L. 2-11-08

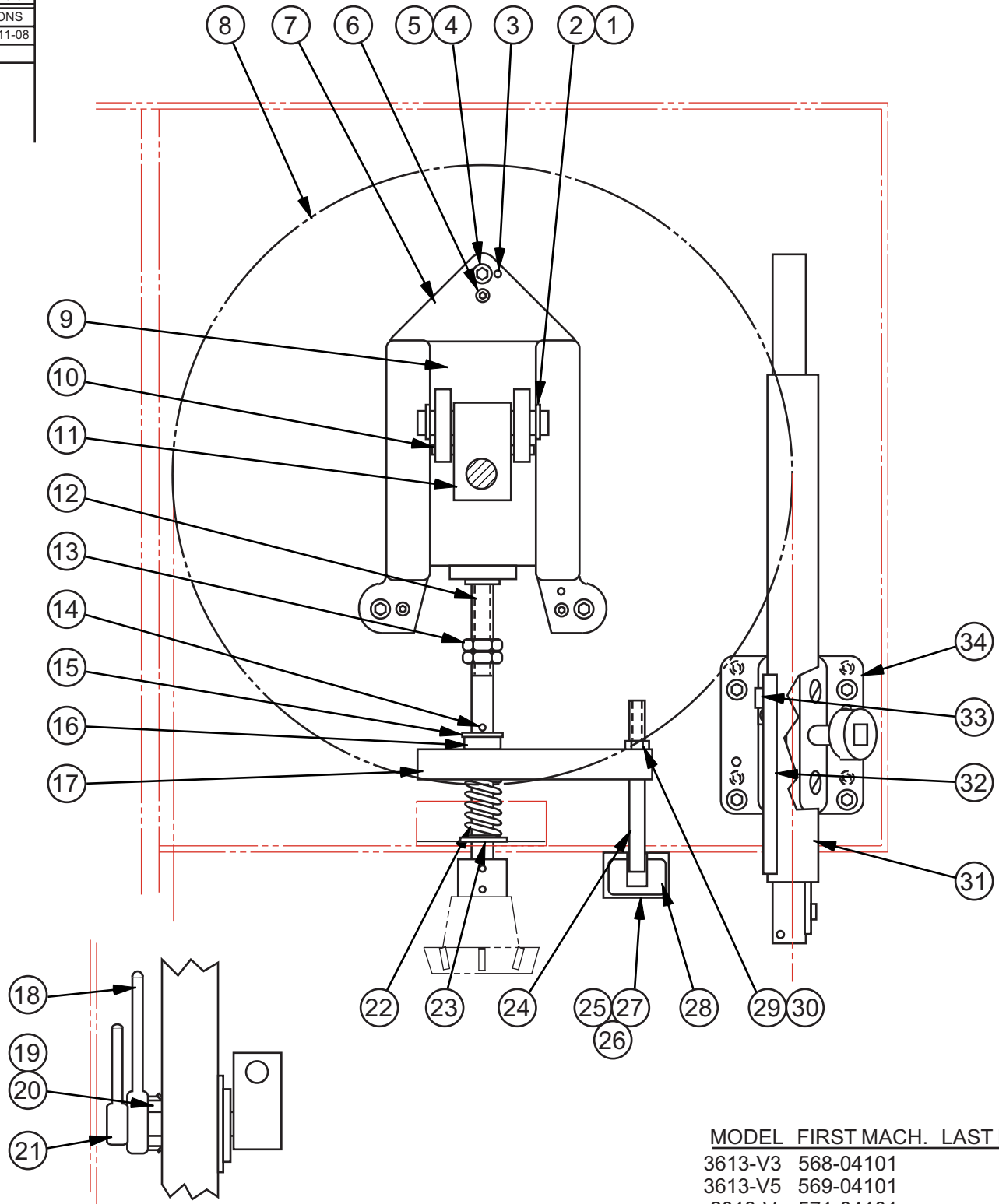


GLIDE TABLE ASSEMBLY

GLIDE TABLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY.
Ref.	208104	Glide Table Assembly (12" Stroke)	
Ref.	220893	Glide Table Assembly (18" Stroke)	
1	208103	. Stop Plate (12" Stroke)	1
	220880	. Stop Plate (18" Stroke)	1
2	198346	. Screw, Button Hd. Soc. #8-32NC x 3/8	1
3	316903	. Center Plate (Oval)	1
4	514113	. Table (12" Stroke)	1
	521541	. Table Weldment (18" Stroke)	1
5	208038	. Guide Wheel	3
6	208036	. Bushing Adaptor (L.H. Side)	3
7	198031	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/2	3
8	199323	. Washer, Lock 5/16 Std.	3
9	35-000516	. Dowel Pin	2
10	321271	. Lower Post Block	1
11	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
12	199325	. Washer, Lock 3/8 Std.	2
13	208041	. Thumbscrew Weldment	1
14	208102	. Lanyard	1
15	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8	2
16	320999	. End Bar (12" Stroke)	1
	325833	. End Bar Weldment (18" Stroke)	1
17	208038	. Guide Wheel	3
18	208035	. Adjustable Bushing Adaptor (R.H. Side)	3
19	198031	. Screw, Hex. Hd. Cap 5/16-18NC x 1-1/2	3
20	199323	. Washer, Lock 5/16 Std.	3
21	198295	. Screw, Soc. Hd. Cap 1/2-13NC x 1-1/2	4
22	199327	. Washer, Lock 1/2 Std.	4
23	198441	. Screw, Soc. Set 5/16-18NC x 1-1/4	4
24	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8	18
25	208037	. Track (12" Stroke)	2
	220874	. Track (18" Stroke)	2
26	418051	. Roller Support Weldment (12" Stroke)	1
	325872	. Glide Table Plate (18" Stroke)	1
27	209106	. Stop Block (12" Stroke)	1
	220889	. Stop Block (18" Stroke)	1
28	199811	. Screw, Button Hd. Soc. 1/4-20NC x 1-1/2	2
29	004599	. Front Table Clamp	1
30	418419	. Glide Table Handle	1
31	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	2
32	199264	. Washer, Flat 3/8 S.A.E. Std.	2
33	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
34	199264	. Washer, Flat 3/8 S.A.E. Std.	2
35	14-00473	. Dowel Pin	2
36	198293	. Screw, Soc. Hd. Cap 1/2-13NC x 1	3
37	517672	. Table Support Weldment (12" Stroke)	1
	521540	. Table Support Weldment (18" Stroke)	1
38	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
39	199325	. Washer, Lock 3/8 Std.	2

NEW DRG.
S.C.L. 2-25-04
REVISIONS
S.C.L. 2-11-08



MODEL FIRST MACH. LAST MACH.

3613-V3	568-04101
3613-V5	569-04101
2013-V	571-04101
2013-V3	572-04101
2013-V5	573-04101
3613-1	577-04101

HEAD ASSEMBLY

HEAD ASSEMBLY

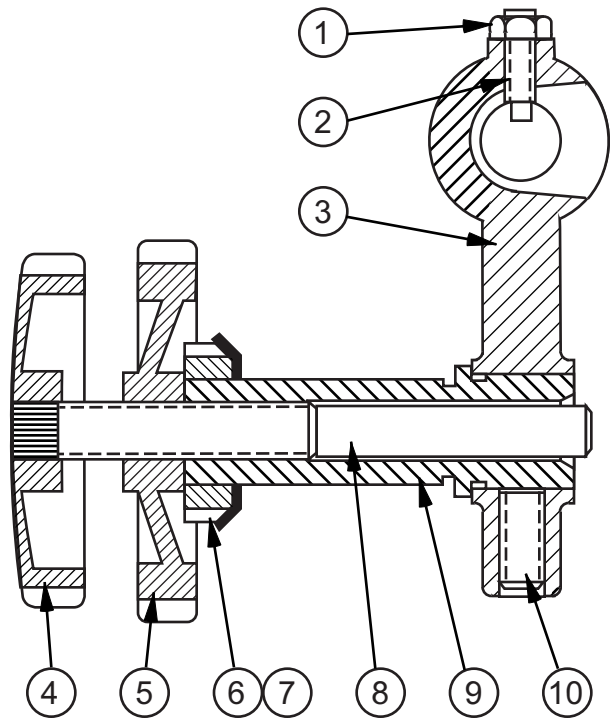
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY.
Ref.	520279	Head Assembly	
1	120627	. Pin	1
2	35-009613	. Retaining Ring	2
3	004265	. Spring Pin	2
4	198264	. Screw, Soc. Hd. Cap 5/16-18NC x 2	3
5	199323	. Washer, Lock 5/16 Std.	3
6	198440	. Screw, Soc. Set 5/16-18NC x 1	3
7	504621	. Head Casting	1
8	402598	. Bandwheel Assembly (See Detail)	1
9	415369	. Head Slide Weldment	1
10	178228	. Screw, Soc. Set 1/4-20NC x 5/8 (Self Locking, Half Dog Point)	2
11	302346	. Wheel Hinge Assembly (See Detail)	1
12	319429	. Band Tension Screw Sub-Assembly	1
	203548	. . Adaptor	1
	139123	. . Screw	1
	004261	. . Spring Pin	1
13	199132	. Nut, Hex. Jam 1/2-13NC	2
14	004259	. Spring Pin	1
15	199266	. Washer, Flat 1/2 S.A.E. Std.	2
16	35-002810	. Thrust Ball Bearing	1
17	144062	. Angle	1
18	319252	. Lock Handle	1
19	5-001506	. Bearing Locknut	1
20	5-001507	. Bearing Lockwasher	1
21	319251	. Tilting Screw Handle (w/Stud)	1
22	35-008761	. Compression Spring	1
23	199267	. Washer, Flat 5/8 S.A.E. Std.	1
24	142250	. Band Tension Pointer	1
25	198001	. Screw, Hex. Hd. Cap #10-24NC x 1/2	2
26	199320	. Washer, Lock #10 Std.....	2
27	199111	. Nut, Hex. #10-24NC	2
28	117737	. Escutcheon (Band Tension) (Inch/English)	1
	131424	. Escutcheon (Band Tension) (Metric/International)	1
29	199123	. Nut, Hex. Jam 5/16-18NC	2
30	163080	. Retaining Compound (Loctite #271)	A.R.
31*	316925	. Guard Weldment (Standard)	1
32	316934	. Guard Slide Cover	1
33	133372	. Thumb Screw	1
34*	216836	. Post Assembly (Standard) (2013-V, 2013-V3, 2013-V5) (See Detail) .	1
*	221771	. Post Assembly (Standard) (3613-1, 3613-V3, 3613-V5) (See Detail) ..	1
*	404971	. Post Elevating Handwheel Assembly (Standard - Optional) (See Detail)	1

*NOTE: See Extra Work Height Assembly If Applicable.

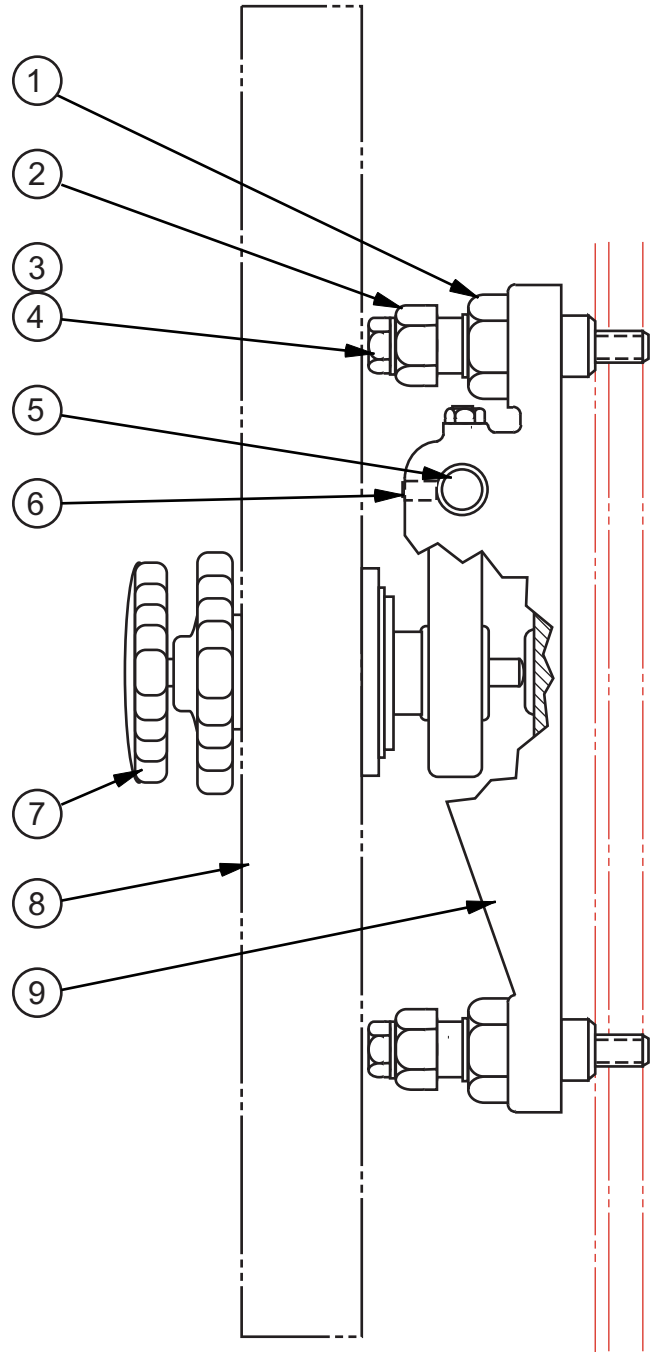
Following Not Shown:

148368	. Escutcheon (Post - Raise/Lower) (International)	1
199396	. Screw, Rd. Hd. Drive #2 x 3/16	3

NEW DRG. S.C.L. 7-8-04
REVISIONS
S.C.L. 2-27-08
S.C.L. 9-9-09



WHEL HINGE ASSEMBLY



MODEL	FIRST MACH.	LAST MACH.
3613-1	577-04101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	

IDLER BANDWHEEL ASSEMBLY (THIRD WHEEL)

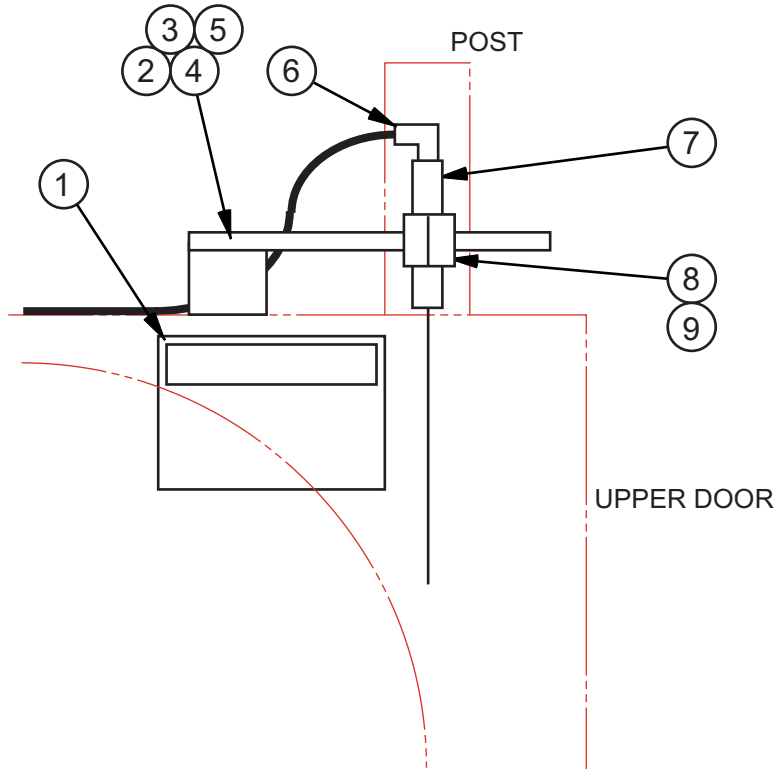
C - 2 - 120 CM - 2 - 133

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IDLER BANDWHEEL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	521622	Idler Bandwheel Assembly (Third Wheel) (Crowned Bandwheels)	
Ref.	521623	Idler Bandwheel Assembly (Third Wheel) (Flanged Bandwheels)	
1	199142	. Nut, Hex. Jam 3/4-16NF	3
2	208549	. Adjustable Screw	3
3	198053	. Screw, Hex. Hd. Cap 3/8-16NC x 2-3/4	3
4	199325	. Washer, Lock 3/8 Std.	3
5	35-008610	. Hinge Pin	1
6	198428	. Screw, Soc. Set 1/4-20NC x 1	2
7	021547	. Wheel Hinge Assembly (Idler) (See Detail)	1
8	402598	. Bandwheel Assembly (Idler) (Crowned Bandwheels) (See Detail)	1
	406558	. Bandwheel Assembly (Idler) (Flanged Bandwheels) (See Detail)	1
9	041264	. Bracket	1
Ref.	021547	. Wheel Hinge Assembly (Idler)	
1	199114	.. Nut, Hex. Jam 1/4-20NC	1
2	003862	.. Screw, Soc. Set 1/4-20NC x 3/4 (Dog Pt.)	1
3	021546	.. Wheel Hinge	1
4	5-001108	.. Tilting Screw Knob	1
5	5-001109	.. Tilting Locknut	1
6	5-001506	.. Bearing Locknut	1
7	5-001507	.. Bearing Lockwasher	1
8	5-001425	.. Tilting Screw	1
9	5-001424	.. Wheel Axis Stud	1
10	198451	.. Screw, Soc. Set 3/8-16NC x 3/4	1

NEW DRG. S.C.L. 3-17-09
REVISIONS



MODEL	FIRST MACH.	LAST MACH.
2012-VH	561-03101	
ZV-3620	565-03101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	
2012-D12	584-08101	

LASER LINE GENERATOR ASSEMBLY

C - 10 - 65 CM - 10 - 45 Z - 10 - 33

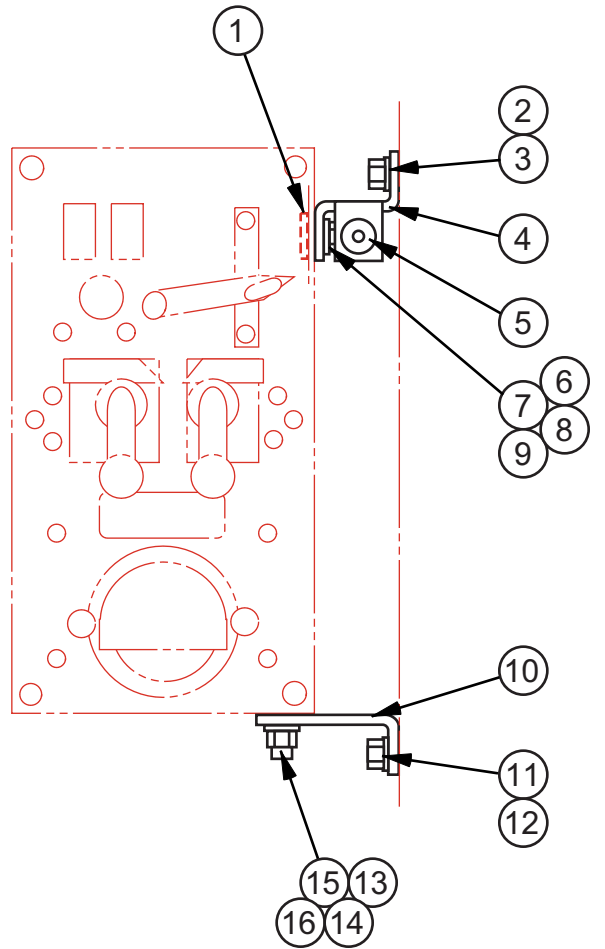
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LASER LINE GENERATOR ASSEMBLY

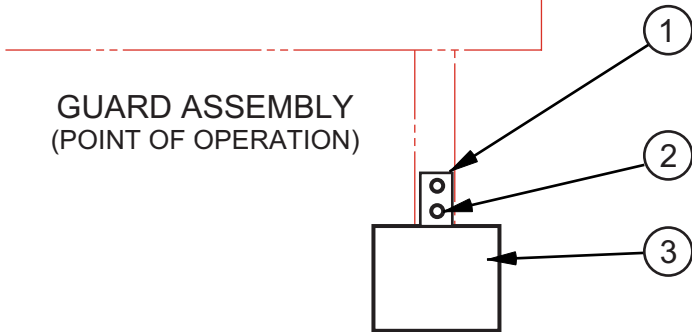
INDEX NO. Ref.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
		Laser Line Generator Assembly	
1	212884	. Label (Caution - Laser)	1
2	326740	. Laser Mounting Bracket Weldment	1
	322740	. Laser Mounting Bracket Weldment (ZV-3620 Only)	1
3	199923	. Screw, Soc. Hd. Cap M6-1.0 x 10	2
4	199965	. Washer, Flat M6	2
5	199347	. Washer, Lock M6	2
6	222859	. Laser Cordset	1
7	223548	. Laser Line Generator (Red) (24VDC)	1
8	322650	. Laser Holder	1
9	199993	. Screw, Soc. Hd. Cap M6-1.0 x 20	2

NEW DRG. S.C.L. 8-5-04
REVISIONS
S.C.L. 2-27-08
S.C.L. 9-9-09

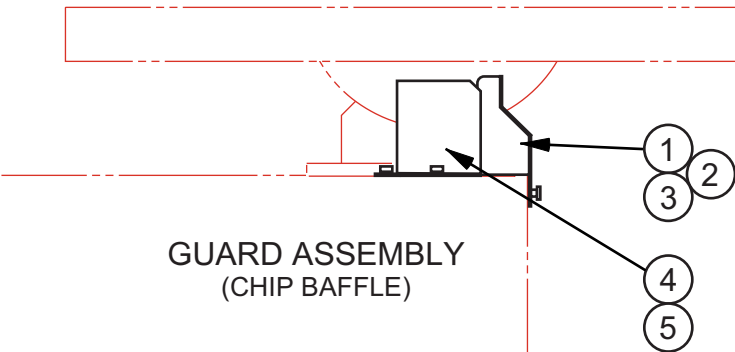
WELDER MOUNTING
BRACKET ASSEMBLY



GUARD ASSEMBLY
(POINT OF OPERATION)



GUARD ASSEMBLY
(CHIP BAFFLE)



MODEL	FIRST MACH.	LAST MACH.
3613-1	577-04101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	

MISCELLANEOUS ASSEMBLIES

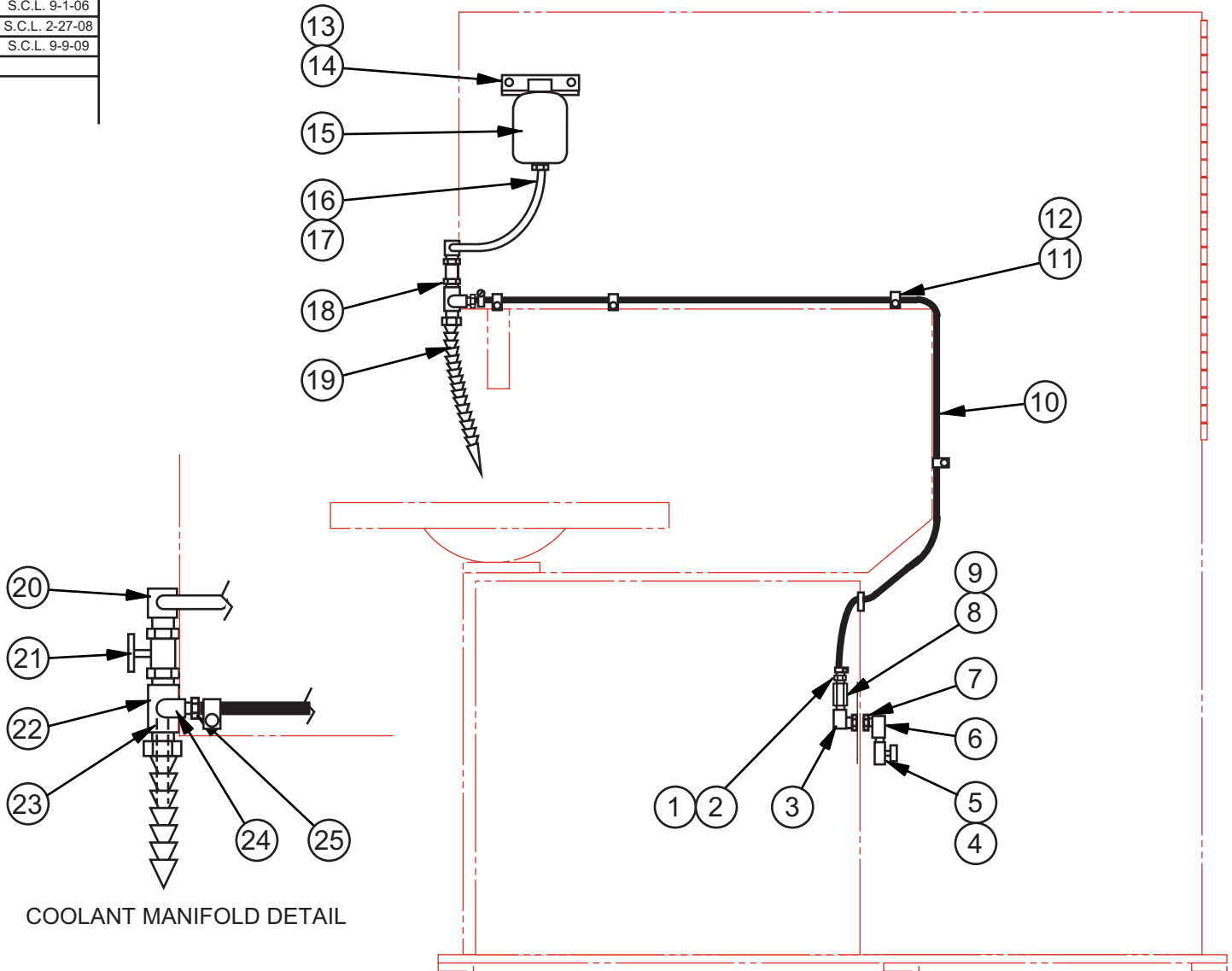
C - 10 - 64 CM - 10 - 46

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MISCELLANEOUS ASSEMBLIES

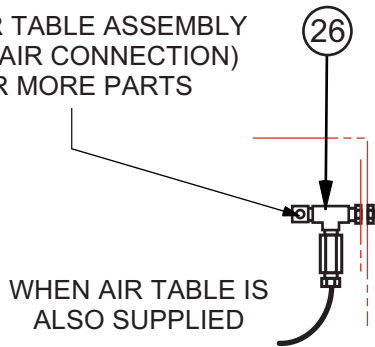
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	221216	Welder Mounting Bracket Assembly (With Optional Buttwelder)	
1	172397	. Bar	1
2	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	2
3	199325	. Washer, Lock 3/8 Std.	2
4	325921	. Upper Mounting Bracket	1
5	012235	. Rubber Grommet	1
6	198184	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
7	199325	. Washer, Lock 3/8 Std.	2
8	199264	. Washer, Flat 3/8 S.A.E. Std.	2
9	199126	. Nut, Hex. 3/8-16NC	2
10	325920	. Lower Mounting Bracket	1
11	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	2
12	199325	. Washer, Lock 3/8 Std.	2
13	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4	2
14	199325	. Washer, Lock 3/8 Std.	2
15	199264	. Washer, Flat 3/8 S.A.E. Std.	2
16	199126	. Nut, Hex. 3/8-16NC	2
Ref.	320639	Guard Assembly (Point of Operation) (Optional)	
1	213713	. Guard Mounting Plate	1
2	146046	. Thumb Screw Assembly	2
	131086	. . Knob	1
	198219	. . Screw, Soc. Hd. Cap #10-24NC x 3/8	1
2	203546	. Spacer	2
3	319337	. Upper Guard (Plexiglas)	1
Ref.	221612	Guard Assembly (Chip Baffle)	
1	326062	. Side Guard Weldment	1
2	133438	. Thumb Screw	2
3	164686	. Escutcheon (Remove Guard...) (English)	1
	163694	. Escutcheon (Remove Guard...) (International)	1
4	326063	. Door Guard	1
5	199299	. Screw, Hex. Hd. Self-Drill M4.8 x 13	2

NEW DRG.
S.C.L. 7-2-04
REVISIONS
S.C.L. 9-1-06
S.C.L. 2-27-08
S.C.L. 9-9-09



COOLANT MANIFOLD DETAIL

SEE AIR TABLE ASSEMBLY
(SHOP AIR CONNECTION)
FOR MORE PARTS



WHEN AIR TABLE IS
ALSO SUPPLIED

MODEL FIRST MACH. LAST MACH.

3613-1 577-04101

3613-V3 568-04101

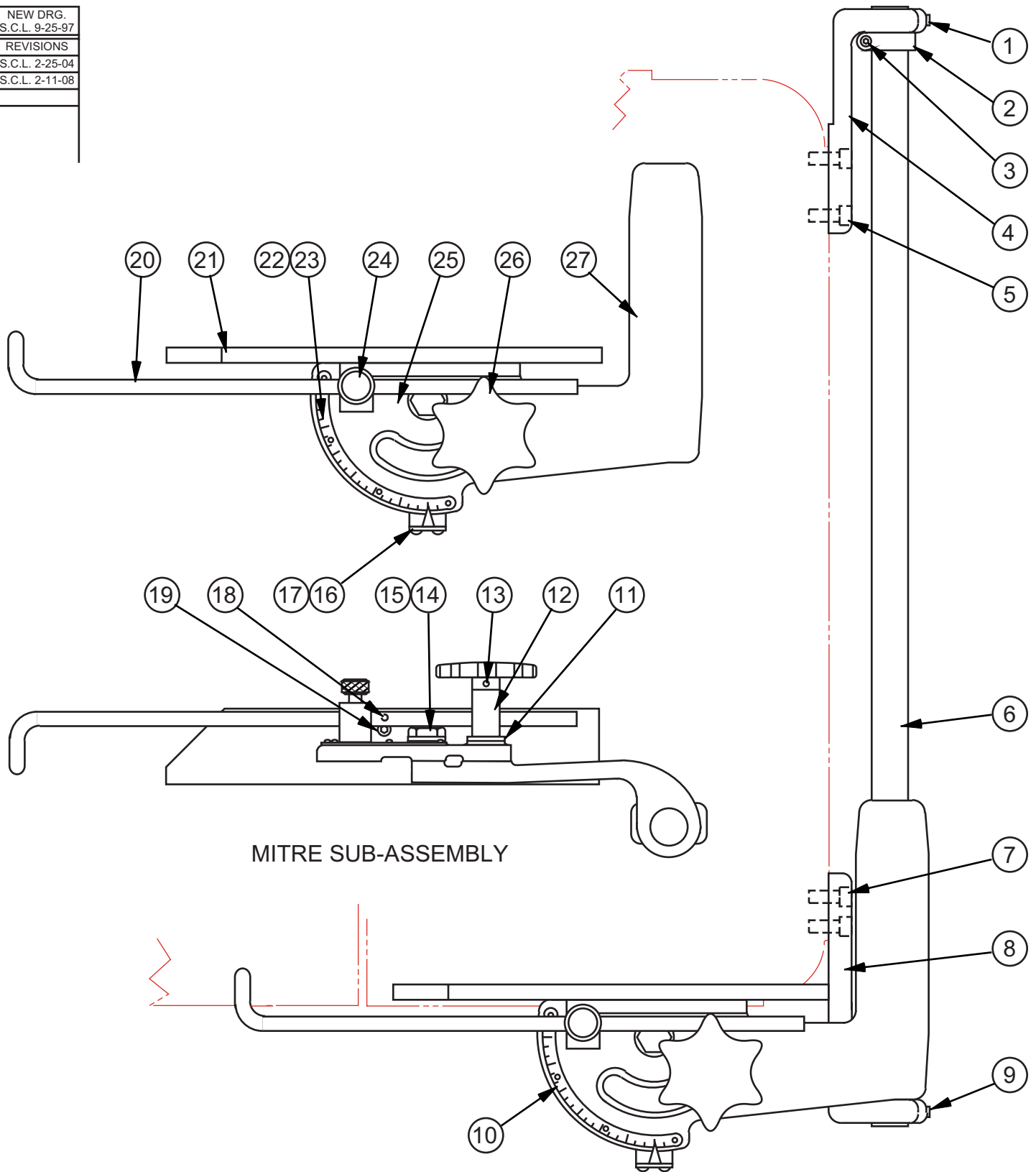
3613-V5 569-04101

MIST COOLANT ASSEMBLY (AND RELATED ITEMS)

**MIST COOLANT ASSEMBLY
(And Related Items)**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY.
Ref.	211180	Mist Coolant Assembly	
Ref.	211182	Mist Coolant Assembly (w/Sliding Air Table Option)	
1	002004	. Barbed Insert	1
2	35-006888	. Hose Clamp	1
3	008254	. 90° Street Elbow	1
4	178934	. Ball Valve	1
5	201746	. Close Nipple (Brass)	1
6	008254	. 90° Street Elbow	1
7	203818	. Anchor Connection	1
8	319526	. Orifice (.038) (Brass)	1
9	201746	. Close Nipple (Brass)	1
10	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
11	115652	. Tubing Clamp	3
12	198366	. Screw, Button Hd. Soc. 1/4-20NC x 3/8	3
13	303956	. Bracket	1
14	199476	. Screw, Rd. Hd. Self-Tap 1/4-20NC x 3/4	2
15	136918	. Bottle Assembly	1
16	197144	. Plastic Tubing 3/8 O.D. (Clear)	A.R.
17	104713	. Hose Clamp	2
18	038303	. Coolant Manifold Assembly (Standard)	1
	038304	. Coolant Manifold Assembly (19" Work Height)	1
	307334	. Coolant Manifold Assembly (25" Work Height)	1
	311565	. Coolant Manifold Assembly (31" Work Height)	1
19	172530	. . Coolant And Air Hose (Standard)	1
	172531	. . Coolant And Air Hose (19" Work Height)	1
	172532	. . Coolant And Air Hose (25" Work Height)	1
	172533	. . Coolant And Air Hose (31" Work Height)	1
	172529	. . . Connector	1
	197322	. . . Segmented Hose (Specify Length)	A.R.
	172528	. . . Nozzle	1
20	108116	. 90° Barbed Insert	1
21	5-027507	. . Sight Feed Valve	1
22	119910	. . Manifold	1
23	121061	. . Coolant Tube Assembly	1
	197140	. . . Nylon Tubing .089 O.D. (Cut to Length)	A.R.
	136893	. . . Glue (Meta Grip #3802)	A.R.
	119912	. . . Pipe Plug	1
24	5-004520	. 90° Street Elbow	1
25	128179	. Barbed Insert	1
	Not Shown:		
	203271	. Grommet	1
	When Air Table is Also Supplied:		
26	120857	. Service Tee	1

NEW DRG.
S.C.L. 9-25-97
REVISIONS
S.C.L. 2-25-04
S.C.L. 2-11-08



MITRE SUB-ASSEMBLY

MITRE ASSEMBLY (NO. 2 STANDARD CUT-OFF)

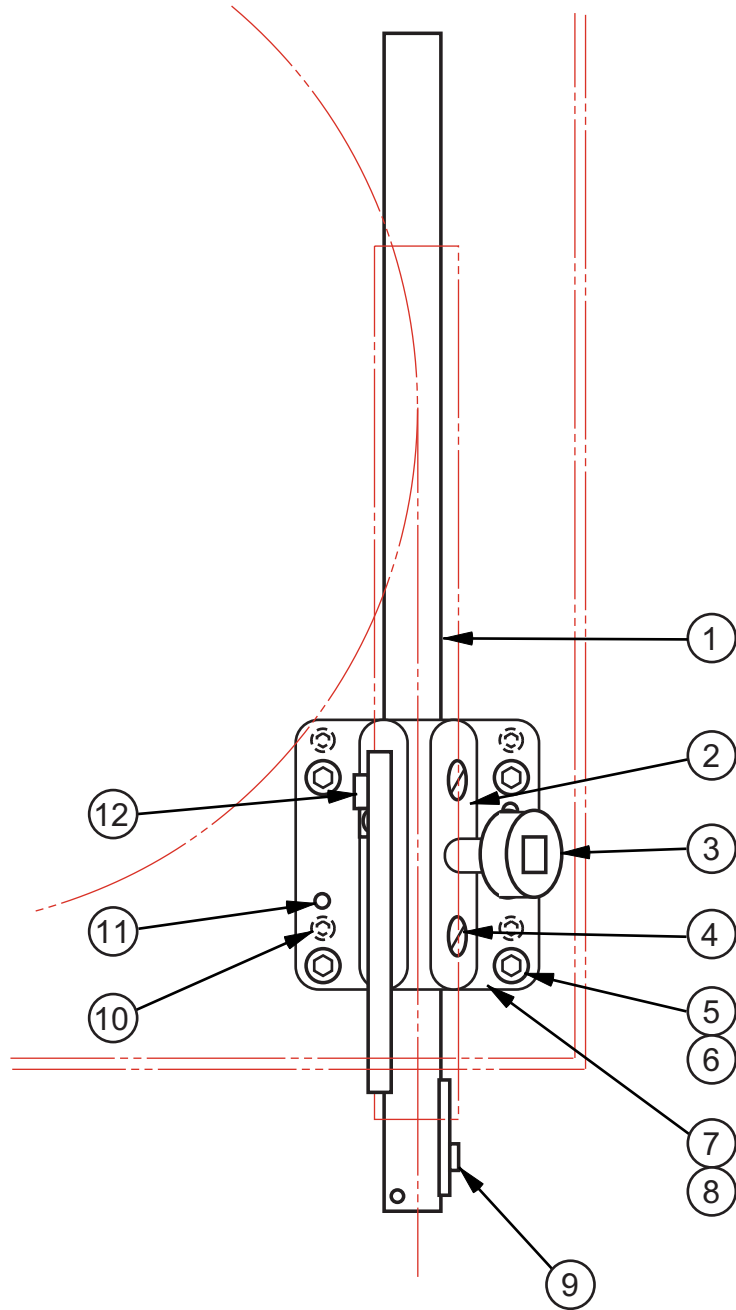
C - 10 - 28 Z - 10 - 6

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MITRE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	050419	Mitre Assembly (No. 2 Standard Cut-Off) (20" Table)	
Ref.	055290	Mitre Assembly (No. 2 Standard Cut-Off) (24" Table)	
Ref.	055305	Mitre Assembly (No. 2 Standard Cut-Off) (26" Table)	
Ref.	050511	Mitre Assembly (No. 2 Standard Cut-Off) (30" Table)	
1	198423	. Screw, Soc. Set 1/4-20NC x 5/16	1
2	201915	. Stop Collar	1
3	198220	. Screw, Soc. Hd. Cap #10-24NC x 1/2	1
4	003682	. Rear Slide Rod Bracket (20" Table)	1
	029583	. Rear Slide Rod Bracket (24", 26", 30" Tables)	1
5	198276	. Screw, Soc. Hd. Cap 3/8-16NC x 1/2 (20", 30" Table)	2
	198278	. Screw, Soc. Hd. Cap 3/8-16NC x 3/4 (24", 26" Table)	2
	34-005414	. Spacer Washer (26" Table Only)	2
6	3-020406	. Slide Rod (20" Table)	1
	4-020401	. Slide Rod (24" Table)	1
	101935	. Slide Rod (26" Table)	1
	101931	. Slide Rod (30" Table)	1
7	198276	. Screw, Soc. Hd. Cap 3/8-16NC x 1/2 (20", 30" Tables)	2
	198278	. Screw, Soc. Hd. Cap 3/8-16NC x 3/4 (24", 26" Tables)	2
	34-005414	. Spacer Washer (26" Table Only)	2
8	003681	. Front Slide Rod Bracket (20" Table)	1
	029584	. Front Slide Rod Bracket (24", 26", 30" Tables)	1
9	198423	. Screw, Soc. Set 1/4-20NC x 5/16	1
10	050710	. Mitre Sub-Assembly (20", 24" Table)	1
	055304	. Mitre Sub-Assembly (26" Table)	1
	050712	. Mitre Sub-Assembly (30" Table)	1
11	34-020410	. . Locking Stud Washer	1
12	003677	. . Stud	1
13	004229	. . Roll Pin	1
14	34-020407	. . Mitre Head Pivot	1
15	34-020409	. . Pivot Washer	1
16	003676	. . Pointer	1
17	199008	. . Screw, Truss Hd. Mach. #8-32NC x 1/4	2
18	004254	. . Roll Pin	2
19	198236	. . Screw, Soc. Hd. Cap 1/4-20NC x 1/2	2
20	4-020302	. . Gauge Rod	1
21	4-020301	. . Mitre Bar (20", 24" Table)	1
	102944	. . Mitre Bar (26" Table)	1
	11-020301	. . Mitre Bar (30" Table)	1
22	003672	. . Degree Plate	1
23	199399	. . Screw, Rd. Hd. Drive #4 x 1/4	4
24	34-017401	. . Thumb Screw	1
25	020941	. . Mitre Head	1
26	005131	. . Handwheel	1
27	040598	. . Slide Arm	1

NEW DRG. S.C.L. 8-25-04
REVISIONS
S.C.L. 2-27-08
S.C.L. 9-9-09



MODEL	FIRST MACH.	LAST MACH.
3613-1	577-04101	
3613-V3	568-04101	
3613-V5	569-04101	

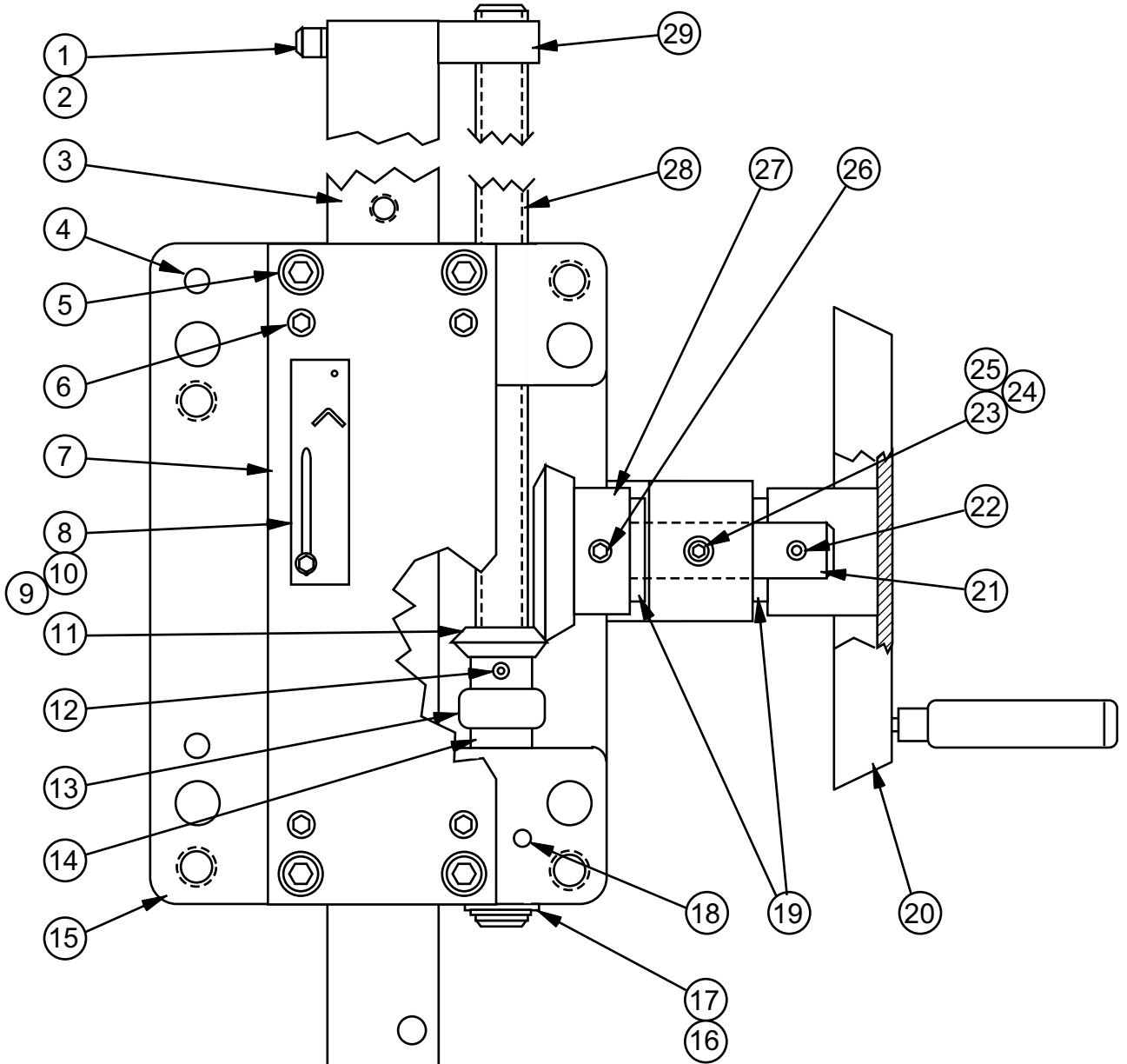
POST ASSEMBLY

C - 2 - 122

POST ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	221771	Post Assembly (Standard)	
Ref.	221772	Post Assembly (19" Work Height)	
Ref.	221773	Post Assembly (25" Work Height)	
Ref.	221774	Post Assembly (31" Work Height)	
1	417400	. Post (21.50") (Standard)	1
	418468	. Post (32.12") (19" Work Height)	1
	418780	. Post (38.12") (25" Work Height)	1
	417630	. Post (44.12") (31" Work Height)	1
2	417394	. Post Slide Casting	1
3	221761	. Lockscrew Sub-Assembly	1
	203548	. . Adaptor	1
	004261	. . Spring Pin	1
	221762	. . Brass Stud	1
4	204850	. Spring Plunger	2
5	198280	. Screw, Soc. Hd. Cap 3/8-16NC x 1-1/4	4
6	199325	. Washer, Lock 3/8 Std.	4
7	319741	. Post Slide Plate	1
8	112328	. Screw, Soc. Hd. Shoulder 5/16-18NC x 1/2	4
9	198698	. Screw, Fill. Hd. Mach. #10-24NC x 1/2	2
10	198459	. Screw, Soc. Set 3/8-24NF x 1	4
11	004282	. Spring Pin	2
12	318807	. Guard Stop Bracket	1

NEW DRG.
S.C.L. 2-25-04
REVISIONS
S.C.L. 8-16-06
S.C.L. 4-4-07
S.C.L. 2-11-08
S.C.L. 9-9-09



MODEL	FIRST MACH.	LAST MACH.
2012-VH	561-03101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	
2012-D12	584-08101	
2613-V3	589-09101	

POST ELEVATING HANDWHEEL ASSEMBLY

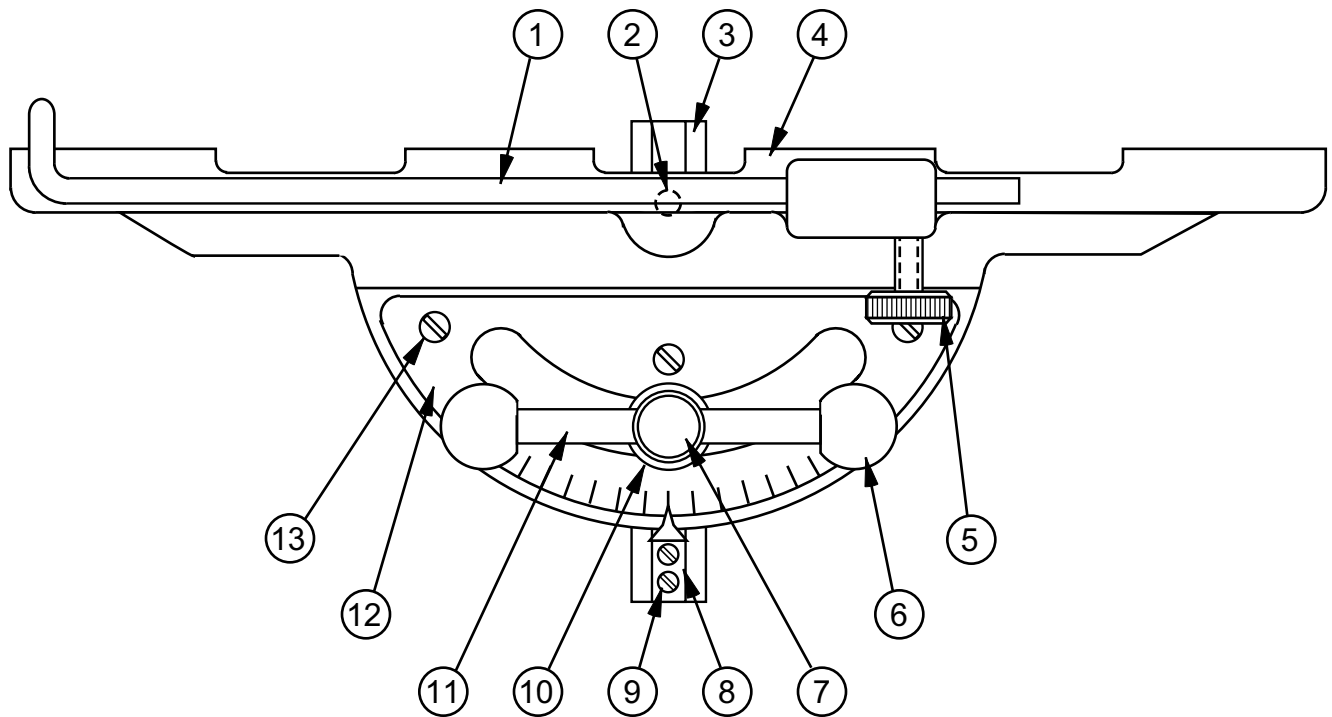
C - 2 - 116 CM - 2 - 130

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POST ELEVATING HANDWHEEL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	404971	Post Elevating Handwheel Assembly (Standard)	
Ref.	407860	Post Elevating Handwheel Assembly (18" and 19" Work Heights)	
Ref.	407729	Post Elevating Handwheel Assembly (24" and 25" Work Heights)	
Ref.	407618	Post Elevating Handwheel Assembly (30" and 31" Work Heights)	
1	198245	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/2	2
2	199374	. Washer, Lock 1/4 Shakeproof	2
3	303029	. Post (25.94") (Standard)	1
	306242	. Post (31.94") (18" and 19" Work Heights)	1
	306243	. Post (37.94") (24" and 25" Work Heights)	1
	306244	. Post (43.94") (30" and 31" Work Heights)	1
4	013122	. Dowel Pin	2
5	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1	4
6	198576	. Screw, Soc. Set 5/16-18NC x 3/4 (Flat Pt.)	4
7	303030	. Cover	1
8	142425	. Guard Stop Weldment	1
9	198000	. Screw, Hex. Hd. Cap #10-24NC x 3/8	1
10	199258	. Washer, Lock #10 S.A.E. Std.	1
11	125566	. Bevel Gear	1
12	004240	. Spring Pin	1
13	016063	. Thrust Ball Bearing	1
14	133113	. Tubing	1
15	404970	. Housing	1
16	317286	. Retaining Ring	1
17	5-013309	. Spacer	A.R.
18	004263	. Spring Pin	1
19	120922	. Bearing	2
20	216098	. Handwheel	1
21	123901	. Pin	1
22	004259	. Spring Pin	1
23	198422	. Screw, Soc. Set 1/4-20NC x 1/4	1
24	003971	. Compression Spring	1
25	140765	. Friction Plug	1
26	004259	. Spring Pin	1
27	125567	. Bevel Gear	1
28	132667	. Shaft (21.88") (Standard)	1
	143983	. Shaft (27.88") (18" and 19" Work Heights)	1
	143984	. Shaft (33.88") (24" and 25" Work Heights)	1
	143985	. Shaft (39.88") (30" and 31" Work Heights)	1
29	132666	. Nut	1

NEW DRG. S.C.L. 9-18-97
REVISIONS
S.C.L. 2-25-04
S.C.L. 2-11-08



USED ON T-SLOT TABLES.

PROTRACTOR WORK STOP AND ALIGNING GAGE ASSEMBLY

C - 10 - 42 CM - 10 - 7

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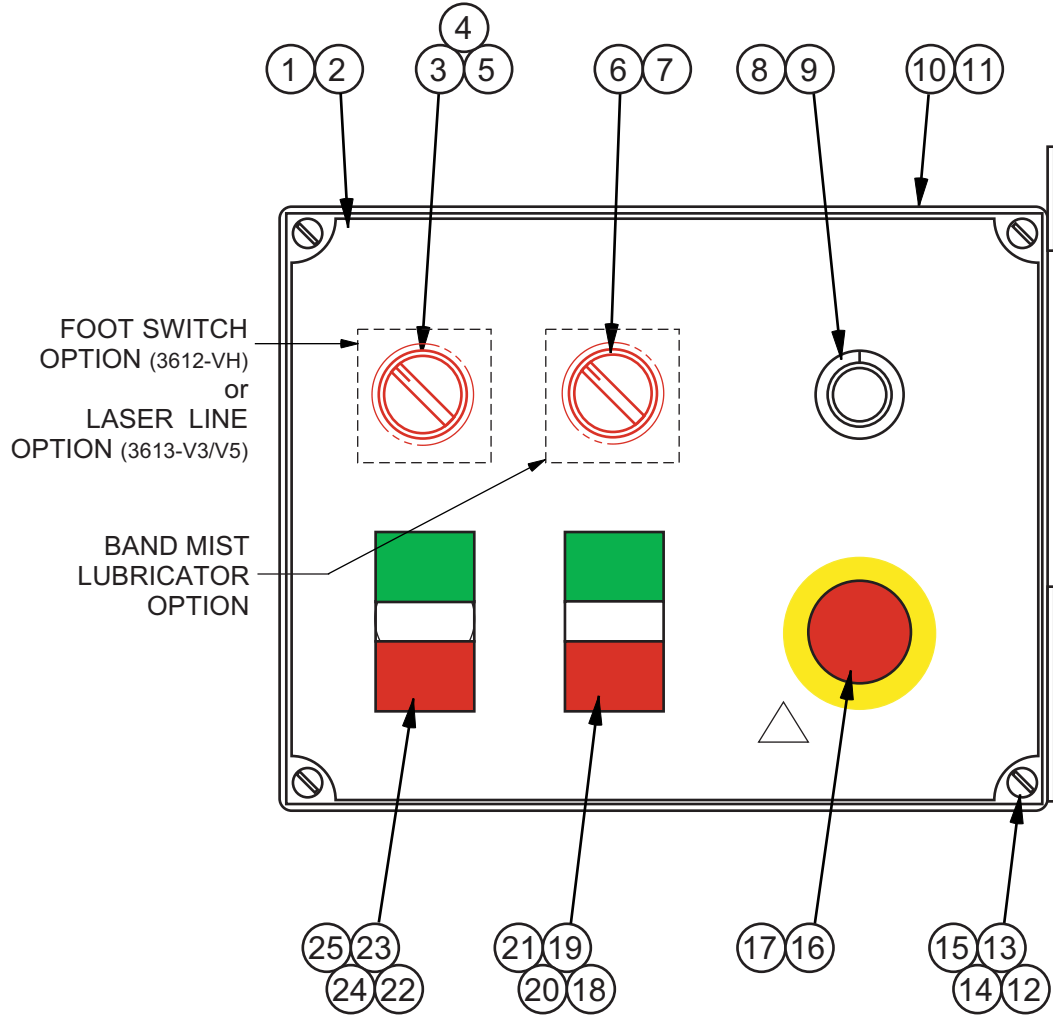
**PROTRACTOR WORK STOP
and
ALIGNMENT GAGE ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.*	051495	Protractor Work Stop And Aligning Gage Assembly	
1	35-001976	. Gage Rod.....	1
2	14-000473	. Dowel Pin	1
3*	025302	. T-Nut	1
4	051496	. Miter Head	1
5	34-017401	. Thumbnut	1
6	133971	. Knob	2
7*	011635	. Stud	1
8	011633	. Pointer	1
9	198867	. Screw, Rd. Hd. Mach. #10-24NC x 3/8.....	2
10	199265	. Washer, Flat 7/16 S.A.E. Std.	1
11	011634	. Shaft	1
12	35-001614	. Protractor Plate	1
13	198867	. Screw, Rd. Hd. Mach. #10-24NC x 3/8	3

*NOTE: For Model 26-HB2

Ref.	054758	Protractor Work Stop And Aligning Gage Assembly	
3	029162	. T-Nut	1
7	101118	. Stud	1

NEW DRG. S.C.L. 7-21-04
REVISIONS
S.C.L. 9-1-06
S.C.L. 2-28-08
S.C.L. 9-9-09



MODEL	FIRST MACH.	LAST MACH.
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	

PUSHBUTTON BOX ASSEMBLY

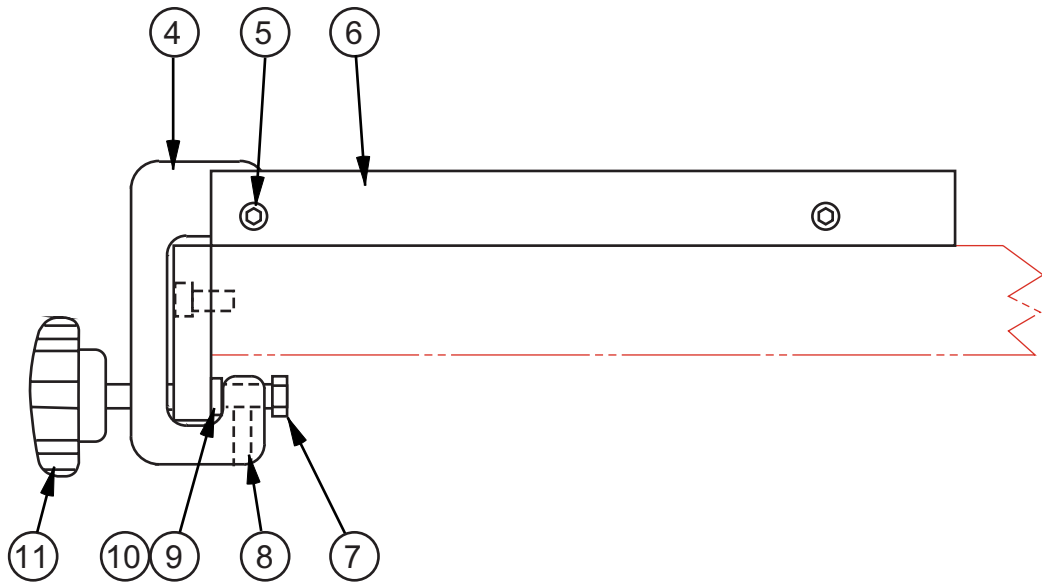
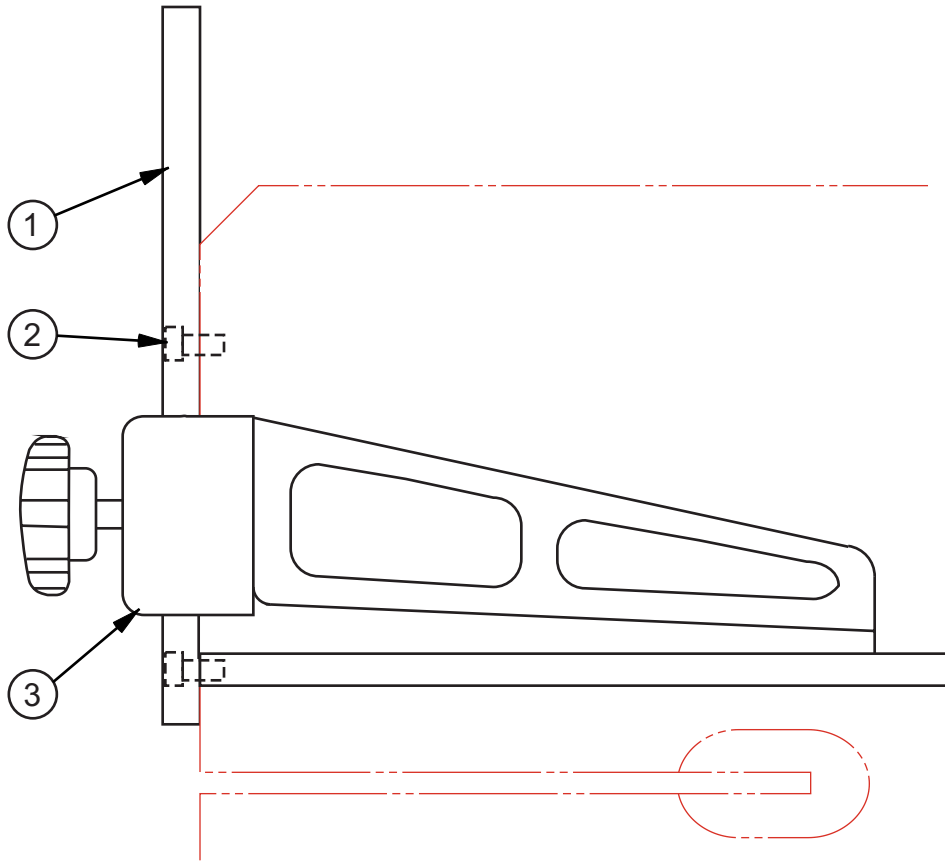
C - 6 - 23 CM - 6 - 30

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PUSHBUTTON BOX ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	221383	Pushbutton Box Assembly	
1	325980	. Backer Plate	1
2**	325979	. Escutcheon (Standard)	1
	326639	. Escutcheon (Foot Switch Option)	1
3**	135106	. Hole Seal (Standard)	1
	207182	. Selector Switch (3 Position) (Foot Switch Option)	1
4**	207185	. Contact Block (1-NO) (Foot Switch Option)	1
5	211501	. Contact Block (2-NC) (Foot Switch Option)	1
6	135106	. Hole Seal (Standard)	1
	207181	. Selector Switch (2 Position) (Mist Lubricator Option)	1
7	207185	. Contact Block (1-NO) (Mist Lubricator Option)	1
8*	223553	. Potentiometer (Mitsubishi VFD)	1
9	178146	. Knob	1
10	531680	. Pushbutton Enclosure	1
11	215267	. Gasket Strip	A.R.
12	207171	. Rivet Nut M5-0.8	4
13	207170	. Screw, Hex. Hd. Slotted M5-0.8 x 20	4
14	204150	. Retaining Ring	4
15	204152	. Nylon Washer	4
16	207191	. Pushbutton Operator (Red Mushroom)	1
17	207186	. Contact Block (1-NC)	1
18	221140	. Double Pushbutton Operator (Red/Green)	1
19	207185	. Contact Block (1-NO)	1
20	207186	. Contact Block (1-NC)	1
21	221385	. Seal Boot	1
22	135106	. Hole Seal (3613-V3, 3613-V5)	1
	221140	. Double Pushbutton Operator (Red/Green) (3612-VH Only)	1
23	207185	. Contact Block (1-NO) (3612-VH Only)	1
24	207186	. Contact Block (1-NC) (3612-VH Only)	1
25	221385	. Seal Boot (3612-VH Only)	1
*NOTE: For Machines With Safronic VFDs:			
8	178275	. Potentiometer	1
**NOTE: For Machines With Laser Line Generator:			
2	1003970	. Escutcheon (Laser Line Option)	1
3	207181	. Selector Switch (2 Position)	1
4	207185	. Contact Block (1-NO)	1

NEW DRG. S.C.L. 9-19-97
REVISIONS
S.C.L. 2-25-04
S.C.L. 2-11-08



RIP FENCE ASSEMBLY

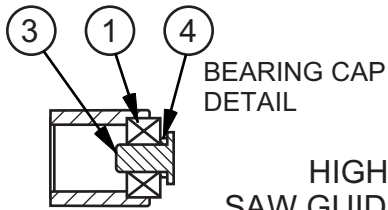
C - 10 - 6 Z - 9 - 5

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RIP FENCE ASSEMBLY

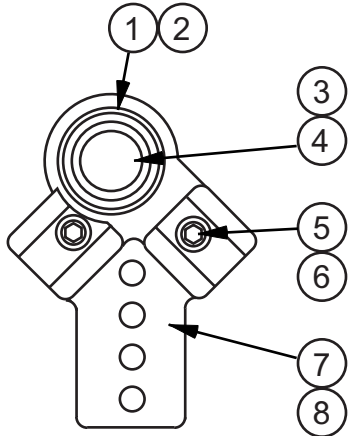
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	35-000543	Rip Fence Assembly (24" Table)	
Ref.	047779	Rip Fence Assembly (26" Table)	
Ref.	35-000542	Rip Fence Assembly (30" Table)	
1	5-016302	. Clamp Guide (24" and 26" Tables)	1
	11-016302	. Clamp Guide (30" Table)	1
2	198278	. Screw, Soc. Hd. Cap 3/8-16NC x 3/4	2
	34-005414	. Spacer Washer (If Supplied)	2
3	35-005251	. Rip Fence Sub-Assembly (24" Table)	1
	35-005178	. Rip Fence Sub-Assembly (26" and 30" Table)	1
4	35-000545	.. Clamp (24" Table)	1
	35-000544	.. Clamp (26" and 30" Tables)	1
5	198278	.. Screw, Soc. Hd. Cap 3/8-16NC x 3/4	2
6	35-000548	.. Work Guide (24" Table)	1
	35-000546	.. Work Guide (26" and 30" Tables)	1
7	5-016403	.. Clamp Bar Screw	2
8	198425	.. Screw, Soc. Set 1/4-20NC x 1/2	2
9	5-016303	.. Clamp Bar	1
10	34-006504	.. Spring Clip	2
11	117670	.. Handwheel Assembly	1
Following Not Shown:			
	203556	. Tag (Rip Fence Alignment)	1

NEW DRG.	S.C.L. 9-25-97
REVISIONS	
S.C.L. 2-20-04	
S.C.L. 2-11-08	

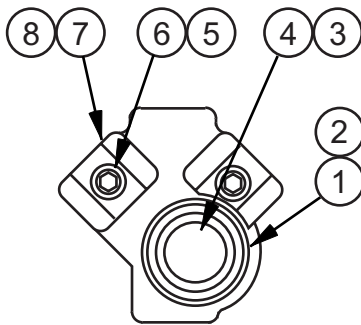


BEARING CAP
DETAIL

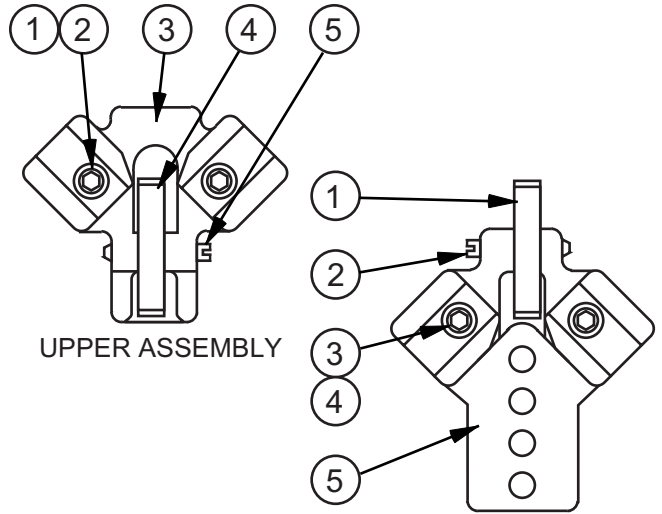
HIGH SPEED
SAW GUIDE ASSEMBLY
(CROWNED BANDWHEELS)
(1/16" - 1/2" SAW BANDS)



LOWER ASSEMBLY



UPPER ASSEMBLY

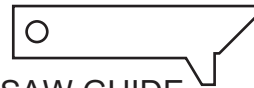


UPPER ASSEMBLY

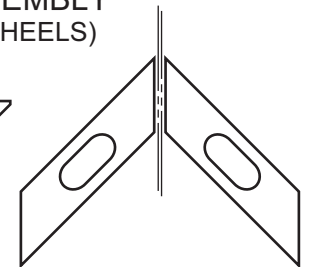
LOWER ASSEMBLY

SAW GUIDE ASSEMBLY
(FLANGED BANDWHEELS)

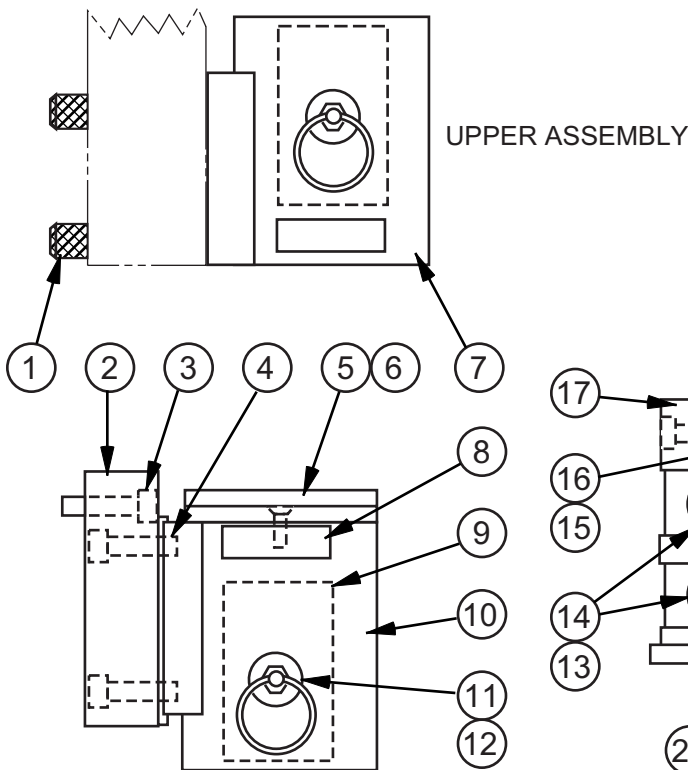
STANDARD



SAW GUIDE
INSERT GAGE

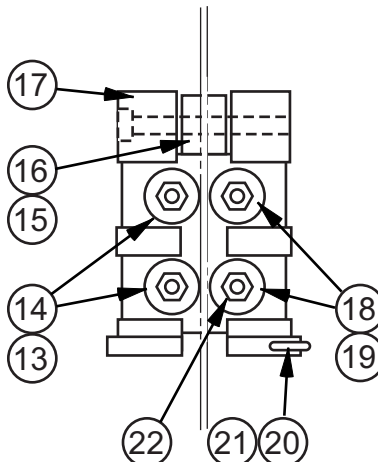


SAW GUIDE INSERTS

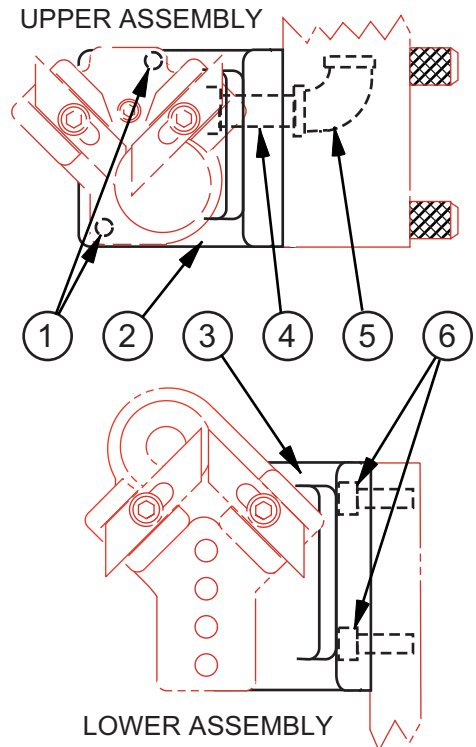


UPPER ASSEMBLY

LOWER ASSEMBLY



TYPICAL FOR
BOTH GUIDES



UPPER ASSEMBLY

LOWER ASSEMBLY
90° SAW GUIDE ASSEMBLY

ADJUSTABLE ANGLE SAW GUIDE ASSEMBLY

SAW GUIDE ASSEMBLIES
(STANDARD and SPECIAL APPLICATION)

SAW GUIDE ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	028081	Upper Saw Guide Assembly (High Speed) (1/16"-1/2")	
1*	011529	. Ball Bearing	1
2	011541	. Retaining Ring (If Supplied)	1
3*	018415	. Bearing Cap	1
4*	176845	. Spacer	1
5	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8 ..	2
6	34-008502	. Insert Washer	2
7	027981	. Upper Saw Guide Block	1
8	137339	. Hole Plug (If Supplied)	1

Ref.	028082	Lower Saw Guide Assembly (High Speed) (1/16"-1/2")	
1*	011529	. Ball Bearing	1
2	011541	. Retaining Ring (If Supplied)	1
3*	018415	. Bearing Cap	1
4*	176845	. Spacer	1
5	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8 ...	2
6	34-008502	. Insert Washer	2
7	027983	. Lower Saw Guide Block	1
8	137339	. Hole Plug (If Supplied)	1

*NOTE: When ordering any of the marked items, ordering #085369 - Bearing Replacement Kit is recommended.

STANDARD FOR FLANGE BANDWHEELS

Ref.	304843	Upper Saw Guide Assy (Carbide Insert).	
1	198244	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4	2
2	34-008502	. Insert Washer	2
3	406430	. Upper Saw Guide Block	1
4	121210	. Back-Up Insert	1
5	140204	. Pivot Bolt	1

Ref.	304844	Lower Saw Guide Assy (Carbide Insert).	
1	121210	. Back-up Insert	1
2	140204	. Pivot Bolt	1
3	198244	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4	2
4	34-008502	. Insert Washer	2
5	406768	. Lower Saw Guide Block	1

90° SAW GUIDE ASSEMBLY

Ref.	416651	90° Saw Guide Assy (26" Table)	
Ref.	044804	90° Saw Guide Assy (30" Table)	
1	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1	2
2	027597	. 90° Upper Angle Saw Guide Bracket....	1
3	027596	. 90° Lower Angle Saw Guide Bracket....	1
4	011658	. Pipe Nipple	1
5	35-003647	. 90° Elbow	1
6	198239	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4 ..	2
	317853	. Center Plate (Oval) (Not Shown)	1
	029261	. Center Plate (Round)(Not Shown).....	1
	416371	. Chip Baffle (If Supplied) (Not Shown)..	1
	133372	. Thumb Screw (Not Shown)	1

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	205025	Adjustable Angle Saw Guide Set (26" Table)	
Ref.	205114	Adjustable Angle Saw Guide Set (30" Table)	
1	018500	. Upper Saw Guide Holding Screw	2
2	319704	. Adaptor Bar	1
3	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1 ..	1
4	198241	. Screw, Soc. Hd. Cap 1/4-20NC x 7/82	
5	205024	. Cap	1
6	198739	. Screw, Flat Hd. Mach. #6-32NC x 3/8	2
7	417525	. Upper Saw Guide Housing	1
8	205818	. Label (Logo)	1
9	205802	. Label (Warning)	1
10	417522	. Lower Saw Guide Housing	1
11	205020	. Spring Plunger	1
12	205399	. Split Ring	1
13	205022	. Roller Bearing	2
14	319979	. Eccentric Stud	2
15	205022	. Roller Bearing	1
16	35-000328	. Dowel Pin	1
17	417524	. Upper Saw Guide	1
	417523	. Lower Saw Guide	1
18	205022	. Roller Bearing	2
19	320173	. Concentric Stud	2
20	205817	. Sleeve Cap	1
21	004219	. Spring Pin	1
22	017655	. Locknut #10-24NC	4

Following Not Shown:

204909	. Gage	1
319939	. Saw Band Guard Assembly	1
319930	. Guard Weldment	1
316934	. Sliding Guard	1
133372	. Thumb Screw	1
317592	. Center Plate (26" Table)	1
120128	. Center Plate (30" Table)	1

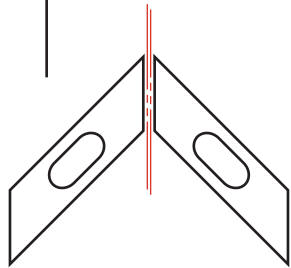
SAW GUIDE INSERT GAGE

34-008320	. Insert Gage (.025)	1
13-008303	. Insert Gage (.032)	1
13-009307	. Insert Gage (.035)	1
34-008506	. Box (For Inserts and Gages)	1

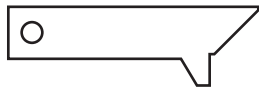
SAW GUIDE INSERT SELECTION

<u>STEEL</u>	<u>SIZE</u>	<u>CARBIDE</u>
004499	1/16"	
004498	3/32"	
004497	1/8"	141759
004496	3/16"	
004495	1/4"	016168
003960	3/8"	016170
003959	1/2"	013291
003958	5/8"	105894
003957	3/4"	013292
003956	1"	008982

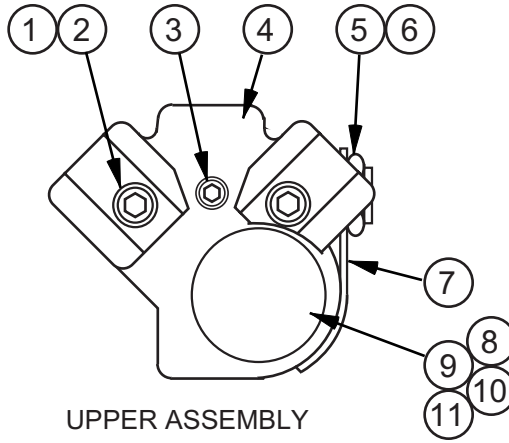
NEW DRG.
S.C.L. 9-29-97
REVISIONS
S.C.L. 2-20-04
S.C.L. 2-11-08



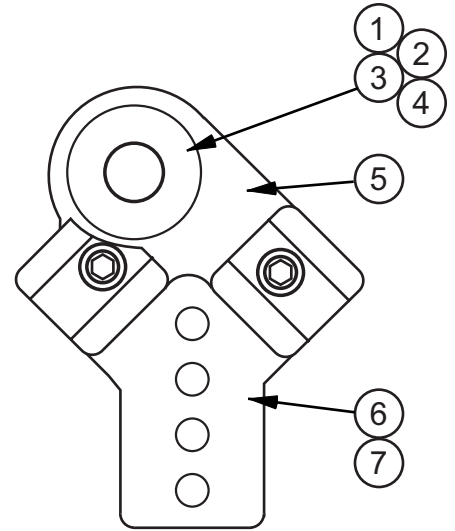
SAW GUIDE INSERTS



SAW GUIDE INSERT GAGE

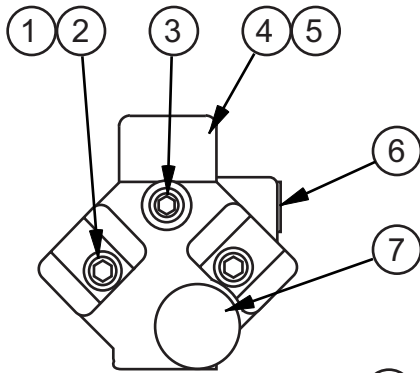


UPPER ASSEMBLY

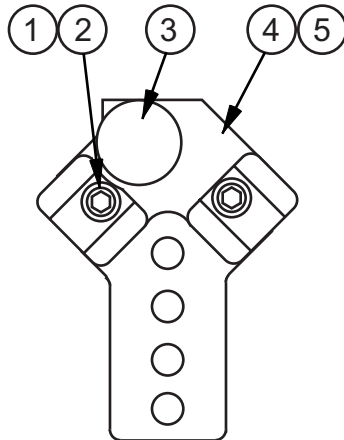


LOWER ASSEMBLY

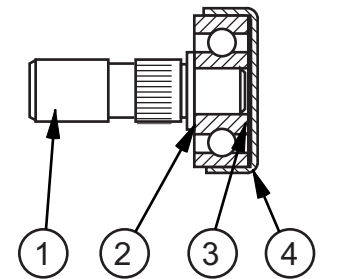
HEAVY DUTY SAW GUIDE ASSEMBLY
(WITH CARBIDE BACK-UP)



UPPER ASSEMBLY

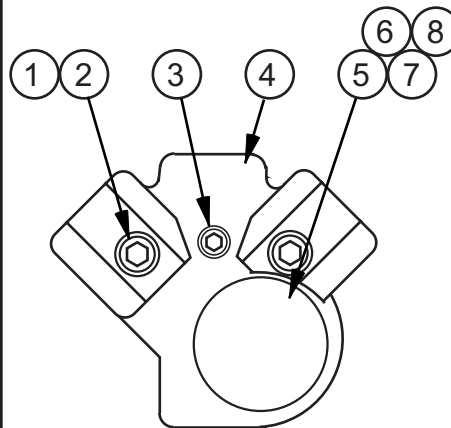


LOWER ASSEMBLY

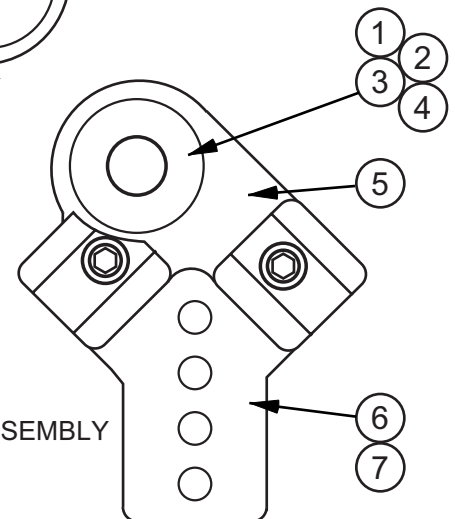


BEARING SUB-ASSEMBLY

PRECISION SAW GUIDE ASSEMBLY
(1/16" - 1/2" SAW BANDS)



UPPER ASSEMBLY



LOWER ASSEMBLY

HEAVY DUTY SAW GUIDE ASSEMBLY
(WITH STEEL BACK-UP)

SAW GUIDE ASSEMBLIES (INSERT TYPE)

C - 7 - 18 CM - 7 - 23

PRINTED IN U.S.A.

SAW GUIDE ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
HEAVY DUTY SAW GUIDE ASSEMBLY (CARBIDE BACK-UP)			
Ref.	119918	Upper Saw Guide Assembly (1/16" - 1/2" Bands)	
Ref.	017861	Upper Saw Guide Assembly (5/8" - 3/4" Bands)	
Ref.	303011	Upper Saw Guide Assembly (1" Band)	
Ref.*	120119	Upper Saw Guide Assembly (1" Bands w/ Coolant Line)	
1	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8 (1/16" - 1/2")	2
	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1 (5/8" - 3/4")	2
	198244	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4 (1"; Coolant Line)	2
2	34-008502	. Insert Washer	2
3	198445	. Screw, Soc. Set 5/16-24NF x 1/2 (5/8", 3/4", 1")	1
	033509	. Coolant Nozzle (Coolant Line)	1
4	038076	. Upper Saw Guide Block (1/16" - 1/2")	1
	025252	. Upper Saw Guide Block (5/8", 3/4")	1
	025253	. Upper Saw Guide Block (1")	1
	033631	. Upper Saw Guide Block (W/Coolant Line)	1
5	135441	. Locknut (5/8", 3/4", 1")	1
6	133202	. Pipe Plug (5/8", 3/4", 1")	1
	108116*	. 90° Barbed Insert (Coolant Line)	1
7	018337	. Guide Guard (5/8", 3/4", 1")	1
8	017218	. Bearing Cap Ass'y. (Includes Carbide)	1
9	011529	. Ball Bearing	2
10	011541	. Retaining Ring	1
11	200306	. Spacer (Between Bearings)	1

* Models 1612-3, 2612-2H, 2613-2, 3613-3, 6013-3, 6013-H3 Only.
 NOTE: If your Machine has 2 Coolant Lines to the Upper Saw Guide,
 Delete This Item and Replace With the Following:

109452	. Swivel Joint	1
016001	. Barbed Insert	2

Ref.	119001	Lower Saw Guide Assembly (1/16" - 1/2" Bands)	
Ref.	018168	Lower Saw Guide Assembly (5/8" - 3/4" Bands)	
Ref.	017732	Lower Saw Guide Assembly (1" Band)	
1	017218	. Bearing Cap Ass'y. (Includes Carbide)	1
2	011529	. Ball Bearing	2
3	011541	. Retaining Ring	1
4	200306	. Spacer (Between Bearings)	1
5	037738	. Lower Saw Guide Block (1/16" - 1/2")	1
	025258	. Lower Saw Guide Block (5/8", 3/4")	1
	025257	. Lower Saw Guide Block (1")	1
6	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8 (1/16" - 1/2")	2
	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1 (5/8" - 3/4")	2
	198244	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4 (1"; Coolant Line)	2
7	34-008502	. Insert Washer	2

SAW GUIDE INSERT SELECTION

STEEL	SIZE	CARBIDE
004499	1/16"	
004498	3/32"	
004497	1/8"	141759
004496	3/16"	
004495	1/4"	016168
003960	3/8"	016170
003959	1/2"	013291
003958	5/8"	105894
003957	3/4"	013292
003956	1"	008982

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
HEAVY DUTY SAW GUIDE ASSEMBLY (STEEL BACK-UP)			
Ref.	120143	Upper Saw Guide Assembly (1/16" - 1/2" Bands)	
Ref.	011528	Upper Saw Guide Assembly (5/8" - 3/4" Bands)	
Ref.	011530	Upper Saw Guide Assembly (1" Band)	
1	198244	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4 (1/16" - 1/2", 1")	2
	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1 (5/8" - 3/4")	2
2	34-008502	. Insert Washer	2
3	198445	. Screw, Soc. Set 5/16-24NF x 1/2 (5/8", 3/4", 1")	1
4	038076	. Upper Saw Guide Block (1/16" - 1/2")	1
	025252	. Upper Saw Guide Block (5/8", 3/4")	1
	025253	. Upper Saw Guide Block (1")	1
5	120369	. Pipe Plug (5/8", 3/4", 1")	1
6	011540	. Bearing Cap	1
7	011529	. Ball Bearing	2
8	011541	. Retaining Ring	1
9	200306	. Spacer (Between Bearings)	1

Ref.	120142	Lower Saw Guide Assembly (1/16" - 1/2")	
Ref.	011543	Lower Saw Guide Assembly (5/8" - 3/4")	
Ref.	011542	Lower Saw Guide Assembly (1")	
1	011540	. Bearing Cap	1
2	011529	. Ball Bearing	2
3	011541	. Retaining Ring	1
4	200306	. Spacer (Between Bearings)	1
5	037738	. Lower Saw Guide Block (1/16" - 1/2")	1
	025258	. Lower Saw Guide Block (5/8", 3/4")	1
	025257	. Lower Saw Guide Block (1")	1
6	198244	. Screw, Soc. Hd. Cap 1/4-20NC x 1-1/4 (1/16" - 1/2", 1")	2
	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1 (5/8" - 3/4")	2
7	34-008502	. Insert Washer	2

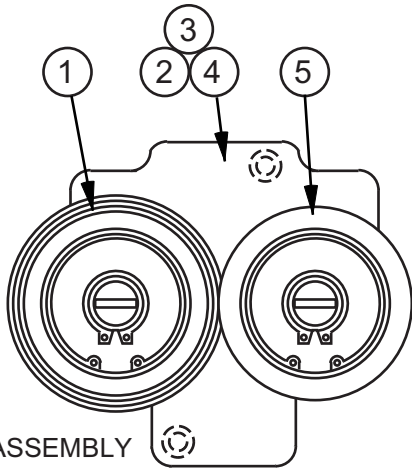
PRECISION SAW GUIDE ASSEMBLY (1/16" - 1/2" Bands)

Ref.	011519	Precision Upper Saw Guide Assembly	
1	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8....	2
2	34-08502	. Insert Washer	2
3	198445	. Screw, Soc. Set 5/16-24NF x 1/2	1
4	025249	. Upper Saw Guide Block	1
5	198501	. Screw, Soc. Set #8-32NC x 1/4 (Cone Pt.)	1
6	120369	. Pipe Plug	1
7	34-080092	. Bearing Sub-Assembly (See Detail)	1
Ref.	011507	Precision Lower Saw Guide Assembly	
1	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8....	2
2	34-008502	. Insert Washer	2
3	34-008009	. Bearing Sub-Assembly (See Detail)	1
4	025247	. Lower Saw Guide Block	1
5	198501	. Screw, Soc. Set #8-32NC x 1/4 (Cone Pt.)	1
Ref.	34-008009	. Bearing Sub-Assembly	
1	34-008418	. Shaft	1
2	35-009043	. Ball Bearing	1
3	34-008312	. Washer	1
4	34-008309	. Roller Seal	1

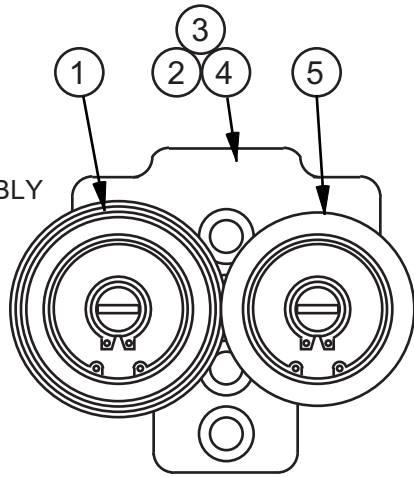
SAW GUIDE INSERT SELECTION

34-008320	. Insert Gage (.025)	1
13-008303	. Insert Gage (.032)	1
13-008307	. Insert Gage (.035)	1
34-008506	. Box (For Inserts and Gages)	1

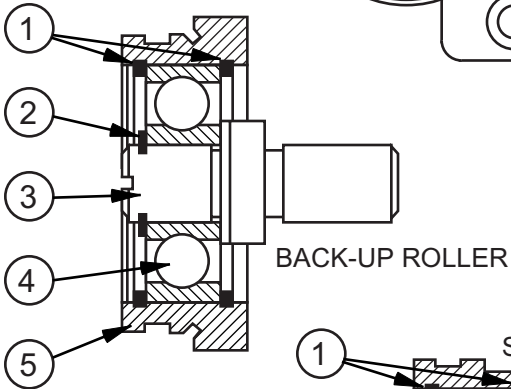
NEW DRG.
S.C.L. 9-30-97
REVISIONS
S.C.L. 2-20-04
S.C.L. 2-11-08



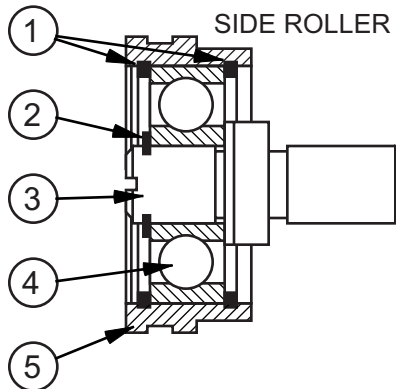
UPPER ASSEMBLY



LOWER ASSEMBLY

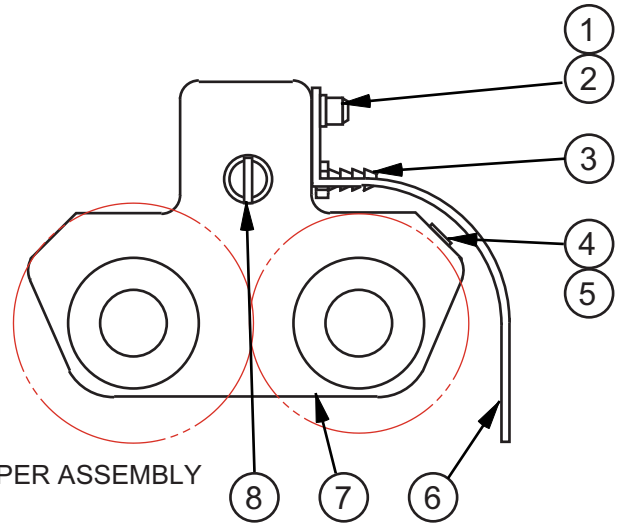


BACK-UP ROLLER

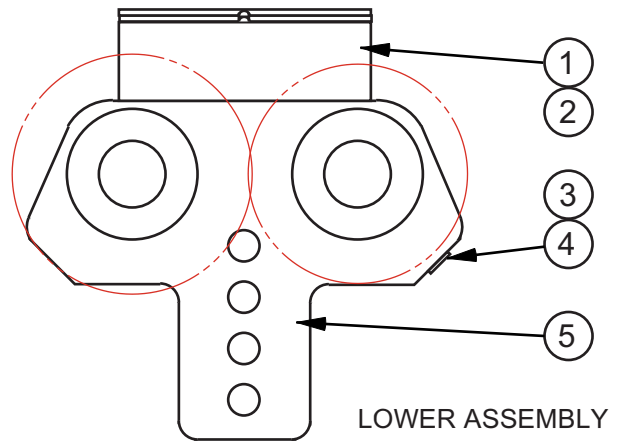


SIDE ROLLER

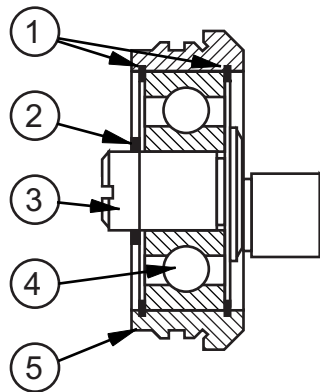
TYPE I - ROLLER SAW GUIDE ASSEMBLY



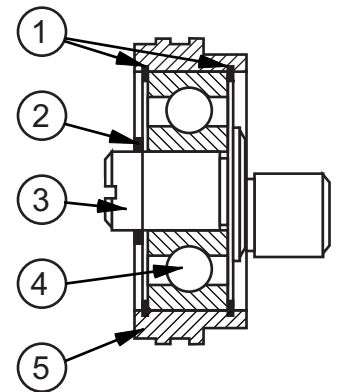
UPPER ASSEMBLY



LOWER ASSEMBLY



BACK-UP ROLLER



SIDE ROLLER

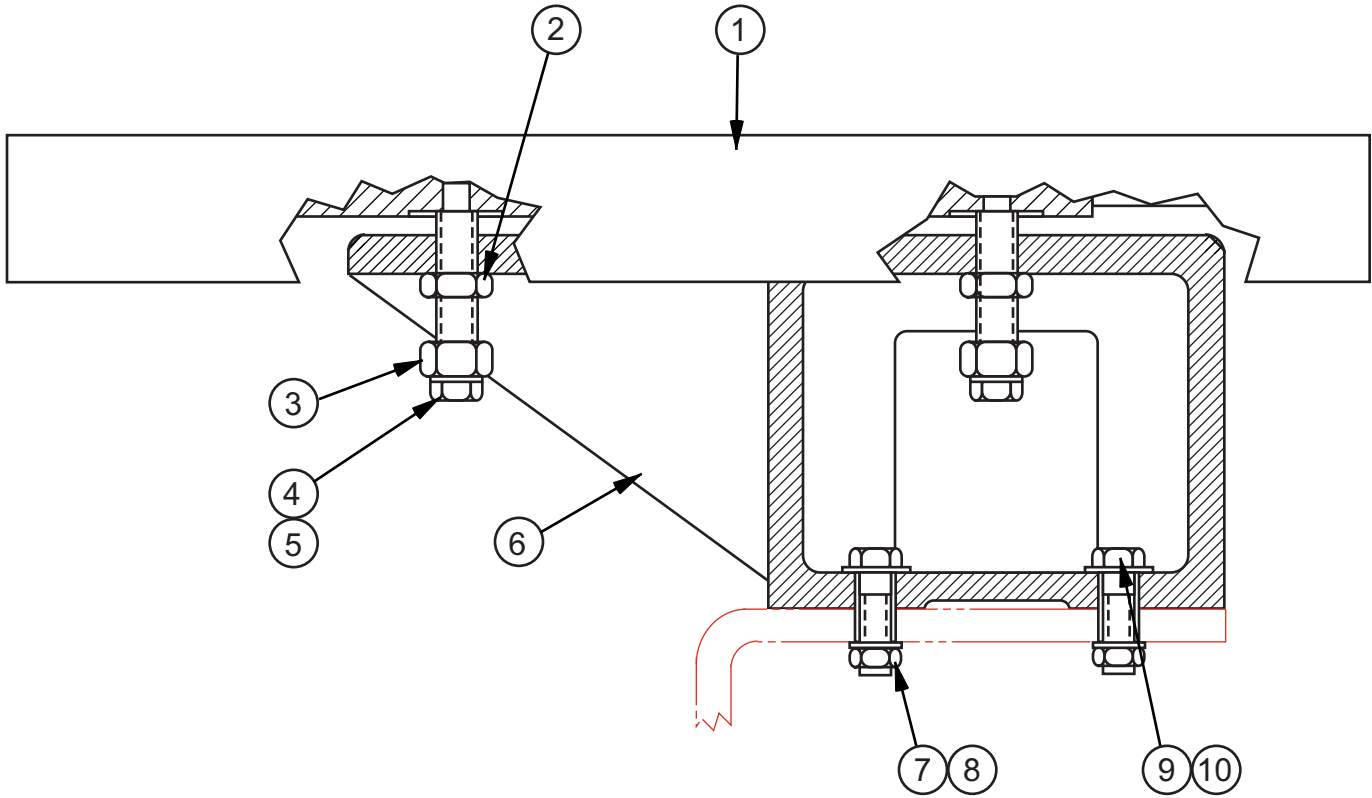
TYPE II - ROLLER SAW GUIDE ASSEMBLY

SAW GUIDE ASSEMBLIES (ROLLER TYPE)

SAW GUIDE ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
<u>TYPE I – ROLLER SAW GUIDE ASSEMBLY</u>				<u>TYPE II ROLLER ASSEMBLIES</u>			
Ref.	029256	1/4" Upper Roller Saw Guide Assembly		Ref.	020798	1/4" Back-Up Roller Assembly	
Ref.	029258	3/8" Upper Roller Saw Guide Assembly		Ref.	020808	3/8" Back-Up Roller Assembly	
Ref.	029506	1/2" Upper Roller Saw Guide Assembly		Ref.	020295	1/2" Back-Up Roller Assembly	
1	See Below	. Back-Up Roller Assy (See Detail)	1	Ref.	021071	5/8" Back-Up Roller Assembly	
2	028960	. Upper Guide Block	1	Ref.	020296	3/4" Back-Up Roller Assembly	
3	198239	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4 ..	2	Ref.*	028968	1" Back-Up Roller Assembly	
4	199321	. Washer, Lock 1/4 Std.	2	1	001303	. Retaining Ring	2
5	See Below	. Side Roller Assy (See Detail)	1	2	001568	. Retaining Ring	1
Ref.	029257	1/4" Lower Roller Saw Guide Assembly		3	013530	. Spindle	1
Ref.	029259	3/8" Lower Roller Saw Guide Assembly		4	001779	. Ball Bearing	2
Ref.	029505	1/2" Lower Roller Saw Guide Assembly		5	013532	. 1/4" Back-Up Roller	1
1	See Below	. Back-Up Roller Assy (See Detail)	1	Ref.	013541	. 3/8" Back-Up Roller	1
2	028961	. Lower Guide Block	1	Ref.	013534	. 1/2" Back-Up Roller	1
3	199239	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4 ..	2	Ref.	013543	. 5/8" Back-Up Roller	1
4	199321	. Washer, Lock 1/4 Std.	2	Ref.	013536	. 3/4" Back-Up Roller	1
5	See Below	. Side Roller Assy (See Detail)	1	Ref.	100757	. 1" Back-Up Roller	1
<u>TYPE I – ROLLER ASSEMBLIES</u>				Ref.	020799	1/4" Side Roller Assembly	
Ref.	028982	1/4" Back-Up Roller Assembly		Ref.	020807	3/8" Side Roller Assembly	
Ref.	028978	3/8" Back-Up Roller Assembly		Ref.	020292	1/2" Side Roller Assembly	
Ref.	028976	1/2" Back-Up Roller Assembly		Ref.	021072	5/8" Side Roller Assembly	
1	100046	. Retaining Ring	2	Ref.	020293	3/4" Side Roller Assembly	
2	011541	. Retaining Ring	1	Ref.*	028967	1" Side Roller Assembly	
3	018296	. Shaft	1	1	001303	. Retaining Ring	2
4	011529	. Ball Bearing	2	2	001568	. Retaining Ring	1
5	028983	. 1/4" Back-up Roller	1	3	013530	. Spindle	1
	028979	. 3/8" Back-up Roller	1	4	001779	. Ball Bearing	2
	028977	. 1/2" Back-up Roller	1	5	013531	. 1/4" Side Roller	1
Ref.	028984	1/4" Side Roller Assembly		Ref.	013540	. 3/8" Side Roller	1
Ref.	028980	3/8" Side Roller Assembly		Ref.	013533	. 1/2" Side Roller	1
Ref.	028974	1/2" Side Roller Assembly		Ref.	013542	. 5/8" Side Roller	1
1	100046	. Retaining Ring	2	Ref.	013535	. 3/4" Side Roller	1
2	011541	. Retaining Ring	1	Ref.	100758	. 1" Side Roller	1
3	018296	. Shaft	1	*NOTE: To Be Used With Flanged Rubber-Tired Wheels Using 1/4", 1/2", 3/4" or 1" Bands. Also Used With Steel Flanged or Rubber Crowned Wheels Using 1" Band Only.			
4	011529	. Ball Bearing	2				
5	028985	. 1/4" Side Roller	1				
	028981	. 3/8" Side Roller	1				
	028975	. 1/2" Side Roller	1				
<u>TYPE II – ROLLER SAW GUIDE ASSEMBLY</u>							
Ref.	109517	Upper Saw Guide Block Assembly					
1	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2 ..	1				
2	199321	. Washer, Lock 1/4 Std.	1				
3	016001	. Barbed Insert	1				
4	198448	. Screw, Soc. Set 3/8-16NC x 3/8	2				
5	001741	. Plug	2				
6	033636	. Coolant Guard	1				
7	033517	. Upper Saw Guide Block	1				
8	033509	. Coolant Nozzle	1				
Ref.	017215	Lower Saw Guide Block Assembly					
1	002140	. Chip Deflector	1				
2	198235	. Screw, Soc. Hd. Cap 1/4-20NC x 3/8 ..	2				
3	198449	. Screw, Soc. Set 3/8-16NC x 1/2	2				
4	001741	. Plug	2				
5	027743	. Lower Saw Guide Block	1				
Not Shown (For Both Upper and Lower Guides):							
	131798	. Cloth Bag	1				

NEW DRG. S.C.L. 7-5-04
REVISIONS
S.C.L. 2-27-08
S.C.L. 9-9-09



MODEL	FIRST MACH.	LAST MACH.
3613-1	577-04101	
3613-V3	568-04101	
3613-V5	569-04101	
3612-VH	570-04101	

SECONDARY TABLE ASSEMBLY

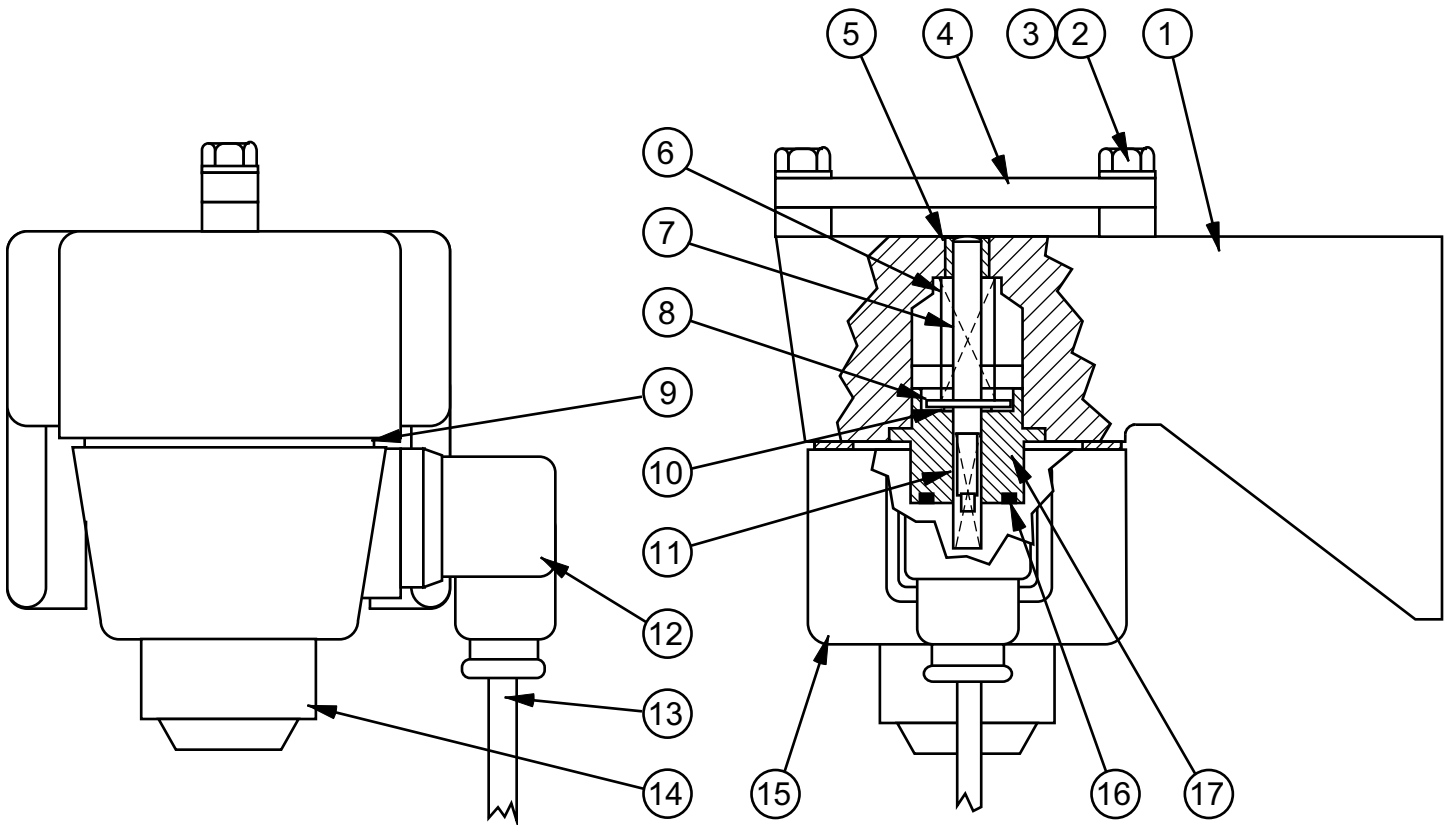
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SECONDARY TABLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	050369	Secondary Table Assembly (Used With Fixed or Glide Tables)	
Ref.	503536	Secondary Table Assembly (Used With Air or Hydraulic Tables)	
1	11-003106	. Secondary Table	1
2	199136	. Nut, Hex. Jam 5/18-11NC	4
3	11-003404	. Support Stud	4
4	198053	. Screw, Hex. Hd. Cap 3/8-16NC x 2-3/4 (Used With Fixed or Glide Tables)	4
	198054	. Screw, Hex. Hd. Cap 3/8-16NC x 3 (Used With Air or Hydraulic Tables)	4
5	199358	. Washer, Lock 3/8 Shakeproof	4
6	020827	. Secondary Table Support (Used With Fixed or Glide Tables)	1
	048045	. Secondary Table Support (Used With Air or Hydraulic Tables)	1
7	199131	. Nut, Hex. 1/2-13NC	4
8	199327	. Washer, Lock 1/2 Std.	4
9	198067	. Screw, Hex. Hd. Cap 1/2-13NC x 1-1/2	4
10	199304	. Washer, Flat 1/2 Wrought	4

NEW DRG.
S.C.L. 10-22-97
REVISIONS
S.C.L. 6-29-01
S.C.L. 2-14-08
S.C.L. 9-9-09



MODEL	FIRST MACH.	LAST MACH.
2012-VH	561-03101	
3613-V3	568-04101	
3613-VH	570-04101	
2013-V3	572-04101	
2613-V3	589-09101	

SHIFT LOCK ASSEMBLY (ELECTRICAL)

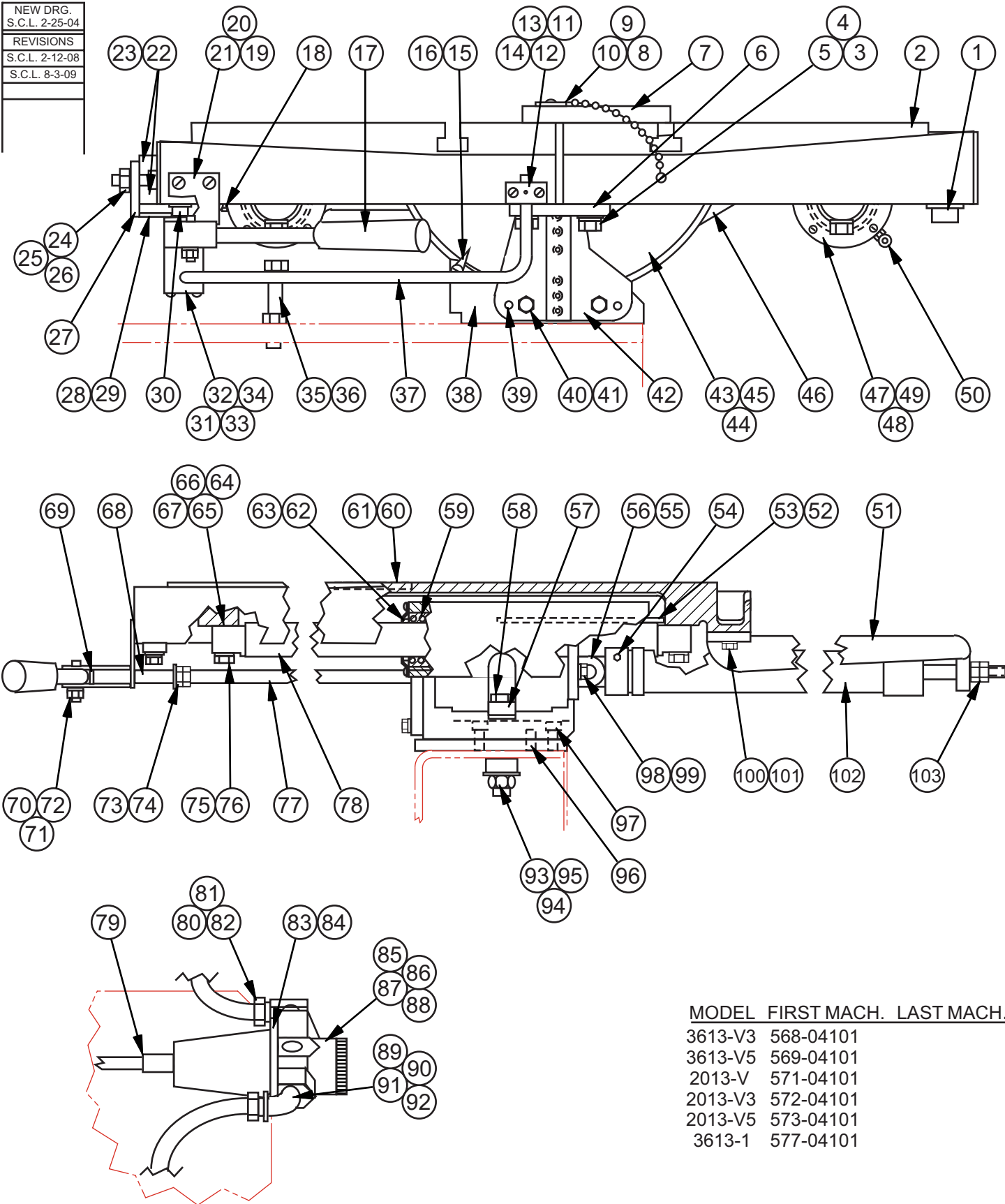
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SHIFT LOCK ASSEMBLY
(Electrical)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	315351	Shift Lock Assembly (110/120V, 50/60 Hz)	
Ref.	315352	Shift Lock Assembly (220/240V, 50/60 Hz)	
1	414422	. Bracket	1
2	198027	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4	2
3	199323	. Washer, Lock 5/16 Std.	2
4	172652	. Bar	1
5	147309	. Sleeve Bearing	1
6	155792	. Compression Spring	1
7	155453	. Locking Pin	1
8	014984	. Copper Washer	1
9	141389	. Solenoid Gasket	1
10	155962	. Retaining Ring	1
11	155791	. Compression Spring	1
12	165639	. Solenoid DIN Connector	1
13	197220	. Electrical Cord (#16-3 Conductor)	A.R.
14	250635	. Retainer	1
15	307253	. Coil (110/120V, 50/60 Hz)	1
	307252	. Coil (220/240V, 50/60 Hz)	1
16	260384	. O-Ring	1
17	307528	. Core Sub-Assembly	1

NEW DRG.	S.C.L. 2-25-04
REVISIONS	
S.C.L. 2-12-08	
S.C.L. 8-3-09	

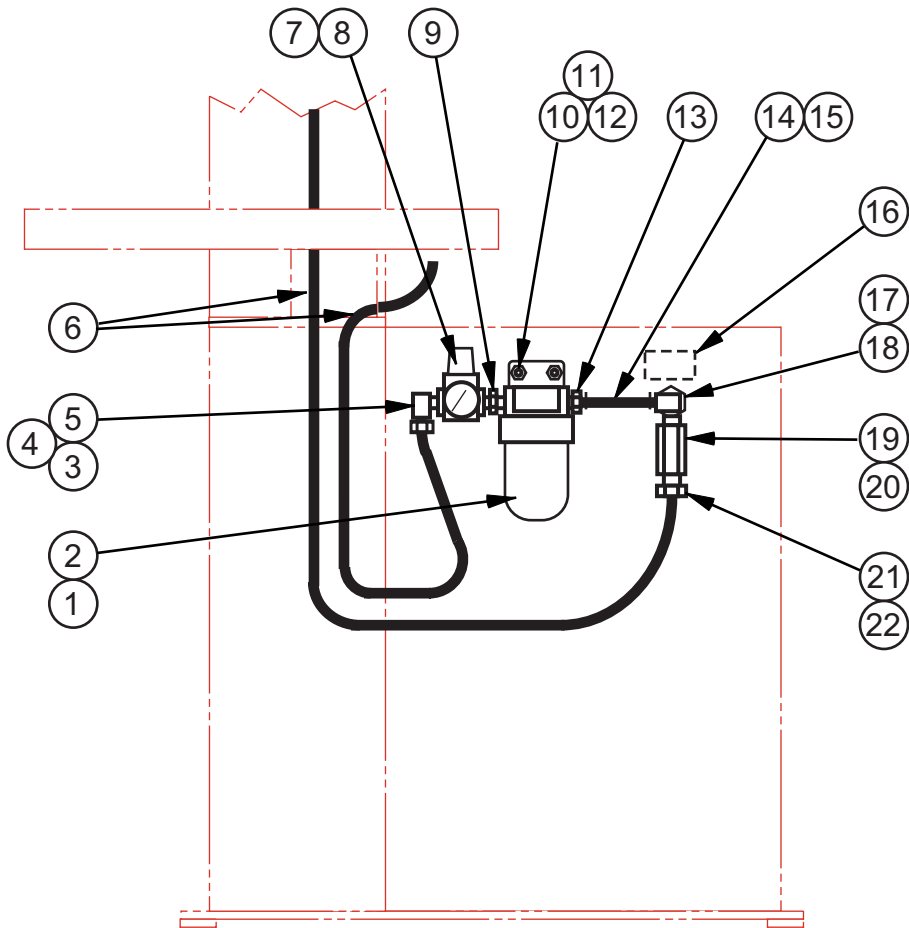


SLIDING AIR TABLE ASSEMBLY

SLIDING AIR TABLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	503826	Sliding Air Table Assembly		53	199019	. Screw, Truss Hd. Mach. 1/4-20NC x 3/8	6
Ref.	211092	Sliding Air Table Assembly (18" Stroke Option)		54	11-005509	. Pipe Plug	1
1	35-006580	. Pipe Plug	1	55	021594	. Swivel Base	1
2	501380	. Table	1	56	005130	. Pin	1
	518044	. Table (18" Stroke Option)	1	57	039464	. Head	1
3	198047	. Screw, Hex. Hd. Cap 3/8-16NC x 1-1/4	2	58	198106	. Screw, Hex. Hd. Cap 3/4-16NF x 5	1
4	199325	. Washer, Lock 3/8 Std.	2	59	003647	. Ball Bushing	4
5	199264	. Washer, Flat 3/8 S.A.E. Std.	2	60	010490	. Center Plate	1
6	004599	. Clamp	1	61	004209	. Spring Pin	1
7	125361	. Square Weldment	1	62	165507	. Rod Wiper	4
8	129590	. Chain	1	63	260468	. O-Ring	4
9	198851	. Screw, Rd. Hd. Mach. #8-32NC x 1/4 ..	2	64	133310	. Shim (.035)	A.R.
10	125393	. Plug	1	65	133311	. Shim (.0149)	A.R.
11	135730	. Support Block	1	66	133312	. Shim (.005)	A.R.
12	198847	. Screw, Rd. Hd. Mach. #6-32NC x 1-1/4	2	67	133313	. Shim (.003)	A.R.
13	199317	. Washer, Lock #6 Std.	2	68	172730	. Shaft	1
14	198406	. Screw, Soc. Set #6-32NC x 1/4	1	69	004244	. Spring Pin	1
15	34-003315	. Pointer	1	70	198252	. Screw, Soc. Hd. Cap 1/4-28NF x 1-1/4	1
16	198838	. Screw, Rd. Hd. Mach. #6-32NC x 1/4 ..	2	71	115660	. Locknut 1/4-28NF (Slotted)	1
17	131011	. Handle Sub-Assembly	1	72	104632	. Belleville Washer	6
	118116	. Handle	1	73	199127	. Nut, Hex. Jam 3/8-16NC	1
	004242	. Spring Pin	1	74	199358	. Washer, Lock 3/8 Shakeproof	1
	125392	. Shaft	1	75	198069	. Screw, Hex. Hd. Cap 1/2-13NC x 2	4
18	35-001775	. Grease Fitting	1	76	199327	. Washer, Lock 1/2 Std.	4
19	125389	. Bracket Weldment	1	77	203103	. Actuator Rod	1
20	198895	. Screw, Rd. Hd. Mach. 1/4-20NC x 1/2 .	2	211086	. Actuator Rod (18" Stroke Option)	1	
21	199356	. Washer, Lock 1/4 Shakeproof	2	78	021612	. Guide Rod	1
22	023967	. Slide Bar	1		321738	. Guide Rod (18" Stroke Option)	1
	321369	. Slide Bar (18" Stroke Option)	1	79	199356	. Washer, Lock 1/4 Shakeproof	1
23	198221	. Screw, Soc. Hd. Cap #10-24NC x 5/8 .	10	80	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
24	009392	. T-Bolt 5/16-18NC	2	81	002004	. Barbed Insert	2
25	199122	. Nut, Hex. 5/16-18NC	2	82	35-006888	. Hose Clamp	2
26	198218	. Screw, Soc. Hd. Cap #10-24NC x 1/4 .	2	83	125386	. Mounting Plate	1
27	009504	. Dog	2	84	198678	. Screw, Fil. Hd. Mach. 1/4-24NF x 1-1/4	2
28	009503	. Stop	2	85	125674	. Regulating Valve	1
29	198895	. Screw, Rd. Hd. Mach. 1/4-20NC x 1/2 .	2	86	198009	. Screw, Hex. Hd. Cap 1/4-20NC x 7/8 ..	2
30	6-033518	. Pipe Plug	1	87	199356	. Washer, Lock 1/4 Shakeproof	2
31	135741	. Support Bar	1	88	122748	. Pipe Plug	1
32	198850	. Screw, Rd. Hd. Mach. #6-32NC x 1-3/4	2	89	17-013521	. 90° Street Elbow	1
33	199317	. Washer, Lock #6 Std.	2	90	002004	. Barbed Insert	2
34	198406	. Screw, Soc. Set #6-32NC x 1/4	1	91	35-006888	. Hose Clamp	2
35	198053	. Screw, Hex. Hd. Cap 3/8-16NC x 2-3/4	1	92	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
36	199127	. Nut, Hex. Jam 3/8-16NC	1	93	199141	. Nut, Hex. Jam 3/4-16NF	1
37	303601	. Guard Bar	1	94	199268	. Washer, Flat 3/4 S.A.E. Std.	1
38	040903	. Cradle	1	95	010501	. Spacer	1
39	133875	. Dowel Pin	2	96	016351	. Dowel Pin (1" Long)	1
40	198047	. Screw, Hex. Hd. Cap 3/8-16NC x 1-1/4	2		35-000445	. Dowel Pin (1-1/2" Long)	1
41	199325	. Washer, Lock 3/8 Std.	2	97	198291	. Screw, Soc. Hd. Cap 1/2-13NC x 3/4 ...	4
42	024241	. Keeper Block	1	98	198027	. Screw, Hex. Hd. Cap 5/16-18NC x 3/4	2
43	021621	. Trunnion Plate	1	99	199323	. Washer, Lock 5/16 Std.	2
44	198822	. Screw, Rd. Hd. Mach. 1/4-20NC x 3/8 .	2	100	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4 ..	2
45	199356	. Washer, Lock 1/4 Shakeproof	2	101	199325	. Washer, Lock 3/8 Std.	2
46	050791	. Trunnion	1	102	209718	. Table Feed Cylinder	1
47	005176	. Retainer	4		209867	. Table Feed Cylinder (18" Stroke Option)	1
48	198867	. Screw, Rd. Hd. Mach. #10-24NC x 3/8.	16	103	199134	. Nut, Hex. Jam 1/2-20NF	2
49	199319	. Washer, Lock #10 Std.	16			Following Not Shown:	
50	010656	. 45° Grease Fitting	1		204231	. Adjustment/Installation Summary	1
51	041061	. Cylinder Bracket	1		35-004455	. Reducer Bushing	1
	418499	. Cylinder Bracket Weldment (18" Stroke Option)	11		203809	. Flow Control Valve (Right Angle)	1
52	503045	. Pan	1		176811	. Vent Filter Breather	1
	518292	. Pan Assembly (18" Stroke Option)	1		203271	. Grommet	3
	418785	. Sliding Pan	1				
	321752	. Pan Weldment	1				

NEW DRG. S.C.L. 2-25-04
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MODEL	FIRST MACH.	LAST MACH.
3613-V3	568-04101	
3613-V5	569-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	

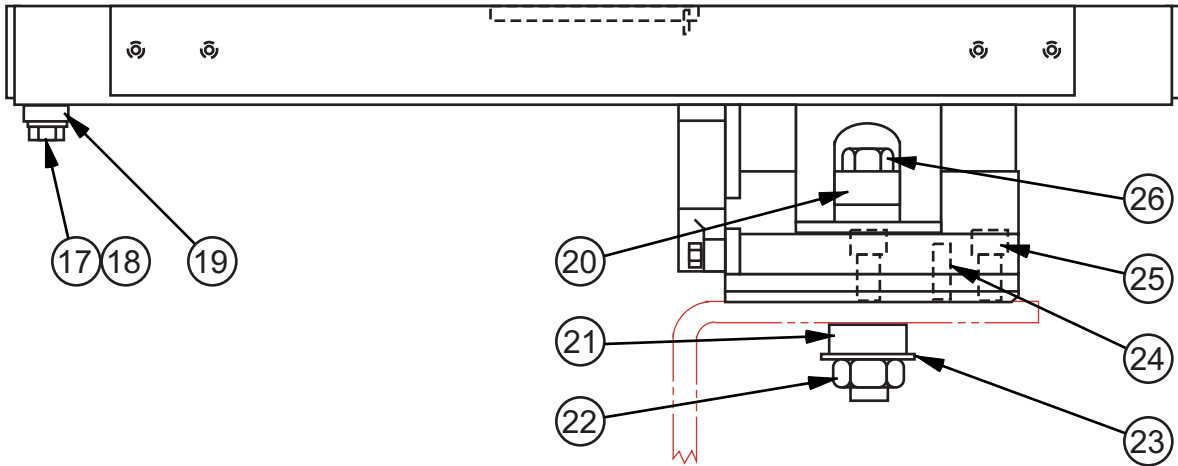
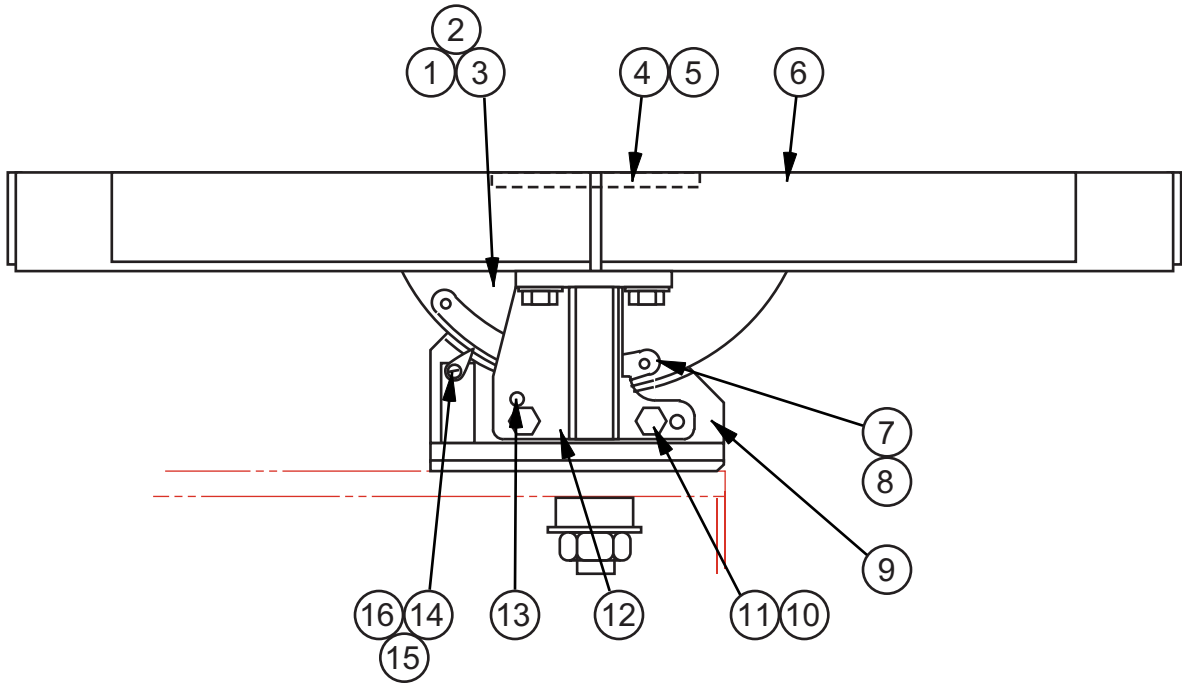
SLIDING AIR TABLE ASSEMBLY (SHOP AIR CONNECTION)

SLIDING AIR TABLE ASSEMBLY
(Shop Air Connection)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	208124	Sliding Air Table Assembly (Shop Air Connection)	
1	145883	. Oil-Fog Lubricator (Includes Bracket)	1
2	138445	. Oil (ASTM #315)	A.R.
3	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
4	5-027506	. 90° Street Elbow	1
5	128179	. Barbed Insert	1
6	35-006888	. Hose Clamp	1
7	206114	. Regulator	1
8	206137	. Gauge	1
9	010923	. Hex. Nipple	1
10	198896	. Screw, Rd. Hd. Mach. 1/4-20NC x 5/8	2
11	199115	. Nut, Hex. 1/4-20NC	2
12	199374	. Washer, Lock 1/4 Shakeproof	2
13	002004	. Barbed Insert	1
14	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
15	35-006888	. Hose Clamp	2
16	176879	. Escutcheon (Air Supply)	1
17	203818	. Anchor Connector	1
18	120389	. 90° Barbed Insert	1
*	120857	. Service Tee (Brass)	1
19*	002004	. Barbed Insert	1
20*	35-006888	. Hose Clamp	1
21*	197094	. Neoprene Hose 11/16 O.D. (Black)	A.R.
22*	35-006888	. Hose Clamp	2

*When Chip Blower or Mist Coolant Options Are Supplied.

NEW DRG. S.C.L. 2-25-04
REVISIONS
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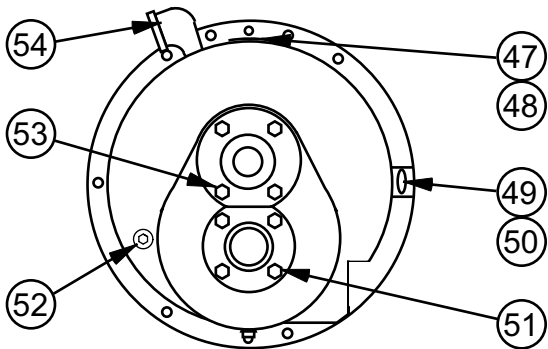
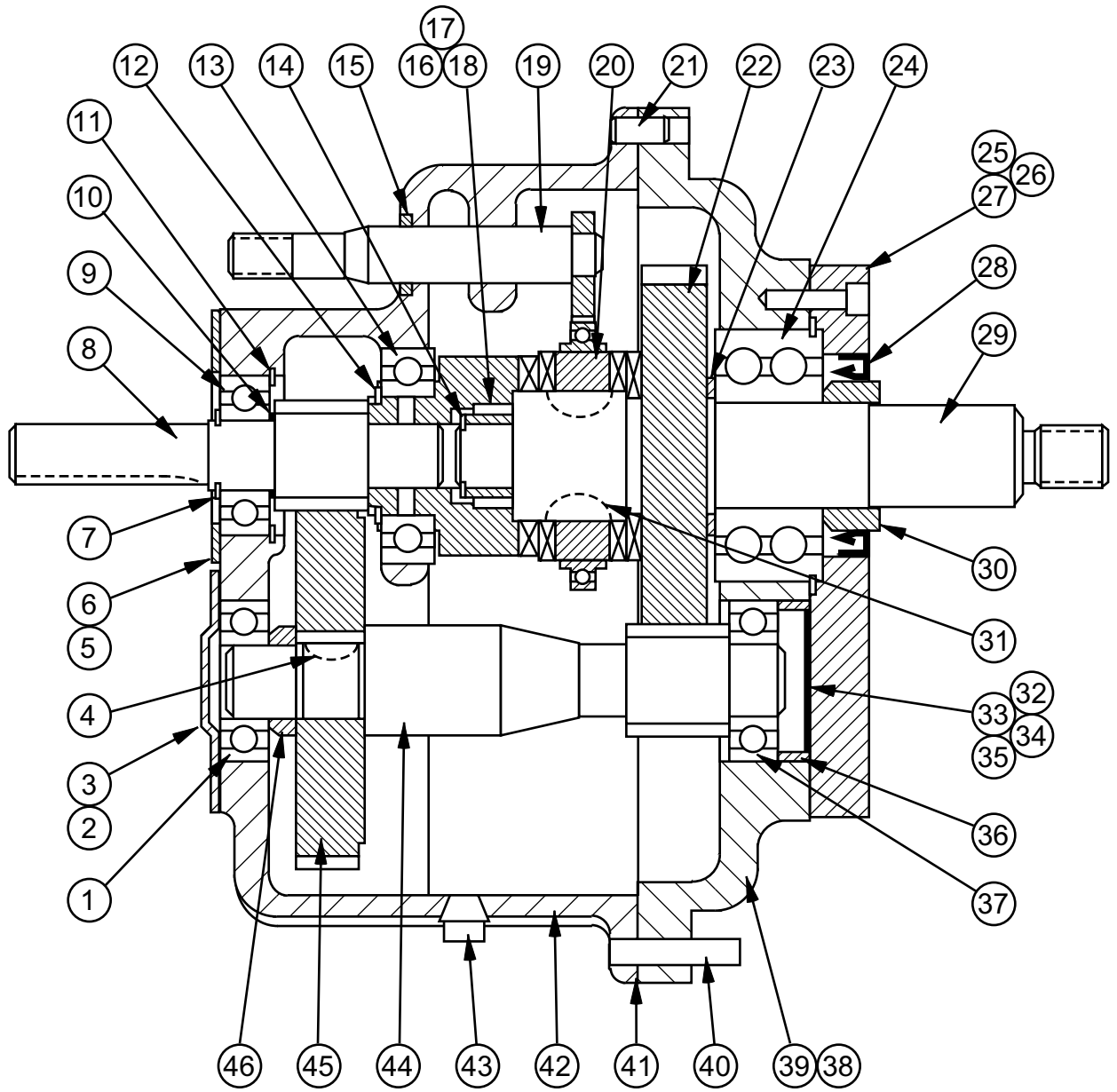
MODEL	FIRST MACH.	LAST MACH.
3613-V3	568-04101	
3613-V5	569-04101	
2013-V	571-04101	
2013-V3	572-04101	
2013-V5	573-04101	
3613-1	577-04101	
2613-V3	589-09101	

TABLE AND TRUNNION ASSEMBLY

TABLE AND TRUNNION ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY.
Ref.	172512	Table and Trunnion Assembly (26" x 26")	
Ref.	172513	Table and Trunnion Assembly (30" x 30")	
1	040645	. Trunnion	1
2	198065	. Screw, Hex. Hd. Cap 1/2-13NC x 1	4
3	199327	. Washer, Lock 1/2 Std.	4
4	316903	. Center Plate (Oval) (Standard)	1
	010490	. Center Plate (Round) (Standard)	1
	317592	. Center Plate (Oval) (Band Filing, Angle Saw Guide Set Option)	1
	120128	. Center Plate (Round) (Band Filing, Angle Saw Guide Set Option)	1
	318034	. Center Plate (Oval) (Band Polishing Option)	1
	010570	. Center Plate (Round) (Band Polishing Option)	1
	317853	. Center Plate (Oval) (90° Saw Guide Option)	1
	029261	. Center Plate (Round) (90° Saw Guide Option)	1
5	004209	. Spring Pin (Round Center Plate Only)	1
6	514113	. Table (26" x 26") (Oval Center Plate)	1
	055303	. Table (26" x 26") (Round Center Plate)	1
	059826	. Table (30" x 30")	1
7	003861	. Escutcheon	1
8	199401	. Screw, Rd. Hd. Drive #6 x 3/8	2
9	512731	. Cradle	1
10	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
11	199325	. Washer, Lock 3/8 Std.	2
12	024244	. Lower Post Block	1
13	35-000516	. Dowel Pin	2
14	34-003315	. Pointer	1
15	198839	. Screw, Rd. Hd. Mach. #6-32NC x 5/16	1
16	199273	. Washer, Flat #6 S.A.E. Std.	2
17	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1	2
18	199264	. Washer, Flat 3/8 S.A.E. Std.	2
19	004599	. Clamp	1
20	039464	. Head	1
21	010501	. Spacer	1
22	199141	. Nut, Hex. 3/4-16NF	1
23	199268	. Washer, Flat 3/4 S.A.E. Std.	1
24	016351	. Dowel Pin	2
25	198291	. Screw, Soc. Hd. Cap 1/2-3NC x 3/4	3
26	198106	. Screw, Hex. Hd. Cap 3/4-16NF x 5	1

NEW DRG.
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VIEW IN DRIVE COMPARTMENT

MODEL FIRST MACH. LAST MACH.

2012-VH	561-03101
3613-V3	568-04101
3612-VH	570-04101
2013-V	571-04101
2013-V3	572-04101
3613-1	577-04101
2613-V3	589-09101

TRANSMISSION ASSEMBLY

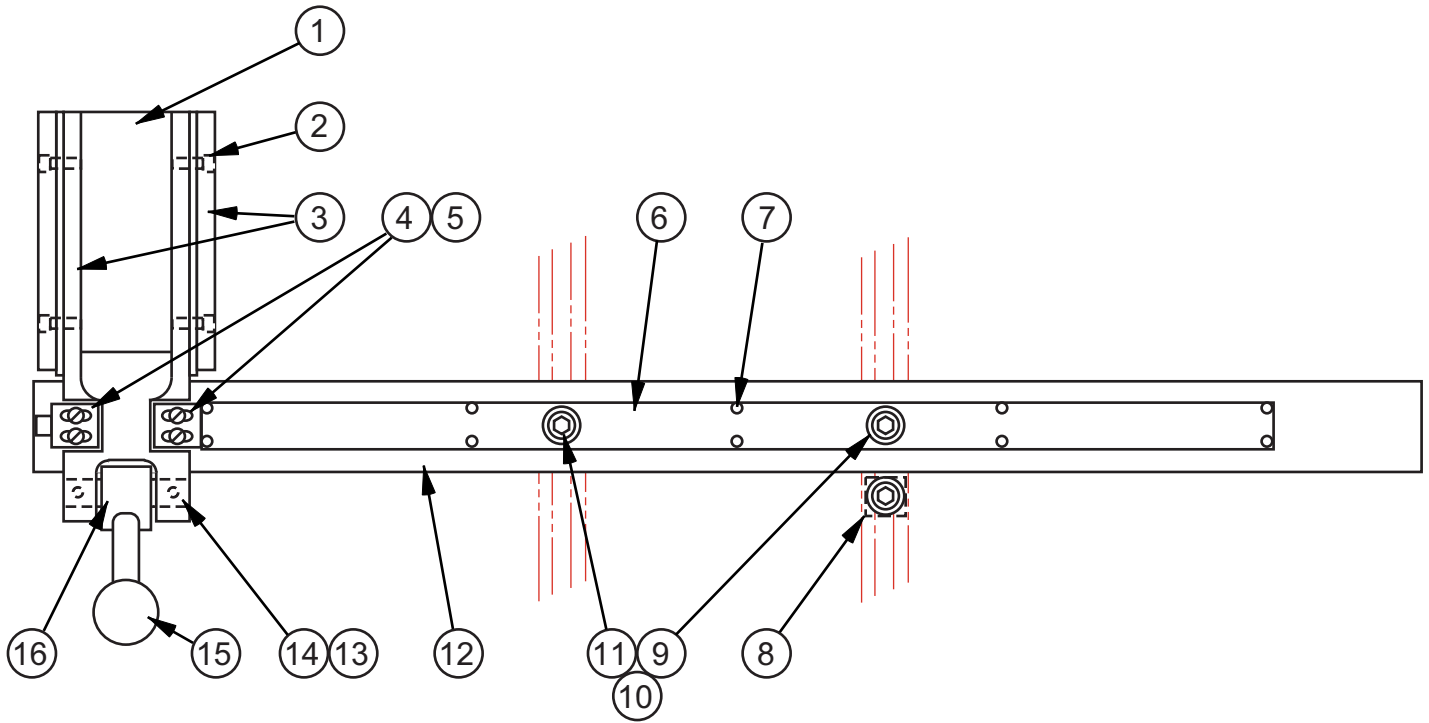
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TRANSMISSION ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	506827	Transmission Assembly	
1	108557	. Bearing	1
2	5-004303	. Countershaft Bearing Cover	1
3	5-004309	. Gasket	1
4	5-004602	. Woodruff Key	1
5	323106	. Bearing Cover	1
6	213598	. Shaft Seal	1
7	35-008664	. Retaining Ring	1
8	307343	. Input Shaft Assembly	1
	031737	. . Input Shaft And Clutch	1
	004283	. . Spring Pin	1
	307344	. . Clutch	1
9	100122	. Ball Bearing	1
10	175651	. Flinger (If Supplied)	1
11	35-008189	. Retaining Ring	1
12	35-007538	. Retaining Ring	1
13	002273	. Ball Bearing	1
14	111692	. Snap Ring	1
15	214190	. Shaft Seal	1
16	164548	. Needle Bearing	1
17	164547	. Inner Race	1
18	143391	. Grease (Union 76 Unoba EP 2)	A.R.
19	111449	. Shifter Fork Weldment	1
20	111451	. Shifter Clutch Assembly	1
	048621	. . Shifter Clutch	1
	111450	. . Ball Bearing	1
	004209	. . Spring Pin	3
21	35-000443	. Dowel Pin	1
22	6-004421	. Clutch Gear	1
23	147522	. Spacer	1
24	147523	. Ball Bearing	1
25	408641	. Bearing Cover Plate	1
26	198239	. Screw, Soc. Hd Cap 1/4-20NC x 3/4	5
27	212668	. Black Silicon (Super Flex 598)	A.R.
28	147524	. Oil Seal	1
29	408637	. Output Shaft	1
30	147521	. Seal Ring	1
31	35-007192	. Woodruff Key	2
32	152085	. Shim (.005)	A.R.
33	152086	. Shim (.010)	A.R.
34	152087	. Shim (.032)	A.R.
35	152088	. Shim (.060)	A.R.
36	147622	. Bearing Spacer	1
37	108557	. Ball Bearing	1
38	506828	. Transmission Cover	1
39	198257	. Screw, Soc. Hd. Cap 5/16-18NC x 5/8	4
40	013122	. Dowel Pin	1
41	5-004311	. Gasket	1
42	054871	. Transmission Case	1
43	152157	. Magnetic Plug	1
44	313681	. Countershaft And Pinion	1
45	5-004424	. Gear	1
46	103235	. Spacer	1
47	160149	. Escutcheon (If Supplied)	1
48	199396	. Screw, Rd. Hd. Drive #2 x 3/16	2
49	113737	. Pipe Plug	1
50	138442	. Gear Oil	A.R.
51	198005	. Screw, Hex. Hd. Cap 1/4-20NC x 3/8	4
52	120369	. Pipe Plug (1/8 NPT)	1
53	159133	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2 (Low Head)	4
54	17-013521	. 90° Street Elbow	1

NEW DRG.
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USED ON T-SLOT TABLES.

UNIVERSALLY CALIBRATED WORK FIXTURE ASSEMBLY

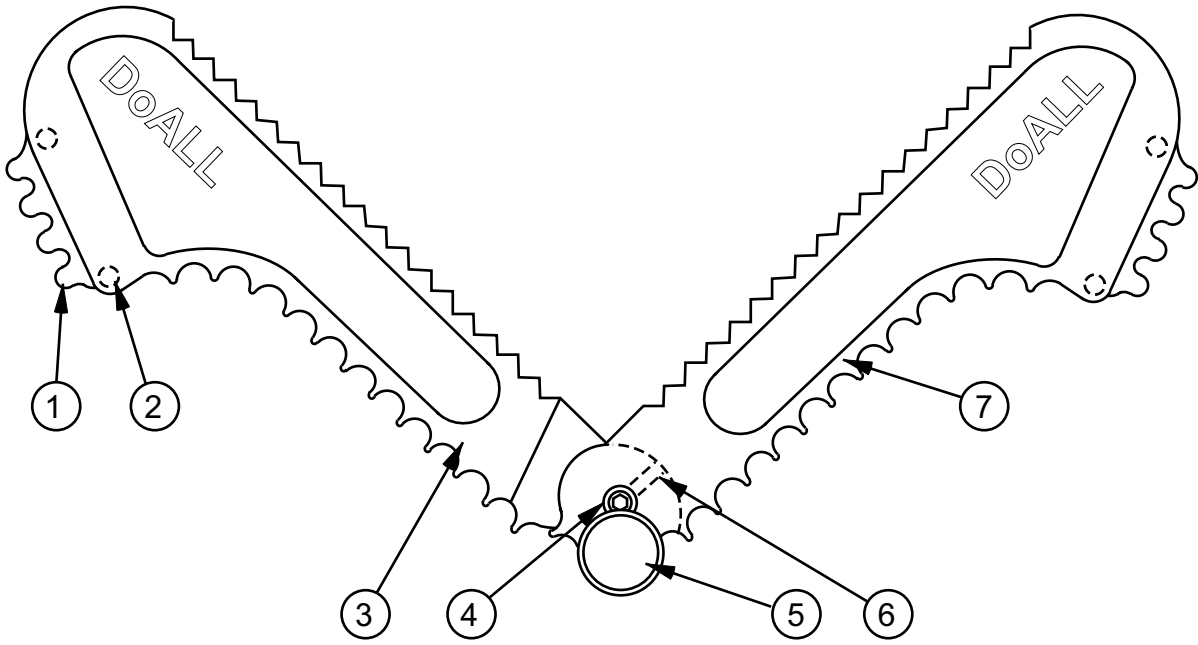
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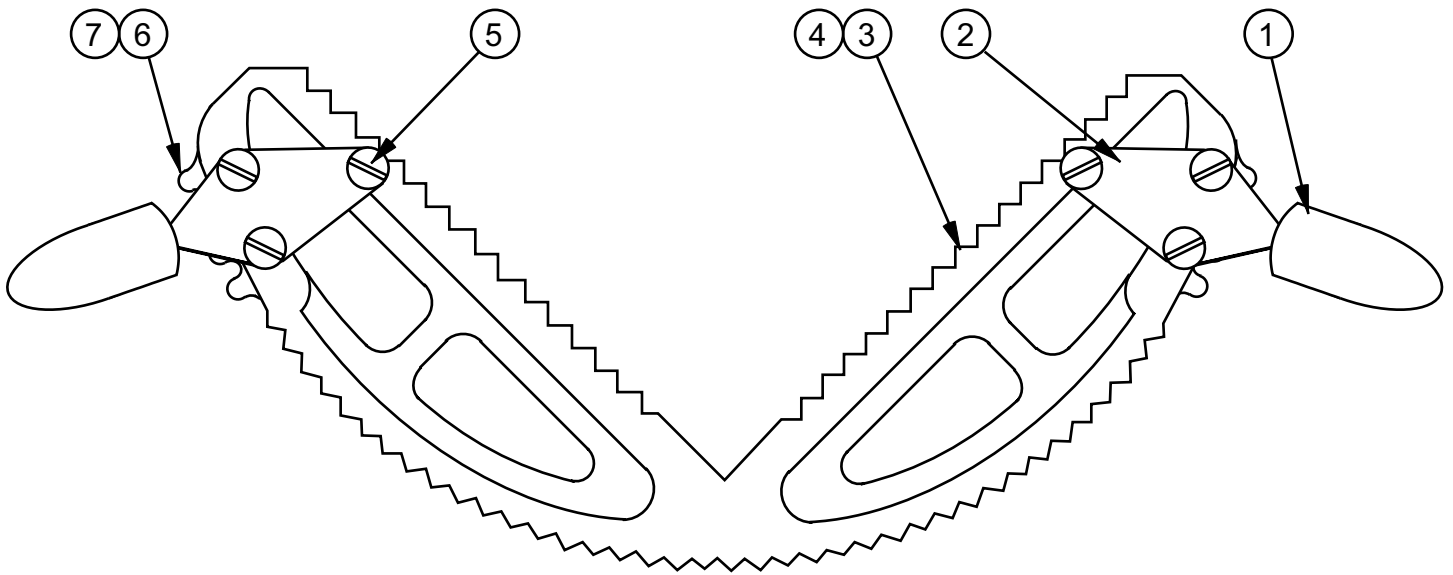
UNIVERSALLY CALIBRATED WORK FIXTURE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	045083	Universally Calibrated Work Fixture Assembly (11" Scale)	
Ref.	404907	Universally Calibrated Work Fixture Assembly (28 cm Scale)	
Ref.	045084	Universally Calibrated Work Fixture Assembly (16" Scale)	
Ref.	404817	Universally Calibrated Work Fixture Assembly (41 cm Scale)	
1	045085	. Head	1
2	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2	4
3	018390	. Wear Strip	2
4	018392	. Pointer	2
5	199005	. Screw, Truss Hd. Mach. #6-32NC x 1/4	4
6	045088	. Scale (11" - 0" - 11")	1
	047500	. Scale (28cm - 0cm - 28cm)	1
	045089	. Scale (16" - 0" - 16")	1
	047499	. Scale (41cm - 0cm - 41cm)	1
7	198833	. Screw, Rd. Hd. Mach. #5-40NC x 1/8	10
8	101117	. Collar (For Angle Cutting)	1
9	198281	. Screw, Soc. Hd. Cap 3/8-16NC x 1-1/2	2
10	199264	. Washer, Flat 3/8 S.A.E. Std.	2
11	003855	. T-Slot Nut	2
12	045086	. Bar (11" and 28 cm Scales)	1
	045087	. Bar (16" and 41 cm Scales)	1
13	018391	. Pin	1
14	198417	. Screw, Soc. Set #10-32NF x 1/4	2
15	34-013508	. Knob	1
16	028892	. Cam Assembly	1
	100702	. . Cam	1
	002579	. . Handle	1

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S.C.L. 2-12-08



WORK HOLDER ASSEMBLY
040262



WORK HOLDING JAW ASSEMBLY
5-013007

WORK HOLDING JAW ASSEMBLIES

WORK HOLDING JAW ASSEMBLIES

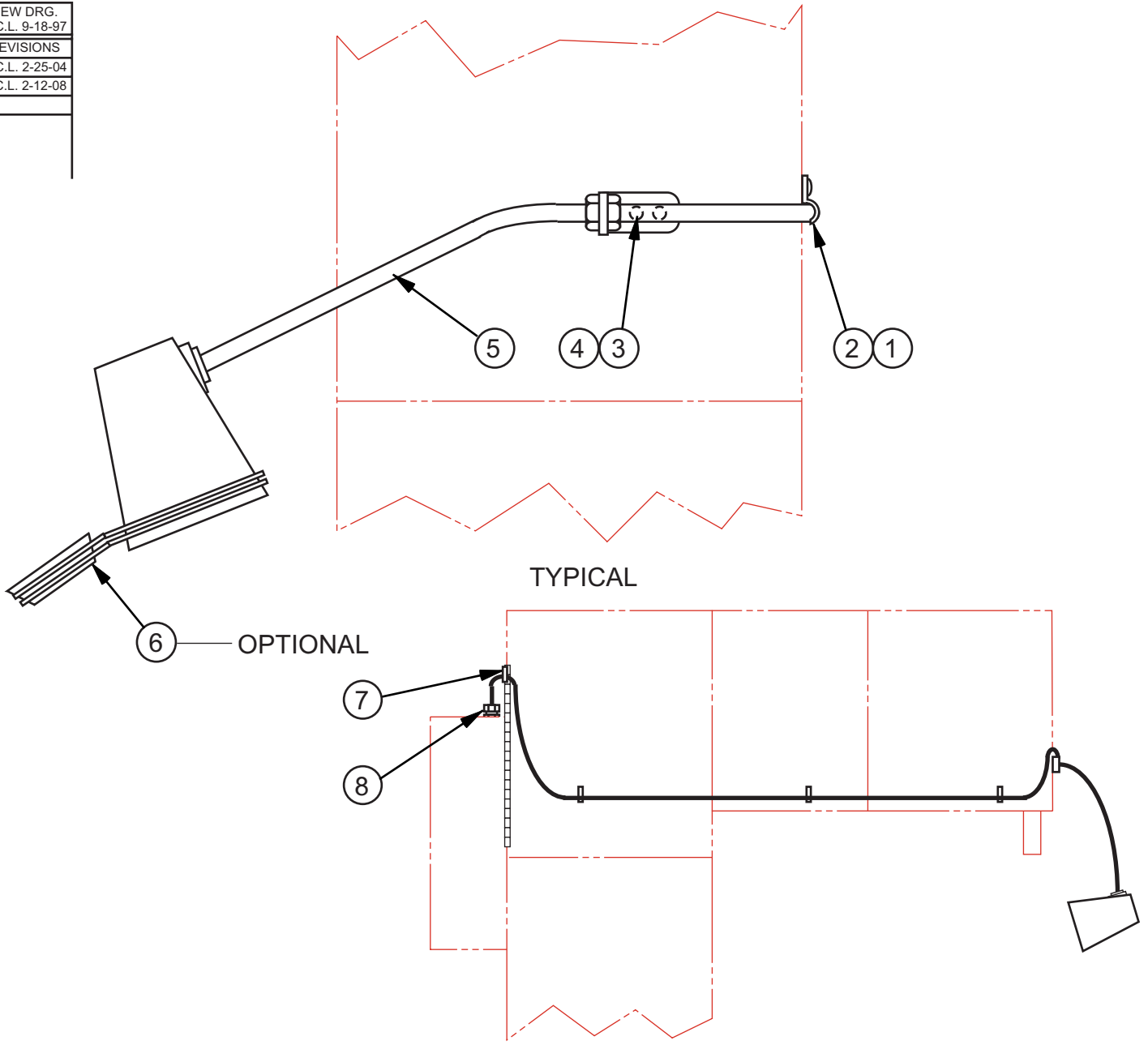
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	040262	Work Holder Assembly	
1*	5-013313	. Sprocket	2
2	198698	. Screw, Fill. Hd. Mach. #10-24NC x 1/2	4
3	020386	. Left Arm	1
4	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2	1
5	002162	. Knurled Screw	1
6	198410	. Screw, Soc. Set #10-24NC x 1/4	2
7	020385	. Right Arm	1

*NOTE: Before 2-12-44 On Hydraulic Machines, Use #6-023337 Sprocket With 3/16" Pitch; Specify Pitch of Chain When Ordering.

Ref.	5-013007	Work Holding Jaw Assembly	
1	5-013512	. Jaw Handle	2
2	5-013318	. Bracket	2
3	040678	. Work Holding Jaw Sub-Assembly	1
4	5-013110	. . Work Holding Jaw	1
5	198892	. . Screw, Rd. Hd. Mach. 1/4-20NC x 5/16	6
6	5-013313	. . Sprocket	2
7	199015	. . Screw, Truss Hd. Mach. #10-24NC x 3/8	4

Ref. 34-003107 Work Holding Jaw (Ratchet And Screw Feed Options)

NEW DRG.
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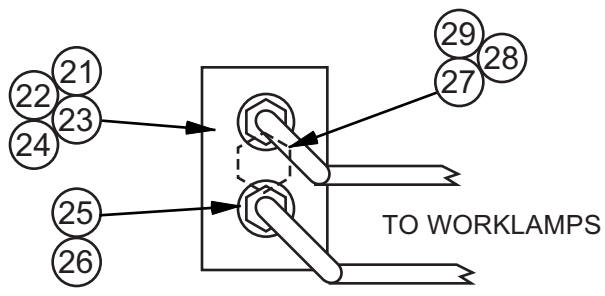


TYPICAL

OPTIONAL

O.S.H.A. REQUIREMENT:
 WIRE DIRECTLY TO CONTROL BOX.
 SEE ELECTRICAL SCHEMATIC FOR
 CONNECTIONS AND/OR MORE
 INFORMATION.

OPTIONAL ON ALL MACHINES.



FOR MACHINES WITH 2 WORKLAMPS
 (2613-3, 2618-4, 6013-H3)

WORKLAMP ASSEMBLY

WORKLAMP ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	220670	Worklamp Assembly (Standard)	
Ref.	220671	Worklamp Assembly (Extra Work Height)	
1	018172	. Tubing Clamp	A.R.
2	198853	. Screw, Rd. Hd. Mach. #8-32NC x 3/8	A.R.
3	198892	. Screw, Rd. Hd. Mach. 1/4-20NC x 5/16	2
4	199321	. Washer, Lock 1/4 Std.	2
5	221545	. Worklamp (Includes Bracket)	1
	221546	. Worklamp (Includes Bracket) (Extra Work Height)	1
6	138436	. Magnifier (Optional)	1
7	009955	. Nylon Tubing Clamp	1
	198853	. Screw, Rd. Hd. Mach. #8-32NC x 3/8	1
8	201688	. Cord Grip Connector (.200-.394)	1
Ref.	406094	Worklamp Assembly (2 Worklamps) (2613-3, 6013-H3)	
21	100506	. Outlet Box Assembly	1
	002992	. Junction Box (2618-4 Only)	1
22	137173	. Box Cover	1
23	137172	. Gasket	1
24	133826	. Wire Connector	A.R.
25	015139	. Cord Grip Connector	2
26	014411	. Flange Washer	2
27	197156	. Sealtite Conduit 1/2 I.D.	A.R.
28	014545	. Sealtite Connector	2
29	014411	. Flange Washer	2

Use Worklamps Listed Above; Quantity of 2.