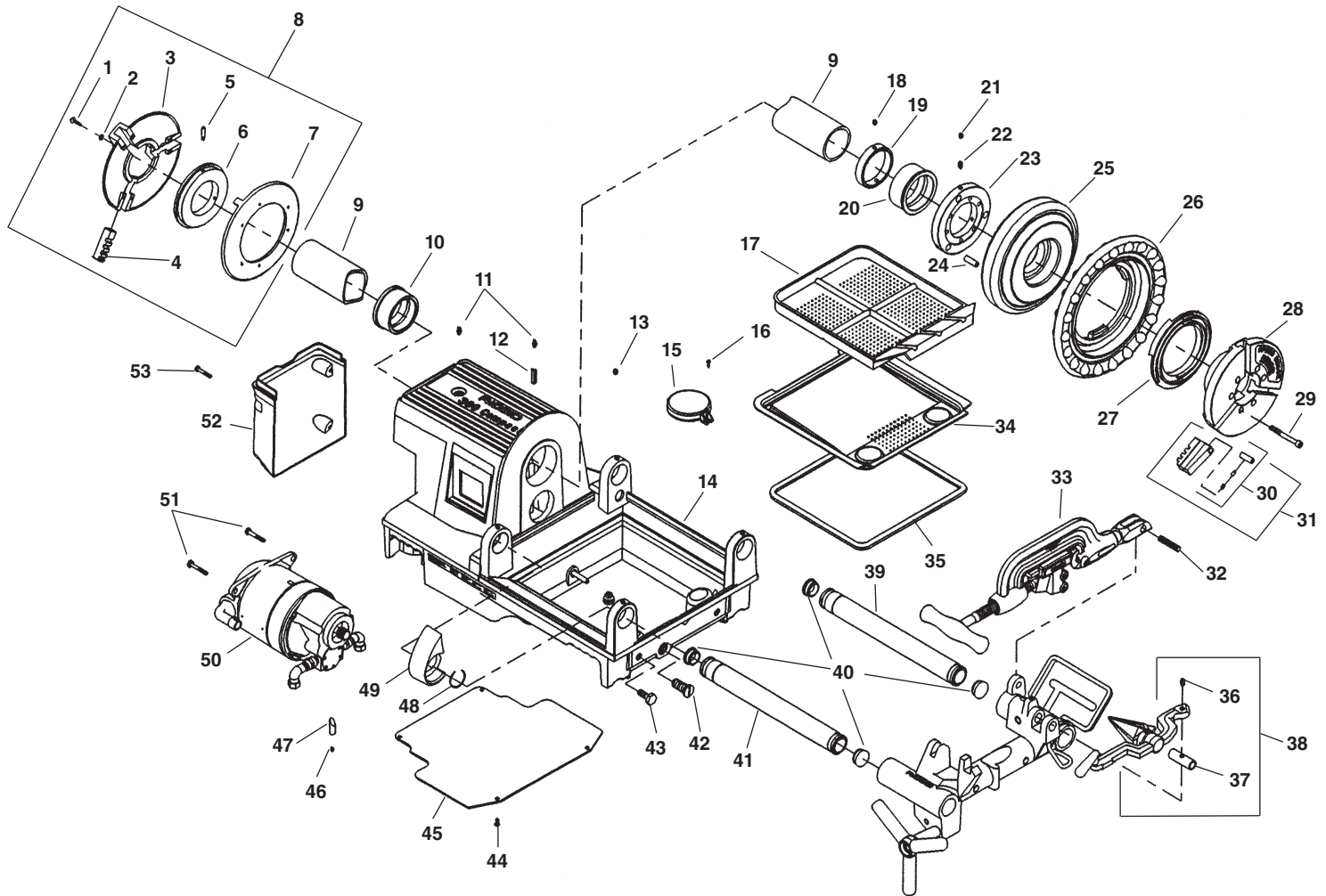


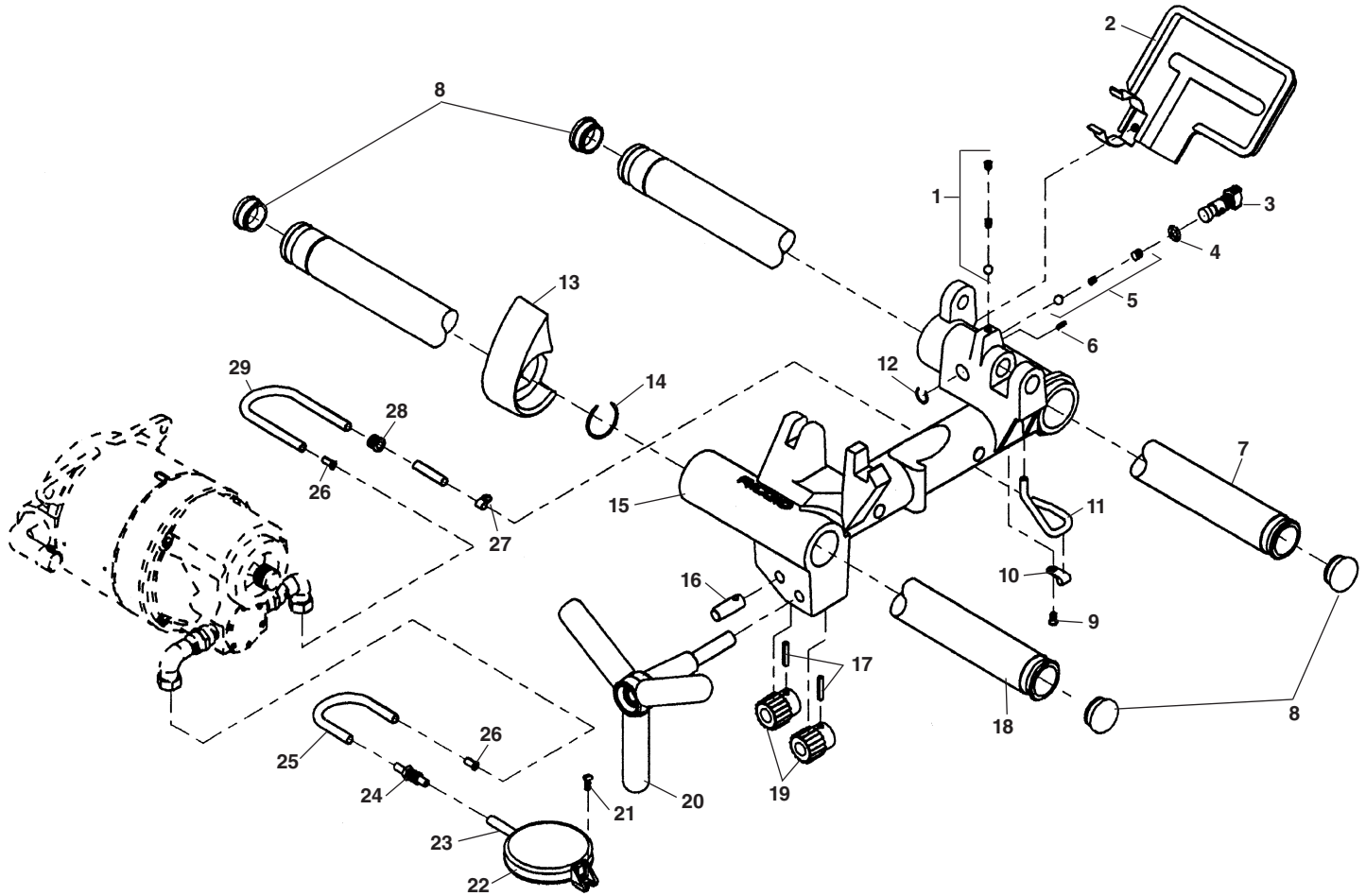
**Main Drive Components**



**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	46790	Screw 12 - 24 x 3/4" (6)	28	43525	Chuck Cap
2	40270	Lock Washer (6)	29	45295	Screw 5/16" x 2 3/4" (6)
3	43735	Rear Centering Head	30	44715	Jaw Insert Set (3)
	19346	Rear Centering Head (Europe)		97365	Jaw Insert Set f/Coated Pipe (3)
4	46500	Rear Jaw	31	44090	Chuck Jaw Set
5	45260	Step Pin	32	45520	Hinge Pin
6	44095	Scroll	33	42370	360 Cutter Complete
7	43740	Back Plate	34	54052	Oil Pan Liner
	19356	Back Plate (Europe)	35	75632	Oil Pan Liner Gasket
8	44165	Rear Centering Assembly	36	36262	Shoulder Screw
9	44100	Drive Shaft	37	36267	Pivot Pin
10	45335R	Rear Bearing	38	34612	344 Reamer
11	46860	Grease Fitting (2)	39	54112	Rear Rail
12	45310R	Pin Split Roll	40	35162	Rail Plug (4)
13	60025R	Set Screw 5/16" - 18 (4)	41	54117	Front Rail
14	54522	Base Export	42	54302	Drain Plug
	76342	Base N.A.	43	54042	M10-1.5 Hex Hd. Cap Screw
15	58467	Filter Screen Assembly	44	87730	Screw 1/4" x 3/8" (4)
16	45420	Screw 10 - 24 x 3/8"	45	61937	Bottom Cover
17	54047	Chip Tray	46	77905	Set Screw 5/16" x 1/4"
18	33785	Set Screw 5/16" x 24 x 5/16" (3)	47	54037	Motor Wedge
19	45345	Thrust Ring	48	87620	Retaining Ring
20	54502	Front Bearing	49	54507	Carriage Stop
21	45300R	Set Screw 5/16" x 24 x 1/4" (3)	50	54797	Model 2192, 115V
22	45265	Set Screw 5/16" x 24 x 1/2" (3)		54802	Model 2292R, 230V
23	30027	Drive Ring		74182	Model 2199R, 115V, 52 RPM
24	30022	Drive Pin (3)	51	85915	Motor Mounting Bolt (2)
25	30017	Ring Gear	52	61932	Motor Cover
26	89150	Hand Wheel	53	54532	Motor Cover Screw (4)
27	43540	Chuck Scroll			

## Carriage and Oil System

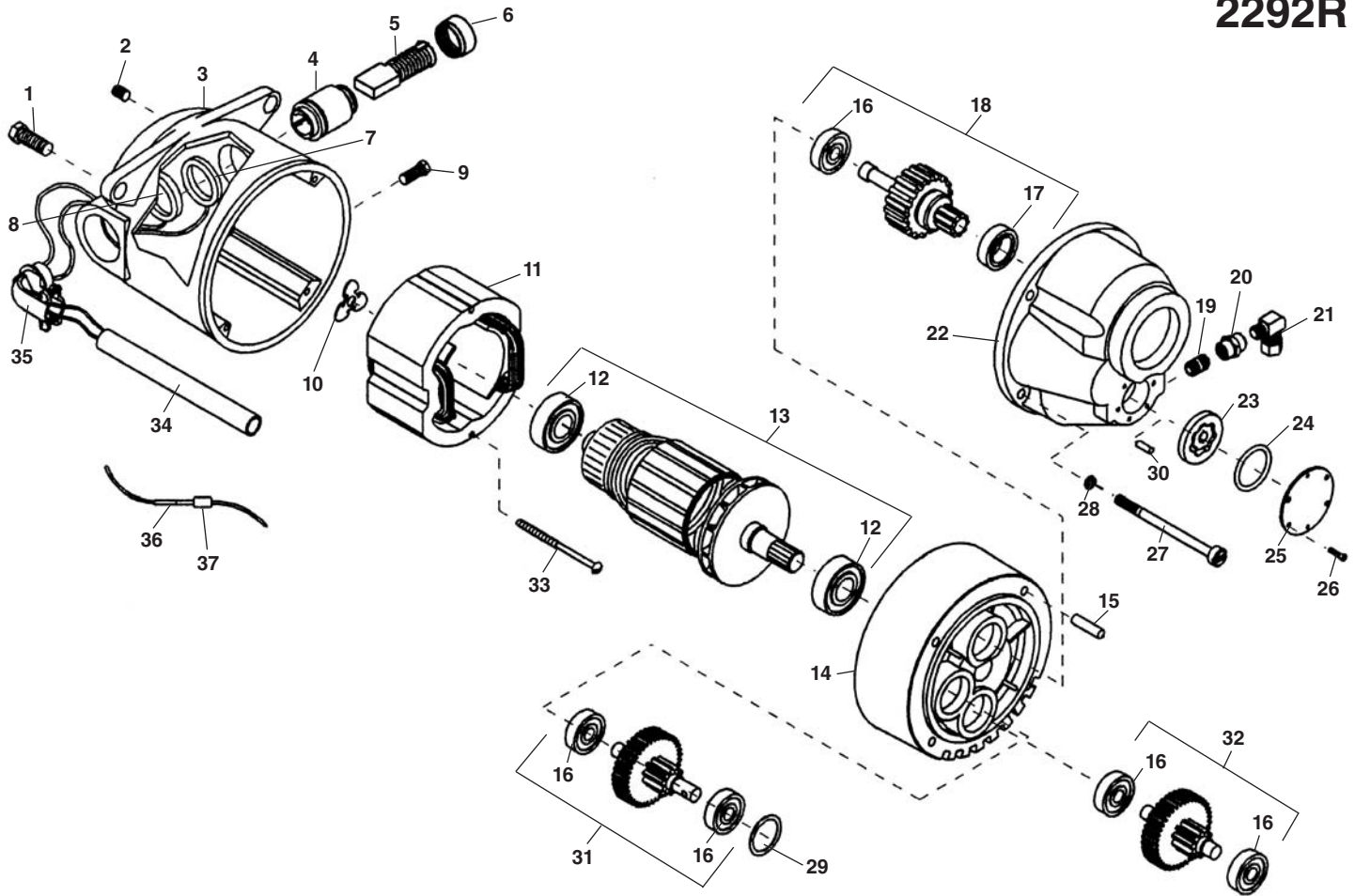


**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description
1	46810	Detente Assembly
2	54517	Drip Pan
3	54097	Spool Valve
4	54102	O-Ring
5	35307	Oil Pressure Relief Set
6	58417	Roll Pin 1/8" x 3/8"
7	54112	Rear Rail
8	35162R	Rail Plug (4)
9	79965	Screw 10 - 32 x 1/2"
10	35062	Oil Line Clamp
11	35067	Oil Tube
12	54107	Retaining Ring
13	54507	Carriage Stop
14	87620	Retaining Ring
15	54512	Carriage
16	35187	Pinion Idler Shaft
	54122	Cap Plug (not shown)
17	34342R	Roll Pin
18	54117	Front Rail
19	59092	Pinion
20	35182R	Hand Wheel
21	45420	Screw 10 - 24 x 3/8"
22	58467	Filter Screen Assembly
23	61897	Oil Filter Tube
24	54142	Bulkhead Fitting
25	54152	Oil Intake Line
26	35117	Oil Line Insert
27	35142	Hose Clamp
28	47080	Oil Line Grommet
29	61282	Carriage Oil Line

**Motor**

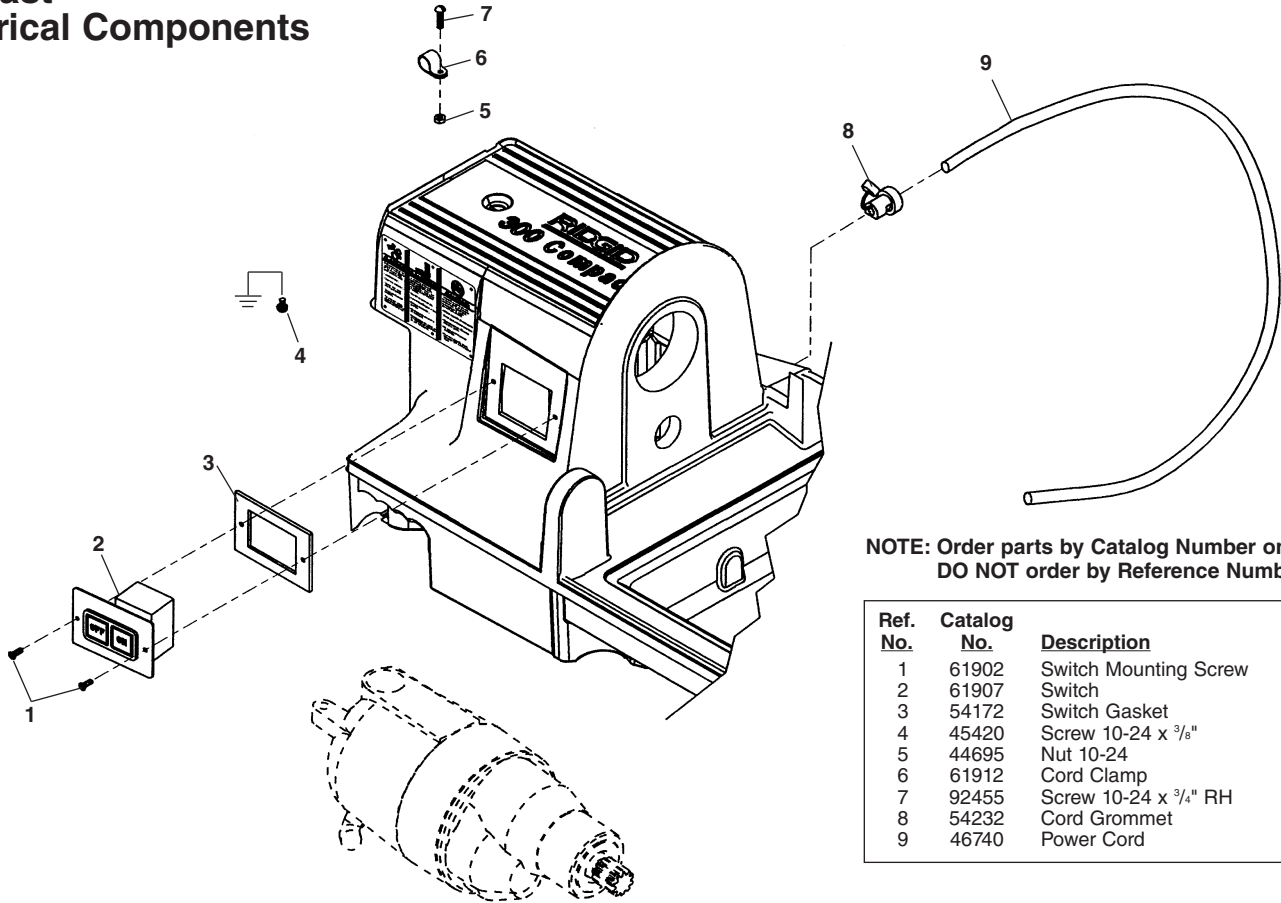
**2292  
2192R  
2292R**



**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
—	72127	Motor Model 2292, 230V	12	44565	Armature Bearing (2)	26	96890	Screw #4 x 3/8" (6)
—	54797	Motor Model 2192R, 115V	13	52497	115V Armature	27	45075	Screw 1/4" - 20
—	54802	Motor Model 2292R, 230V	14	54542	230V Armature	28	45150	Lock Washer 1/4"
1	85915	Motor Mounting Bolt (2)	15	54552R	Fan Housing Assembly	29	96880	Oil Seal
2	39770	Set Screw 1/4" - 20 x 1/4" (2)	16	44760	Gear Bearing	30	96885	Pin
3	52482	Motor Housing	17	45315	Front Bearing	31	52522	1st Gear Assembly
4	45025	Brush Holder Set (2)	18	54537	Main Drive Gear Assembly	32	54547R	2nd Gear Assembly
5	44540	Brush Assembly Set (2)	19	52507	1/8" NPT Close Nipple (2)	33	44555	Screw 10 - 24 x 3"
6	44545	Brush Cap Set (2)	20	52512	1/8" Coupling (2)	34	63382	Plastic Tube
7	86685	Red Brush Lead	21	52517	Elbow Compression Fitting (2)	35	46900	90 Connector
8	86680	White Brush Lead	22	96830	Gear Case	—	47412	Male Wire Connector
9	83500	Field Locking Screw	23	96870	Gerotor Set	36	16946	Male Connector
10	44580	Loading Spring	24	96875	"O" Ring	37	16956	Female Connector
11	44015	Field 100/115V	25	96840	Cover Plate			
	44035	Field 230V						

## Far East Electrical Components

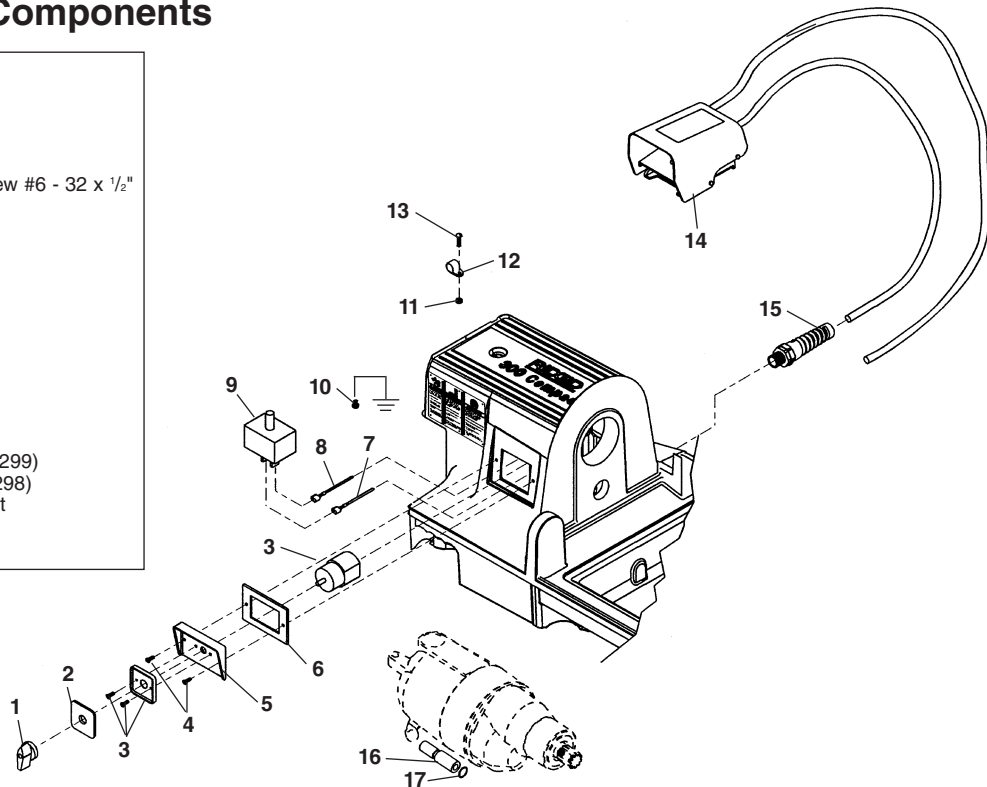


**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description
1	61902	Switch Mounting Screw
2	61907	Switch
3	54172	Switch Gasket
4	45420	Screw 10-24 x 3/8"
5	44695	Nut 10-24
6	61912	Cord Clamp
7	92455	Screw 10-24 x 3/4" RH
8	54232	Cord Grommet
9	46740	Power Cord

## European Electrical Components

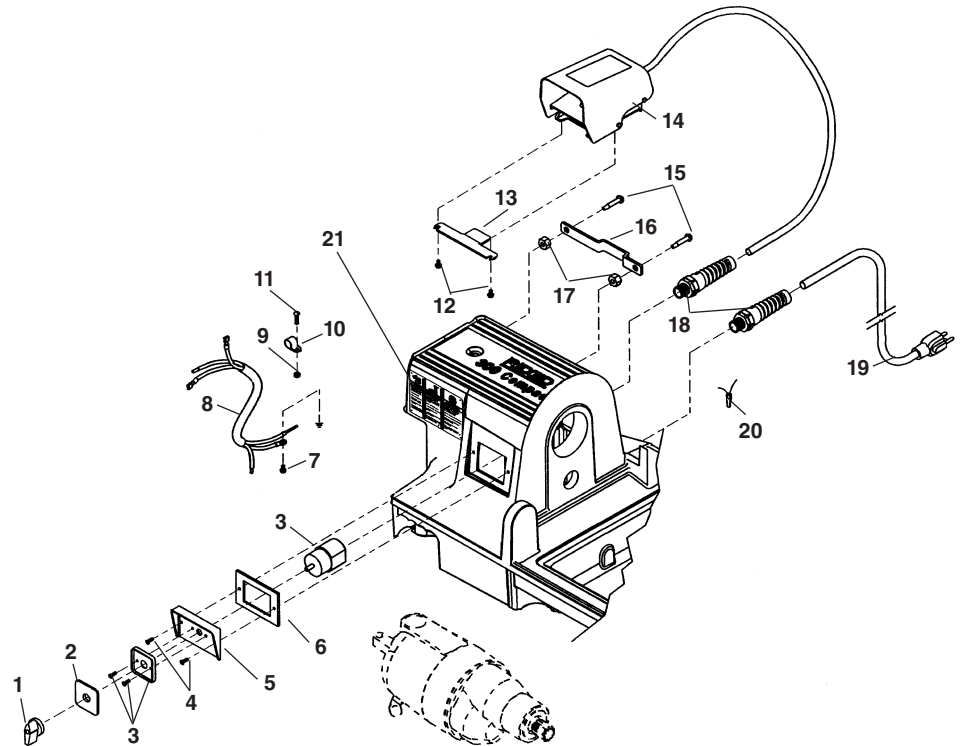
Ref. No.	Catalog No.	Description
1	61397	Switch Knob
2	54167R	Switch Face Plate
3	54157	Switch & Screws
4	61902	Slotted Pan Head Screw #6 - 32 x 1/2"
5	61917	Switch Plate
6	54172	Switch Gasket
7	63387	Brown Wire
8	63392	Blue Wire
9	63372	Suppressor
—	63387	Brown Lead Wire
—	63392	Blue Lead Wire
10	45420	Screw 10-24 x 3/8"
11	44695	Nut 10-24
12	61912	Cord Clamp
13	92455	Screw 10-24 x 3/4" RH
14	36652	Foot Switch (B-296)
	40022	Foot Switch f/Aust. (B-299)
	40017	Foot Switch f/U.K. (B-298)
15	46730	Strain Relief w/Locknut
16	63377	Ferrite Bead
17	43552	Cable Tie



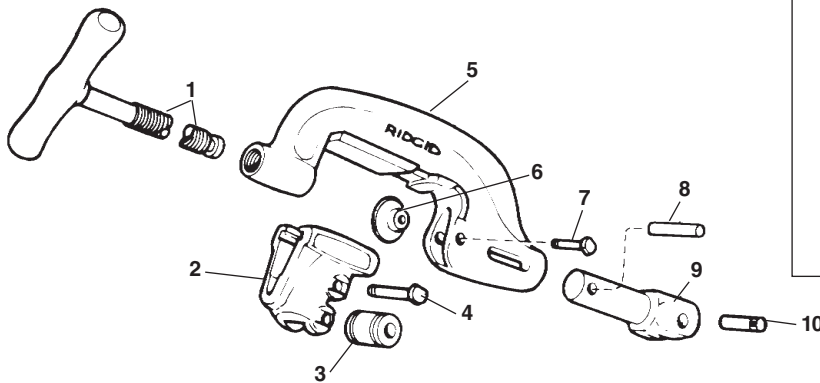
### 120V 60Hz Electrical

NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.

Ref. No.	Catalog No.	Description
1	61397	Switch Knob
2	61967	Switch Face Plate
3	54157	Switch Assembly
4	54162	Screw (2)
5	61917	Switch Plate
6	54172	Gasket
7	45420	Screw #10 - 24 x 3/8"
8	30953	Connecting Cord
9	44695	Hex Nut #10 - 24
10	61912	Cord Retainer
11	92455	Screw #10 - 24 x 3/4"
12	54357	Screw 3/16" - 18 (2)
13	58602	Foot Switch Hook
14	36642	B-294 Foot Switch
15	54137	Screw (2)
16	62767	Foot Switch Hanger Bracket
17	96730	Hex Nut 3/16" - 18
18	72107	Strain Relief
19	46740	Power Cord
20	44635	End Splice Connector
21	78367	Warning Plate



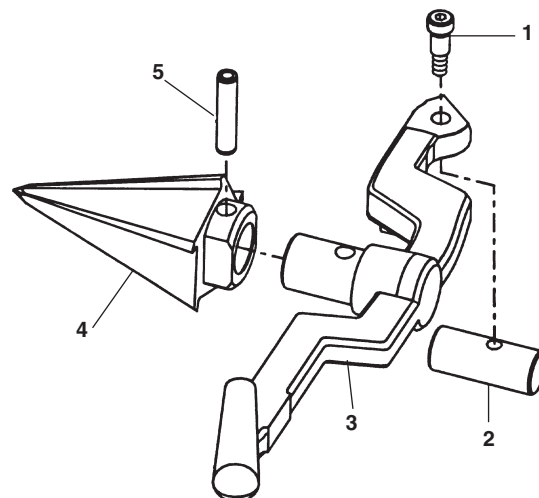
### No. 360 Cutter



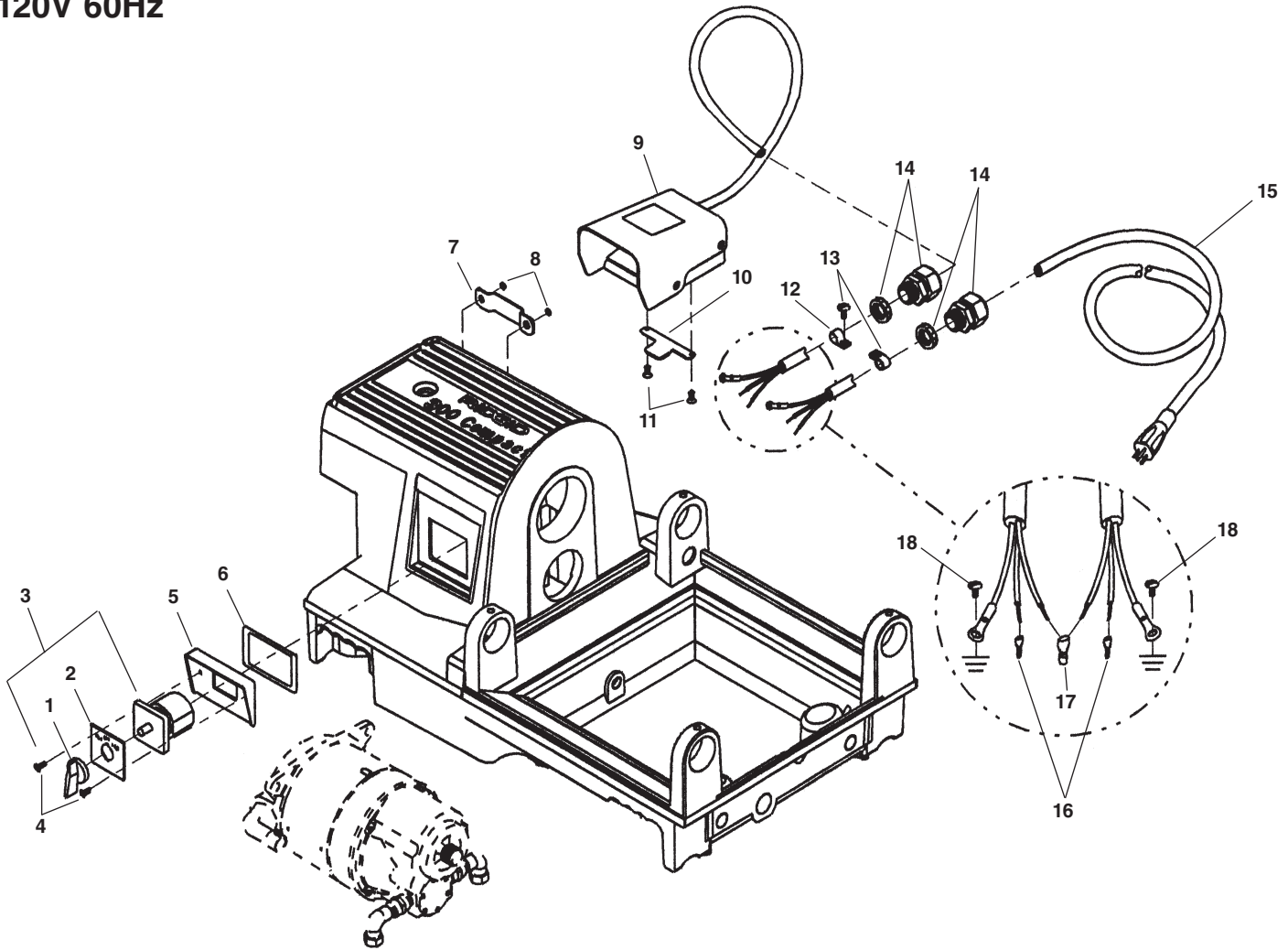
Ref. No.	Catalog No.	Description
—	42370	360 Cutter Complete
1	43625	D-1024-X Screw Handle
2	33400	C-878-X Roll Housing Assembly
3	34305	E-1751 Roll (2)
4	34310	E-1752 Roll Pin (2)
5	43595	C-877 Cutter Frame
6	33100	F-514 Cutter Wheel Thin
	33105	F-3 Cutter Wheel H.D.
7	44185	E-1032 Cutter Wheel Std.
8	34780	F-9 Wheel Pin
9	45435	E-3549 Retaining Pin
10	45505R	E-3759 Support Arm
	45520	E-3819 Pin

### No. 344 Reamer

Ref. No.	Catalog No.	Description
—	34612	344 Reamer Complete
1	36262	Shoulder Screw
2	36267	Pivot Pin
3	36272	Reamer Arm
4	36277	Reamer Cone
5	35355	Split Roll Pin



52 RPM Electrical  
120V 60Hz



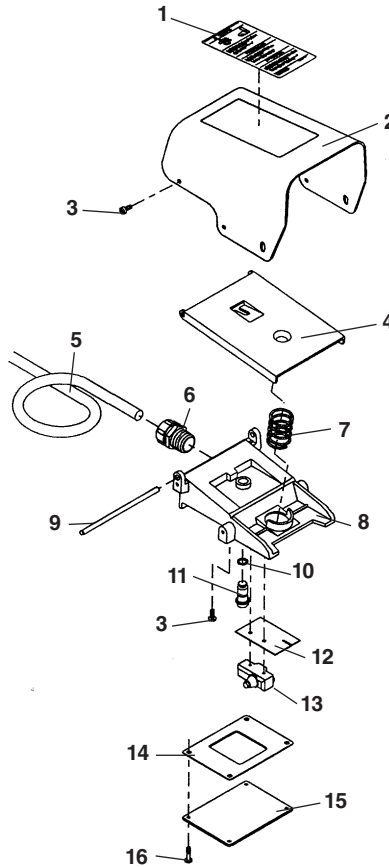
**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	61397	Switch Knob	10	58602	Foot Switch Hook
2	61967	Switch Face Plate	11	54357	Screw $\frac{5}{16}$ " - 18 (2)
3	54157	Switch Assembly	12	75937	Cable Clamp (2)
4	54162	Screw (2)	13	92455	Screw #10-24 x $\frac{3}{4}$ "
5	61917	Switch Plate	14	75952	Strain Relief with Nut
6	54172	Gasket	15	75902	Power Cord
7	62767	Foot Switch Hanger Bracket	16	76347	Wire Terminals (6)
8	54137	Screw (2)	17	44635	Wire End Splice
9	74272	B294 HD Foot Switch	18	45420	Grand Screw #10-24 x $\frac{3}{8}$ " (2)

**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

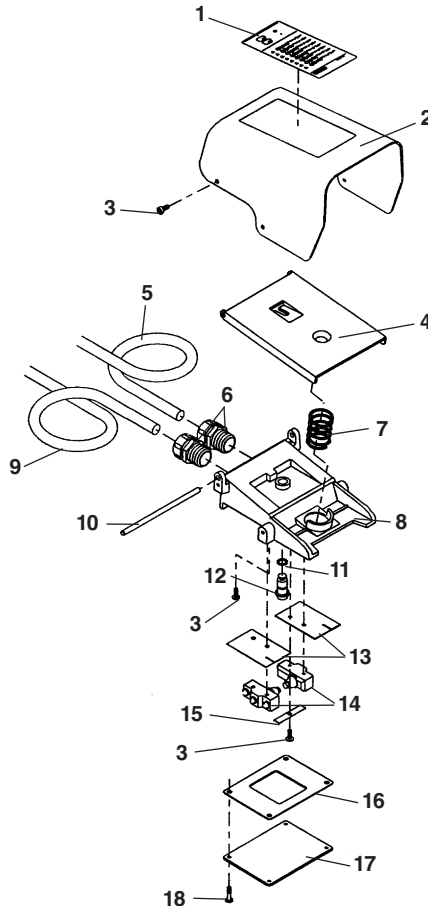
**B-294  
B-295  
301-A  
B-294 HD**

Ref. No.	Catalog No.	Description
—	36642	B-294 Foot Switch
—	36647	B-295 Foot Switch
—	36662	301-A Foot Switch
—	74272	B-294 HD Foot Switch
1	36667	Warning Label (B-294)
	36672	Warning Label (B-295)
	36687R	Warning Label (301-A)
	76352	Warning Label (B-294 HD)
2	36692R	Cover
3	36787	Screw #10 Self-tapping (5)
4	36697R	Foot Pedal
5	68880	Cord (B-294)
	36712	Cord (B-295)
	36727	Cord (301-A)
	75972	Cord (B-294 HD)
6	36732	Cord Connector
	75977	Cord Connector (B-294 HD)
7	36702	Spring
8	54347	Base
9	36747	Pivot Pin
10	36767	O-Ring
11	36772	Poppet
12	54367	Insulator
13	36762	Micro Switch
14	54372	Seal
15	54362	Bottom Cover
16	54357	Bottom Cover Screw (4)

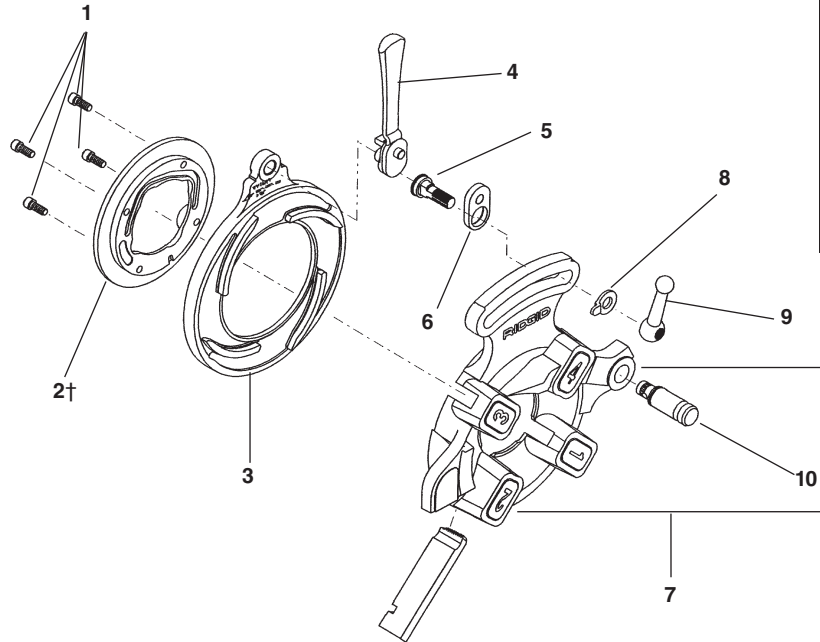


**B-296  
B-297  
B-298  
B-299**

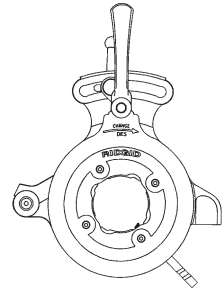
Ref. No.	Catalog No.	Description
—	36652	B-296 Foot Switch
—	36657	B-297 Foot Switch
—	40017	B-298 Foot Switch (U.K.)
—	40022	B-299 Foot Switch (Australia)
1	36677	Warning Label (B-296)
	36682	Warning Label (B-297)
	54392	Warning Label (B-298)
	45017	Warning Label (B-299)
2	54382	Cover
3	36787	Screw #10 Self-tapping (6)
4	36697R	Foot Pedal
5	36717	Cord (B-299)
	36792	Cord (B-296)
	36722	Cord (B-297)
	45027	Cord (B-298)
6	36732	Cord Connector (2 )
7	36702	Spring
8	54352	Base
9	36717	Line Cord (B-296)
	36797	Line Cord (B-297)
	45022	Line Cord (B-298)
10	36747	Pivot Pin
11	36767	O-Ring
12	36772	Poppet
13	54367	Insulator (2)
14	36762	Micro Switch (2)
15	54377	Switch Bracket
16	54372	Seal
17	54362	Bottom Cover
18	54357	Bottom Cover Screw (4)



**811A  
842  
555  
531B  
532B  
500A MONO**



**Service Note**



†2 Retaining Ring must be oriented as shown for proper oil flow.

**QUICK OPENING DIE HEADS**

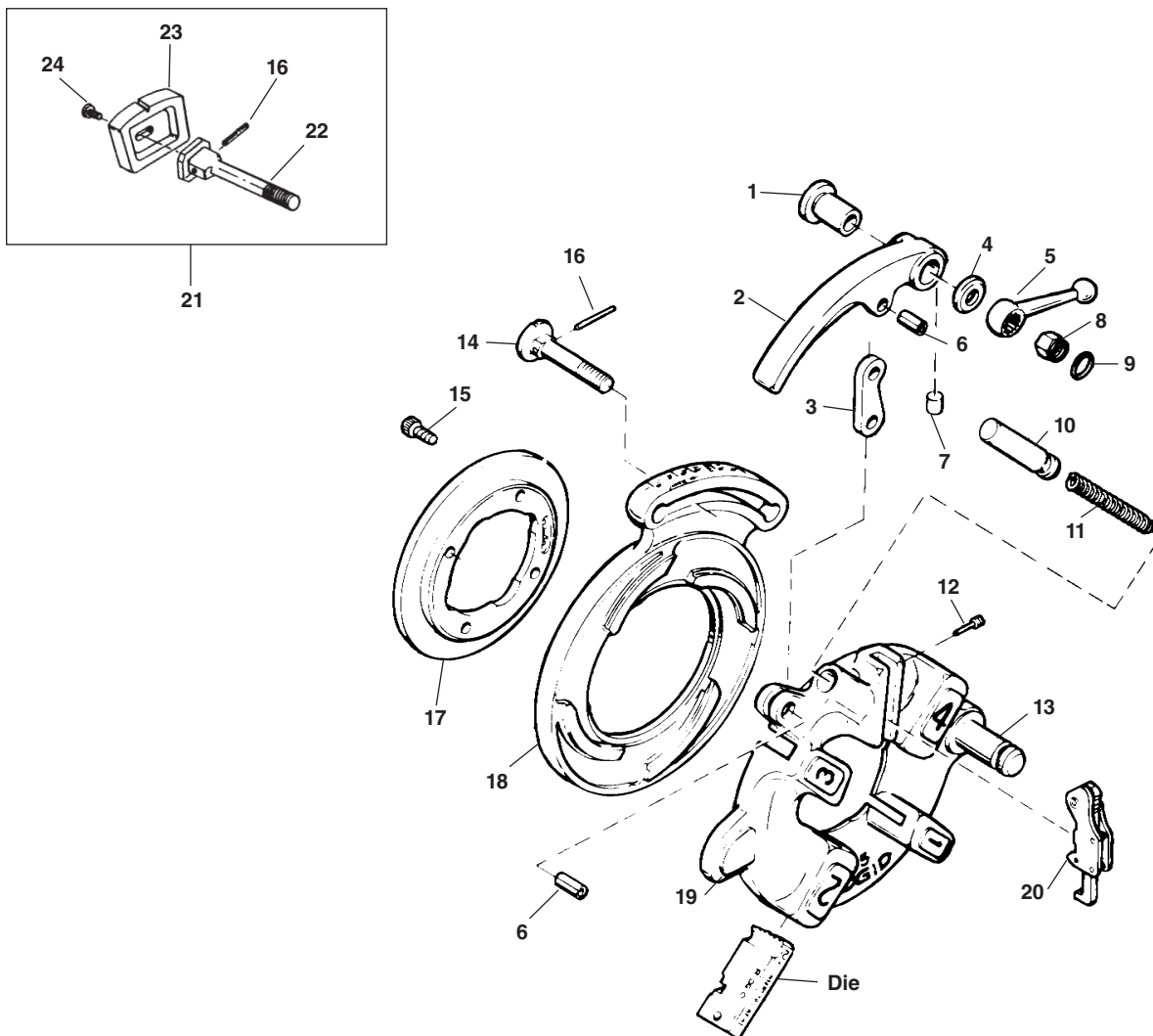
**NOTE: Order parts by Catalog Number only. DO NOT order by Reference Number.**

Ref. No.	1	2†	3	4	5	6	7	8	9	10
Die Head & Catalog No.	Screw	Retaining Ring	Cam Plate	Throw-Out Lever	Lock Screw	Link	Head/w Post	Lever Washer	Clamp Lever	Post
811A (97065) 1/8"-2" RH NPT	32205	97020	43360	46520	39860R	39950	40922	26957	39970	59832
842 (23282) 1/8"-2" LH NPT	32205	23292	43360	46520	39860R	39950	23287	26957	39970	59832
555 (10491) 1/8"-3/4"	32205	24256	43365	46555	39860R	39950	24006	26957	39970	59832
531B (97045) 1/4"-1" RH/LH	32205	46620	43405	46555	39955	39950	97055	26957	39970	59832
532B (97050) 1 1/8"-2" RH/LH	32205	46625	43410	46555	39955	39950	97060	26957	39970	59832
811A (97070) 1/8"-2" BSPT	32205	97020	43360	46520	39860R	39950	40957	26957	39970	59832
842 (23297) 1/8"-2" LH (BSPT)	32205	23292	43360	46520	39860R	39950	23287	26957	39970	59832
500A Mono (1/8"-3/8") RH 1/8" (41032) 1/4" (41037) 3/8" (41042)	32205	1/8"-41862 1/4"-41867 3/8"-41872	43305	46555	47140	39950	41907	26957	46820*	59832
500A Mono (1/2"-3/4") RH 1/2" (41047) 3/4" (41062)	32205	1/2"-41877 3/4"-41882	43300	46555	47140	39950	41912	26957	46820*	59832
500A Mono (1"-1 1/4") RH 1" (41057) 1 1/4" (41062)	32205	1"-41887 1 1/4"-41892	43295	46555	47140	39950	41917	26957	46820*	59832
500A Mono (1 1/2"-2") RH 1 1/2" (41067) 2" (41072)	32205	1 1/2"-41897 2"-41902	43290	46555	47140	39950	41922	26957	46820*	59832

\*Hex Nut For Mono Die Heads



### 815A Self-Opening Through-Head Oiling Die Head

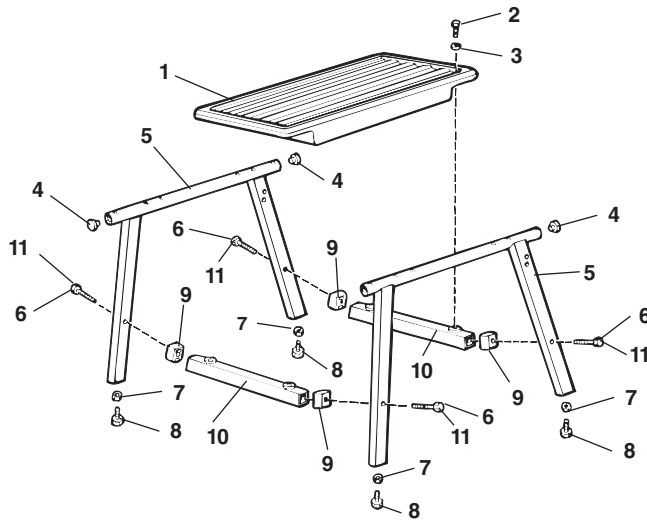


**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
—	97075	815A Self-Opening (Through-Head-Oiling) Die Head (NPT)	13	59832	Post
	97080	815A Self-Opening (Through-Head-Oiling) Die Head (BSPT)	14	44235	Lock Screw
1	44240	Bushing	15	32205	Screw (4)
2	43830	Throw-Out Lever	16	45050	Pin
3	44265	Throw-Out Link	17	97020	Retaining Ring
4	44245	Washer	18	40942	Cam Plate (815A NPT)
5	44260	Clamp Lever		97040	Cam Plate (815A BSPT)
6	44270	Roll Pin (2)	19	40932	Head w/Post
7	45055	Insert	20	44285	Trigger Assembly
8	44250	Nut		32982	Adj. Trigger Assy. (Europe)
9	44255	Retaining Ring		45327	Trigger Assy. (Europe)
10	44275	Throw-Out Plunger	21	45332	Gauge Plate Assy.
11	11565	Spring	22	46722	Adj. Lock Screw
12	44290	Trigger Screw	23	46717	Gauge Plate
			24	47147	Buttonhead Screw

NOTE: Early Style 815/845 parts interchangeable with 815A NPT  
Early Style 855 parts interchangeable with 815A BSPT

No. 100A Leg and Tray Stand

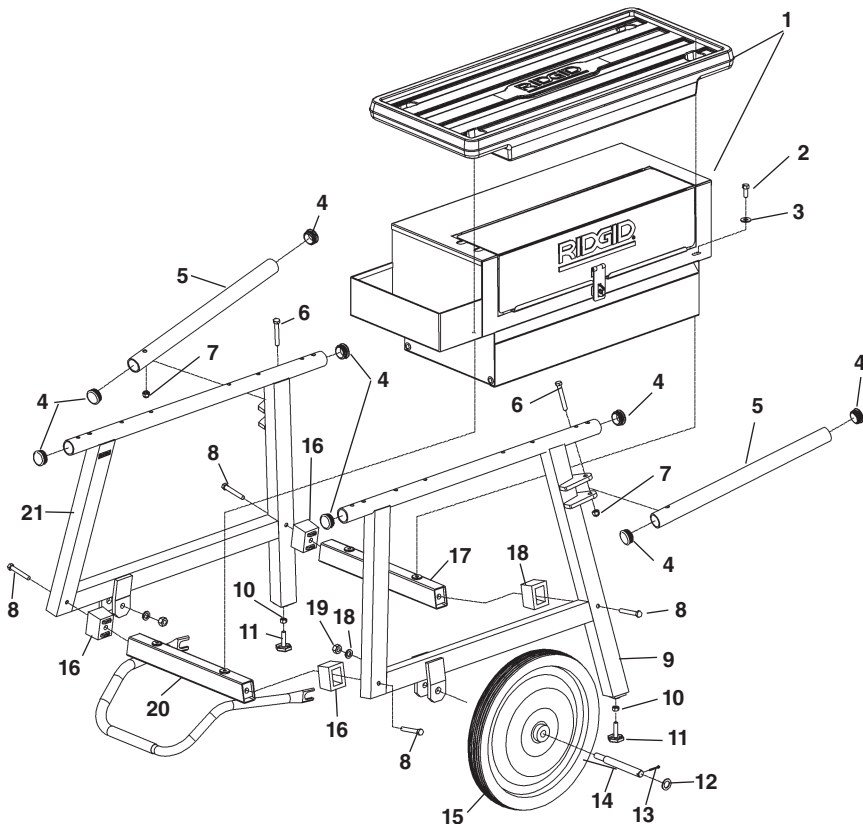


**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description
—	92457	Leg Stand Assembly
1	56872	Tray
2	80030	Hex Bolt $\frac{3}{8}$ " - 16 x 1" (4)
3	44230	Flat Washer $\frac{3}{8}$ " (4)
4	58037	End Cap (4)
5	58022	Leg (2)
6	58052	Hex Bolt $\frac{3}{8}$ " - 16 x 2 $\frac{1}{2}$ " (4)
7	44225	Hex Nut $\frac{3}{8}$ " - 16 (4)
8	58027	Leveling Pad (4)
9	58042	Spacer (4) - (1224 Machine Only)
10	58032	Cross Member (2)
11	58047	Hex Bolt $\frac{3}{8}$ " - 16 x 4" (4) (1224 & 535 Auto Machine Only)

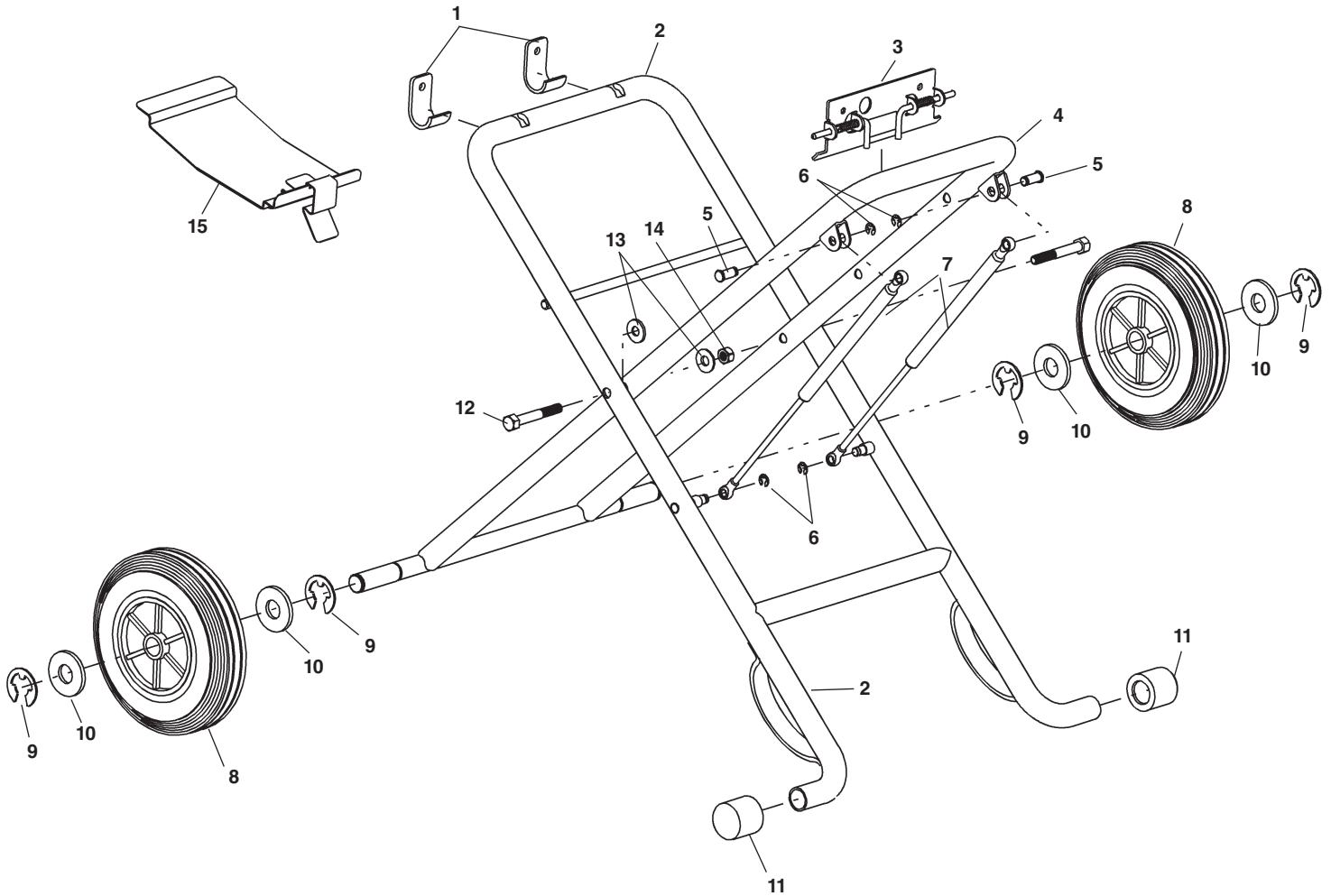
**NOTE:  $\frac{3}{8}$ " - 16 x 4" Bolts and spacers used when mounting 1224 & 535 Auto machines.**

No. 150A/200A Wheel and Tray Stands



Ref. No.	Catalog No.	Description
—	92462	150A Wheel and Tray Assembly
—	92467	200A Wheel and Cabinet Assembly
1	56872	Tray
	22563	Cabinet
2	80030	Hex Bolt $\frac{3}{8}$ " - 16 x 1" (4)
3	44230	Flat Washer (4)
4	58037	End Cap (6)
5	58067	Handle (2) includes Ref. No. 6
	34843	Handle - Type 2 (2)
6	46675	Hex Bolt $\frac{3}{8}$ " - 16 x 2 $\frac{3}{4}$ " (2)
7	79985	Locknut $\frac{3}{8}$ " - 16 (2)
8	58052	Hex Bolt $\frac{3}{8}$ " - 16 x 2 $\frac{1}{2}$ " (4)
	58047	Hex Bolt $\frac{3}{8}$ " - 16 x 4" (4) (1224 & 535 Automatic Machine Only)
9	26788	Front Leg
10	44225	Hex Nut $\frac{3}{8}$ " - 16 (4)
11	58027	Leveling Pad
12	95860	Washer (2)
13	47030	Cotter Pin (2)
14	58072	Axle (2)
15	27442	Wheel (2)
16	58042	Spacer (4) (1224 & 535 Automatic Machines Only)
17	58032	Front Cross Member
18	84150	Lock Washer $\frac{1}{2}$ " (2)
19	44745	Locknut $\frac{1}{2}$ " (2)
20	26798	Rear Cross Member w/Stand Stop Assembly
21	26793	Rear Leg

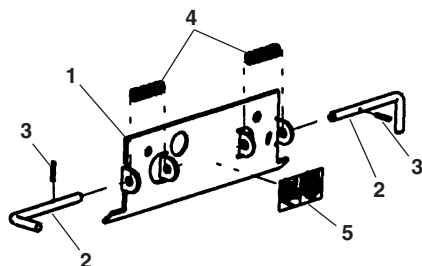
**NOTE:  $\frac{3}{8}$ " - 16 x 4" bolts and spacers used when mounting 1224 & 535 Auto machines.**



**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
—	58077	250 Folding Stand	7	48126	Gas Strut (2)
—	67657	250 Folding Stand (North America)	8	43846	Wheel (2)
1	43796	Rear Bracket (2)	9	43856	Retaining Ring (4)
2	43866	Outer Leg Assembly	10	43936	Washer (4)
3	70812	Outer Leg Assembly (North America)	11	23607	End Cap (2)
4	70817	Front Bracket Assembly	12	43836	Bolt (2)
5	43906	Inner Leg Assembly	13	43886	Washer (4)
6	43946	Pin (2)	14	43896	Locking Nut M12 (2)
	48146	Retaining Ring (4)	15	67787	Pressure Plate Assembly (North America)

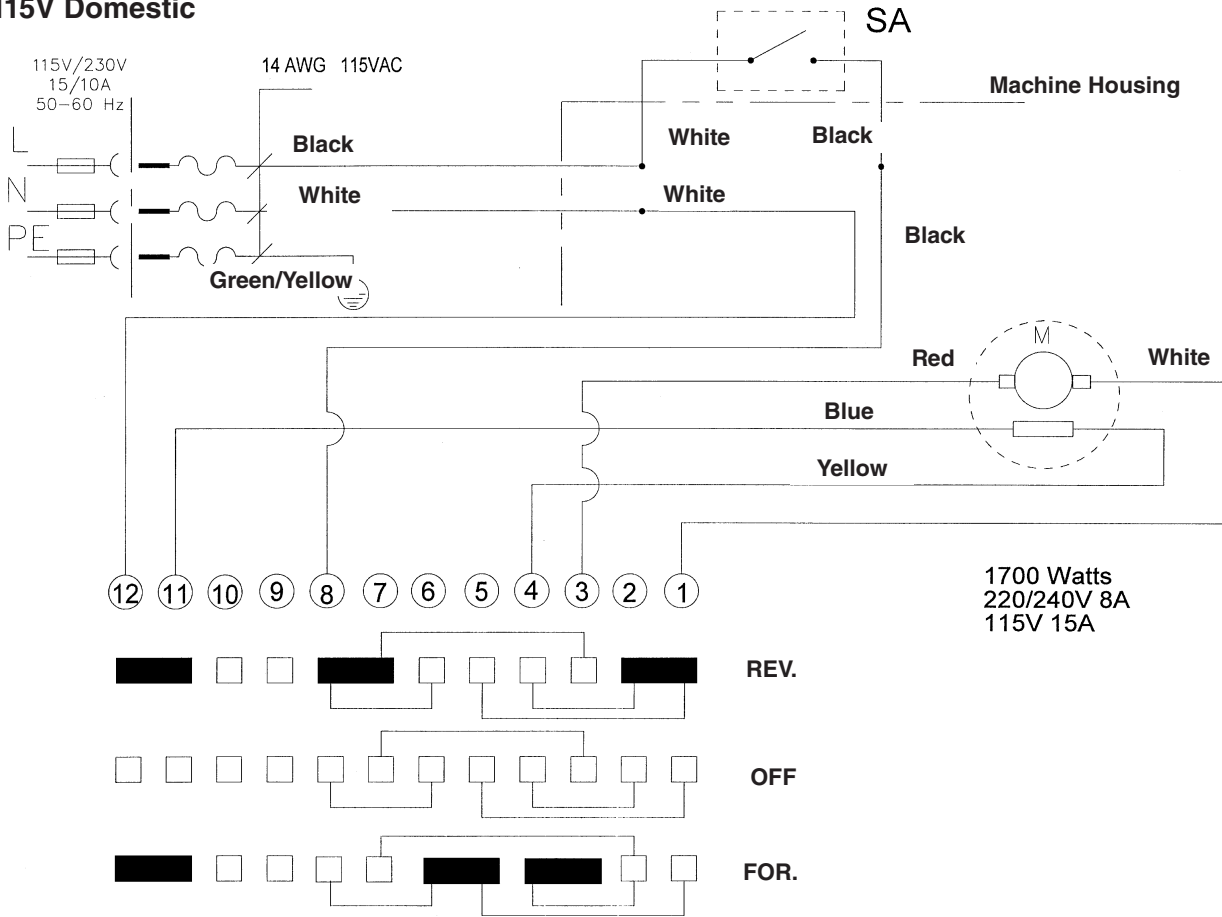
### Front Bracket Assembly



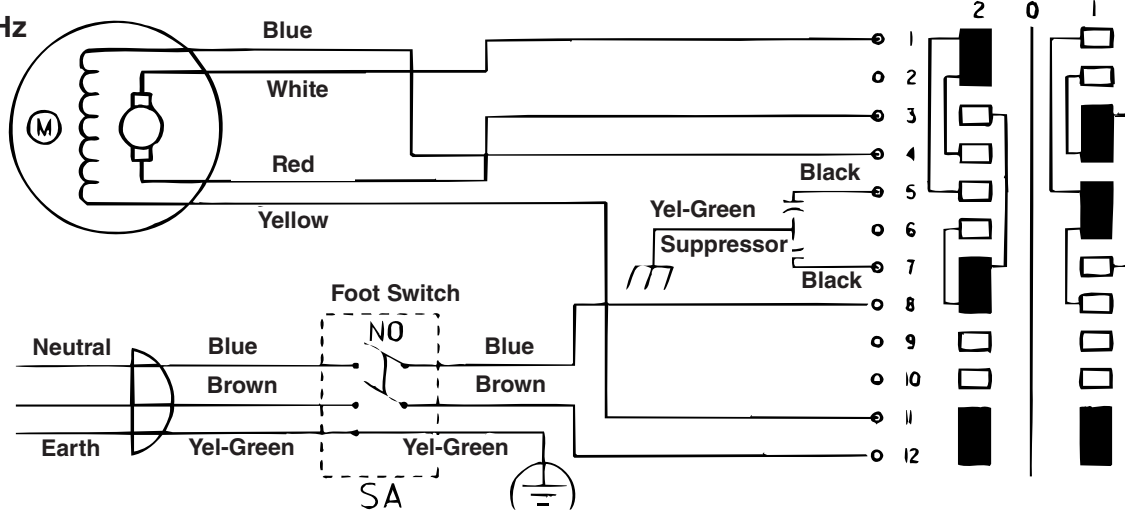
Ref. No.	Catalog No.	Description
—	70817	Front Bracket Assembly
1	43806	Front Bracket
2	43816	Latch Handle (2)
3	43826	Roll Pin (2)
4	43926	Spring (2)
5	43916	Warning Decal

## Wiring Diagrams

### 115V Domestic



### 115V/230V 25-60 Hz



### 115/230V Far East

