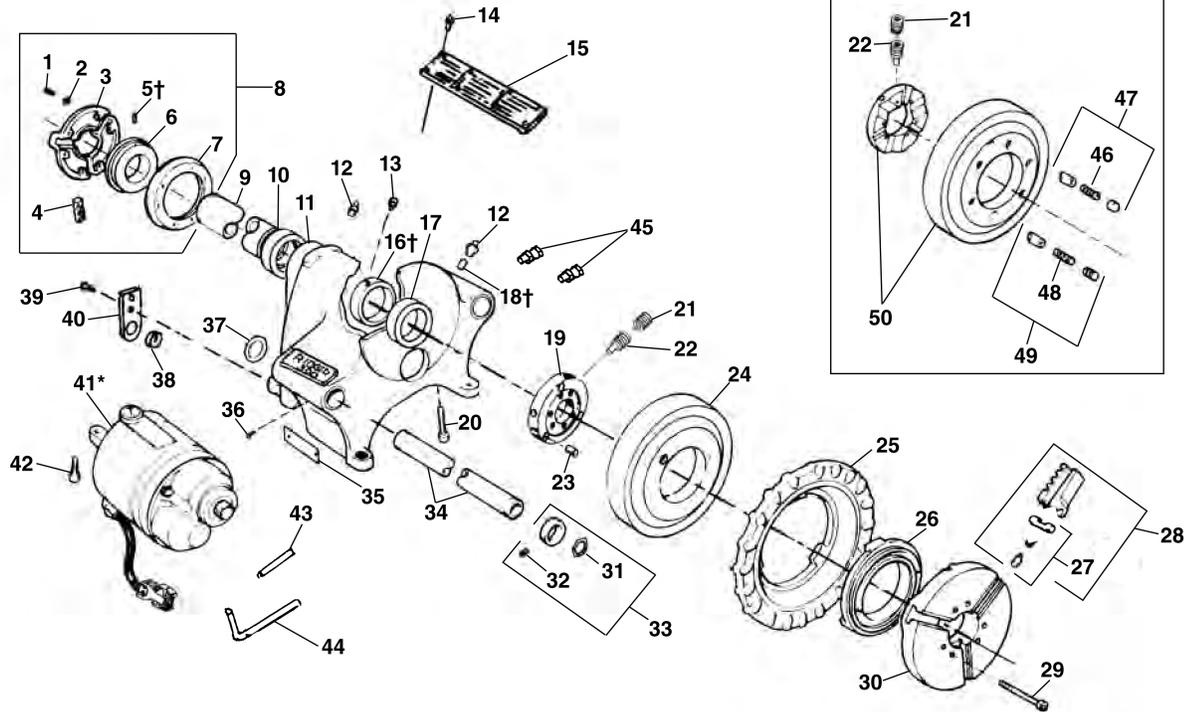


**Main Components**



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

**For Information on Cutters, Die Heads and Reamers SEE INDEX**

| Ref. No. | Catalog No. | Description   | Ref. No. | Catalog No. | Description                               |
|----------|-------------|---|----------|-------------|---|
| 1        | 46790       | Screw, 12 - 24 x 3/4" (6)   | 27       | 44715       | Jaw Insert Set                            |
| 2        | 40270       | Lock Washer (6)   |          | 97365       | Jaw Insert Set F/Coated Pipe              |
| 3        | 43735       | Centering Head  | 28       | 44090       | Chuck Jaw Set                             |
|          | 19346       | Centering Head (Europe)   | 29       | 45295       | Screw 5/16" - 18 x 2 3/4" (6)             |
| 4        | 46500       | Rear Jaw (3)  | 30       | 43525       | Cap                                       |
| 5†       | 45260       | Step Pin (3)  | 31       | 44720       | Snap Ring (2)                             |
| 6        | 44095       | Scroll  | 32       | 46050       | Set Screw 1/4" - 18 x 1/4" (2)            |
| 7        | 43740       | Back Plate  | 33       | 44725       | Ring Assembly (2)                         |
|          | 19356       | Back Plate (Europe)   | 34       | 44425       | Support Bar (Incl. Ref. No. 37)           |
| 8        | 44165       | Rear Centering Assembly   | 35       | 90392       | FOR/OFF/REV Label                         |
| 9        | 44100       | Drive Shaft   | 36       | 45280       | Screw #8 - 32 x 5/8" (2)                  |
| 10       | 45335       | Rear Bearing-Bronze   | 37       | 44525       | Spring Ring (2)                           |
| 11       | 42845       | 300 Body Assembly (Incl. Ref. No. 10, 11, 12, 13, 14, 15, 17, 18, 38, 39, 40)                   | 38       | 46735       | Cord Grommet                              |
|          | 19056       | 300A Body Assy.- Europe (Incl. Ref. No. 10, 11, 12, 13, 14, 15, 17, 18, 38, 39, 40, 43, 44, 45) | 39       | 44735       | Screw 1/4" - 20 x 5/8" (2)                |
|          | 96805       | 300A Body Assy. (Incl. Ref. No. 10, 11, 12, 13, 14, 15, 17, 18, 38, 39, 40, 43, 44, 45)         | 40       | 45825       | Strain Relief Plate                       |
| 12       | 46860       | Grease Fitting  | 41*      | 87740       | 3177 Motor 115V (300)                     |
| 13       | 33785       | Set Screw 5/16" - 24 x 1/4" (2)   |          | 87780       | 3277 Motor 230V (300)                     |
| 14       | 85920       | Pop Rivet (10)  |          | 96810       | 3181 Motor 115V (300A)                    |
| 15       | 88690       | Warning Plate   |          | 96975       | 3281 Motor 230V (300A)                    |
| 16†      | 45345       | Thrust Ring   |          | 61202       | 3177-CE Motor 115V (300CE)                |
| 17       | 45270       | Front Bearing   |          | 61207       | 3277-CE Motor 230V (300CE)                |
| 18†      | 45310       | Split Roll Pin  |          | 61192       | 3181-CE Motor 230V (300A CE)              |
| 19       | 30027       | Drive Ring, Type II   |          | 61197       | 3281-CE Motor 115V (300A CE)              |
| 20       | 46035       | Screw 5/16" - 18 x 1 3/4"   | 42       | 46745       | Screw 3/8" - 16 x 1 1/4" (2)              |
| 21       | 45300       | Set Screw 5/16" - 24 x 1/4" (2)   | 43       | 96850       | Tubing (300A)                             |
| 22       | 45265       | Set Screw 5/16" - 24 x 1/2" (3)   | 44       | 96855       | Tubing (300A)                             |
| 23       | 30022       | Drive Pin, Type II (3)  | 45       | 96860       | Bulkhead Union (2) (300A)                 |
| 24       | 30017       | Ring Gear, Type II  | 46       | 44310       | Drive Spring (3)                          |
| 25       | 89150       | Hand Wheel  | 47       | 91552       | Drive Wedge Kit                           |
| 26       | 43540       | Scroll  | 48       | 45285       | Pressure Spring (3)                       |
|          |             |   | 49       | 91557       | Plunger Kit                               |
|          |             |   | 50       | 91562       | Conversion Kit (Includes Ref. Nos. 19-24) |

\* Refer to Motor Model No. for Component Parts

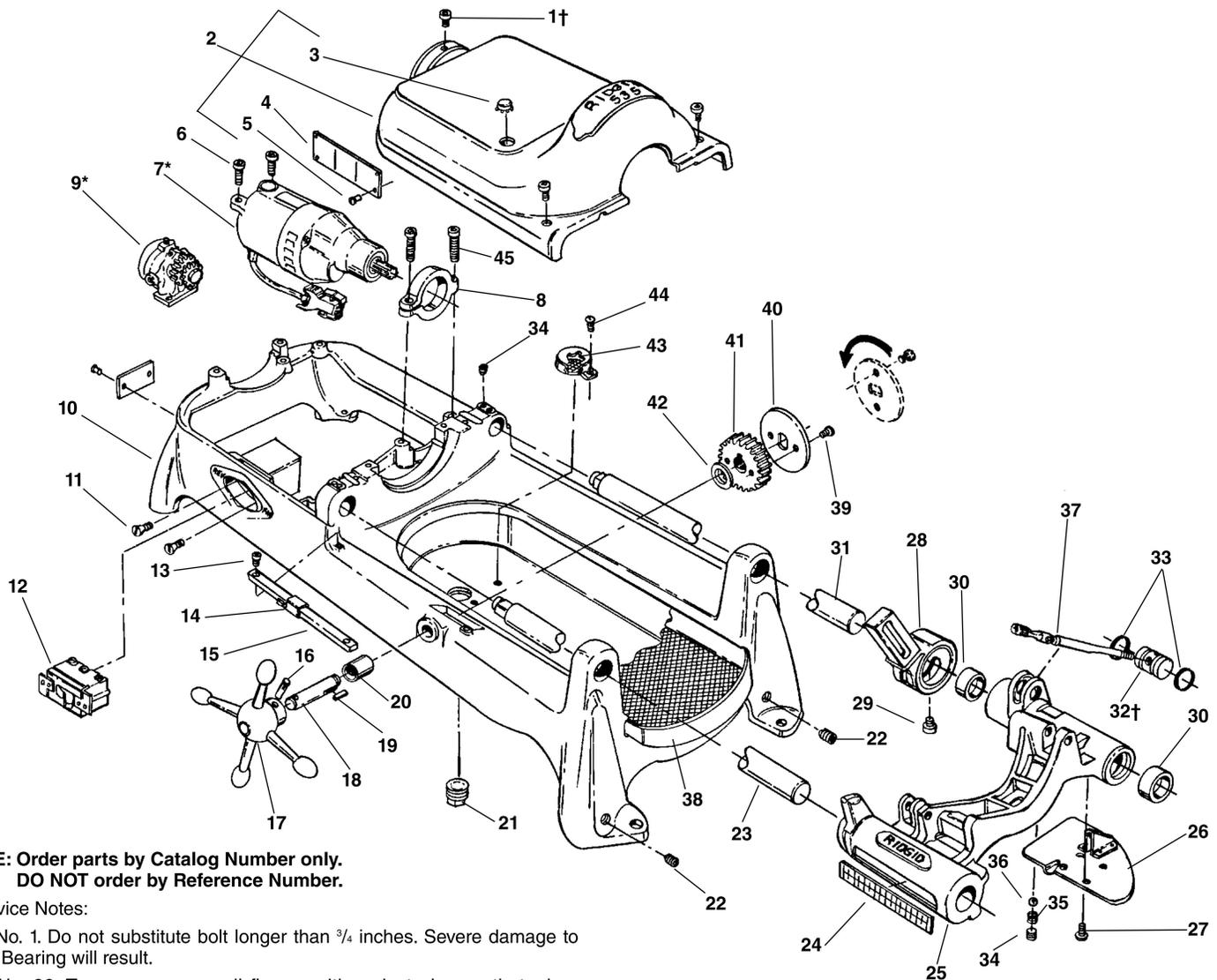
**Service Notes:**

†Ref. 5 Stop Pins are easily removed by pushing from inside to outside.

†Ref. 18 Before removing front bearing sleeve (Ref. No. 17), dowel pin and grease fitting must be pushed out from inside.

†Ref. 16 Position thrust ring so that offset screw holes are closer to chuck.

## Main Components – Early Style



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

†Service Notes:

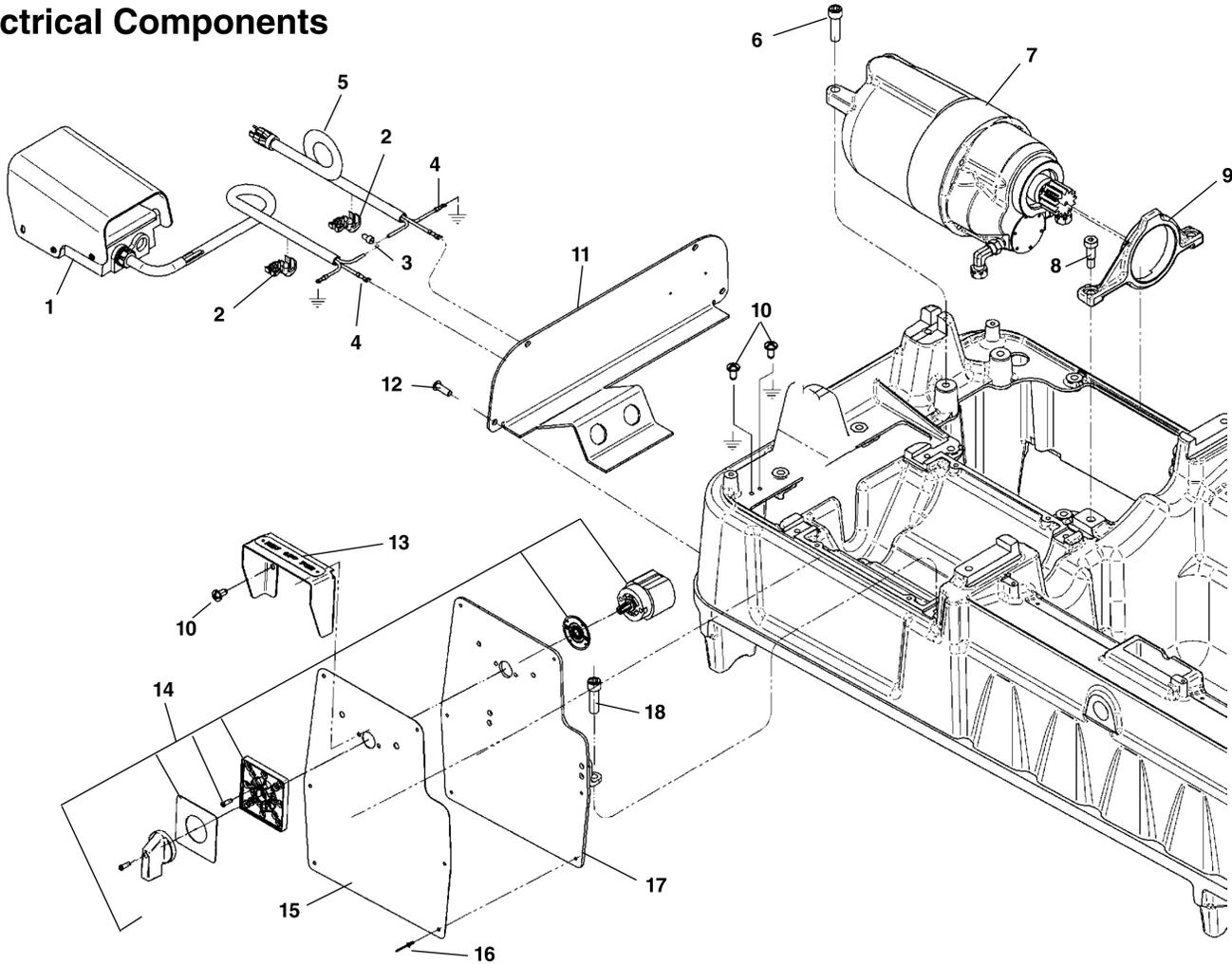
Ref. No. 1. Do not substitute bolt longer than  $\frac{3}{4}$  inches. Severe damage to Rear Bearing will result.

Ref. No. 32. To assure proper oil flow, position pivot plug so that when spout is in up position, oil flow hole is visible in carriage slot below spout.

| Ref. No. | Catalog No. | Description  | Ref. No. | Catalog No. | Description  |
|----------|-------------|--|----------|-------------|--|
| 1†       | 46760       | Screw $\frac{3}{8}$ " - 16 x $\frac{3}{4}$ " (3)     | 24       | 46370       | Scale  |
| 2        | 43190       | Cover (Incls. Ref. No. 3, 4, 5)                      | 25       | 62057       | Carriage Assy. (Includes Ref. Nos. 24, 26, 27, 28, 29, 30, 34, 35, 36) |
| 3        | 89310       | Plug Button  | 26       | 45195       | Drip Plate   |
| 4        | 88690       | Warning Plate  | 27       | 46270       | Screw $\frac{1}{4}$ " - 20 x $\frac{1}{2}$ " Pan Head (4)              |
| 5        | 85920       | Pop Rivet (8)  | 28       | 43690       | Cutter Arm   |
| 6        | 46745       | Screw $\frac{3}{8}$ " - 16 x $1\frac{1}{4}$ " (2)    | 29       | 44930       | Screw, $\frac{7}{16}$ " x $\frac{9}{32}$ "                             |
| 7*       | 88125       | Motor Model 1177, 115V                               | 30       | 46720       | Oil Seal (2)   |
|          | 88165       | Motor Model 2377, 230V                               | 31       | 45220       | Support Bar - Rear   |
| 8        | 43795       | Motor Bracket  | 32†      | 44340       | Pivot Plug   |
| 9*       | 47195       | Model A Oil Pump                                     | 33       | 44470       | O-Ring (2)   |
| 10       | 43030       | Base (Incls. Ref. No. 20, 21, 22, 44)                | 34       | 46800       | Set Screw $\frac{3}{8}$ " - 16 x $\frac{3}{8}$ " (3)                   |
| 11       | 45280       | Screw #8-32 x $\frac{5}{8}$ " Flat Head (2)          | 35       | 46680       | Spring   |
| 12       | 44505       | Switch   | 36       | 46925       | Ball   |
| 13       | 45615       | Screw #10-32 x $\frac{1}{2}$ " Flat Head (2)         | 37       | 44495       | Oil Spout Assembly   |
| 14       | 47110       | Indicator Slide                                      | 38       | 43355       | Chip Tray  |
| 15       | 47105       | Indicator Bar  | 39       | 46785       | Screw #10-32 x $\frac{3}{8}$ "   |
| 16       | 47165       | Pin  | 40       | 47120       | Lock Plate   |
| 17       | 46510       | Handwheel  | 41       | 45430       | Pinion   |
| 18       | 47115       | Pinion Shaft   | 42       | 47145       | Spacer   |
| 19       | 46930       | Key $\frac{3}{16}$ " Square                          | 43       | 46655       | Filter   |
| 20       | 46540       | Bushing  | 44       | 45420       | Screw #10-24 x $\frac{3}{8}$ "   |
| 21       | 44485       | Drain Plug   | 45       | 44220       | Screw $\frac{3}{8}$ " - 16 x $1\frac{1}{2}$ "                          |
| 22       | 42037       | Set Screw $\frac{1}{2}$ " - 13 x $\frac{1}{2}$ " (4) |          |             |  |
| 23       | 45440       | Support Bar - Front                                  |          |             |  |

\*Refer to Motor Model No./Refer to Model "A" Oil Pump for Component Parts

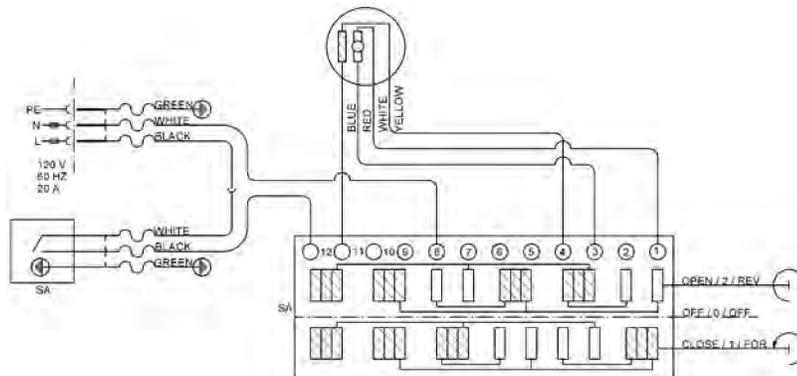
Electrical Components



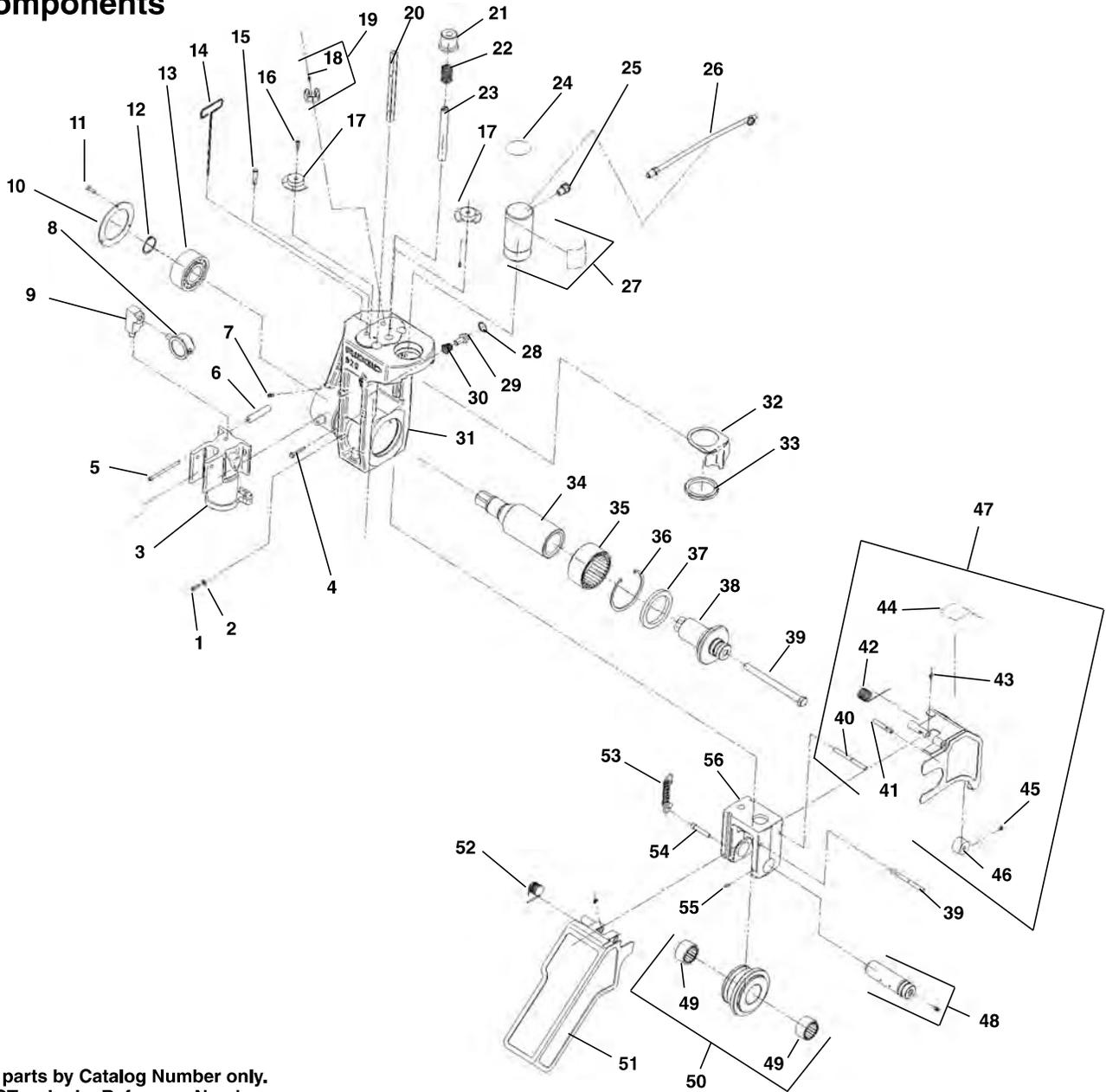
NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.

| Ref. No. | Catalog No. | Description        | Ref. No. | Catalog No. | Description   |
|----------|-------------|--------------------|----------|-------------|---|
| 1        | 36642       | Foot Switch, B-294 | 11       | 51973       | Back Cover  |
| 2        | 75952       | Strain Relief (2)  | 12       | 94337       | Screw, Button Head<br>1/4" x 20 x 3/8" B.H.C.S. (4) |
| 3        | 44635       | End Splice         | 13       | 96452       | Switch Cover  |
| 4        | 46875       | Spade Terminal (2) | 14       | 20123       | Switch Assembly                                     |
| 5        | 46740       | Power Cord 115V    | 15       | 96472       | Warning Label                                       |
| 6        | 46745       | Screw (2)          | 16       | 94427       | Pop Rivet (6)                                       |
| 7        | 96442       | Motor              | 17       | 96457       | Control Panel                                       |
| 8        | 36262       | Shoulder Bolt (2)  | 18       | 40910       | Screw   |
| 9        | 96402       | Motor Bracket      |          |             |   |
| 10       | 45420       | Screw (4)          |          |             |   |

Wiring Diagram



Main Components



**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                  |
|----------|-------------|--------------------------------|----------|-------------|-------------------------------|----------|-------------|------------------------------|
| 1        | 40910       | 1/4" - 20 x 3/4" Cap Screw (3) | 21       | 49117       | Depth Adj. Nut                | 40       | 11158       | Pivot Shaft (2)              |
| 2        | 27402       | 1/4" Flat Washer (4)           | 22       | 49122       | Compression Spring            | 41       | 11223       | Shaft Roller                 |
| 3        | 11173       | Hand Pump                      | 23       | 11123       | Depth Adj. Rod                | 42       | 11153       | Torsion Spring RH            |
| 4        | 64877       | 1/4" - 20 x 1 3/4" Screw (4)   | 24       | 49262       | Depth Setting Decal           | 43       | 61042       | Ret. Ring (3)                |
| 5        | 11203       | 1/4" - 20 x 5 1/2" Screw       | 25       | 11213       | 3/8" Swivel Connector         | 44       | 13198       | Warning Decal Guard          |
| 6        | 11198       | Pump Standoff                  | 26       | 11208       | Hydraulic Hose                | 45       | 61042       | Ret. Ring (3)                |
| 7        | 46860       | Grease Fitting (4)             | 27       | 11818       | Cylinder (Inc. Decals)        | 46       | 11218       | Guard Roller                 |
| 8        | 11058       | Pressure Gauge                 | 28       | 49177       | Retaining Ring                | 47       | 11143       | Right Guard                  |
| 9        | 11093       | Hydraulic Tee                  | 29       | 11118       | Stop Pin                      | 48       | 11078       | Roller Shaft                 |
| 10       | 11128       | Bearing Retaining Plate        | 30       | 11168       | Stop Pin Spring               | 49       | 11108       | Needle Bearing (6)           |
| 11       | 60265       | 1/4" - 20 x 1/2" Screw (3)     | 31       | 11003       | 920 Main Housing              | 50       | 11018       | 2" - 6" Upper Groove Roll    |
| 12       | 11088       | Retaining Ring                 | 32       | 11248       | Actuator                      | 11028    |             | 8" - 12" Upper Groove Roll   |
| 13       | 11163       | Angular Contact Bearing        | 33       | 49152       | Lock Ring                     | 11038    |             | 14" - 16" Upper Groove Roll  |
| 14       | 49087       | 1/8" Tee Handle Hex Wrench     | 34       | 11073       | Drive Shaft                   | 51       | 11138       | Left Guard                   |
| 15       | 11233       | Clevis Pin                     | 35       | 11063       | Roller Bearing (2)            | 52       | 11148       | Torsion Spring LH            |
| 16       | 87947       | Shoulder Screw                 | 36       | 11083       | Internal Ret. Ring            | 53       | 11238       | Return Spring                |
| 17       | 11048       | Depth Adj. Gauge LT            | 37       | 11133       | Grease Seal                   | 54       | 46745       | 3/8" - 16 x 1 1/4" Screw (2) |
| 18       | 54307       | Drive Screw                    | 38       | 11013       | 2" - 6" Drive Roll            | 55       | 34892       | Set Screw 1/4" - 20          |
| 19       | 11263       | Spring Clip (Inc. Ref. 18)     | 11023    |             | 8" - 12" Drive Roll           | 56       | 11008       | Upper Roll Housing           |
| 20       | 11068       | Key Slide (2)                  | 11033    |             | 14" - 16" Drive Roll          |          |             |                              |
|          |             |                                | 39       | 11113       | 5/8" - 11 x 7 3/4" HX HD Bolt |          |             |                              |