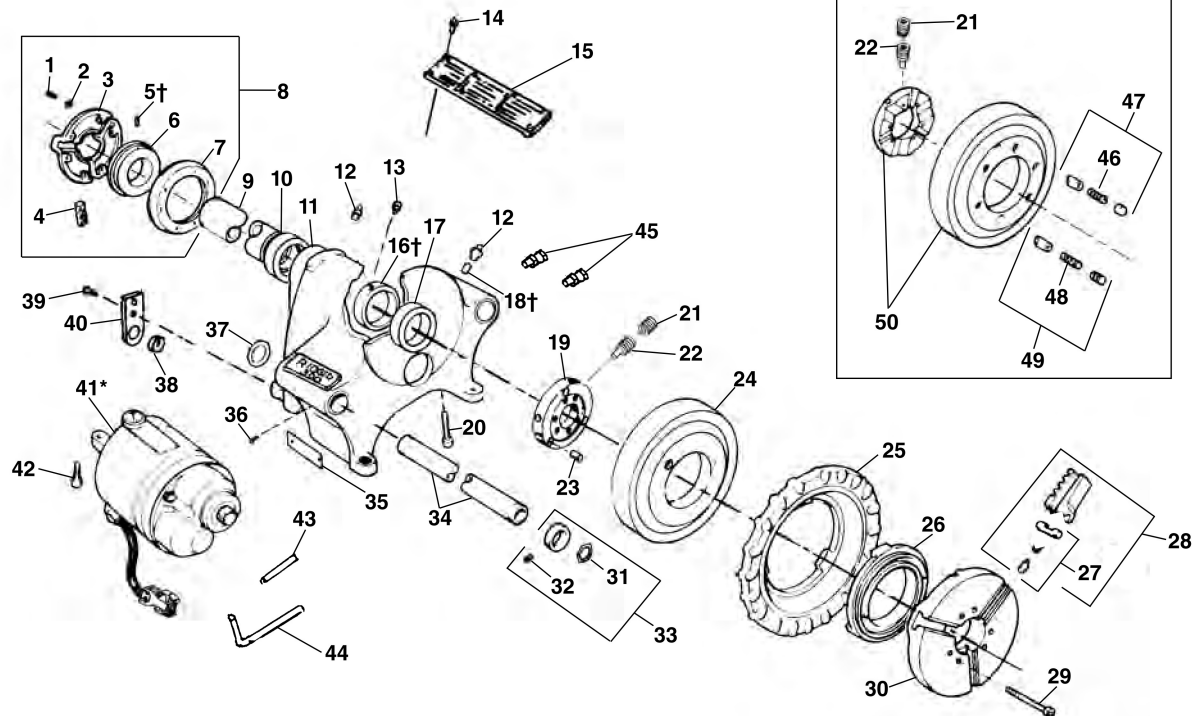


Main Components



**NOTE: Order parts by Catalog Number only.
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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

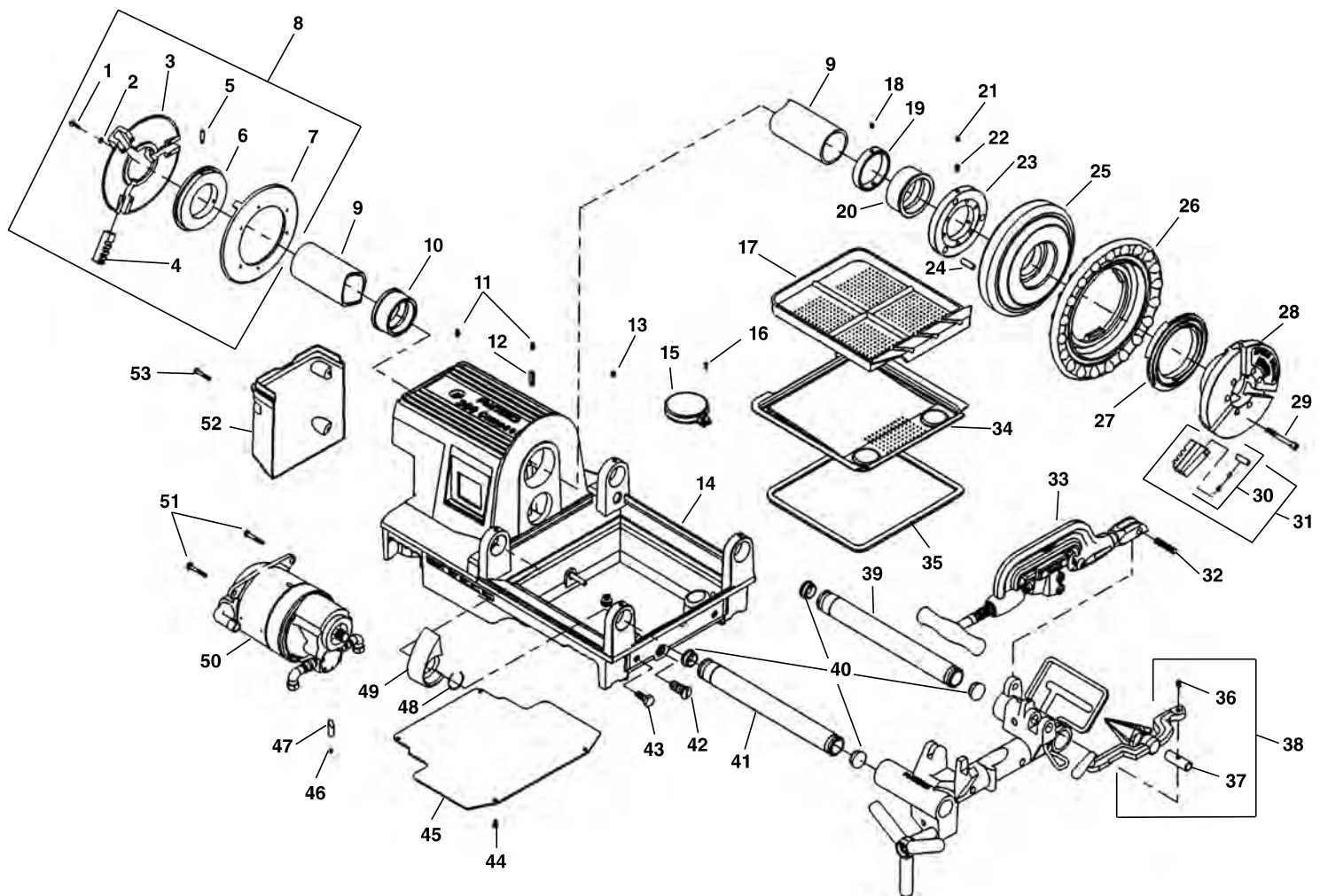
Service Notes:

†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.

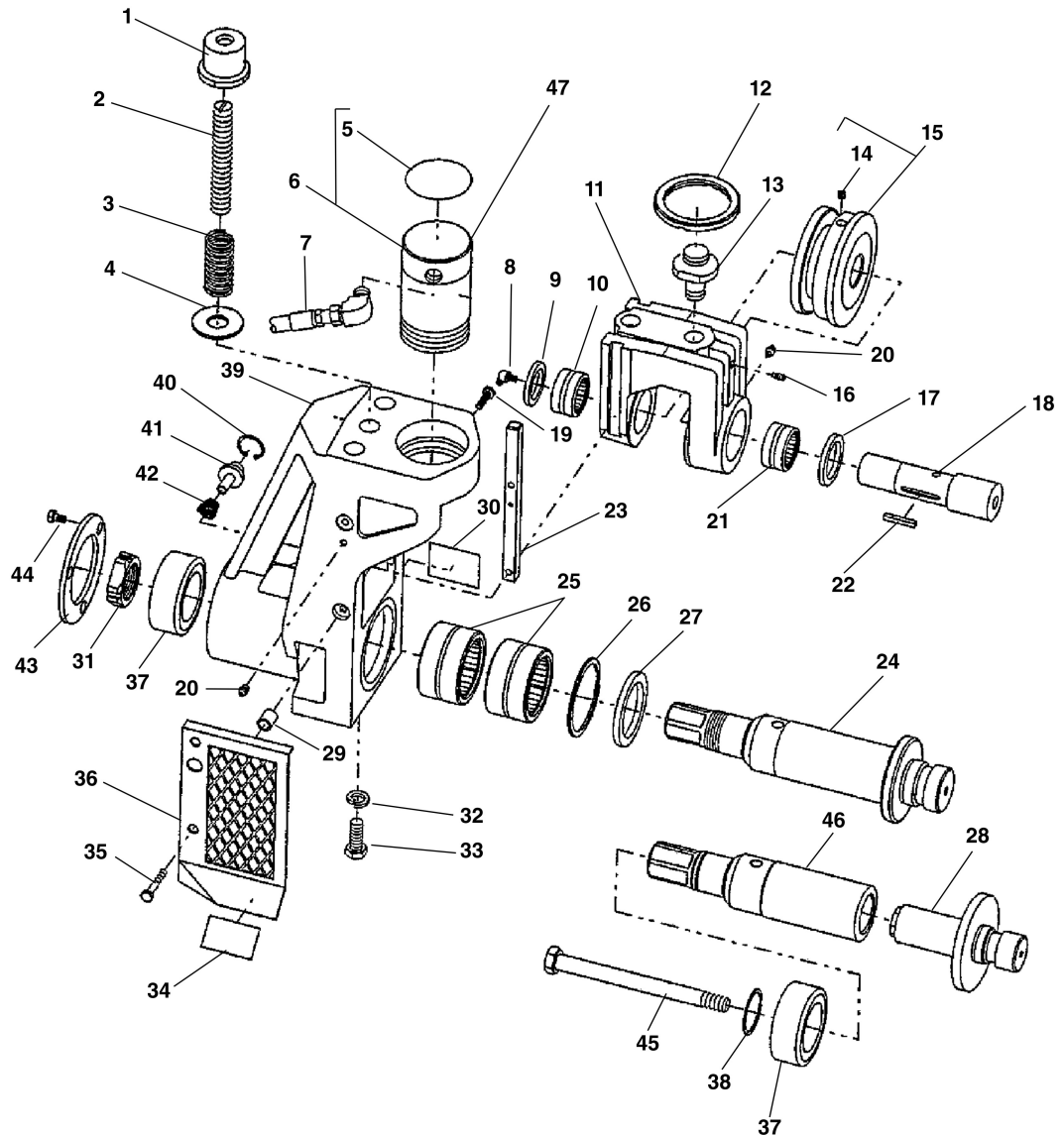
†Ref. 16 Position thrust ring so that offset screw holes are closer to chuck.

Main Drive Components



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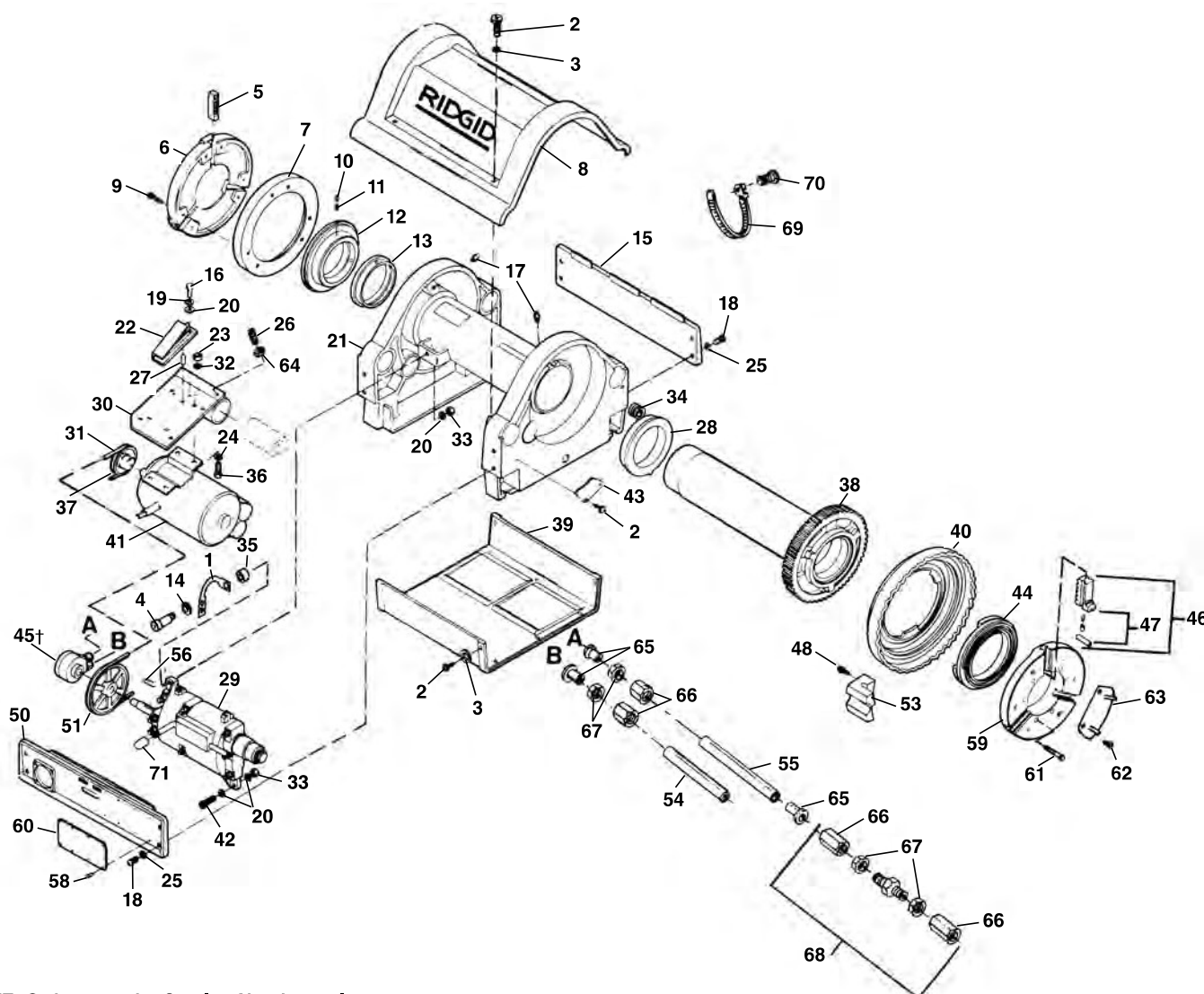
Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	46790	Screw 12 - 24 x 3/4" (6)	28	43525	Chuck Cap
2	40270	Lock Washer (6)	29	45295	Screw 5/16" x 2 3/4" (6)
3	43735	Rear Centering Head	30	44715	Jaw Insert Set (3)
	19346	Rear Centering Head (Europe)		97365	Jaw Insert Set f/Coated Pipe (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	45335	Rear Bearing	38	34612	344 Reamer
11	46860	Grease Fitting (2)	39	54112	Rear Rail
12	45310	Pin Split Roll	40	35162	Rail Plug (4)
13	60025	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	45300	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			



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Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	49117	Depth Adjustment Nut	18	49102	Upper Roll Shaft (Incls. Ref. 8, 22)	34	49257	Label, Warning
2	49112	Depth Rod	19	49252	Hex Screw, 1/4" - 20 x 1" (2)	35	49212	Hex Screw, 1/4" - 20 x 1 3/4" (2)
3	49122	Spring	20	46860	Grease Fitting (4)	36	49197	Guard (Incls. Ref. 29)
4	60995	Flat Washer, 3/4"	21	87610	Roller Bearing	37	49127	Bearing
5	49262	Label, Depth Adjustment	22	27002	Key, 3/16" Sq. x 1 5/16"	38	49192	Spiral Retaining Ring
6	49147	Hydraulic Cylinder	23	49107	Set of 2 Slide Keys	39	49057	Lower Roll Housing (Incls. Ref. 20)
7	49142	Hydraulic Hose Assembly - 115V/230V	24	51427	Drive Shaft, 2" - 6" Sch 10 & 40	40	49177	Retaining Ring
8	46915	Grease Fitting - 65 Deg.	25	51432	Drive Shaft Assy. - same as above and includes Ref. 31, 37	41	49172	Lock Pin
9	87695	Seal	26	51817	Drive Shaft, 8" - 12" Sch. 10, 8" Sch 40	42	44915	Spring
10	87710	Roller Bearing	27	51812	Drive Shaft Assy. - same as above and includes Ref. 31, 37	43	49132	Retaining Plate
11	49062	Upper Roll Housing (Incls. Ref. 9, 10, 16, 17, 20, 21)	28	87600	Roller Bearing (2)	44	60265	Hex Screw, 1/4" - 20 x 1 1/2" (3)
12	49152	Lock Ring	29	49187	Spiral Retaining Ring	45	49667	Hex Bolt 5/8" - 11 x 7"
13	49082	Piston Rod Coupling	30	91000	Seal	46	49067	Drive Shaft - for 1", 1 1/4", 1 1/2" Rolls and Copper Roll 2" - 6"
14	45192	Cone Pt. Screw, 1/4" - 20 x 3/8"	31	49157	Drive Roll, 1"		49627	Drive Shaft Assy. - same as above and includes Ref. 37, 38, 45
15	49162	Groove Roll, 1"	32	49072	Drive Roll, 1 1/4" - 1 1/2"	47	35943	Cylinder Repair Kit
	49097	Groove Roll, 1 1/4" - 1 1/2"	33	51732	Drive Roll, Copper 2" - 6"	Following Items Not Shown:		
	49217	Groove Roll 2" - 6" SC 10/40		49202	Set of 2 Spacers	49087		T-Handle Hex Key, 1/8"
	51822	Groove Roll, 8" - 12" Sch. 10, 8" Sch 40		49207	Label, Warning	53987		Roll Storage Case
	50127	Groove Roll, Copper 2" - 6"		49607	Bearing Retaining Nut	54317		Box Wrench
16	45265	Set Screw, 1/4" - 20 x 1/2"		84150	Lock Washer, 1/2" (2)	67192		Spanner Wrench
17	87690	Seal		45500	Hex Screw, 1/2" x 1 1/4" (2)	67197		Hex Key 3/8"

Main Drive Components



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Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	33622	Pump Bracket	25	40930	Lock Washer $\frac{3}{16}$ " (8)	46	40087	Chuck Jaw Set
2	41597	Screw (12)	26	88265	Set Screw $\frac{3}{16}$ " - 16 x 1"	47	47517	Chuck Jaw Set Pl. Ctd. Pipe
3	41592	Washer (10)	27	88230	Roll Pin $\frac{1}{4}$ " x $\frac{9}{16}$ "	47	54212	Jaw Insert Set
4	33627	Screw	28	26767	Front Bearing		26247	Jaw Insert Set F/Coated Pipe
5	32412	Centering Jaw Set	29	26362	Gear Box Assy.	48	27067	Self-Tapping Screw (2 Req. f/G.S.)
6	26537	Centering Head	30	27062	Motor Bracket	50	59722	Front Side Plate
7	26542	Back Plate	31	26832	V-Belt	51	26852	Gear Box Pulley
8	26477	Top Cover	32	40770	Lock Washer $\frac{5}{16}$ " (4)	53	26507	Pinch Point Boss (2 Req. f/G.S.)
	46867	Die Head Decal (Not Shown)	33	27517	Lock Nut $\frac{5}{16}$ " - 18	54	27007	Inlet Hose
9	40910	Screw $\frac{1}{4}$ " - 20 x $\frac{3}{4}$ " (6)	34	47080	Grommet	55	26822	Output Hose
10	45300	Set Screw $\frac{5}{16}$ " - 24 x $\frac{1}{4}$ " (3)	35	33617	Spacer	56	27002	Key
11	45265	Set Screw $\frac{5}{16}$ " - 24 x $\frac{1}{2}$ " (3)	36	85910	Bolt $\frac{5}{16}$ " - 18 x $1\frac{1}{4}$ "	58	85920	Rivets (8)
12	32407	Scroll	37	26857	Motor Pulley (60 Hz)	59	26332	Chuck Cap
13	26352	Rear Bearing		27082	Motor Pulley (50 Hz)	60	88690	Safety Plate
14	26307	Washer	38	26347	Drive Gear/Spindle Assy.	61	26522	Screw $\frac{5}{16}$ " - 24 x $2\frac{1}{4}$ " (6)
15	26487	Rear Side Plate	39	26482	Bottom Cover	62	27242	Screw 10 - 32 (6)
16	32145	Screw $\frac{1}{4}$ " - 20 x $\frac{1}{2}$ "	40	26337	Handwheel	63	33612	Set of 3 Cover Plates
17	46860	Grease Fitting (2)	41	26237	Motor w/Capacitor 120V, 60 Hz	64	83545	Jam Nut $\frac{5}{8}$ " - 16
18	26997	Screw $\frac{3}{8}$ " - 16 x $\frac{3}{4}$ " (8)		27287	Motor w/Capacitor 110V, 50 Hz	65	35117	Tube Insert (3)
19	44740	Lock Washer $\frac{1}{4}$ "		26232	Motor w/Capacitor 240V, 60 Hz	66	40602	Compression Nut
20	96740	Washer $\frac{5}{16}$ "		27282	Motor w/Capacitor 220/240V, 50 Hz	67	40607	Ferrule
21	26357	Base	42	27037	Shoulder Bolt	68	26972	Union
22	26492	Belt Tensioner	43	27012	Pinion Guard	69	43552	Tie Down Strap
23	96730	Nut $\frac{5}{16}$ " - 18 (4)	44	26517	Scroll	70	45275	Screw 10 - 24 x $\frac{1}{2}$ "
24	27402	Washer $\frac{5}{16}$ " (4)	45†	27307	Oil Pump	71	27032	Shifter Knob