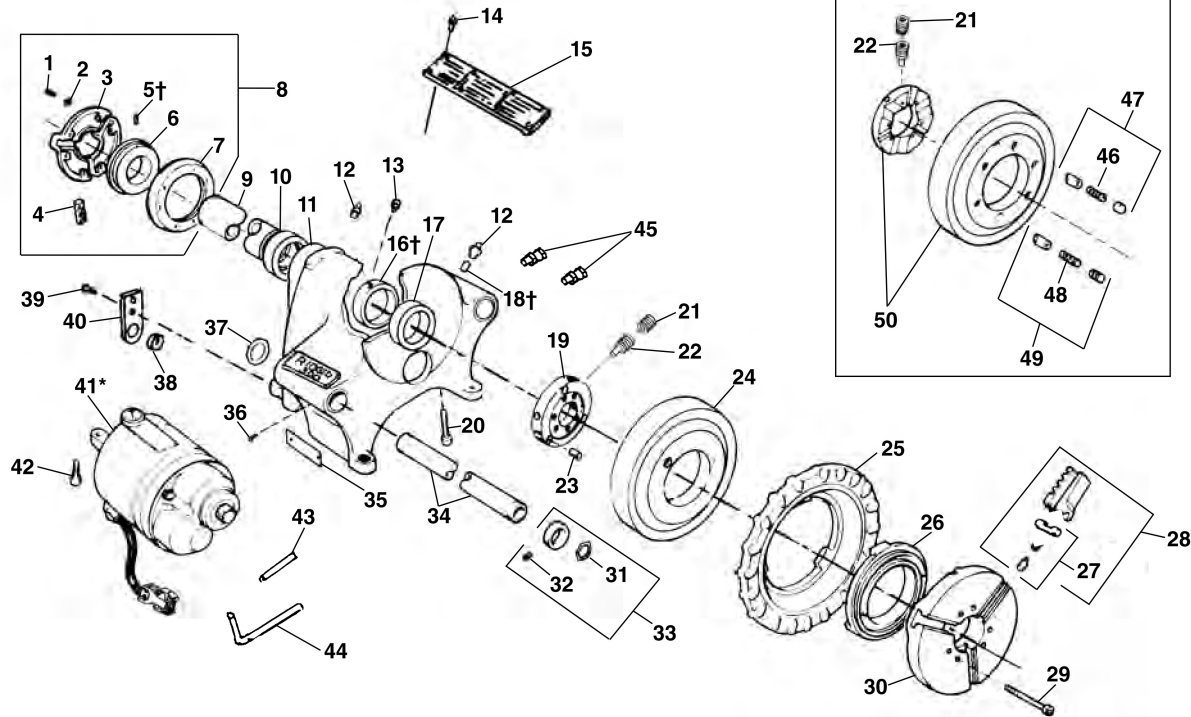


Main Components



**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

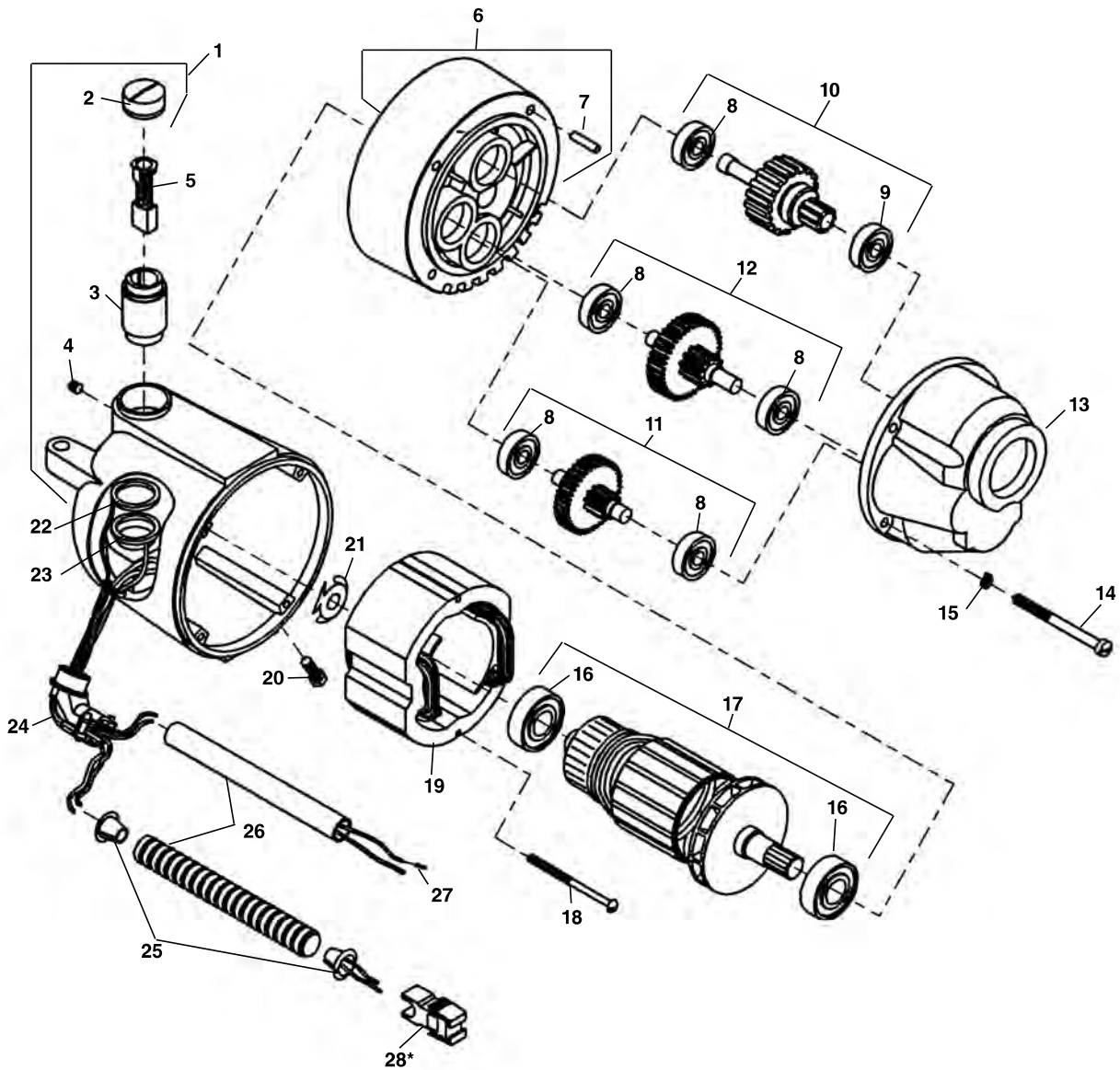
Service Notes:

†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.

3177
3277
3177-CE
3277-CE



**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
†	87740	3177 Motor 115V	10	45370	Drive Gear	20	83500	Locking Screw
†	87780	3277 Motor 230V	11	44985	1st Gear Assembly	21	44580	Loading Spring
†	61202	3177-CE Motor 115V	12	45005	2nd Gear Assembly	22	86680	White Upper Lead
†	61207	3277-CE Motor 230V	13	42875	Gear Housing	23	86685	Red Lower lead
1	43160	Housing Assembly	14	45075	Screw (4)	24	46900	Connector 90 Degree
2	44545	Brush Cap Set	15	45150	Lock Washer	25	46890	E-918 Insulator (2)
3	45025	Brush Holder Set	16	44565	Armature Bearing (2)	26	47407	Flexible Conduit
4	39770	Set Screw (2)	17	44010	Armature (115V)		46880	Plastic Tube (CE Only)
5	44540	Brush Assembly Set		44030	Armature (230V)	27	88402	Wire Terminal (4) (CE Only)
6	43165	Fan Housing Assembly	18	44555	Mounting Screw (2)	28*	50552	Plug (Included in Switch Box Assy. 91187)
7	45165	Dowel Pin	19	44015	Field (115V)			
8	45060	Gear Bearings (5)		44035	Field (230V)			
9	45315	Front Bearing						

† Refer to Speed Change Chart for Optional Speeds on Page 25

**SPEED CHANGE GEAR CHART
MACHINE MODEL NO. 300 MOTORS**

Catalog Number	Model No.	Volts	Spindle Speed	Ref. #17 Armature	Ref. No. 11 - 1st Intermediate Gear Assembly	Ref. No. 12 - 2nd Intermediate Gear Assembly	Ref. No. 10 Drive Gear
87740 87780 61202 61207	3177 3277 3177-CE 3277-CE	115V 230V 115V 230V	38 STD.	Pinion - 14 T.	CAT. NO. 44985 (E-2600-X) 51 T. GEAR 12 T. PINION	CAT. NO. 45005 (E-2601-X) 42 T. GEAR 13 T. PINION	CAT. NO. 45370 (E-3283-X) 48 T.
87750 87790	3177A 3277A	115V 230V	57 STD.		CAT. NO. 44985 (E-2600-X) 51 T. GEAR 12 T. PINION	CAT. NO. 44990 (E-2601-AX) 42 T. GEAR 18 T. PINION	CAT. NO. 45375 (E-3284-X) 43 T.
87760 87800	3177B 3277B	115V 230V	77		CAT. NO. 44975 (E-2600-BX) 51 T. GEAR 15 T. PINION	CAT. NO. 44995 (E-2601-BX) 39 T. GEAR 18 T. PINION	CAT. NO. 45375 (E-3284-X) 43 T.
87770 87810	3177C 3277C	115V 230V	108		CAT. NO. 44980 (E-2600-CX) 51 T. GEAR 19 T. PINION	CAT. NO. 45000 (E-2601-CX) 35 T. GEAR 18 T. PINION	CAT. NO. 45375 (E-3284-X) 43 T.

**SPEED CHANGE GEAR CHART
MACHINE MODEL NO. 300A MOTORS**

Catalog No.	Model No.	Volts	Spindle Speed	Ref. #17 Armature	Ref. No. 11 - 1st Intermediate Gear Assembly	Ref. No. 12 - 2nd Intermediate Gear Assembly	Ref. No. 10 Drive Gear
96810 96975 61192 91197	3181 3281 3181-CE 3281-CE	115V 230V 115V 230V	38 STD.	Pinion - 14 T.	CAT. NO. 97000 (E-2600-X) 51 T. GEAR 12 T. PINION	CAT. NO. 45005 (E-2601-X) 42 T. GEAR 13 T. PINION	CAT. NO. 45370 (E-3283-X) 48 T.
96815 96980	3181A 3281A	115V 230V	57 STD.		CAT. NO. 97000 (E-2600-X) 51 T. GEAR 12 T. PINION	CAT. NO. 44990 (E-2601-AX) 42 T. GEAR 18 T. PINION	CAT. NO. 45375 (E-3284-X) 43 T.
96820 96985	3181B 3281B	115V 230V	77		CAT. NO. 97005 (E-2600-BX) 51 T. GEAR 15 T. PINION	CAT. NO. 44995 (E-2601-BX) 39 T. GEAR 18 T. PINION	CAT. NO. 45375 (E-3284-X) 43 T.