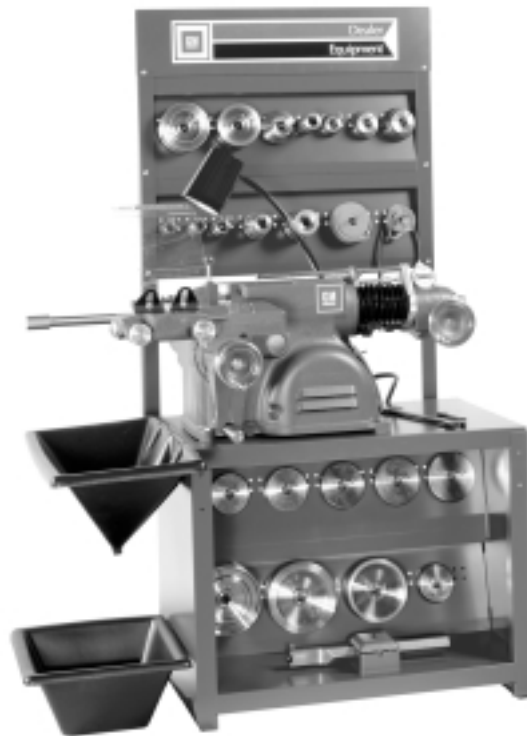




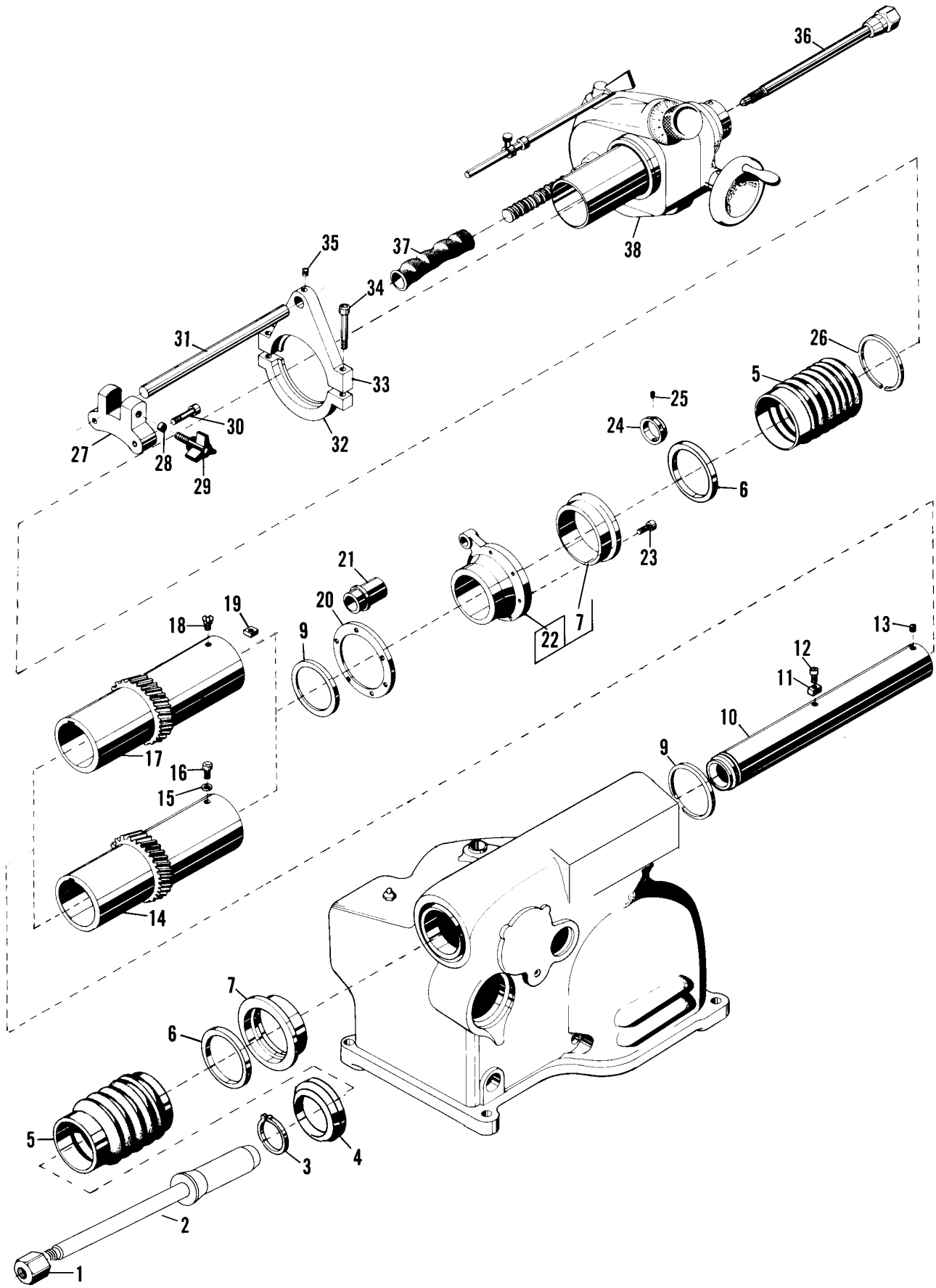
4000 GM Drum & Disk BRAKE LATHE



Parts Identification

READ these instructions before placing unit in service. KEEP these and other materials delivered with the unit in a binder near the machine for ease of reference by supervisors and operators.

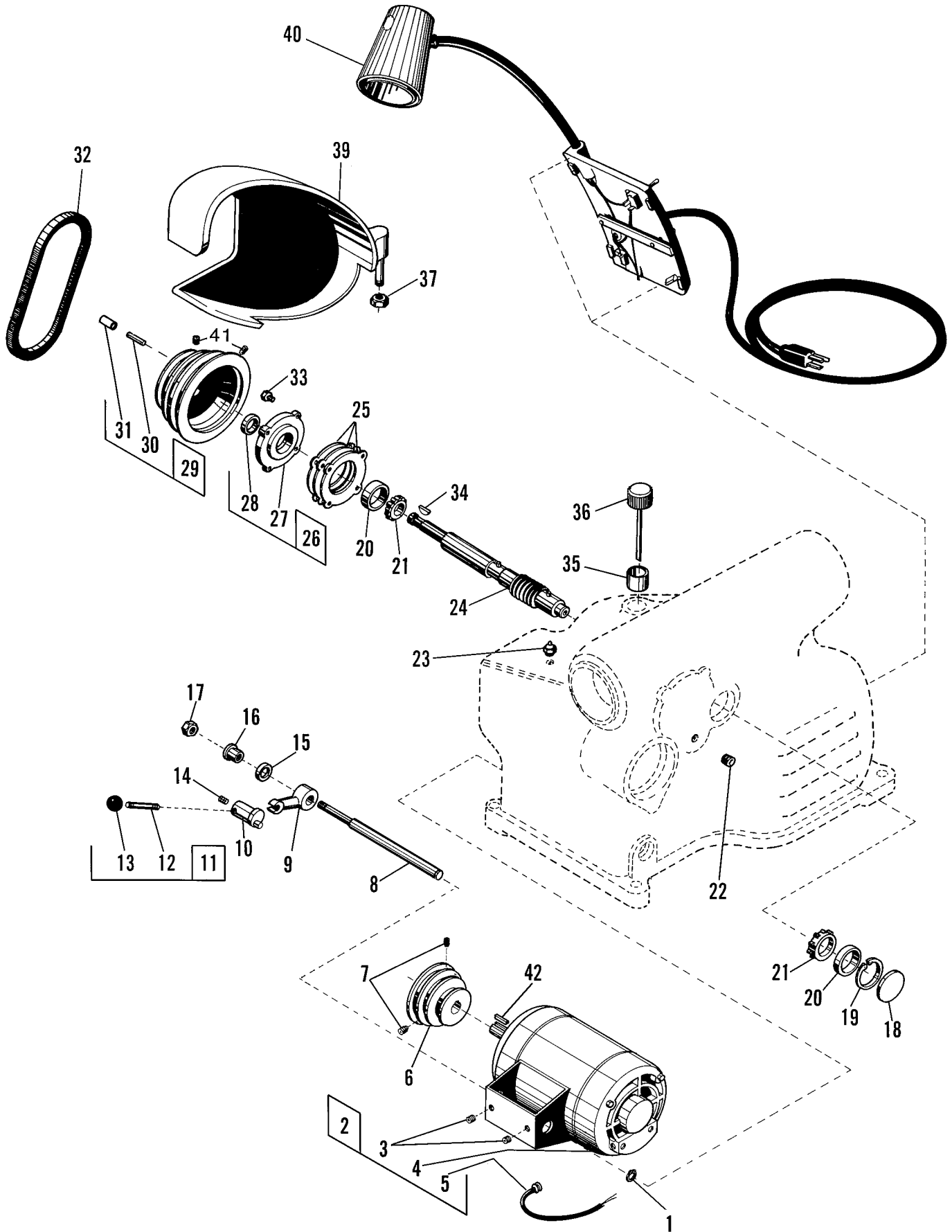
4000 GM



Spindle - 3000, 4000, 4100, 7700

ITEM	PART NO.	Qty.	DESCRIPTION
1	3102	1	Nut, arbor
2	3101	1	Arbor
3	3159	1	Ring, retaining
4	23682	1	Ring, adapter
5	3085	2	Boot
6	40720	1	Seal, oil, double-lip
7	3089	2	Ring, oil seal adapter
8	3164	1	Seal, oil
9	3033	2	Washer, thrust
10	3153	1	Spindle body, 3000/4000
11	9831	1	Key, drive
12	6486	1	Screw, cup point set
14	9830	1	Quill, drive, 3000/4000
15	283	1	Washer, lock, 3000/4000
16	1602	1	Screw, hex hd. cap, 3000/4000
17	10216	1	Quill, drive, 4100/7700
18	6868	1	Screw, flat hd., 4100/7700
19	10737	1	Block, keyway, 4100/7700
20	3032	*	Shim (* quantity as required)
21	4670	1	Nut, lead screw, 4000/7000
22	7344R-1	1	Rear flange assembly, 4000 GM
23	209	4	Screw, skt. hd. cap, 4000, 4100
24	4671	1	Nut, take up
25	3338	1	Screw, skt. hd. set
26	4435	1	Ring, boot, 4000/4100
27	9592	1	Clamp, front
28	3142	1	Plug, brass
29	6854	1	Knob
30	3319	2	Screw, skt. hd. cap, 4000 GM
31	9645	1	Rod, lock, 4000
32	9998	1	Clamp, rear, lower
33	9999	1	Clamp, rear, upper
34	6825	2	Screw, skt. hd. cap
35	213	1	Screw, set
36	7005	1	Drawbar & nut assy, 3000/4000
37	3086	1	Boot & spring, 3000/4000
38	3037-GM	1	Feed mechanism, 4000 GM

4000 GM

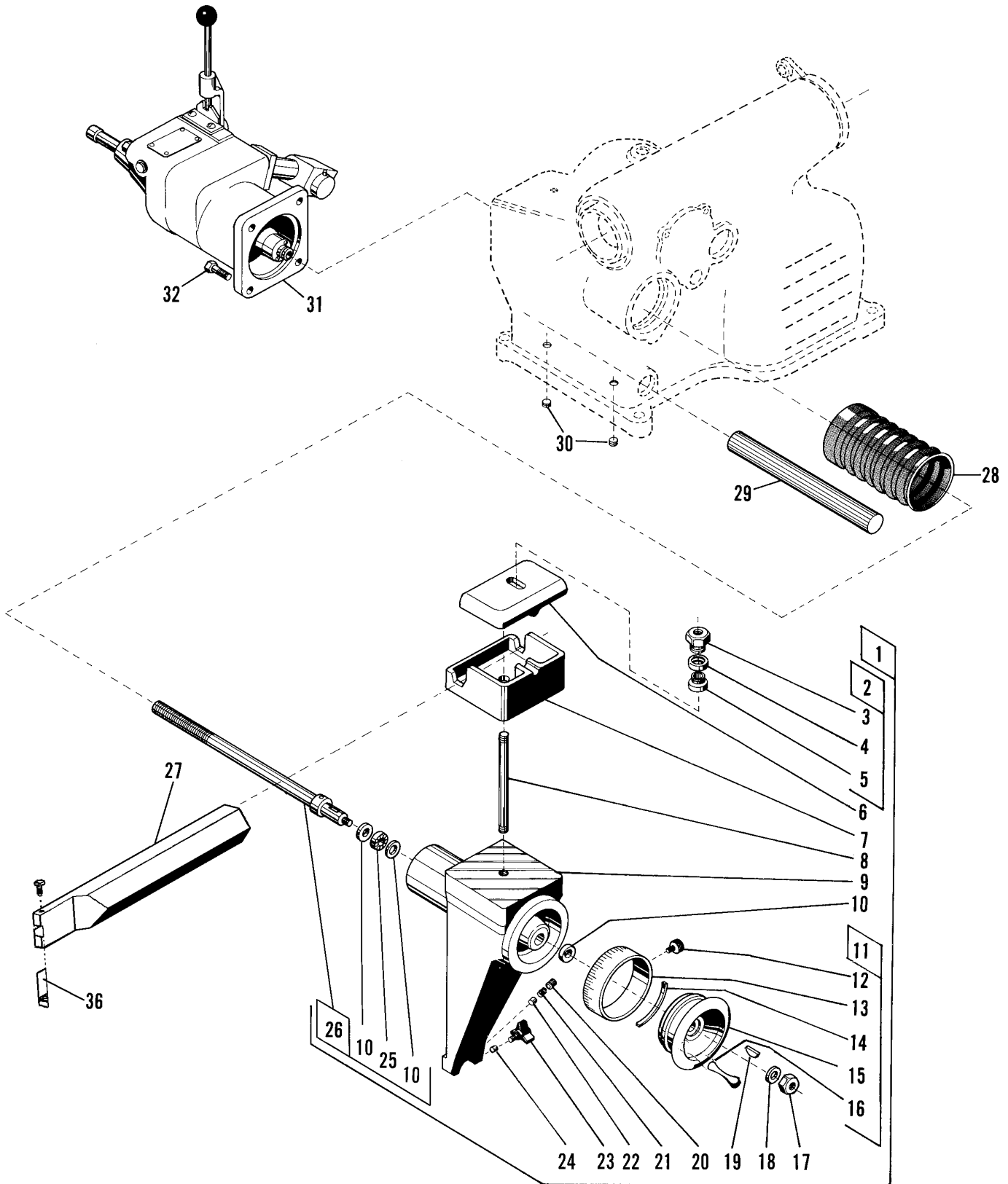


4000 GM

Motor Mount and Drive Shaft

ITEM	PART NO.	Qty.	DESCRIPTION	ITEM	PART NO.	Qty.	DESCRIPTION
1	6766	1	O-ring	25	3169	*	Shim, 0.005" (*Quantity as required)
2	6101	2	Screw, hex hd. cap		3170	*	Shim, 0.007" (*Quantity as required)
3	21557	2	Washer, lock		3171	*	Shim, 0.020" (*Quantity as required)
4	2165	1	Motor/bracket assembly	26	3186	1	Cap and seal assembly
6	40538	1	Pulley, drive, 4000 GM	27	3010	1	Cap, bearing seal
7	220	2	Set screw, 3000/4000	28	3163	1	Seal, oil
8	3023	1	Shaft, motor mount	29	40581	1	Pulley w/pin and tube, 4000 GM
9	3015	1	Lever, belt tension	30	24239	1	Pin, groove, 4000/4100
10	3035	1	Pin, eccentric belt release	31	25588	1	Tube, rubber, 4000/4100
11	7348	1	Lever belt release assembly	32	40141	1	Poly V-belt, GM
12	3088	1	Handle, belt release	33	236	1	Screw, hex hd. cap
13	320	1	Knob, ball	34	40139	1	Key, square
14	3180	1	Screw, socket hd.	35	3215	1	Sleeve, oil filler
15	2364	*	Washer, wave (* quantity as required)	36	3148	1	Dipstick
16	3223	1	Bushing, motor mount shaft	37	11273	1	Nut, self-locking
17	3377	1	Nut, hex	39	7788-1	1	Guard, belt, GM
18	3166	1	Plug, Welch	40	10352-2	1	Panel assembly, electrical, GM
19	3172	1	Ring, retaining I.D.	41	220	2	Screw, set
20	3394	2	Cup, bearing	42	25454	1	Key, square
21	3393	2	Bearing, Cone				
22	3372	1	Plug, allen pipe				
23	22006	1	Fitting, grease				
24	9847-C	1	Shaft, worm w/square key				

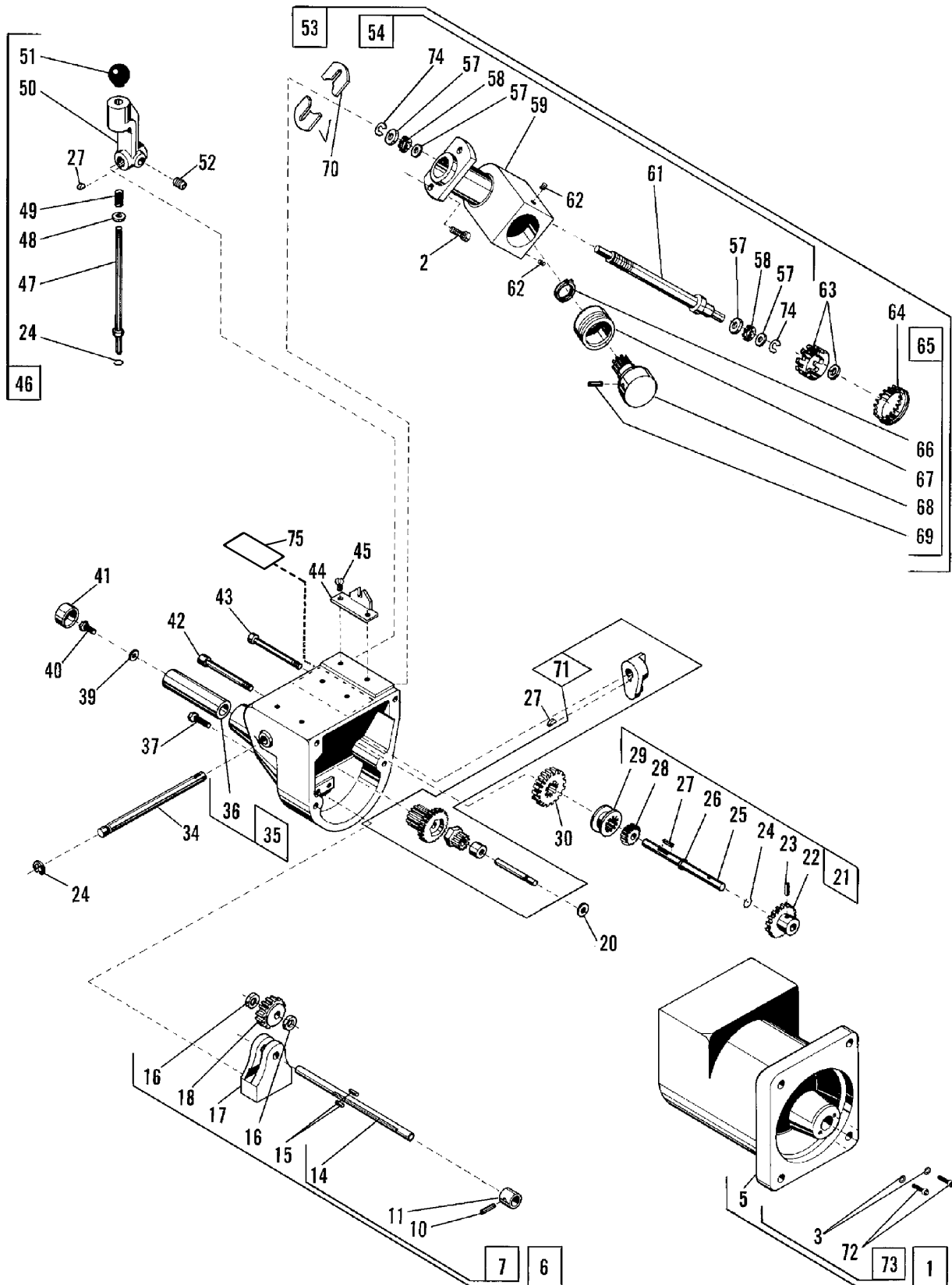
4000 GM



Cross Feed Assembly

PART			
ITEM	NO.	Qty.	DESCRIPTION
1	7345-1	1	Cross feed assembly, GM
2	11227	1	Nut/washer, hex, self-align, assy.
3	11221	1	Nut, locking
4	11225	1	Retainer
5	11224	1	Washer
6	3017-1	1	Clamp, boring bar, upper, GM
7	20666-1	1	Clamp, boring bar, lower, GM
8	3031	1	Stud, boring bar
9	9835-02	1	Cross feed, GM
10	6874	3	Race
11	9626-1	1	Cross feed handwheel assy., GM
12	6839	1	Screw, set
13	9634	1	Dial
14	9611	1	Spring, dial
15	9633-1	1	Handwheel, GM
16	3026	1	Crank, handwheel
17	2309	1	Nut, handwheel
18	3214	1	Washer, flat
19	3176	1	Key, woodruff
20	220	1	Screw, set
21	2064	1	Spring
22	9836	1	Plug
23	6854	1	Knob, locking
24	3142	1	Plug, brass
25	6873	1	Bearing, needle thrust
26	3211-1	1	Lead screw assy.
27	29240	1	Boring bar and screw assy.
28	3087	1	Boot and spring assy.
29	10346	1	Bar, guide
30	1680	2	Screw, hex hd. set
31	7751-GM	1	Gearbox assy., 4000 GM
32	237	4	Screw, cap, 4000/4100/7500
36	40558	1	Tool bit holder assembly, drum
	7681	1	Carbide insert, positive rake

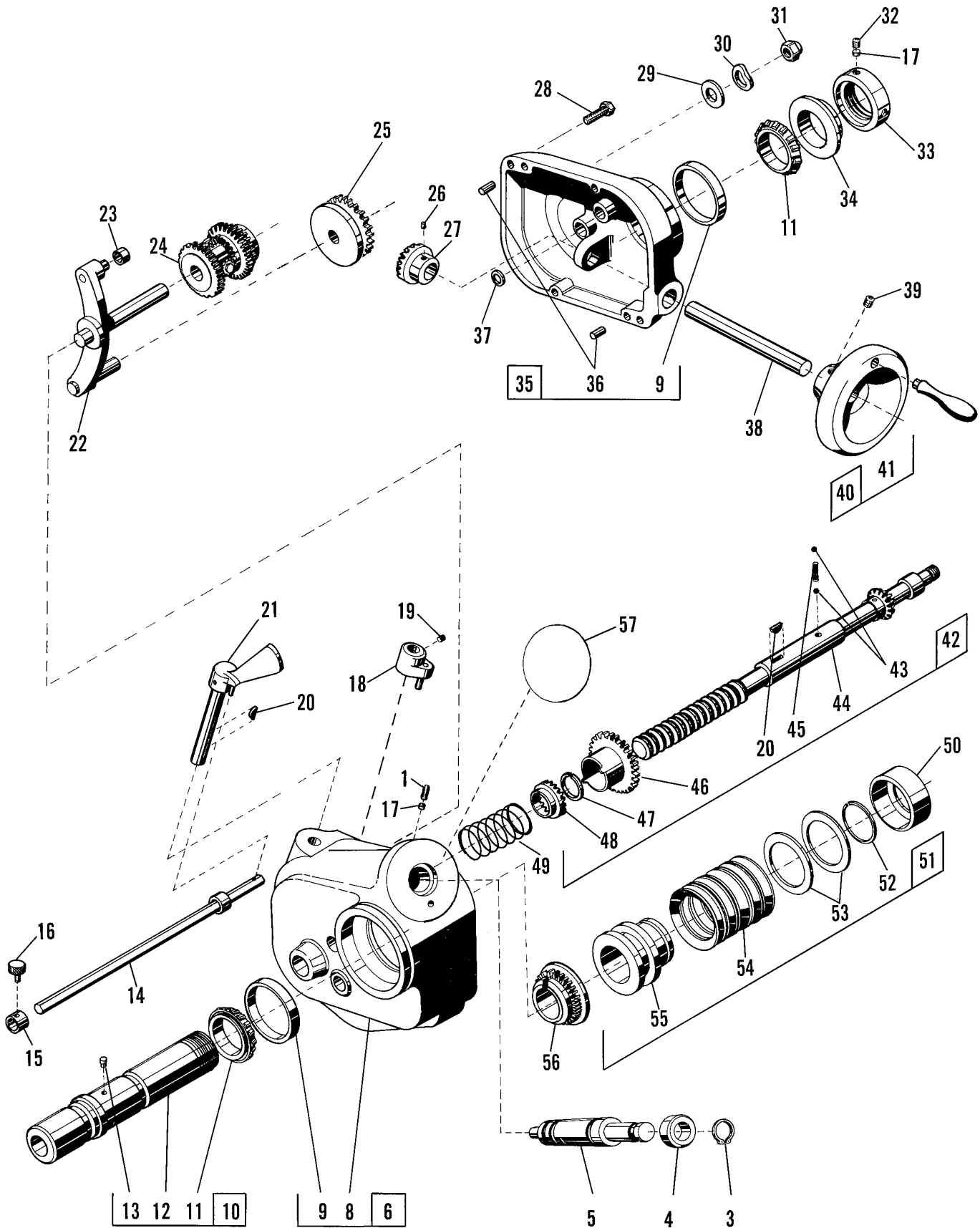
4000 GM



Disc Brake Feed Mechanism, #7751-GM

ITEM	PART NO.	Qty.	DESCRIPTION	ITEM	PART NO.	Qty.	DESCRIPTION
1	10870-11	1	Gear case assy., GM	54	24241	1	Worm drive assy.
2	3221	4	Screw, socket head	57	6872	4	Washer, travel
3	3910	2	Washer, lock	58	6871	2	Bearing, needle thrust
5	7790-1	1	Case, gear, GM	59	7998-1	1	Housing and Bushing assy., GM
6	40718	1	Coupling assy.	61	7992	1	Worm drive assy.
7	40719	1	Universal coupling assy.	62	6834	2	Screw, cone point set
10	40403	1	Pin, roll	63	7996	1	Shear gear and ring assy.
11	40717	1	Coupling	64	6446	1	Plug, dot
14	10340	1	Rod, drive	65	9821	1	Coupling assy.
15	6937	2	Pin, dowel	66	3174	1	Ring, retaining
16	6973	2	Washer, thrust	67	9825	1	Spacer and bushing assy.
17	7775	1	Trap	68	9822	1	Coupling and gear assy.
18	7778	1	Gear, drive	69	4096	1	Pin, roll
20	6350	1	Washer, bone shim	70	7908	2	Shim, 0.005"
21	9814	1	Shifter shaft assy.		7903	2	Shim, 0.010"
22	7994	1	Gear, helix		7904	2	Shim, 0.020"
23	4006	1	Pin, roll		7905	2	Shim, 0.030"
24	5613	2	Ring, retaining	71	24516	1	Shifter & intermediate gear assy.
25	7764	1	Shaft, clutch	72	28367	2	Screw, cap
26	6138	1	Ring, Retaining	73	28529	1	Lead screw nut kit
27	3176	5	Key, woodruff	74	5639	2	Ring, retaining
28	9816	1	Gear, fine feed	75	40529	1	Decal
29	9813	1	Clutch				
30	9812	1	Gear, coarse feed				
34	7748	1	Shaft, shift				
35	7902-1	1	Gear case cover and tube assy., GM				
36	7783	1	Tube				
37	3221	2	Screw, socket hd. cap				
39	4789	1	Washer				
40	6254	1	Screw, socket hd. cap				
41	6974	1	Cap, tube				
42	6392	2	Screw, hex hd. machine				
43	6391	2	Screw, hex hd. machine				
44	40521	1	Plate, index, GM				
45	4508	2	Screw, round hd. machine				
46	7742	1	Shifter handle assy.				
47	7746	1	Pin, shifter handle				
48	6451	1	Washer				
49	7699	1	Spring				
50	7744	1	Body, shifter handle				
51	320	1	Knob, ball				
52	220	1	Screw, set				
53	9815	1	Driven assembly., GM				

4000 GM

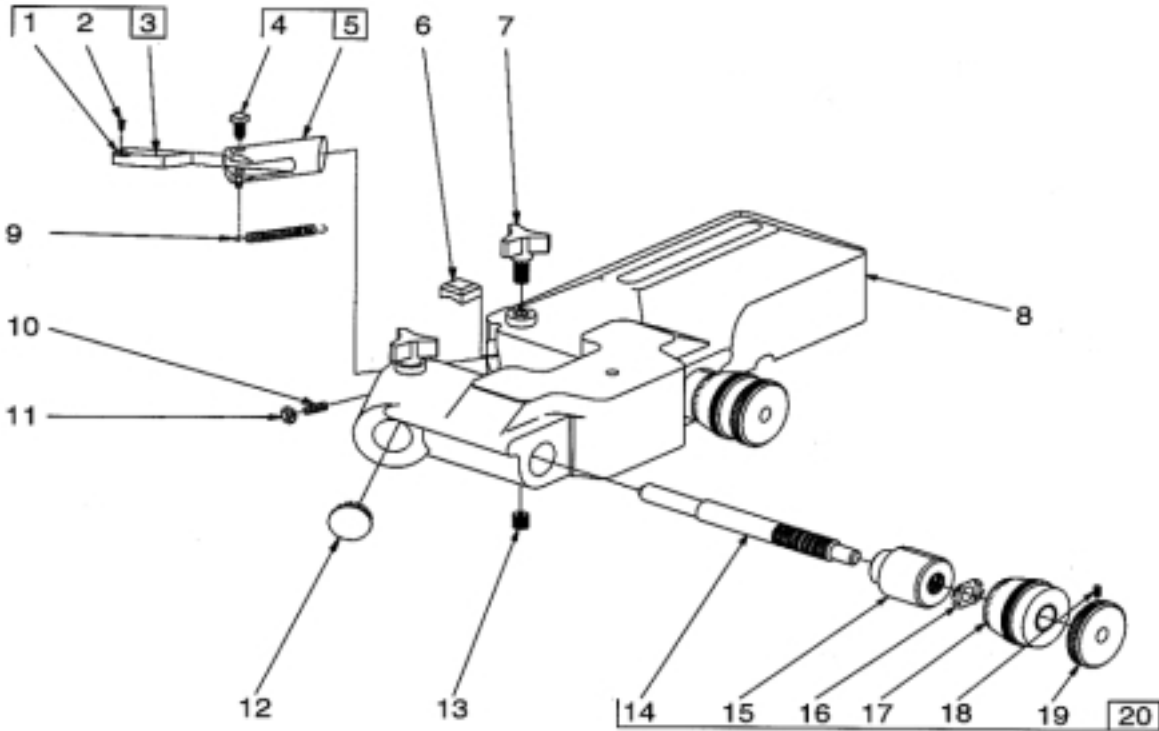


Variable Feed Gearbox Assy. 3037-GM

ITEM	PART NO.	Qty.	DESCRIPTION	ITEM	PART NO.	Qty.	DESCRIPTION
1	2308	1	Screw, allen set	45	3060	1	Spring, clutch
3	3097	1	Ring, retaining	46	3047	1	Gear, sliding clutch
4	9930	1	Bearing, thrust	47	6163	1	Ring, retaining
5	40533	1	Screw, feed adjusting, GM	48	7264	1	Clutch jaw
6	3715-1	1	Gear case assy.	49	7263	1	Spring, coil
8	25182-1	1	Gear case, GM	50	3061	1	Cup, spring loading
9	3392	1	Cup, bearing	51	3082	1	Friction disc assy.
10	7007	1	Spindle extension assy.	52	3093	1	Ring, retaining
11	3391	1	Bearing, taper roller	53	3064	2	Washer
12	3154	1	Spindle extension	54	3062	10	Spring, Belleville
13	3092	1	Pin, groove	55	3078	1	Disc, sliding friction
14	3040	1	Shut-off assy., 3000/4000	56	3077	1	Clutch, fixed friction
15	3039	1	Collar, stop	57	40530	1	Decal
16	3084	1	Screw, knurled				
17	3141	2	Plug, brass				
18	3058	1*	Clutch shifter assy.				
19	212	1	Screw, allen set				
20	4449	2	Key, Hy-Pro				
21	3042	1*	Clutch handle and shaft assy.				
22	7343	1*	Feed control lever and differential assy.				
23	3036	1	Roller				
24	7338	1	Pinion bushing assy.				
25	3081	1*	Driven friction disc & bearing assy.				
26	3098	1	Screw, dog point set				
27	3069	1	Gear, miter				
28	3094	4	Screw, socket hd. cap				
29	3324	4	Washer				
30	6155	1	Washer, wave				
31	3184	1	Nut, stop				
32	213	1	Screw, allen set				
33	9443	1	Nut, bearing lock				
34	9444	1	Washer, spherical				
35	9498-1	1	Gear case cover assy.				
36	3038	2	Pin, dowel				
37	4641	1	Washer, bone fiber				
38	3054	1	Shaft				
39	220	1	Screw, set				
40	3090-1	1*	Handwheel assy., GM				
41	3026	1	Handle, crank				
42	8235	1	Lead screw & clutch assy. 3000/4000				
43	311	2	Ball, steel				
44	9918	1*	Lead screw/miter gear assy. 3000/4000				

*Sold as assy. only

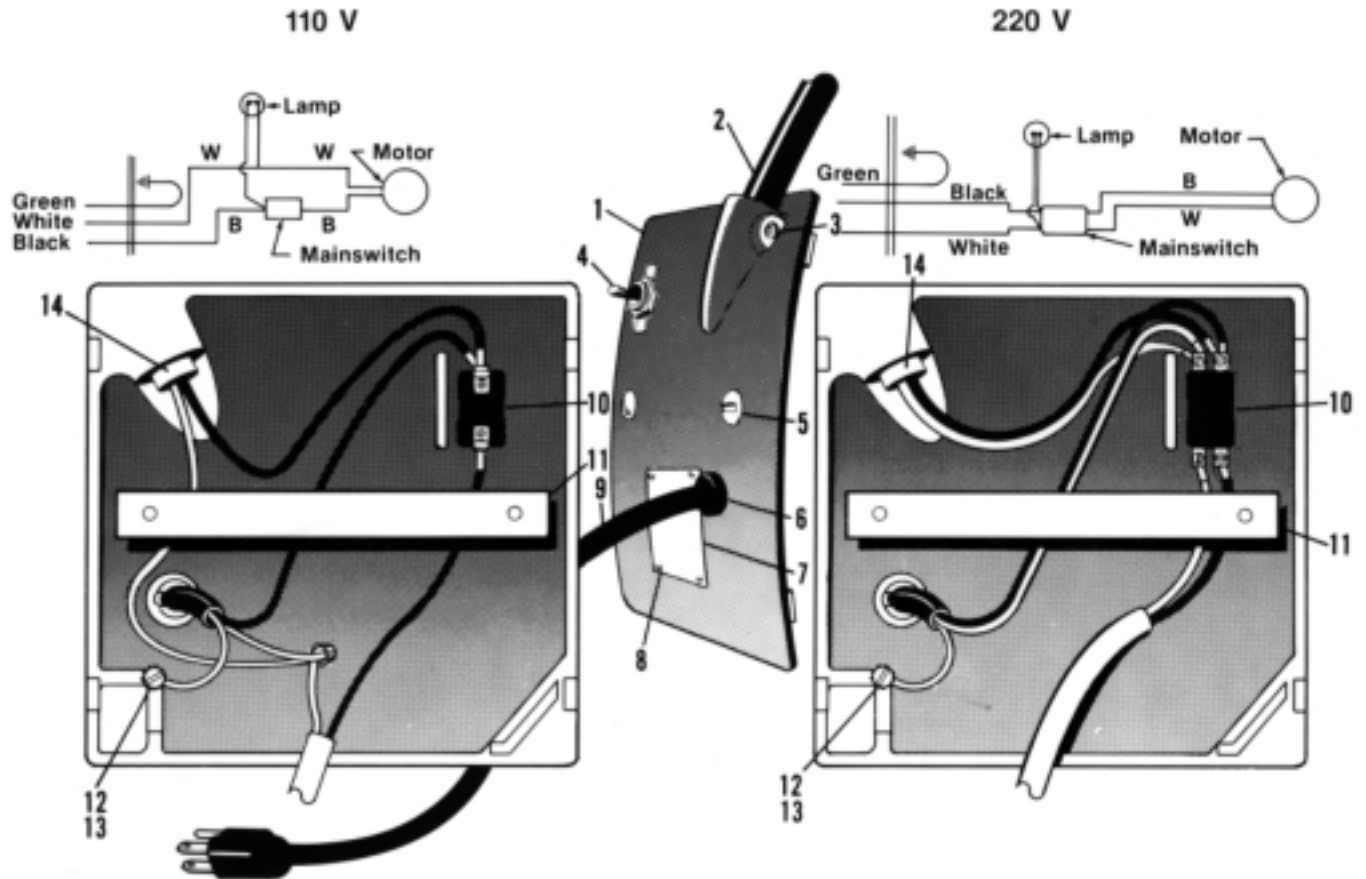
6950 Twin Cutter



ITEM	PART NO.	Qty.	DESCRIPTION
1	7681	2	Carbide Insert, Positive Rake
2	6499	2	Screw, #4-40 x .25 Oval Head
3	40559	1	Holder, Tool Bit, Right Hand, Positive Rake
	40560	1	Holder, Tool Bit, Left Hand, Positive Rake
4	9249	2	Screw, Square Head Set
5	10650	1	Tool Holder, Left Hand
	10651	1	Tool Holder, Right Hand
6	28584	2	Gib, Brass, Tool Holder
7	6854	1	Screw, Lock
8	28572-4	1	Twin Cutter Housing, GM
9	6905	1	Spring
10	9879	2	Screw, Locating
11	3528	2	Nut, Hex
12	6977	2	Plug, Dot
13	6109	2	Screw, 3/8-16 Set
14	6908	2	Rod, Dial
15	6906	2	Plug, Dial
16	6929	2	Washer, Spring
17	6907	2	Dial, Micrometer
18	3338	2	Screw, Set
19	6923	2	Knob, Dial Rod
20	6901	1	Dial Assy.

4000 GM

Electrical Panel Assembly



ITEM	PART NO.	Qty.	DESCRIPTION
1	10348-1	1	Panel, electrical, GM
2	7963	1	Lamp
3	220	1	Set Screw
4	1185	1	Switch, Plate
5	3183	2	Screw, round head machine
6	6058	1	Grip, cord, 110 V
	6077	1	Grip, cord, 220 V
7	20463	1	Plate, electrical caution
8	306	4	Screw, drive
9	7209	1	Cord, set, 110 V
	7210	1	Cord, set, 220 V
10	6893	1	Switch, 110 V
	21464	1	Switch, 220 V
11	3079	1	Strap, clamp
12	21972	1	Screw, Self Tapping
13	1926	1	Washer, lock
14	2889	1	Bushing, insulated

Not Shown:

- 22763 - Replacement lamp switch & socket
- 22764 - Replacement dust boot for lamp

