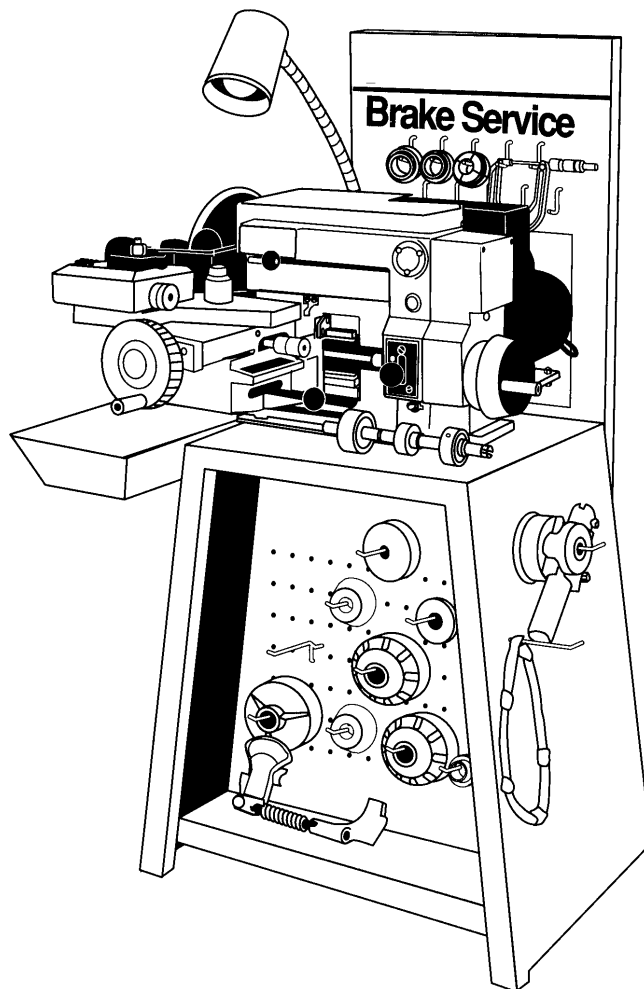




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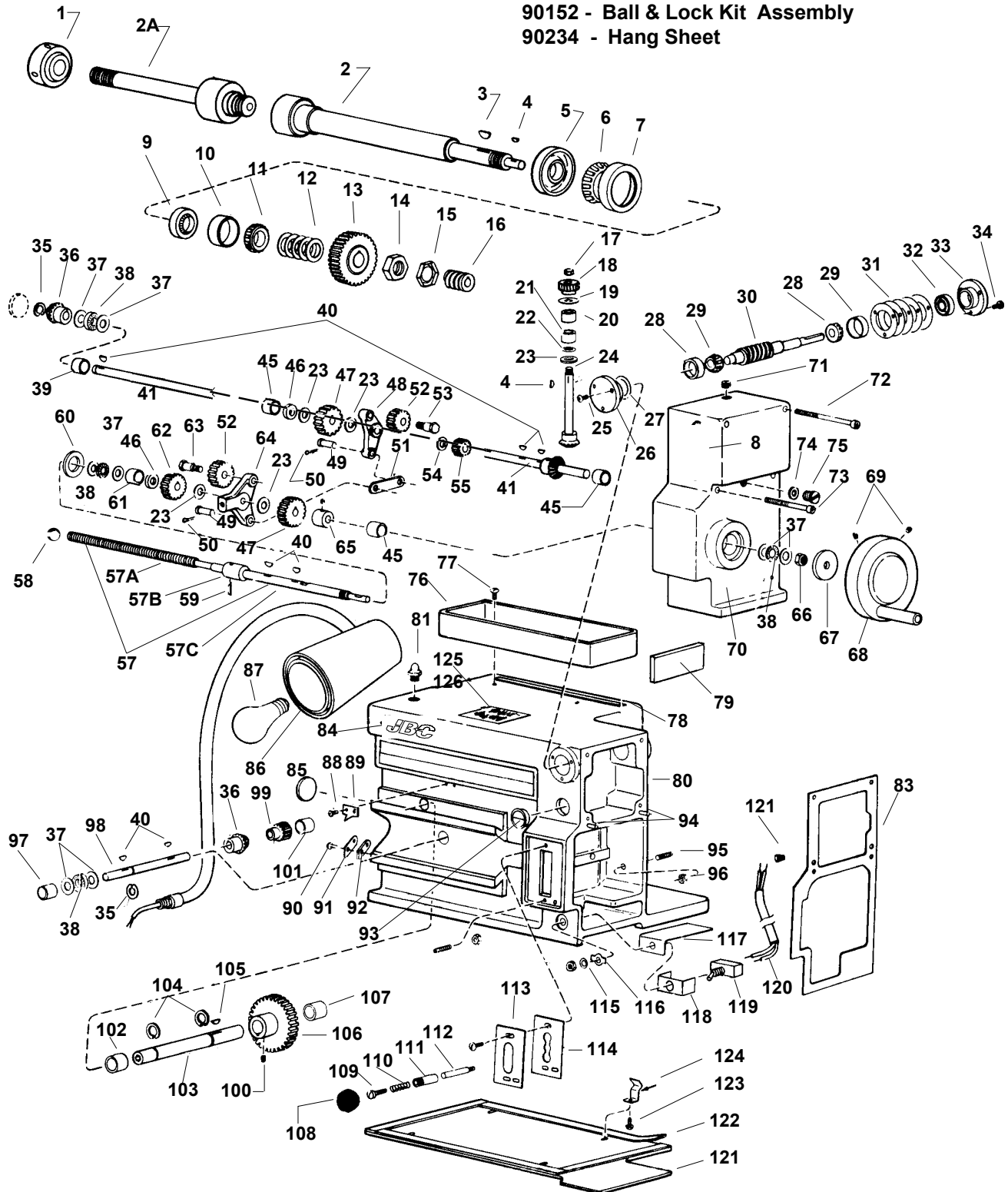
600 Series Brake Lathe Parts Reference



FORM 3814-8

Figure 1 - Main Housing Group

- 9010319 - End Cover Assembly
- 90226 - Chip Deflector Assembly
- 9010322 - Gear Train Assembly
- 90152 - Ball & Lock Kit Assembly
- 90234 - Hang Sheet

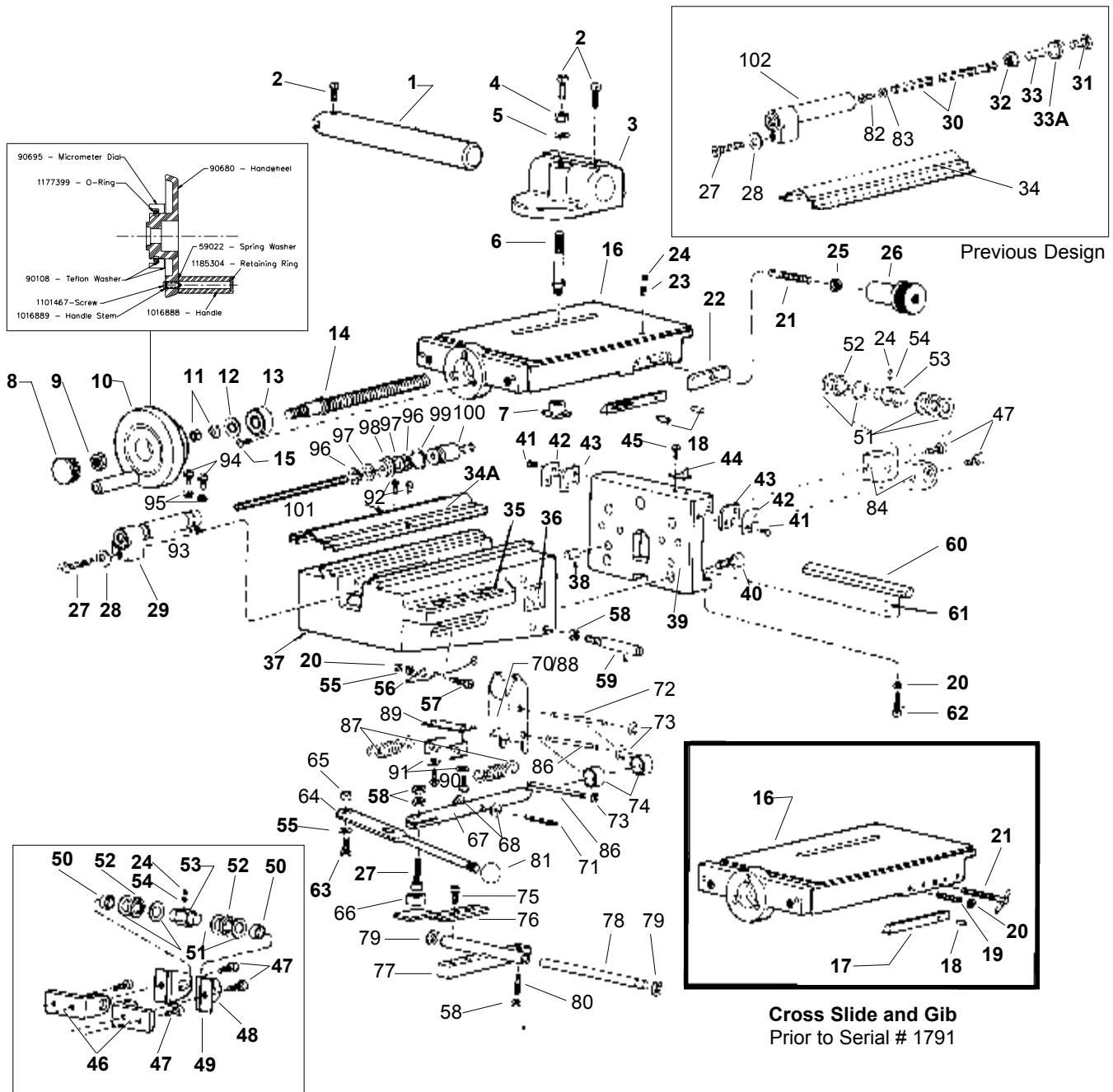


<u>Ref No</u>	<u>Part No</u>	<u>Description</u>	<u>Ref No</u>	<u>Part No</u>	<u>Description</u>
1	90547	Self-centering Arbor Nut	67	8027201	Washer, Neoprene Seal
2	90042	Spindle	68	90658	Handwheel Assy., Carriage Traverse
2A	90043	Arbor, 1" Dia.	69	1103470	Soc. Setscrew, 5/16-18x1/2"
3	1109881	#608 Woodruff Key	70	2013020	End Cover
4	1100905	#404 Woodruff Key	71	90570	Oil Fill Plug
5	1101518	Front Oil Seal, Spindle	72	1101486	HSC Screw, 1/4-20x3-3/4"
6	1101441	Front Bearing Cone, Spindle	73	1102351	HSC Screw, 1/4-20x3.0"
7	1177644	Front Bearing Cup, Spindle	74	8022550	Gasket, Oil Drain Plug (3/8" ID)
8	90777	600 Series Decal, John Bean	75	1007010	Oil Drain Plug
9	1177749	Rear Oil Seal, Spindle	76	90384	Tool Tray (Larger than Shown)
10	1177512	Rear Bearing Cup, Spindle	77	1120023	Screw, Truss Hd. 1/4-20 x1/2"
11	1177511	Rear Bearing Cone, Spindle	78	8027274	Tool Tray Shim
12	8009650	Shim, Worm Gear (0.005")	79	8027209	Cushion, Belt Guard
13	1006600	Worm Gear, 38 Tooth	80	2013018	Lathe Housing
14	1016859	Special Hex Nut, 1-14 TPI	81	1100759	Grease Fitting
15	1187063	Pal Nut, 1-14 TPI	83	8027193	Gasket End Cover
16	90237	Worm, Feed	84	44251	JBC Logo
17	1109587	Hex Jam Nut, 3/8 X 24 TPI	85	1110551	Expansion Plug
18	1006591	Helical Gear, End Cover Shaft	86	2511339	Lamp Assembly
19	8017520	Fiber Washer, 1/2x1-3/8x0.015"	87	7007620	Bulb
20	1177646	Bronze Bearing - Cover Shaft (top)	88	1187863	Screw
21	1177648	Bronze Bearing - Cover Shaft(bottom)	89	8027221	Pointer
22	1185187	O-Ring, 1/2x11/16x3/32"	90	1115098	Screw
23	8000390	Fiber Washer, 1/2x1.0x1/32"	91	8009620	Plate, Gib Wiper - Lower
24	2504221	Shaft & Gear Assy., End Cover	92	8009630	Gib Wiper - Lower
25	1101467	Button Hd. Soc. Cap Screw,#10-4x38"	93	8009790	Gauge, Oil
26	1016804	Front Cap, Worm Shaft Bearing	94	1110180	Pin Dowel
27	1101468	O-Ring, 1-1/4 ID x1-3/8" OD	95	1103452	Screw Socket Set 1/4-20 x 7/8"
28	1177642	Bearing Cup, Worm Shaft	96	8027192	Cover, Shift Selector
29	1177641	Bearing Cone, Worm Shaft	97	1101512	Bearing, Oillite
30	90237	Worm Drive Shaft	98	1016850	Front Idler Shaft
31	8027228	Shim, Seal Retainer Cap, .002"	99	1016832	Gear, Spur Idler Shaft - 21 Tooth
	8009660	Shim, Seal Retainer Cap, .005"	100	1103437	Screw
32	1177650	Oil Seal, Worm Shaft	101	5001538	Bearing Oillite
33	2006890	Cap, Seal Retainer	102	1101509	Bearing Oillite
34	1102540	RHM Screw, #10-24x5/8"	103	1016899	Shaft Feed Drive
35	1185191	Ring Retainer Cresent 1/2"	104	1185388	Retainer Ring 3/4"
36	1016837	Miter Gear	105	1104436	#606 Woodruff Key
37	5001535	Race, Needle Bearing Thrust, 1/2"	106	1016833	Gear, Spur
38	5001534	Needle Bearing, 1/2"	107	1101511	Bearing, Oillite
39	1101513	Oillite Bearing 1/2"x7/8"x3/4"	108	90150	Gear Shift Ball - White
40	1177640	#304 Woodruff Key	109	1102547	Machine Screw #10-24 x 1 1/4"
41	2511349	Idler Shaft and Gear Assembly	110	6001110	Spring, Gear Shift Handle
44	1103446	No longer used	111	90151	Lock, Feed
45	1177647	Bearing, Idler Shaft - Bronze	112	90700	Gear Shift Handle
46	1016824	Gear Spacer	113	8027192	Cover Shift Selector
47	1006560	Spur Gear - 30 Tooth	114	8027191	Plate Shift Cover
48	2006822	Gear Shift Arm	115	1187357	Internal Washer (Shakeproof) - 7/16"
49	1006670	Clevis Pin - Shift Link	116	1206548	Plate, On- Off switch
50	1100362	Cotter Pin, 3/32"x1/2"	117	7007614	Toggle Switch Insulator
51	8009510	Shifter Link	118	7007632	Insulator, Switch Proper
52	1006541	Spur Gear - 24 Tooth	119	7007631	Switch, On- Off
53	1006680	RH Shoulder Bolt	120	2511366	Wire, Toggle Switch - 2 Conductor
54	8009670	Fiber Washer, 1/2"x13/16"x1/32"	121	90870	Lathe Housing Bottom Plate
55	1006550	Spur Gear - 15 Tooth	122	60353	Tape Foam Gasket 3/8" x 3.2'
57	90666	Carriage Feed Screw Assy.	123	1118157	RHS Screw #10-24x3/8"
57A	90667	Carriage Feed Screw	124	8019870	Spring Clip - Bottom Plate
57B	1016817	Feed Screw Coupling	125	90243	Warning Label
57C	1016823	Feed Screw Drive Shaft	*	1187961	Roll Pin 5/32x1.0" (p/o 2511349)
58	1185304	Retainer Clip, Carriage Feed	*	985255	Red 1/4" Striping Tape
59	1177799	Roll Pin - Feed Screw	*	90152	Lock Feed - Gear Shift
60	5001536	Felt Washer, Feed Screw	*	90080	UL Label
61	1177647	Bronze Bearing - Feed Screw	*	1101511	Oillite Bearing, 3/4"x1-1/4"x1.0"
62	1006541	Spur Gear - 24 Tooth			
63	1007680	LH Shoulder Bolt			
64	2006844	Gear Shift Bracket			
*	90199	Spacer Plate			
*	57968	Mat			
*	1006571	Miter Gear (p/o 2511349)			
65	1015340	Collar, Set			
66	1120263	ESNA Thin Nut, 1/2-20			

* NOT SHOWN

Figure 2 - Cross Slide Carriage and Tool Post Group

9010323 - Carriage Assembly
 90220 - Shut Off Assembly - Switch



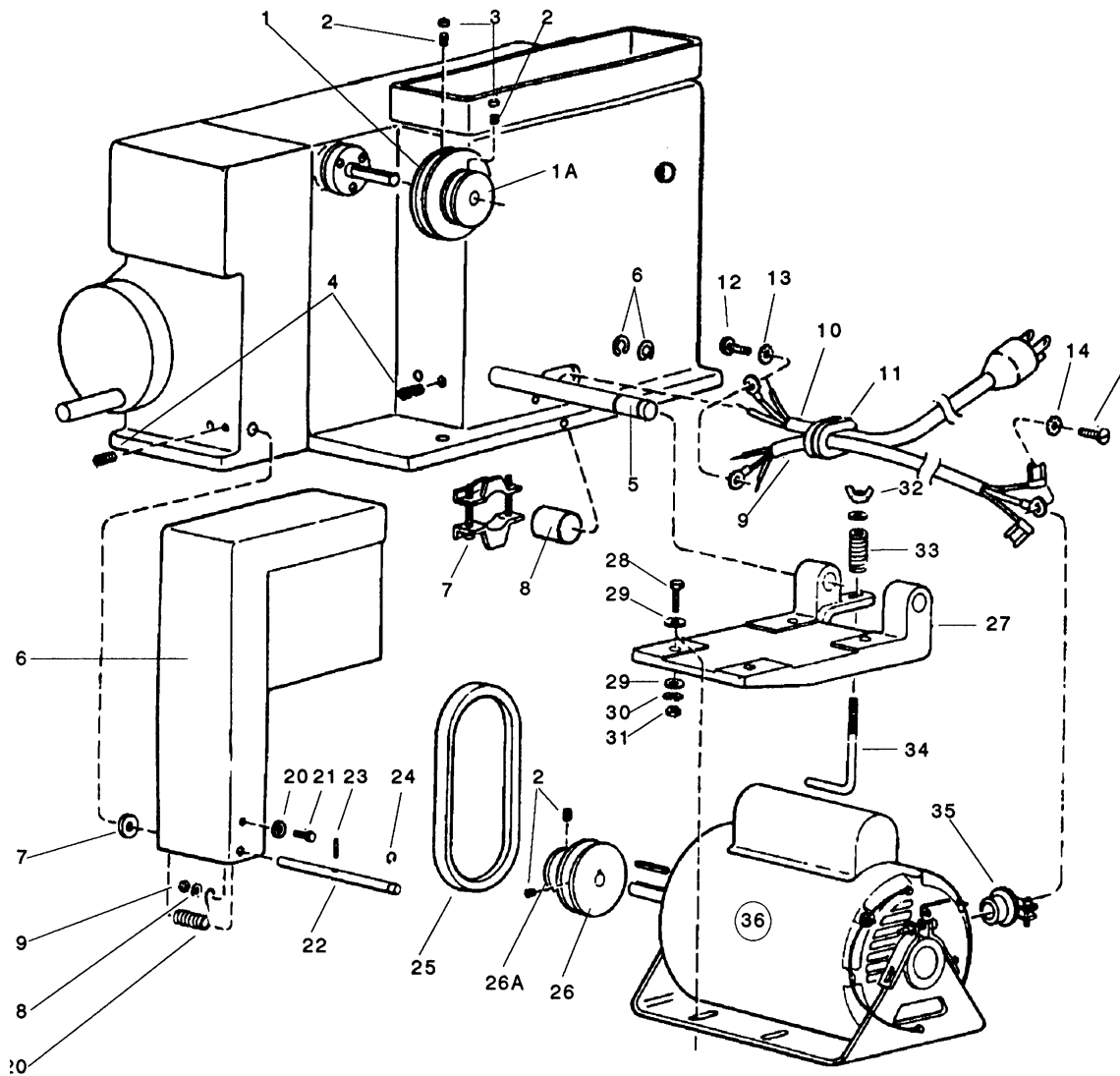
Feed Nut Bracket Assembly
 Prior to Serial No. 6154

Cross Slide and Gib
 Prior to Serial # 1791

<u>Ref #</u>	<u>Part No</u>	<u>Description</u>	<u>Ref #</u>	<u>Part No</u>	<u>Description</u>
1	1006691	Tool Bar	54	8025720	Nylon Insert, Carriage Nut
2	1015540	Sq. Hd. Screw 3/8-16x3/4"	55	1100241	Lockwasher 1/4"
3	2011112	Tool Post Holder	56	6002494	Detent Spring
4	1109285	Hex Nut 1/2-13 Heavy	57	1102345	SHC Screw, 1/4-20x1.0"
5	1107385	SAE Washer 1/2"	58	1182563	Hex Jam Nut, 5/16-18
6	90681	Adjustable Pivot Post	59	90220	Shut-off Rod Assembly
7	1016843	Pivot Post T-Nut	*	90219	Shutoff Sleeve
8	90282	Button Plug	*	6002110	Spring
9	1109591	Hex Nut 5/8-18	*	1102355	Rod, 5/16x18x2"
10	90678	Dial Wheel Assembly	60	8027215	Carriage Gib
11	8027258	Dial Wheel Locking Element	61	1110180	Dowel Pin, Carriage Gib
12	8027272	Dial Wheel Shim	62	1101515	Sq. Hd. Screw, 1/4-20x1.0"
13	1185064	Ball Bearing	63	1111599	HHC Screw, 1/4-20x5/8"
14	90071	Cross Slide Feed Screw	64	8027220	Carriage Control Lever
15	1120023	Truss Hd. Screw 1/4-20x1/2"	65	1016835	Lever Pivot Spacer
16	9010340	Cross Slide Assembly	66	8027222	Pressure Lock Cap
17	—	Cross Slide Gib	67	1016852	Feed Control Shaft
	8027218	Before Ser No. 1791	68		No Longer Used
	8027286	After Ser. No. 1790	69		No Longer Used
18	—	Dowel Pin, Cross Slide Gib	*70	8027273	Control Link(Prior to 9010356)
	1110180	Before Ser No. 1791	71	1177551	Roll Pin, Feed Control Shaft,1/16x1-3/4"
	1016867	After Ser. No. 1790	72	1016841	Link Pivot Shaft
19	1016865	Soc Setscrew 1/4-20x1-1/4"(To Ser 1791)	73	1101510	Type E Retaining Ring, 1/4"
20	1121549	Hex Jam Nut, 1/4-20	74	1101508	Oillite Bearing, 3/4x7/8x3/4"
21	—	Mounting Lock Screw	75	1110818	Soc. Setscrew, 5/16-18x1-1/4"
	1016777	Before Ser No. 1791 - with T-Handle	76	6002493	Carriage Control Lock Spring
	1016868	After Ser. No. 1790	77	2511345	Carriage Control Lock Pivot
22	8027285	Pressure Lock Plate	78	1016844	Lock Pivot Shaft
23	1110770	Cove Pt. Setscrew, 1/4-20x3/8"	79	1185427	Type E Retainer Ring, 1/2"
24	1177531	Mac-It Screw, 1/4-20x1/8"	80	1103480	Soc. Setscrew, 5/16-18x1-1/4"
25	1120249	ESNA Lock Nut, 5/16-24	81	8009610	Ball, Black Plastic
26	1016869	Lock Nut, Cross Slide Gib	82	1112276	Soc. Setscrew (Prev. Design)
27	1112293	HSC Screw, 5/16-18x1-1/2"	83	1016873	Special Washer (Prev. Design)
28	8027010	Feed Nut Washer	84	1016890	Feed Nut Carrier
29	90077	Cross Slide Feed Nut	*85	9010356	Service Kit (See Nos. 86 to 91)
30	1016872	Cross Slide Hex Drive Shaft	86	1016895	Spring Anchor Shaft
31	1016878	Compression Bushing	87	6002488	Spring
32	1016879	Compression Nut	88	8027323	Link Control
33	1016880	Locking Sleeve	89	8027324	Anchor Bracket
33A	1016881	Yoke	90	1101467	Screw, #10-24x1/2"
--	920073	Svc. Kit Includes 31, 32, 33, 33A	91	1100240	Lockwasher
34	8027225	Knee Dovetail Cover	92	1115142	Screw FH #8-32x7/16"
34A	90073	Aluminum Cross Feed Cover	93	90067	Bearing Tube Assembly
35	8027223	Feed Selector Label	94	1187794	Screw, 1/4-20x5/8"
36	8017740	Feed Instruction Label	95	1100241	Lockwasher 1/4"
37	90048	Carriage Knee	96	90075	Retainer Clip
38	1110189	Dowel Pin 3/8x1.0"	97	90074	Support Washer
39	2013028	Carriage Slide	98	90076	Bearing, Conveyor Type
40	1102362	SHS Screw, 3/8-16x1.0"	99	1118716	Internal Retaining Ring
41	1110598	RHM Screw, #8-32x3/8"	100	90686	Hex Drive Selector
42	8009560	Gib Wiper Plate	101	90070	Hex Drive Shaft
43	8009640	Gib Wiper Felt	102	90009	Feed Nut Assembly
44	8027221	Carriage Alignment Pointer			
45	1187863	PHSM Screw, #8-32x1/4"			
46	1016890	Feed Nut Bracket (To Ser. 6154)			
47	1102343	SHC Screw 1/4-20x1/2"			
48	8027224	Carriage Feed Nut Shield(to 6154)			
49	8027235	Carriage Feed Nut Wiper (to 6154)			
50	5001520	Flanged Feed Nut Bearing(to 6154)			
51	5001530	Needle Bearing Thrust Race, 3/4"			
52	5001529	Needle Bearing, 3/4"			
53	1016845	Carriage Feed Nut			

* NOT SHOWN

Figure 3 Motor and Guard Group

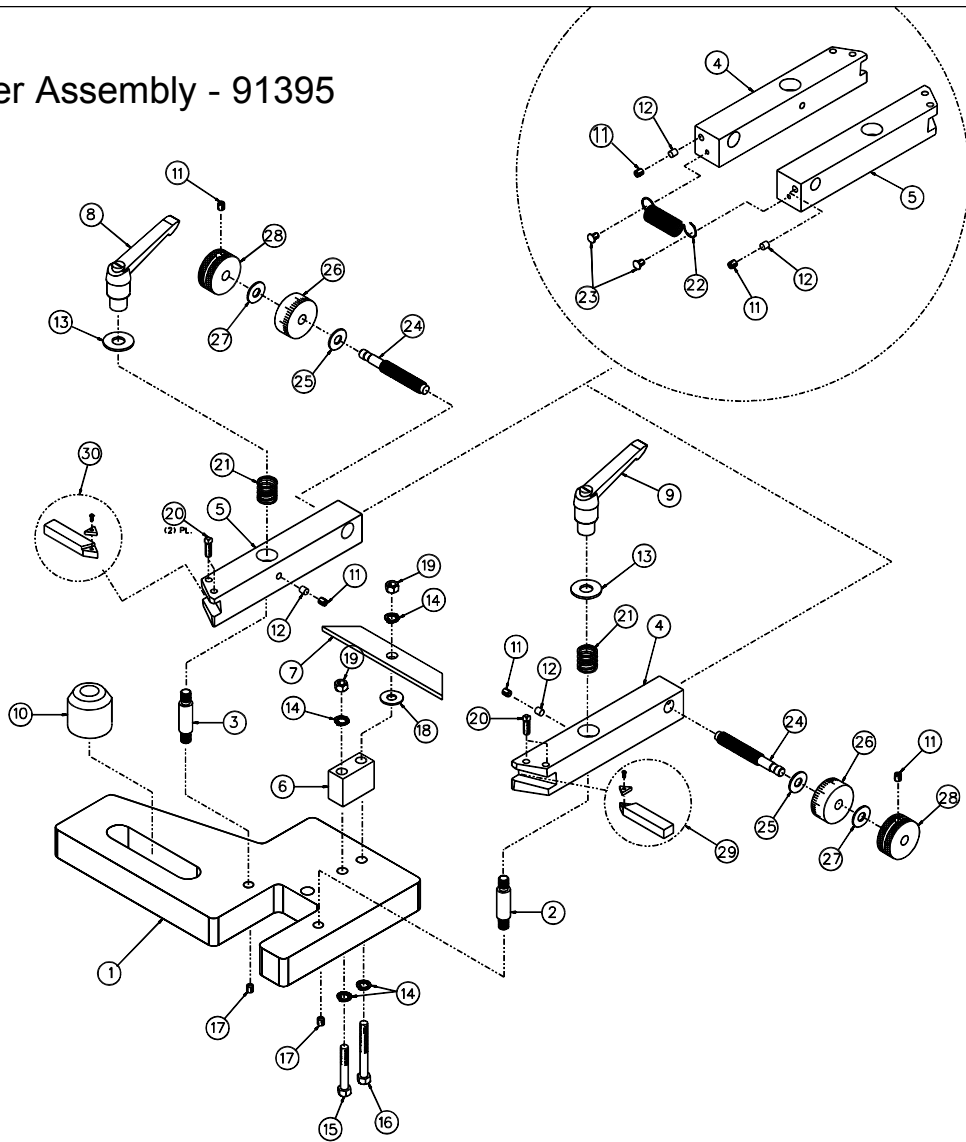


- 90160 - Belt Guard Assembly
- 90193 - Lathe Motor Assembly
- 90188 - Motor Mount Assembly

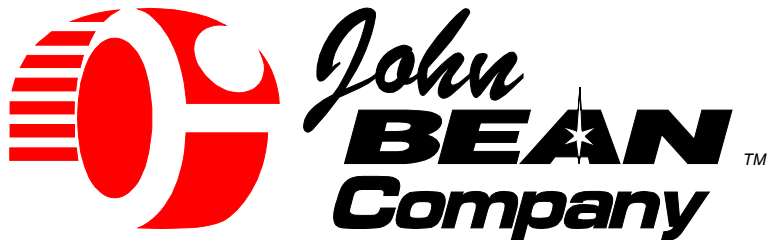
Ref #	Part No	Description
1	1016885	Slow Pulley, Worm Shaft
1A	1016887	Fast Pulley, Worm Shaft
2	1103466	Soc. Setscrew 5/16-18x3/8"
3	1177440	Mac-It Screw 5/16-18x5/32"
4	1103441	Soc. Setscrew 1/4-20x3/8"
5	1006410	Motor Pivot Bar
6	1185430	3/4" Retaining Ring
7	7007630	Power Cord Strain Relief
8	999694	Power Cord PVC Tubing
9	90701	Motor Wire Assy., 3-wire
10	2511355	Power Cord Assembly
11	8027275	Rubber Grommet
12	1102566	Brass Ground Screw 1/2-20
13	1100241	Hsg Gnd Lockwasher 1/4"
14	1187949	Motor Gnd L'washer #10 INT
15	1177216	Self-tap Gnd Screw #10-32
16	2511343	Drive Belt Guard
*	90187	Nyliner Bearing
*	90247	Fuse Label (ENG/FR)
*	90248	Caution Label (ENG/FR)
*	80322	UL Warning Label
*	90022	Motor Stud Retainer
17	8027203	Plastic Belt Guard Spacer
18	1107381	Washer 1/4"
19	1121549	Hex Jam Nut 1/4-20
20	1247425	Belt Guard Torsion Spring
21	1100805	HHC Screw 1/4-20x3/4"
22	1016819	Belt Guard Pivot Shaft
23	1177625	Roll Pin 1/8x3/4"
24	1118799	3/8" Retaining Ring
25	8027227	21" Drive Belt
26	1016886	Motor Shaft Fast Pulley
26A	1016882	Motor Shaft Slow Pulley
27	2006850	Motor Mount
28	1100045	HHC Screw 5/16-18x1"
29	1107382	5/16" Plain Washer
30	1100242	5/16" Lockwasher
31	1182563	5/16-18 Hex Nut
32	1110023	5/16-18 Wing Nut
33	6001100	Tension Compression Spring
34	1006420	5/16-18 Tension Adj. Stud
35	35148	Strain Relief (Motor Wire)
36	90193	115/230V Motor, 50/60Hz
*	90187	Nyliner Bearing (Motor)
*	80280	CSA Label

* Not Shown

Figure 4
Rotor Truer Assembly - 91395



Ref. No.	Qty. Used	Part Number	Description	Ref. No.	Qty. Used	Part Number	Description
1	1	08027322000	Support, Tool Bar	16	1	01111615000	Screw, Hex, 3/8-16x3 1/2
2	1	00091390000	Stud - Tool Bar, LH	17	2	01103490000	Screw, Set
3	1	00091391000	Stud - Tool Bar, RH				3/8 - 16 x .38 CP PT
4	1	00091385000	Tool Bar - LH	18	1	01100256000	Washer - Flat, 3/8
5	1	00091384000	Tool Bar - RH	19	2	01121509000	Nut - Hex
6	1	08027124000	Block - Striker				3/8-16 UNC-2B CAD/ZN
7	1	00091379000	Plate - Pointer	20	4	01101892000	Screw - Set
8	1	00091381000	Handle - RH				5/16 - 18 X 7/8 SQ HD
9	1	00091382000	Handle - LH	21	2	00091380000	Spring - Compression
10	1	00090711000	Spacer	22	1	06002488000	Spring
			1.75Ox.516IDx1.56L	23	2	01118669000	Screw - Drive
11	4	01112790000	Screw, Set				#10 x 1/2 RD HD Z
			1/4 - 20 X 3/8 HS	24	2	01016776000	Screw - Micrometer
12	4	00090746000	Insert	25	2	06002486000	Washer - Wave
			Nylon Torlon #4301	26	2	01016774000	DIAL - Micrometer
13	2	01101310000	Washer - Flat	27	2	08000360000	Washer - Nylatron GS
14	4	01100243000	Washer, 3/8 Lock Spg	28	2	01016775000	Knob - Micrometer
15	1	01111614000	Screw	29	1	00090495000	Cutter - With tri-tip, LH
			HHCS, 3/8-16 x 3 ZN	30	1	00090494000	Cutter - With tri-tip, RH



USA

John Bean Company
309 Exchange Avenue
Conway, Arkansas 72032
Tel.: (800) 362-8326 or (501) 450-1500
Fax: (501) 450-1585

FRANCE

John Bean Company
Snap-On Equipment France
Z.A. Du Vert Galant
15, rue de la Guivernone
BP 7175
95310 Saint Ouen L'Aumone
Tel: (33) 1-3448-5878
Fax: (33) 1-3448-5879

IRELAND

Snap-On Equipment Europe Ltd.
Bay 99
Industrial Estate,
Shannon
Co. Claire, Ireland
Tel: (353) 6147-1300
Fax: (353) 6147-2556

CANADA

John Bean Company
6500 Millcreek Drive
Mississauga, Ontario
Canada L5N 2W6
Tel: (905) 814-0114
Fax: (905) 814-0110

GERMANY

John Bean Auto Service Gerate
Division to Sun Electric Deutschland GmbH
Gewerbepark Sinn
D-35764 Sinn Herborner Str. 7-9
Tel: (49) 2772-9404-0
Fax: (49) 2772-94042-23

LATIN AMERICA

Rua Apinages
1268 cj. 605B
Perdizes-Sao Paulo-S.P.
Cep: 05017-0000
Brazil
Tel: (55) 11-871-0713
Fax: (55) 11-871-0713

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