



# PARTS MANUAL



## METAL LATHE MODEL: PL-1860

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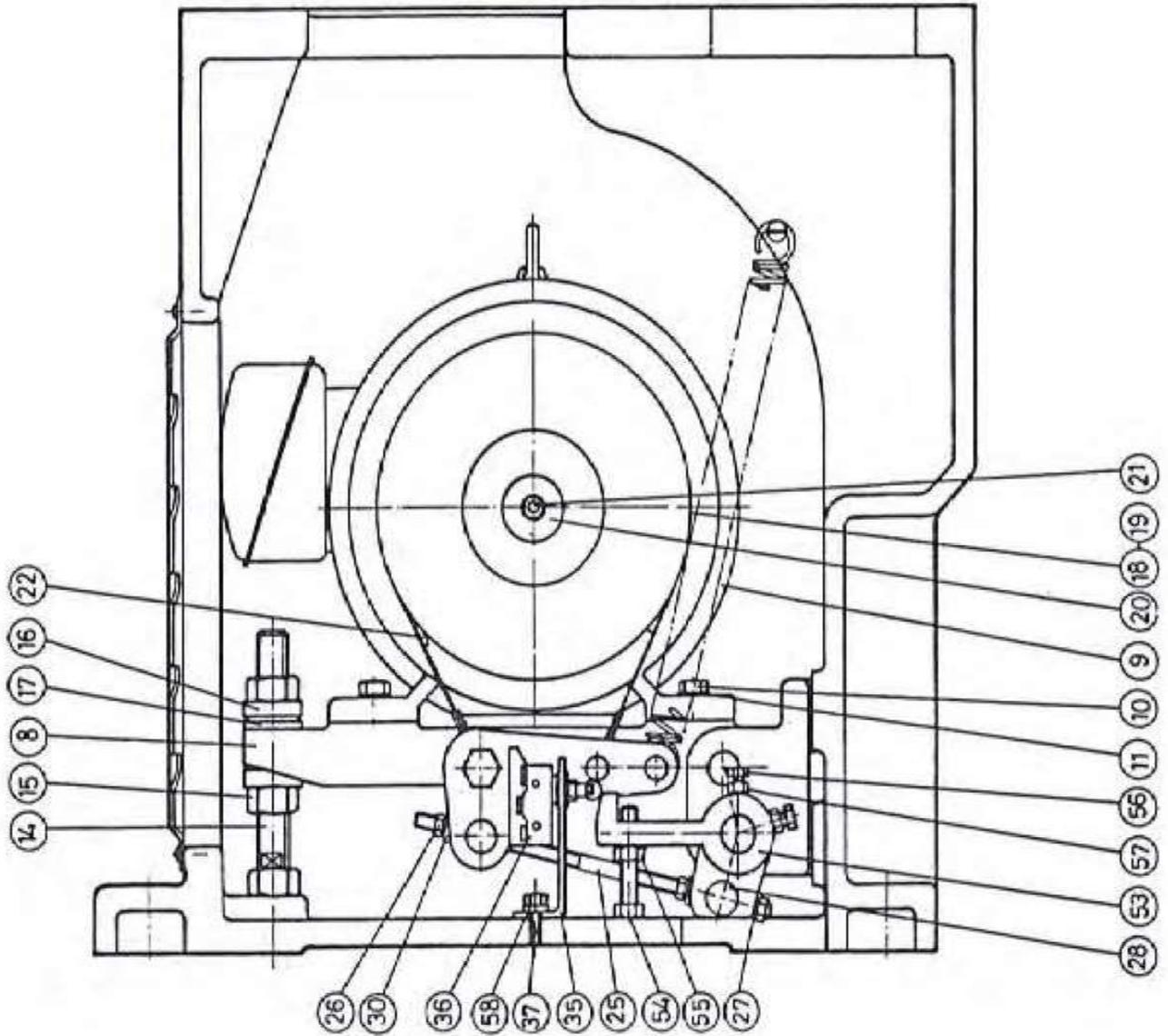


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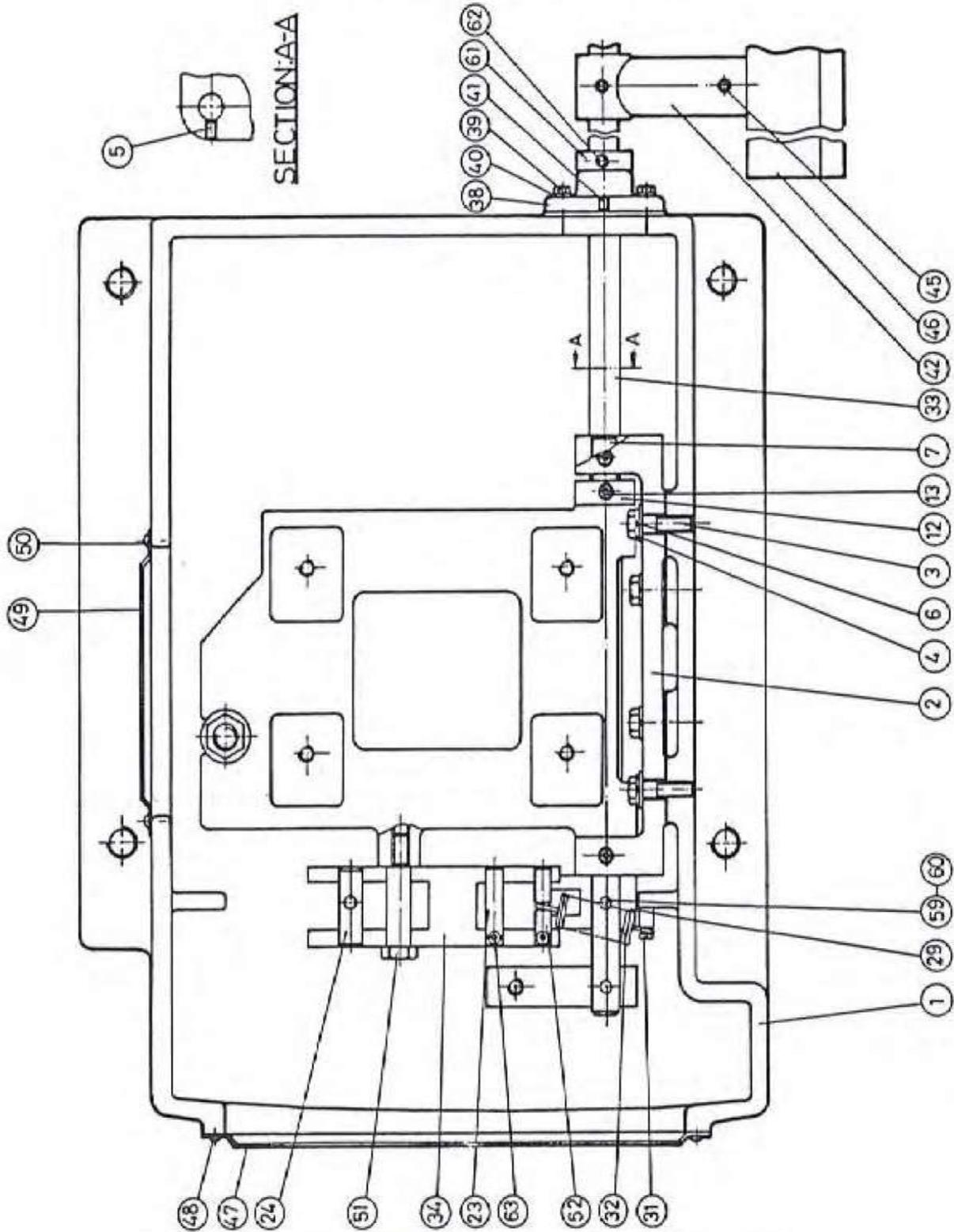


BED ASSEMBLY (BRAKE UNIT) 1/2





**BED ASSEMBLY (BRAKE UNIT) 2/2**





## BED ASSEMBLY (BRAKE UNIT) IDENTIFICATION

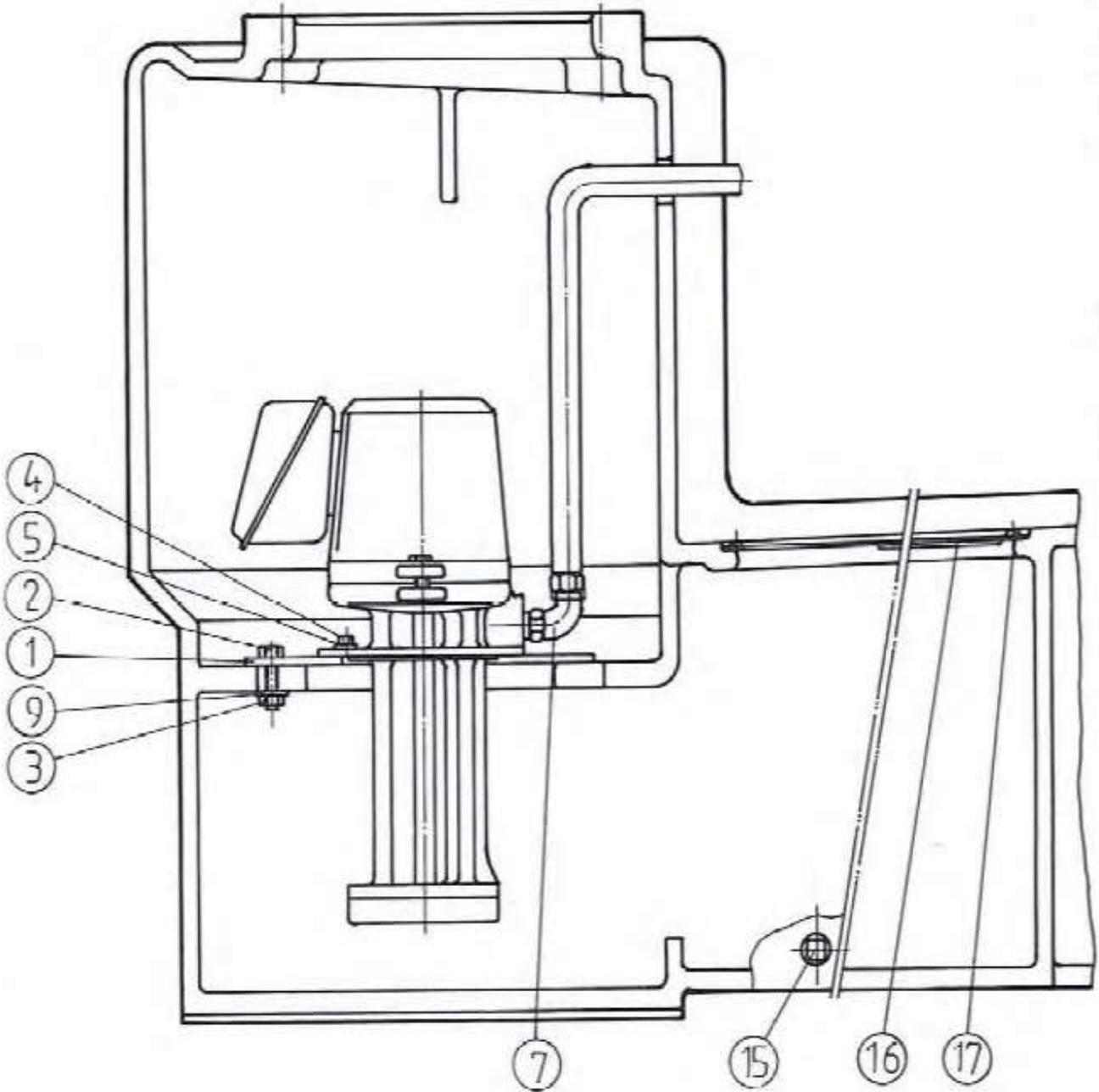
No.	Part No.	Name	Specification	Qty.
1	60-0674A-00	Base		1
2	50-0676-00	Motor Plate Bracket		1
3	SW01M12X45	Hexagon Head Screw	M12xP1.75x45L	4
4	WR03M12	Spring Washer	M12	4
5	SW14M8X16	Socket Head Set Screw	M8xP1.25x16L	2
7	50-0677-00	Shaft		1
8	62-0678-00	Motor Plate 7 ½ Hp		1
9	IM1236220440	Motor 7 ½ Hp	3Ph, 4P, 220/440	1
10	SW01M10X35	Hexagon Head Screw	M10xP1.5x35L	4
11	WR01M10	Flat Washer	M10	4
12	50-0679-00	Collar		1
13	SW14M8X16	Socket Head Set Screw	M8xP1.25x16L	1
14	50-0680-00	Stud Bolt		1
15	NT01M20	Hexagon Nut	M20XP2.5	3
16	50-0681-01	Spherical Washer	Concave	2
17	50-0682-00	Spherical Washer	Convex	2
18	60-0684-00	Motor Pulley	60Hz	1
19	BT01B77	V-Belt (Matched Set)	B-77 (60Hz)	3
20	50-0685-00	Washer		1
21	SW01M12X50	Hexagon Head Screw	M12xP1.75x50L	1
22	50-0686-00	Brake Band	7 ½ Hp	1
23	50-0687-01	Pin		1
24	50-0688-01	Axle		1
25	50-0689-01	Connecting Rod		1
26	NT01M8	Hexagon Nut	M8xP1.25	1
27	WR03M8	Spring Washer	M8	4
28	50-0690-00	Axle		1
29	50-0691-00	Rocking Arm		1
30	50-0692-00	Spacer		4
31	50-0693-00	Set Screw		1
32	50-0694-00	Extension Spring		1
33	60-0695A-00	Bracket Shaft		1
34	50-0697-00	Rocking Arm		1



No.	Part No.	Name	Specification	Qty.
35	50-0698-00	Support Plate		1
36	LSTM1308	Limit Switch	LS2, 15A, 125V	2
37	SW01M8X16	Hexagon Head Screw	M6xP1.0x16L	2
38	50-0699-00	Bracket		2
39	SW01M8X25	Hexagon Head Screw	M8xP1.25x25L	8
40	WR01M8	Flat Washer	M8	8
41	SW14M8X10	Socket Head Set Screw	M8xP1.25x10L	6
42	50-06100-00	Brake Arm		2
45	PN03Ø6X40	Spring Pin	Ø6x40L	4
46	60-06101A-00	Brake Pedal		1
47	50-06113-00	Side Cover		1
48	SW04M6X8	Cross Recessed Head Screw	M6xP1.0x8L	4
49	50-06114-00	Rear Cover		1
50	SW04M6X8	Cross Recessed Head Screw	M6xP1.0x8L	4
51	50-06128-00	Support Bolt		1
52	50-06129-01	Pin		1
53	50-06131-00	Position Arm		1
54	SW01M12X50	Hexagon Head Screw	M12xP1.75x50L	1
55	NT01M12	Hexagon Nut	M12xP1.75	1
56	SW01M8X25	Hexagon Head Screw	M8xP1.25x25L	2
57	NT01M8	Hexagon Nut	M8	1
58	11-0418-00	Washer		1
59	50-06133-00	Taper Pin w/External Thread		1
60	NT01M6	Hexagon Nut	M6xP1.0	1
61	50-06134-00	Collar		1
62	SW14M8X10	Socket Head Set Screw	M8xP1.25x10L	1
63	SW02M6X12	Socket Head Cap Screw	M6xP1.0x12L	2

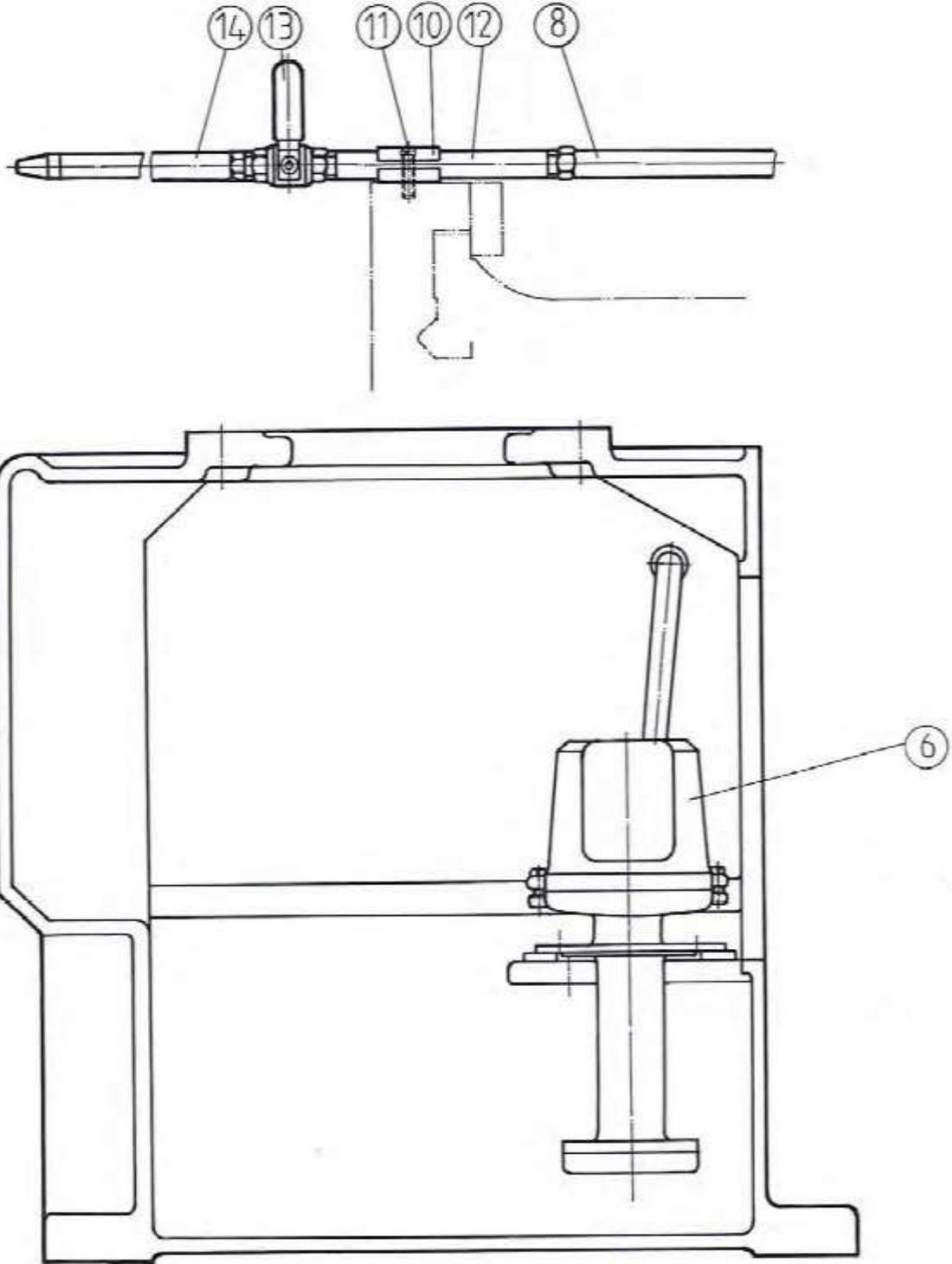


**BED ASSEMBLY (COOLANT SYSTEM) 1/2**





**BED ASSEMBLY (COOLANT SYSTEM) 2/2**



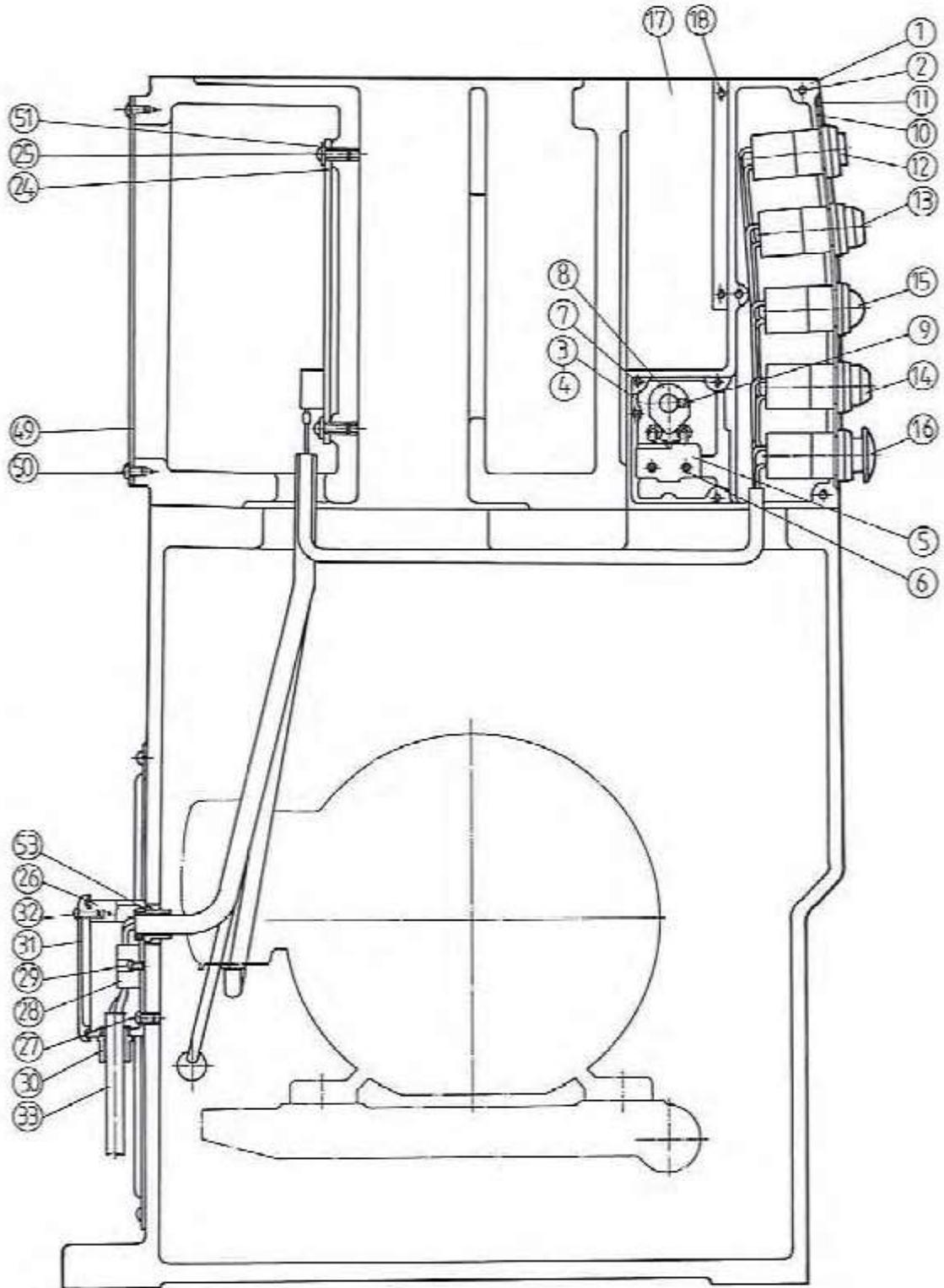


## **BED ASSEMBLY (COOLANT SYSTEM) IDENTIFICATION**

No.	Part No.	Name	Specification	Qty.
1	50-06109-00	Pump Plate		1
2	SW01M8X30L	Hexagon Head Screw	M8xP1.25x30L	2
3	NT01M8	Hexagon Nut	M8	2
4	SW01M6X16L	Hexagon Head Screw	M6xP1.0x16L	4
5	WR03M6	Spring Washer	M6	4
6	CP0130220380C	Cooling Pump 1/8 Hp, 220/380V	3Ph,2P,50/60 Hz	1
7	50-06109-00-1	90° Elbow	PT 3/8xPT 3/8	1
8	50-06109-00-2	Flexible Tube	3/8" x 12"L	1
9	17-0306-00	Washer		2
10	17-0746-00	Bracket		1
11	SW02M6X30	Socket Head Cap Screw	M6xP1.0x30L	2
12	17-0746-00-1	Connecting Pipe	3/8" x 18"L	1
13	17-0746-00-2	Manual Valve	3/8"	1
14	17-0746-00-3	Flexible Jet Tube	3/8" x 14"L	1
15	17-0746-00-4	Drain Plug	PT 3/8"	1
16	15-06143-00	Filter Plate		1
17	SW04M6X8	Cross Recessed Head Screw	M6xP1.0x8L	4

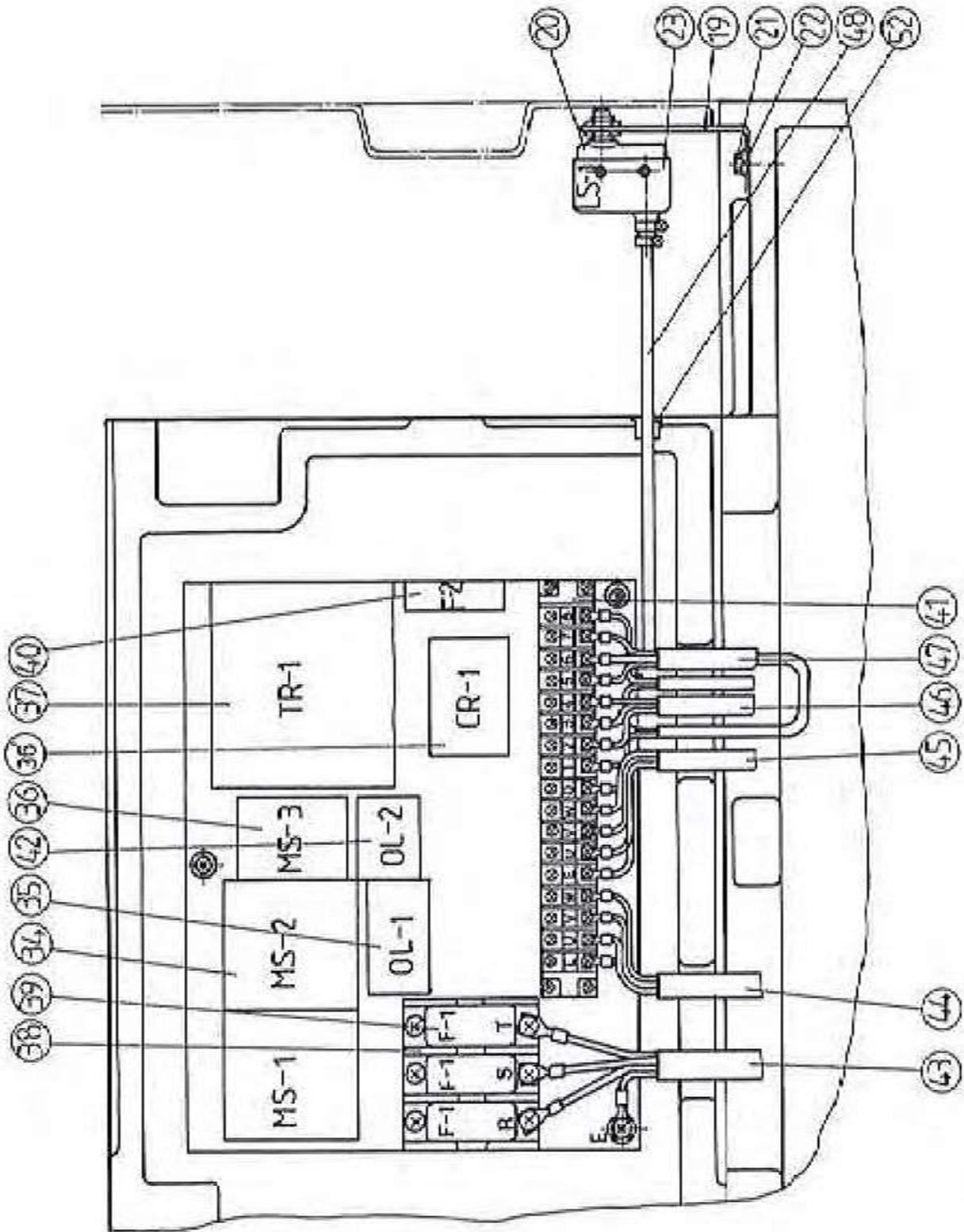


**BED ASSEMBLY (ELECTRICAL SECTION) 1/2**





**BED ASSEMBLY (ELECTRICAL SECTION) 2/2**





## BED ASSEMBLY (ELECTRICAL) IDENTIFICATION

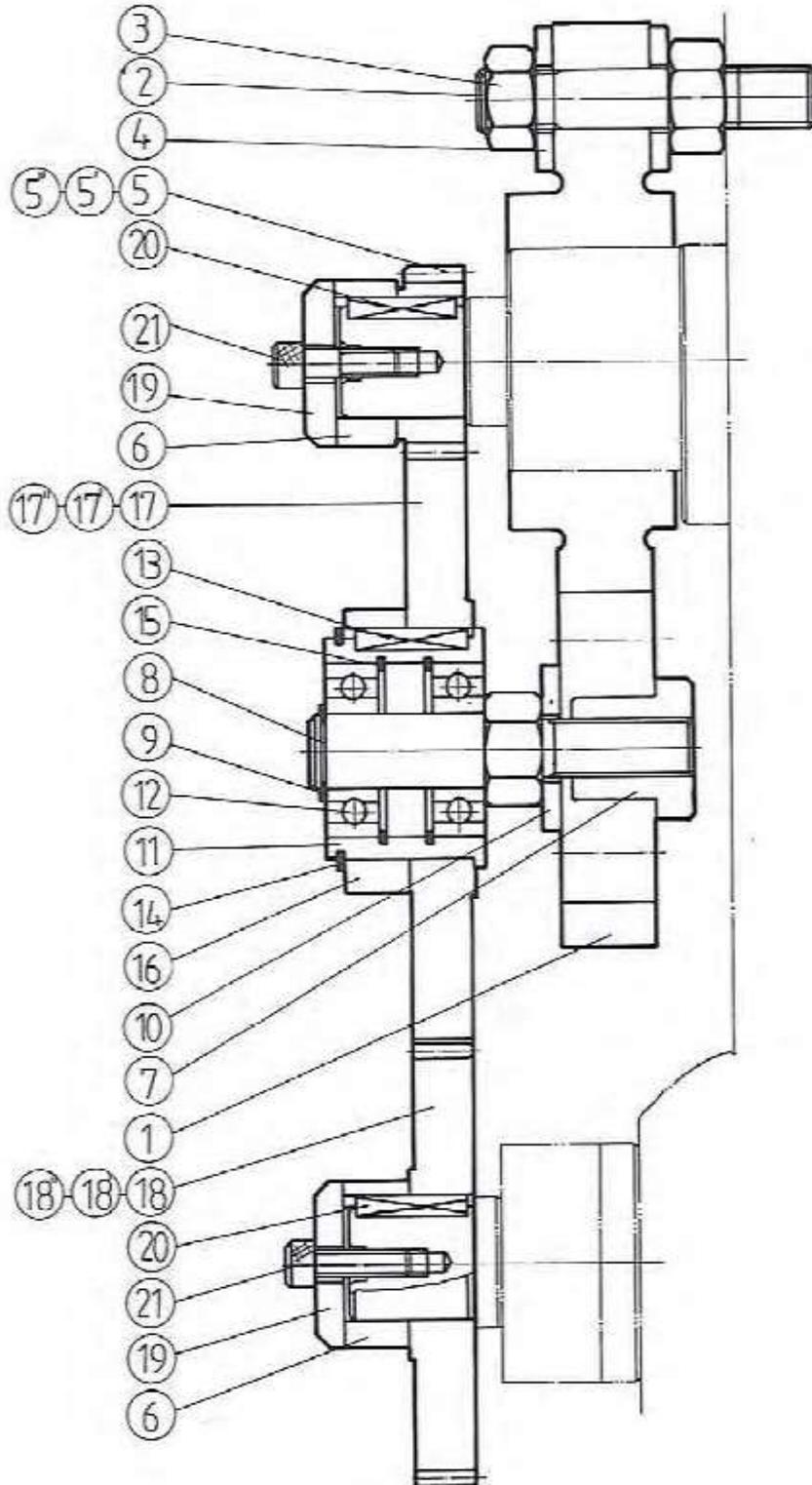
No.	Part No.	Name	Specification	Qty.
1	62-0626-00	Switch Box		1
2	SW02M6X75	Socket Head Cap Screw	M6xP1.0x75L	3
3	50-0627-00	Packing		1
4	60-0628-00	Switch Cover		1
5	LSTM1704	Micro Switch LS-3/LS-4	15A, 125VAC	2
6	SW04M4X40	Cross Recessed Head Screw	M4xP0.7x40L	2
7	SW02M5X12	Socket Head Cap Screw	M5xP0.8x12L	3
8	17-0697-00	Cam		1
9	SW15M5X8	Socket Head Set Screw	M5xP0.8x8L	2
10	62-0629-00	Operation Panel		1
11	SW04M4X8	Cross Recessed Head Screw	M4xP0.7x8L	6
12	PB0330G1A	Inching Switch (PB-1)	6A,250V,Ø30	1
13	CS0130R1A	On/Off Switch (CS-1)	6A,250V	1
14	CS0130G1A	Coolant Pump Switch (CS-2)	6A,250V,Ø30	1
15	PL0130W110V	Pilot Lamp	18V,24W,Ø30	1
16	PB0130R1A1B	E-Stop Button (PB-2)	10A,250V,Ø30	1
17	60-0630-00	Side Plate		1
18	SW04M5X8	Cross Recessed Head Screw	M5xP0.8x8L	4
19	50-0698-00	Support Plate		1
20	LSTM1308	Limit Switch (LS-1)	15A,125VAC	1
21	SW01M6X12	Hexagon Head Screw	M6xP1.0x12L	2
22	WR01M6	Flat Washer	M6	2
23	50-0608-00-1	Protective Covering		1
24	50-06117-00	Switch Gear Plate		1
25	SW04M6X16	Cross Recessed Head Screw	M6xP1.0x16L	3
26	11-0773-00	Junction Box		1
27	SW04M6X12	Cross Recessed Head Screw	M6xP1.0x12L	2
28	TB014P50A	Terminal Blocks (TB-4P)	50A,600V	1
29	SW04M4X10	Cross Recessed Head Screw	M4xPo.7x10L	2
30	11-0711	Socket		1
31	16-0812	Cover		1
32	SW04M6X20	Cross Recessed Head Screw	M6xP1.0x20L	1
33	16-0812-1	Power Cable (Outside)	3.5mmx4 cores	1



No.	Part No.	Name	Specification	Qty.
34	MS01C-25G	Magnetic Contactor MS-1/MS-2	50A,110V	2
35	OL01RH-18/26	Thermal Relay (OL-1,RH-18/26)	21-34A,220V	1
36	MS01C-11G	Magnetic Contactor (MS-3)	20A,110V	2
36'	MS01C-11G	Control Relay (CR-1)	20A,110V	1
37	TRVA1503220/24	Control Cir. Transformer (T-1)	VA-150	1
38	FH013P50A	Fuse Base	50A,600V	1
39	FS0250A	Listed Fuse (F-1)	50A,220V	3
40	FS015A	Circuit Fuse	5A	1
41	TB0217P	Terminal Blocks (TB-17)	20A,600V	1
42	OL02RH-10E/0.55	Thermal Relay (OL-2)	.43-.67A,110V	1
43	50-06117-00-10	Power Cable (Inside)	3.5mmx4 cores	1
44	50-06117-00-11	Cable (To Motor)	3.5mmx4 cores	1
45	50-06117-00-12	Cable (To Pump)	1.25mmx4 cores	1
46	50-06117-00-13	Control Cable	.75mmx4 cores	1
47	50-06117-00-14	Control Cable	.75mmx4 cores	1
48	50-06117-00-15	Control Cable	.75mmx2 cores	1
49	60-06118-00	Switch Gear Cover		1
50	SW04M6X10	Cross Recessed Head Screw	M6xP1.0x10L	6
51	WR01M6	Flat Washer	M6	3
52	50-06147A-00	Guide Bushing	SB-13	4
53	50-06147C-00	Guide Bushing	SB-22	1

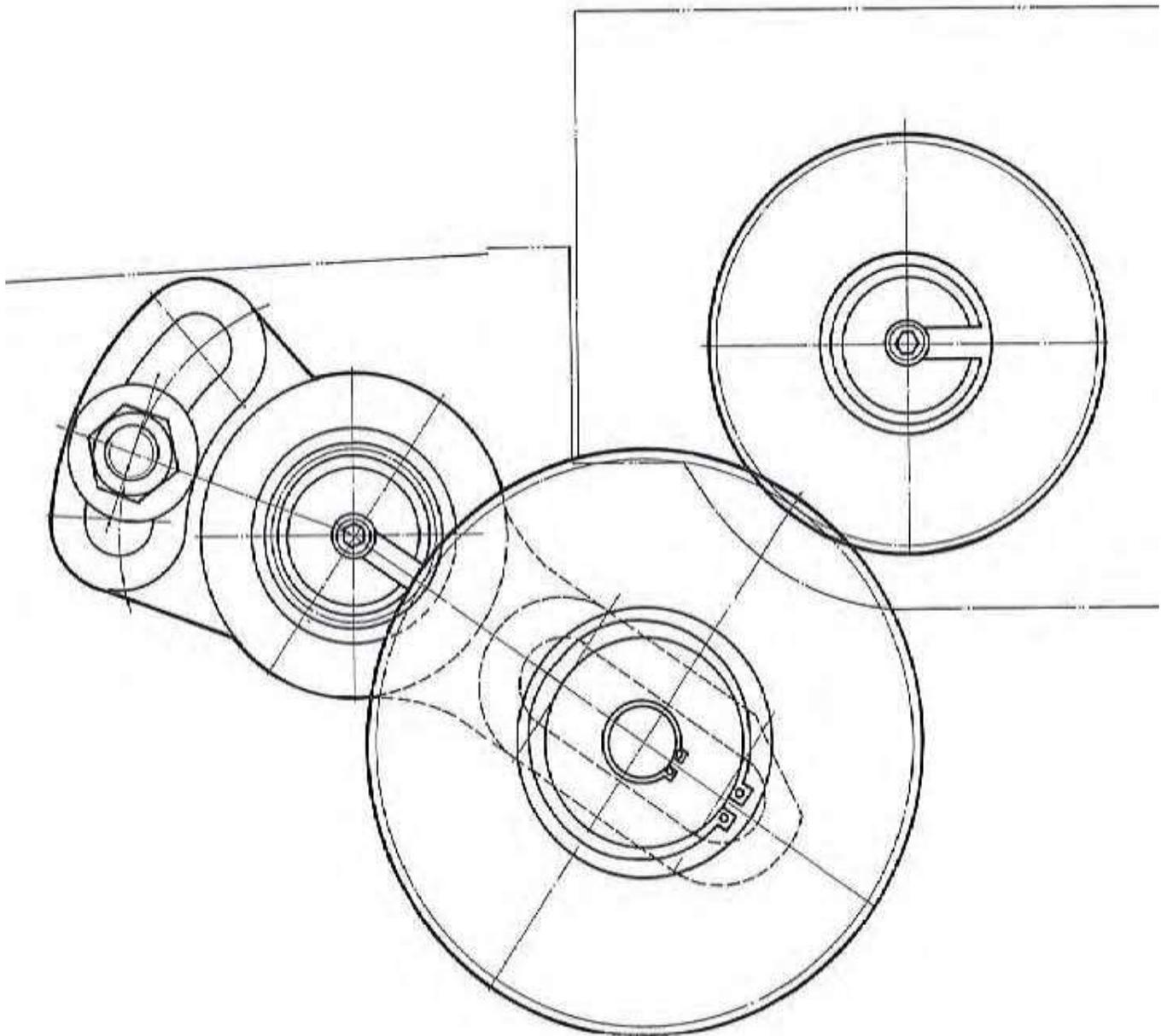


**CHANGE GEARS (IMPERIAL LEADSCREW) 1/2**





CHANGE GEARS (IMPERIAL LEADSCREW) 2/2





## CHANGE GEARS (IMPERIAL LEADSCREW) IDENTIFICATION

No.	Part No.	Name	Specification	Qty.
1	60-0603-00	Swing Frame		1
2	50-0604-00	Clamping Bolt		1
3	NT01M16	Hexagon Nut	M16xP2.0	1
4	50-0605-00	Washer		1
5	60-0607-00	Gear	M2.0x24T	1
5'	60-0617-00	Gear	M2.0x41T	1
6	50-0611-00	Spacer Collar		2
7	50-0612-00	Clamping Nut		1
8	50-0613-00	Idle Axle		1
9	RR01STW20	Retaining Ring (External)	STW#20	1
10	50-0614-00	Washer		1
11	50-0615-00	Change Gear Bearing Housing		1
12	RB6204	Deep Groove Ball Bearing	#6204	2
13	KY036X6X30	Double Round Head Key	6x6x30L	1
14	RR01STW60	Retaining Ring (External)	STW#60	1
15	RR07RTW47	Retaining Ring (Internal)	RTW#47	2
16	60-0609-00	Spacer		1
17	60-0621-00	Gear	M2.0x64T	1
18	50-0622-00	Gear	M2.0x31T	1
18'	50-0616-00	Gear	M2.0x31T	1
19	50-0207-00	Washer		2
20	KY036X6X30	Double Round Head Key	6x6x30L	2
21	SW02M8X30	Socket Head Cap Screw	M8xP1.25x30L	2



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