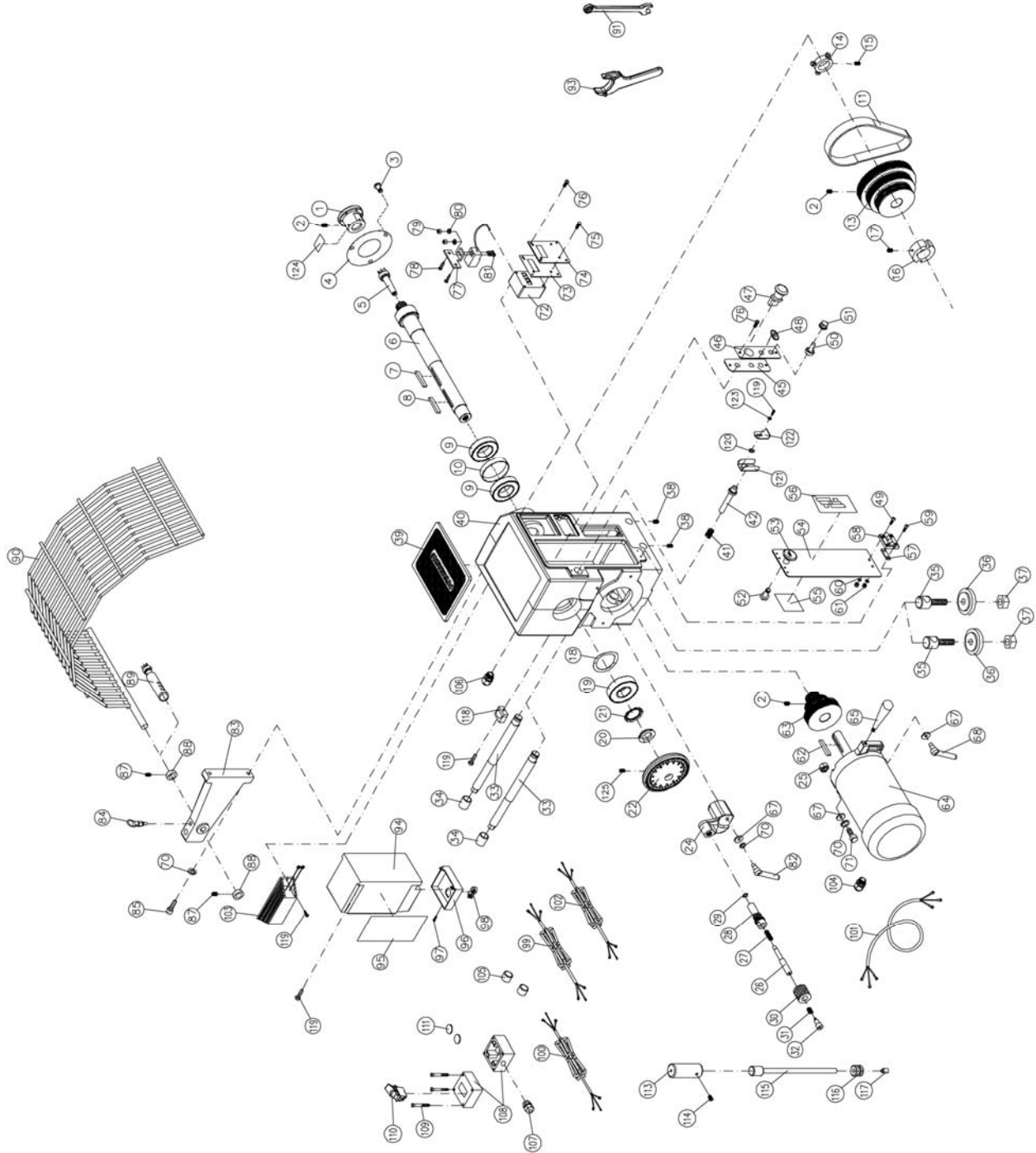


17.1.1 Headstock Assembly – Exploded View



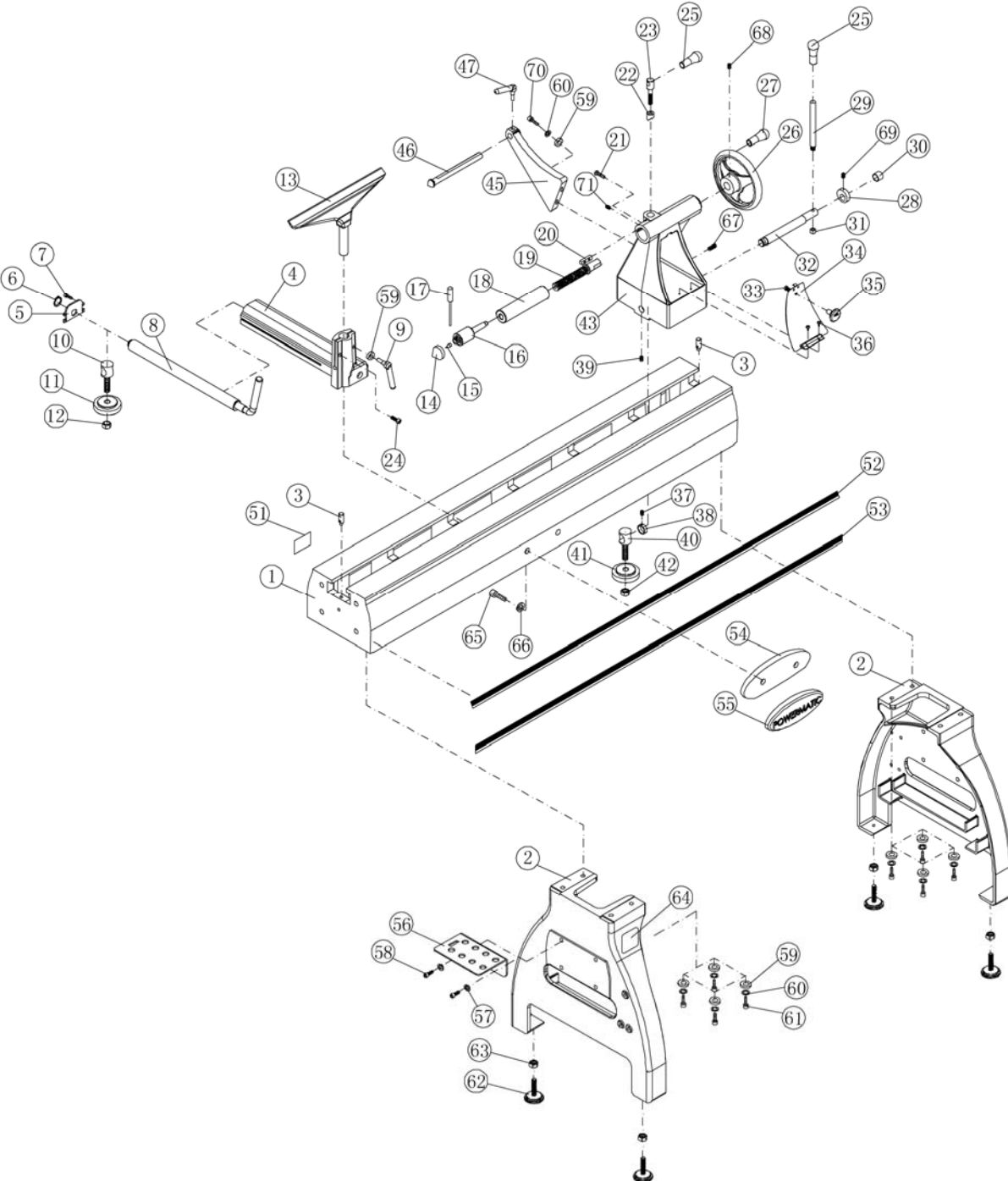
17.1.2 Headstock Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	6294736	Faceplate with set screws	3"	1
2	6295796	Nylon Insert Socket Set Screw	1/4-20 x 3/8"	6
3	TS-0253031	Socket Head Button Screw	#10-24 x 1/2"	3
4	6295799	Front Plate		1
5	6294725	Spur Center	MT2	1
6	4224B-106	Spindle		1
7	4224B-107	Key	6 x 6 x 90 mm	1
8	4224B-108	Key	6 x 6 x 35 mm	1
9	BB-6209ZZ	Ball Bearing	6209ZZ	2
10	4224B-110	Spacer		1
11	4224B-111	Belt	290J	1
13	4224B-113	Spindle Pulley		1
14	4224B-114	RPM Sensor Collar		1
15	TS-0270031	Set Screw	5/16"-18 x 3/8"	2
16	4224B-116	Spindle Lock Collar		1
17	TS-0267021	Set Screw	1/4"-20 x 1/4"	2
18	4224B-118	Wave Washer		1
19	BB-6308ZZ	Ball Bearing	6308ZZ	1
20	4224B-120	Spanner Nut		1
21	4224B-121	Spanner Lock Washer		1
22	4224B-122	Handwheel		1
24	4224B-123	Index Bracket		1
25	TS-0640091	Nylon Nut	3/8"-16	1
	4224B-IPA	Index Pin Assembly (includes #26 thru 32)		1
26	4224B-126	Index Pin		1
27	6295822	Spring		1
28	6295817	Index Bushing		1
29	4224B-129	C-Ring	S-8	1
30	6295819	Knurled Locking Knob		1
31	6295820	Spring		1
32	6295821	Hex Socket Bolt		1
33	4224B-133	Headstock Locking Cam		2
34	6095038	Bushing	7/8" x 1" x 7/8"	2
35	3058001	Clamp Bolt		2
36	4224B-136	Cam Locking Disc		2
37	6520009	Nylon Nut	5/8"-11	2
38	4224B-138	Set Screw	#10-24 x 1"	2
39	3520B-209	Headstock Mat		1
40	4224B-140	Headstock Main Casting		1
41	6813062	Spring		1
42	3601006	Spindle Lock Plunger		1
45	4224B-145	Control Panel Cover Plate		1
46	4224B-146	Control Panel Label		1
47	6295839	Push/Pull Switch		1
48	4224B-148	Switch Fwd/Rev		1
49	6708019	Socket Head Cap Screw	#8-32 x 5/8"	2
50	6295915	Potentiometer with wiring leads		1
51	6430047	Knob		1
52	TS-1490021	Hex Cap Screw	M8 x 16	1
53	6295717	Knob		1
54	4224B-154	Access Door		1
55	3520B-294	Warning Label – Belt Adjustment		1
56	4224B-156	Speed Label		1
57	6295911	Pad		1

Index No.	Part No.	Description	Size	Q'ty
58	6365012	Door Hinge		1
59	6710015	Socket Head Cap Screw	#10-24 x 1/2"	2
60	6860704	Lock Washer	#8	2
61	6508007	Nut	#8-32	2
62	6294761	Key	6 x 6 x 45 mm	1
63	4224B-163	Motor Pulley		1
64	4224B-164	Motor	3HP 3PH	1
65	4224B-165	Handle		1
67	TS-0680041	Flat Washer	3/8"	3
68	4224B-168	Lock Handle		1
70	TS-0720091	Lock Washer	3/8"	4
71	TS-0209091	Socket Head Cap Screw	3/8"-16 x 2"	1
72	JWL1642-130A	Digital Readout (DRO)		1
73	3520B-238	DRO Mounting Plate		1
74	3520B-239	DRO Cover Plate		1
75	JWL1642-127	Pan Head Self-Tapping Screw	M3 x 10	4
76	TS-0253031	Socket Head Button Screw	#10-24 x 1/2"	7
77	4224B-177	Bracket		1
78	JWL1642-134	Pan Head Self-Tapping Screw	1/4" x 1/2"	2
79	4224B-179	Nylon Nut	M3	2
80	TS-2361031	Lock Washer	M3	2
81	6295838	Phillips Round Head Machine Screw	M3 x 20	2
82	4224B-182	Lock Handle		1
83	4224B-183	Guard Bracket		1
84	6644005	Plunger		1
85	TS-0209061	Socket Head Cap Screw	3/8"-16 x 1-1/2"	2
87	TS-0270011	Set Screw	5/16"-18 x 1/4"	2
88	6143004	Retaining Collar		2
89	4224B-189	Spindle Comparator Spur Center		1
90	6294747	Guard		1
91	4224B-191	Combination Wrench	19mm	1
93	6294744	Face Plate Wrench	2"	1
94	4224B-194	Inverter		1
95	3520B-293	Inverter Caution Label		2
96	JWL1642-166	Bottom Cover		1
97	3520B-296	Phillips Pan Head Machine Screw	M3-0.5P x 10	3
98	JWL1642-165	Strain Relief	7N-2	3
99	4224B-199	Control Panel Cord		1
100	6295765	Remote Switch Cord		1
101	6294790	Motor Cord		1
102	6294787	Power Cord		1
103	JWL1642-169A	Braking Resistor		1
104	4224B-1104	Strain Relief for Motor	PG 13.5	1
105	3520B-295	Cord Snap Ring		2
106	4224B-1106	Strain Relief	M16	1
	6294733	Remote Switch Assembly (Includes #100, 107 thru 111)		1
107	6295766	Strain Relief		1
108	6295761	Remote Switch Box		1
109	4224B-1109	Tap Screw		4
110	6295760	Remote Switch		1
	6295760-1	Remote Switch Safety Key		1
111	4224B-1112	Magnet		2
	4224B-KRA	Knockout Rod Assembly (includes #113 thru 117)		1
113	3520B-288	Slide Hammer		1
114	TS-0267041	Set Screw	1/4"-20 x 3/8"	2
115	4224B-1115	Rod		1
116	3520B-291	Collar		1

Index No.	Part No.	Description	Size	Q'ty
117	3520B-292	Brass Tip		1
118	4224B-1118	Cord Holder		1
119	TS-0206031	Socket Head Cap Screw	#10-24 x 5/8"	7
120	4224B-143	Wave Washer		1
121	6294786	Spindle Lock Guard		1
122	4224B-1122	Spindle Lock Tab		1
123	TS-069204	Flat Washer	#10	1
124	4224B-1124	Warning Label, Faceplate		1
125	TS-1523031	Set Screw	M6 x 10	2

17.2.1 Bed and Leg Assembly – Exploded View



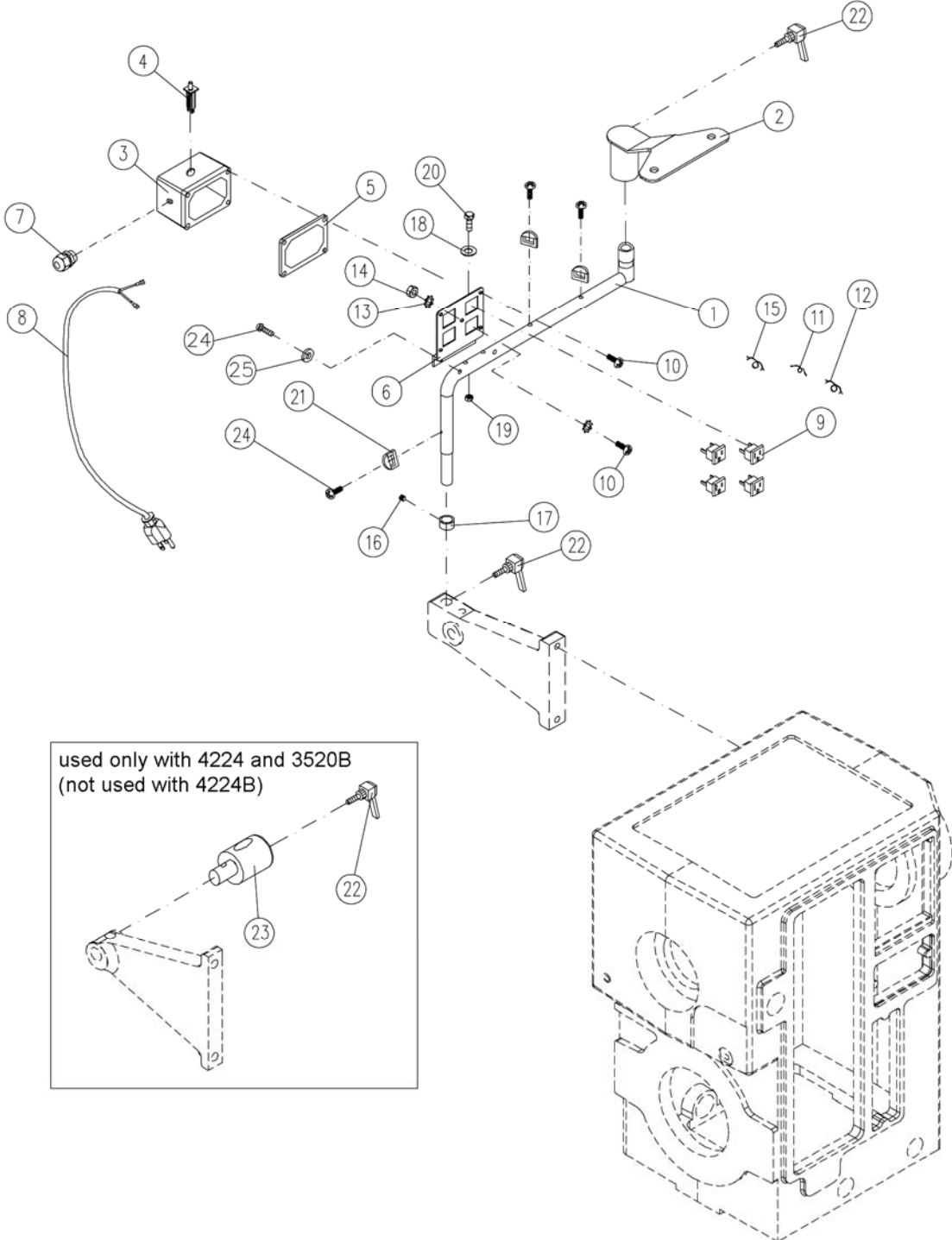
17.2.2 Bed and Leg Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	4224B-201	Bed		1
2	4224B-202	Leg		2
3	6295754	Stop Bolt		2
4	4224B-204	Tool Rest Base		1
5	3520B-105	End Cover		1
6	3520B-106	C-Ring	S-22	1
7	TS-0206021	Socket Head Cap Screw	#10-24 x 1/2"	4
8	4224B-208	Tool Support Cam		1
9	4224B-209	Lock Handle		1
10	3520B-110	Clamp Bolt		1
11	6294770	Cam Locking Disc		1
12	TS-0650081	Nylon Lock Hex Nut	3/4"-10	1
13	6294742	Tool Support	14"	1
	6295902	Live Center Assembly (includes #14 thru 17)		1
14	6295905	Live Center Cap		1
15	6295904	Live Center Tip		1
16	6295903	Live Center Body		1
17	6295906	Live Center Rod		1
18	4224B-218	Quill		1
19	4224B-219	Lead Screw		1
20	4224B-220	Key		1
21	TS-0253031	Socket Head Button Screw	#10-24 x 1/2"	2
22	3728005	Quill Lock Sleeve		1
23	4224B-223	Lock Bolt		1
24	TS-0209061	Socket Head Cap Screw	3/8"-16 x 1-1/4"	1
25	4224B-165	Lock Handle		2
26	4224B-226	Handwheel		1
27	3520B-126	Swivel Handle		1
28	4224B-228	Eccentric Collar		1
29	4224B-229	Rod		1
30	6095038	Bushing	7/8" x 1" x 7/8"	1
31	TS-0640091	Nylon Lock Nut	3/8"-16	1
32	4224B-232	Tailstock Eccentric Cam		1
33	TS-1490021	Hex Bolt	M8 x 16	1
34	3520B-134	Storage Cover Plate		1
35	6295717	Knob		1
36	TS-0253031	Socket Head Button Screw	#10-24 x 1/2"	2
37	TS-0270011	Set Screw	5/16"-18 x 1/4"	1
38	3096003	Collar		1
39	4224B-138	Set Screw	#10-24 x 1"	1
40	3058001	Clamp Bolt		1
41	4224B-136	Cam Locking Disc		1
42	6520009	Nylon Nut	5/8"-11	1
43	4224B-243	Tailstock Casting		1
45	4224B-245	Comparator Bracket		1
46	3520B-151	Comparator Dead Center		1
47	4224B-247	Lock Handle	3/8" x 1-1/4"	1
51	4224B-251	I.D. Label		1
52	3520B-157	Upper Stripe		2
53	3520B-158	Lower Stripe		2
54	3520B-154	Backer Plate		1
55	3520B-140	Powermatic Nameplate		1
56	4224B-256	Tool Caddy		1
57	TS-0720111	Lock Washer	1/2"	2
58	4224B-258	Socket Head Cap Screw	1/2"-12 x 1"	2

Index No.	Part No.	Description	Size	Q'ty
59	TS-0680041	Flat Washer	3/8"	11
60	TS-0720091	Lock Washer	3/8"	10
61	TS-0209071	Socket Head Cap Screw	3/8"-16 x 1-1/2"	8
62	4224B-262	Leveling Foot		4
63	4224B-263	Hex Nut	1/2"-12	4
64	6294773	Warning Label		1
65	TS-0207071	Socket Head Cap Screw	1/4"-20 x 1-1/4"	2
66	TS-0680021	Flat Washer	1/4"	2
67	4224B-267	Ball Plunger		1
68	TS-0270031	Set Screw	5/16"-18 x 3/8"	2
69	TS-0267021	Set Screw	1/4"-20 x 1/4"	1
70	TS-0209061	Socket Head Cap Screw	3/8"-16 x 1-1/4"	2
71	TS-0267041	Set Screw	1/4"-20 x 3/8"	1

.....	4224B-HP	Hardware Package (<i>includes all parts below</i>)		
.....	TS-0680041	Flat Washer	3/8"	10
.....	TS-0720091	Lock Washer	3/8"	12
.....	TS-0209071	Socket Head Cap Screw	3/8"-16 x 1-1/2"	10
.....	TS-0209061	Socket Head Cap Screw	3/8"-16 x 1-1/2"	2
.....	TS-0720111	Lock Washer	1/2"	2
.....	4224B-258	Socket Head Cap Screw	1/2"-12 x 1"	2

17.3.1 Lamp Holder Set – Exploded View



17.3.2 Lamp Holder Set – Parts List

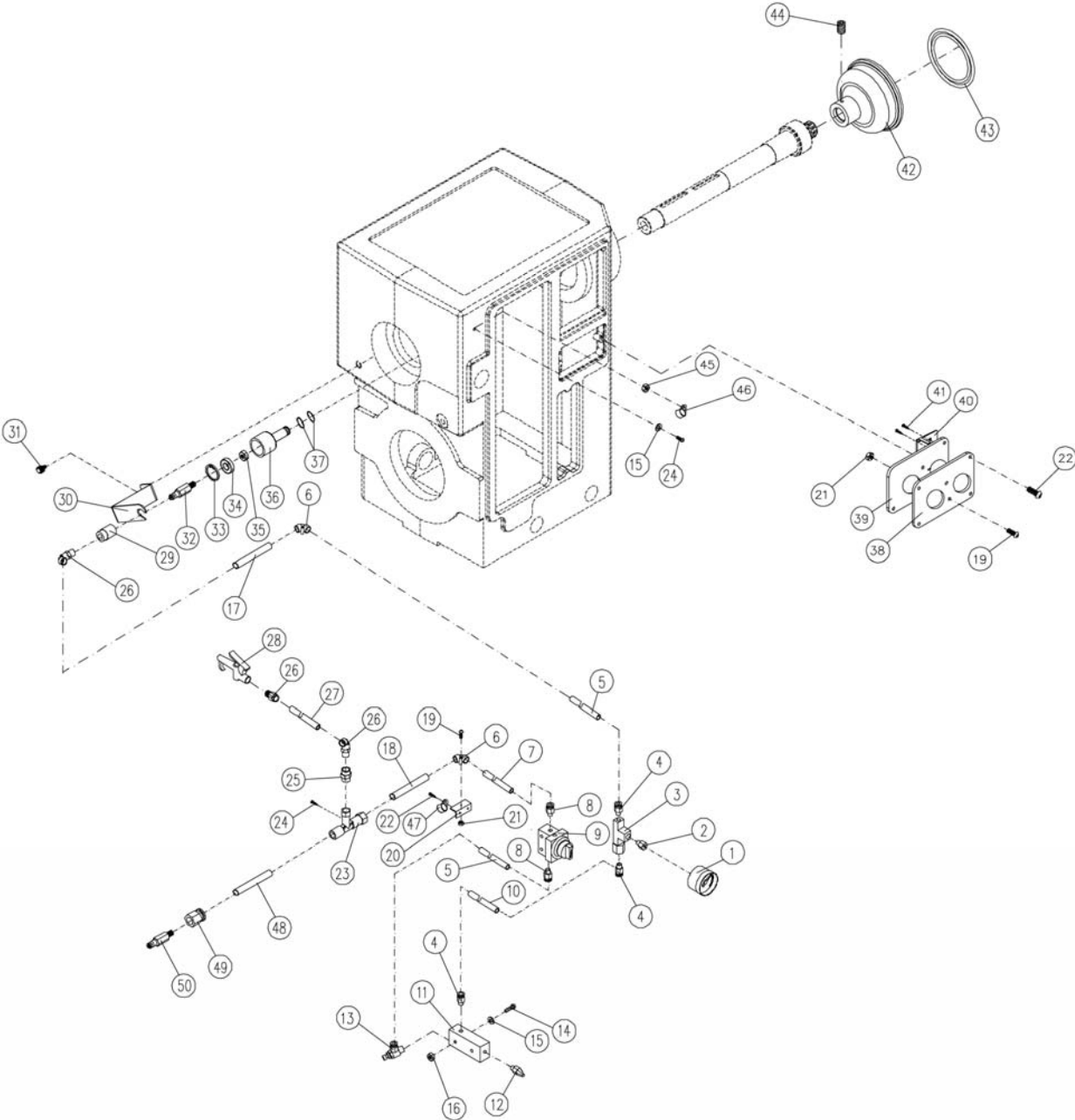
Index No	Part No	Description	Size	Qty
	6294901	Lamp Holder Set <i>(includes #1 thru 25)</i>		1
1	4224B-301	Support Tube		1
2	4224B-302	Lamp Holder		1
3	4224B-303	Junction Box		1
4	4224B-304	Current Overload Switch	15A	1
5	4224B-305	Gasket		1
6	4224B-306	Receptacle Cover Plate		1
7	4224B-307	Strain Relief	PG11	1
8	4224B-308	Power Cord	AWG14	1
9	4224B-309	Socket with Cover		4
10	TS-1533062	Phillips Pan Head Machine Screw	M5 x 20	5
11	4224B-311	Jumper (Black)		4
12	4224B-312	Jumper (White)		3
13	TS-0733041	Star Washer	M5	2
14	TS-1540031	Hex Nut	M5	2
15	4224B-315	Ground Jumper (Green)		4
16	TS-0270011	Set Screw	5/16"-18 x 1/4"	1
17	6143004	Retaining Collar		1
18	TS-1550031	Flat washer	M5	4
19	TS-1541011	Nylon Hex Nut	M5	2
20	TS-1481081	Hex Bolt	M5 x 35	2
21	4224B-321	Cord Restraint		3
22	JML-59A	Lock Handle		2
23	4224B-323	Holder Shaft		1
24	TS-0253031	Socket Head Button Screw	#10-24 x 1/2"	5
25	TS-069204	Flat Washer	#10	2

17.3.3 Lamp Kit – Parts List

Index No.	Part No.	Description	Size	Qty.
	6294901K	Lamp Kit <i>(includes #40-44)</i>		1
40	6294901	Lamp Holder Set <i>(includes #1 thru 25)</i>		1
41	6294902	Lamp (bulb not included) <i>(includes #42-44)</i>	100W	2
42	*	Stud	M51	2
43	*	Lock Washer, Internal tooth	3/8"	2
44	*	Jam Nut	3/8"	2

NOTE: Powermatic lamps are supplied by Moffatt. For replacement parts indicated by an asterisk (*), contact Moffatt directly at 800-346-0761.

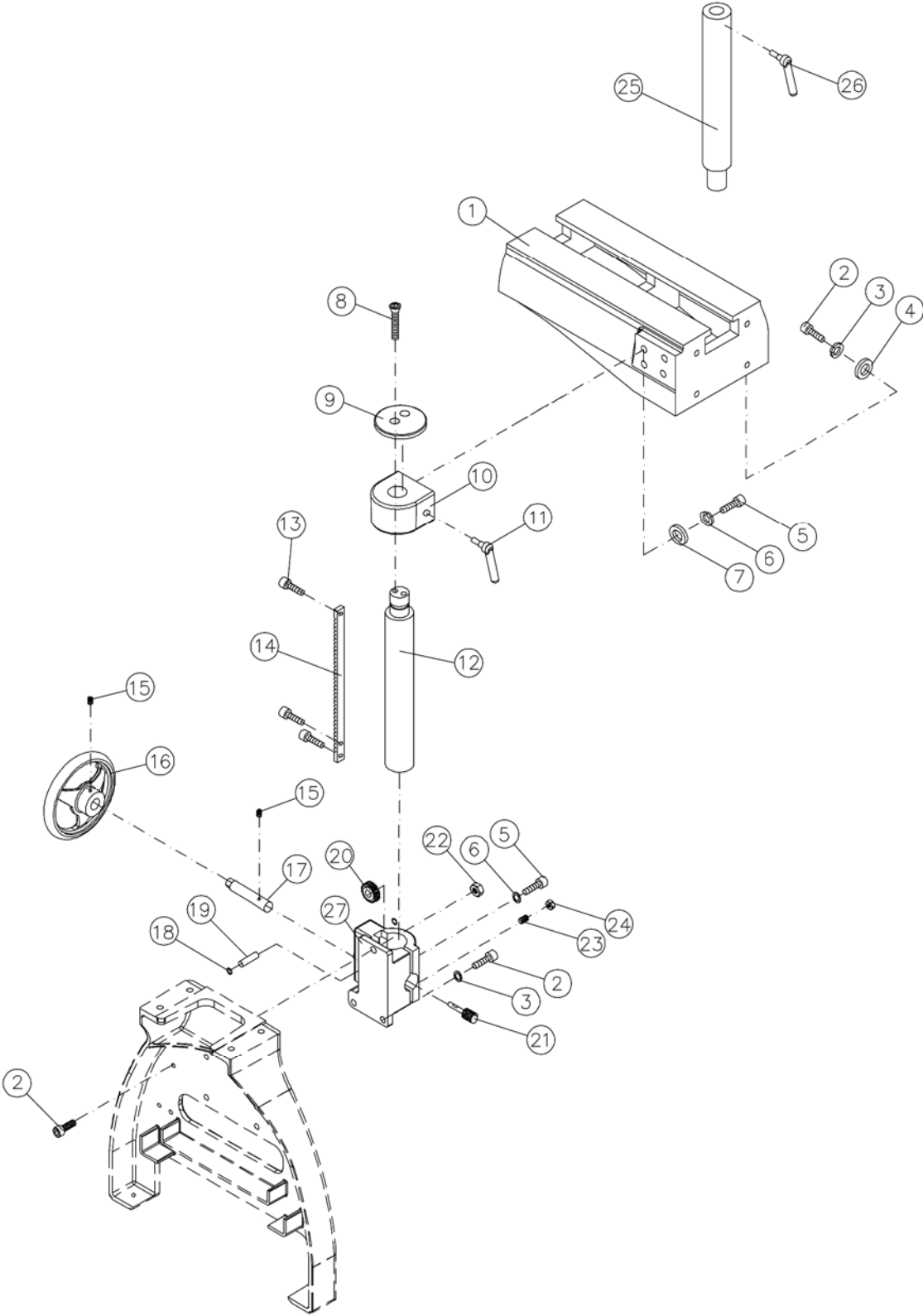
17.4.1 Vacuum System – Exploded View



17.4.2 Vacuum System – Parts List

Index No	Part No	Description	Size	Qty
1	4224B-401	Pressure Vacuum Gauge		1
2	4224B-402	Gauge Fitting		1
3	4224B-403	Tee Fitting		1
4	4224B-404	Quick Release Fitting	1/4" NPT	3
5	4224B-405	Air Line	350mm	2
6	4224B-406	Elbow Fitting		2
7	4224B-407	Air Line	390mm	1
8	4224B-408	Quick Release Fitting	1/8" NPT	2
9	4224B-409	Vacuum Switch		1
10	4224B-410	Air Line	230mm	1
11	4224B-411	Vacuum Generator		1
12	4224B-412	Silencer		1
13	4224B-413	Air Flow Regulator		1
14	4224B-414	Socket Head Button Screw	M4-0.7Px45	2
15	TS-1550021	Flat Washer	M4	3
16	TS-1541001	Nylon Nut	M4	2
17	4224B-417	Air Line	800mm	1
18	4224B-418	Air Line	110mm	1
19	4224B-419	Socket Head Button Screw	M3x20	3
20	4224B-420	Bracket		1
21	TS-1540011	Hex Nut	M3	3
22	TS-0253031	Socket Head Button Screw	#10-24x1/2"	6
23	4224B-423	Tee Fitting		1
24	4224B-424	Socket Head Button Screw	M4-0.7Px25	3
25	4224B-425	Union		1
26	4224B-426	Elbow Fitting	1/4" NPT	3
27	4224B-427	Air Line	3M	1
28	4224B-428	Air Blow Gun		1
29	4224B-429	Coupler	1/4" NPT	1
30	4224B-430	Support Bracket		1
31	4224B-431	Lock Knob		1
	4224B-VAA	Vacuum Adaptor Assembly (includes #32 thru 37)		1
32	4224B-432	Male Adaptor		1
33	4224B-433	C-Ring	R-32	1
34	BB-6201VV	Ball Bearing	6201VV	1
35	4224B-435	Nylon Nut	M12-1.75P	1
36	4224B-436	Vacuum Adaptor Body		1
37	4224B-437	O-Ring	O12	2
38	4224B-438	Vacuum Face Plate		1
39	4224B-439	Face Plate		1
40	4224B-440	Bracket		1
41	4224B-441	Pan Head Screw	M3x6	2
	4224B-VCA	Vacuum Chuck Assembly (includes #42 thru 44)		1
42	4224B-442	Vacuum Chuck		1
43	4224B-443	Seal		1
44	6295796	Nylon Insert Socket Set Screw	1/4-20x3/8"	2
45	TS-1540021	Hex Nut	M4	1
46	JWL1642-183	Air Line Clamp		1
47	4224B-447	Air Line Clamp		1
48	4224B-448	Air Line	600mm	1
	4224B-CFPS	Coupler Fitting Plug Set (includes #49 thru 50)		1
49	4224B-449	Female Straight Fitting		1
50	4224B-450	Coupler Fitting Plug, Male		1

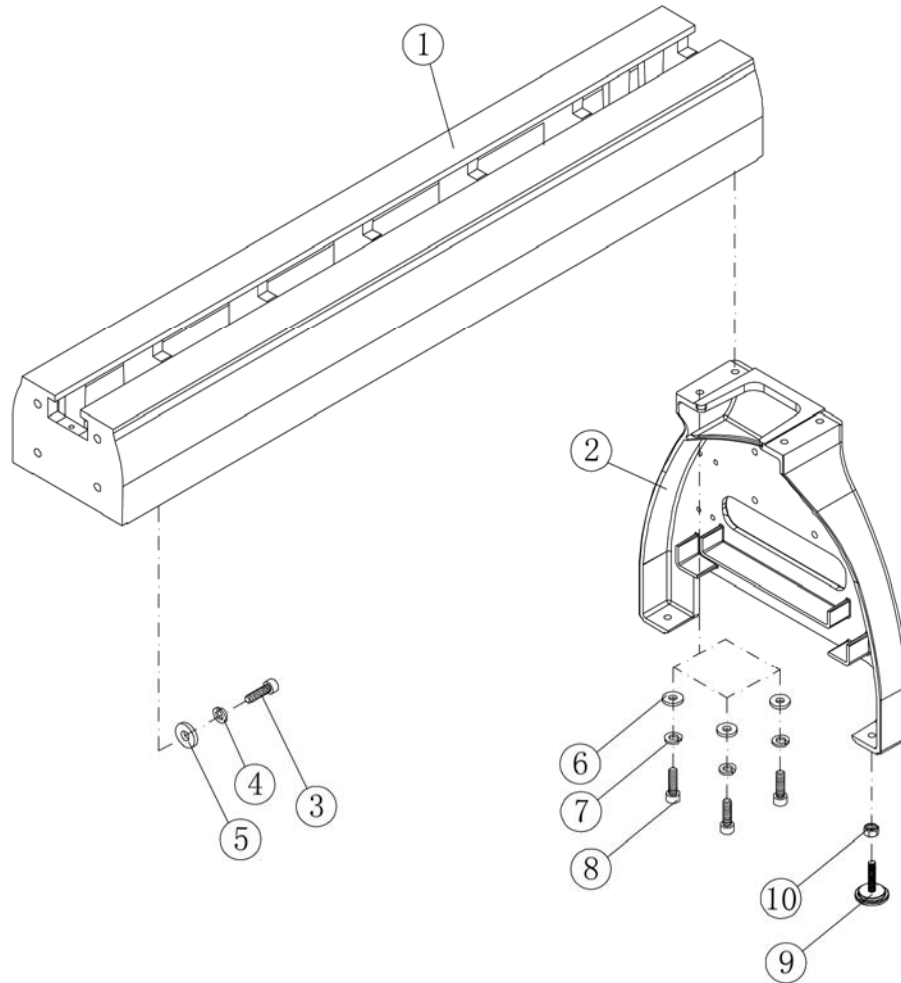
17.5.1 20-inch Extension Bed Kit (Optional Accessory) – Exploded View



17.5.2 20-inch Extension Bed Kit (Optional Accessory) – Parts List

Index No	Part No	Description	Size	Qty
	6294900	20" Extension Bed Kit (includes #1 thru 27)		1
1	6294905	20" Extension Bed with mounting hardware		1
2	4224B-502	Socket Head Cap Screw	1/2"-12x2"	7
3	TS-0720111	Lock Washer	1/2"	6
4	TS-0680061	Flat Washer	1/2"	4
5	TS-0209081	Socket Head Cap Screw	3/8"-16x1-3/4"	6
6	TS-0720091	Lock Washer	3/8"	6
7	TS-0680042	Flat Washer	3/8"	4
8	4224B-508	Socket Flat Head Screw	3/8"-16x1"	2
9	4224B-509	Top Plate		1
10	4224B-510	Pivot Bracket		1
11	4224B-209	Lock Handle		1
12	4224B-512	Column		1
13	TS-0209031	Socket Head Cap Screw	3/8"-16x3/4"	3
14	4224B-514	Rack		1
15	TS-0270031	Set Screw	5/16"-18x3/8"	4
16	4224B-226	Handwheel		1
17	4224B-517	Extension Shaft		1
18	4224B-518	C-Ring	S-12	2
19	4224B-519	Shaft		1
20	4224B-520	Gear		1
21	4224B-521	Worm		1
22	4224B-522	Nylon Nut	1/2"-12	1
23	TS-0271111	Set Screw	3/8"-16x1-1/2"	1
24	TS-0570031	Hex Nut	3/8"-16	1
25	6295853	Tool Rest Post		1
26	6294763	Lock Handle		2
27	4224B-527	Gear Base		1

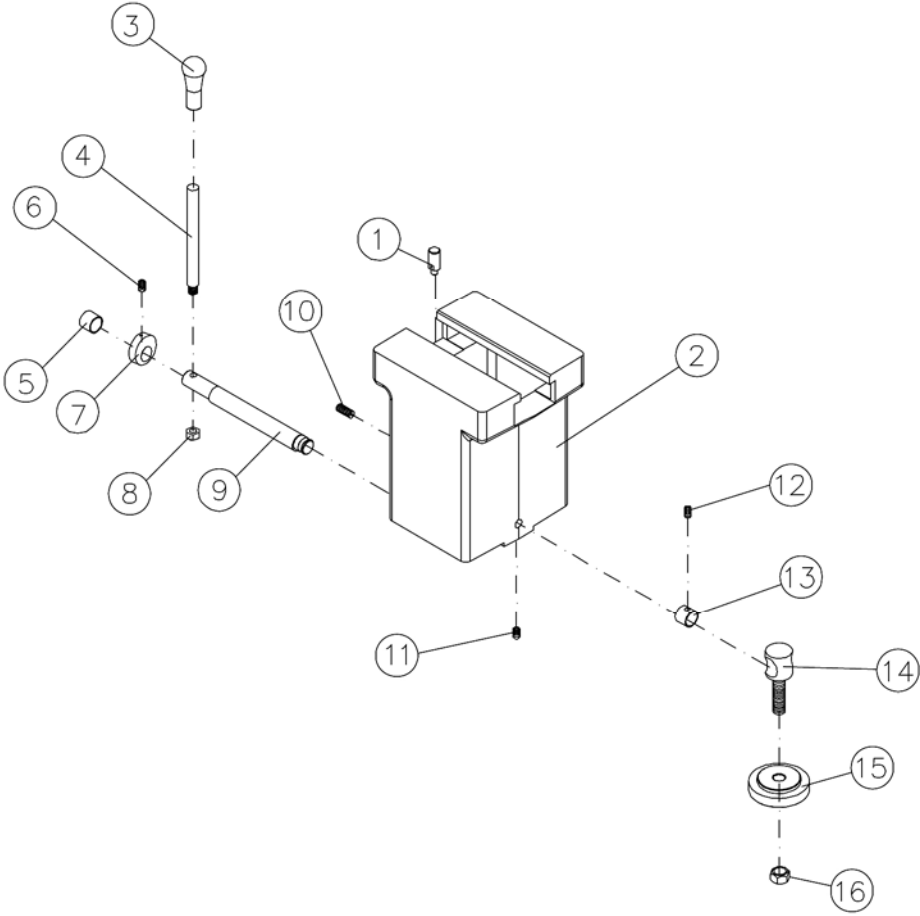
17.6.1 63-inch Extension Bed Assembly (Optional Accessory) – Exploded View



17.6.2 63-inch Extension Bed Assembly (Optional Accessory) – Parts List

Index No	Part No	Description	Size	Qty
.....	6294904	63" Extension Bed with Leg (includes #1 thru 10.)		1
1.....	4224B-201	Bed		1
2.....	4224B-202	Leg		1
3.....	4224B-502	Socket Head Cap Screw	1/2"-12x2"	4
4.....	TS-0720111	Lock Washer	1/2"	4
5.....	TS-0680061	Flat Washer	1/2"	4
6.....	TS-0680042	Flat Washer	3/8"	4
7.....	TS-0720091	Lock Washer	3/8"	4
8.....	TS-0209071	Socket Head Cap Screw	3/8"-16x1-1/2"	4
9.....	4224B-262	Leveling Foot		2
10.....	4224B-263	Hex Nut	1/2"-12	2

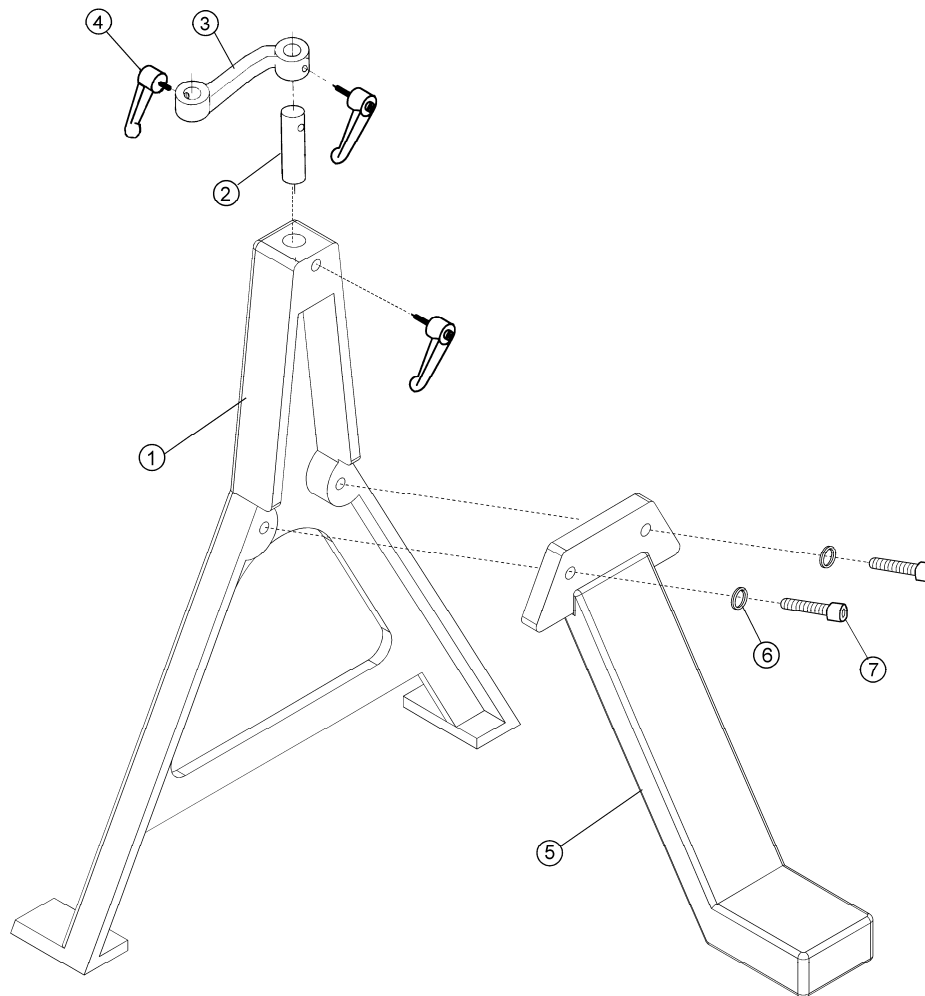
17.7.1 Tailstock Riser Block Assembly (Optional Accessory) – Exploded View



17.7.2 Tailstock Riser Block Assembly (Optional Accessory) – Parts List

Index No	Part No	Description	Size	Qty
.....	6294903.....	Tailstock Riser Block Assembly (includes #1 thru 16).....		
1.....	6295754.....	Stop Bolt.....		1
2.....	4224B-602.....	Riser Block Casting.....		1
3.....	4224B-165.....	Lock Handle.....		1
4.....	4224B-229.....	Rod.....		1
5.....	6095038.....	Bushing.....		1
6.....	TS-0267021.....	Set Screw.....	1/4"-20x1/4"	1
7.....	4224B-228.....	Eccentric Collar.....		1
8.....	TS-0640091.....	Nylon Nut.....	3/8"-16	1
9.....	4224B-232.....	Eccentric Rod.....		1
10.....	4224B-267.....	Ball Plunger.....		1
11.....	4224B-138.....	Set Screw.....	#10-24x1"	1
12.....	TS-0270011.....	Set Screw.....	5/16"-18x1/4"	1
13.....	3096003.....	Collar.....		1
14.....	3058001.....	Bolt.....		1
15.....	4224B-136.....	Cam Locking Disc.....		1
16.....	6520009.....	Nylon Nut.....	5/8"-11	1

17.8.0 Outboard Turning Stand (Optional Accessory) – Exploded View



17.8.1 Outboard Turning Stand (Optional Accessory) – Parts List

Index No.	Part No.	Description	Size	Qty.
.....	6294732	Heavy Duty Outboard Turning Stand Assembly (includes # 1 thru 7)	
1	3042503	Turning Stand Base		1
2	6295897	Offset Tool Support Pin	1.00" diameter	1
3	6295898	Offset Tool Support Casting	1.00" hole	1
4	2695026	Screw Lock Assembly		3
5	3423055	Turning Stand Leg		1
6	6861700	Lock Washer	5/8"	2
7	6769002	Socket Head Cap Screw	5/8"-18 x 2"	2

18.0 Electrical Connections – 4224B Lathe

