



# Operating Instructions and Parts Manual Variable Speed Turret Mill

Models JTM-1254VS and JTM-1254RVS

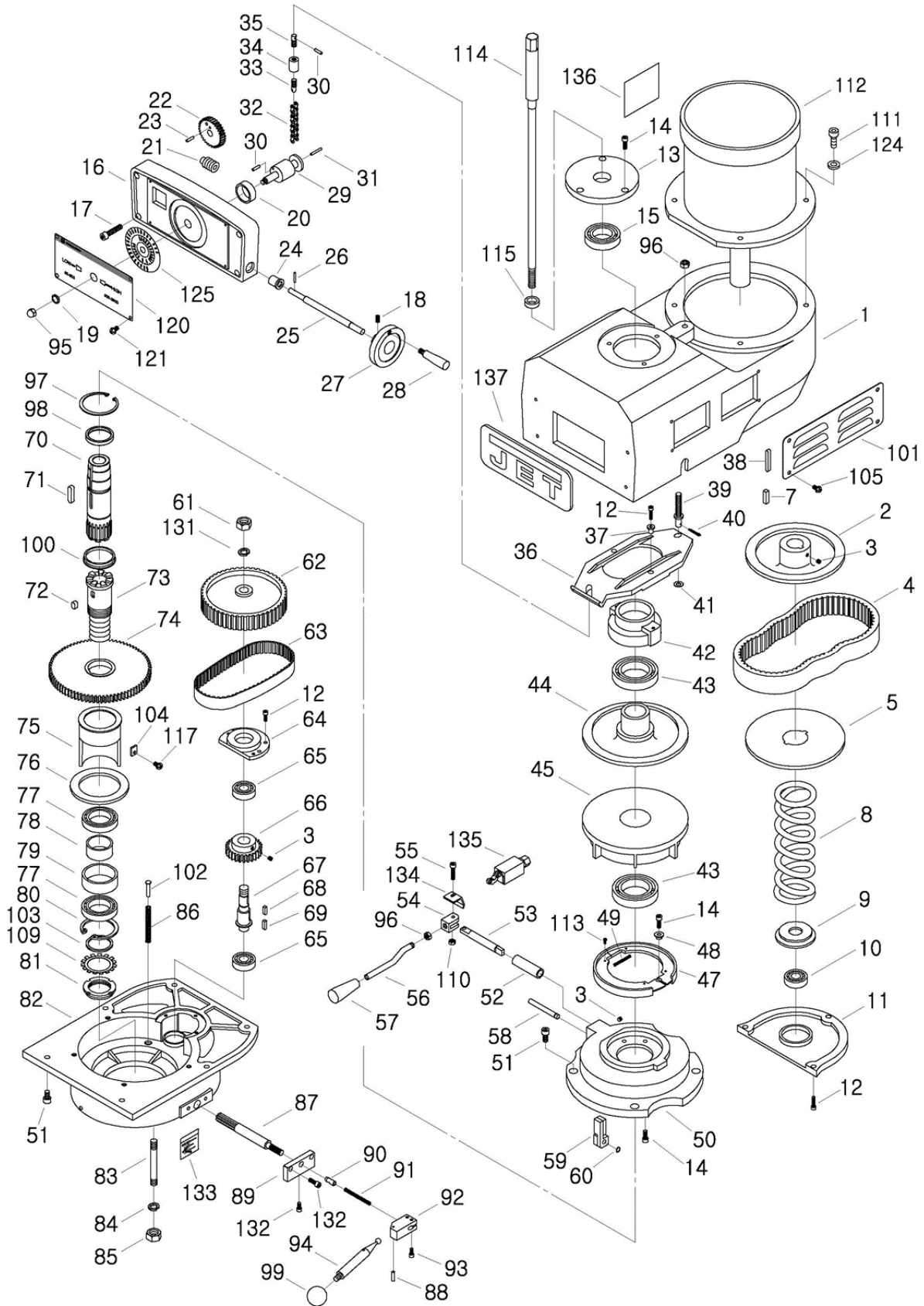


JTM-1254VS shown

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### 12.2.1 JTM-1254RVS (R8) Upper Head Assembly – Exploded View



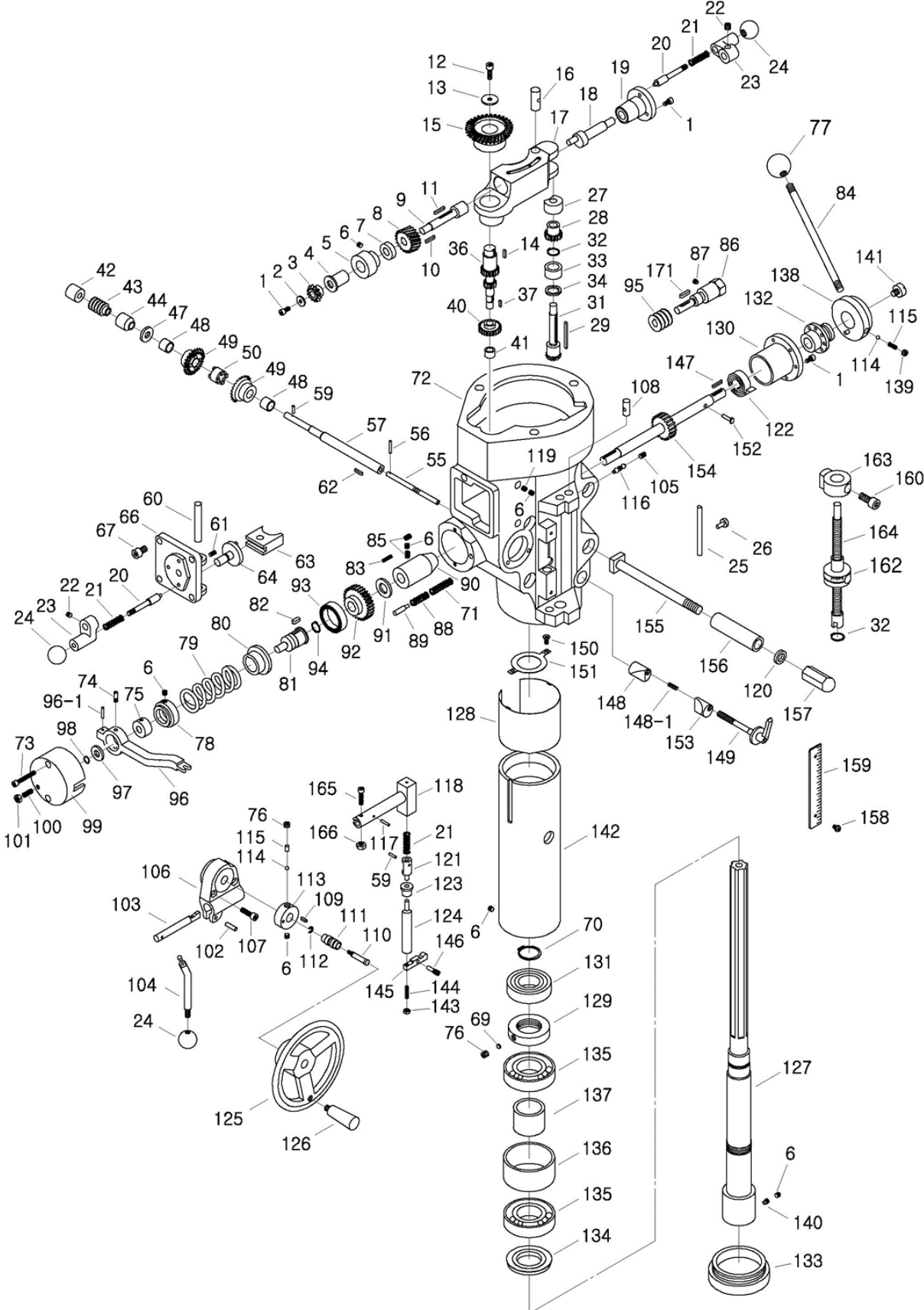
## 12.2.2 JTM-1254RVS (R8) Upper Head Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	JTM949EVS-A77	Upper Pulley Housing		1
2	JTM1254RVS-A02	Motor Disc - Upper		1
3	TS-1523011	Set Screw	M6x6L	4
4	JTM1254RVS-A04	Belt		1
5	JTM1254RVS-A05	Motor Disc - Lower		1
7	6295247	Key	7x7x25L	1
8	JTM1254RVS-A08	Spring		1
9	JTM1254RVS-A09	Washer		1
10	BB-6204ZZ	Ball Bearing	6204ZZ	1
11	JTM949EVS-A69	Motor Pulley Cover		1
12	TS-1504041	Hex Socket Cap Screw	M8x20	3
13	JTM1254RVS-A13	Upper Cover		1
14	TS-1502041	Hex Socket Cap Screw	M5x16	10
15	BB-6009ZZ	Ball Bearing	6009ZZ	1
16	JTM1254RVS-A16	Dial Housing		1
17	TS-1503071	Hex Socket Cap Screw	M6x30L	4
18	TS-1523051	Set Screw	M6x16L	2
19	JTM1254RVS-A19	Bushing		1
20	JTM1254RVS-A20	Spacer		1
21	JTM1254RVS-A21	Worm Gear Shaft		1
22	JTM1254RVS-A22	Worm Gear		1
23	5301041	Spring Pin	Ø5x10L	2
24	JTM1254RVS-A24	Bushing		2
25	JTM1254RVS-A25	Shaft		1
26	5302611	Spring Pin	Ø3x12L	1
27	JTM1254RVS-A27	Handwheel		1
	JTM1254RVS-A27A	Handwheel Assembly (includes #18,27,28)		1
28	JTM1254RVS-A28	Handle		1
29	JTM1254RVS-A29	Chain axle		1
30	5509313	Spring Pin	Ø4x16L	2
31	GA7X-865	Spring Pin	Ø3x25L	1
32	JTM1254RVS-A32	Chain		1
33	JTM1254RVS-A33	Screw		1
34	JTM1254RVS-A34	Spacer		1
35	JTM1254RVS-A35	Jointer		1
36	JTM1254RVS-A36	Adjustable Plate		1
37	JTM1254RVS-A37	Shift Sleeve		2
38	6294761	Key	6x6x45L	1
39	JTM1254RVS-A39	Bottom Pin		1
40	5307431	Spring Pin	3/32"x3/4"	1
41	JTM1254RVS-A41	Flat Washer	Ø8	1
42	JTM1254RVS-A42	Bearing Housing		1
43	BB-6010ZZ	Ball Bearing	6010ZZ	2
44	JTM1254RVS-A44	Spindle Disc - Upper		1
45	JTM1254RVS-A45	Spindle Disc - Lower		1
47	JTM949EVS-A48	Brake Shoe		1
48	JTM949EVS-A58	Lock Collar		1
49	JTM949EVS-A62	Brake Spring		1
50	JTM949EVS-A43	Brake Base		1
51	TS-1504041	Hex Socket Cap Screw	M8x20L	10
52	JTM949EVS-A53	Brake Sleeve		1
53	JTM949EVS-A54	Spindle Brake Shaft		1
54	JTM949EVS-A56	Spindle Brake Lever Pivot		1
55	TS-1503071	Hex Socket Cap Screw	M6x30	1
56	JTM949EVS-A63	Spindle Brake Lever		1
57	JTM949EVS-A50	Brake Lock Knob	3/8"	1
58	JTM949EVS-A49	Brake Shaft		1
59	JTM949EVS-A47	Brake Finger Stud (set of 2)		1
60	JTM949EVS-A46	Retaining Ring	STW8	1
61	JTM1254RVS-A61	Hex Nut	5/8-18UNF	1

Index No	Part No	Description	Size	Qty
62	JTM949EVS-A34	Timing Pulley		1
63	JTM949EVS-A32	Timing Belt	225L100	1
64	JTM949EVS-A19	Ball Bearing Bracket		1
65	BB-6203ZZ	Ball Bearing	6203ZZ	2
66	JTM949EVS-A18	Gear		1
67	JTM949EVS-A16	Gear Shaft		1
68	KF2R5515	Double Round Key	5x5x15L	1
69	KF2R5518	Double Round Key	5x5x18L	1
70	JTM949EVS-A41	Input Clutch		1
71	5307741	Key	8x7x24L	1
72	KF2R8712	Key	8x7x12L	1
73	JTM949EVS-A38	Output Clutch		1
74	JTM949EVS-A33	Gear		1
75	JTM949EVS-A31	Bearing Sleeve		1
76	JTM949EVS-A30	Washer		1
77	BB-6908ZZ	Ball Bearing	6908ZZ	2
78	JTM949EVS-A29	Gear Bearing Spacer (Small)		1
79	JTM949EVS-A28	Gear Bearing Spacer (Large)		1
79A	JTM949EVS-A28A	Gear Bearing Spacer Assembly (#78,79)		1
80	RTW62	Retaining Ring	RTW62	1
81	AN08	Bearing Nut	AN08	1
82	JTM949EVS-A01	Upper Pulley Housing		1
83	JTM949EVS-A88	Stud	7/16"x4"	3
84	TS-0720101	Spring Washer	7/16"	3
85	TS-0561041	Hex Nut	7/16"	3
86	JTM949EVS-A21	Pressure Spring		3
87	JTM949EVS-A03	Bull Gear Shifter Pinion Shaft		1
88	B-56	Spring Pin	Ø3x20L	1
89	JTM949EVS-A04	Hi-Lo Detent Plate		1
90	JTM949EVS-A05	Sleeve		1
91	JTM949EVS-A06	Spring		1
92	JTM949EVS-A08	Hi-Lo Pinion Block		1
93	TS-1502031	Hex Socket Cap Screw	M5x12L	2
94	JTM949EVS-A09	Hi-Lo Shift Handle		1
95	F004478	Cap Nut	5/16"-18UNC	1
96	TS-0570031	Hex Nut	3/8"-16UNC	2
97	JTM949EVS-A42	Retaining Ring	STW80	1
98	JTM949EVS-A59	Collar		1
99	BH1/4	Black Plastic Ball	1/4"	1
100	JTM949EVS-A39	Clutch Collar		1
101	JTM949EVS-A75	Side Belt Housing Cover		2
102	JTM949EVS-A22	Spring Shaft		3
103	JTM949EVS-A25	Spacer		1
104	JTM1254RVS-A104	Nut		1
105	JTM1254VS-A105	Pan Head Screw	M5x8L	4
109	AW08	Bearing Washer	AW08	1
110	TS-1540041	Nut	M6	1
111	TS-1505031	Hex Socket Cap Screw	M10x25	4
112	JTM1254VS-A112	Motor	5HP (3.75kW)	1
	JTM1254VS-A112-1	Motor Fan (not shown)		1
	JTM1254VS-A112-2	Motor Fan Cover (not shown)		1
	JTM1254VS-A112-3	Junction Box Cover (not shown)		1
113	JTM949EVS-A51	Pan Head Screw	1/8"x1/4"	4
114	JTM949EVS-A87	Draw Bar	7/16"	1
115	JTM949EVS-A86	Spacer		1
117	VS-117	Pan Head Screw	3/16"x1/2"L	1
120	JTM1254VS-A120	Speed Plate		1
121	TS-2284202	Pan Head Screw	M4x20L	4
124	TS-1550071	Flat Washer	Ø10	4
125	JTM1254VS-A125	Speed Dial		1
131	TS-0720131	Spring Washer	5/8"	1
132	TS-1502041	Hex Socket Cap Screw	M5x16	3

<b>Index No</b>	<b>Part No</b>	<b>Description</b>	<b>Size</b>	<b>Qty</b>
133	LM000005	Speed Range Label		1
134	JTM949EVS-A91	Push Plate		1
135	JTM949EVS-A92	Limit Switch		1
136	LM000182	Motor Label		1
137	JET-165	JET Logo	165x68 mm	1

12.4.1 JTM-1254RVS (R8) Lower Head Assembly – Exploded View



## 12.4.2 JTM-1254RVS (R8) Lower Head Assembly – Parts List

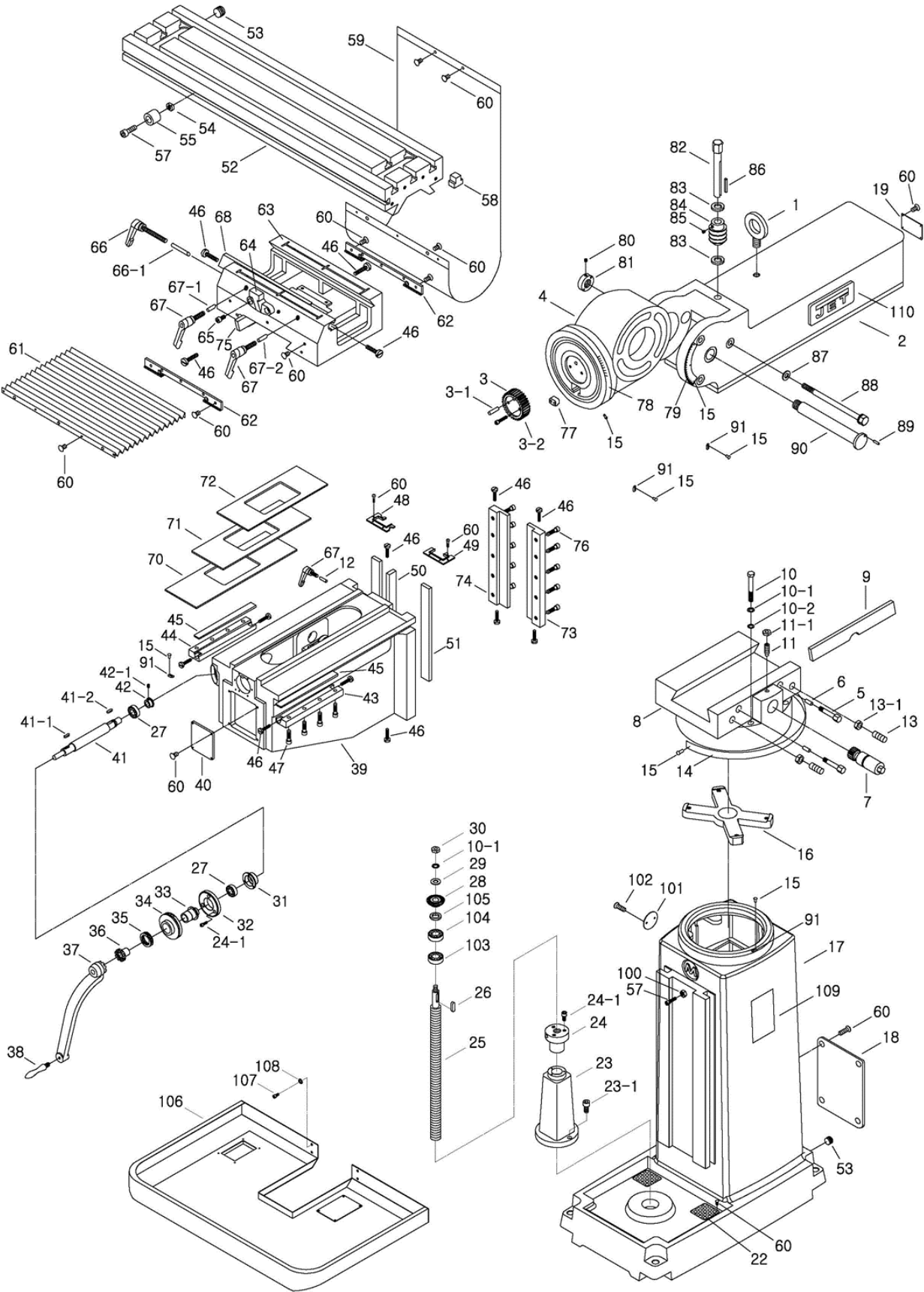
Index No	Part No	Description	Size	Qty
1	TS-1502031	Hex Socket Cap Screw	M5x12	6
2	JTM949EVS-B02	Flat Washer	Ø5	1
3	JTM949EVS-B03	Feed Gear		1
4	JTM949EVS-B04	Shaft Sleeve		1
5	JTM949EVS-B05	Worm Cradle Bushing		1
6	TS-1523011	Socket Set Screw	M6x6	8
7	JTM949EVS-B07	Worm Gear Spacer		1
8	JTM949EVS-B08	Feed Drive Worm Gear		1
9	JTM949EVS-B09	Worm Gear Shaft		1
10	JTM949EVS-B10	Worm Shaft Key	3x3x8	1
11	KF2R3320	Key	3x3x20	1
12	TS-1503041	Hex Socket Cap Screw	M6x16	1
13	JTM949EVS-B13	Flat Washer	Ø6	1
14	KF2R5508	Key	5x5x8	1
15	JTM949EVS-B15	Feed Reverse Bevel Gear		1
16	JTM949EVS-B16	Feed Engage Pin		1
17	JTM949EVS-B17	Worm Gear Cradle		1
18	JTM949EVS-B18	Cam Rod		1
19	JTM949EVS-B19	Shift Sleeve		1
20	JTM949EVS-B20	Lock Rod		2
21	JTM949EVS-B21	Spring		3
22	5302731	Socket Set Screw	M8x6	2
23	JTM949EVS-B23	Crank		2
24	BH1/4	Black Plastic Ball	1/4"	3
25	JTM949EVS-B25	Indicator Rod		1
26	JTM949EVS-B26	Indicator Rod Screw		1
27	JTM949EVS-B27	Upper Bushing		1
28	JTM949EVS-B28	Cluster Gear		1
29	KF2R4445	Key	4x4x45	1
31	JTM949EVS-B31	Bevel Gear Shaft		1
32	STW16	Retaining Ring	STW16	2
33	JTM949EVS-B33	Bevel Gear Bushing		1
34	JTM949EVS-B34	Spacer		1
36	JTM949EVS-B36	Feed Drive Gear		1
36A	JTM949EVS-B36A	Feed Drive Gear Assembly (#36,37)		1
37	KF2R5512	Key	5x5x12	1
40	JTM949EVS-B40	Feed Drive Gear		1
41	BB-BA66	Needle Bearing	BA66	1
42	JTM949EVS-B42	Bushing		1
43	JTM949EVS-B43	Worm		1
44	JTM949EVS-B44	Feed Worm Shaft Bushing		1
47	JTM949EVS-B47	Bevel Gear Thrust Spacer		1
48	JTM949EVS-B48	Bushing		2
49	JTM949EVS-B49	Feed Reverse Bevel Gear		2
50	JTM949EVS-B50	Feed Reverse Clutch		1
55	JTM949EVS-B55	Reverse Clutch Rod		1
56	TS-209203	Spring Pin	3x20	1
57	JTM949EVS-B57	Feed Worm Shaft		1
59	5302611	Spring Pin	3x12	2
60	JTM949EVS-B60	Feed Shift Rod		1
61	TS-1522031	Socket Set Screw	M5x10	1
62	KF2R3315	Key	3x3x15	1
63	JTM949EVS-B63	Feed Gear Shift Fork		1
64	JTM949EVS-B64	Cluster Gear Shift Crank		1
66	JTM949EVS-B66	Cluster Gear Cover		1
67	TS-1502021	Hex Socket Cap Screw	M5x10	4
69	JTM949EVS-B69	Lock Block		1
70	2210-266	Retaining Ring	STW30	1
71	JTM949EVS-B71	Spring	10x20	1
72	JTM949EVS-B72	Quill Housing	105mm	1

Index No	Part No	Description	Size	Qty
73	TS-1502081	Hex Socket Cap Screw	M5x35	2
74	JTM949EVS-B74	Clutch Ring Pin		2
75	JTM949EVS-B75	Clutch Ring		1
76	5302731	Socket Set Screw	M8x6	2
77	JTM949EVS-B77	Ball Grip		1
78	JTM949EVS-B78	Overload Clutch Lockout		1
79	JTM949EVS-B79	Safety Clutch Spring		1
80	JTM949EVS-B80	Overload Clutch		1
80A	JTM949EVS-B80A	Overload Clutch Assembly (#6,78,80,81)		
81	JTM949EVS-B81	Overload Clutch Sleeve		1
82	KF2R5516	Key	5x5x16	1
83	TS-1532052	Pan Head Machine Screw	M4x16	3
84	JTM949EVS-B84	Handle		1
85	TS-1523031	Socket Set Screw	M6x10	2
86	JTM949EVS-B86	Worm Shaft		1
87	TS-1523011	Set Screw	M6x6	1
88	JTM949EVS-B88	Spring		1
89	JTM949EVS-B89	Spring Plunger		1
90	JTM949EVS-B90	Pinion Shaft		1
91	JTM949EVS-B91	Spacer		1
92	JTM949EVS-B92	Overload Clutch Worm Gear		1
93	JTM949EVS-B93	Overload Clutch Ring		1
94	STW22	Retaining Ring	STW22	1
95	JTM949EVS-B95	Worm Gear		1
96	JTM949EVS-B96	Trip Lever		1
96-1	GA7X-122	Spring Pin	Ø5x20	1
97	JTM949EVS-B97	Washer		1
98	STW10	Retaining Ring	STW10	1
99	JTM949EVS-B99	Clutch Arm Cover		1
100	TS-1523051	Socket Set Screw	M6x16	1
101	TS-2311061	Hex Nut	M6	1
102	5625391	Spring Pin	Ø5x16	1
103	JTM949EVS-B103	Cam Rod		1
104	JTM949EVS-B104	Trip Handle		1
105	5302731	Socket Set Screw	M8x6	1
106	JTM949EVS-B106	Feed Trip Bracket		1
107	TS-1503051	Hex Socket Cap Screw	M6x20	2
108	JTM949EVS-B108	Plunger		1
109	KF2R3312	Key	3x3x12	1
110	JTM949EVS-B110	Feed Reverse Stud Bolt		1
110A	JTM949EVS-B110A	Feed Reverse Stud Assembly (#110,111,112)		
111	JTM949EVS-B111	Feed Reverse Stud		1
112	ETW6	Retaining Ring	ETW6	1
113	JTM949EVS-B113	Handwheel Clutch		1
114	SB-3/16	Steel Ball	3/16"	2
115	JTM949EVS-B115	Spring		2
116	JTM949EVS-B116	Lever		1
117	JTM949EVS-B117	Spring Pin	Ø3x16	1
118	JTM949EVS-B118	Cam Rod Sleeve Assembly		1
119	TS-1523011	Socket Set Screw	M6x6	2
120	JTM949EVS-B120	Flat Washer	Ø13	4
121	JTM949EVS-B121	Trip Plunger		1
122	JTM949EVS-B122	Adjustable Spring		1
123	JTM949EVS-B123	Bushing		1
124	JTM949EVS-B124	Feed Trip Plunger		1
125	JTM1254VS-B77	Cast Handwheel		1
125A	JTM1254VS-B77HA	Handwheel Assembly (#125,126)		
126	JTM1254VS-B78	Handle		1
127	JTM949EVS-B127	Spindle	R8	1
128	JTM949EVS-B128	Quill Skirt		1
129	JTM949EVS-B129	Lock Nut	M35	1
130	JTM949EVS-B130	Spring Cover		1



Index No	Part No	Description	Size	Qty
131	BB-6206ZZ	Ball Bearing	6206ZZ	1
132	JTM949EVS-B132	Hub Sleeve		1
133	JTM949EVS-B133	Nose Piece		1
134	JTM949EVS-B134	Spindle Shield		1
135	BB-7207C	Ball Bearing	7207C	2
136	JTM949EVS-B136	Bearing Spacer (large)		1
136A	JTM949EVS-B136A	Bearing Spacer Assembly (#136,137)		
137	JTM949EVS-B137	Bearing Spacer (small)		1
138	JTM949EVS-B138	Hub		1
139	TS-0270011	Socket Set Screw	5/16"x1/4"	1
140	TS-1523011	Socket Set Screw	M6x6	1
141	JTM949EVS-B141	Pinion Shaft Hub		1
142	JTM949EVS-B142	Quill		1
143	TS-1540021	Hex Nut	M4	1
144	TS-1521071	Socket Set Screw	M4x20	1
145	JTM949EVS-B145	Feed Trip Lever		1
146	JTM949EVS-B146	Trip Lever Pin		1
147	KF2R5525	Key	5x5x25	1
148	JTM949EVS-B148	Quill Lock Sleeve		1
148-1	JTM949EVS-B148-1	Spring		1
149	JTM949EVS-B149	Lock Handle	M8	1
150	TS-1533032	Pan Head Screw	M5x10	2
151	JTM949EVS-B151	Washer		1
152	JTM949EVS-B152	T-type Pin		1
153	JTM949EVS-B153	Quill Lock Sleeve		1
154	JTM949EVS-B154	Quill Pinion Shaft		1
154A	JTM949EVS-B154A	Quill Pinion Shaft Assembly (#152,154)		
155	JTM949EVS-B155	T-Bolt Assembly		4
156	JTM949EVS-B156	Spacer		4
157	JTM949EVS-B157	Lock Nut		4
158	TS-2171012	Pan Head Screw	M4x6	2
159	JTM949EVS-B159	Micrometer Scale		1
160	TS-0209032	Hex Socket Cap Screw	3/8"-24UNFx3/4"	1
162	JTM949EVS-B162	Micrometer Nut	Inch	1
163	JTM949EVS-B163	Quill Stop Knob		1
164	JTM949EVS-B164	Quill Micro-Screw	Inch	1
165	TS-1502051	Hex Socket Cap Screw	M5x20	1
166	TS-1540031	Hex Nut	M5	1
171	KF2R4418	Key	4x4x18	1

12.6.1 JTM-1254RVS (R8) Base Machine – Exploded View

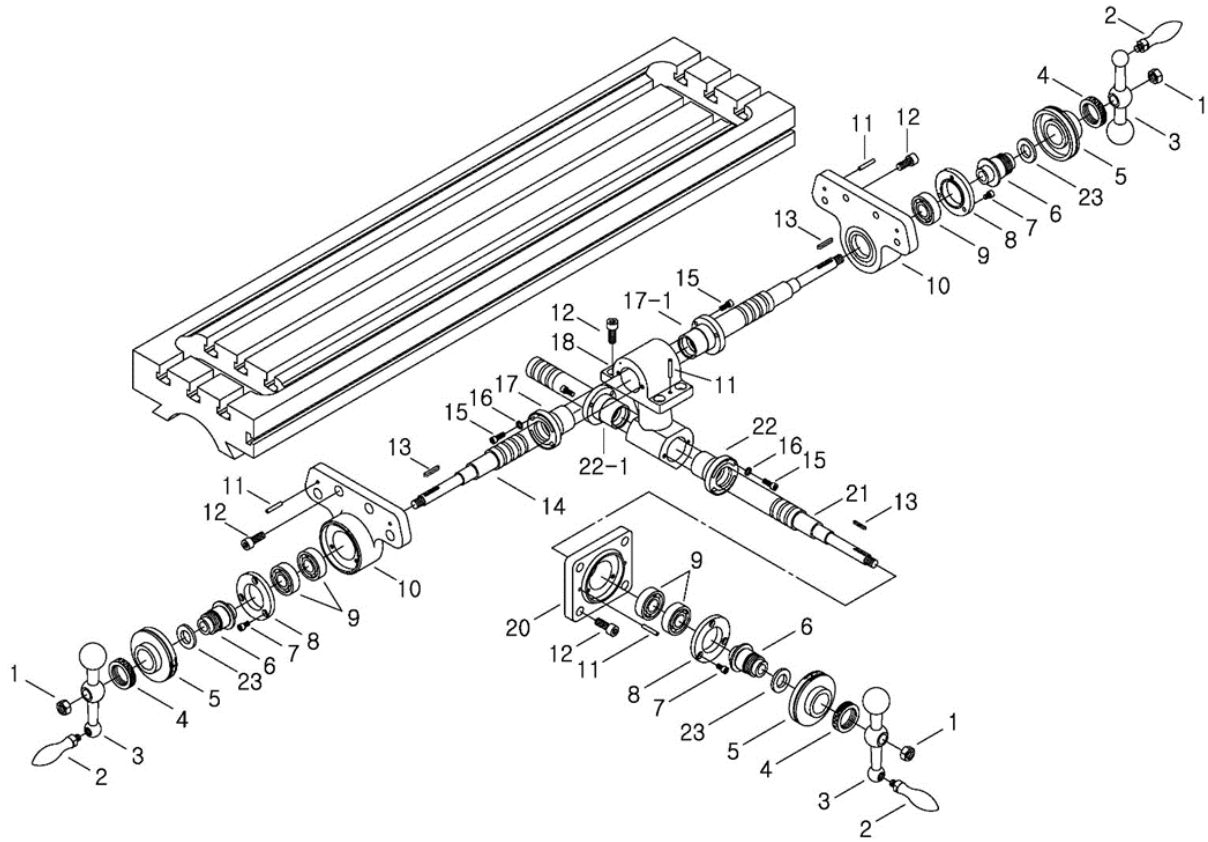


## 12.6.2 JTM-1254RVS (R8) Base Machine – Parts List

Index No	Part No	Description	Size	Qty
1	JTM1050EVS2-C29A	Lifting Ring	M20	1
2	JTM1050EVS2-30	Ram		1
3	JTM949EVS-C02	Worm Gear		1
3-1	JTM949EVS-C03-1	Spring Pin	Ø6x30L	1
3-2	TS-1504061	Hex Socket Cap Screw	M8x30L	2
4	JTM1050EVS2-C40	Ram Adapter	Ø30	1
5	JTM1254VS-C05	Ram Lock Bolt		2
6	JTM1254VS-C06	Ram Lock Plunger		2
7	JTM1050EVS2-88	Ram Pinion	M2.54x13T	1
8	JTM1254VS-C08	Turret		1
9	JTM1050EVS2-79	Turret Gib	7.6t	1
10	JTM1254RVS-C10	Hex Head Screw	M12x125L	4
10-1	TS-2361121	Spring Washer	Ø12	5
10-2	JTM949EVS-B120	Flat Washer	Ø13	4
11	JWS35X-222	Socket Set Screw	M8x30L	1
11-1	JTM1254VS-C11-1	Hex Nut	M8	1
12	JTM1254RVS-C12	Knee Lock Plunger	Ø10x35L	2
13	JTM1254RVS-C13	Set Screw	M10x60L	2
13-1	TS-2331101	Hex Nut	M10	2
14	JTM949EVS-C81	Turret Scale		1
15	RN2L6	Rivet	Ø2x6L	12
16	JTM949EVS-C27	Spider		1
17	JTM1254VS-C17	Column		1
18	JTM1254VS-C18	Plate		1
19	JTM1254VS-C19	Ram Cover		1
22	JTM949EVS-C87	Strainer Net	90*90	2
23	JTM1254VS-C23	Elevating Screw Housing		1
23-1	JTM1254VS-C23-1	Hex Socket Cap Screw	M10x45L	2
24	JTM1254VS-C24	Elevating Nut (Inch)	Ø32 x 5 Tpi	1
24-1	TS-1503051	Hex Socket Cap Screw	M6x20L	6
25	JTM1254VS-C25	Lead Screw (Inch)	Ø35x5 Tpi (590)	1
26	KF2R5520	Key	5x5x20L	1
27	BB6204ZZ	Bearing	6204ZZ	2
28	JTM1254VS-C28	Bevel Gear	Ø25x36T- 20.6m	1
29	JTM1254VS-C29	Washer	Ø13xØ32x5T	1
30	JTM1254VS-C30	Hex Nut	1/2-20UNF	1
31	JTM1254VS-C31	Bearing Seat		1
32	JTM1254VS-C32	Cover	62mm	1
33	JTM949EVS-C67	Dial Holder	3/4, 51L	1
34	JTM949EVS-C66	Dial (Inch)	100/ 0.001"	1
35	JTM949EVS-C65	Dial Lock Nut		1
36	JTM949EVS-C64	Clutch Insert	3mm, 9T	1
37	JTM1050EVS2-75	Elevating Crank		1
38	JTM949EVS-C62	Handle		1
39	JTM1254VS-C39	Knee		1
40	JTM1254VS-C40	Knee Cover		1
41	JTM1254VS-C41	Elevating Shaft	Ø23.81x354x 538L	1
41-1	JTM1254VS-C41-1	Key	3x3x10L	1
41-2	JTM1254VS-C41-2	Key	4x4x16L	1
42	JTM949EVS-C74	Bevel Gear	18T	1
42-1	TS-1523031	Socket Set Screw	M6x10L	1
43	JTM1254VS-C43	Support Plate-R		1
44	JTM1254VS-C44	Support Plate-L		1
45	JTM1254VS-C45	Gib		2
46	JTM949EVS-C34	Adjustable Screw	M8*37L	14
47	JTM1254VS-C47	Hex Socket Cap Screw	M12x35L	8
48	JTM1254VS-C48	Knee Wiper (Left)		1
49	JTM1254VS-C49	Knee Wiper (Right)		1
50	JTM1254VS-C50	Knee/ Column Gib		1
51	JTM1254VS-C51	Knee/ Column Gib		2

Index No	Part No	Description	Size	Qty
52	JTM1254VS-C52	Table	12"x54"	1
53	JTM1254VS-C53	Oil Plug	1/2"PT	3
54	JTM1254VS-C54	Nut		2
55	JTM1254VS-C55	Bushing		2
57	TS-1505041	Hex Socket Cap Screw	M10x30L	3
58	JTM1254VS-C58	Rubber	23x32x16	6
59	JTM1254VS-C59	Flat Way Cover (rear)	450x850x1.5T	1
60	TS-2245102	Socket Head Button Screw	M5x10L	39
61	JTM1254VS-C61	Pleated Way Cover (front)	450x600L	1
62	JTM1254VS-C62	Wiper		2
63	JTM1254VS-C63	Saddle		1
64	JTM1254VS-C64	Table Stop Bracket		1
65	JTM1254VS-C65	Hex Socket Cap Screw	M10X16L	2
66	JTM949EVS-C21	Lock Handle	M12x25L	1
66-1	JTM1254VS-C66-1	Pluger	Ø10x195L	1
67	JTM949EVS-C21	Lock Handle	M12x25L	4
67-1	JTM1254VS-C67-1	Pluger	Ø10 x L50°	1
67-2	JTM1254VS-C67-2	Pluger	Ø10 x L50°	1
68	JTM1254VS-C68	Gib		1
70	JTM1254VS-C70	Chip Guard (Bottom)	680 mm (129x2.0T)	1
71	JTM1254VS-C71	Chip Guard (Middle)	565 mm (129x2.0T)	2
72	JTM1254VS-C72	Chip Guard (Top)	430 mm (129x2.0T)	1
73	JTM1254VS-C73	Knee Support Plate (Right)		1
74	JTM1254VS-C74	Knee Support Plate (Left)		1
75	JTM1254VS-C75	Gib		1
76	JTM1254VS-C76	Hex Socket Cap Screw	M14x35L	10
77	JTM1254RVS-C77	Lock Stud		1
78	JTM949EVS-C06	Adapter Scale		1
79	JTM949EVS-C12	Angle Scale		1
80	TS-1521021	Set Screw	M4x8L	1
81	JTM1050EVS2-39	Lock Nut	Ø45x13L	1
82	JTM1050EVS2-24	Shaft	19H x162L	1
83	JTM1050EVS2-25	Washer	Ø32*17.6*3.2L	2
84	JTM949EVS-C07	Worm	Ø44.4*17.4*50.7 L	1
85	TS-1523021	Socket Set Screw	M6x8L	1
86	KF2R5549	Key	5x5x50L	1
87	JTM1050EVS2-31	Washer	Ø12	3
88	JTM1050EVS2-32	Adapter Locking Bolt	19H*203L, M14*P2.0	3
89	6293347	Spring Pin	Ø3x16L	1
90	JTM1050EVS2-34	Adapter Shaft	Ø30x200L	1
91	JTM1254RVS-C91	Pointer		4
100	TS-1540071	Hex Nut	M10	1
101	JTM949EVS-C84	Side Cover		1
102	TS-1503031	Socket Head Button Screw	M6x12L	2
103	BA51305	Bearing	51305	1
104	BB6205ZZ	Ball Bearing	6205ZZ	1
105	JTM949EVS-C44	Washer		1
106	JTM1254RVS-C106	Chip Pan	5J	1
107	TS-1504031	Hex Socket Cap Screw	M6x12L	4
108	TS-1550041	Flat Washer	Ø6	4
109	LM000243	ID/Warning Label, JTM-1254RVS		1
110	JET-254	JET Logo	254x105 mm	2
	JTM1254RVS-TB	Tool Box Kit Complete (not shown)		1

## 12.7.1 JTM-1254VS/RVS Table Assembly – Exploded View



## 12.7.2 JTM-1254VS/RVS Table Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	TS-0561052	Nut	1/2-20UNF	3
2	JTM949EVS-D02	Handle	3/8"	3
	JTM949EVS-D03A	Ball Crank Assembly (includes #2,3)		1
3	JTM949EVS-D03	Ball Crank		3
4	JTM949EVS-D04	Dial Lock Nut		3
5	JTM949EVS-D05	Dial (Inch)	200/0.001"	3
6	JTM949EVS-D06	Dial Holder	3mm / 56.6L	3
7	TS-1503031	Hex Socket Cap Screw	M6x12	9
8	JTM949EVS-D08	Cover		3
9	BB-6204ZZ	Ball Bearing	6204ZZ	5
10	JTM949EVS-D10	Bearing Bracket	Ø60	2
11	5311251	Spring Pin	Ø5x30	6
12	TS-1505011	Hex Socket Cap Screw	M10x16	16
13	KF2R3325	Key	3x3x25	3
14	JTM1254VS-D14	Lead Screw	Ø32 x 5 tpi (1632)	1
15	TS-1503041	Hex Socket Cap Screw	M6x16	10
16	TS-1550041	Flat Washer	M6	4
17	JTM949EVS-D17	Feed Screw Nut (Inch)	Ø32 x 5 tpi	1
17-1	JTM949EVS-D17-1	Feed Screw Nut (Adjust-I)	Ø32 x 5 tpi	1
18	JTM1254VS-D18	Lead Screw Housing		1
20	JTM949EVS-D20	Cross Bearing Bracket		1
21	JTM1254VS-D21	Cross Feed Screw	Ø32 x 5 tpi (720)	1
22	JTM949EVS-D22	Cross Feed Adjustment Nut (Inch)	Ø32 x 5 TPI	1
22-1	JTM949EVS-D22-1	Cross Feed Nut (Inch)	Ø32 x 5 TPI	1
23	JTM949EVS-D23	Adjusting Washer	Ø45xØ34x0.15t	3

## 12.8.1 JTM-1254VS/RVS Control Box Assembly – Exploded View



## 12.8.2 JTM-1254VS/RVS Control Box Assembly – Parts List

Index No	Part No	Description	Size	Qty
.....	JTM1254VS-CBA.....	Control Box Assembly (includes #1-8).....		1
1 .....	JTM949EVS-E01 .....	Control Box .....		1
2 .....	JTM1254VS-CB .....	Control Panel.....		1
3 .....	JTM949EVS-E09 .....	Emergency Switch .....		1
4 .....	JTM949EVS-E07 .....	Spindle Stop Button.....		1
5 .....	JTM949EVS-E06 .....	Coolant Pump Switch .....		1
6 .....	JTM949EVS-E08 .....	Power Start Button .....		1
7 .....	JTM949EVS-E04 .....	F/R Select Switch .....		1
8 .....	TS-2245102 .....	Socket Head Button Screw.....	M5x10L .....	4
9 .....	TS-1540031 .....	Hex Nut.....	M5 .....	4
10 .....	TS-1550031 .....	Flat Washer .....	Ø5 .....	4
11 .....	JTM949EVS-E12 .....	Handle .....		1
12 .....	TS-2245162 .....	Socket Head Button Screw.....	M5x16 .....	4
.....	JTM949EVS-E14 .....	Support Rod Unit Assembly (includes #13, 13-1, 13-2, 16, 20, 23) .....		1
13 .....	JTM1254VS-E13.....	Rod .....		1
13-1 .....	JTM1254VS-E13-1....	Rotating Bracket .....		1
13-2 .....	JTM1254VS-E13-2....	Control Box Bracket.....		1
14 .....	TS-1504041 .....	Hex Socket Cap Screw.....	M8X20L .....	2
15 .....	TS-1523031 .....	Socket Set Screw .....	M6x10 .....	3
16 .....	JTM949EVS-E18 .....	Lock Handle.....	M12X35L .....	1
17 .....	JTM949EVS-E19 .....	Bracket.....		1
18 .....	TS-1523051 .....	Hex Socket Cap Screw.....	M6x16L .....	3
19 .....	JTM1254VS-E19.....	Spacer .....		1
20 .....	JTM949EVS-B120 ....	Flat Washer .....	Ø13xØ20x2T .....	1
21 .....	TS-0640081 .....	Hex Nylon Lock Nut.....	5/16"-18 .....	1
22 .....	JTM1254VS-E22.....	Rubber gasket .....		1
23 .....	JTM1254VS-E23.....	Nut.....		1
.....	JTM1254VS-D19.....	Cable (Control Panel to Electrical Box) – not shown.....		1

## 12.9.1 JTM-1254VS/RVS Electrical Box – Exploded View



## 12.9.2 JTM-1254VS/RVS Electrical Box – Parts List

Index No	Part No	Description	Size	Qty
1	JTM949EVS-F01	Electrical Cabinet (RE: JTM949EVS-F21)		1
2	JTM949EVS-F02	Electrical Plate (RE: JTM949EVS-F21)		1
3	JTM949EVS-F03	Electrical Cabinet Door (RE: JTM949EVS-F21)		1
	JTM949EVS-F21	Electrical Cabinet Assembly (includes #1-3)		1
4	JTM949EVS-F04	Door Latch		1
6	JTM949EVS-F18	Fan Cover		1
7	JTM949EVS-F19	Electric Receptacle		1
8	JTM949EVS-F16	Aluminum Rail		2
9	JTM949EVS-F14	Wire Casing		5
10	JTM949EVS-F15	Terminal Block		1
11	JTM949EVS-F21	Switch Bracket		1
12	JTM949EVS-F05-1	Switch Interface		1
QS1	JTM949EVS-F05	Door Switch (includes #12)		1
TC1	JTM949EVS-F06	Transformer	400VA	1
KM1	JTM1254VS-FKM1	Magnetic Contactor	TECO / CU-11	1
FR1	JTM1254VS-FFR1	Flicker Relay		1
KM2	JTM1254VS-FKM2	Magnetic Contactor	TECO / CU-11	1
KA1	JTM1254VS-FKA1	Relay	RMIA4524VAC	1
KA2	JTM1254VS-FKA2	Relay	RMIA21024VAC	1
KA3	JTM1254VS-FKA3	Relay	RMIA4524VAC	1
QF1	JTM1254VS-FQF1	Power Circuit Breaker	3P 25A	1
QF2	JTM1254VS-FQF2	Power Circuit Breaker	1P 2A	1
QF3	JTM1254VS-FQF3	Power Circuit Breaker	1P 6A	1
QF4	JTM1254VS-FQF4	Power Circuit Breaker	1P 6A	1

### 12.10.1 JTM-1254VS/RVS Coolant Pump (Optional) – Exploded View

### 12.11.1 JTM-1254VS/RVS Work Lamp – Exploded View



### 12.10.2 JTM-1254VS/RVS Coolant Pump (Optional) – Parts List

Index No	Part No	Description	Size	Qty
.....	JTM949EVS-G00	Coolant Pump Kit (includes #1 thru 12)	.....	.....
1	JTM949EVS-G01	Plastic Nozzle	.....	1
2	JTM949EVS-G02	Valve	PT 3/8" x 1/2"	1
3	TS-1503091	Hex Socket Cap Screw	M6 x 40	2
4	JTM949EVS-G04	Block	.....	1
5	JTM949EVS-G07	Hose Fitting	PT 3/8" x 1/2" (90°)	1
6	JTM949EVS-G06	Hose	1/2"	1
7	JTM949EVS-G07	Hose Fitting	PT 3/8" x 1/2" (90°)	1
8	JTM949EVS-G08	Hose Clamp	5/6" (11 ~ 20)	2
9	JTM949EVS-G09	Coolant Pump	1/8HP	1
10	JTM949EVS-G10	External Coolant Tank	.....	1
11	JTM949EVS-G11	Strainer	.....	1
12	JTM949EVS-G12	Cover with handle	.....	1

### 12.11.2 JTM-1254VS/RVS Work Lamp – Parts List

13	JTM949EVS-G13	Work Lamp	24V / LED	1
14	TS-1502041	Hex Socket Cap Screw	M5X16	4
15	JTM949EVS-G15	Work Light Bracket	.....	1
16	TS-1503041	Hex Socket Cap Screw	M6X16	6
17	TS-1550041	Flat Washer	Ø6mm	6
18	JTM949EVS-G18	LED Bulb (not shown)	24V	1



**12.12.1 JTM-1254VS/RVS Spindle Guard Assembly – Exploded View**



**12.12.2 JTM-1254VS/RVS Spindle Guard Assembly – Parts List**

Index No	Part No	Description	Size	Qty
	JTM949EVS-SGA	Spindle Guard Assembly (#1 thru 10)		
1	TS-1502101	Hex Socket Cap Screw	M5x45	2
2	JTM949EVS-H02	Support Plate		1
3	TS-2245102	Socket Head Button Screw	M5x10	2
4	JTM949EVS-H04	Bushing Bracket (Re: JTM949EVS-H04A)		1
	JTM949EVS-H04A	Bushing Bracket Assembly (includes #4,5)		1
5	JTM949EVS-H05	Bushing		1
6	JTM949EVS-H06	Support Rod		1
7	TS-1550031	Washer	Ø5	2
8	TS-1502031	Hex Socket Cap Screw	M5x12	2
9	JTM949EVS-H09	Spindle Guard		1
10	TS-1522021	Socket Set Screw	M5x8	1

### 12.13.1 JTM-1254VS/RVS Lubrication System – Exploded View



### 12.13.2 JTM-1254VS/RVS Lubrication System – Parts List

Index No	Part No	Description	Size	Qty
1	JTM949EVS-J01N	Automatic Oiler	2L, 0~180min	1
2	TS-1503061	Hex Socket Cap Screw	M6x25L	2
3	JTM949EVS-J03	Flexible Steel Tube	Ø4	1
4	JTM949EVS-J04	Elbow Adaptor	Ø4	3
5	JTM949EVS-J10	Oil Distributor	Ø4, 6 holes	2
6	JTM949EVS-J06	Flexible Steel Tube		1
7	JTM949EVS-J07	Aluminum Pipe	Ø4	2
8	TS-1502061	Hex Socket Cap Screw	M5x25L	4
9	JTM1254VS-J09	Oil Distributor	Ø4, 8 holes	1
	JTM1254VS-J05A	Oil Distributor Kit (incl. #3,5,6,9)		1