



Operating Instructions and Parts Manual Variable Speed Turret Mill

Model: JTM-1054R



For serial no. 120xxxx and higher

JET
427 New Sanford Road
LaVergne, Tennessee 37086
Ph.: 800-274-6848
www.jettools.com

Part No. M-690053
Revision B1 06/2014
Copyright © 2014 JET

Parts

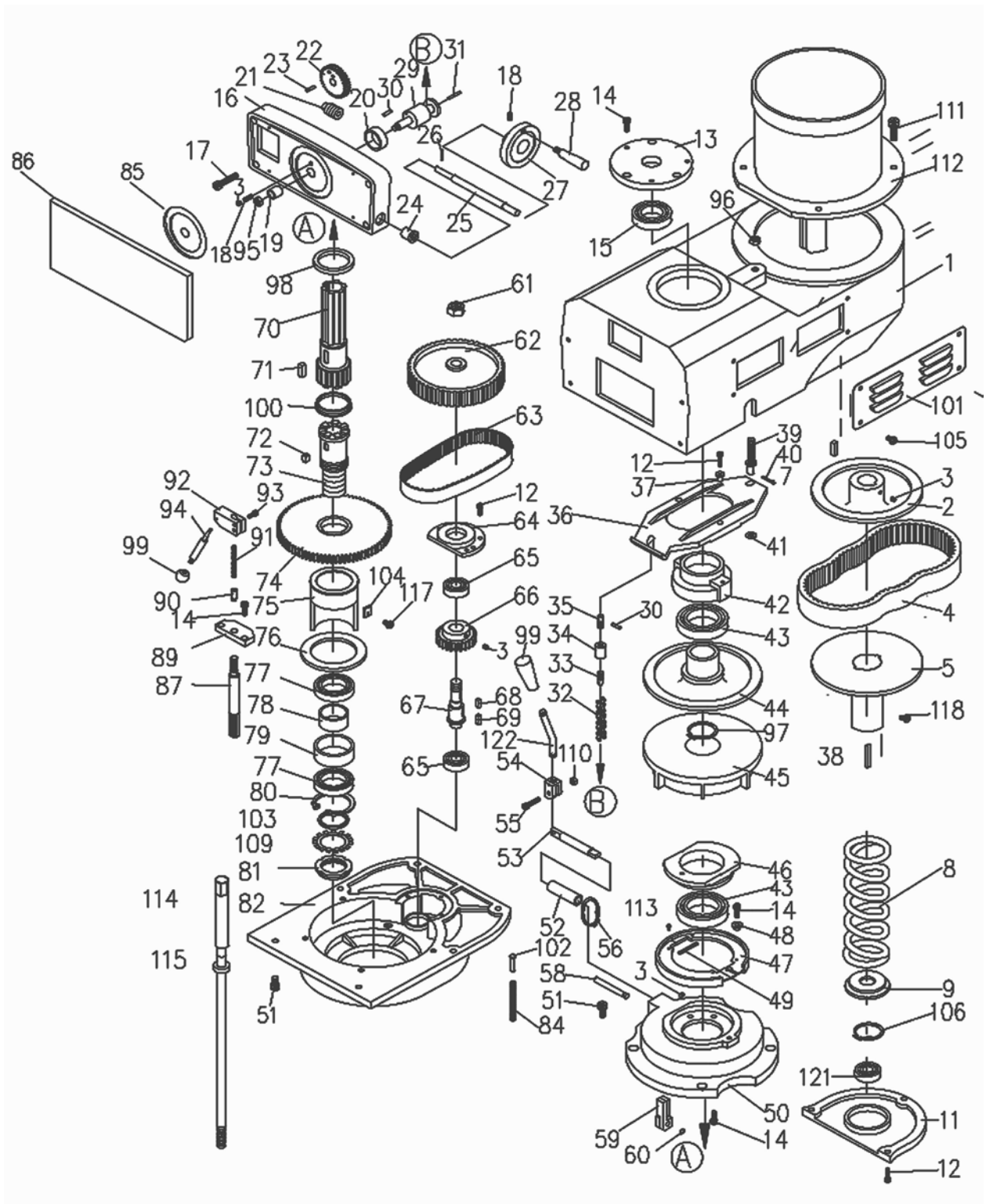
Variable Speed Head Assembly

Index No	Part No	Description	Size	Qty
1	PVS-001	Housing		1
2	PVS-002	Motor Pulley		1
3	TS-1523011	Set Screw	M6x6	4
4	PVS-004	Belt	3830900	1
5	PVS-005	Motor Pulley		1
7	KEY7725	key	7x7x25	1
8	PVS-008	Motor Pulley Spring		1
9	PVS-009	Spring Stop Washer		1
11	PVS-011	Motor Pulley Cover		1
12	TS-1502051	Hex Socket Cap Screw	M5x20	9
13	PVS-013	Cover		1
14	TS-1502041	Hex Socket Cap Screw	M5x16	1
15	BB-6007ZZ	Ball Bearing	6007ZZ	1
16	PVS-016	Dial Cover		1
17	TS-1502081	Hex Socket Cap Screw	M5x35	4
18	TS-1503041	Hex Socket Cap Screw	M6x16	3
19	PVS-019	Bushing		1
20	PVS-020	Bushing		1
21	PVS-021	Worm		1
22	PVS-022	Worm Gear		1
23	PVS-023	Spring Pin	5x10	2
24	PVS-024	Bushing		2
25	PVS-025	Dial Control Shaft		1
26	PVS-026	Spring Pin	3x12	2
27	PVS-027	Dial Wheel		1
28	PVS-028	Wheel Handle		1
29	PVS-029	Shaft		1
30	PVS-030	Spring Pin	4x35	2
31	PVS-031	Spring Pin	3x25	1
32	PVS-032	Speed Change Chain		1
33	PVS-033	Adjustment Stud		1
34	PVS-034	Sleeve Nut		1
35	PVS-035	Adjustment Stud		1
36	PVS-036	Tilter		1
37	PVS-037	Bushing		2
38	KEY8760	Key	8x7x60	2
39	PVS-039	Regulating Screw		1
40	PVS-040	Spring Pin	4x12	1
41	PVS-041	Washer		1
42	PVS-042	Support		1
43	BB-6010ZZ	Ball Bearing	6010ZZ	2
44	PVS-044	Drive Pulley Assembly		1
45	PVS-045	Steady Pulley		1
46	PVS-046	Bearing Cover		1
47	PVS-047	Brake Lining		1
48	PVS-048	Lock Screw		1
49	PVS-049	Brake Spring		2
50	PVS-050	Lower Housing Cover		1
51	TS-1503051	Hex Socket Cap Screw	M6x20	10
52	PVS-052	Brake Shaft Sleeve		1
53	PVS-053	Brake Lock Shaft		1
54	PVS-054	Brake Lock Block		1
55	TS-1503061	Hex Socket Cap Screw	M6x25	1
56	PVS-056	Snap Ring	S-12	1

Variable Speed Head Assembly

Index No	Part No	Description	Size	Qty
58	PVS-058	Brake Finger Pivot Stud		1
59	PVS-059	Brake Stud		2
60	PVS-060	Snap Ring	S-8	1
61	PVS-061	Nut	5/8"-18NF	1
62	PVS-062	Timing Belt Pulley		1
63	PVS-063	Timing Belt	225L100	1
64	PVS-064	Bearing Housing		1
65	BB-6203ZZ	Ball Bearing	6203ZZ	2
66	PVS-066	Bull Gear		1
67	PVS-067	Counter Shaft		1
68	KEY5515	Key	5x5x15	1
69	KEY5518	Key	5x5x18	1
70	PVS-070	Spindle Pulley Hub		1
71	KEY8720	Key	8x7x20	1
72	KEY8712	Key	8x7x12	1
73	PVS-073	Spindle Gear Hub		1
74	PVS-074	Gear		1
75	PVS-075	Rack Cup		1
76	PVS-076	Washer		1
77	BB-6908ZZ	Ball Bearing	6908ZZ	2
78	PVS-078	Bearing Washer		1
79	PVS-079	Bearing Washer		1
80	PVS-080	Snap Ring	C-62	1
81	PVS-081	Nut		1
82	PVS-082	Housing		1
84	PVS-084	Spring		3
85	PVS-085	Vari-Speed Plate		1
86	PVS-086	Plastic Face Plate		1
87	PVS-087	Gear Shaft Pinion		1
89	PVS-089	Deter Plate		1
90	PVS-090	Bearing Stop		1
91	PVS-091	Spring		1
92	PVS-092	Pinion Block		1
93	TS-1503011	Hex Socket Cap Screw	M5x14	2
94	PVS-094	Pinion Crank		1
95	PVS-095	Cap Nut		1
96	PVS-096	Nut	3/8"	1
98	PVS-098	Wave Washer		1
99	PVS-099	Plastic Ball		2
100	PVS-100	Collar		1
101	PVS-101	Cover		2
102	PVS-102	Spring Shaft		3
103	PVS-103	Washer		1
105	PVS-105	Round Head Screw	3/16"x3/8"	1
106	PVS-106	Snap Ring	S-28	1
109	PVS-109	Lock Washer		1
110	TS-1540041	Nut	M6	1
111	TS-0209051	Hex Socket Cap Screw	3/8"x1"	2
112	PVS-112	Motor		1
113	PVS-113	Round Head Screw	1/8"x1/4"	4
114	PVS-114	Draw Bar		1
115	PVS-115	Draw Bar Washer		1
118	PVS-118	Hex Socket Cap Screw	M5x6	1
121	BB-6024ZZ	Ball Bearing	6204ZZ	1
122	PVS-122	Handle		1

Variable Speed Head Assembly



Head Assembly

Index No	Part No	Description	Size	Qty
1	TS-1503031	Hex Socket Cap Screw	M6x12	1
2	B-2	Washer		1
3	B-3	Feed Bevel Pinion		1
4	B-4	Worm Gear Shaft Sleeve		1
5	B-5	Bushing		1
6	TS-1522011	Set Screw		1
8	B-8	Worm Gear		1
10	KEY3312	Key	3x312	1
12	TS-1504031	Hex Socket Cap Screw	M8x16	1
13	B-13	Washer		1
14	KEY3308	Key	3x3x8	2
15	B-15	Bevel Gear		1
16	B-16	Feed Engage Pin		1
17	1050B-17	Worm Gear Cradle		1
18	B-18	Worm Gear Cradle Shaft		1
19	1050B-19	Shaft Sleeve		1
20	B-20	Gear Shaft Plunger		2
21	B-21	Spring		2
22	1050B-22	Spring Pin	3x20	2
23	B-23	Shift Crank		2
24	B-24	Black Plastic Ball		3
25	TS-1503010	Hex Socket Cap Screw	M5/12	3
27	B-27	Bushing		1
28	B-28	Gear		1
29	KEY3345	Key	3x3x45	1
31	1050B-31	Gear Shaft		1
32	1050B-32	Snap Ring	S-16	1
33	1050B-33	Bevel Gear Bushing		1
34	1050B-34	Spacer		1
36	1050B-36	Gear		1
39	TS-1540031	Nut	M5	1
40	1050B-40	Feed Drive Gear		1
41	1050B-41	Needle Bearing		1
42	1050B-42	Bushing		1
43	1050B-43	Worm Gear		1
44	B-44	Bushing		1
47	B-47	Washer		1
48	B-48	Bushing		2
49	B-49	Bevel Gear		2
50	B-50	Feed Reverse Clutch		1
54	TS-1503061	Hex Socket Cap Screw	M6x25	1
55	B-55	Reverse Clutch Rod		1
56	B-56	Spring Pin	3x20	1
57	B-57	Feed Worm Shaft		1
58	TS-1523011	Set Screw	M6x6	1
59	B-59	Spring Pin	3x12	2
60	B-60	Chip Guards		1
61	TS-1522031	Set Screw	M5x10	1
62	KEY3315	KEY	3x3x15	2
63	B-63	Feed Gear Shift Fork		1
64	B-64	Gear Shift Crank		1
66	B-66	Cluster Gear Cover		1
67	TS-1502031	Hex Socket Cap Screw	M5x12	4
73	TS-1502081	Hex Socket Cap Screw	M5x35	2
74	B-74	Clutch Ring Pin		2
75	B-75	Clutch Ring		1

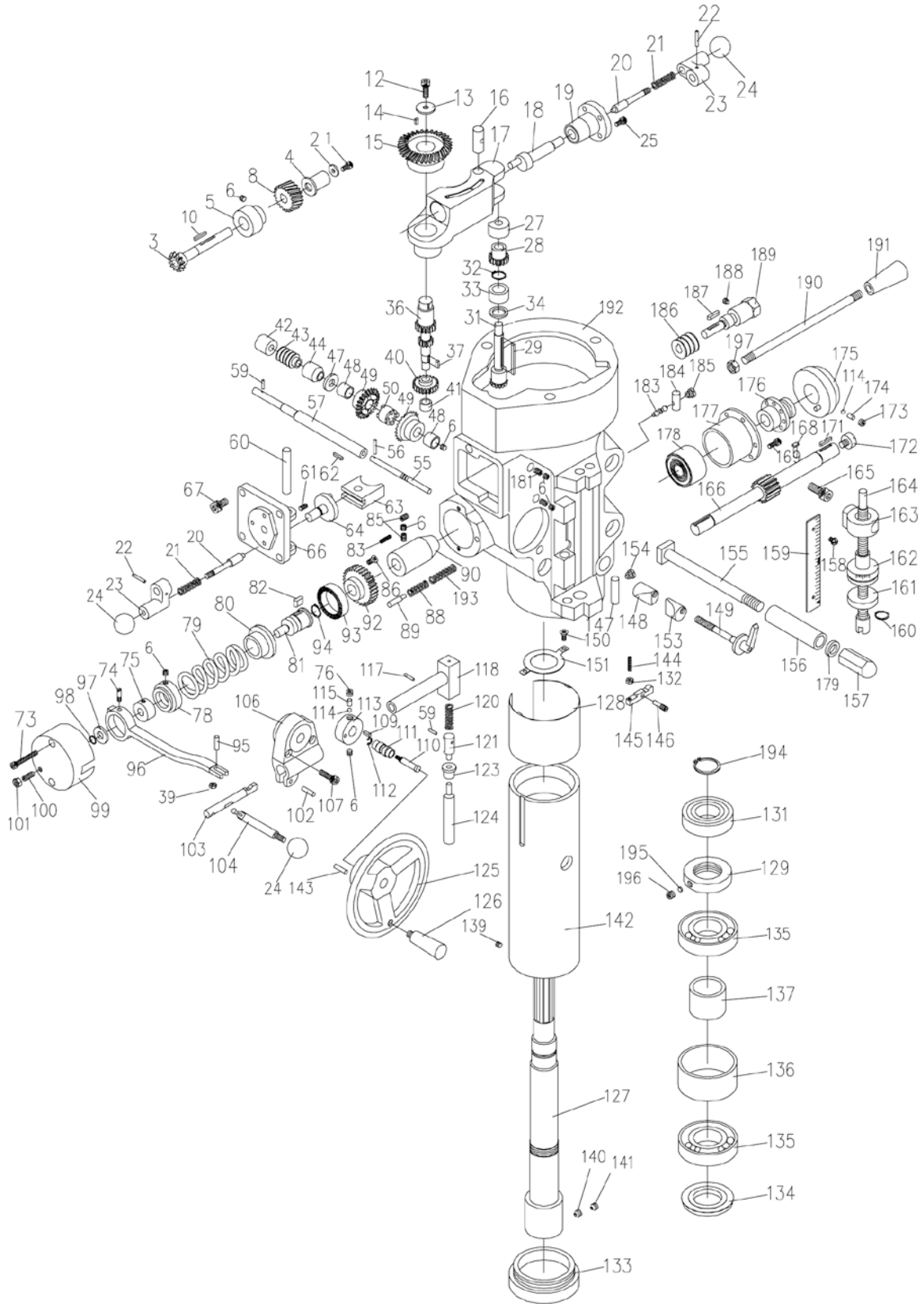
Head Assembly

Index No	Part No	Description	Size	Qty
76	TS-1523021	Set Screw	M6x8	1
78	B-78	Clutch Locknut		1
79	B-79	Safety Clutch Locknut		1
80	B-80	Overload Clutch		1
81	B-81	Overload Clutch Sleeve		1
82	KEY5813	Key	5x8x13	1
83	B-83	Hex Socket Head Bolt		3
85	TS-1523011	Set Screw	M6x6	2
86	B-86	Cross Plate Screw	M4x16	4
88	B-88	Spring		1
89	B-89	Spring Plunger		1
90	B-90	Bushing		1
92	B-92	Worm Gear		1
93	B-93	Clutch Ring		1
94	B-94	Snap Ring	S-10	1
95	TS-1502051	Hex Socket Cap Screw	M5x20	1
96	B-96	Clutch Trip Lever		1
97	B-97	Clutch Washer		1
98	B-98	Snap Ring	S-10	1
99	B-99	Clutch Arm Cover		1
100	C-19-1	Set Screw	M6x16	1
101	TS-1540041	Nut	M6	1
102	B-102	Spring Pin	5x18	1
103	B-103	Cam Rod		1
104	B-104	Trip Handle		1
106	B-106	Feed Trip Bracket		1
107	TS-1503051	Hex Socket Cap Screw	M6x20	1
108	TS-1523031	Set Screw	M6x10	1
109	KEY3310	Key	3x3x10	1
110	B-110	Knob Stud		1
111	B-111	Reverse Knob		1
112	B-112	E-Ring	E-6	1
113	B-113	Handle Wheel Clutch		1
114	B-114	Steel Ball	3/16"	2
115	B-115	Compression Spring		2
116	B-116	Set Screw	M8x6	1
117	B-117	Spring Pin	3x15	1
118	B-118	Cam Rod Sleeve		1
119	B-119	Spring Pin	3x12	1
120	B-120	Compression Spring		1
121	B-121	Trip Plunger		1
123	B-123	Bushing		4
124	B-124	Feed Trip Plunger		1
125	B-125	Handle Wheel		1
126	B-126	Handle		1
127	B-127	Spindle		1
128	B-128	Quill Skirt		1
129	B-129	Locknut		1
131	BB-6206ZZ	Ball Bearing	6206ZZ	1
132	B-132	Nut	M4	1
133	B-133	Nose Piece		1
134	B-134	Spindle Dirt Shield		1
135	BB-7207C	Angular Bearing	7207	1
136	B-136	Spacer		1
137	B-137	Spacer		1
138	BB-7207C	Angular Bearing	7207	1

Head Assembly

Index No	Part No	Description	Size	Qty
139	B-139	Set Screw		1
140	B-140	Set Screw		1
141	TS-1523011	Set Screw	M6x6	1
142	B-142	Quill		1
143	B-143	Spring Pin	3x16	1
144	B-144	Set Screw	M4x20	1
145	B-145	Feed Trip Lever		1
146	B-146	Trip Lever Pin		1
147	B-147	Indicator Rod		1
148	B-148	Quill Lock Sleeve		1
149	B-149	Lock Handle		1
150	B-150	Round Head Screw	M5x8	2
151	B-151	Washer	M5	2
153	B-153	Quill Lock Sleeve		1
154	B-154	Indicator Rod Screw		1
155	B-155	T-Bolt		4
156	B-156	Spacer		4
157	B-157	Adaptor Nut		4
158	B-158	Round Head Screw		2
159	B-159	Micrometer Scale		1
160	B-160	Snap Ring	S-16	1
161	B-161	Quill Micro-Stop Nut		1
162	B-162	Quill Micro-Stop Nut		1
163	B-163	Quill Stop Knob		1
164	B-164	Quill Micro-Stop Nut		1
165	B-165	Round Head Screw	M10x15	1
166	B-166	Quill Pinion Shaft		1
168	B-168	Pin		1
169	TS-1503010	Hex Socket Cap Screw	M5x12	2
171	KEY3320	Key	3x3x20	1
172	B-172	Pinion Shaft Hub Screw		1
173	B-173	Set Screw	5/16"x1/4"	1
174	B-174	Compression Spring		1
175	B-175	Handle Hub		1
176	B-176	Hub Sleeve		1
177	B-177	Spring Cover		1
178	B-178	Clock Spring		1
179	B-179	Washer		4
181	TS-1523041	Set Screw	M6x12	2
183	B-183	Reverse Trip Ball Lever		1
184	B-184	Reverse Trip Plunger		1
185	B-185	Trip Ball Lever Screw		1
186	B-186	Worm Gear		1
187	KEY4418	Key	4x4x18	1
188	B-188	Set Screw		1
189	B-189	Worm Shaft		1
190	B-190	Pinion Shaft Hub Handle		1
191	B-191	Black Plastic Ball		1
192	B-192	Quill Housing		1
193	B-193	Compression Spring		1
194	B-194	Snap Ring	S-30	1
195	B-195	Bush		1
196	TS-1523011	Set Screw	M6x6	1
197	B-197	Nut		1

Head Assembly



Base Assembly

Index No	Part No	Description	Size	Qty
1	JTM1050C-11	Hook		1
2	1050C-10	Ram		1
3	1050C-1	Worm Gear		1
3-1	1050C-14	Spring Pin		1
3-2	TS-1504061	Hex Socket Cap Screw	M8*30	2
4	1050C-4	Lock Nut		1
5	1050C-3	Adaptor Scale		1
6	1050C-16	Rivet		6
7	C-120	Ram Pinion		1
7-1	JTM1054R-7-1	Crank		1
7-2	JTM1054R-7-2	Plastic Ball		1
8	C-124	Turret		1
9	C-111	Gib		1
10	C-127	Bolt		4
10-1	C-123	Spring Washer		4
11	C-128	Set Screw		1
12	C-38A	Lock Handle	1/2"x25L	2
13	C-110	Set Screw	3/8"X60	2
13-1	C-109	Hex Nut	3/8"	2
13-2	C-126	Ram Lock Plunger		2
14	JTM1054R-14	Scale Label		1
15	JTM1055-B15	Rivet		4
16	C-118	Spider		1
17	JTM1055-B17N	Base (s/n 120xxxx and higher)		1
18	JTM1055-B18	Cover		1
18-1	JTM1055-B18-1	Round Head Screw	M5x10	4
19	C-132A	Breaker Box (W/#21)		1
20	C-133	Beaker		1
21	C-134	Breaker Box Cover		1
	C-133A	Breaker Box Assembly		1
22	JTM1055-B22	Strainer		1
23	JTM1055-B23	Lead Screw Housing		1
23-1	TS-1503041	Hex Socket Cap Screw	M6x16	3
24	JTM1055-B24	Flange		1
24-1	TS-1503061	Hex Socket Cap Screw	M6x35	2
25	JTM1055-B25	Lead Screw		1
25-1	JTM1055-B25-1	Key	5x5x20	1
26	JTM1055-B26	Flange		1
26-1	TS-1503051	Hex Socket Cap Screw	M6x20	3
27	JTM1055-B27	Ball Bearing	6204ZZ	3
28	JTM1055-B28	Bevel Gear		1
29	JTM1055-B29	Washer		1
30	JTM1055-B30	Hex Nut		1
31	JTM1055-B31	Bearing Cover		1
32	JTM1055-B32	Bearing Stop		1
33	JTM1055-B33	Dial Holder		1
34	JTM1055-B34	Dial Ring		1
35	JTM1055-B35	Dial Lock Nut		1
36	JTM1055-B36	Gear Shear Clutch		1
37	JTM1055-B37	Elevating Crank		1
38	JTM1055-B38	Handle		1
39	JTM1055-B39N	Knee (s/n 120xxxx and higher)		1
40	JTM1055-B40	Knee Front Cover		1
40-1	JTM1055-B40-1	Cross Head Screw	M5x20	4
41	JTM1055-B41	Shaft		1

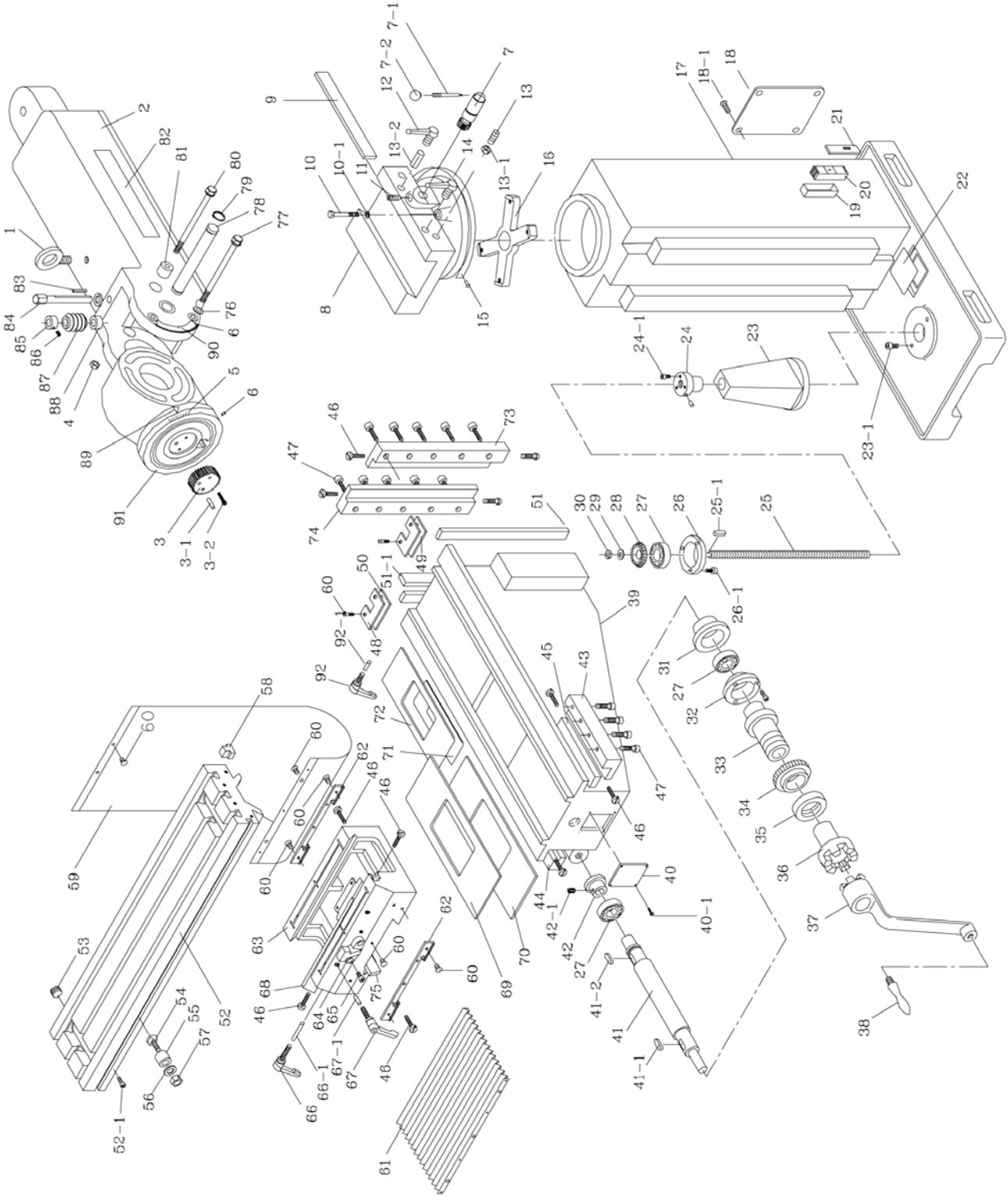
Base Assembly

Index No	Part No	Description	Size	Qty
41-1	JTM1055-B41-1	Key	3x3x10	1
41-2	JTM1055-B41-2	Key	4x4x16	1
42	JTM1055-B42	Bevel Gear		1
42-1	JTM1055-B42-1	Set Screw	M6x20	1
43	JTM1055-B43	Gib Holder-R		1
44	JTM1055-B44	Gib Holder-L		1
45	JTM1055-B045	Gib		2
46	JTM1055-B46	Adjusting Screw		12
47	JTM1055-B47	Hex Socket Cap Screw	M12x35	18
48	JTM1055-B48	Wiper Cover		2
49	JTM1055-B49	Wiper-R		1
50	JTM1055-B50	Wiper-L		1
51	JTM1055-B51N	Gib (s/n 120xxxx and higher)		2
51-1	JTM1055-B51-1N	Gib (s/n 120xxxx and higher)		1
52	JTM1055-B52	Table		1
52-1	TS-1502061	Hex Socket Cap Screw	M5x25	2
53	JTM1055-B53	Plug		2
54	JTM1055-B54	T-Bolt		2
55	JTM1055-B55	Bushing		2
56	JTM1055-B56	Flat Washer		2
57	JTM1055-B57	Hex Nut		2
58	JTM1055-B58	Rubber T-Nut		6
59	JTM1055-B59	Chip Guard		1
60	JTM1055-B60	Screw		22
61	JTM1055-B61	Dust Protective Cover		1
62	JTM1055-B62N	Wiper (s/n 120xxxx and higher)		2
63	JTM1055-B63	Saddle		1
64	JTM1055-B64	Stop Block		1
65	JTM1055-B65	Hex Socket Cap Screw		2
66	JTM1055-B66	Handle		2
66-1	JTM1055-B66-1	Brass Block		2
67	JTM1055-B67	Handle		2
67-1	JTM1055-B67-1	Brass Block		2
68	JTM1055-B68N	Gib (s/n 120xxxx and higher)		1
69	JTM1055-B69	Chip Guard-XL		1
70	JTM1055-B70	Chip Guard-L		1
71	JTM1055-B71	Chip Guard-M		1
72	JTM1055-B72	Chip Guard-S		1
73	JTM1055-B73	Gib Holder-R		1
74	JTM1055-B74	Gib Holder-L		1
75	JTM1055-B75N	Gib (s/n 120xxxx and higher)		1
	JTM1055-TBC	Tool Box complete(not shown)		1
	JTM1055-LP	Leveling Pad(not shown)		4
	JTM1055-LB	Leveling Bolt w/Nut(not shown)		4
	JTM1055-JS	JET Striping(not shown)		1
	JTM1055-ID	ID & Warning Label(not shown)		1
76	C-18	Washer		2
77	C-19	Locking Bolt		2
78	JTM1050C-17	Adaptor Pivot Stud		1
79	JTM1050C-79	C-Ring		1
80	C-19	Locking Bolt		1
81	C-19-1	Collar		1
82	JTM1054R-82	Name Plate		1
83	KEY5550	KEY	5*5*50	1
84	1050C-8	Worm Shaft		1

Base Assembly

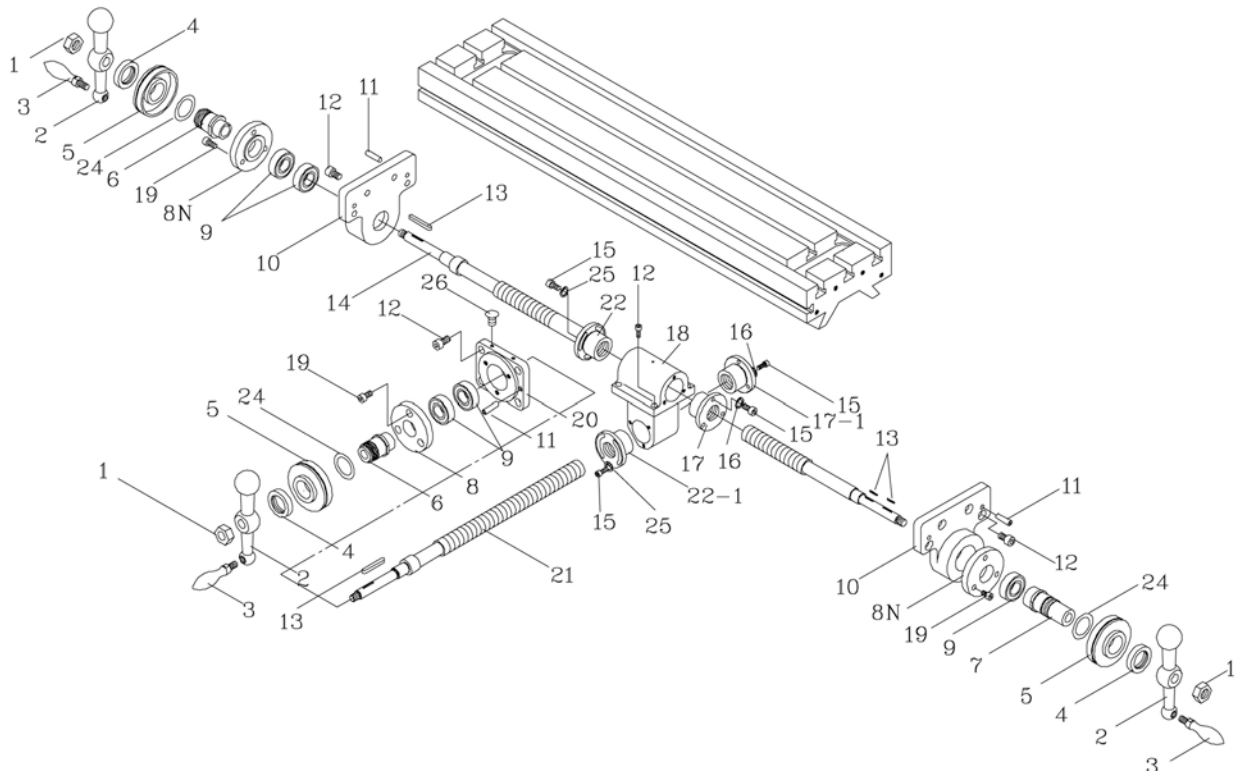
Index No	Part No	Description	Size	Qty
85	C-7-1	Washer		1
86	JTM1050-C86	Set Screw	M6*8L	1
87	1050C-6	Worm Gear		1
88	1050C-12	Collar		1
89	JTM-1050C-89	Index Plate		1
90	JTM-1050C-15	Angle Plate	90°	1
91	1050C-2	Ram Adaptor		1
92	JTM1055-B12	Lock Handle	1/2"x40L	2
92-1	JTM1055-B12-1	Brass Block		2
	STRIPE-1-3/4	JET Striping (not shown)	1-3/4" W	per ft.

Base Assembly



Lead Screw Assembly

Index No	Part No	Description	Size	Qty
1	JTM1055-L01	Nut.....	1/2-20UNF	3
2	JTM1055-L02	Ball Crank.....		3
3	JTM1055-L03	Handle.....		3
4	JTM1055-L04	Dial Lock Nut.....		3
5	JTM1055-L05	Dial.....		3
6	JTM1055-L06	Dial Holder.....		2
7	JTM1055-L07	Dial Holder-(left).....		1
8	JTM1055-L08	Bearing Stop for Y-Axis.....		1
8N	JTM1055-L08N	Bearing Stop for X-Axis (s/n 120xxx and higher).....		2
9	BB-6204ZZ	Ball Bearing.....		5
10	JTM1055-L10N	Extended Bearing Bracket (s/n 120xxx and higher).....		2
11	JTM1055-L11	Spring Pin.....	M5X20	6
12	TS-1505031	Hex Socket Cap Screw.....	M10X25	16
13	JTM1055-L13	Key.....	3X3X25	4
14	JTM1055-L14N	Lead Screw for Ext. Bearing Bracket (s/n 120xxx and higher).....		1
15	TS-1503041	Hex Socket Cap Screw.....	M6X25	8
16	TS-1550041	Washer.....	M6	2
17	JTM1055-L17	Feed Screw Nut for X axis.....		1
17-1	JTM1055-L17-1	Feed Screw Nut for Y axis.....		1
18	JTM1055-L18	Feed Nut Bracket.....		1
19	TS-1514011	Hex Socket Cap Screw.....	M6X12	9
20	JTM1055-L20	Cross Feed Bearing Bracket.....		1
21	JTM1055-L21	Cross Feed Screw.....		1
22	JTM1055-L22	Adjustable Feed Nut for X axis.....		1
22-1	JTM1055-L22-1	Adjustable Feed Nut for Y axis.....		1
24	JTM1055-L24	Spacer.....		3
25	JTM1055-L25	Lock Washer.....	M6	2
26	JTM1055-L26	Cross Head Screw.....		2

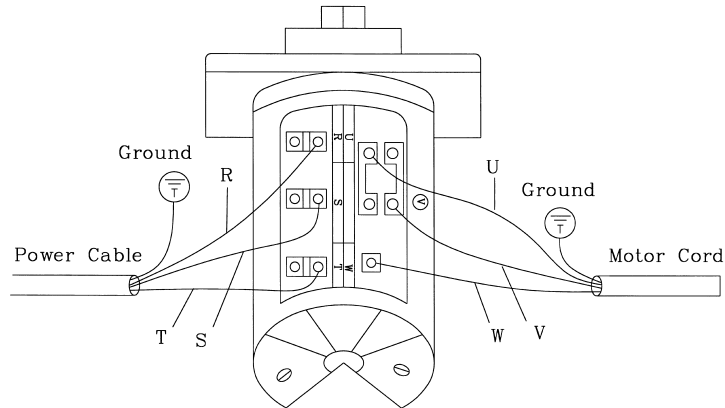


One Shot Lubrication System

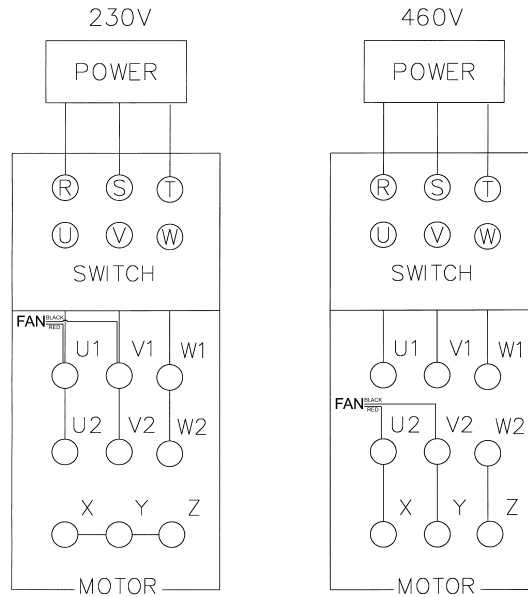
Index No	Part No	Description	Size	Qty
1	JTM1055-CLA	Lubricating Pump		1
2	ALMP-04	Aluminum Pipe	13.5x450L	1
3	A-8	Oil Regulating Distributor		1
4	JTM1055-A4	Oil Regulating Distributor		1
5	A-5	Flexible Steel Tube	4X550	1
6	PH-4011	Elbow joint		2
7	PI-401	Elbow joint		8
8	PA-4	Thimble Nut		26
9	PB-4	Thimble		26
10	PG-004	Union		1
11	TS-1503031	Hex Socket Cap Screw	M6X12	4
12	TS-1502061	Hex Socket Cap Screw	M5X25	4
13	PD-401	Straight Joint		1
14	A-14	Nylon Piece	4X700	1

Wiring

Forward/Reverse Switch



230V and 460V Motor Configurations



Ordering Replacement Parts

To order parts or reach our service department, call 800-274-6848 Monday through Friday (see our website for business hours, www.jettools.com). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.



427 New Sanford Road
LaVergne, Tennessee 37086
Phone: 800-274-6848
www.jettools.com