



# Operating Instructions and Parts Manual Variable Speed Vertical Mill

Model JTM-1055



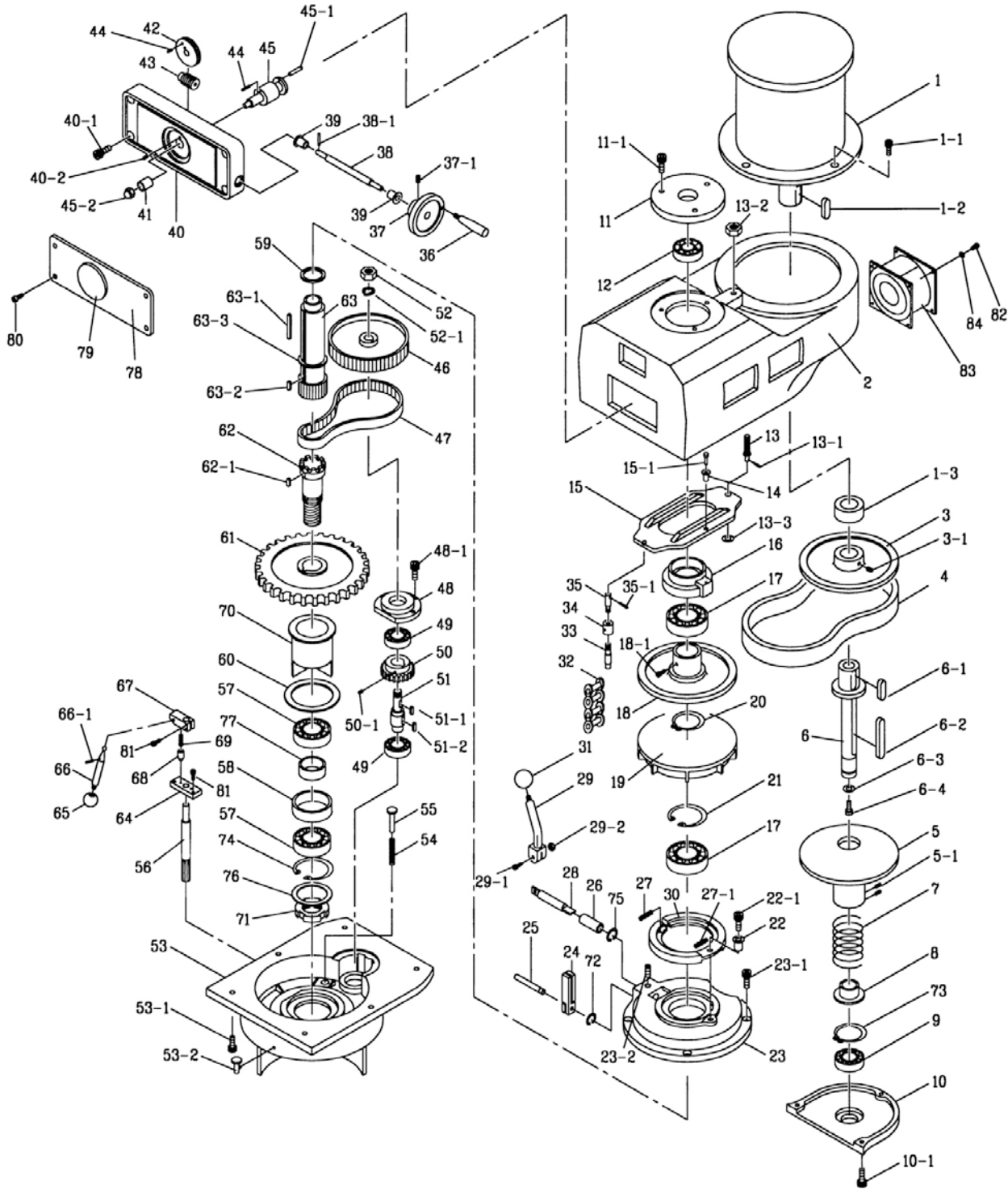
*For serial no. 120xxxx and higher*

## **JET**

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**Part No. M-690055**  
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### 12.1.1 Variable Speed Head – Exploded View



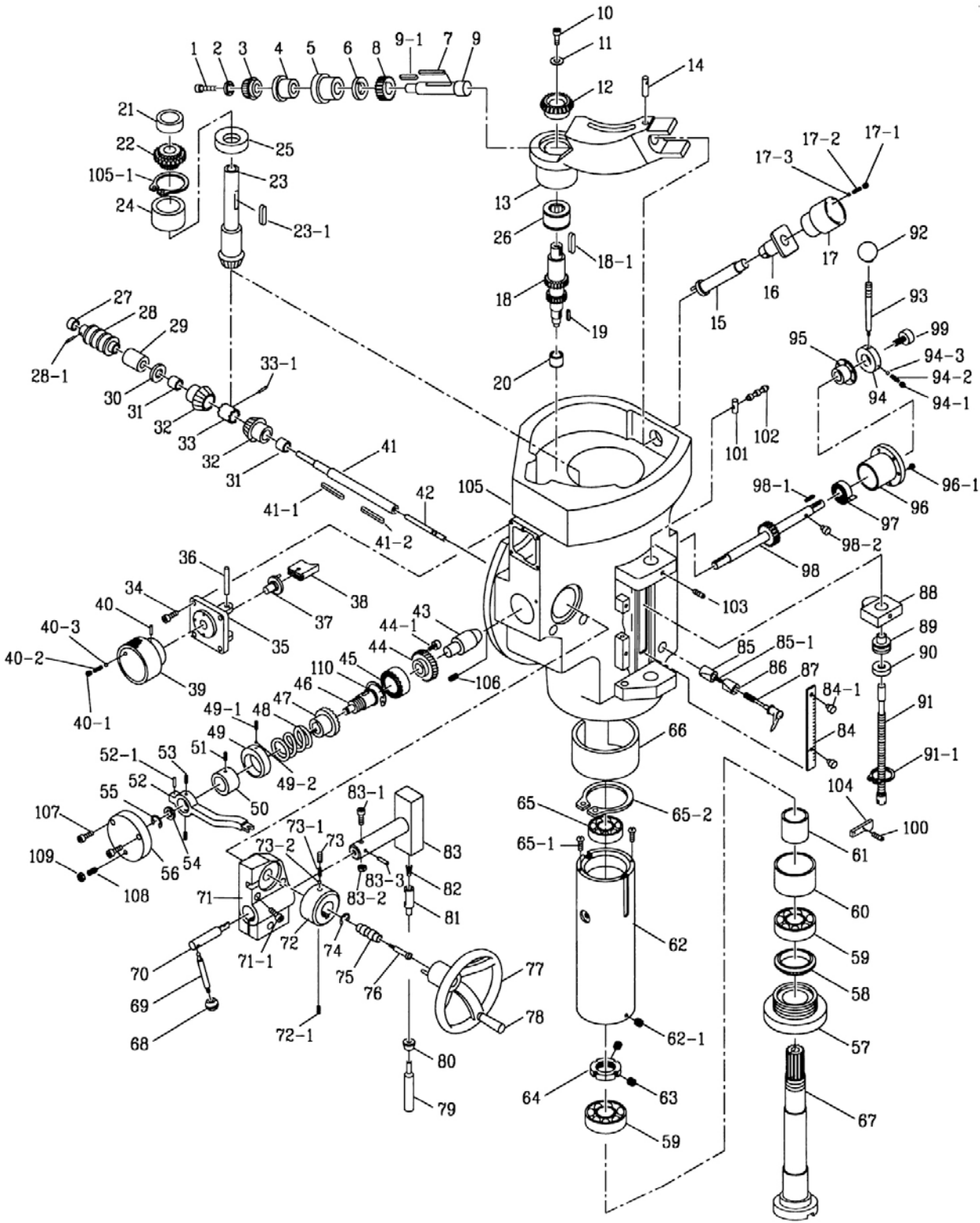
## 12.1.2 Variable Speed Head – Parts List

Index No	Part No	Description	Size	Qty
1	JTM1055-V01	Motor		1
1-1	TS-0209051	Hex Socket Cap Screw	3/8"x1"	3
1-2	JTM1055-V01-2	Key	6x7x30	1
1-3	JTM1055-V01-3	Spacer		1
2	JTM1055-V02	Housing		1
3	JTM1055-V03	Motor Pulley		1
3-1	JTM1055-V03-1	Set Screw		1
4	JTM1055-V04	Belt	900VC3830	1
5	JTM1055-V05	Motor Pulley		1
5-1	JTM1055-V05-1	Screw		2
6	JTM1055-V06	Shaft		1
6-1	JTM1055-V06-1	Key	7x6x30	1
6-2	JTM1055-V06-2	Key	7x7x55	1
6-3	JTM1055-V06-3	Flat Washer	M8	1
6-4	TS-1504111	Hex Socket Cap Screw	M8x55	1
7	JTM1055-V07	Spring		1
8	JTM1055-V08	Bushing		1
9	BB-6005ZZ	Ball Bearing	6005ZZ	1
10	JTM1055-V10	Motor Pulley Cover		1
10-1	TS-1502041	Hex Socket Cap Screw	M5x16	3
11	JTM1055-V11	Bearing Cover		1
11-1	TS-10503051	Hex Socket Cap Screw	M6x20	3
12	BB-6009ZZ	Ball Bearing	6009ZZ	1
13	JTM1055-V13	Regulating Screw		1
13-1	JTM1055-V13-1	Spring Pin		1
13-2	JTM1055-V13-2	Hex Nut		1
13-3	JTM1055-V13-3	Washer		1
14	JTM1055-V14	Bushing		2
15	JTM1055-V15	Tilter		1
15-1	JTM1055-V15-1	Screw		2
16	JTM1055-V16	Support		1
17	BB-6012ZZ	Ball Bearing	6012ZZ	2
18	JTM1055-V18	Drive Pulley		1
18-1	JTM1055-V18-1	Drive Pulley Screw		1
19	JTM1055-V19	Steady Pulley		1
20	JTM1055-V20	C-Clip	S50	1
21	JTM1055-V21	C-Clip	R95	1
22	JTM1055-V22	Bushing		1
22-1	TS-1052021	Hex Socket Cap Screw	M5x6	1
23	JTM1055-V23	Lower Housing Cover		1
23-1	TS-1504051	Hex Socket Cap Screw	M8x25	3
23-2	JTM1055-V23-2	Set Screw	M6x6	1
24	JTM1055-V24	Brake Stud		2
25	JTM1055-V25	Brake Finger Pivot Stud		1
26	JTM1055-V26	Brake Shaft Sleeve		1
27	JTM1055-V27	Brake Spring		1
27-1	JTM1055-V27-1	Brake Spring (short)		1
28	JTM1055-V28	Brake Lock Shaft		1
29	JTM1055-V29	Brake Lock Handle		1
29-1	TS-1503061	Hex Socket Cap Screw	M6x25	1
29-2	JTM1055-V29-2	Hex Nut	M6	1
30	JTM1055-V30A	Brake Assembly (Includes: #27, 27-1, 22, 22-1)..		1
31	JTM1055-V31	Plastic Ball		1
32	JTM1055-V32	Chain		1
33	JTM1055-V33	Adjustment Stud		1
34	JTM1055-V34	Sleeve Nut		1

Index No	Part No	Description	Size	Qty
35	JTM1055-V35	Adjustment Stud		1
35-1	JTM1055-V35-1	Pin		1
36	JTM1055-V36	Wheel Handle		1
37	JTM1055-V37	Wheel		1
37-1	TS-1523031	Set Screw	M6x8	1
38	JTM1055-V38	Dial Control Shaft		1
38-1	JTM1055-V38-1	Spring Pin		1
39	JTM1055-V39	Bushing		2
40	JTM1055-V40	Dial Housing		1
40-1	TS-1502081	Hex Socket Cap Screw	M5x35	3
40-2	JTM1055-V40-2	Screw		1
41	JTM1055-V41	Bushing		1
42	JTM1055-V42	Worm Gear		1
43	JTM1055-V43	Worm		1
44	JTM1055-V44	Spring Pin		2
45	JTM1055-V45	Shaft		1
45-1	JTM1055-V45-1	Spring Pin		1
45-2	JTM1055-V45-2	Nut		1
46	JTM1055-V46	Timing Belt Pulley		1
47	JTM1055-V47	Belt	8M560	1
48	JTM1055-V48	Bearing Retainer		1
48-1	TS-1502051	Hex Socket Cap Screw	M5x20	1
49	JTM1055-V49	Ball Bearing	6203-2RS	2
50	JTM1055-V50	Bull Gear		1
50-1	JTM1055-V50-1	Set Screw	M8x6	1
51	JTM1055-V51	Counter Shaft		1
51-1	JTM1055-V51-1	Key	5x5x15	1
51-2	JTM1055-V51-2	Key	5x5x18	1
52	JTM1055-V52	Nut	5/8"	1
52-1	TS-0720131	Lock Washer	5/8"	1
53	JTM1055-V53	Lower Housing		1
53-1	TS-1504041	Hex Socket Cap Screw	M8x20	6
53-2	JTM1055-V53-2	Oil Cup		1
54	JTM1055-V54	Spring		3
55	JTM1055-V55	Spring Shaft		3
56	JTM1055-V56	Pinion Gear		1
57	JTM1055-V57	Ball Bearing	6910ZZ	2
58	JTM1055-V58	Spacer		1
59	JTM1055-V59	Spacer		1
60	JTM1055-V60	Spacer		1
61	JTM1055-V61	Spindle Gear		1
62	JTM1055-V62	Spindle Gear Hub		1
62-1	JTM1055-V62-1	Key	8x7x12	1
63	JTM1055-V63	Spindle Pulley Hub		1
63-1	JTM1055-V63-1	Key	8x7x60	1
63-2	JTM1055-V63-2	Key	8x8x20	1
63-3	JTM1055-V63-3	Spacer		1
64	JTM1055-V64	Deter Plate		1
65	JTM1055-V65	Plastic Ball		1
66	JTM1055-V66	Pinion Crank		1
66-1	JTM1055-V66-1	Spring Pin		1
67	JTM1055-V67	Pinion Block		1
68	JTM1055-V68	Detent		1
69	JTM1055-V69	Spring		1
70	JTM1055-V70	Rack Cup		1
71	JTM1055-V71	Lock Nut		1
72	JTM1055-V72	C-Clip	S8	1
73	JTM1055-V73	C-Clip	S25	1

Index No	Part No	Description	Size	Qty
74	JTM1055-V74	C-Clip	R72	1
75	JTM1055-V75	C-Clip	S12	1
76	JTM1055-V76	Spacer		1
77	JTM1055-V77	Spacer		1
78	JTM1055-V78	Face Plate		1
79	JTM1055-V79	Dial Plate		1
80	JTM1055-V80	Screw	1/8"x1/4"	4
81	TS-1502041	Hex Socket Cap Screw	M5x16	4
82	JTM1055-V82	Screw	1/8"x1"	4
83	JTM1055-V83	Fan Assembly		1
84	JTM1055-V84	Flat Washer	1/8"	1
	JTM1055-WBC	Wiring Box Cover (not shown)		1
	JTM1055-PSC	Plastic Side Cover (not shown)		2
	JTM1055-JET	JET Plaque (not shown)		1

### 12.2.1 Head Assembly – Exploded View



## 12.2.2 Head Assembly – Parts List

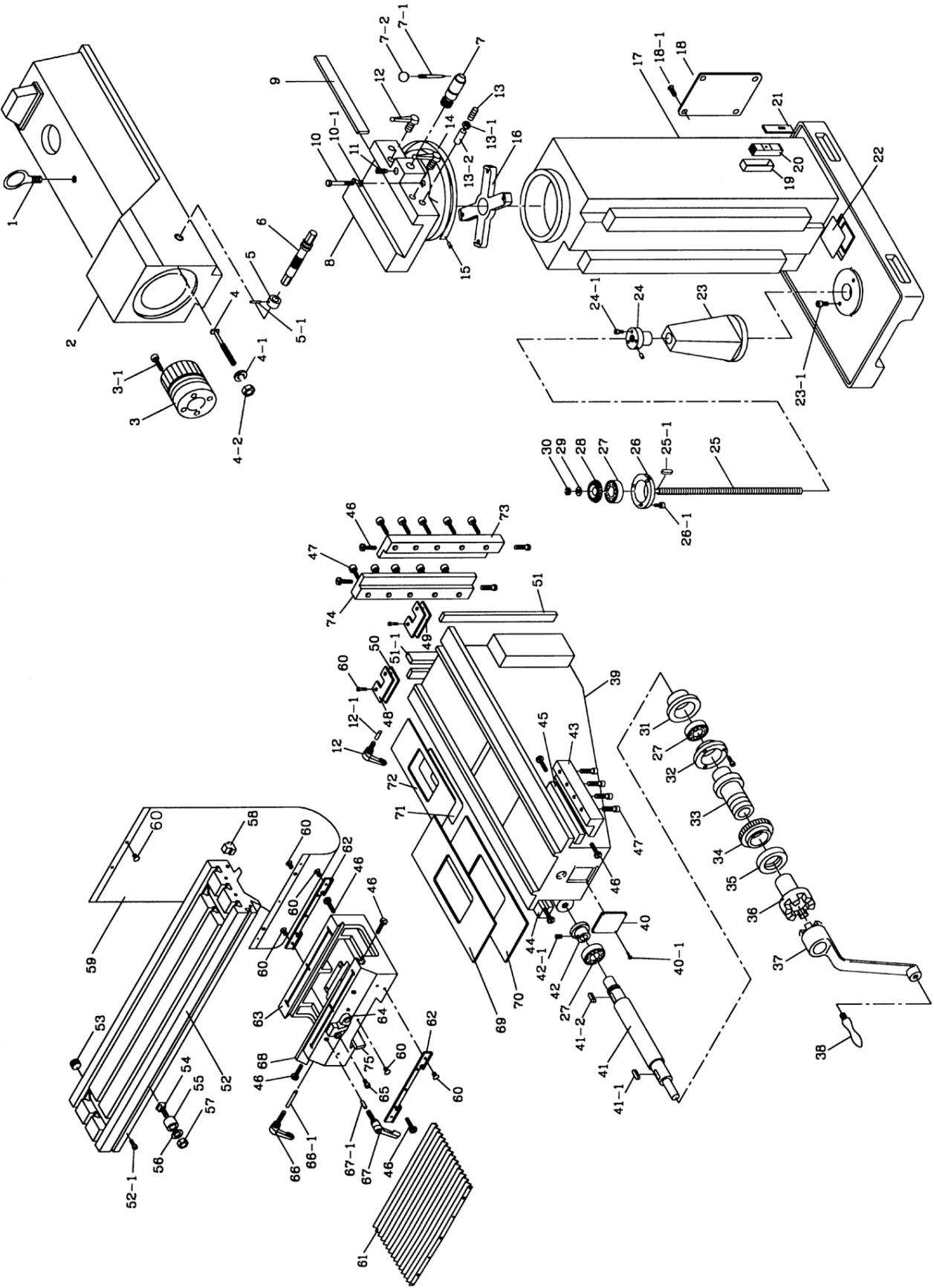
Index No	Part No	Description	Size	Qty
1	JTM1055-H01	Hex Socket Cap Screw	M5X12	1
2	JTM1055-H02	Washer		1
3	JTM1055-H03	Bevel Gear		1
4	JTM1055-H04	Shaft Sleeve		1
5	JTM1055-H05	Bushing		1
6	JTM1055-H06	Spacer		1
7	JTM1055-H07	Key	3X3X20	1
8	JTM1055-H08	Gear		1
9	JTM1055-H09	Shaft		1
9-1	JTM1055-H09-1	Key	3x3x10	1
10	JTM1055-H10	Hex Socket Cap Screw	5/16"X1/2"	1
11	JTM1055-H11	Washer		1
12	JTM1055-H12	Bevel Gear		1
13	JTM1055-H13	Worm Gear Cradle		1
14	JTM1055-H14	Feed Engage Pin		1
15	JTM1055-H15	Worm Gear Cradle Shaft		1
16	JTM1055-H16	Shaft Sleeve		1
17	JTM1055-H17	Knob		1
17-1	JTM1055-H17-1	Set Screw	M6x8	1
17-2	JTM1055-H17-2	Spring		1
17-3	JTM1055-H17-3	Steel Ball		1
18	JTM1055-H18	Gear Shaft		1
18-1	JTM1055-H18-1	Key	5x5x8	1
19	JTM1055-H19	Key	5x5x12	1
20	JTM1055-H20	Needle Bearing	BA78Z	1
21	JTM1055-H21	Bushing		1
22	JTM1055-H22	Gear		1
23	JTM1055-H23	Shaft (w/bevel gear)		1
23-1	JTM1055-H23-1	Key	4x4x45	1
24	JTM1055-H24	Bevel Gear Bushing		1
25	JTM1055-H25	Spacer		1
26	JTM1055-H26	Needle Bearing	TA2620Z	1
27	JTM1055-H27	Bushing		1
28	JTM1055-H28	Worm Gear		1
28-1	JTM1055-H28-1	Spring Pin		1
29	JTM1055-H29	Bushing		1
30	JTM1055-H30	Washer		1
31	JTM1055-H31	Bushing		2
32	JTM1055-H32	Bevel Gear		2
33	JTM1055-H33	Feed Reverse Clutch		1
33-1	JTM1055-H33-1	Spring Pin		1
34	TS-1513011	Hex Socket Cap Screw	M5X10	4
35	JTM1055-H35	Cluster Gear Cover		1
36	JTM1055-H36	Shaft		1
37	JTM1055-H37	Gear Shift Crank		1
38	JTM1055-H38	Feed Gear Shift Fork		1
39	JTM1055-H39	Knob		1
40	JTM1055-H40	Set Screw	M6x6	1
40-1	JTM1055-H40-1	Set Screw	M6x6	1
40-2	JTM1055-H40-2	Spring		1
40-3	JTM1055-H40-3	Steel Ball		1
41	JTM1055-H41	Feed Worm Shaft		1
41-1	JTM1055-H41-1	Key	5x5x15	1
41-2	JTM1055-H41-2	Key	5x5x10	1
42	JTM1055-H42	Reverse Clutch Rod		1
43	JTM1055-H43	Brass Shaft		1

Index No	Part No	Description	Size	Qty
44	JTM1055-H44	Worm Gear		1
44-1	JTM1055-H44-1	Round Head Screw		3
45	JTM1055-H45	Clutch Ring		1
46	JTM1055-H46	Overload Clutch Sleeve		1
47	JTM1055-H47	Overload Clutch		1
48	JTM1055-H48	Spring		1
49	JTM1055-H49	Clutch Lockout		1
49-1	JTM1055-H49-1	Set Screw	M6x8	1
49-2	JTM1055-H49-2	Brass Piece		1
50	JTM1055-H50	Brass Bushing		1
51	JTM1055-H51	Set Screw		1
52	JTM1055-H52	Clutch Trip Lever		1
52-1	JTM1055-H52-1	Spring Pin		1
53	JTM1055-H53	Flat Head Screw		2
54	JTM1055-H54	Clutch Washer		1
55	JTM1055-H55	E-Ring		1
56	JTM1055-H56	Clutch Arm Cover		1
57	JTM1055-H57	Nose Piece		1
58	JTM1055-H58	Spindle Dirt Shield		1
59	JTM1055-H59	Angular Bearing	7010	2
60	JTM1055-H60	Spacer		1
61	JTM1055-H61	Spacer		1
62	JTM1055-H62	Quill		1
62-1	JTM1055-H62-1	Set Screw	M5x5	1
63	JTM1055-H63	Set Screw	M6x6	2
64	JTM1055-H64	Lock Nut		1
65	JTM1055-H65	Ball Bearing	6008ZZ	1
65-1	JTM1055-H65-1	Cross Head Screw		2
65-2	JTM1055-H65-2	C-Clip	S37	1
66	JTM1055-H66	Quill Skirt		1
67	JTM1055-H67	Spindle		1
68	JTM1055-H68	Black Plastic Ball		1
69	JTM1055-H69	Trip Handle		1
70	JTM1055-H70	Cam Rod		1
71	JTM1055-H71	Feed Trip Bracket		1
71-1	TS-1513051	Hex Socket Cap Screw	M5x25	2
72	JTM1055-H72	Hand Wheel Clutch		1
72-1	JTM1055-H72-1	Set Screw	M6x6	1
73	JTM1055-H73	Set Screw	M8x6	1
73-1	JTM1055-H73-1	Spring		1
73-2	JTM1055-H73-2	Ball		1
74	JTM1055-H74	C-Clip		1
75	JTM1055-H75	Reverse Knob		1
76	JTM1055-H76	Knob Stud		1
77	JTM1055-H77	Handle Wheel		1
78	JTM1055-H78	Handle		1
79	JTM1055-H79	Feed Trip Plunger		1
80	JTM1055-H80	Bushing		1
81	JTM1055-H81	Trip Plunger		1
82	JTM1055-H82	Spring		1
83	JTM1055-H83	Cam Rod Sleeve		1
83-1	TS-1502051	Hex Socket Cap Screw	M5x20	1
83-2	JTM1055-H83-2	Hex Nut		1
83-3	JTM1055-H83-3	Spring Pin		1
84	JTM1055-H84	Micrometer Scale		1
84-1	JTM1055-V84-1	Round Head Screw		2
85	JTM1055-H85	Quill Lock Sleeve (threaded)		1
85-1	JTM1055-H85-1	Spring		1



Index No	Part No	Description	Size	Qty
86	JTM1055-H86	Quill Lock Sleeve		1
87	JTM1055-H87	Lock Handle		1
88	JTM1055-H88	Quill Stop Knob		1
89	JTM1055-H89	Quill Micro-Stop Nut		1
90	JTM1055-H90	Quill Micro-Jam Nut		1
91	JTM1055-H91	Quill Micro-Screw		1
91-1	JTM1055-H91-1	C-Clip		1
92	JTM1055-H92	Plastic Ball		1
93	JTM1055-H93	Handle		1
94	JTM1055-H94	Hub		1
94-1	JTM1055-H94-1	Set Screw	5/16"x3/8"	1
94-2	JTM1055-H94-2	Spring		1
94-3	JTM1055-H94-3	Steel Ball		1
95	JTM1055-H95	Hub Sleeve		1
96	JTM1055-H96	Spring Cover		1
96-1	TS-1502101	Hex Socket Cap Screw	M5x12	1
97	JTM1055-H97	Clock Spring		1
98	JTM1055-H98	Quill Pinion Shaft		1
98-1	JTM1055-H98-1	Key	5x5x25	1
98-2	JTM1055-H98-2	T-Pin		1
99	JTM1055-H99	Pinion Shaft Hub		1
100	JTM1055-H100	Set Screw		1
101	JTM1055-H101	Plunger		1
102	JTM1055-H102	Lever		1
103	JTM1055-H103	Set Screw		1
104	JTM1055-H104	Feed Trip Lever		1
105	JTM1055-H105	Quill Housing		1
105-1	JTM1055-H105-1	C-Clip		1
106	JTM1055-H106	Set Screw	M6x8	1
107	TS-1502071	Hex Socket Cap Screw	M5x45	2
108	JTM1055-H108	Set Screw	M6x15	1
109	JTM1055-H109	Hex Nut		1
110	JTM1055-H110	C-Clip	S22	1
	JTM1055-FRS	Forward Reverse Switch (not shown)		1
	JTM1055-FRSC	Forward Reverse Switch Cover (not shown)		1
	JTM1055-SC	Short Cable from Switch to Breaker (not shown)		1
	JTM1055-LC	Long Cable from switch to Breaker Box (not shown)		1
	JTM1055-SR	Plastic Strain Relief (not shown)		1

12.3.1 Base Assembly – Exploded View

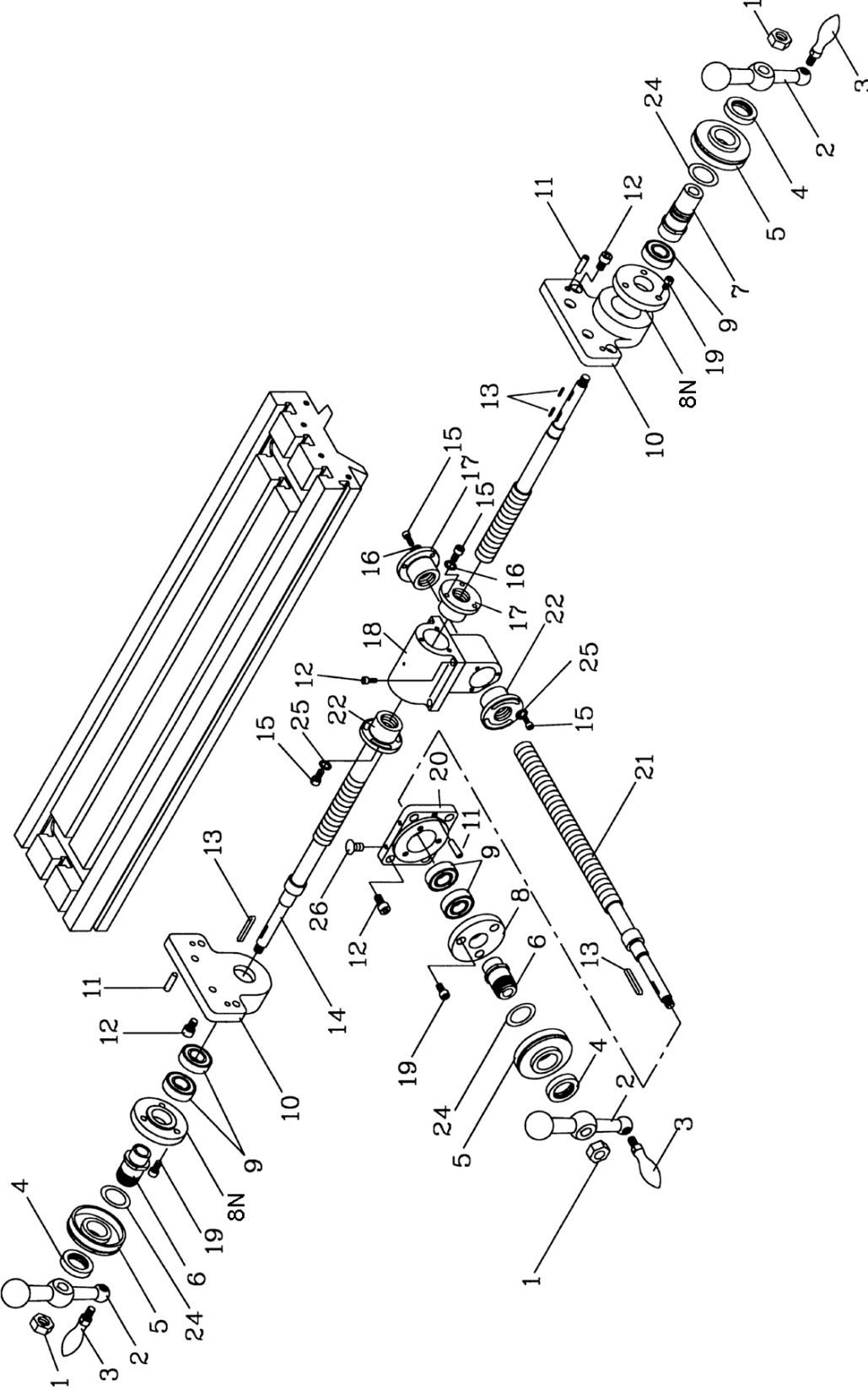


### 12.3.2 Base Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	JTM1055-B01	Eye Bolt		1
2	JTM1055-B02	Ram		1
3	JTM1055-B03	Head Tilt Block		1
3-1	JTM1055-B03-1	Hex Socket Cap Screw	M10x95	4
4	JTM1055-B04	Bolt		4
4-1	JTM1055-B04-1	Lock Washer		4
4-2	JTM1055-B04-2	Hex Nut		4
5	JTM1055-B05	Flange		1
5-1	JTM1055-B05-1	Spring Pin		1
6	JTM1055-B06	Worm Shaft		1
7	JTM1055-B07	Ram Pinion		1
7-1	JTM1055-B07-1	Handle		1
7-2	JTM1055-B07-2	Plastic Ball		1
8	JTM1055-B08	Turret		1
9	JTM1055-B09	Gib		1
10	JTM1055-B10	Bolt		4
10-1	JTM1055-B10-1	Washer		4
11	JTM1055-B11	Set Screw		1
12	JTM1055-B12	Lock Handle		2
12-1	JTM1055-B12-1	Brass Block		2
13	JTM1055-B13	Set Screw	M10X60	2
13-1	JTM1055-B13-1	Hex Nut	M10	2
13-2	JTM1055-B13-2	Block		2
14	JTM1055-B14	Scale Label		1
15	JTM1055-B15	Rivet		4
16	JTM1055-B16	Spider		1
17	JTM1055-B17N	Base ( <i>serial no. 120xxxx and higher</i> )		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 (w/ #19-21)		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-1503081	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	BB-6204ZZ	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 ( <i>serial no. 120xxxx and higher</i> )		1
40	JTM1055-B40	Knee Front Cover		1

Index No	Part No	Description	Size	Qty
40-1	JTM1055-B40-1	Cross Head Screw	M5x20	4
41	JTM1055-B41	Shaft		1
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	TS-1506041	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 ( <i>serial no. 120xxxx and higher</i> )		1
51-1	JTM1055-B51-1N	Gib ( <i>serial no. 120xxxx and higher</i> )		
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-B62	Wiper		2
63	JTM1055-B63N	Saddle ( <i>serial no. 120xxxx and higher</i> )		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 ( <i>serial no. 120xxxx and higher</i> )		1
69	JTM1055-B69	Chip Guard Assembly (includes: #69-72)		1
70		Chip Guard-L		1
71		Chip Guard-M		1
72		Chip Guard-S		1
73	JTM1055-B73	Gib Holder-R		1
74	JTM1055-B74	Gib Holder-L		1
75	JTM1055-B75N	Gib ( <i>serial no. 120xxxx and higher</i> )		1
	JTM1055-TBC	Toolbox Complete (not shown)		1
	JTM1055-LP	Leveling Pad (not shown)		4
	JTM1055-LB	Leveling Bolt w/Nut (not shown)		4
	STRIPE-1-3/4	JET Striping (not shown)	1-3/4" W	per ft.
	JTM1055-ID	ID & Warning Label (not shown)		1

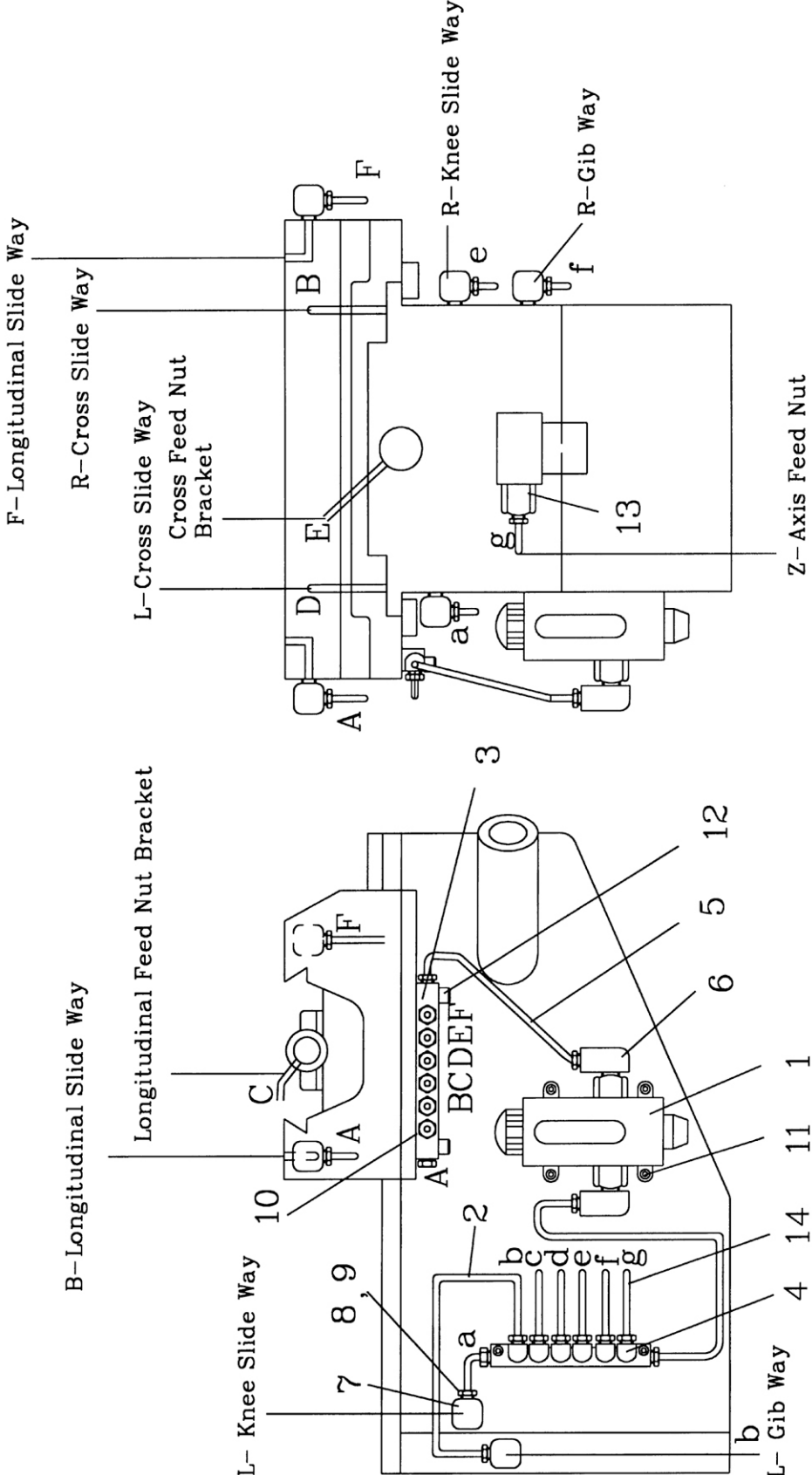
12.4.1 Lead Screw Assembly – Exploded View



## 12.4.2 Lead Screw Assembly – Parts List

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 ( <i>serial no. 120xxxx and higher</i> ).....		2
9	BB-6204ZZ	Ball Bearing.....		5
10	JTM1055-L10N	Extended Bearing Bracket ( <i>serial no. 120xxxx and higher</i> ).....		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 ( <i>serial no. 120xxxx and higher</i> ).....		1
15	TS-1503041	Hex Socket Cap Screw.....	M6X25	8
16	TS-1550041	Washer.....	M6	2
17	JTM1055-L17	Feed Screw Nut.....		2
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 Cross Feed Nut.....		2
24	JTM1055-L24	Spacer.....		3
25	JTM1055-L25	Lock Washer.....	M6	2
26	JTM1055-L26	Cross Head Screw.....		2

12.5.1 One Shot Lubrication System – Diagram



## 12.5.2 One Shot Lubrication System – Parts List

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