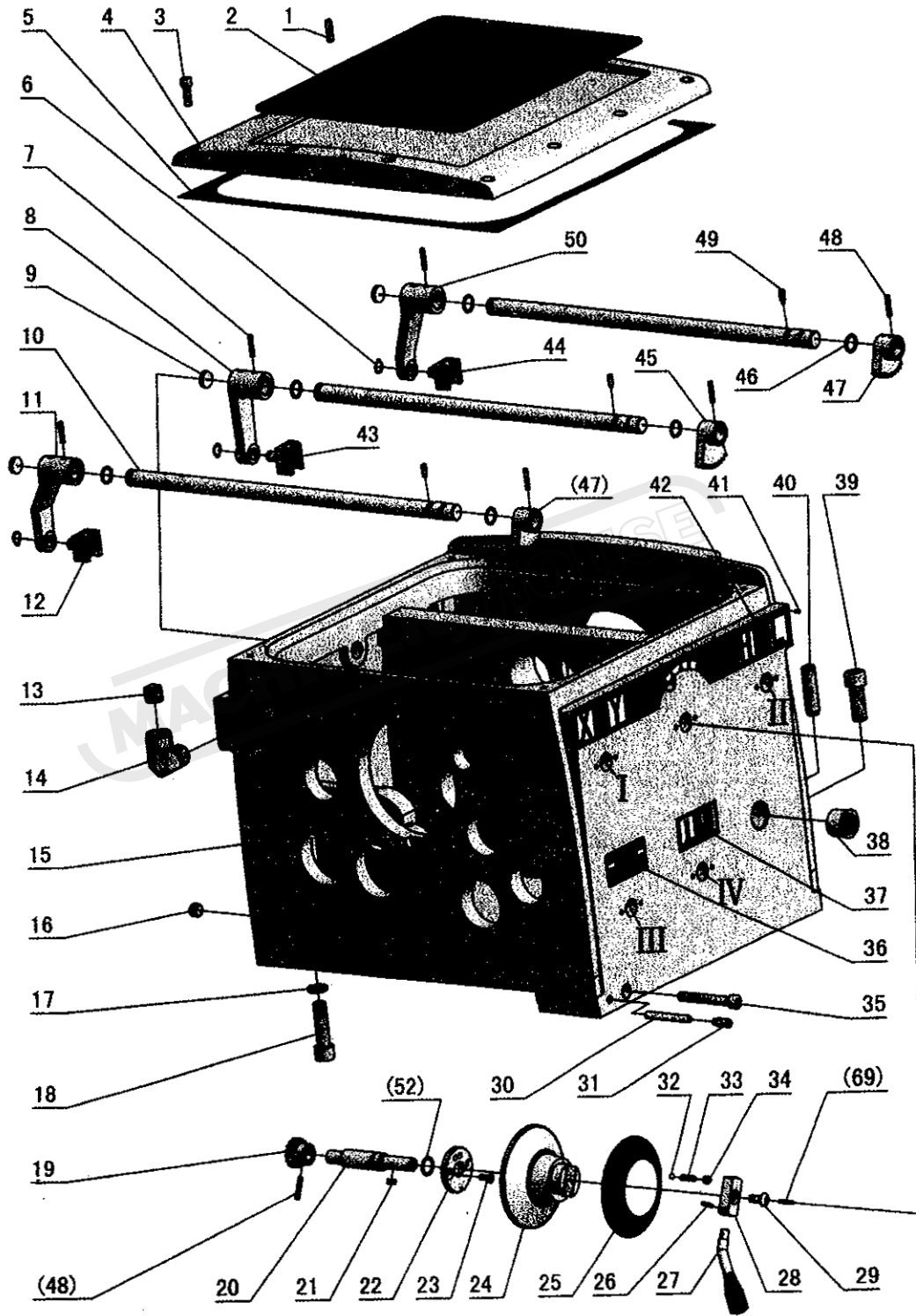
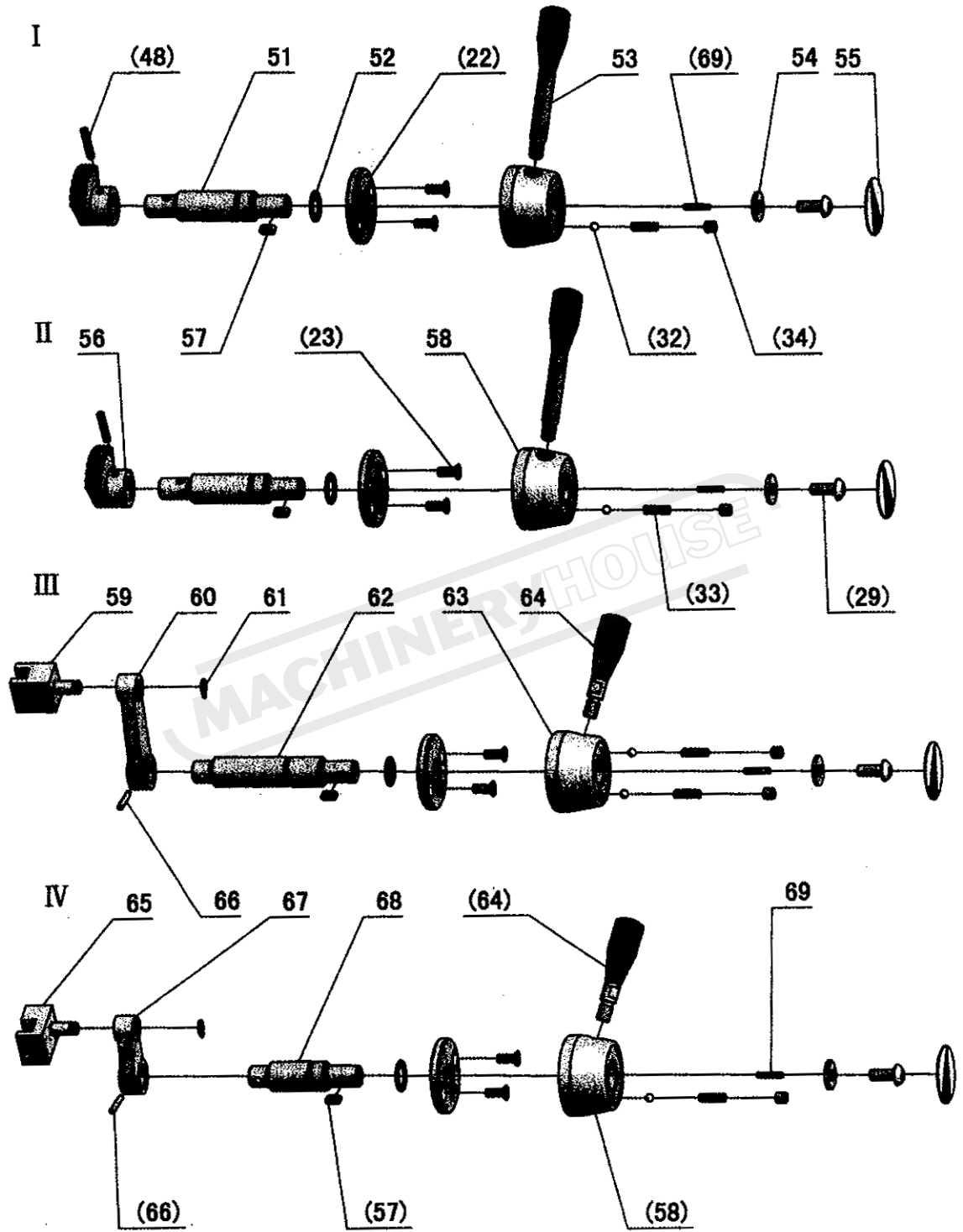
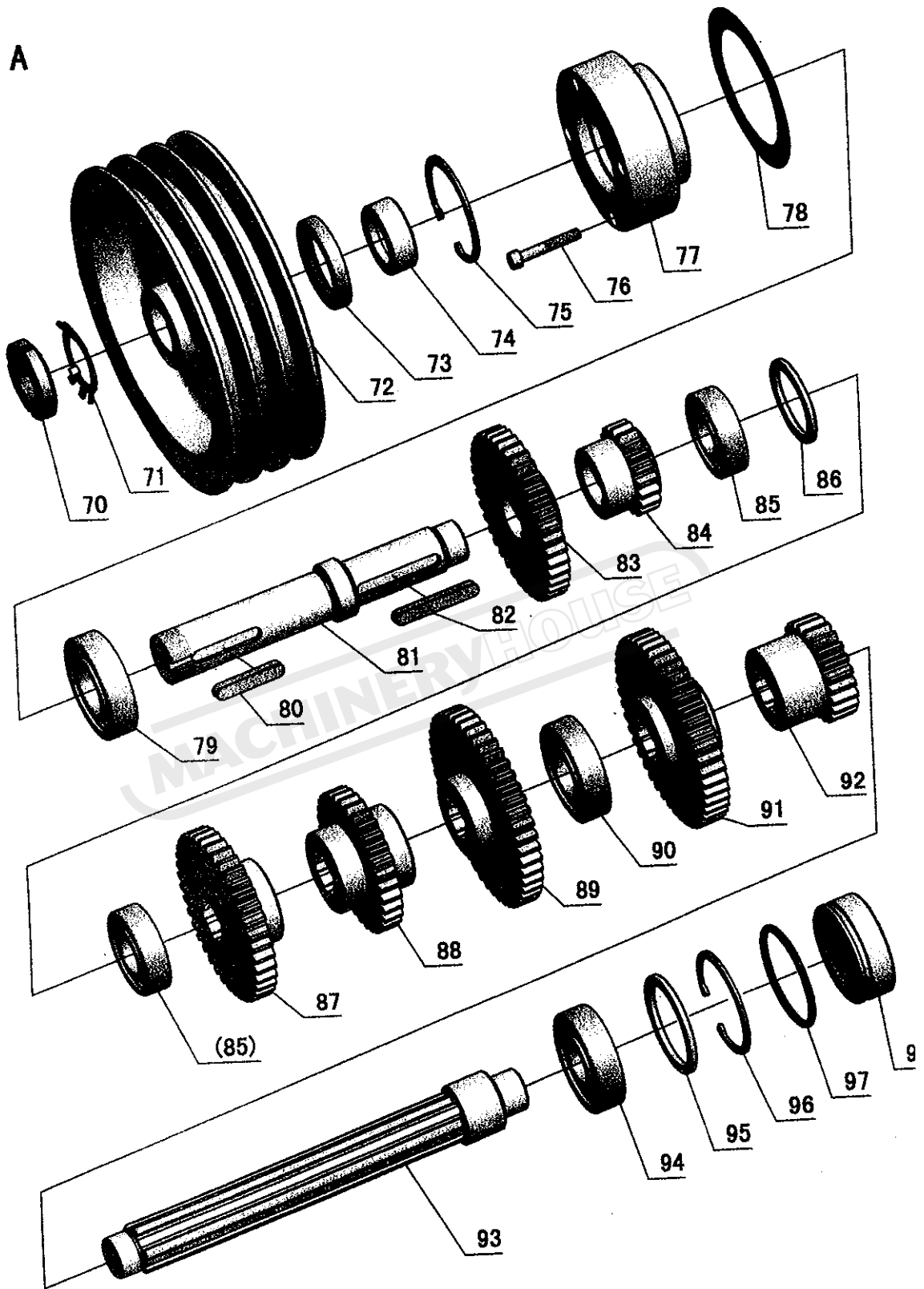


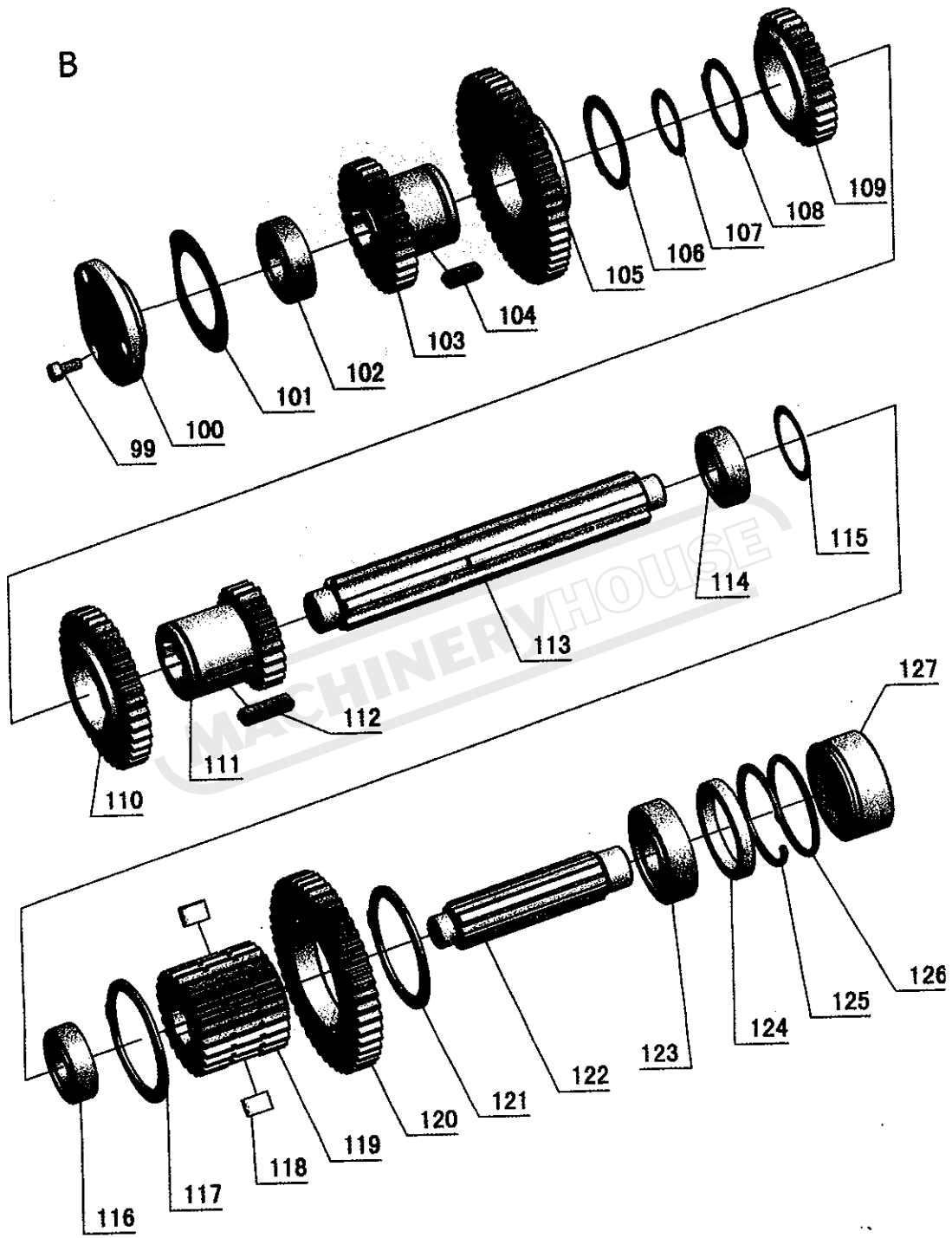
# 11.Parts List Assembly

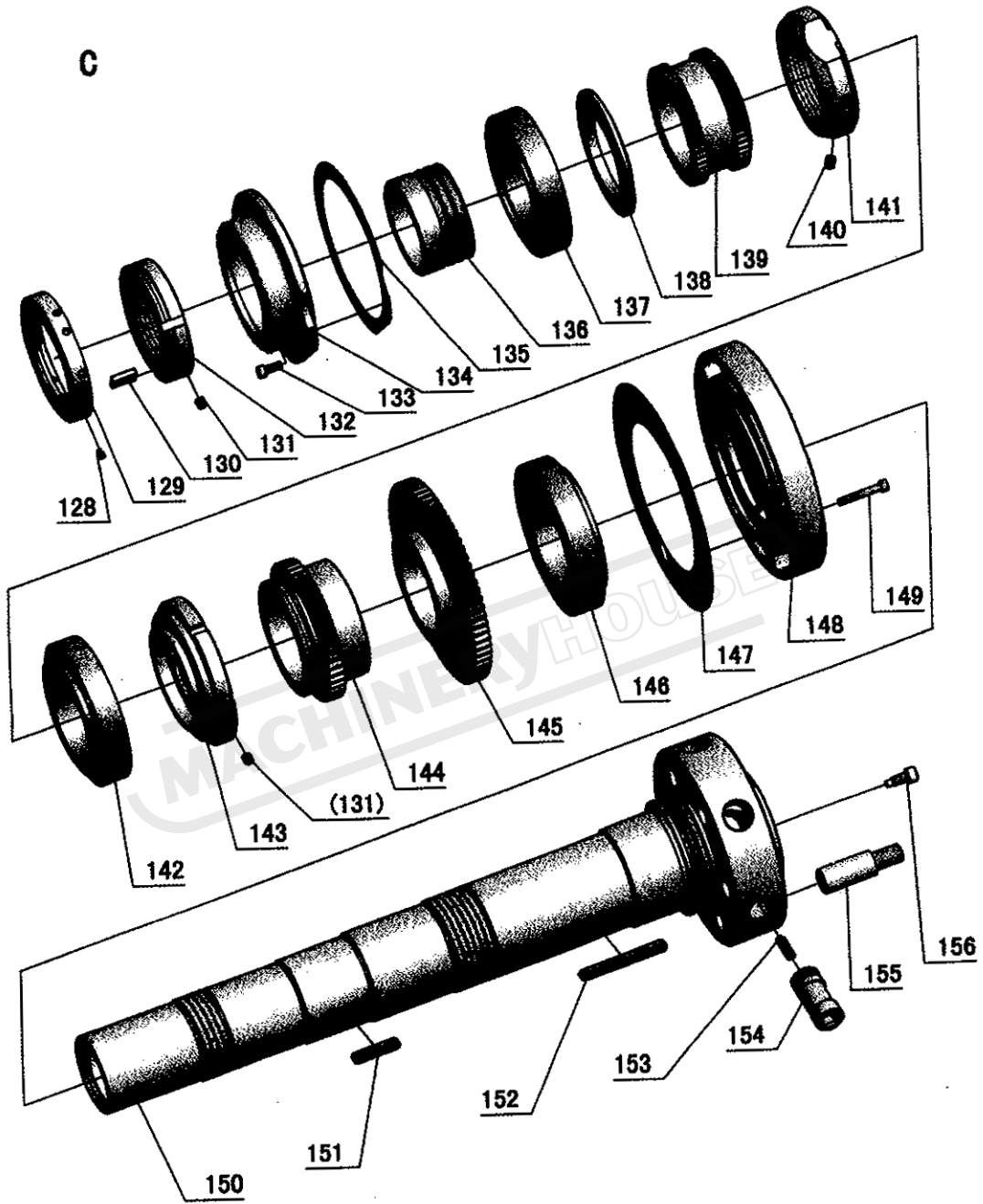
## Headstock



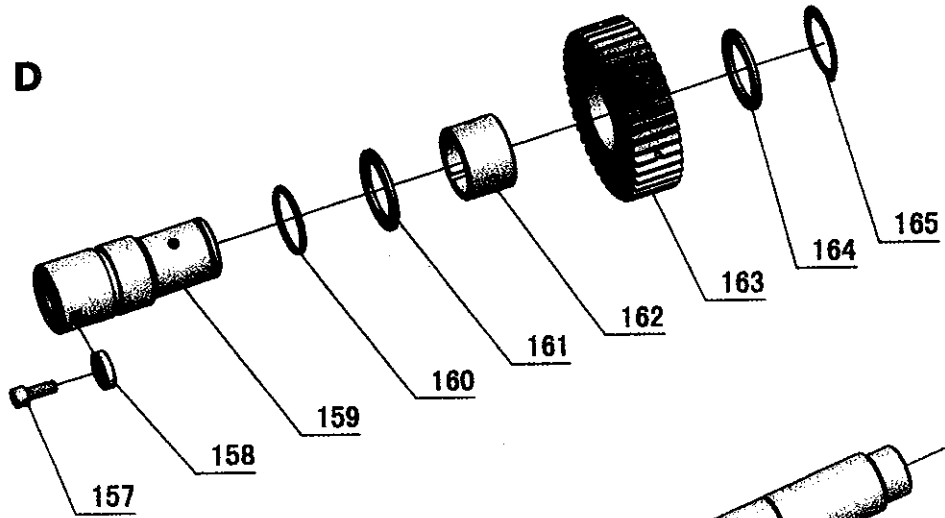




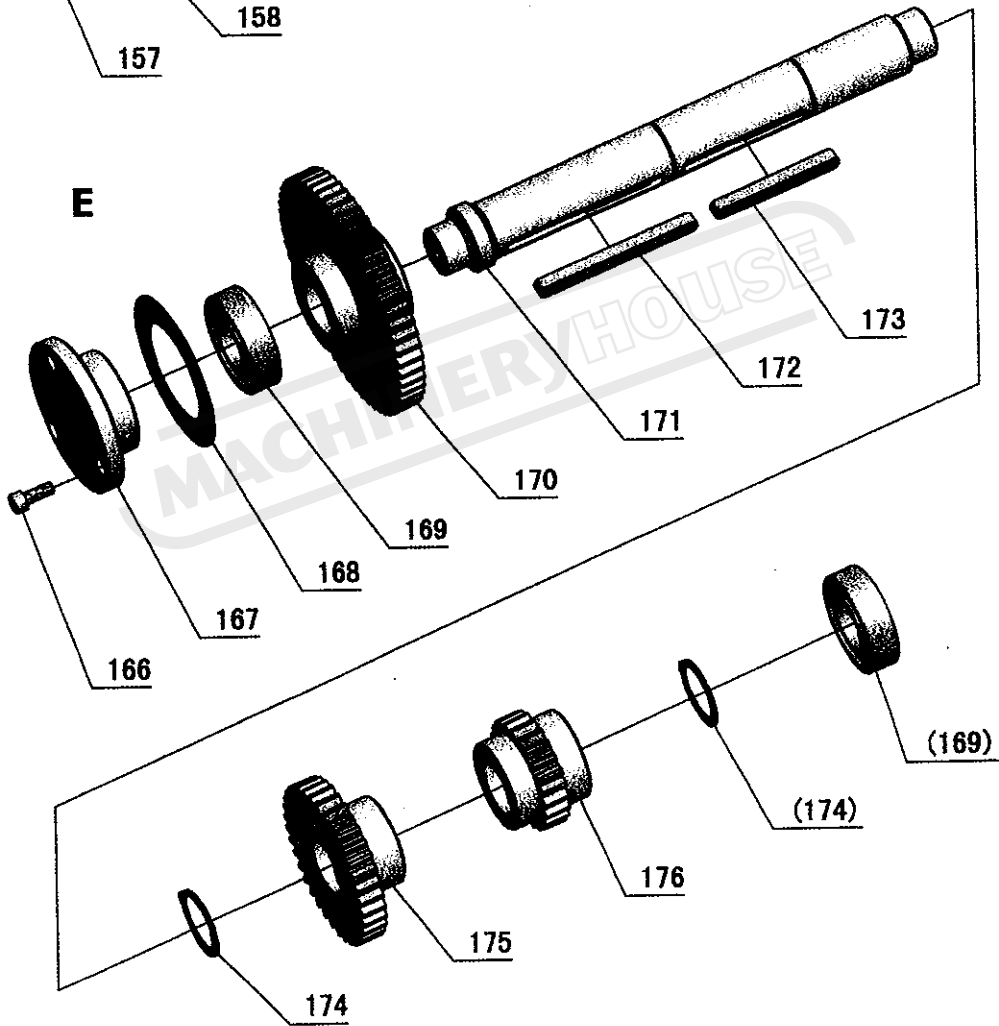


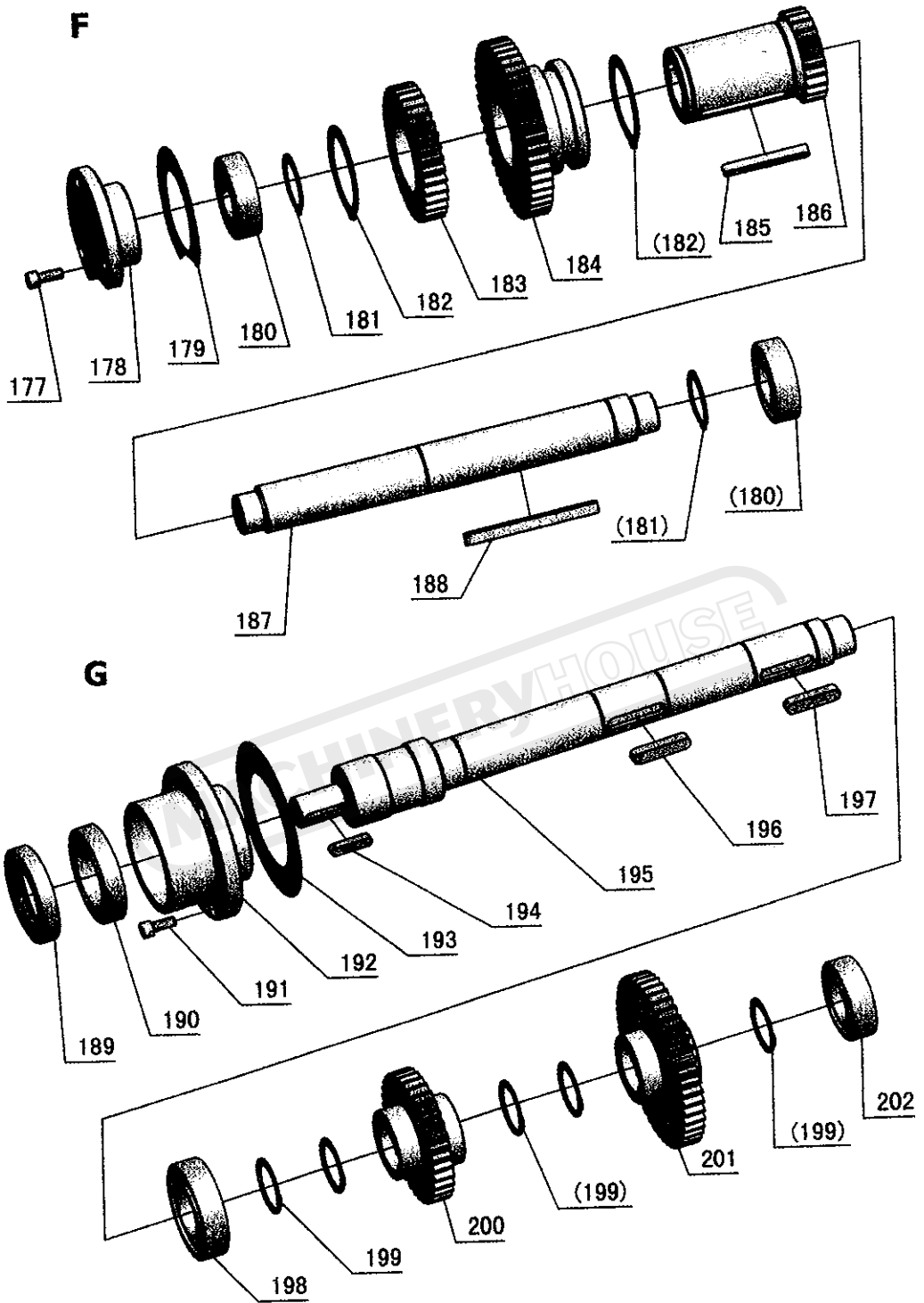


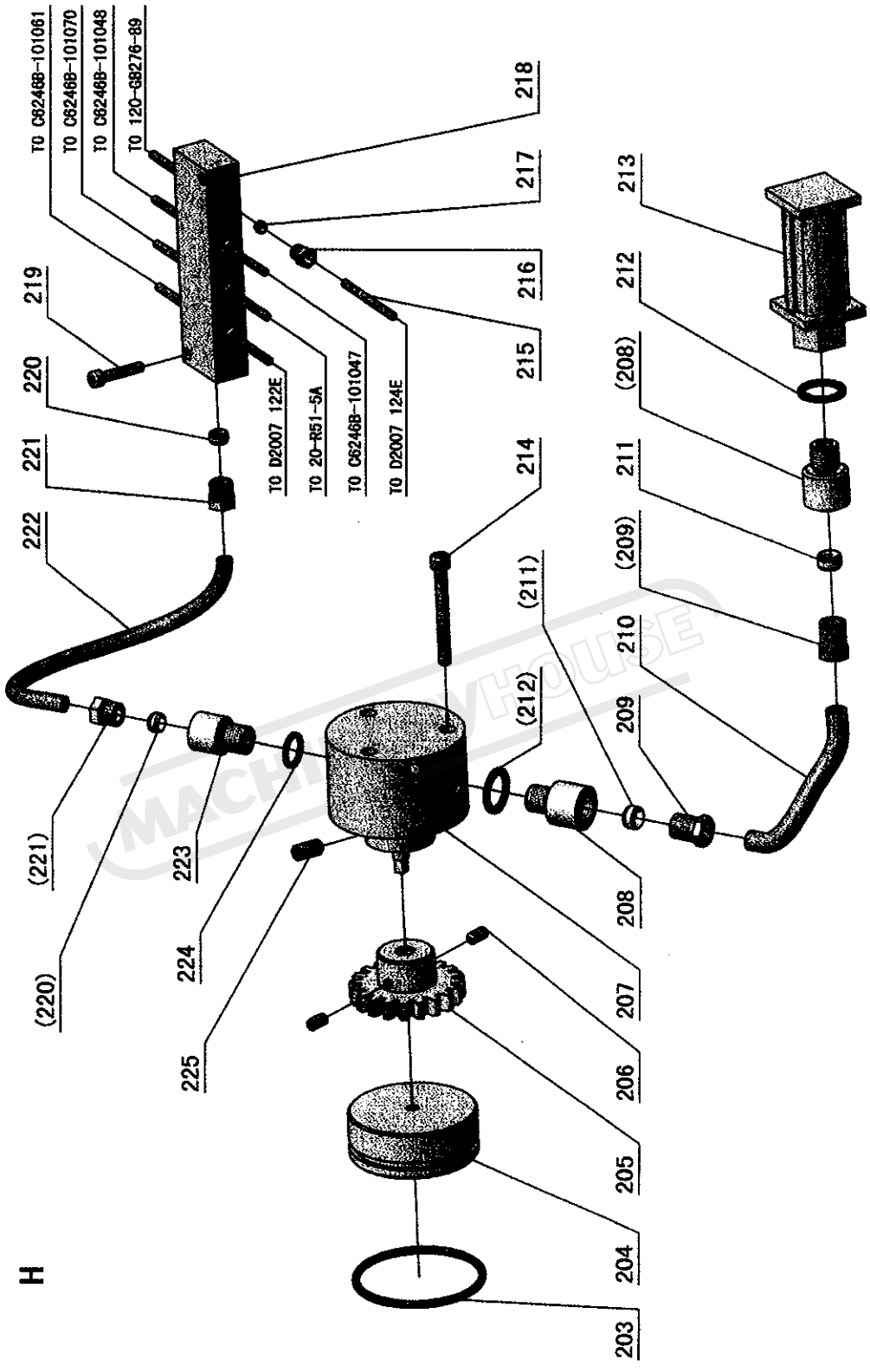
**D**



**E**







H



No.	Part No.	Name	Specification	Qty.
1	GB77-85	Screw	M8 × 25	1
2	C6246B-101003	Cover Dress		1
3	GB70-85	Screw	M8 × 20	4
4	C6246B-101002	Headstock Cover		1
5	C6246B-101002-1	Sealed Mat		1
6	GB894.1-86	Circlip	12	3
7	GB879-86	Spring Pin	5 × 30	3
8	C6246B-101011	Lever		1
9	RUN6246-101083	Plug		3
10	RUN6246-101059	Shaft		3
11	C6246B-101022	Lever		1
12	C6246B-101021	Fork		1
13	SB4032-65	Plug		1
14	SB4010-65	Tube Fitting		1
15	C6251A-04-01	Headstock		1
15	C6256A-04-01	Headstock		1
16	G38-3A	Oil Plug	Z 3/8"	1
17	GB93-87	Washer	16	3
18	GB70-85	Socket Head Cap Screw	M16 × 55	3
19	C6246B-101004-1	Gear		1
20	RUN6246-101065-1	Shaft		1
21	GB1096-79	Flat Key	5 × 12	1
22	RUN6246-101067	Fix Plate		5
23	GB819-85	Screw	M6 × 16	10
24	RUN6246-101077-1	Handle		1
25	RUN6246-101097	Plate		1
26	GB879-86	Spring Pin	4 × 20	1
27	RUN6246-101077-3	Lever		1
28	RUN6246-101077-2	Fix Bracket		1
29	RUN6246-101088	Round Head Screw		5
30	RUN6246-101080	Pin		2
31	GB79-85	Socket Head Set Screw	M10 × 25	2
32	GB308-84	Steel Ball	1/4"	6
33	RUN6246-101066	Spring		6
34	GB77-85	Screw	M8 × 8	6
35	GB70-85	Screw	M10 × 110	1
36	C6246B-101098	Plate		1
37	C6246B-101100	Plate		1
38	R51-5A	Oil Sight Glass	20	1
39	GB70-85	Screw	M16 × 55	3

No.	Part No.	Name	Specification	Qty.
40	GB120-86	Pin	16 × 55	1
41	GB827-86	Rivet	2 × 5	24
42	C6246B-101006	Plate		1
43	C6246B-101012	Fork		1
44	C6246B-101012-1	Fork		1
45	C6246B-101005-1	Gear		1
46	GB1235-76	O-Ring	20 × 2.4	6
47	C6246B-101005	Gear		2
48	GB879-86	Spring Pin	5 × 26	6
49	GB79-85	Screw	M6 × 6	3
50	C6246B-101018	Lever		1
51	RUN6246-101065	Shaft		2
52	GB1235-76	O-Ring	22 × 2.4	5
53	RUN6246-101072	Lever		2
54	RUN6246-101070-1	Washer		4
55	RUN6246-101099	Plate		4
56	RUN6246-101064	Gear		2
57	GB1096-79	Key	5 × 12	4
58	RUN6246-101071	Lever Head		3
59	C6246B-101008	Fork		1
60	C6246B-101009	Lever		1
61	GB894.1-86	Circlip	10	2
62	C6246B-101017-1	Shaft		1
63	RUN6246-101077A	Handle		1
64	C6246B-101010	Lever		2
65	C6246B-101015	Fork		1
66	GB879-86	Spring Pin	4 × 26	2
67	C6246B-101016	Lever		1
68	C6246B-101017	Shaft		1
69	GB77-85	Screw	M4 × 20	5
70	GB812-88	Nut	M30 × 1.5	1
71	GB858-88	Nut	30	1
72	RUN6246-101011	Pulley		1
73	HG4-692-67	Oil Seal	PD40 × 62 × 12	1
74	GB278-89	Ball Bearing	1080908	1
75	GB893.1-86	Snap Ring	62	1
76	GB70-85	Socket Head Cap Screw	M6 × 30	4
77	C6246B-101024	Bearing Cap		1
78	C6246B-101024-1	Bearing Seat Seal		1
79	GB278-89	Ball Bearing	80306	1

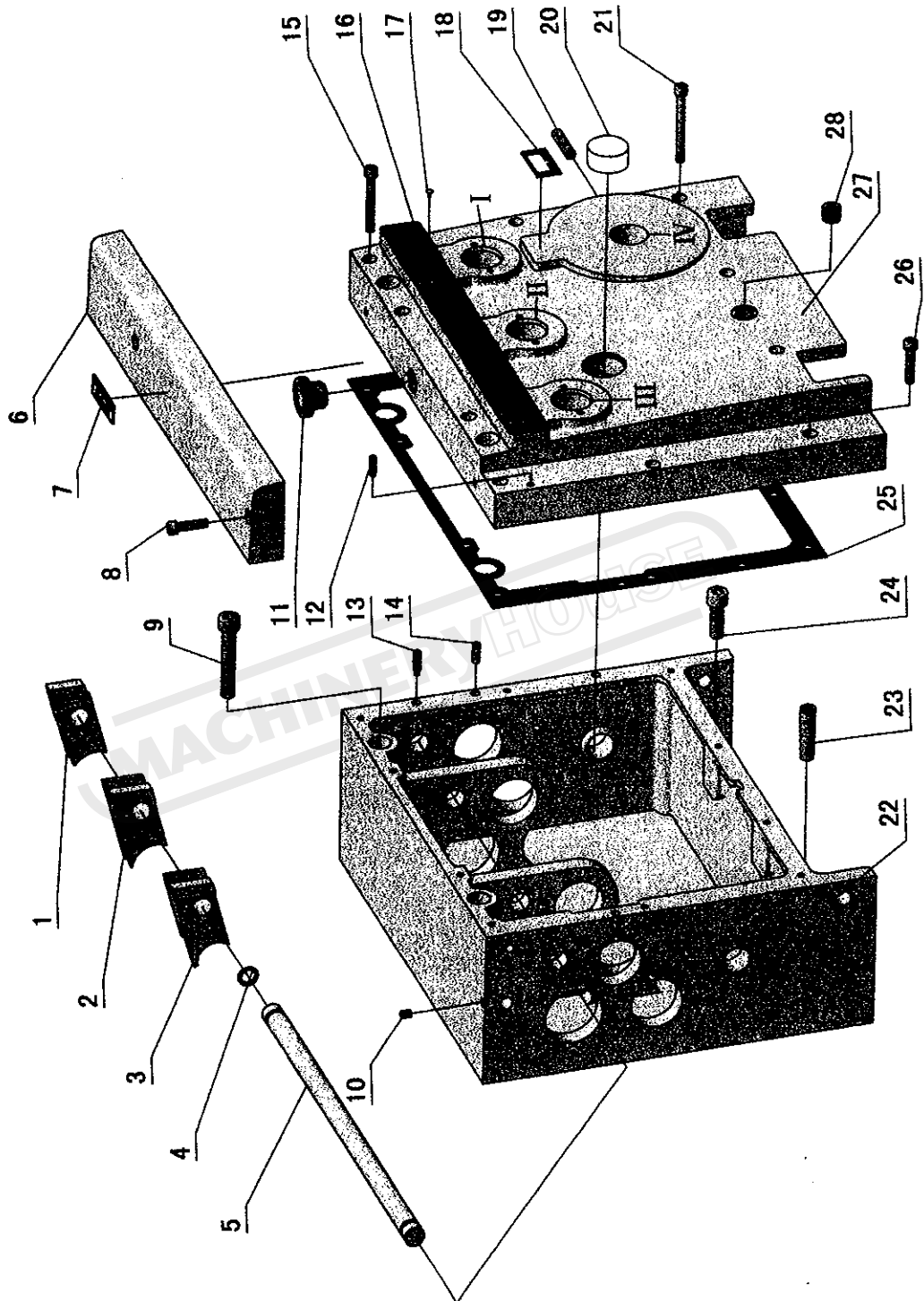
No.	Part No.	Name	Specification	Qty.
80	GB1096-79	Flat Key	8 × 40	1
81	C6246B-101080	Input Shaft		1
82	GB1096-79	Flat Key	8 × 70	1
83	C6246B-101026	Gear		1
84	C6246B-101027	Gear		1
85	GB278-89	Ball Bearing	80205	2
86	C6246B-101028	Spacer		3
87	C6246B-101029	Gear		1
88	C6246B-101030	Gear		1
89	C6246B-101031	Gear		1
90	GB278-89	Ball Bearing	80206	1
91	C6246B-101032	Gear		1
92	C6246B-101033	Gear		1
93	C6246B-101035	Spline Shaft		1
94	GB278-89	Ball Bearing	80305	1
95	C6246B-101034-2	Washer		1
96	GB893.1-86	Snap Ring	62	1
97	GB3452.1-82	O-Ring	56 × 2.65	1
98	RUN6246-101019-1	Plug		1
99	GB70-85	Socket Head Cap Screw	M6 × 16	3
100	C6246B-101079	Bearing Cover		1
101	C6246B-101079-1	Bearing Cover Seal		1
102	GB278-89	Ball Bearing	80205	1
103	C6246B-101077	Gear		1
104	GB1096-79	Flat Key	8 × 20	1
105	C6246B-101076	Gear		1
106	GB894.1-86	Snap Ring	52	1
107	GB894.1-86	Snap Ring	34	2
108	GB894.1-86	Snap Ring	48	1
109	C6246B-101039	Gear		1
110	C6246B-101040	Gear		1
111	C6246B-101041	Gear		1
112	GB1096-79	Flat Key	8 × 32	1
113	C6246B-101078	Spline Shaft		1
114	GB278-89	Ball Bearing	80205	1
115	C6246B-101028	Spacer		3
116	GB278-89	Ball Bearing	80205	1
117	GB894.1-86	Snap Ring	75	1
118	C6246B-101036-1	Flat Key		2
119	C6246B-101038	Gear		1

No.	Part No.	Name	Specification	Qty.
120	C6246B-101036	Gear		1
121	GB894.1-86	Snap Ring	75	1
122	C6246B-101037	Spline Shaft		1
123	GB278-89	Ball Bearing	80305	1
124	C6246B-101034-2	Washer		1
125	GB893.1-86	Snap Ring	62	1
126	GB3452.1-82	O-Ring	56 × 2.65	1
127	RUN6246-101019-1	Protection Cover		1
128	GB79-85	Socket Head Set Screw	M6 × 8	4
129	C6246B-101073	Balance Block		2
130	C6246B-101074-1	Brass		1
131	GB79-85	Socket Head Set Screw	M10 × 10	1
132	C6246B-101074	Lock Nut		1
133	GB70-85	Socket Head Cap Screw	M6 × 20	4
134	C6246B-101075	Rear Bearing Cover		1
135	C6246B-101075-1	Rear Spindle Bearing Cover Sealer		1
136	C6246B-101072	Oil Ring		1
137	GB276-89	Ball Bearing	120	1
138	C6246B-101071	Shaft Ring		1
139	C6246B-101070	Gear		1
140	GB79-85	Socket Head Set Screw	M8 × 10	3
141	C6246B-101045	Lock Nut		1
142	GB297-84	Ball Bearing	D2007122E	1
143	C6246B-101046	Lock Nut		1
144	C6246B-101047	Gear		1
145	C6246B-101048	Gear		1
146	GB297-84	Ball Bearing	D2007124E	1
147	C6246B-101051-1	Front Bearing Cover Seal		1
148	C6246B-101051	Front Bearing Cover	D1-8	1
149	GB70-85	Socket Head Cap Screw	M6 × 40	5
150	C6246B-101049-1	Spindle		1
151	GB1096-79	Flat Key	10 × 80	1
152	GB1096-79	Flat Key	10 × 90	1
153	RUN6246-101082-1	Spring		6
154	C6246B-101042	Cam Lock For D1-8		6
155	C6246B-101050	Cam Screw For D1-8		6
156	C6246B-101044	Screw For D1-8		6
157	GB70-85	Socket Head Cap Screw	M6 × 16	1
158	RUN6246-101048	Spacer		1
159	C6246B-101061	Stationary Pulley Shaft		1

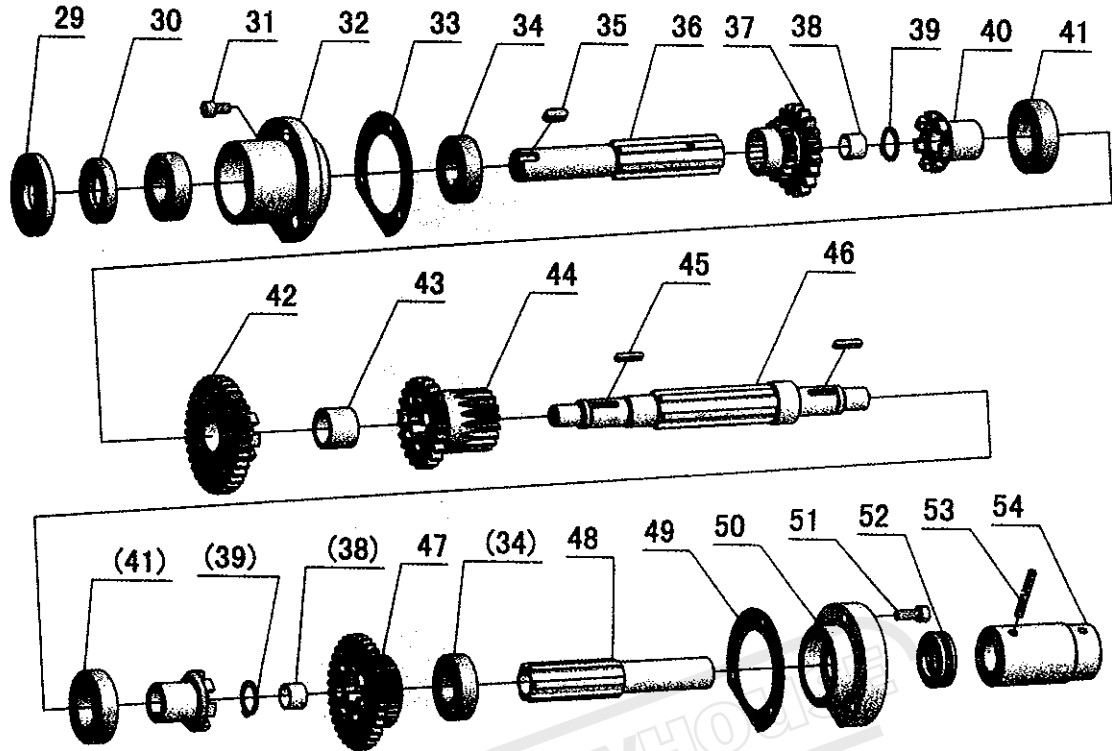
No.	Part No.	Name	Specification	Qty.
160	GB1235-76	O-Ring	30 × 2.4	1
161	C6246B-101059	Spacer		1
162	C6246B-101060-1	Brass		1
163	C6246B-101060	Stationary Pulley		1
164	C6246B-101059	Spacer		1
165	GB894.1-86	Snap Ring	30	1
166	GB70-85	Socket Head Cap Screw	M6 × 16	3
167	C6246B-101068	Bearing Cover		1
168	C6246B-101068-1	Bearing Cover Seal		1
169	GB278-89	Ball Bearing	80205	1
170	C6246B-101066	Gear		1
171	C6246B-101069	Shaft		1
172	GB1096-79	Flat Key	8 × 90	1
173	GB1096-79	Flat Key	8 × 70	1
174	GB894.1-86	Snap Ring	30	2
175	C6246B-101053	Gear		1
176	C6246B-101052	Gear		1
177	GB70-85	Socket Head Cap Screw	M6 × 16	13
178	C6246B-101067	Bearing Cover		1
179	C6246B-101067-1	Bearing Cover Seal		1
180	GB278-89	Ball Bearing	80205	1
181	GB894.1-86	Snap Ring	30	2
182	GB894.1-86	Snap Ring	48	2
183	C6246B-101057	Gear		1
184	C6246B-101056	Gear		1
185	GB1096-79	Flat Key	6 × 56	1
186	C6246B-101055	Gear		1
187	C6246B-101065	Shaft		1
188	GB1096-79	Flat Key	8 × 90	1
189	HG4-692-67	Oil Seal	PD40 × 62 × 12	1
190	GB278-89	Ball Bearing	1080908	1
191	GB70-85	Socket Head Cap Screw	M6 × 20	3
192	C6246B-101063	Bearing Seat		1
193	C6246B-101063-1	Bearing Seat Seal		1
194	GB1096-79	Flat Key	6 × 28	1
195	C6246B-101064	Output Shaft		1
196	GB1096-79	Flat Key	8 × 40	1
197	GB1096-79	Flat Key	8 × 36	1
198	GB278-89	Ball Bearing	80206	1
199	GB894.1-86	Snap Ring	30	5

No.	Part No.	Name	Specification	Qty.
200	C6246B-101058	Gear		1
201	C6246B-101054	Gear		1
202	GB278-89	Ball Bearing	80205	1
203	GB1235-76	O-Ring	68 × 3.1	1
204	C6246B-101082	Protection		1
205	C6246B-101081	Gear		1
206	GB80-85	Screw	M6 × 12	2
207	SNBY2.5/0.5	Oil Pump	M14 × 1.5	1
208	C6246B-101088	Conjunctional Block		1
209	25568	Tie-In		2
210	GB1527-79-M-T3	Brass Tube	10 × 0.75	1
211	25677	Double Taper Sheath		2
212	GB52-2	Washer	18	1
213	Wu-16 × 180-J	Filter		1
214	GB70-85	Screw	M6 × 55	3
215	GB1527-79-M-T3	Brass Tube	4 × 0.75	1
216	15326C	Tie-In		9
217	B1061C	Double Taper Sheath		9
218	C6246B-101084	Manifold		1
219	GB70-85	Socket Head Cap Screw	M5 × 25	2
220	B145C	Double Taper Sheath		2
221	25567	Tie-In		2
222	GB1527-79-M-T3	Brass Tube	8 × 0.75	1
223	C6246B-101086	Conjunctional Block		1
224	G52-2	Washer	14	2
225	GB80-85	Screw	M6 × 16	1

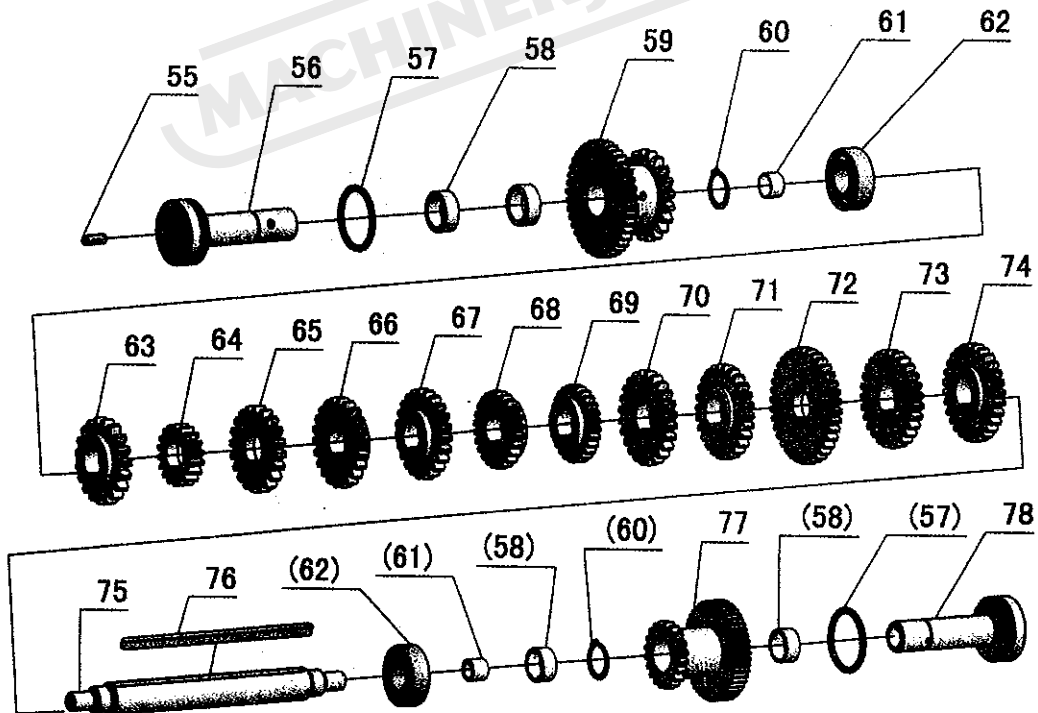
# Gearbox



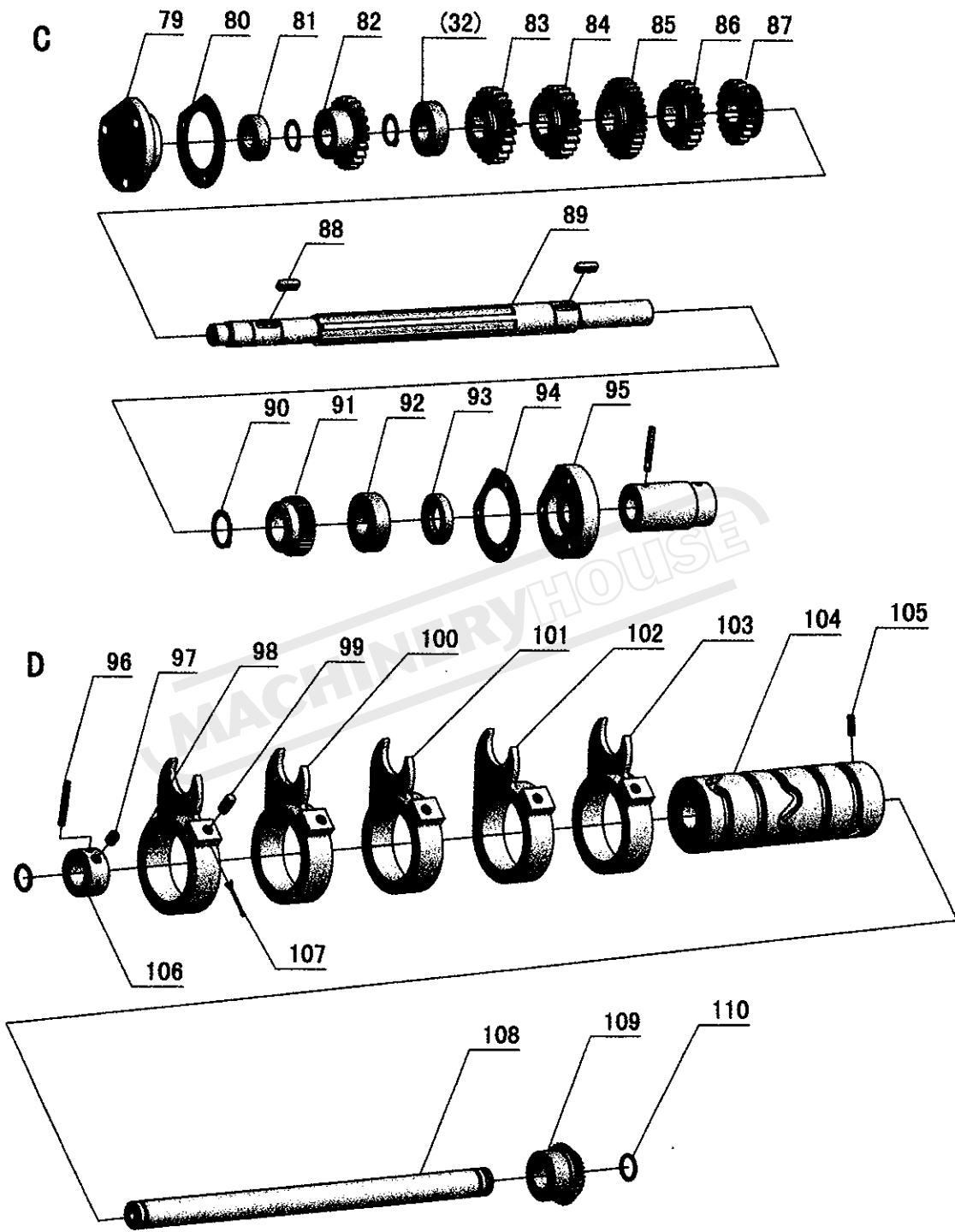
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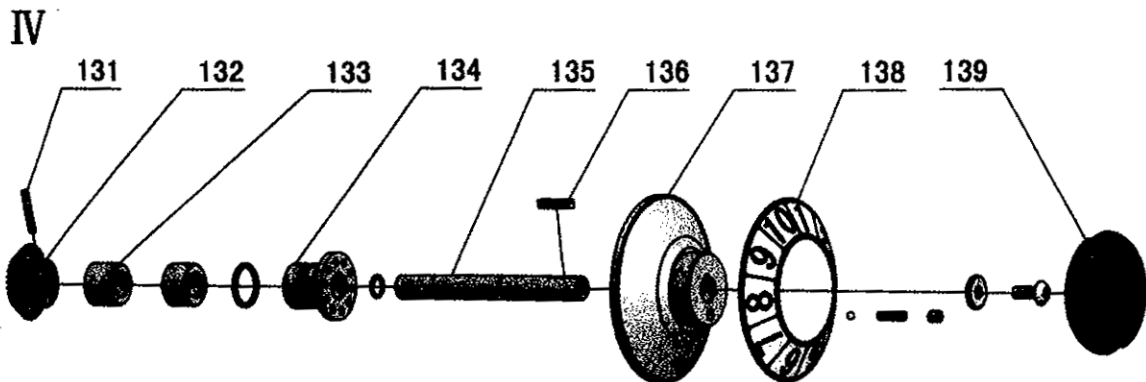
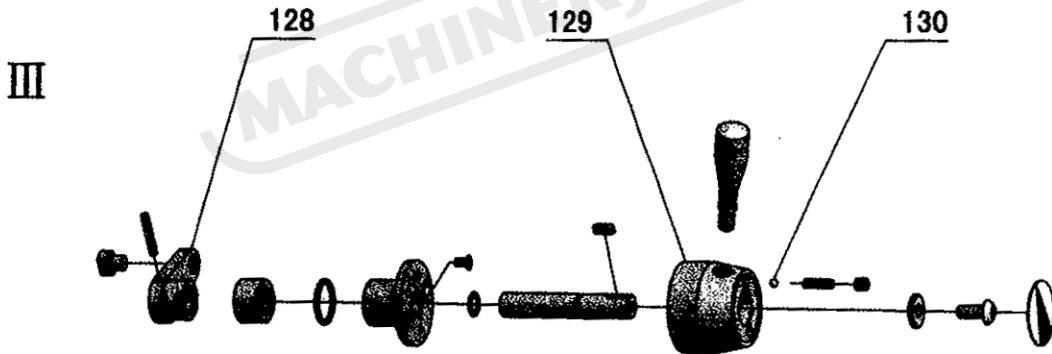
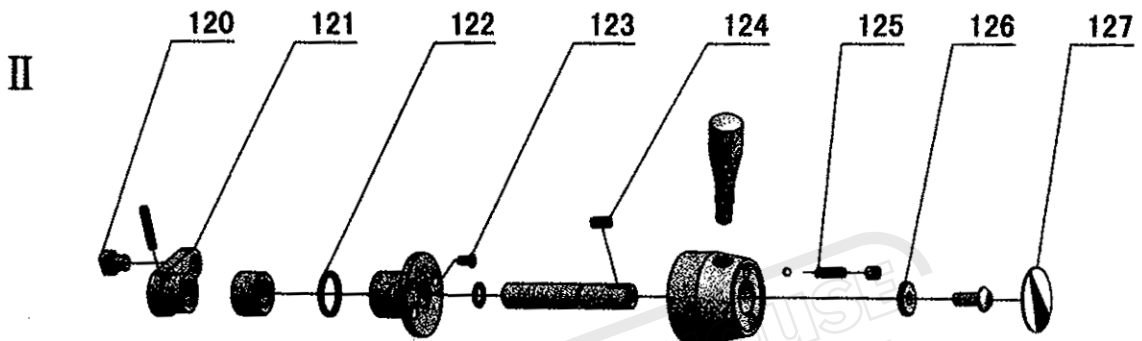
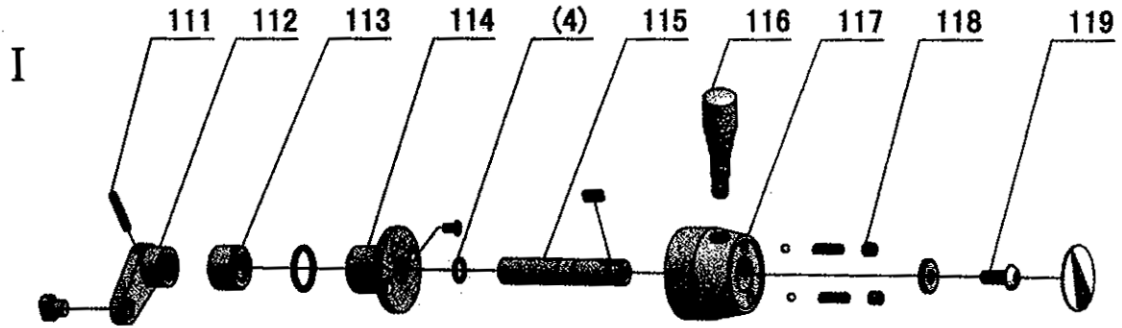


B









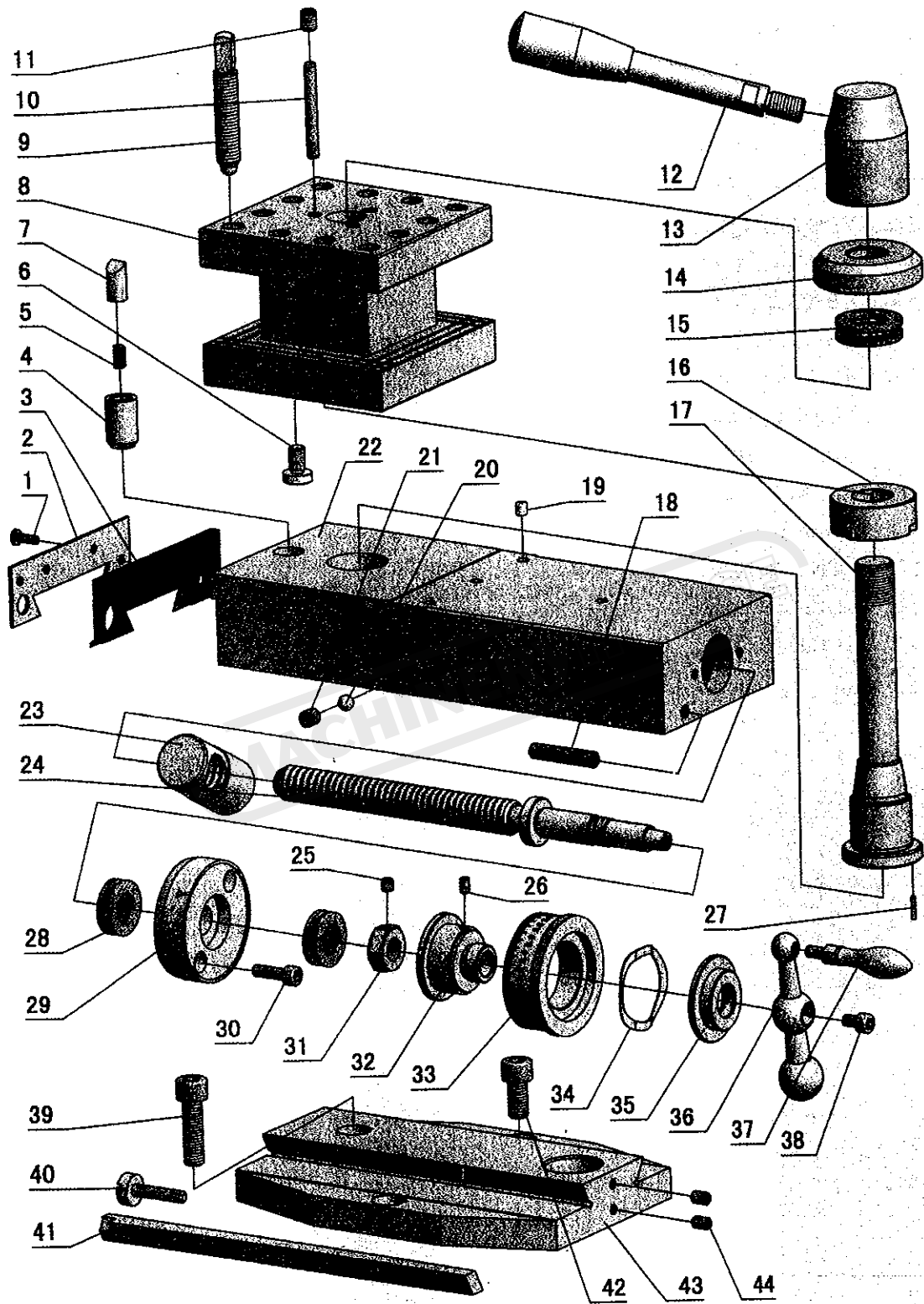
No.	Part No.	Name	Specification	Qty.
1	RUN6141-102070-1	Fork		1
2	RUN6246-102069	Fork		1
3	RUN6246-102069-1	Fork		1
4	GB1235-76	O-Ring	16 × 2.4	6
5	RUN6246-102077	Shaft		1
6	C6251A-05-06	Top Cover		1
7	RUN6246-102079	Plate		1
8	GB70-85	Screw	M6 × 30	2
9	GB70-85	Screw	M10 × 60	2
10	GB78-85	Screw	M6 × 8	1
11	RUN6246-103031	Oil Cover		1
12	GB879-86	Spring Pin	5 × 16	2
13	GB79-85	Socket Set Screw	M6 × 20	2
14	GB78-85	Screw	M6 × 16	2
15	GB70-85	Screw	M6 × 50	1
16	RUN6246-102080	Plate		1
17	GB827-86	Rivet	2 × 5	10
18	RUN6246-102081	Plate		1
19	GB78-85	Screw	M8 × 35	1
20	GB1160.1-89	Oil Sight Glass	20	1
21	GB70-85	Screw	M6 × 60	3
22	RUN6246-102001A	Gear Box		1
23	GB118-86	Taper Pin	10 × 45	2
24	GB70-85	Screw	M10 × 30	2
25	RUN6246-102001-2A	Sealed Mat		1
26	GB70-85	Screw	M6 × 30	3
27	RUN6141-102002A	Front Cover		1
28	G38-3A	Oil Plug	Z 3/8"	1
29	C6251A-05-05	Spacer		1
30		Oil-Seal	TC20 × 42 × 8	1
31	GB70-85	Socket Head Cap Screw	M6 × 12	6
32	RUN6246-102050	Cap		1
33	RUN6246-102050-1	Sealed Mat		1
34	GB278-89	Ball Bearing	80104	4
35	GB1096-79	Key	6 × 10	1
36	C6251A-05-04	B-Shaft		1
37	RUN6246-102048	Gear		1
38	SF-1	Ball Bearing	1410	2
39	GB894.1-86	Snap Ring	18	2
40	RUN6246-102047	Clutch		2

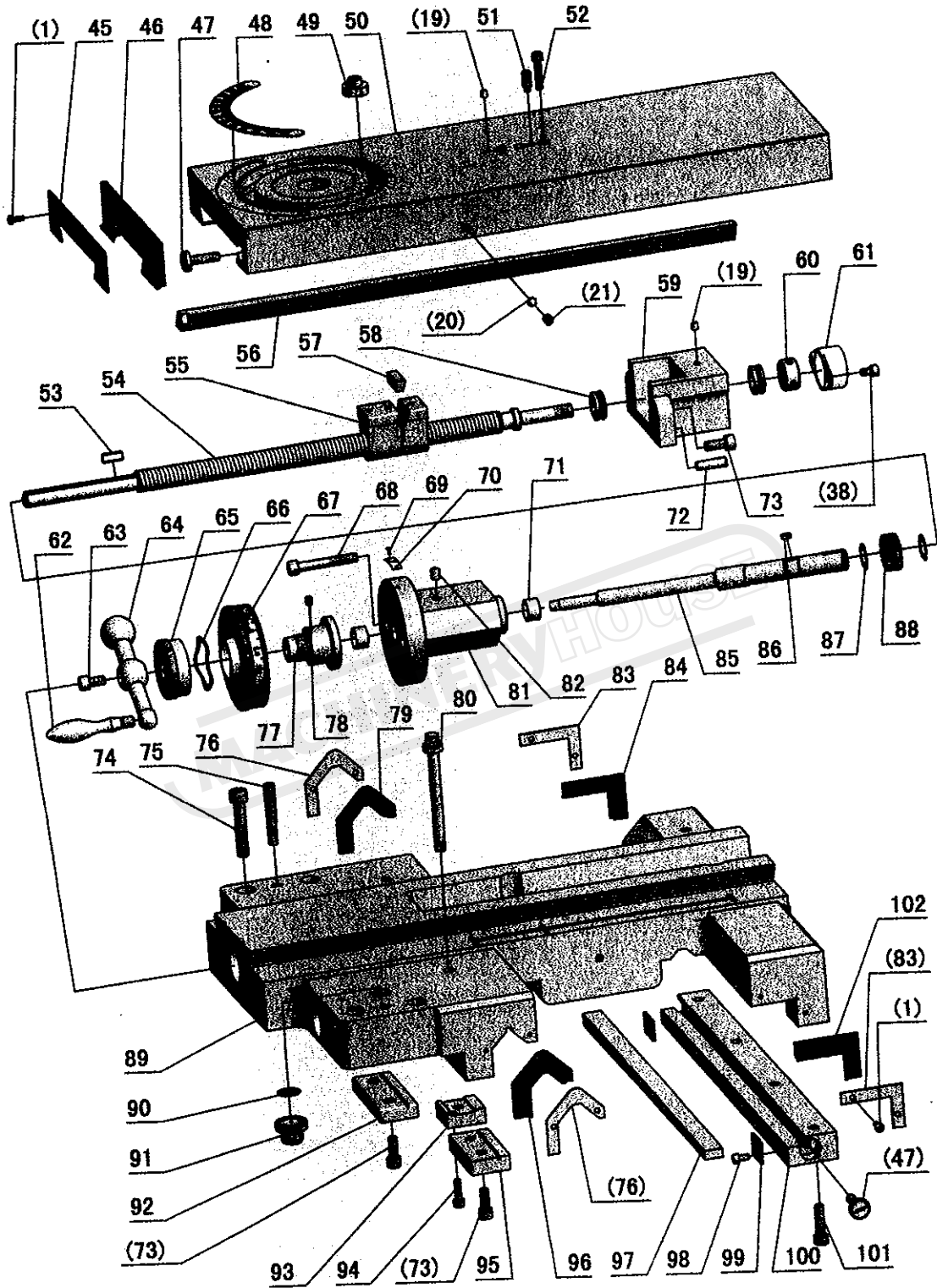
No.	Part No.	Name	Specification	Qty.
41	GB278-89	Ball Bearing	80105	2
42	RUN6246-102046	Gear		1
43	SF-1	Ball Bearing	2020	1
44	RUN6246-102045	Gear		1
45	GB1096-79	Key	4 × 20	2
46	RUN6246-102044	A-Shaft		1
47	RUN6141-102042-1	Gear		1
48	RUN6246-102041	C-Shaft		1
49	RUN6246-102040-1	Sealed Mat		1
50	RUN6246-102040	Cap		1
51	GB70-85	Socket Cap Screw	M6 × 20	6
52	GB301-84	Thrust Bearing	8104	1
53	GB879-86	Spring Pin	5 × 35	2
54	C6251A-05-03	Collar-Linkage		1
54	RUN6246-102012	Collar-Linkage		2
55	GB78-85	Screw	M6 × 16	2
56	RUN6246-102023	E-Shaft		1
57	GB3452.1-82	O-Ring	35.5 × 3.55	2
58	SF-1	Ball Bearing	2012	4
59	RUN6246-102024	Gear		1
60	GB894.1-86	Snap Ring	20	4
61	SF-1	Ball Bearing	1218	2
62	RUN6246-102026	Gear		1
63	RUN6246-102027	Gear		1
64	RUN6246-102028	Gear		1
65	RUN6246-102029	Gear		1
66	RUN6246-102030	Gear		1
67	RUN6246-102031	Gear		1
68	RUN6246-102032	Gear		1
69	RUN6246-102033	Gear		1
70	RUN6246-102034	Gear		1
71	RUN6246-102035	Gear		1
72	RUN6246-102036	Gear		1
73	RUN6246-102037	Gear		1
74	RUN6246-102025	D-Shaft		1
75	GB1096-79	Key	6 × 146	1
76	GB278-89	Ball Bearing	80203	2
77	RUN6141-102038	Gear		1
78	RUN6246-102039	F-Shaft		1
79	RUN6246-102022	Cap		1

No.	Part No.	Name	Specification	Qty.
80	RUN6246-102022-1	Sealed Mat		1
81	GB278-89	Ball Bearing	80103	1
82	RUN6246-102020	Gear		1
83	RUN6246-102019	Gear		1
84	RUN6246-102018	Gear		1
85	RUN6246-102017	Gear		1
86	RUN6246-102016	Gear		1
87	RUN6246-102015	Gear		1
88	GB1096-79	Key	6 × 20	2
89	RUN6246-102021	G-Shaft		1
90	GB894.1-86	Snap Ring	25	1
91	RUN6141-102014-1	Gear		1
92	GB278-89	Ball Bearing	80204	1
93		Oil Seal	TC20 × 40 × 7	1
94	RUN6246-102013-1	Sealed Mat		1
95	RUN6246-102013	Cap-Right		1
96	GB879-86	Spring Pin	5 × 35	1
97	GB78-85	Socket Set Screw	M8 × 10	1
98	RUN6246-102008	Claw-Shifter		1
99	GB119-86	Pin	B8 × 16	5
100	RUN6246-102007	Claw-Shifter		1
101	RUN6246-102006	Claw-Shifter		1
102	RUN6246-102005	Claw-Shifter		1
103	RUN6246-102004	Claw-Shifter		1
104	RUN6246-102009	Cam Shifter		1
105	GB879-86	Spring Pin	5 × 16	2
106	RUN6246-102010	H-Shaft		1
107	GB91-86	Split Pin	2 × 30	5
108	RUN6246-102011	H-Shaft		1
109	RUN6246-102003	Bevel Gear		1
110	GB1235-76	O-Ring	22 × 2.4	2
111	GB879-86	Spring Pin	5 × 30	3
112	RUN6246-102066	Arm		1
113	RUN6141-102062-2	Spacer		4
114	RUN6246-102075	Detent Plate		3
115	RUN6141-102072	Shaft		3
116	RUN6246-102056-1	Lever		3
117	RUN6246-102076	Speed Change Handle		1
118	GB77-85	Screw	M8 × 8	5
119	RUN6246-101088	Screw		4

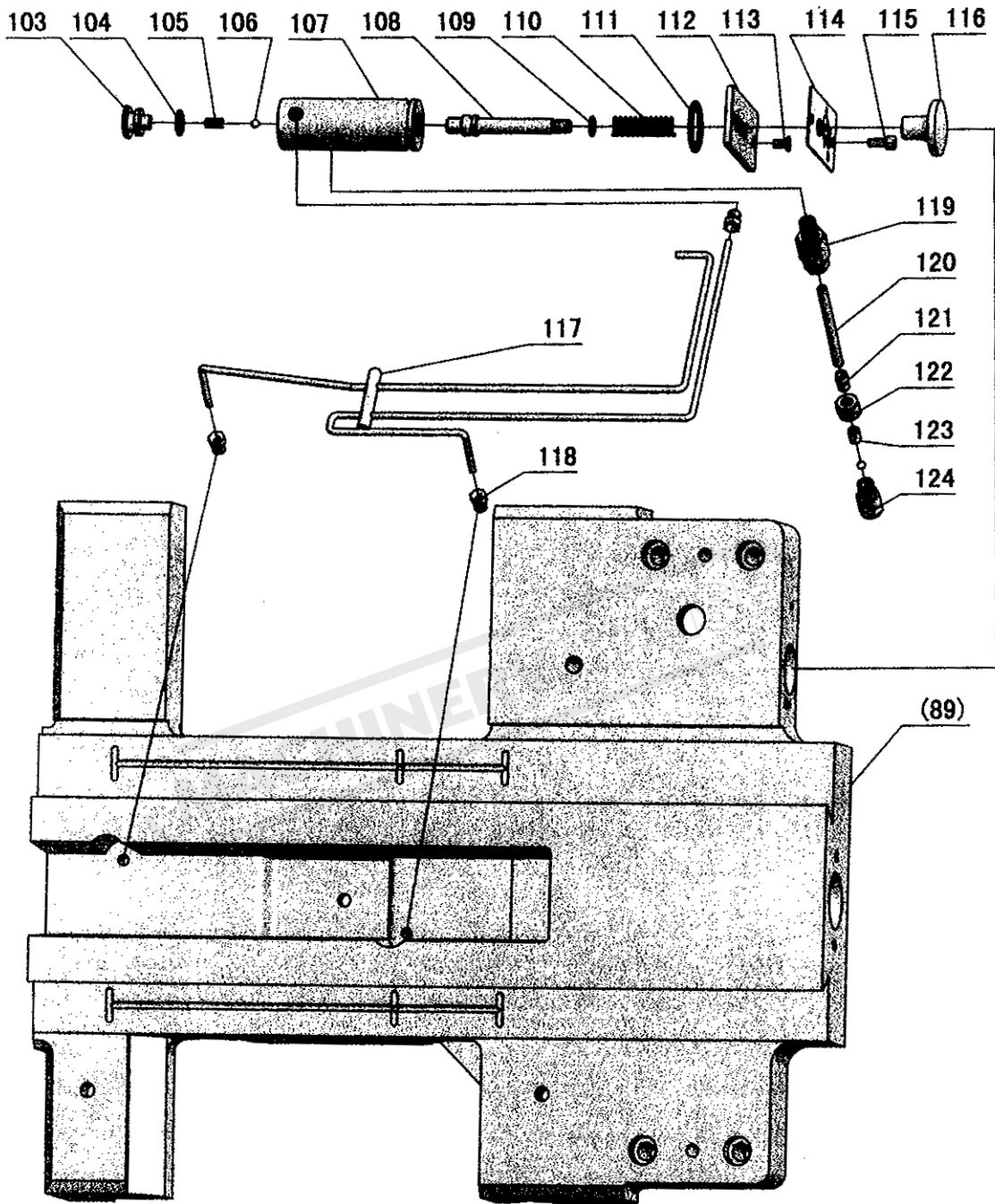
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120	RUN6246-102073	Fork		3
121	RUN6246-102067	Arm		1
122	GB1235-76	O-Ring	30 × 3.1	4
123	GB819-85	Screw	M5 × 10	6
124	GB1096-79	Key	5 × 14	3
125	RUN6246-101066	Spring		5
126	RUN6246-101070-1	Washer		4
127	RUN6246-101099	Plate		3
128	RUN6246-102068	Arm		1
129	RUN6246-102065	Speed Change Handle		2
130	GB308-77	Steel Ball	1/4"	5
131	GB879-76	Spring Pin	5 × 30	1
132	RUN6246-102060	Bevel Gear		1
133	RUN6246-102062-1	Spacer		1
134	RUN6246-102062	Shaft Sleeve		1
135	RUN6141-102055	Shaft		1
136	GB1096-79	Key	5 × 28	1
137	RUN6246-102063	Selecting Dial		1
138	RUN6246-102082	Plate		1
139	RUN6246-102053	Wheel		1

# Saddle









No.	Part No.	Name	Specification	Qty.
1	GB818-85	Screw	M4 × 12	16
2	C6251A-07-44	Case-Wiper		1
3	C6251A-07-43	Wiper		1
4	RUN6246-103056-1	Sleeve		1
5	GB2089-80	Spring	1 × 5 × 18	1
6	RUN6246-103058-2	Adjust Screw (Flat Type)		3
7	RUN6246-103057-2	Round Pin		1
8	C6251A-07-45	Four Way Tool Post		1
8	C6251A-07-46	Block-Tee (T Type)		1
9	GB83-88	Screw	M12 × 55	12
10	GB119-86	Pin	D6 × 60	3
11	GB77-85	Screw	M8 × 10	3
12	RUN6246-103062	Clamping Handle		1
13	RUN6246-103061	Clamping Handle		1
14	RUN6246-103060	Washer		1
15	GB301-84	Thrust Bearing	8104	1
16	RUN6246-103058-1	Sleeve (Flat Type)		1
17	C6251A-07-42	Tool Post Shaft (Flat Type)		1
17	C6251A-07-42-1	Tool Post Shaft (T Type)		1
18	GB77-85	Screw	M8 × 40	1
19	GB1155-79	Ball Cup	6	6
20	GB308-84	Steel Ball	1/4"	2
21	GB80-85	Screw	M8 × 10	2
22	C6251A-07-50	Compound Rest (Flat Type)		1
22	C6251A-07-50-1	Compound Rest (T Type)		1
23	RUN6246H-103043-1	Nut (Metric)		1
23	RUN6246H-103043-2	Nut (Inch)		1
24	RUN6246-103043	Screw-Compound Rest (Metric)		1
24	RUN6246-103043-3	Screw-Compound Rest (Inch)		1
25	GB77-85	Screw	M6 × 6	1
26	GB80-85	Screw	M5 × 8	1
27	GB879-86	Spring Pin	2 × 12	1
28	GB301-84	Thrust Bearing	8102	2
29	RUN6246-103044	Seat Compound Rest Screw		1
30	GB70-85	Screw	M6 × 20	2
31	RUN6246-103044-1	Nut		1
32	RUN6246-103045	Collar		1
33	RUN6246-103046-1	Dial-Compound Rest (Metric)		1
33	RUN6246-103046-2	Dial-Compound Rest (Inch)		1
34	RUN6246-103047-1	Wave Type Washer		1

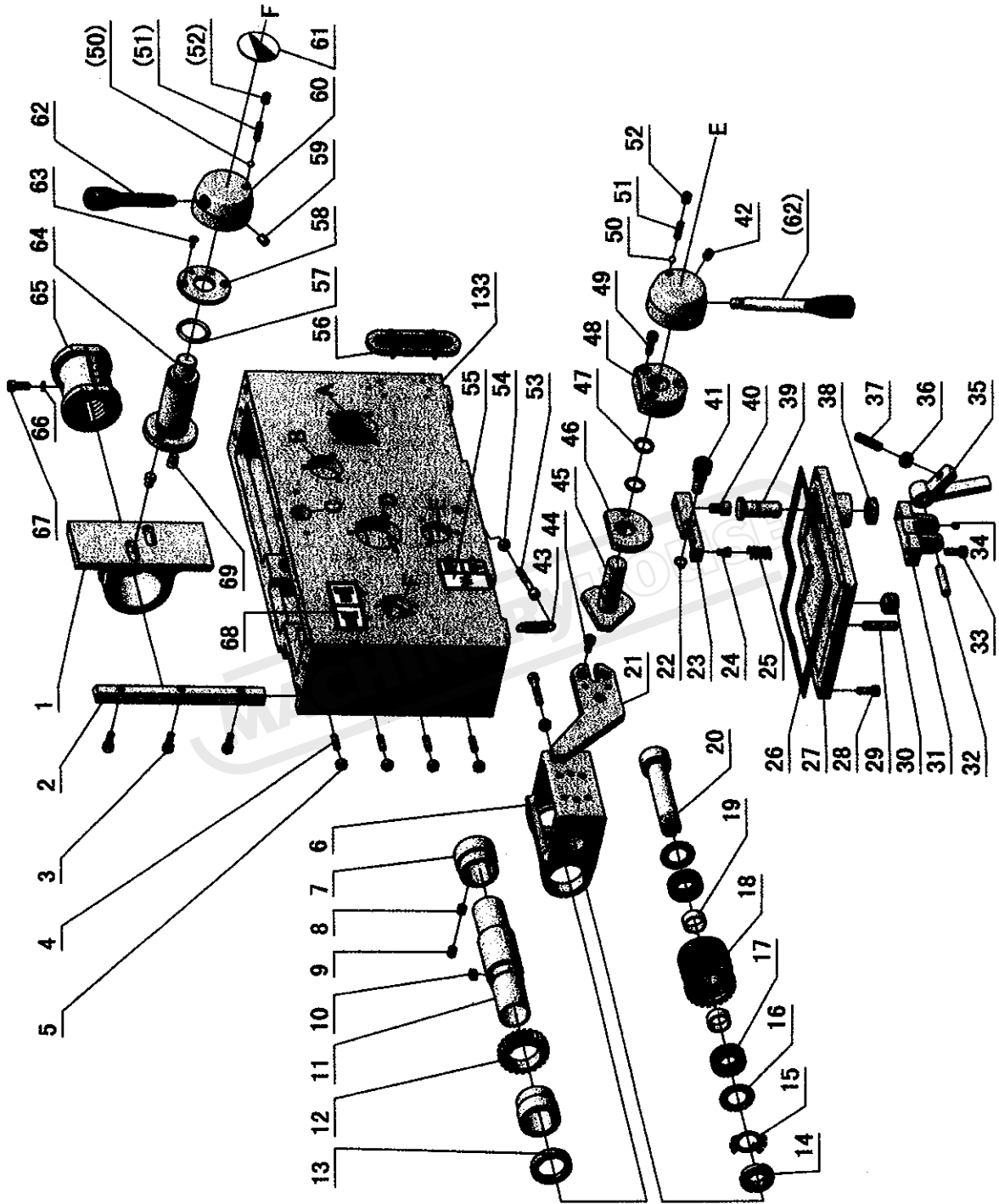
No.	Part No.	Name	Specification	Qty.
35	RUN6246-103047	Nut		1
36	RUN6246-103048	Handle		1
37	RUN6246-103049	Handle		1
38	GB70-85	Screw	M6 × 10	3
39	GB70-85	Screw (C6251A)	M10 × 55	1
39	GB70-85	Screw (C6256A)	M10 × 80	1
40	RUN6246-103037	Screw		1
41	C6251A-07-51	Gib		1
42	GB70-85	Screw (C6251A)	M10 × 40	2
42	GB70-85	Screw (C6256A)	M10 × 65	2
43	C6251A-07-41	Swivel Table		1
43	C6256A-07-41	Swivel Table		1
44	GB80-85	Screw	M6 × 10	2
45	C6251A-07-39	Case-Wiper		1
46	C6251A-07-38	Wiper		1
47	RUN6246-103036	Screw		4
48	C6251A-07-02-1	Indicator Dial		1
49	RUN6246-103040	Nut		3
50	C6251A-07-02	Cover-Cross Sliding		1
51	GB79-85	Screw	M8 × 30	1
52	GB70-85	Socket Head Cap Screw	M6 × 35	3
53	RUN6246-103022-2	Key		1
54	C6251A-07-21Y	Cross Feed Screw (Inch)		1
54	C6251A-07-21	Cross Feed Screw (Metric)		1
55	RUN6141-103003	Nut (Metric)		1
55	RUN6141-103003-1	Nut (Inch)		1
56	C6251A-07-35	Gib		1
57	RUN6246-103004	Gib		1
58	GB301-84	Thrust Bearing	8101	2
59	RUN6141-103007	Bracket		1
60	RUN6246-103007-1	Nut		1
61	RUN6141-103105	Cover		1
62	RUN6246-103030A	Handle		1
63	GB70-85	Screw	M8 × 16	1
64	RUN6246-103029	Handle		1
65	RUN6246-103028	Nut		1
66	RUN6246-103025	Wave Type Washer		1
67	RUN6141-103027	Cross Feed Dial (Metric)		1
67	RUN6141-103027-1	Cross Feed Dial (Inch)		1
68	GB70-85	Socket Head Set Screw	M8 × 70	2

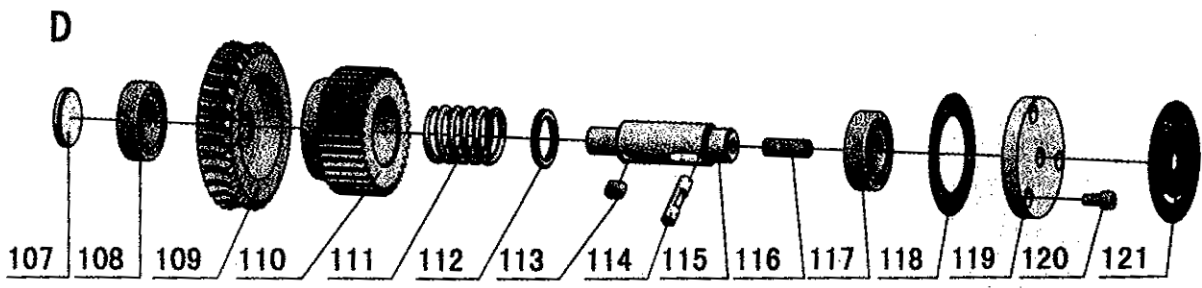
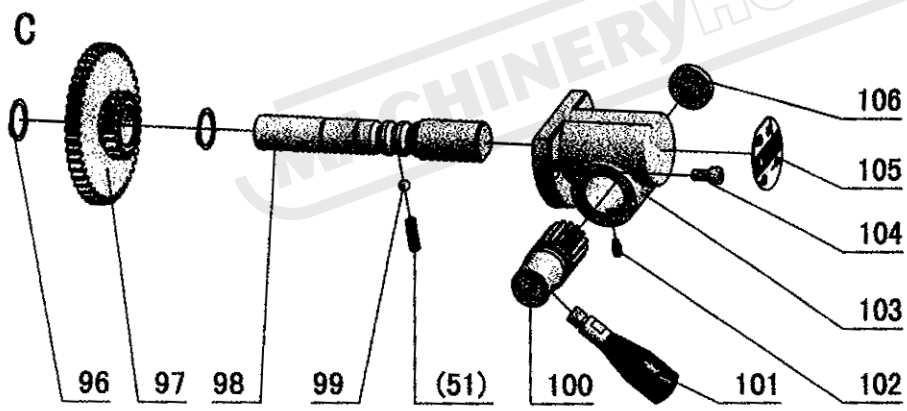
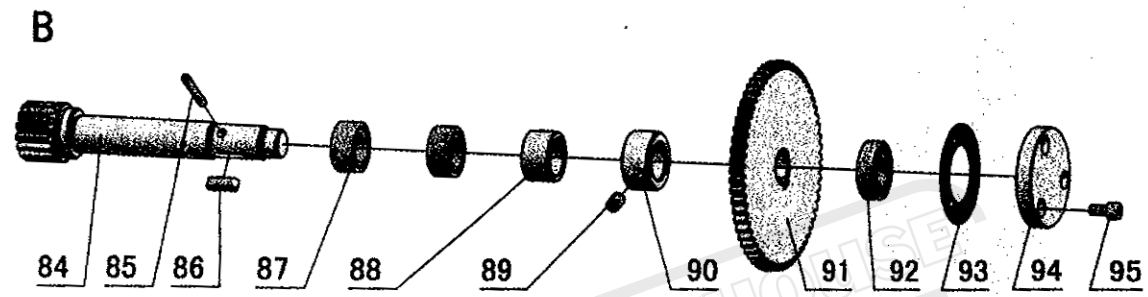
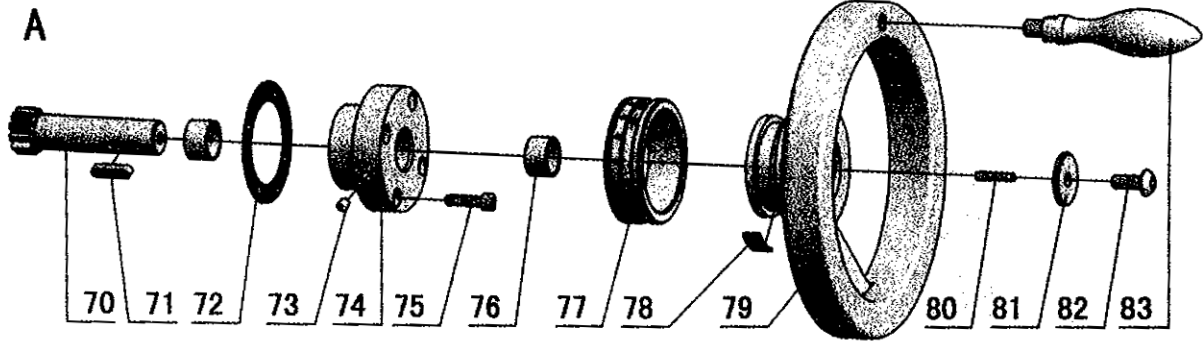
No.	Part No.	Name	Specification	Qty.
69	GB278-86	Screw	2 × 5	2
70	RUN460-105031	Plate		1
71	SF-1	Bearing	1810	2
72	GB118-86	Taper Pin	6 × 26	2
73	GB70-85	Screw	M8 × 20	6
74	GB70-85	Screw	M10 × 60	4
75	GB118-86	Taper Pin	8 × 60	2
76	C6251A-07-13	Case-Wiper		2
77	RUN6246-103026	Clutch-Dial		1
78	GB80-85	Screw	M6 × 8	1
79	C6251A-07-11	Wiper		1
80	RUN6246-103077	Bolt		1
81	C6251A-07-23	Bracket		1
82	GB1155-79	Ball Cup	8	1
83	C6251A-07-10	Case-Wiper		2
84	C6251A-07-08	Wiper		1
85	C6251A-07-22	Cross Feed Pinion		1
86	GB1567-79	Key	8 × 12	1
87	GB894-1-86	Snap Ring	24	2
88	C6251-A-07-22-2	Gear		1
89	C6251A-07-01	Saddle		1
90	RUN6246-103031-1	Plate		1
91	RUN6246-103031	Plug-Oil Inlet		1
92	C6251A-07-20	Gib-Front		1
93	RUN6246-103019	Clamp-Carriage		1
94	GB70-85	Screw	M6 × 20	1
95	C6251A-07-18	Gib-Left-Front		1
96	C6251A-07-12	Wiper		1
97	C6251A-07-15	Gib		1
98	GB70-85	Screw	M5 × 10	4
99	RUN6141-103016-1	Baffle		2
100	C6251A-07-16	Holder Gib		1
101	GB70-85	Screw	M8 × 30	4
102	C6251A-07-09	Wiper		1
103	RUN6246-103070	Oil Plug		1
104	GB1235-76	O-Ring	16 × 2.4	1
105	GB2089-80	Spring	0.5 × 4.5 × 16	1
106	GB308-84	Steel Ball	φ 5	2
107	RUN6246-103063	Body Pump		1
108	RUN6246-103064	Piston Rod		1

No.	Part No.	Name	Specification	Qty.
109	GB3452.1-82	O-Ring	9 × 1.8	1
110	RUN6246-103065	Spring		1
111	GB1235-76	O-Ring	32 × 3.1	1
112	RUN6246-103066	Bottom Board		1
113	GB68-85	Screw	M5 × 10	2
114	RUN6246-103068	Plate		1
115	GB70-85	Screw	M5 × 12	2
116	RUN6246-103067	Plug		1
117	RUN6141-103106	Vitta welding		1
118		Tube Fitting	Z 1/8" × φ 4	3
119		Tube Fitting	Z 1/8" × φ 6	1
120		Brass Tube	φ 6 × 170	1
121	RUN6246-103071	Tube Fitting		1
122	RUN6246-103072	Nut		1
123	RUN6246-103073-2	Sleeve		1
124	RUN6246-103073-1	One Way Valve Ass		1

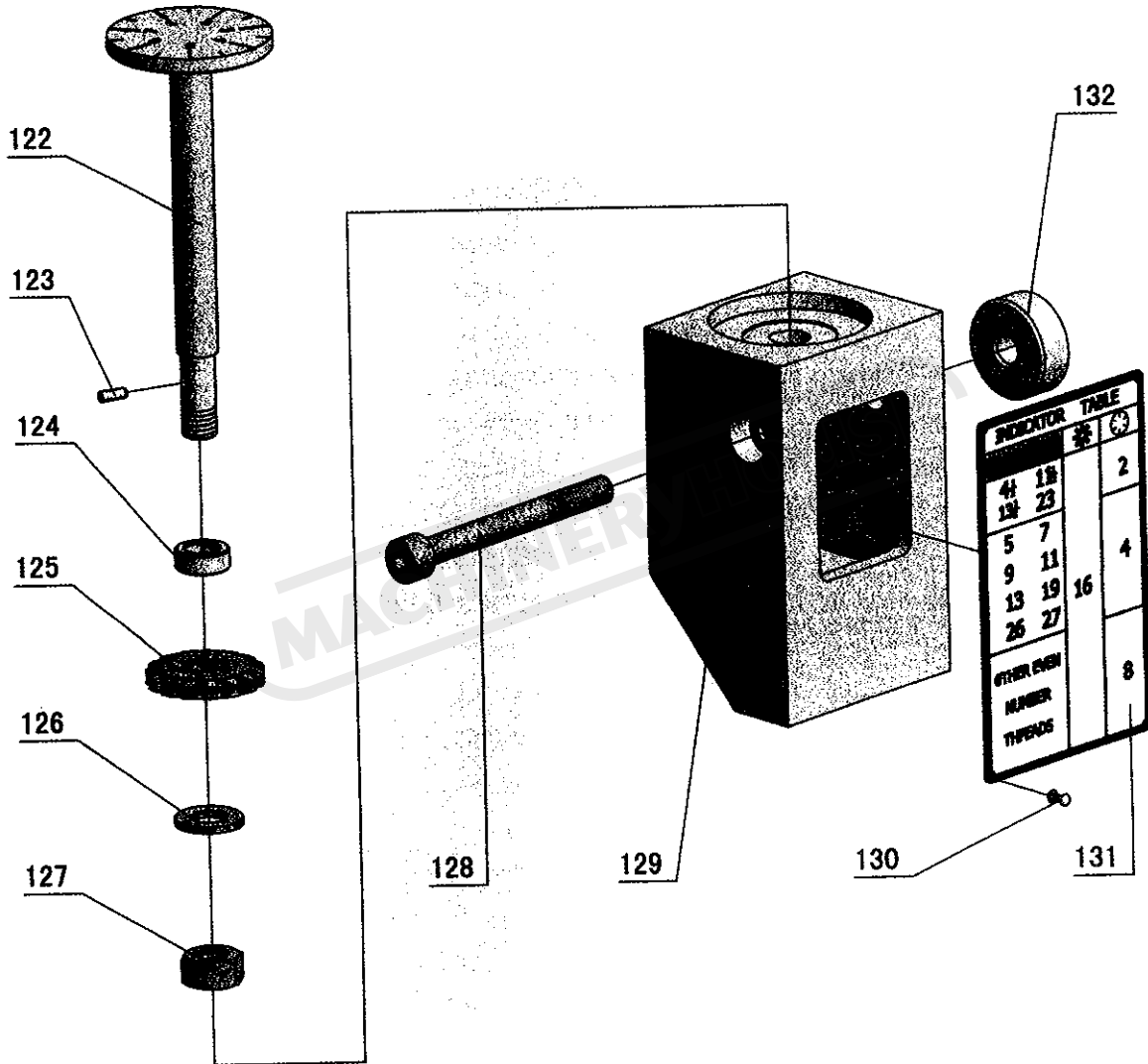
MACHINERYHOUSE

# Apron





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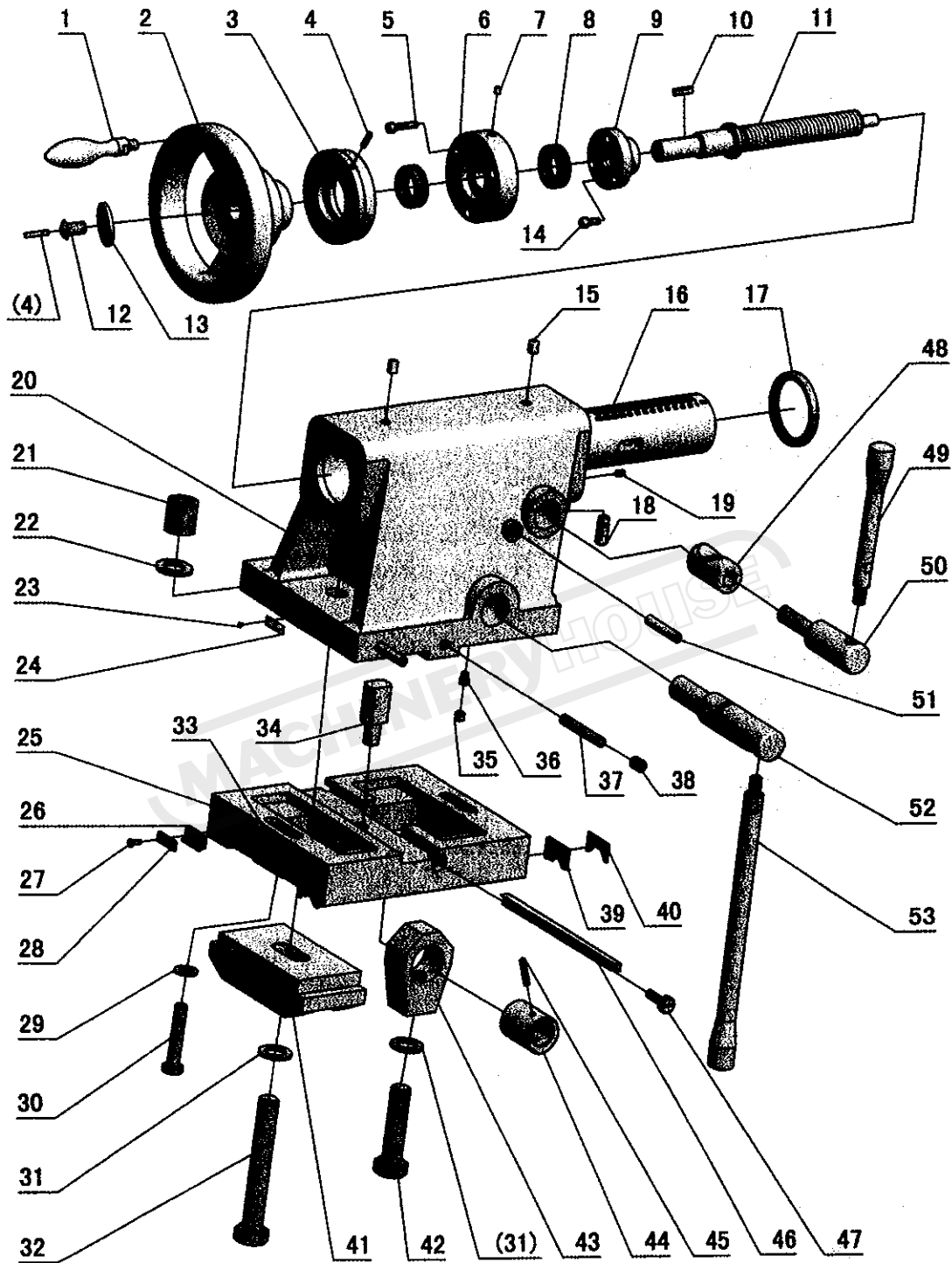
No.	Part No.	NAME	Specification	Qty
1	RUN460-104003A	LEAD NUT ASSY (RIGHT		1
2	RUN460-104002	GIB		1
3	GB70-85	SCREW	M6 × 16	3
4	GB80-85	SCREW	M6 × 20	4
5	GB6170-86	NUT	M6	4
6	RUN460-104018-01	SEAT-WORM		1
7	RUN460-104015	BUSHING		2
8	GB80-85	SCREW	M8 × 10	2
9	GB77-85	SCREW	M8 × 10	2
10	GB1096-79	KEY	6 × 12	1
11	RUN460-104016	SLEEVE-FEED ROD		1
12	RUN460-104017	GEAR		1
13		OIL SEAL	TC32 × 42 × 8	2
14	GB812-88	NUT	M20 × 1.5	1
15	GB858-88	NUT	20	1
16	RUN6246-104020-1	WASHER		2
17	GB301-84	THRUST BEARING	8104	2
18	RUN460-104020	WORM GEAR		1
19	CB85-2010	SET	20	2
20	RUN6246-104019	SHAFT		1
21	RUN460-104023-01	SAFE DEVICE BLOCK		1
21	RUN460-104023-02	SAFE DEVICE BLOCK (LEFT		1
22	GB894.1-86	SNAP RING	10	1
23	RUN460-104030	LEVER		1
24	GB70-85	SCREW	M5 × 8	1
25	RUN460-104032	SPRING		1
26	RUN460-104011	BOTTOM COVER		1
27	RUN460-104011-1	SEALED MAT		1
28	GB70-85	SCREW	M6 × 16	9
29	GB77-85	SCREW	M6 × 35	1
30	G38-3A	OIL PLUG	Z 3/8"	1
31	RUN460-104012	BRACKET		1
32	GB119-86	PIN	B8 × 40	1
33	GB70-85	SCREW	M6 × 16	2
34	GB80-85	SCREW	M6 × 6	1
35	RUN460-104014	LEVER		1
36	GB77-85	SCREW	M8 × 30	1
37	GB6170-86	NUT	M8	1
38		OIL SEAL	TC15 × 25 × 7	1
39	RUN460-104010	PIN		1

No.	Part No.	NAME	Specification	Qty
40	GB70-85	SCREW	M8 × 12	1
41	RUN460-104031	SCREW		1
42	GB80-85	SCREW	M8 × 10	1
43	RUN460-104022-01	SPRING		1
44	GB70-85	SCREW	M6 × 12	3
45	RUN460-104026-01	SHAFT (RIGHT HAND)		1
46	RUN460-104027	BUFFER		1
47		O-RING	20 × 24	2
48	RUN460-104028	SLEEVE		1
49	GB70-85	SCREW	M6 × 20	3
50	GB308-84	STEEL BALL	1/4"	2
51	RUN6246-101066	SPRING		3
52	GB77-85	SCREW	M8 × 10	2
53	GB70-85	SCREW	M6 × 35	2
54	GB6170-86	NUT	M6	2
55	RUN6246-104074	KNOB (RIGHT HAND)		1
56	RUN460-104068	OIL SIGHT		1
57	GB1235-76	O-RING	32 × 35	2
58	RUN6246-104007-01	SHAFT SLEEVE (RIGHT		1
58	RUN6246-104007-02	SHAFT SLEEVE (LEFT		1
59	GB80-85	SCREW	M8 × 10	1
60	RUN460-104007-02	SHAFT SLEEVE (RIGHT		1
61	RUN6246-101099	PLATE		1
62	RUN460-104008	LEVER		2
63	GB819-85	SCREW	M4 × 10	2
64	RUN460-104006-01	SHAFT (RIGHT HAND)		1
64	RUN460-104006-02	SHAFT (LEFT HAND)		1
65	C6251A-06-01	HAFT NUT (METRIC)		1
65	C6251A-06-01Y	HAFT NUT (INCH)		1
66	GB93-87	SPRING PIN	6	2
67	GB70-85	SCREW	M6 × 16	2
68	RUN460-104073	PLATE (RIGHT HAND)		1
69	RUN460-104005	KEY		2
70	RUN460-104051	SHAFT		1
71	GB1096-79	KEY	6 × 25	1
72	RUN460-104052-1	SEALED MAT		1
73	GB1155-89	BALL CUP	6	1
74	RUN460-104052	SEAT		1
75	GB70-85	SCREW	M6 × 25	4
76	SF-1	BEARING	2010	2

No.	Part No.	NAME	Specification	Qty
77	RUN460-104054-01	DIAL-RACK (METRIC)		1
78	Q67-4-33	SPRING	80	1
79	RUN460-104055	HAND WHEEL		1
80	GB77-85	SCREW	M4 × 20	1
81	RUN460-104057	WASHER		1
82	RUN6246-101088	SCREW		1
83	RUN460-104056A	HANDLE		1
84	RUN460-104047	PINON		1
85	GB879-86	PIN	5 × 35	1
86	GB1096-79	KEY	6 × 20	1
87	GB5801-86	NEEDLE BEARING	4644903	2
88	RUN460-104053	SLEEVE		1
89	GB80-85	SCREW	M8 × 12	1
90	RUN460-104048	SPACER		1
91	RUN460-104049	GEAR		1
92	GB278-89	BALL BEARING	80103	1
93	RUN460-104050-1	SEALED MAT		1
94	RUN460-104050	COVER		1
95	GB70-85	SCREW	M6 × 12	3
96	GB894.1-86	SNAP RING	20	2
97	RUN460-104041	GEAR		1
98	RUN460-104042	SHAFT		1
99	GB308-84	STEEL BALL	7/32"	1
100	RUN460-104044	CHANGE GEAR		1
101	RUN460-104045	HANDLE LEVER		1
102	GB79-85	SCREW	M5 × 10	1
103	RUN460-104043	CHANGE SLEEVE		1
104	GB70-85	SCREW	M6 × 12	2
105	RUN460-104077	PLATE		1
106	RUN460-104043-1	PLUG		1
107	RUN460-104036-1	COVER		1
108	GB278-89	BALL BEARING	180105	1
109	RUN460-104034	WORM GEAR		1
110	RUN460-104035	GEAR		1
111	RUN460-104038	SPRING		1
112	RUN460-104039	SPACER		1
113	GB1096-79	KEY	8 × 12	1
114	RUN460-104037	PIN		1
115	RUN460-104036	COVER		1
116	GB77-85	SCREW		1

No.	Part No.	NAME	Specification	Qty
117	GB278-89	BALL BEARING	80204	1
118	RUN460-104040-1	SEALED MAT		1
119	RUN460-104040	COVER		1
120	GB70-85	SCREW	M6 × 12	3
121	RUN6246-104072	PLATE		1
122	RUN460-104059B	DIAL INDICATOR SHAFT		1
123	GB879-86	PIN	3 × 8	1
124	RUN460-104046	SPACER		1
125	RUN460-104060	GEAR (METRIC)		1
126	GB97.2-85	WASHER	10	1
127	GB6170-86	NUT	M10	1
128	GB70-85	SCREW	M8 × 85	1
129	RUN460-104058	THREAD DIAL BODY		1
130	GB827-86	RIVET	2 × 5	10
131	RUN6246-104071	INDICATOR DIAL (METRIC)		1
132	RUN460-104024	SPACER		1
133	RUN6246-104001A	APRON (RIGHT HAND)		1
133	RUN460-104001B	APRON (LEFT HAND)		1

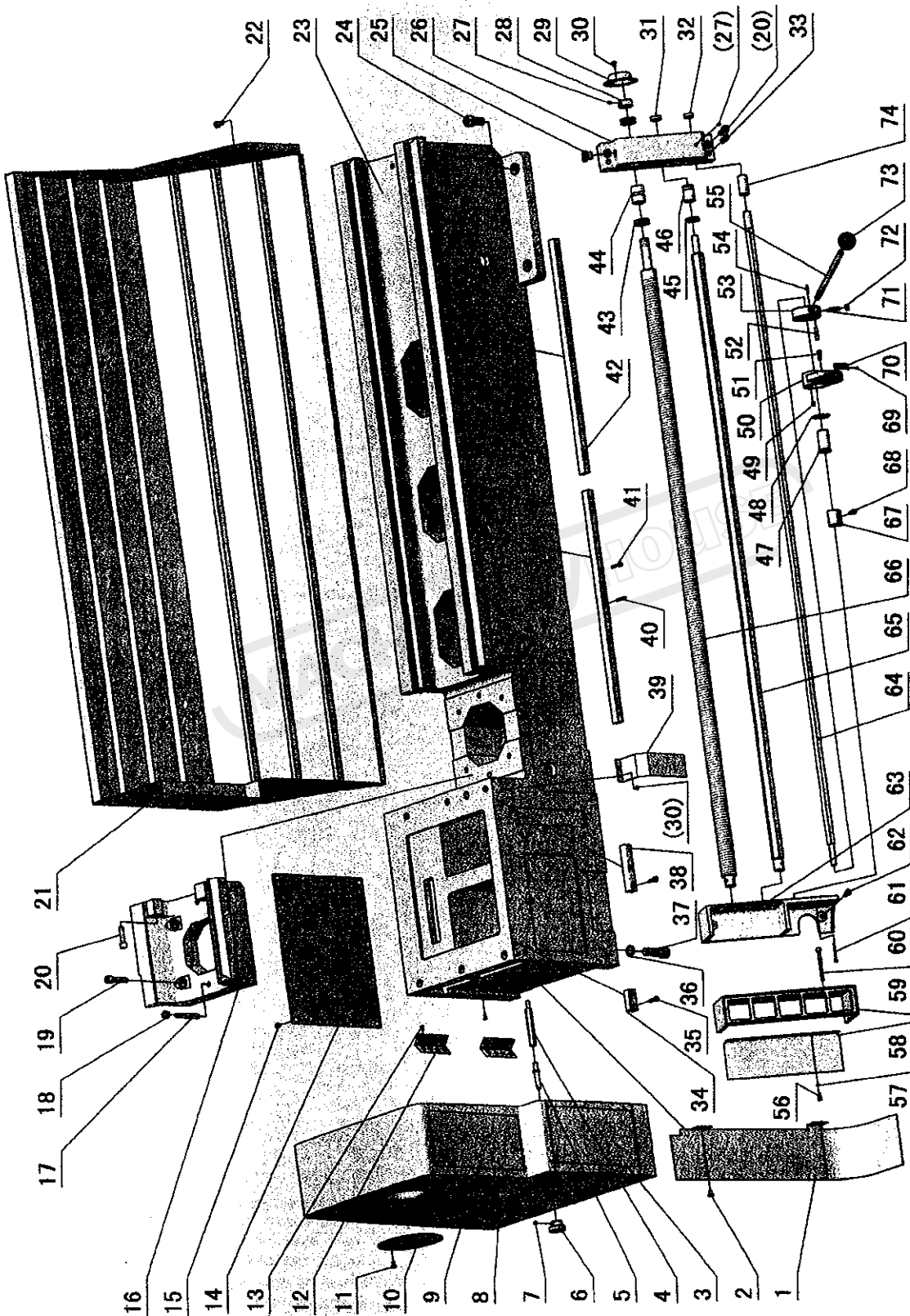
### Tailstock



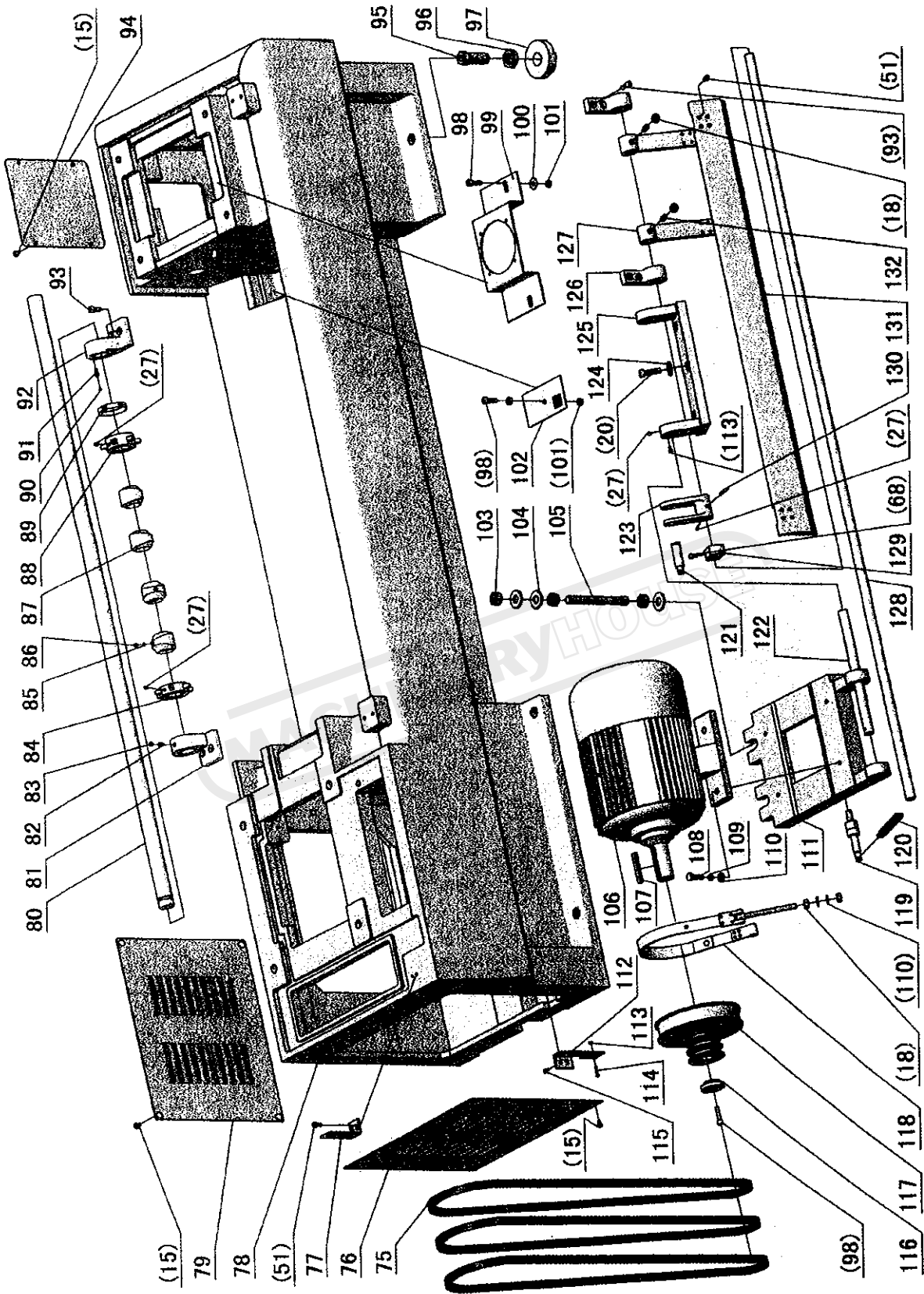
No.	Part No.	Name	Specification	Qty.
1	RUN460-104056A	Handle		1
2	C6246B-105010	Handle Wheel		1
3	C6251A-08A-03	Dial-Feed (Metric)		1
3	C6251A-08A-03Y	Dial-Feed (Inch)		1
4	GB80-85	Screw	M5 × 25	2
5	GB70-85	Screw	M6 × 35	3
6	C6251A-08A-02	Cap-Body End		1
7	GB1155-79	Ball Cup	6	1
8	GB301-84	Thrust Bearing	8105	2
9	C6246B-105005	Feed Nut (Metric)		1
9	C6246B-105005-1	Feed Nut (Inch)		1
10	GB1096-79	Key	6 × 16	1
11	C6251A-08A-01	Feed Screw (Metric)		1
11	C6251A-08A-01Y	Feed Screw (Inch)		1
12	C6266-08-18	Screw		1
13	C6266-08-19	Washer		1
14	GB70-85	Screw	M6 × 16	4
15	GB1155-79	Ball Cup	10	2
16	C6246B-105003	Tailstock Sleeve		1
17	HG4-692-67	Oil-Seal	PD75 × 95 × 12	1
18	C6246B-105030	Pin Shaft		1
19	GB80-85	Screw	M6 × 10	1
20	C6251A-08-01	Tailstock Body		1
21	GB56-88	Nut	M20	1
22	GB95-85	Washer	20	1
23	RUN460-105031	Plate		1
24	GB827-86	Rivet	2 × 5	4
25	C6251A-08-02	Bottom Tailstock		1
25	C6256A-08-02	Bottom Tailstock		1
26	C6251A-08-09	Wiper		2
27	GB818-85	Cross Recessed Head Screw	M4 × 12	8
28	C6251A-08-08	Case-Wiper		2
29	GB95-85	Washer	12	2
30	GB5782-86	Screw (C6251A)	M12 × 70	2
30	GB5782-86	Screw (C6256A)	M12 × 90	2
31	GB848-85	Washer	20	1
32	GB37-88	Bolt (C6251A)	M20 × 150	1
32	GB37-88	Bolt (C6256A)	M20 × 175	1
33	RUN460-105032	Plate		1
34	RUN460-105017	Block-Adjusting		1

No.	Part No.	Name	Specification	Qty.
35	GB77-86	Screw	M10 × 8	1
36	GB79-85	Screw	M10 × 12	1
37	GB119-86	Pin Shaft	12 × 85	2
38	GB80-85	Screw	M16 × 20	2
39	C6251A-08-06	Wiper		2
40	C6251A-08-07	Case-Wiper		2
41	C6251A-08-03	Clamping Handle		2
42	GB5782-86	Screw (C6251A)	M20 × 100	1
42	GB5782-86	Screw (C6256A)	M20 × 125	1
43	RUN460-105018	Bracket		1
44	RUN460-105028	Eccentric Block		1
45	GB879-86	Spring Pin	6 × 36	1
46	C6246B-105012	Taper Gib Strip		1
47	RUN460-105020	Screw		1
48	C6246B-105021	Block Clamp		1
49	RUN460-105004	Lead Screw		1
50	C6251A-08-05	Shaft		1
51	RUN6246-105007	Screw-Brake		2
52	C6251A-08-04	Shaft		1
53	RUN460-105006	Lead Screw		1

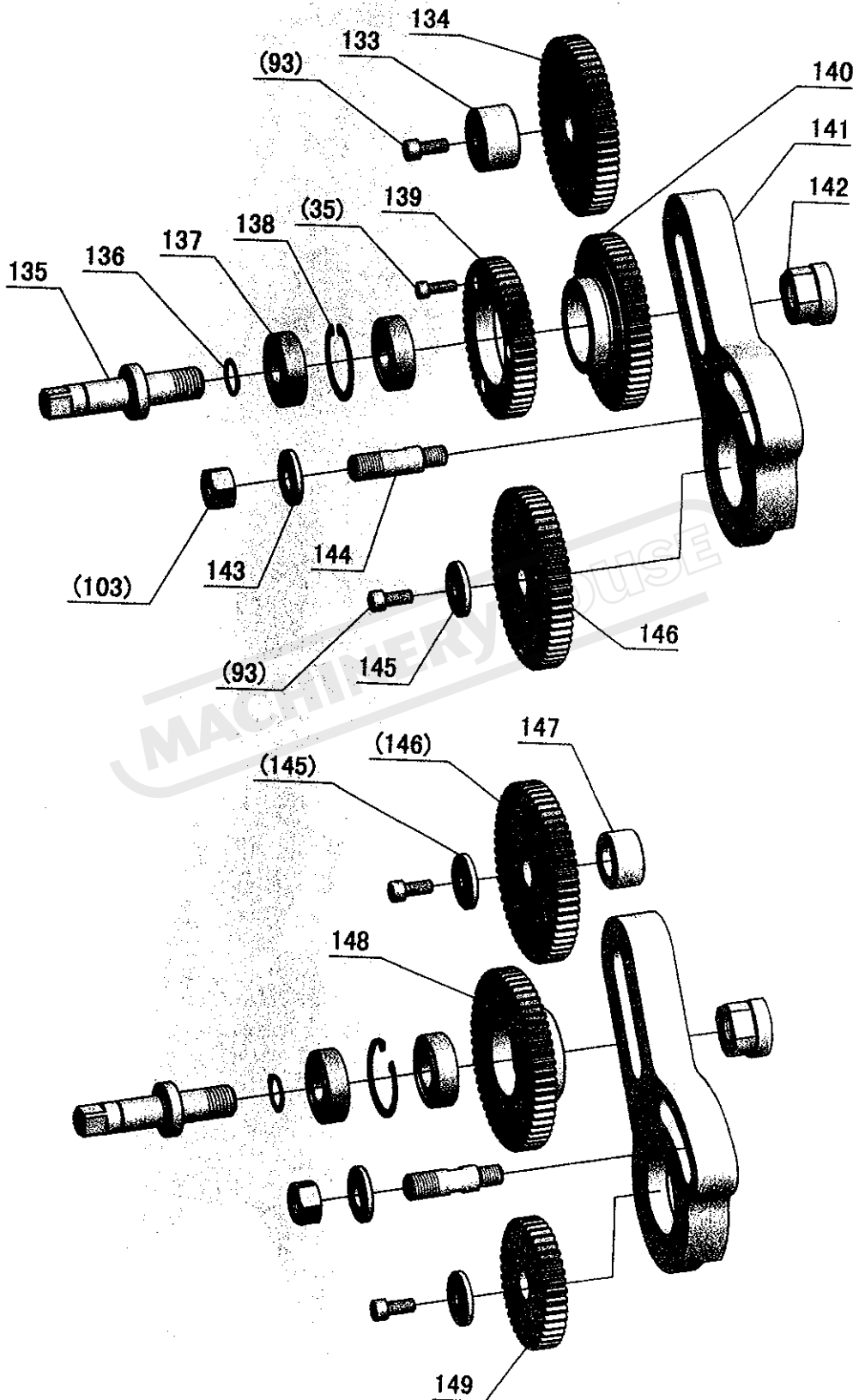
### Bed Assembly



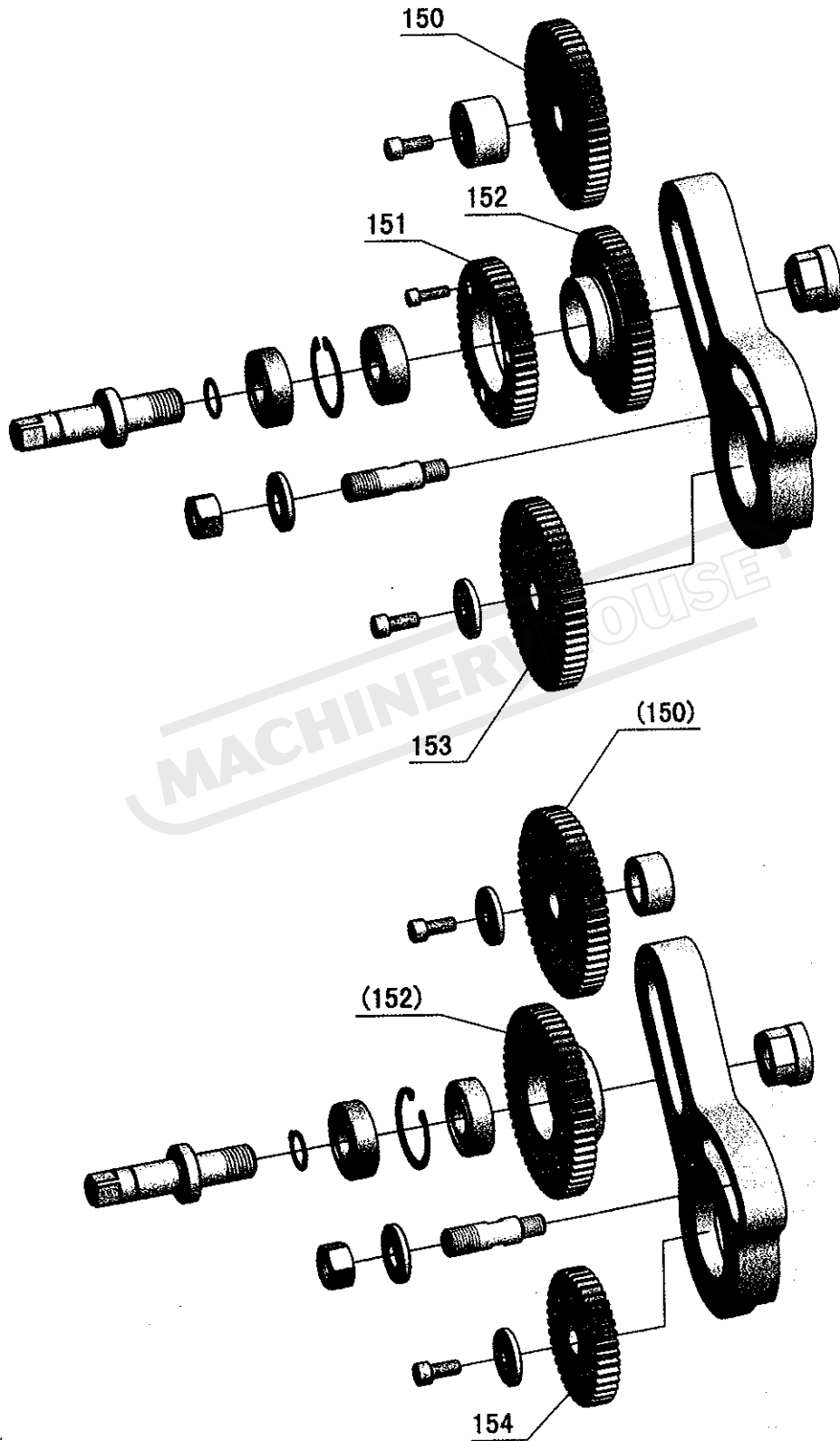




(Metric)



(Inch)



No.	Part No.	Name	Specification	Qty.
1	C6251A-01-20	Oil Guard		1
1	C6256A-01-20	Oil Guard		1
2	GB70-85	Screw	M6 × 10	2
3	RUN6246-108094	Plate		1
4	C6251A-05-12	Screw		1
5	RUN6246-108074	Screw		1
6	RUN6246-108073	Nut		1
7	GB79-85	Screw	M6 × 8	1
8	C6251A-04-02	Cover-End		1
8	C6256A-04-02	Cover-End		1
9	C6251A-04-04	Plate (Metric)		1
9	C6251A-04-04Y	Plate (Inch)		1
10	C6251A-04-05	Cover		1
11	GB/T70.2-2000	Screw	M6 × 10	1
12	GB7277-87	Hinge	100	2
13	GB68-85	Screw	M5 × 10	16
14	RUN6246-106071	Electric Cover		1
15	GB818-85	Screw	M6 × 10	16
16	C6251A-01-02	Bed Gap		1
17	GB118-86	Pin	10 × 70	2
18	GB6170-86	Nut	M10	6
19	GB70-85	Screw	M12 × 50	4
20	GB70-85	Screw	M10 × 40	7
21	C6251A-01-15A	Guard Assembly 1000		1
21	RUN6246-106072B	Guard Assembly 1500		1
21	RUN6246-106072C	Guard Assembly 2000		1
21	C6251A-01-15D	Guard Assembly 3000		1
22	GB70-85	Screw	M8 × 16	4
23	C6251A-01-01	Bed 1000		1
23	C6251A-01-01-1	Bed 1500		1
23	C6251A-01-01-2	Bed 2000		1
23	C6251A-01-01-5	Bed 3000		1
24	GB70-85	Screw	M16 × 35	4
25	RUN6246-106010-4	Plug-Oil Inlet		1
26	C6251A-01-07	Bracket		1
27	GB80-85	Screw	M6 × 8	
28	C6251A-01-04	Nut		1
29	RUN6246-106031	Cover		1
30	GB818-85	Screw	M5 × 8	5
31	RUN6246-106010-1	Plug		1

No.	Part No.	Name	Specification	Qty.
32	RUN6246-106010-2	Plug		1
33	GB118-86	Taper Pin	10 × 45	2
34	C6251A-01-19	Block		1
35	GB70-85	Screw	M6 × 25	7
36	GB93-86	Spring Washer	16	4
37	GB70-85	Screw	M16 × 55	4
38	C6251A-01-18	Block		1
39	RUN6246-106009	Protection Cover		1
40	GB879-86	Spring Pin	5 × 30	6
41	GB70-85	Screw	M6 × 25	8
42	C6251A-01-05	Rack (Left Hand)		1
42	RUN6246-106005B	Rack		1
42	RUN6246-106005C	Rack		1
43	GB301-84	Thrust Bearing	8105	2
44	C6251A-01-07-1	Bush		1
45	RUN6246-106010-7	Spacer		1
46	RUN6246-106008	Bush		1
47	RUN6246-106056	Shaft Sleeve		1
48	RUN6246-106058	Washer		1
49	Q81-1	Spring	1 × 6 × 20	3
50	RUN6246-106059	Switch Bracket		1
51	GB70-85	Screw	M6 × 16	12
52	RUN6246-106055	Pin		1
53	RUN6246-106053	Bracket		1
54	GB879-86	Spring Pin	3 × 20	1
55	RUN6246-106057A	Lever		1
56	GB70-85	Screw	M5 × 10	2
57	GB93-87	Washer	5	2
58	RUN6141-106018-1	Cover		1
59	RUN6141-106018	Seat-Pilot Light		1
60	GB70-85	Screw	M6 × 70	2
61	GB70-85	Screw	M4 × 40	2
62	GB70-85	Screw	M8 × 25	2
63	RUN6246-106016	Seat-Switch		1
64	C6251A-01-09	Started Rod 1000		1
64	C6251A-01-09-1	Started Rod 1500		1
64	C6251A-01-09-2	Started Rod 2000		1
64	C6251A-01-09-5	Started Rod 3000		1
65	C6251A-01-08	Feed Rod 1000		1
65	C6251A-01-08-1	Feed Rod 1500		1

No.	Part No.	Name	Specification	Qty.
65	C6251A-01-08-2	Feed Rod 2000		1
65	C6251A-01-08-5	Feed Rod 3000		1
66	C6251A-01-06	Lead Screw 1000 (Metric)		1
66	C6251A-01-06-1	Lead Screw 1500 (Metric)		1
66	C6251A-01-06-2	Lead Screw 2000 (Metric)		1
66	C6251A-01-06-5	Lead Screw 3000 (Metric)		1
66	C6251A-01-06Y	Lead Screw 1000 (Inch)		1
66	C6251A-01-06Y-1	Lead Screw 1500 (Inch)		1
66	C6251A-01-06Y-2	Lead Screw 2000 (Inch)		1
66	C6251A-01-06Y-5	Lead Screw 3000 (Inch)		1
67	CM6233-2055	Cam		1
68	GB70-85	Screw	M6 × 12	2
69	GB827-86	Screw	2 × 5	2
70	RUN6246-106089	Plate		1
71	GB79-85	Screw	M8 × 30	2
72	GB6170-86	Nut	M8	2
73	Z16-1	Lever Bush	M12 × 40	1
74	RUN6246-106014	Bush		1
75	GB1171-74	Belt (C6251A)	B76(60Hz)	1
75	GB1171-74	Belt (C6256A)	B78(60Hz)	1
75	GB1171-74	Belt (C6251A)	B77(50Hz)	1
75	GB1171-74	Belt (C6256A)	B79(50Hz)	1
76	C6251A-01-11	Cover Motor Seat		1
77	RUN6246-108078	Limited Switch Seat		1
78	C6251A-01-03	Stand 1000		1
78	C6251A-01-03-1	Stand 1500		1
78	C6251A-01-03-2	Stand 2000		1
78	C6251A-01-03-5	Stand 3000		1
79	RUN6246-106028-1	Cover Motor Seat		1
80	C6251A-01-10	Auto Stopping Rod 1000		1
80	C6251A-01-10-1	Auto Stopping Rod 1500		1
80	C6251A-01-10-2	Auto Stopping Rod 2000		1
80	C6251A-01-10-5	Auto Stopping Rod 3000		1
81	RUN6141-106024	Bracket		1
82	GB79-85	Screw	M8 × 12	1
83	GB77-85	Screw	M8 × 6	1
84	RUN6246-106019-1	Star Type Ring		1
85	RUN6246-106020-1	Shoe Clamp		4
86	GB80-85	Screw	M8 × 6	4
87	RUN6246-106020	Cam		4

No.	Part No.	Name	Specification	Qty.
88	RUN6246-106019-2	Star Type Ring		1
89	RUN6246-106019-5	Plate		1
90	GB308-84	Steel Ball	6	1
91	Q81-1	Spring	1 × 5 × 25	1
92	RUN6141-106025	Bracket		1
93	GB70-85	Screw	M8 × 20	10
94	C6251A-01-12	Pump Hole Cover		1
95	RUN6246-106029	Bolt		6
96	GB6173-86	Nut	M24 × 2	6
97	RUN6246-106069	Block-Leveling		6
98	GB70-85	Screw	M8 × 30	4
99	C6251A-01-17	Coolant Pump Seat 1000		1
99	C6251A-01-17	Coolant Pump Seat 1500		1
99	C6251A-01-17	Coolant Pump Seat2000		1
99	C6251A-01-17-5	Coolant Pump Seat 3000		1
100	GB96-85	Washer	8	2
101	GB6170-86	Nut	M8	4
102	RUN6246-106051	Screen		1
103	GB6170-86	Nut	M16	7
104	RUN6246-106079	Washer		6
105	RUN6246-106046	Screw		2
106	Y132M-4	Motor	7.5kw	1
107	GB1096C-79	Key	10 × 70	1
108	GB5782-86	Bolt	M10 × 35	4
109	GB93-87	Spring Washer	10	4
110	GB97.1-86	Washer	10	4
111	RUN6246-106034	Motor Seat		1
112	RUN6246-106091	Limited Switch Seat		1
113	GB6170-86	Nut	M4	2
114	GB818-85	Screw	M4 × 20	2
115	GB70-85	Screw	M5 × 8	3
116	RUN6141-106049a	Washer		1
117	RUN6141-106048a	Belt Pulley	60Hz	1
117	RUN6141-106048a-1	Belt Pulley	50Hz	1
118	RUN6246-106047	Belt-Brake		1
119	RUN6246-106050	Shaft		1
120	Q81-3	Spring	3 × 16 × 115	1
121	RUN6246-106039	Shaft		1
122	RUN6246-106044	Shaft		1
123	RUN6246-106040	Arm Brake		1

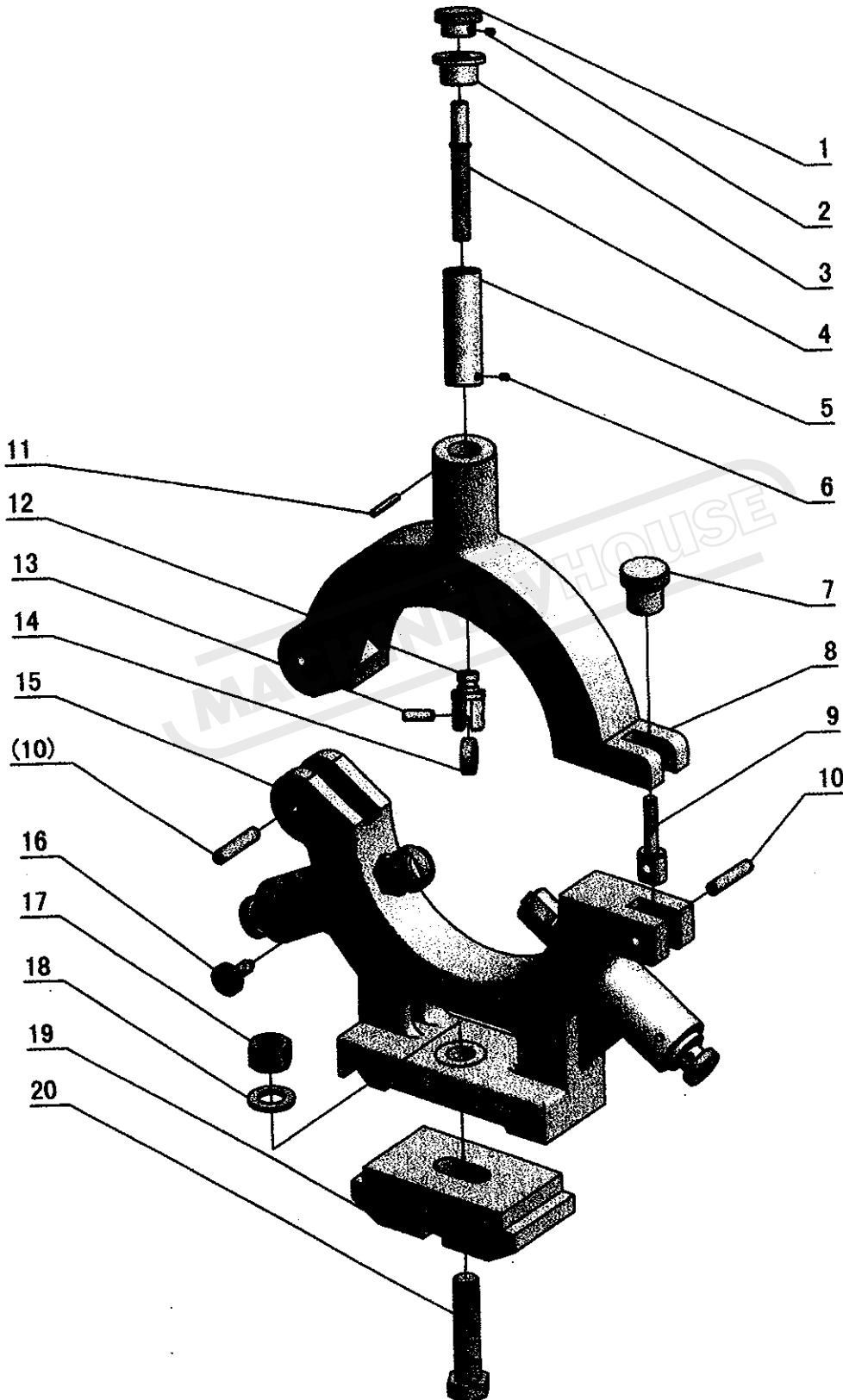
No.	Part No.	Name	Specification	Qty.
124	RUN6246-106097	Washer		3
125	RUN6246-106041	Bracket-Motor Seat		1
126	RUN6246-106036	Bracket		2
127	RUN6246-106042A	Arm		2
128	C6251A-01-14	Shaft 1000		1
128	C6251A-01-14-1	Shaft 1500		1
128	C6251A-01-14-2	Shaft 2000		1
128	C6251A-01-14-5	Shaft 3000		1
129	RUN6246-106037	Cam		1
130	GB879-86	Spring Pin	5 × 40	1
131	C6251A-01-13	Pedal-Brake 1000		1
131	C6251A-01-13-1	Pedal-Brake 1500		1
131	C6251A-01-13-2	Pedal-Brake 2000		1
131	C6251A-01-13-5	Pedal-Brake 3000		2
132	GB79-85	Screw	M10 × 25	2
133	RUN6141-108002	Spacer		1
134	C6251A-04-03	Gear	55T × M2.25	1
134	C6256A-04-03	Gear	55T × M2.5	1
135	RUN6141-108004	Bolt		1
136	GB894.1-86	Snap Ring	20	1
137	GB278-89	Ball Bearing	180204	2
138	GB893.1-86	Snap Ring	47	1
139	C6251A-05-10	Gear	49T × M2.25	1
139	C6256A-05-10	Gear	49T × M2.5	1
140	C6251A-05-11	Gear	54T × M2.25	1
140	C6256A-05-11	Gear	54T × M2.5	1
141	C6251A-05-08	Bracket		1
142	RUN6141-108005	Nut		1
143	RUN6141-108017	Washer		1
144	C6251A-05-01	Bolt		1
145	C6251A-05-09	Spacer		2
146	C6251A-05-07	Gear	56T × M2.25	1
146	C6256A-05-07	Gear	56T × M2.5	1
147	RUN6141-108015	Spacer		1
148	C6251A-05-11Y	Gear	57T × M2.25	1
148	C6256A-05-11Y	Gear	57T × M2.5	1
149	C6251A-15-01	Gear	40T × M2.25	1
149	C6256A-15-01	Gear	40T × M2.5	1
150	C6251A-04-03Y	Gear	48T × M2.25	1
150	C6256A-04-03Y	Gear	48T × M2.5	1



No.	Part No.	Name	Specification	Qty.
151	C6251A-15-02y	Gear	66T × M2.25	1
151	C6256A-15-02Y	Gear	66T × M2.5	1
152	C6251A-05-11Y	Gear	57T × M2.25	1
152	C6256A-05-11Y	Gear	57T × M2.5	1
153	C6251A-15-01y	Gear	42T × M2.25	1
153	C6256A-15-01Y	Gear	42T × M2.5	1
154	C6251A-05-07Y	Gear	57T × M2.25	1
154	C6256A-05-07Y	Gear	57T × M2.5	1

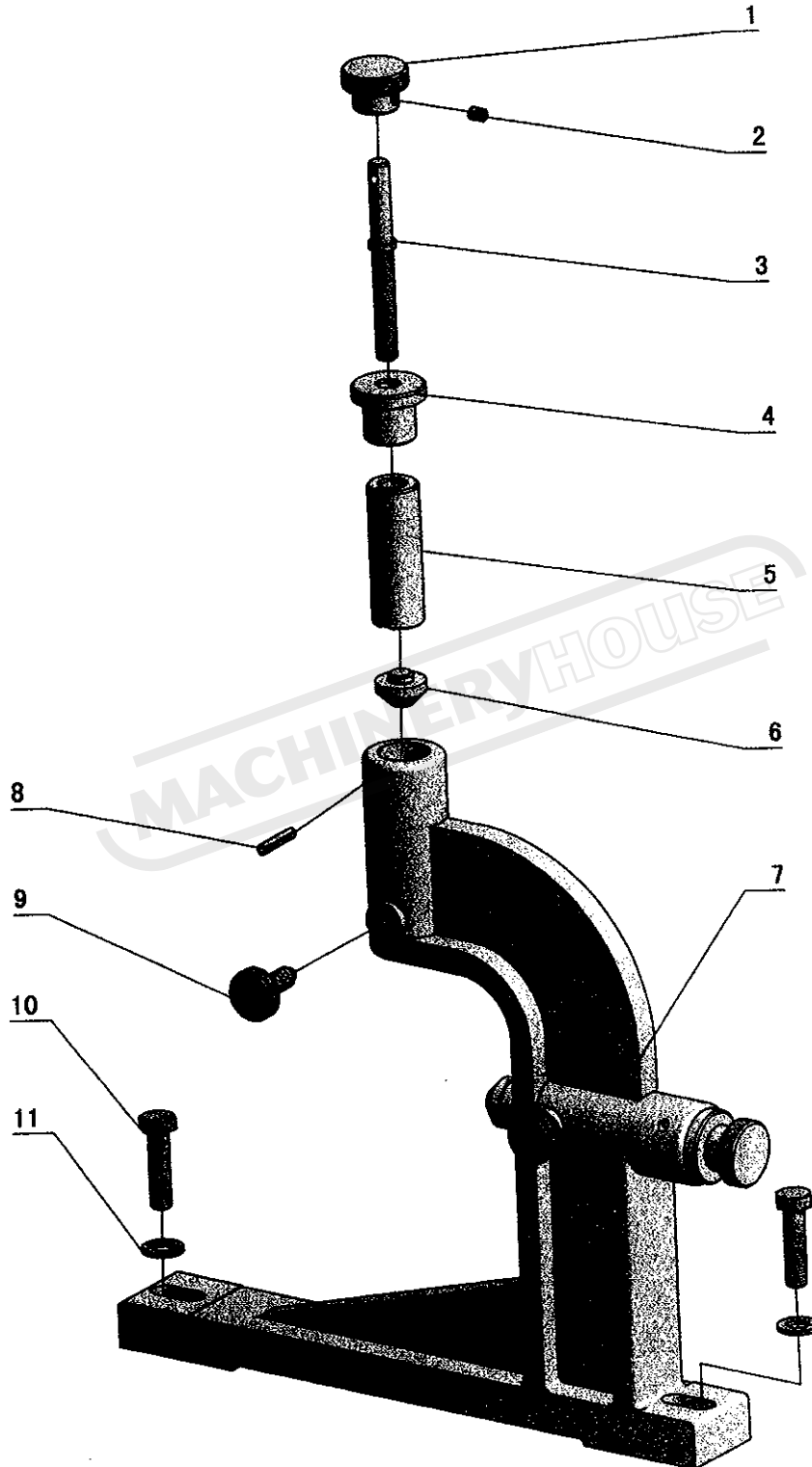
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### Steady Rest



No.	Part No.	Name	Specification	Qty.
1	C6251A-10-08	Rotate Handle		3
2	GB78-85	Screw	M6 × 8	3
3	C6251A-10-07	Bush		3
4	C6251A-10-05	Screw Shaft		3
5	C6251A-10-04	Sleeve		3
6	GB77-85	Screw	M6 × 8	3
7	C6251A-10-09	Handle		1
8	C6251A-10-06	Upside Of Steady Rest		1
9	C6251A-10-10	Clamping Screw		1
10	GB119-86	Pin	10 × 60	2
11	GB879-86	Spring Pin	5 × 50	3
12	C6251A-10-02	Support Shaft		3
13	C6251A-10-03	Pin		3
14	GB279-88	Ball Bearing	180300	3
15	C6251A-10-01	Downside Of Steady Rest		1
15	C6256A-10-01	Downside Of Steady Rest		1
16	RUN6246-110018	Limited Screw		3
17	GB55-88	Nut	M20	1
18	GB97.2-85	Washer	20	1
19	C6251A-08-03	Clamping Bracket		1
20	GB37-88	Bolt	M20 × 110	1

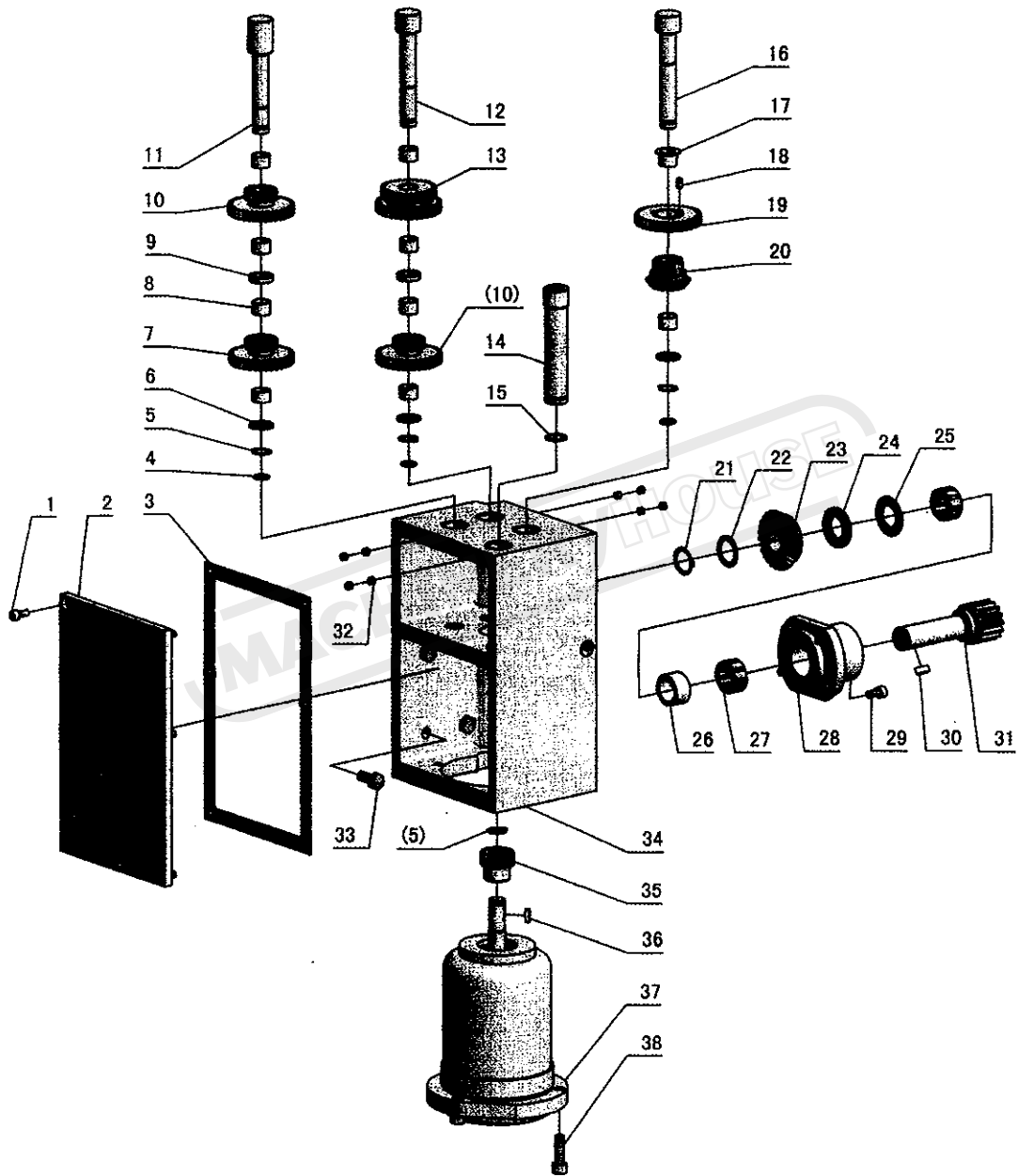
### Follow Rest



No.	Part No.	Name	Specification	Qty.
1	RUN6246-110019	Rotate Handle		2
2	GB78-85	Screw		2
3	C6251A-10-11	Follow Rest		1
3	C6256A-10-11	Follow Rest		1
4	RUN6246-110004	Bush		2
5	RUN6246-110016	Sleeve		2
6	RUN6246-110024	Bracket		2
7	RUN6141-110005	Follow Rest ( C6241 )		1
7	RUN6246H-110005	Follow Rest ( C6246h )		1
8	GB879-86	Spring Pin	5 × 26	2
9	RUN6246-110018	Limited Screw		2
10	GB5782-86	Bolt	M10 × 40	2
11	GB97.1-85	Washer		2

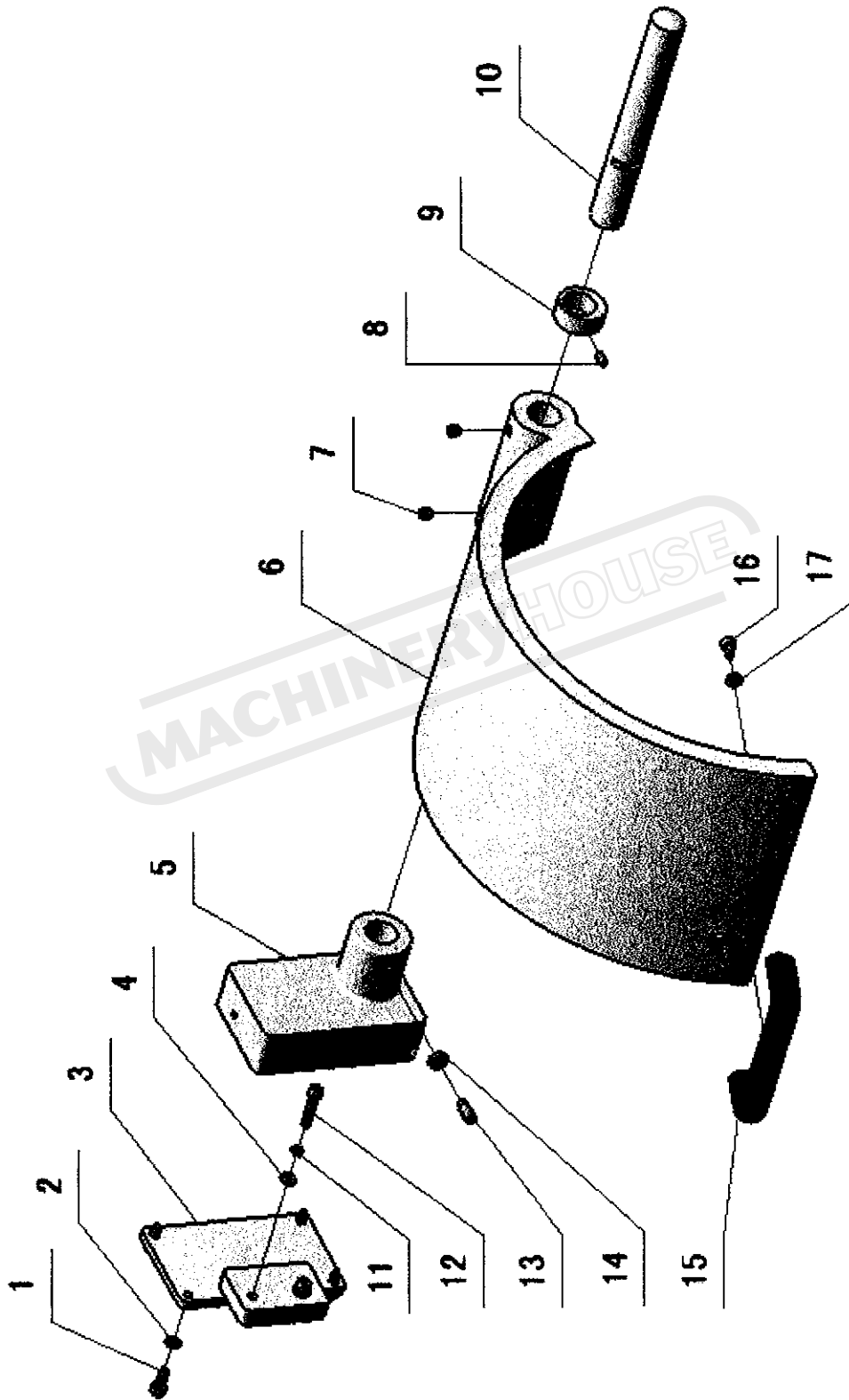
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### Speed-move Device



No.	Part No.	Name	Specifications	Qty.
1	GB70-85	Socket Head Cap Screw	M5×12	8
2	C6251A-19-08-04	Cover		1
3	C6251A-19-08-12	Cover Seal		1
4	GB/T3452.1-1992	O-Ring	Φ10.6×1.8	3
5	GB894.1-86	Snap Ring	14	4
6	C6251A-19-08-11	Spacer		3
7	C6251A-19-08-05	Gear I	Z36 × 1.5/Z17 ×	1
8	SF-1(DU)	Bearing	C/SF-1410	9
9	C6251A-19-08-10	Spacer		2
10	C6251A-19-08-06	Gear II	Z37 × 1.5/Z17 ×	2
11	C6251A-19-08-07	Shaft I		1
12	C6251A-19-08-08	Shaft II		1
13	C6251A-19-08-09	Gear III	Z37 × 1.5/Z31 ×	1
14	C6251A-19-08-24	Shaft		1
15	GB/T3452.1-1992	O-Ring	Φ16×1.8	1
16	C6251A-19-08-23	Shaft III		1
17	SF-1F	Bearing	C/SFF-14120	1
18	GB77-85	Screw	M5×8	3
19	C6251A-19-08-21	Gear	Z37×1.5	1
20	C6251A-19-08-22	Bevel Gear	Z21×1.75	1
21	GB894.1-86	Snap Ring	20	1
22	C6251A-19-08-20	Washer II		1
23	C6251A-19-08-15	Bevel Gear	Z29×1.75	1
24	GB/T4605-1984	Bearing	AXK 2035	1
25	C6251A-19-08-16	Washer I		1
26	C6251A-19-08-19	Spacer		1
27	GB/T5801-1994	Bearing	RNA 4902	2
28	C6251A-19-08-17	Bearing Cover		1
29	GB70-85	Socket Head Cap Screw	M6×12	4
30	GB1096-79	Key	5×14	1
31	C6251A-19-08-18	Pinion		1
32	GB80-85	Screw	M6×6	8
33	GB5783-86	Bolt	M8×20	4
34	C6251A-19-08-14	Box		1
35	C6251A-19-08-02	Gear	Z18×1.5	1
36	GB1096-79	Key	4×12	1
37	YS	Motor	YSS2-5634	1
38	GB70-85	Socket Head Cap Screw	M8×25	3

### Chuck Guard Cover





NO	Part No.	Name	Specification	Qty.
1	GB70-85	Screw	M6×16	4
2	GB93-87	Washer	6	4
3	RUN6246-F101002F	Support Bracket		1
4	GB97.1-85	Washer	6	2
5	RUN6246-101101	Bracket		1
6	C6241-16-01	Cover		1
7	GB80-85	Screw	M8×8	2
8	GB78-85	Screw	M6×10	1
9	CM6233-F1005	Cam		1
10	C6241-16-02	Shaft		1
11	GB93-87	Washer	6	2
12	GB70-85	Screw	M6×30	2
13	GB79-85	Screw	M8×20	1
14	GB6172-86	Nut	M8	1
15	HY8315.4	handle	A=114	1
16	GB70-85	Screw	M6×10	2
17	GB97.1-85	Washer	6	2

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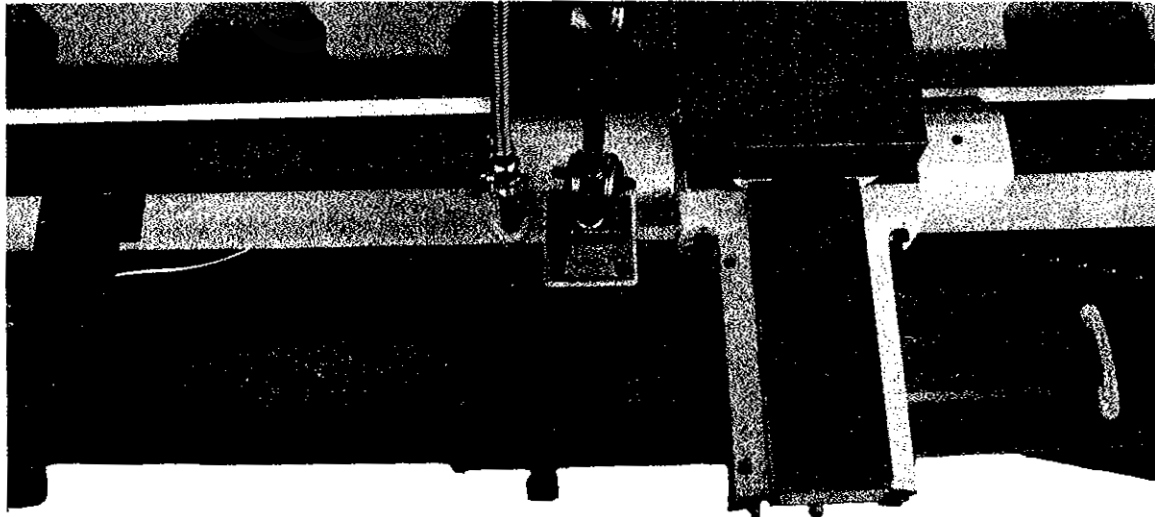
# Operation Manual for

## Copying Device of Horizontal Lathe\*

“\*” IS FOR USERS' SPECIAL ORDER

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**Figure 1**

**(1) Main Data**

Stroke	455 mm
Angle	$\pm 8^\circ$
Packing Sizes (mm)	740 × 350 × 270
Net Weight (kg)	43 kg
Gross Weight (kg)	52 kg

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(2) List of Parts

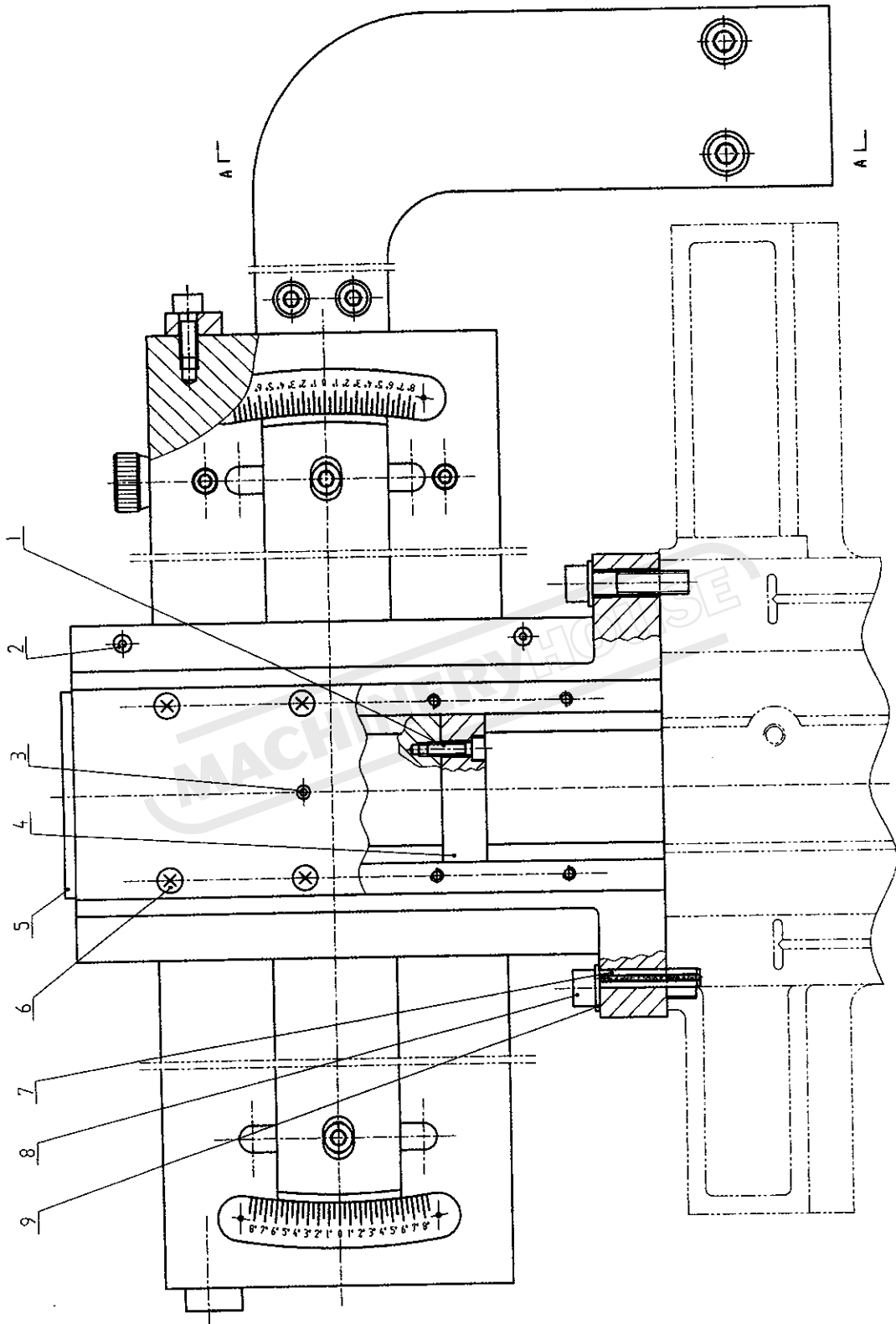


Figure 2

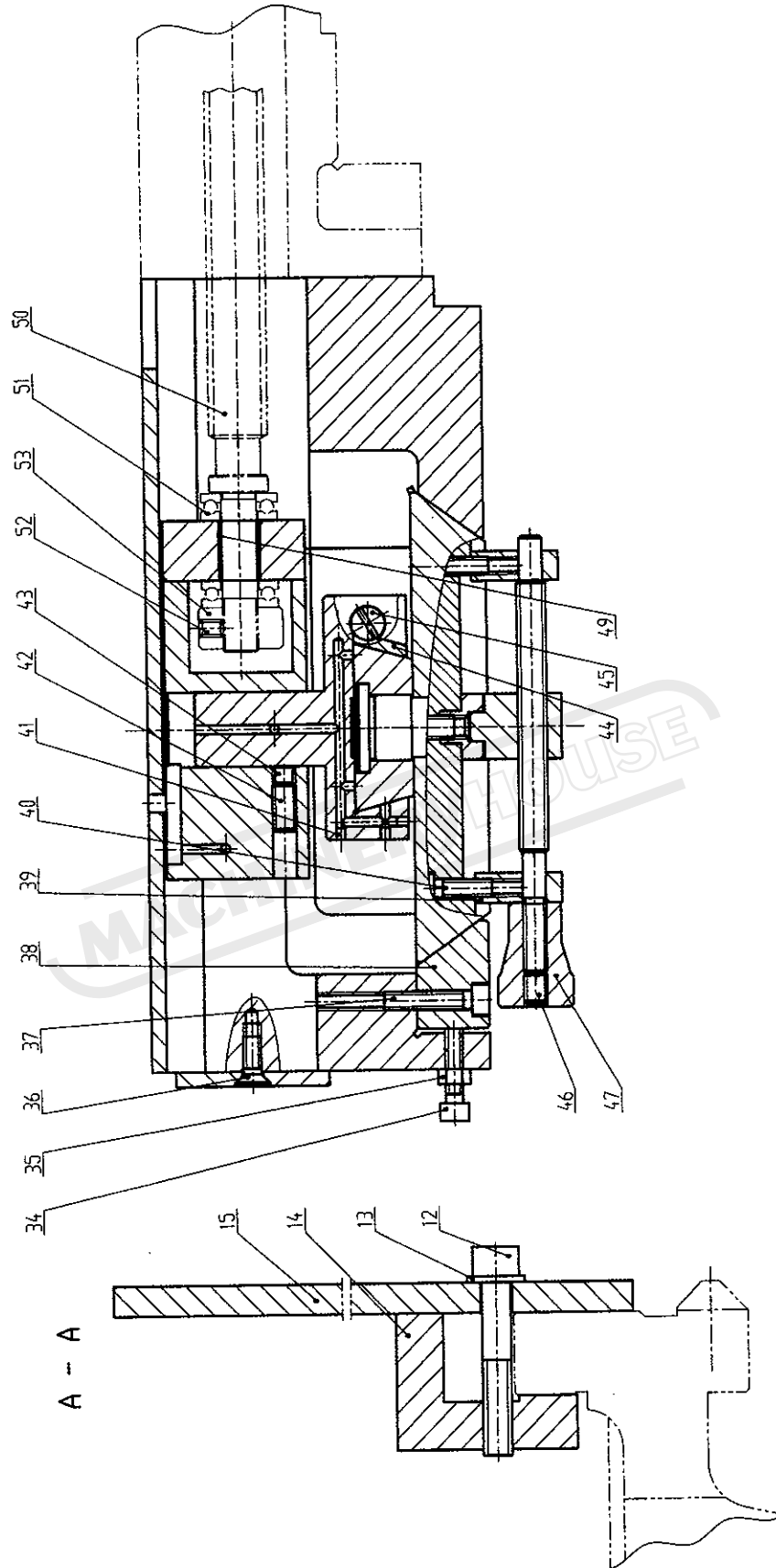


Figure 3

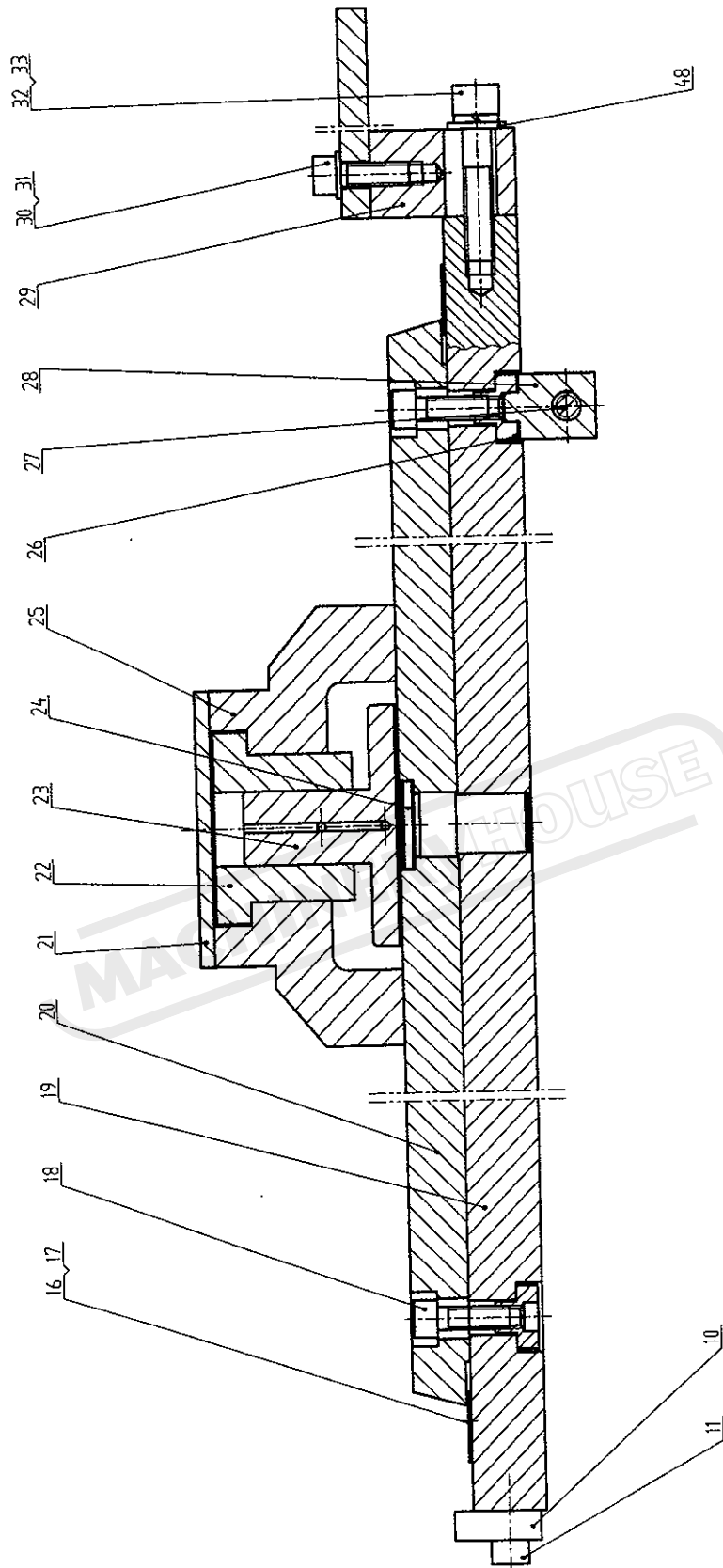


Figure 4

S/N	Code of Part	Name	Size	Quantity
1	GB70-85	Socket Cap Screw	M6×20	2
2	GB1155-89	Press-Fit Oil Cup	D=8	2
3	GB1155-89	Press-Fit Oil Cup	D=6	1
4	C6241-115001	End Block (for C6241, C6246H, C6251A,		1
4	C6266A-17-01	End Block (for C6266A)		1
5	C6241-115002	Stopper		1
6	GB819-85	Cross Recess Sunk Screw	M6×16	8
7	GB879-86	Spring Cylindrical Pin	8×45	2
8	GB70-85	Socket Cap Screw	M10×45	4
9	GB97.1-85	Flat Washer	d1=10	4
10	C6241-115003	Stopper		2
11	GB70-85	Socket Cap Screw	M8×20	2
12	GB70-85	Socket Cap Screw	M10×60	2
13	GB97.1-85	Flat Washer	d1=10	2
14	C6241-115033	Pressed Block (for C6241, C6246H,		1
14	C6251A-17-01	Pressed Block (for C6251A, C6256A)		1
15	C6241-115032	Pull Rod		1
16	GB827-86	Nails for Sign Board	2×6	4
17	C6241-115009	Sign Board		2
18	GB70-85	Socket Cap Screw	M8×25	2
19	C6241-115034	Profiling Seat		1
20	C6241-115012	Profiling Plate		1
21	C6241-115013	Press Plate Cover		1
22	C6241-115014	Slide Block		1
23	C6241-115015	Pivot		1
24	C6241-115016	Position Axle		1
25	C6241-115017	Main Support		1
26	C6241-115018	Mobile Block		2
27	C6241-115019	Adjustment Screw		1
28	C6241-115020	Adjustment Nut		1

S/N	Code of Part	Name	Size	Quantity
29	C6241-115031	Connection Block (for C6241, C6246H, C6251A, C6256A)		1
29	C6266A-17-02	Connection Block (for		1
30	GB70-85	Socket Cap Screw	M8×25	2
31	GB97.1-85	Flat Washer	d1=8	2
32	GB70-85	Socket Cap Screw	M10×50	2
33	GB93-86	Spring Washer	10	2
34	GB70-85	Socket Cap Screw	M6×25	3
35	GB6170-86	Model 1 Hexagon Nut –	M6 zinc	3
36	GB819-85	Cross Recess Sunk Screw	M6×16	2
37	GB70-85	Socket Cap Screw	M6×30	3
38	C6241-115024	Wedge		1
39	C6241-115025	Adjustment Supporter		2
40	GB70-85	Socket Cap Screw	M6×20	2
41	C6241-115026	Block Pin		3
42	GB77-85	Socket Flat Set Screw	M8×16	1
43	C6241-115027	Copper Washer		1
44	C6241-115028	Inlaid Strip		1
45	C6241-115029	Press Screw		2
46	GB77-85	Socket Flat Set Screw	M8×10	1
47	C6241-115030	Handle		1
48	GB97.1-85	Flat Washer	d1=10 zinc	2
49	SF-1	Oil-Free Lubrication	1218	1
50	RUN6141-103021	Guide Screw		1
51	GB/T 301-1995	Thrust Ball Bearing	51101	2
52	GB80-85	Socket Recess Set Screw	M6×8	1
53	RUN6246-103007-1	Nut		1



### (3) Installation Method

- 3.1 Remove the back plate of the lather for easy installation of the copying device.
- 3.2 Loosen the socket recess set screw 54 in Figure 5, remove the nut 55; draw up the position pin 60 in A-Direction View in Figure 5, remove the socket cap screw 59 and remove the rear supporter 57 and the thrust ball bearing 56 in Figure 5 at last.

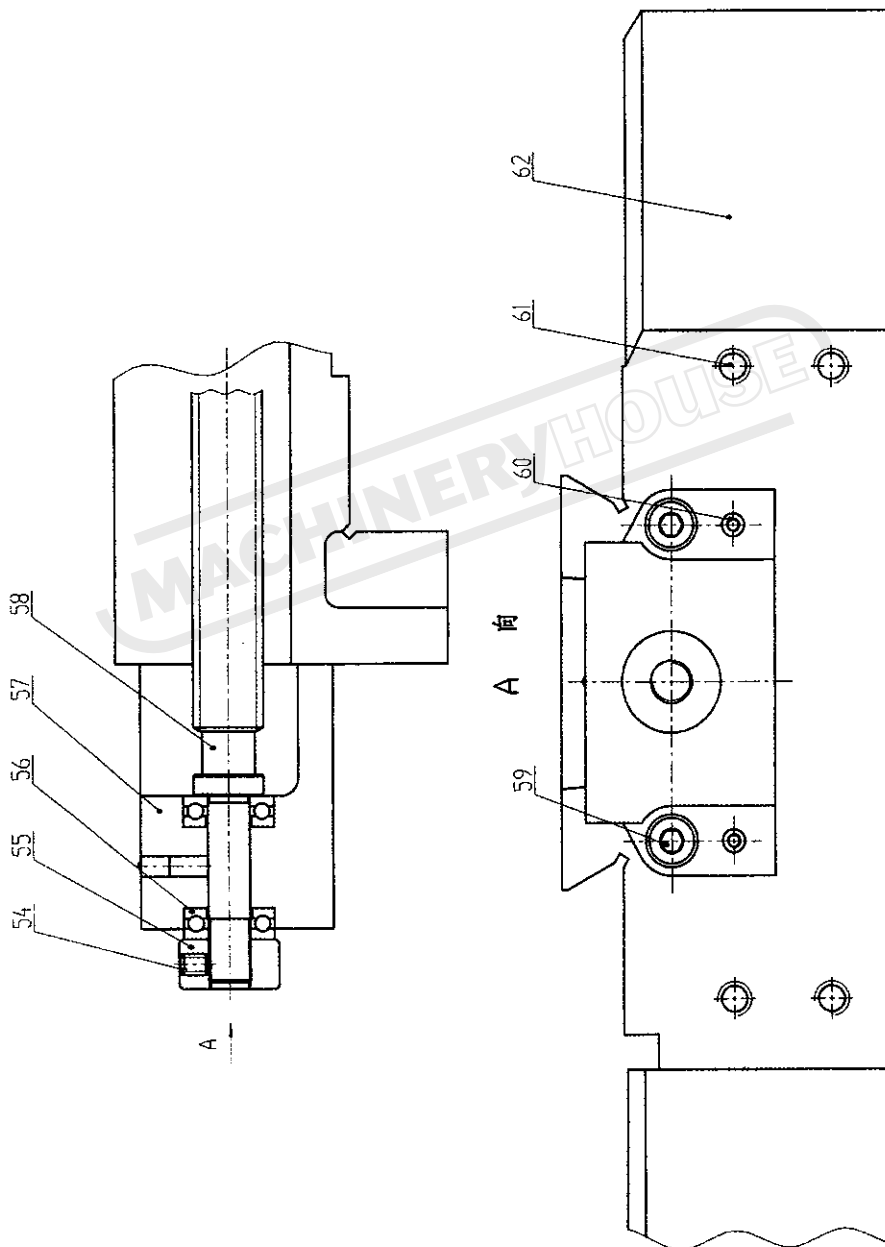


Figure 5

- 3.3 Remove the cross recess sunk screw 6 in Figure 2 and the press plate cover 21 in figure 4; loosen the socket flat set screw 42 in Figure 3, remove the slide block 22 in Figure 4, the end block 4 in Figure 2 and the socket cap screw 1 .
- 3.4 According to Figure 3, fix the guide screw 50, the thrust ball bearing 51 and the nut 53 on the end block 4 in Figure 2, adjust the axial playing of the guide screw 50 in Figure 3, fix the nut 53 by means of the socket recess set screw 52, mount the end block 4 in Figure 2 into the slide block 22 in Figure 4 by means of the socket cap screw 1.
- 3.5 Mount the remaining part of the copying device into the screw hole 61 on the bed saddle 62 in Figure 5 by means of the socket cap screw 8 and the flat washer 9 in Figure 2. Take care to insert the cylindrical part of the pivot 23 in Figure 4 into the hole of the slide block 22.
- 3.6 Mount the one end of the pull rod 15 on the connection block 29 by means of the socket cap screw 30 and the flat washer 31 in Figure 4, and fix the other end and press block 14 in Figure 3 on the plane guide rail of the bed by means of the socket cap screw 12 and the flat washer 13, tighten the socket cap screw 12 to fix relatively the pull rod 15 with the bed.
- 3.7 Fix the indicator according to the way in Figure 6. Move the carriage leftward or rightward and calibrate the upper face of the profiling seat 19 to be  $\leq 0.05$  mm in Figure 4, drill the position pinhole  $\phi 8$  on the bed saddle 62 in A-Direction View in Figure 5 by the electric hand drill and mount the spring cylindrical pin 7 in Figure 2.

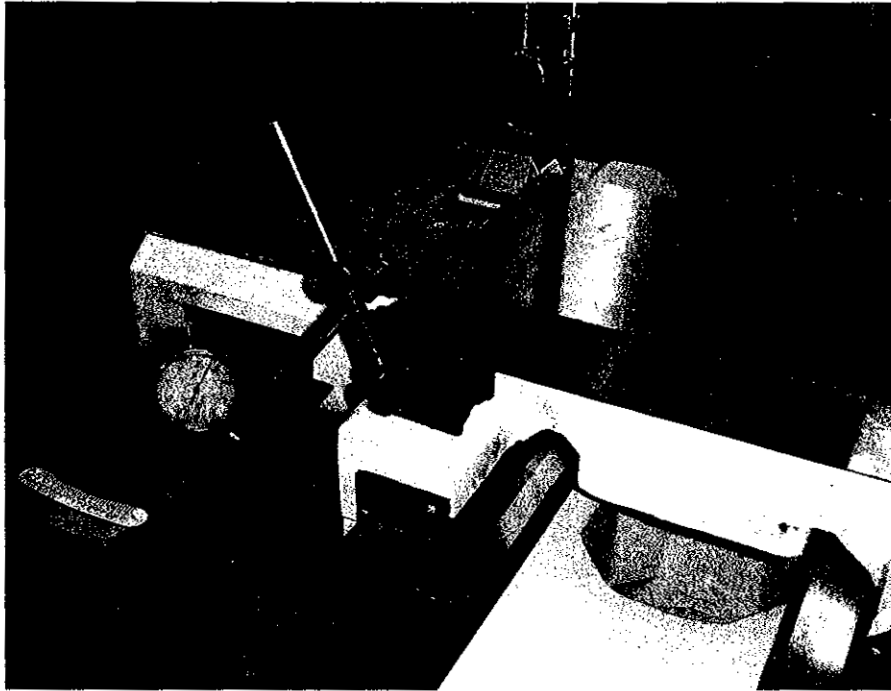


Figure 6

- 3.8 Turn the guide screw 50 in Figure 3 to make it move axially and knock the upper face of the slide block 22 in Figure 3 by wooden hammer at the same time. In case when the guide screw turning is free, fix the slide block 22 and the pivot 23 in Figure 4 by means of the socket cap set screw 42 in Figure 3 (take care the socket flat set screw 42 cannot press the pivot 23 too tight).
- 3.9 According to Figure 2 mount the press plate cover 21 in Figure 4 by means of the cross recess sunk screw 6 and loosen the socket caps crew 12 in Figure 3.
- 3.10 Mount the back plate on the position as the original status to complete the whole installation course.

#### (4) Operation Method

- 4.1 Before operation, move the carriage in front of the taper face to be turned, tighten the socket cap screw 12 in Figure 3 to lock the pull rod 15 in Figure 3 tightly on the bed.
- 4.2 Loosen the socket cap screws 18 in Figure 4 (one each at the both ends), turn the handle 47 in Figure 3 to adjust the required taper, then lock the socket cap

screws 18 in Figure 4 (one each at the both ends).

- 4.3 When running the tool on the carriage longitudinally, the guide screw 50 and the lateral slide plate are driven by the pivot 23 and the slide block 22 in Figure 4 to finish the function to turn the taper.
- 4.4 When it is not in use, loosen the socket cap screws 18 in Figure 4 (one each at the both ends), turn the handle 47 in Figure 3 to adjust the profiling plate 20 to “zero” position, then lock the socket cap screws 18 in Figure 4 (one each at the both ends), loosen the socket cap screw 12 in Figure 3 to make all other normal turning.

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