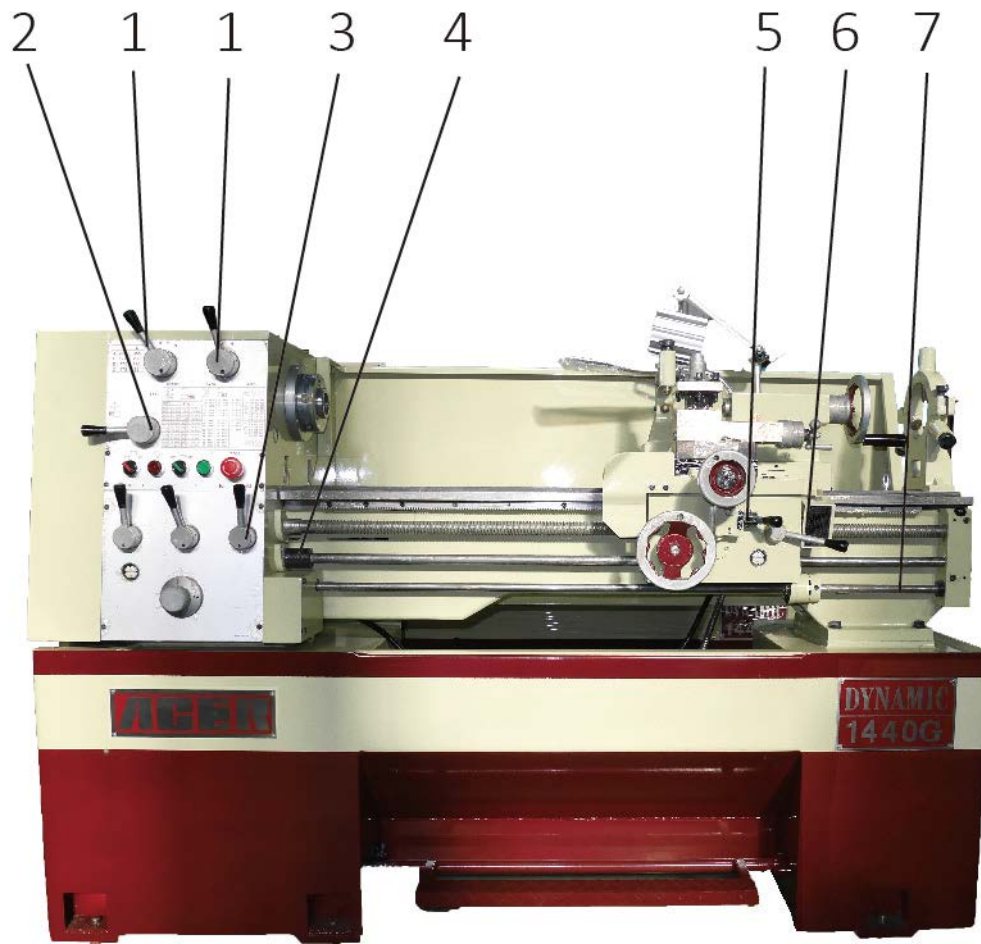
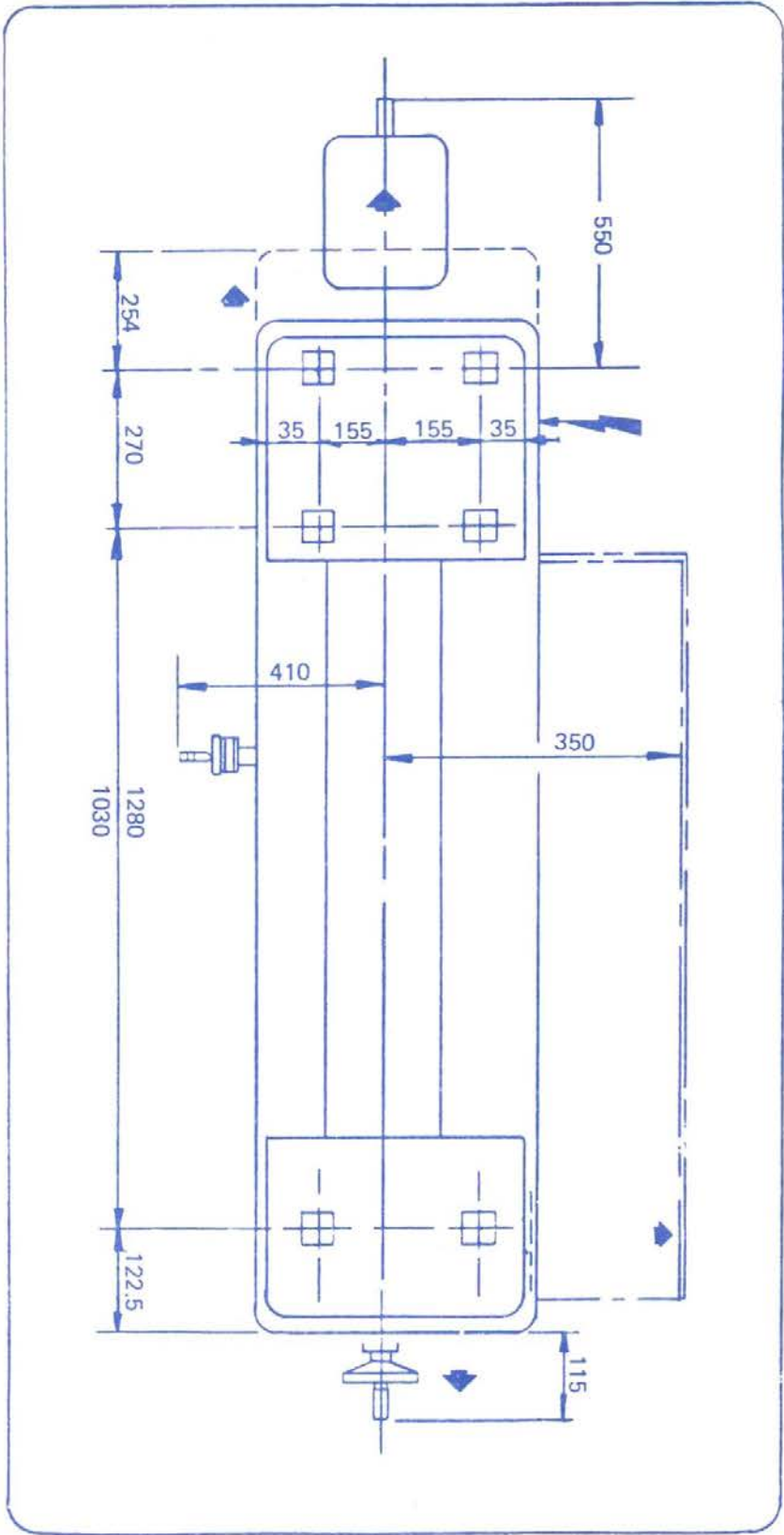


**1440G**  
**INSTRUCTION MANUAL**  
**AND**  
**PARTS LISTS**

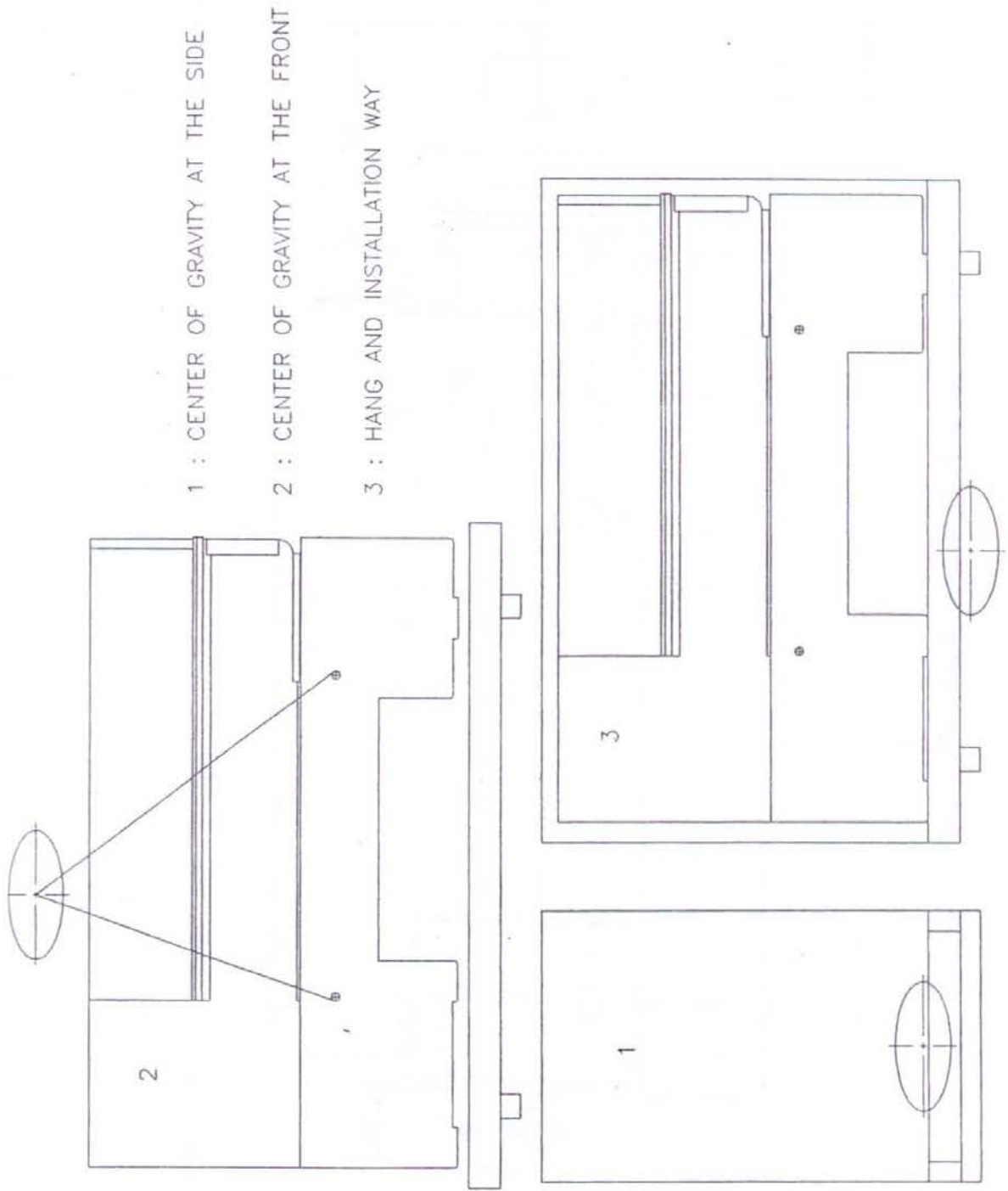


## OPERATION:

1. Spindle speed selector.
2. Forward and reverse selector.
3. Threads and feed selector.
4. Safety equipment.
5. Cross or longitudinal feed selector.
6. Threading clutch lever.
7. Starting lever.



**FOUNDATION PLANIN**



## OPERATION

### CHUCK AND CHUCK MOUNTING

When fitting chucks or faceplates first ensure the spindle and chuck tapers are scrupulously clean that all comes lock in the correct position

see fig 9 It may be necessary to re-set the camlock studs (A) when mounting a new chuck

To do this remove the cap-head locking screws(B) and set each stud so that the scribed ring

(C) is flush with the rear face of the chuck with the slot lining up with the locking screw hole see fig 8

Now mount the chuck or faceplate on the spindle nose and tighten the six cams in turn

When fully tightened the cam lock line on each cam should be between the

V marks on the spindle nose

If any of the cams do not tighten fully within these limit marks remove the chuck or faceplate and re adjust the stud as indicated in the illustration

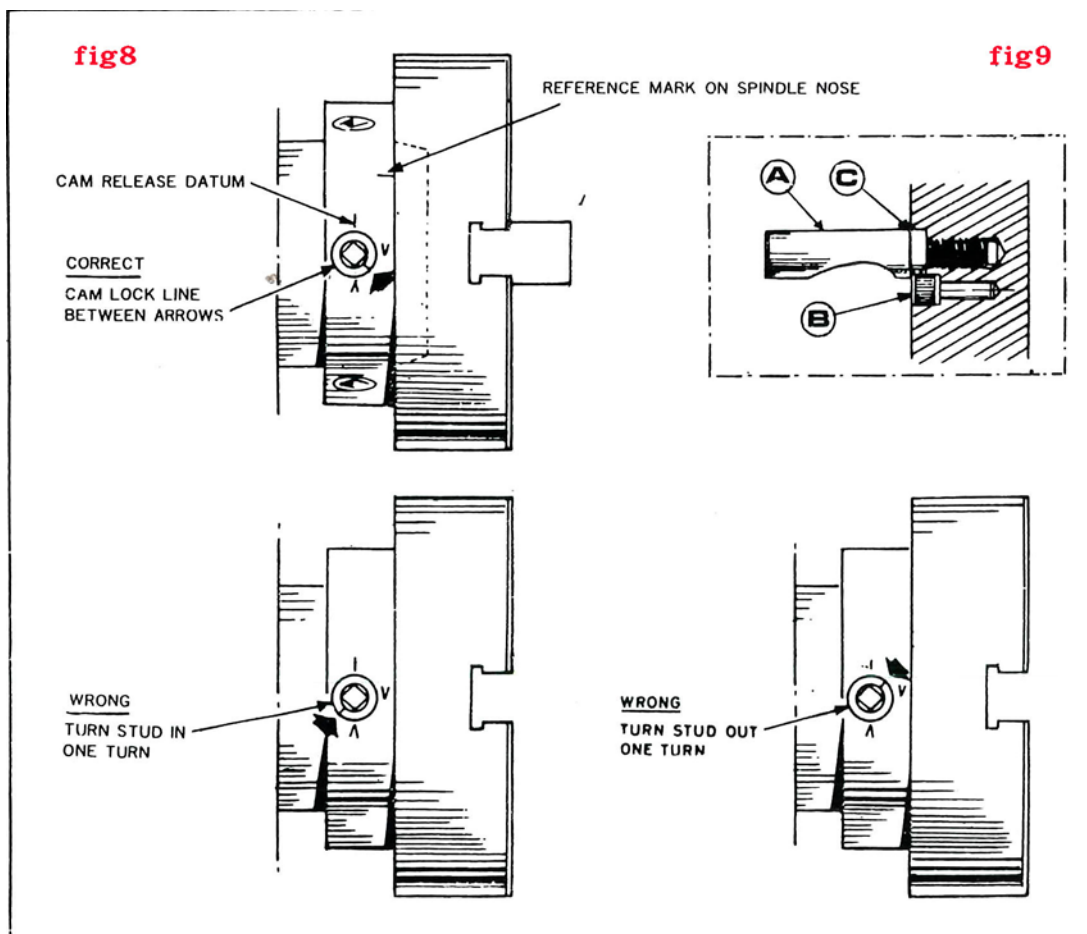
Fit and tighten the locking screw (B) at each stud before remounting the chuck for work

A reference mark should be made on each correctly fitted chuck or faceplate to coincide with the reference mark scribed on the spindle nose

This will assist subsequent re-mounting

**DO NOT INTERCHANGE CHUCKS OR FACE PLATES BETWEEN LATHES WITHOUT CHECKING FOR CORRECT CAM LOCKING**

**IMPORTANT:**Take careful note of speed limitations when using faceplate 12 in or 10 in faceplates should not be run at speeds higher than 680 rev/min



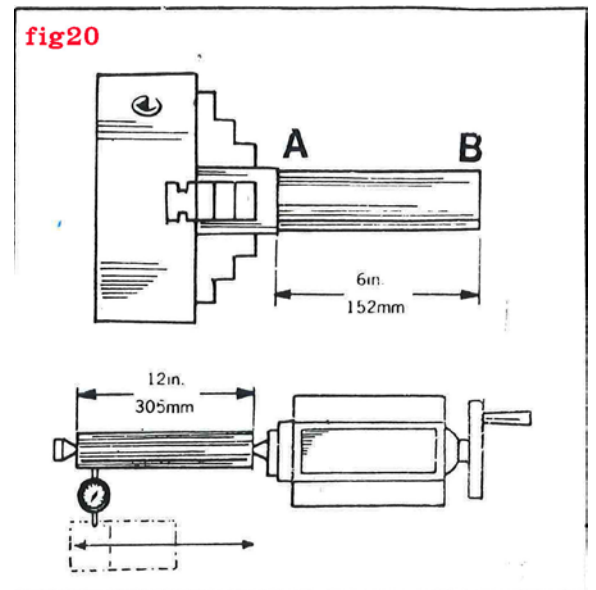
## SERVICE AND MAINTENANCE

### LATHE ALIGNMENT

with the lathe installed running we recommend a chuck on machine alignment before commencing work Check leveling machine alignment at regular periods to ensure continued lathe accuracy

### HEADSTOCK CHECK

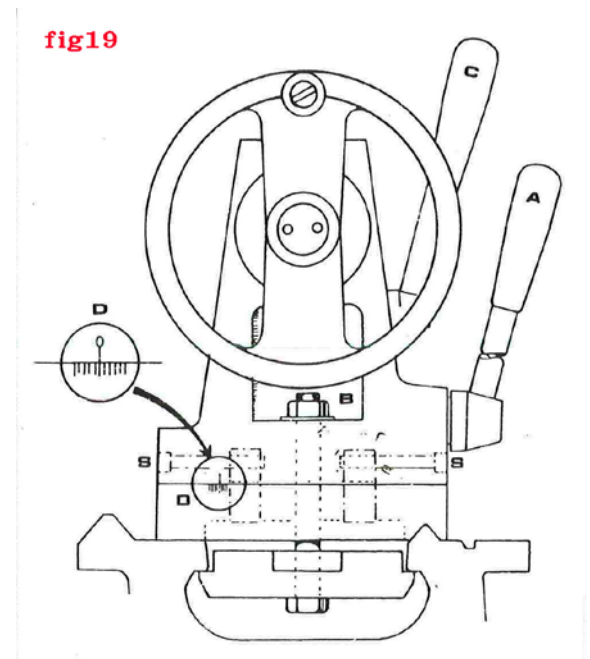
Take a right cut with a keen tool over a 6" (150mm) long and 2" dia(50mm) steel bar gripped in the chuck but not supported at the free end micrometer readings at each end of the turned length (at A AND B fig20) should be the same



Tailstock chuck using a 12"(305mm) ground steel bar fitted between headstock and tailstock centers check the alignment by fitting a dial-twst indicator to the topslide and traversing thw center line of the bar (lower sletch Fig 20) To correct error relase the ttailstock clamp lever and adjust the set over screws provided Continue with checking and correction until the alignment is perfect

### TAILSTOCK

Can be freed for movement along the bed by unlocking the clamp lever (A) Additional clamping may be obtained by tightening the large nut (B) located in a recess below the handwheel Reease this clamping nut before attempting to move the tailstock and when in the need for extra clapming The tailstock barrel is locked by lever (C) see Fig 19 The tailstock can be set-over for production of shallow apers pr for re-alignment Release the clamping lever and sdjust screw (S) at each slide of the base (Fig19) to move tailstock laterally across the base An indication of the set over is given by the datim mark (D) at the tailstock end face as shown in FIG 19 Apply clamp lever after adjustment of set-over



## STARTING AND STOPPING

Before starting up machine make sure if the proper lubrication to all running parts has been Done as per lubrication chart

And switch on after ensuring the starting lever at apron which should be placed in the neutral position

During switching on the pilot lamp will be on

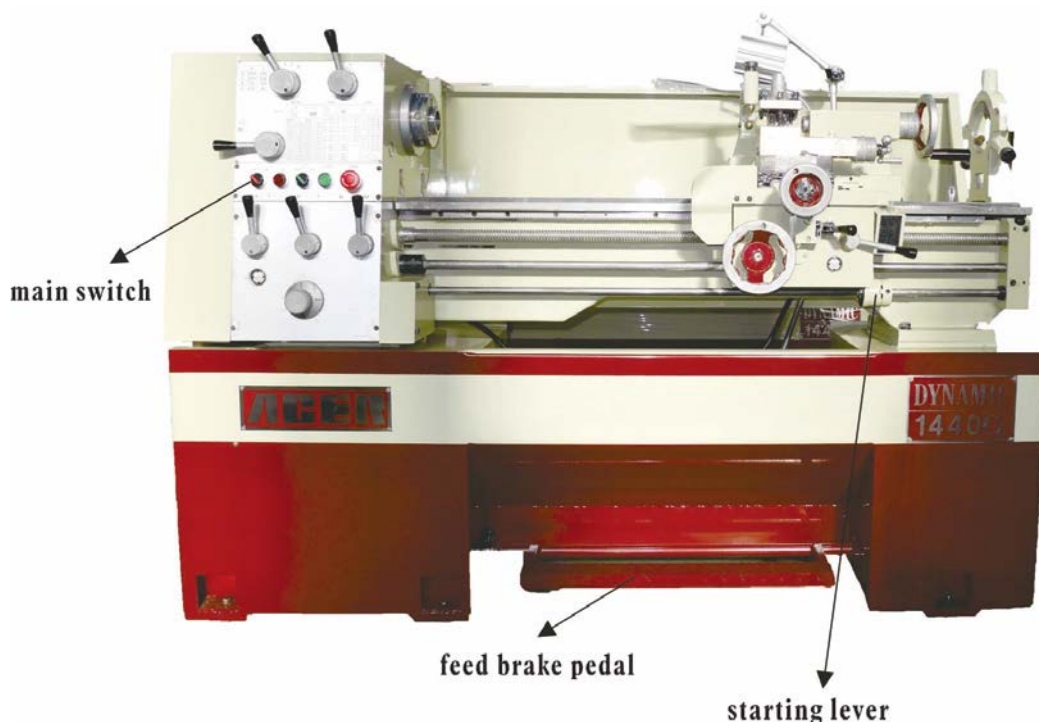
The starting up of main spindle is accomplished by the starting level at the right of apron the starting level has a safety locking device which prevents any abrupt accident from operator.

Move this starting level horizontally to disengage a safety pin

When this lever is moved down the main spindle stops revolving

During the main spindle is revolving if the foot brake pedal is pressed down the main spindle will be stopped at once

If you want to start the machine again switch the starting lever If the emergency stop button is pressed down to stop the machine firstly pull up the emergency stop button and then switch the starting lever to start the machine again





Select the appropriate spindle speed for working from cutting speed chart on the top of headstock there are 8 steps in the range of spindle speed (85-2000r.p.m)

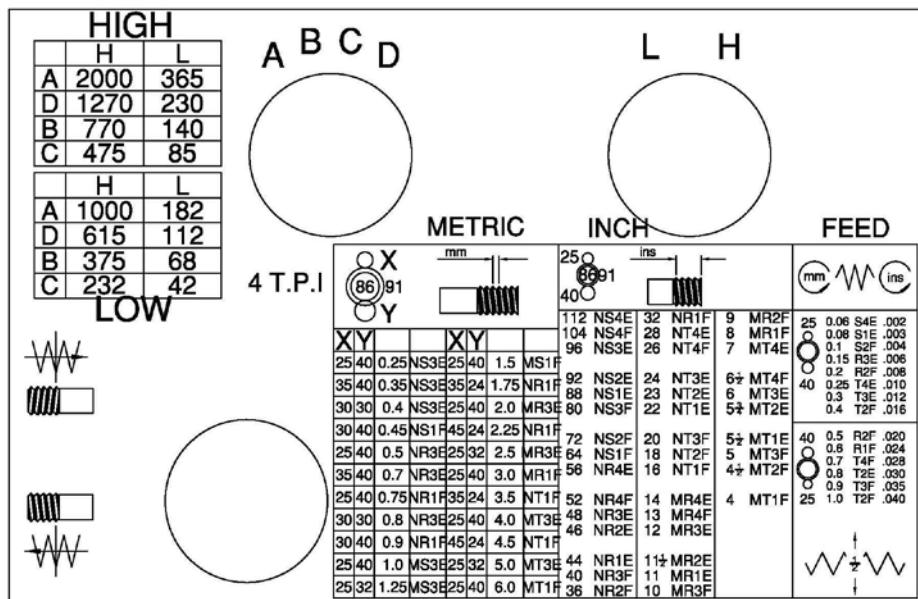
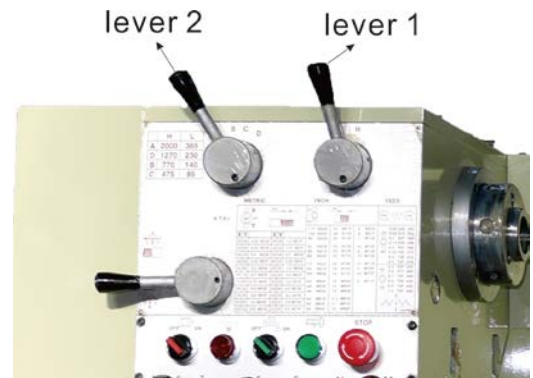
The change of main spindle speed are accomplished by the level 1 and the level 2

level 1 selects M、L position

level 2 select speeds of 8 grades corresponding with level 1

Please refer to figure below

spindle speed chart and feed chart



In order to obtain the desired spindle speeds place the level at the proper position

Be sure do not shift the level when the spindle is running

Warning : Should turn off the motor and let spindle stop before changing the position of levers



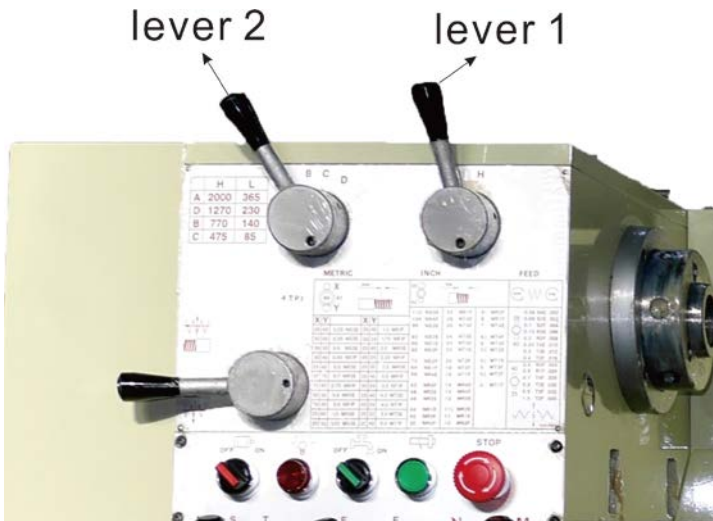
# Introduction

Spindle speed change levers

Select the A、B、C、D、H、L position to decide spindle speed

Spindle speed change level

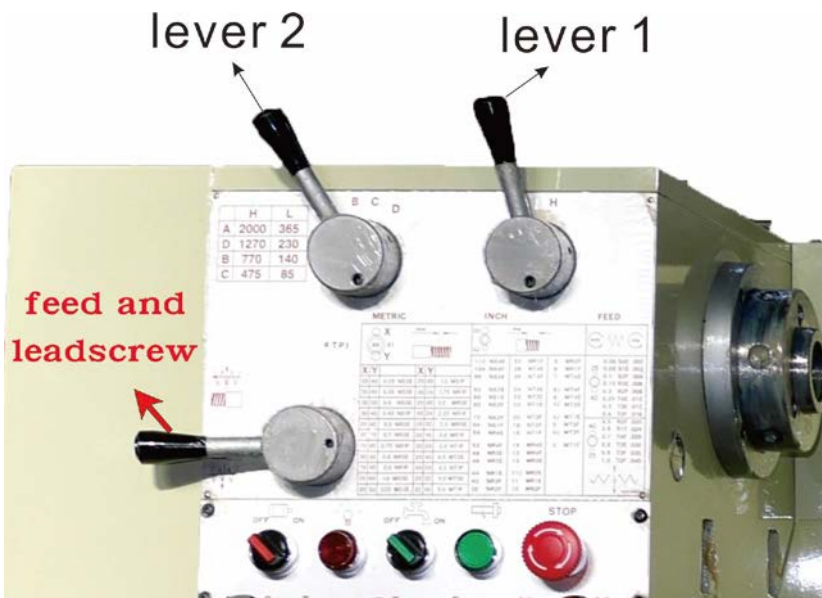
Select the 8 different spindle speeds with lever 1 and 2



feed and leadscrew selection lever

select the forward or backward rotation for the leadscrew

feeds and threads change lever

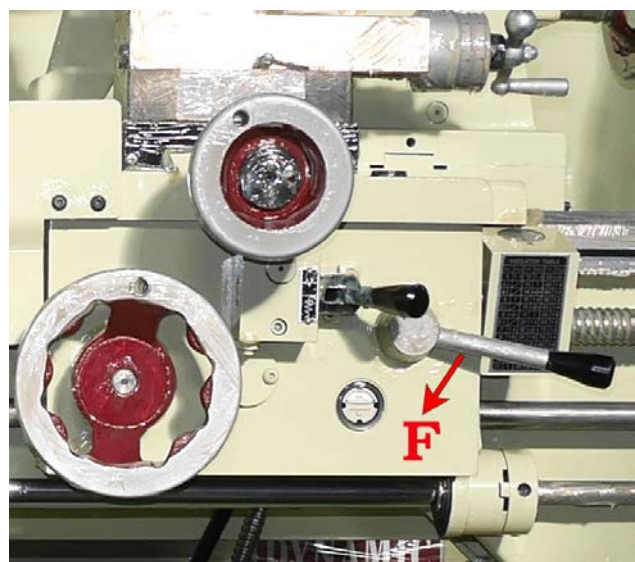
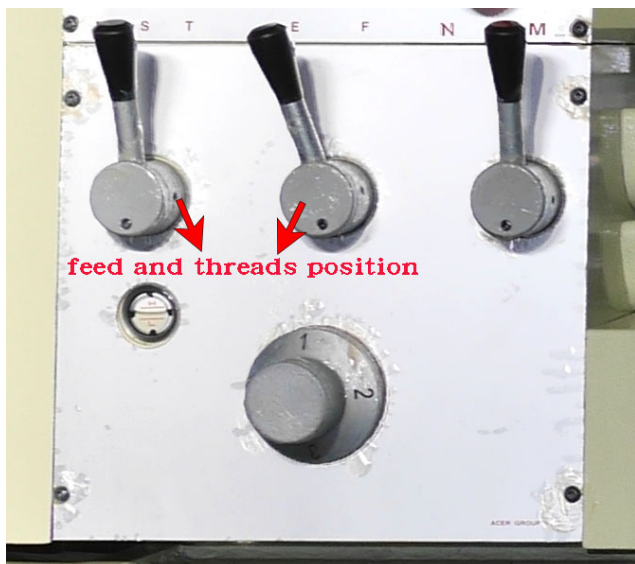
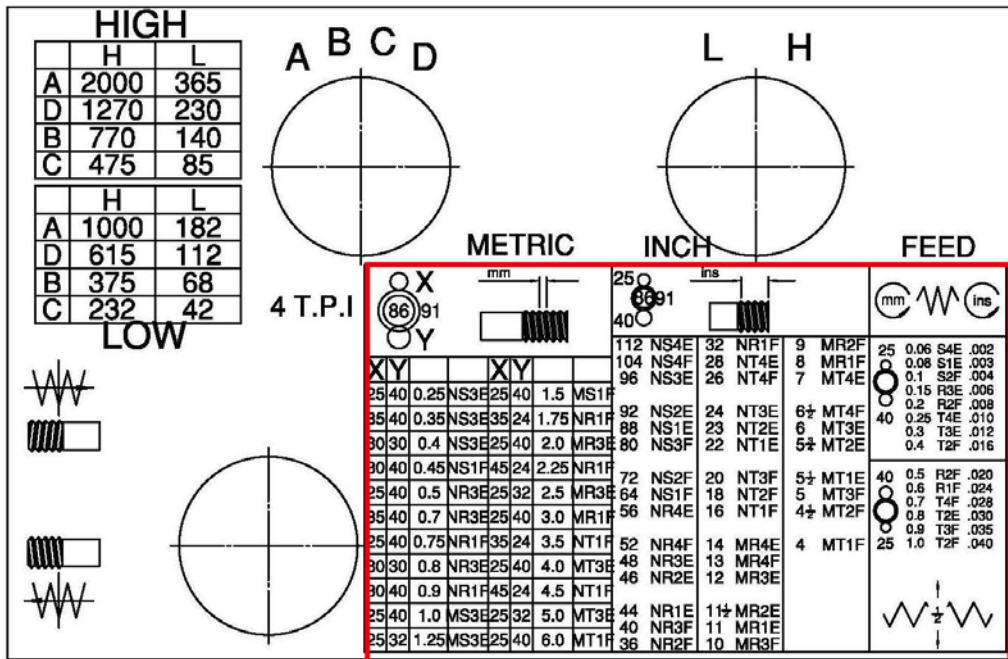


Select E、F、R、S、T、M、N position to decide the rate of feeds or threads accompanied with lever F

Please refer to chapter of table

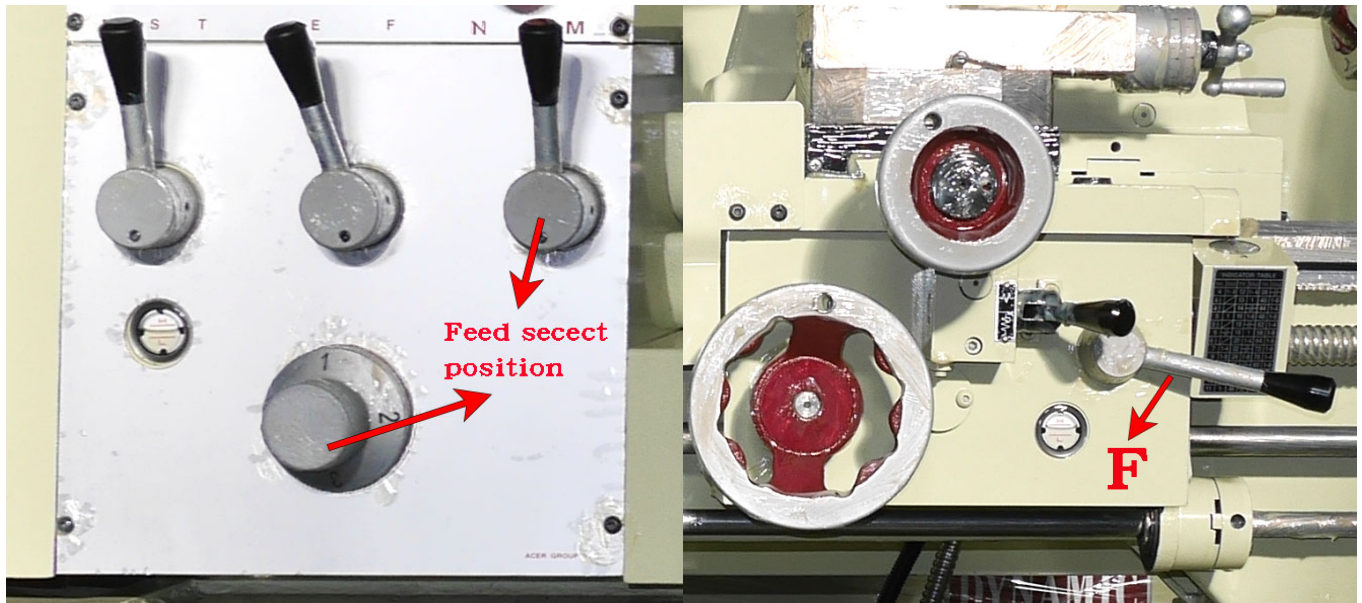
If you want to select the module threads (feeds) please change the gears shown in the table

## spindle speed chart and feed chart

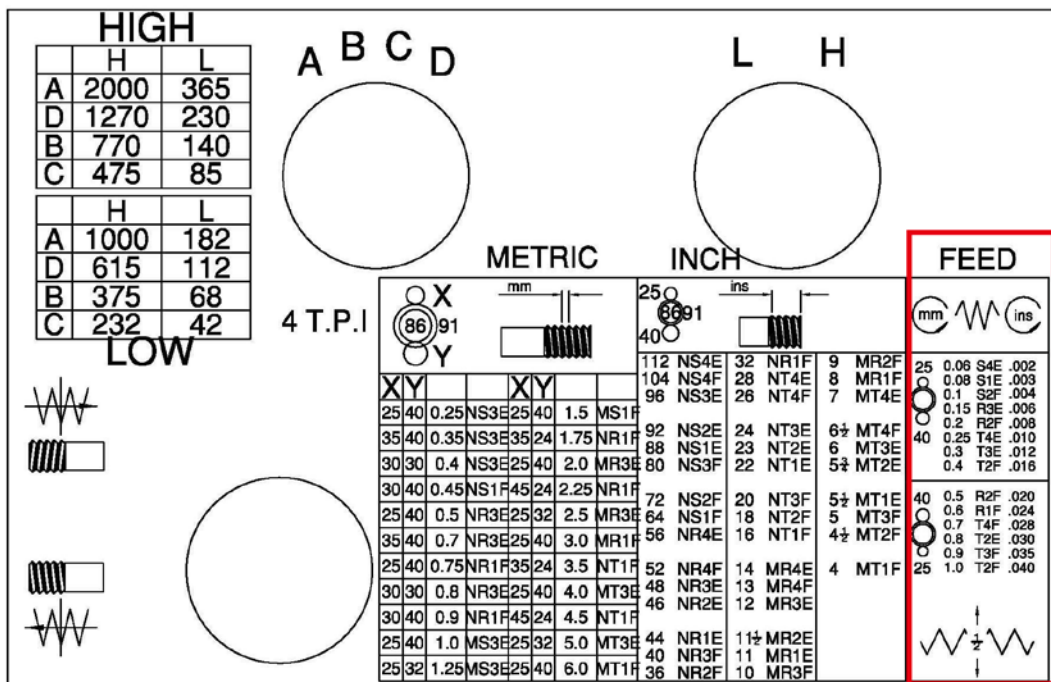


Select M、N 1、2、3、4 position to decide the rate of feeds or threads accompanied with lever F

Please refer to chapter of table



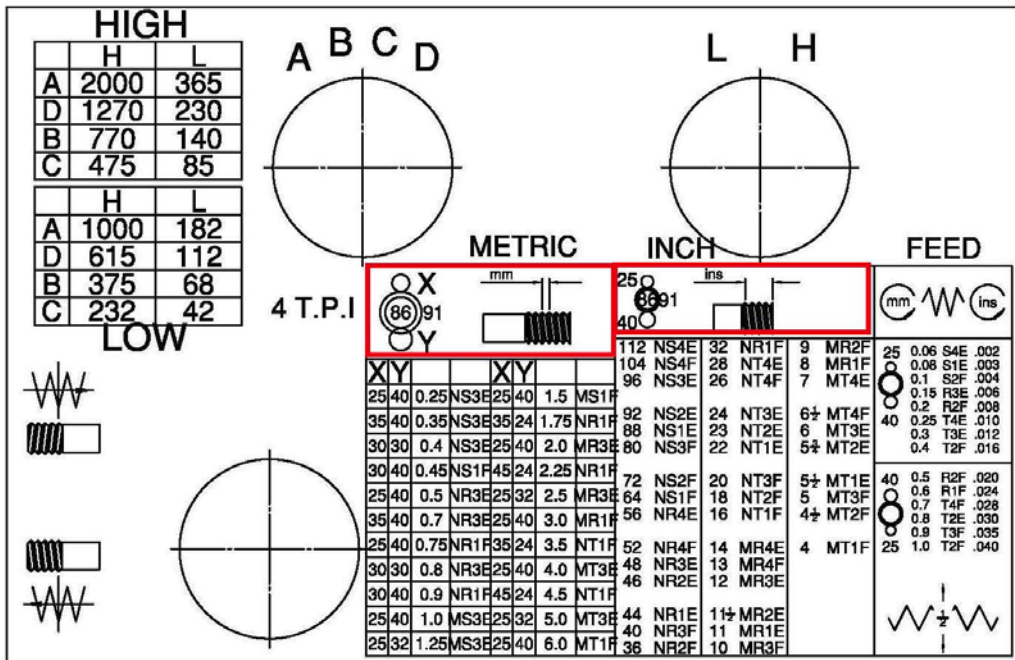
spindle speed chart and feed chart



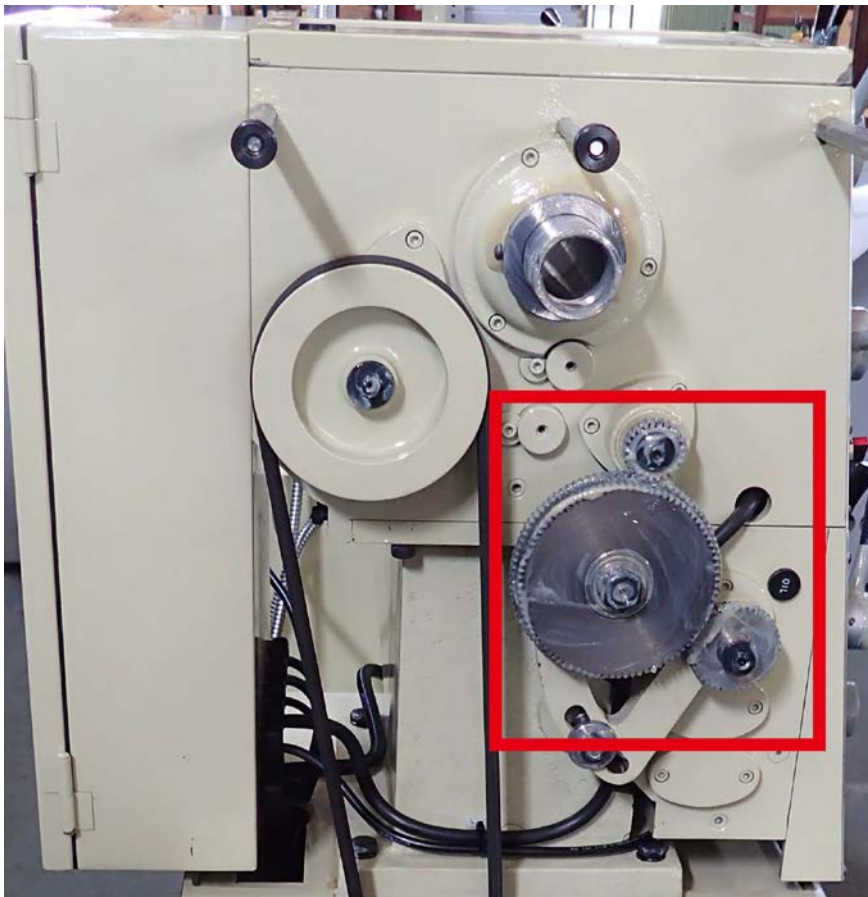


Inch and metric change  
 please change the gears shown in the table

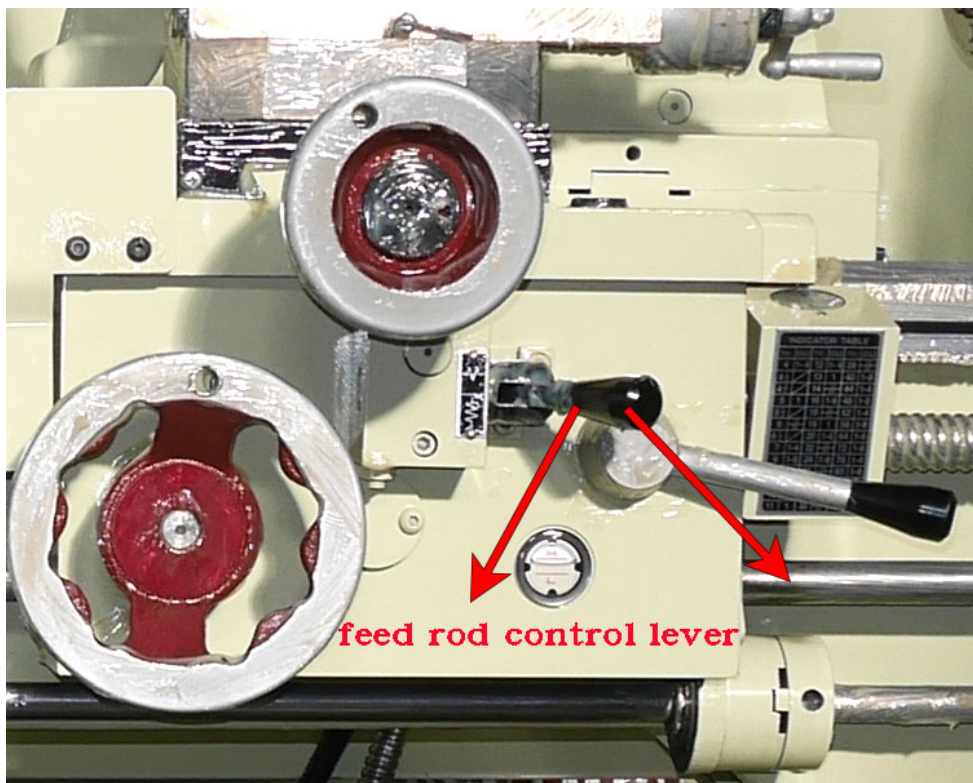
spindle speed chart and feed chart



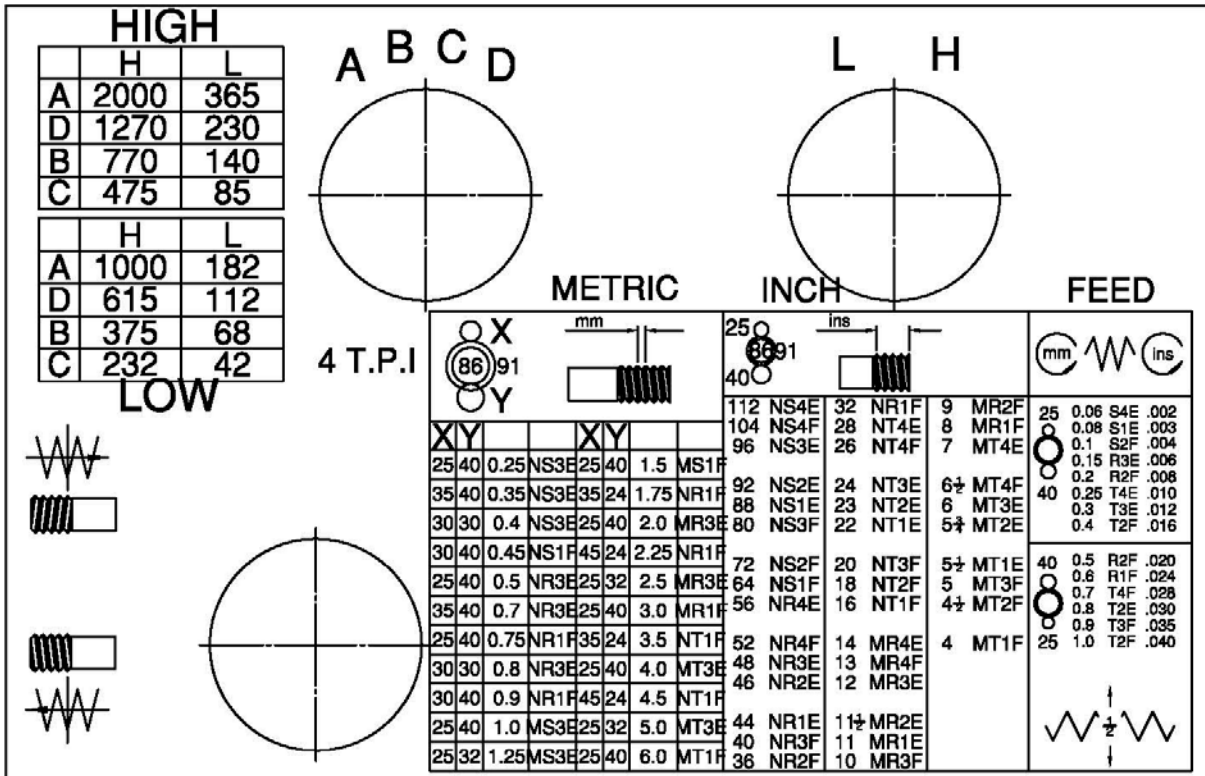
please change the gears



## Feed rod engage and disengage clamping lever



# spindle speed chart and feed chart






4 T.P.I

METRIC						INCH						FEED	
XY			XY			25	32	9	25	0.06	S4E .002		
25 40	0.25	NS3E	25 40	1.5	MS1F	112 NS4E	32 NR1F	9 MR2F	25	0.08	S1E .003		
35 40	0.35	NS3E	35 24	1.75	NR1F	104 NS4F	28 NT4E	8 MR1F	40	0.1	S2F .004		
30 30	0.4	NS3E	25 40	2.0	MR3E	96 NS3E	26 NT4F	7 MT4E	25	0.15	R3E .006		
30 40	0.45	NS1F	45 24	2.25	NR1F	92 NS2E	24 NT3E	6 1/2 MT4F	40	0.2	R2F .008		
25 40	0.5	NR3E	25 32	2.5	MR3E	88 NS1E	23 NT2E	6 MT3E	25	0.25	T4E .010		
35 40	0.7	NR3E	25 40	3.0	MR1F	80 NS3F	22 NT1E	5 3/4 MT2E	40	0.3	T3E .012		
25 40	0.75	NR1F	35 24	3.5	NT1F	72 NS2F	20 NT3F	5 1/2 MT1E	40	0.4	T2F .016		
30 30	0.8	NR3E	25 40	4.0	MT3E	64 NS1F	18 NT2F	5 MT3F	25	0.5	R2F .020		
30 40	0.9	NR1F	45 24	4.5	NT1F	56 NR4E	16 NT1F	4 1/2 MT2F	40	0.6	R1F .024		
25 40	1.0	MS3E	25 32	5.0	MT3E	52 NR4F	14 MR4E	4 MT1F	40	0.7	T4F .028		
25 32	1.25	MS3E	25 40	6.0	MT1F	48 NR3E	13 MR4F		25	0.8	T2E .030		
						46 NR2E	12 MR3E		40	0.9	T3F .035		
						44 NR1E	11 1/2 MR2E		25	1.0	T2F .040		
						40 NR3F	11 MR1E						
						36 NR2F	10 MR3F						

PICHTH  
6mm

METRIC						INCH						FEED	
XY			XY			25	32	9	25	0.06	S4E .002		
25 40	0.25	NS3E	25 40	1.5	MS1F	112 NS4E	32 NR1F	9 MR2F	25	0.08	S1E .003		
35 40	0.35	NS3E	35 24	1.75	NR1F	104 NS4F	28 NT4E	8 MR1F	40	0.1	S2F .004		
30 30	0.4	NS3E	25 40	2.0	MR3E	96 NS3E	26 NT4F	7 MT4E	25	0.15	R3E .006		
30 40	0.45	NS1F	45 24	2.25	NR1F	92 NS2E	24 NT3E	6 1/2 MT4F	40	0.2	R2F .008		
25 40	0.5	NR3E	25 32	2.5	MR3E	88 NS1E	23 NT2E	6 MT3E	25	0.25	T4E .010		
35 40	0.7	NR3E	25 40	3.0	MR1F	80 NS3F	22 NT1E	5 3/4 MT2E	40	0.3	T3E .012		
25 40	0.75	NR1F	35 24	3.5	NT1F	72 NS2F	20 NT3F	5 1/2 MT1E	40	0.4	T2F .016		
30 30	0.8	NR3E	25 40	4.0	MT3E	64 NS1F	18 NT2F	5 MT3F	25	0.5	R2F .020		
30 40	0.9	NR1F	45 24	4.5	NT1F	56 NR4E	16 NT1F	4 1/2 MT2F	40	0.6	R1F .024		
25 40	1.0	MS3E	25 32	5.0	MT3E	52 NR4F	14 MR4E	4 MT1F	40	0.7	T4F .028		
25 32	1.25	MS3E	25 40	6.0	MT1F	48 NR3E	13 MR4F		25	0.8	T2E .030		
						46 NR2E	12 MR3E		40	0.9	T3F .035		
						44 NR1E	11 1/2 MR2E		25	1.0	T2F .040		
						40 NR3F	11 MR1E						
						36 NR2F	10 MR3F						



<b>PITCH</b>	<b>WORM</b>	
0.5 1.25 2.5 4.0 5.0	20T	
0.75 1.0 1.5 1.75 2.0 3.0 3.5 6.0 7.0	21T	



### METRIC



Table 3

INDICATOR TABLE					
T. P. I.	SCALE	T. P. I.	SCALE	T. P. I.	SCALE
4	1-4	12	1-4	38	$\frac{13}{24}$
4 $\frac{1}{2}$	/	13	1	40	1-8
4 $\frac{3}{4}$	/	14	$\frac{13}{24}$	44	1-4
5	1	16	1-8	48	1-8
5 $\frac{1}{2}$	/	18	$\frac{13}{24}$	52	1-4
6	$\frac{13}{24}$	19	1	56	1-8
6 $\frac{1}{2}$	/	20	1-4	64	1-8
7	1-4	22	$\frac{13}{24}$	72	1-8
8	1-8	24	1-8	76	1-4
9	1	26	$\frac{13}{24}$	80	1-8
9 $\frac{1}{2}$	/	28	1-4	96	1-8
10	$\frac{13}{24}$	32	1-8	104	1-8
11	1	36	$\frac{13}{24}$	112	1-8

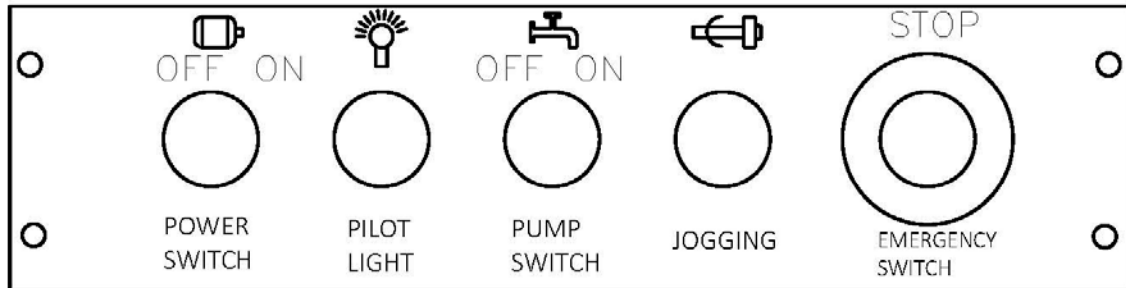
### INCH

## D. P. M. P. THREADS INDICATOR (OPTIONAL)

	28						
	54	55					
			28				
D.P.							
112	NS4E	46	NR2E	18	NT2F		
104	NS4F	44	NR1E	16	NT1F		
96	NS3E	40	NR2F	14	MT4E		
92	NS2E	36	NR2F	13	MT4F		
88	NS1E	32	NR1F	12	MT3E		
80	NS3F	28	NT4E	11 $\frac{1}{2}$	MT2E		
72	NS2F	26	NT4F	11	MT1E		
64	NS1F	24	NT3E	10	MT3F		
56	NR4E	23	NT2E	9	MT2F		
52	NR4F	22	NT1E	8	MT1F		
48	NR3E	20	NT3F				

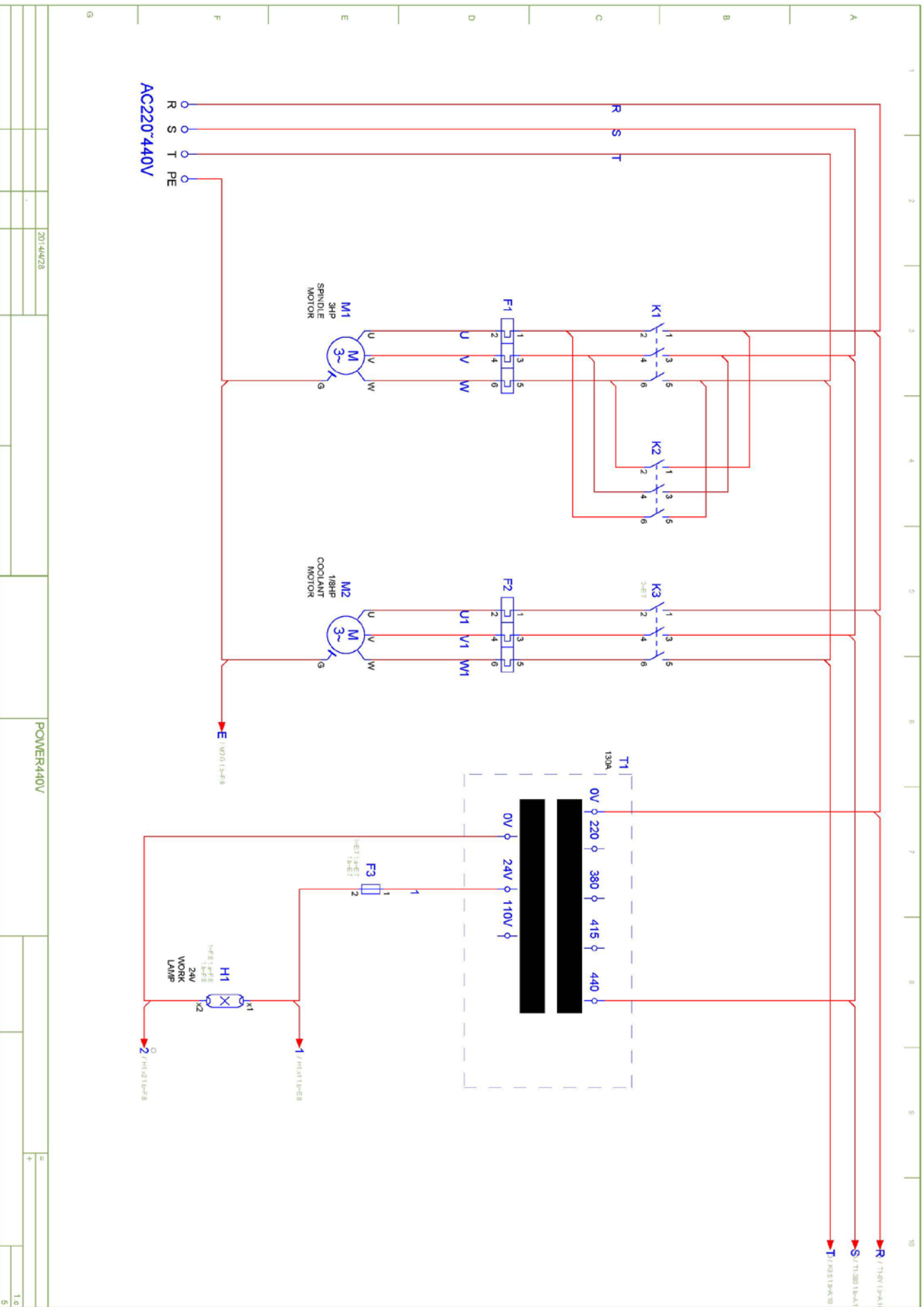
	X						
	60	89					
			Y				
M.P.							
X	Y	mod.		X	Y	mod.	
25	40	0.25	NR3E	25	40	1	MR3E
35	40	0.35	NR3E	25	32	1.25	MR3E
30	30	0.4	NR3E	25	40	1.5	MR1F
30	40	0.45	NR1F	35	24	1.75	NT1F
25	40	0.5	MS3E	25	40	2	MT3E
35	40	0.7	MS3E	45	24	2.25	NT1F
25	40	0.75	MS1F	25	32	2.5	MT3E
30	30	0.8	NT3E	25	40	3	MT1F
30	40	0.9	NT1F				

## ELECTRICAL CONTROL



with the exception of the lathe isolator  
all electrical controls are fitted onto the front face of the headstock

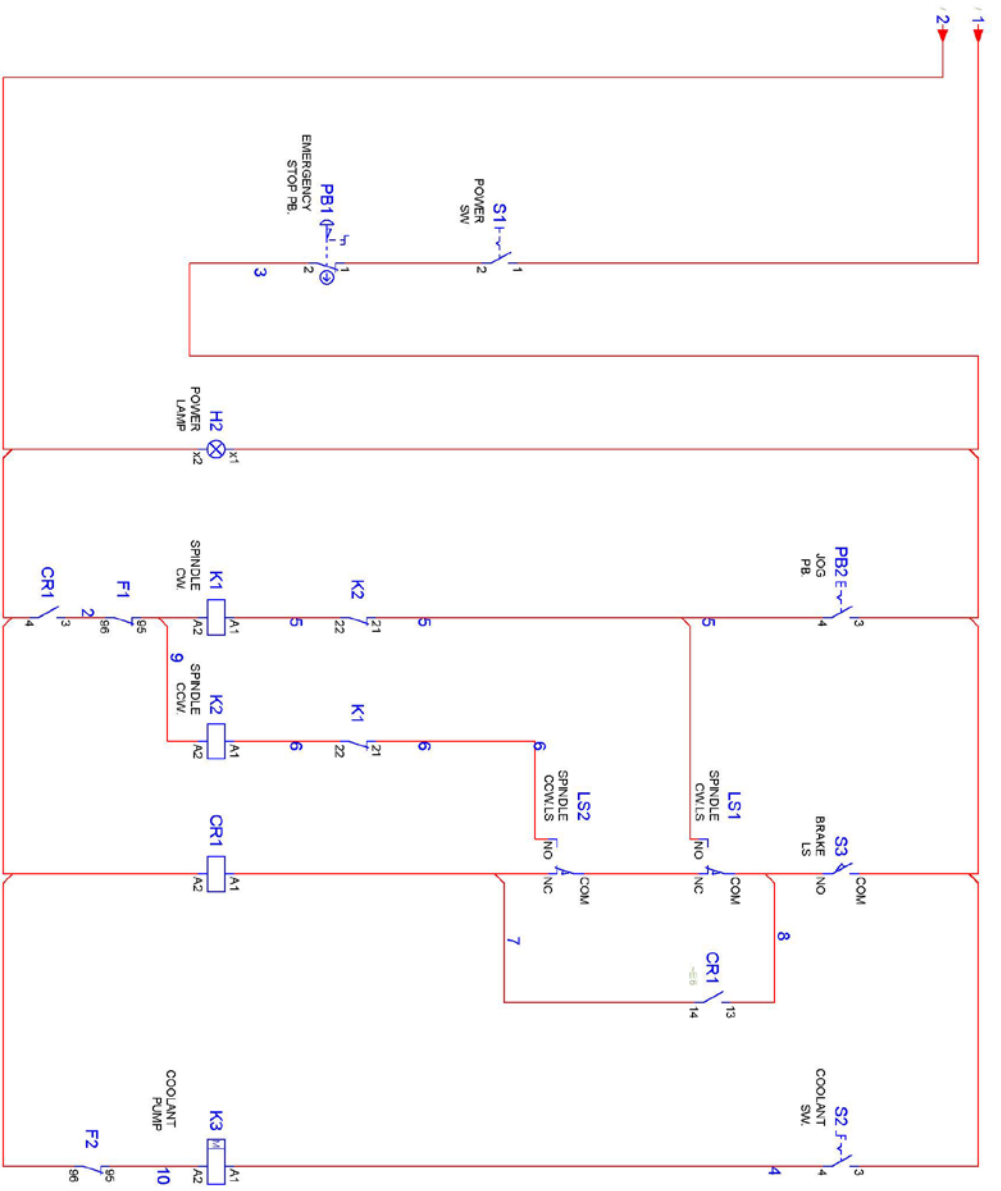
1. Press the RED button on stop the main motor and also electrical supply to ancillary services
2. Turn the button on The indicator lamp will glow whilst the electricity is supplied
3. Coolant pump ON/OFF push buttons
4. Press the GREEN button to start the main drive motor and the indicator lamp glows whilst the motor is running
5. Emergency stop reset button



20144728

POWER440V

1	2	3	4	5
1	2	3	4	5



201-44/28

CONTROL

+

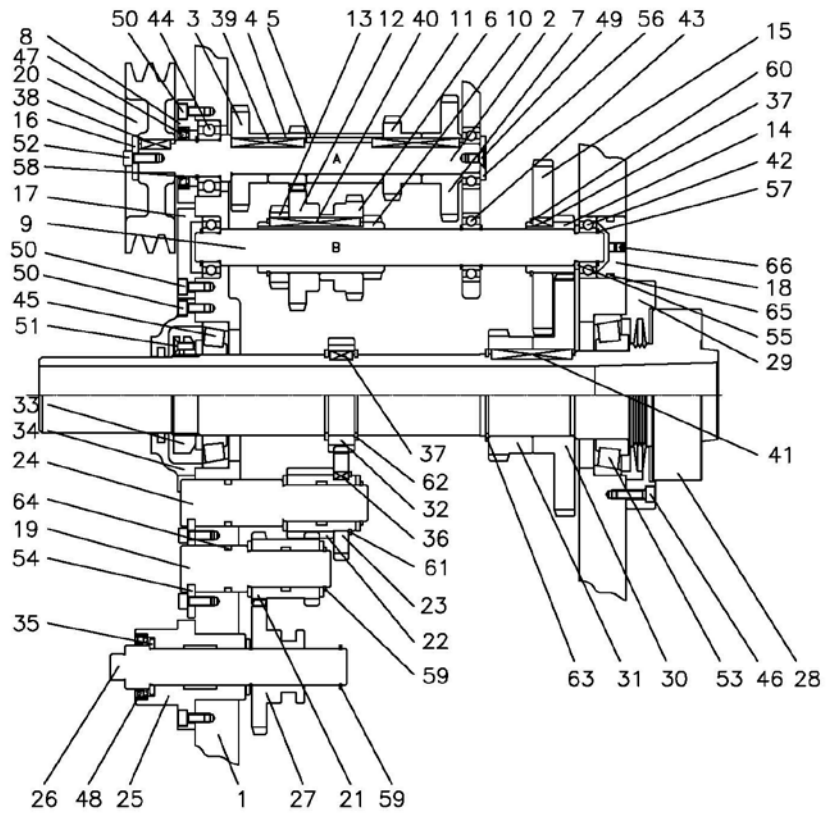
5

## HEAD STOCK

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
1	CASTING	5101	1	
2	A SHAFT	7102	1	
3	GEAR	7103	1	
4	GEAR	7104	1	
5	COLLAR	7105	1	
6	GEAR	7106	1	
7	GEAR	7107	1	
8	COVER	7108	1	
9	B SHAFT	7109	1	
10	GEAR	7110	1	
11	GEAR	7111	1	
12	GEAR	7112	1	
13	GEAR	7113	1	
14	GEAR	7114	1	
15	GEAR	7115	1	
16	WASHER	7116	1	
17	COVER	7117	1	
18	PLUG	7118	1	
19	C SHAFT	7119	1	
20	PULLEY	7120	1	
21	GEAR	7121	1	
22	GEAR	7122	1	
23	GEAR	7123	1	
24	D SHAFT	7124	1	
25	KEEP ASSY	7125	1	
26	E SHAFT	7126	1	
27	GEAR	7127	1	
28	SPINDLE	7128	1	
29	COVER	7129	1	
30	GEAR	7130	1	
31	GEAR	7131	1	
32	GEAR	7132	1	
33	NUT	7133	1	
34	COVER	7134	1	
35	COLLAR	7135	6	
36	PARALLEL KEY		5*5*10	1

## HEAD STOCK

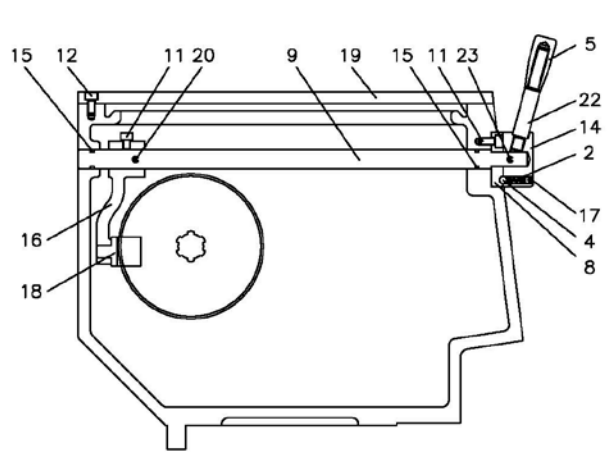
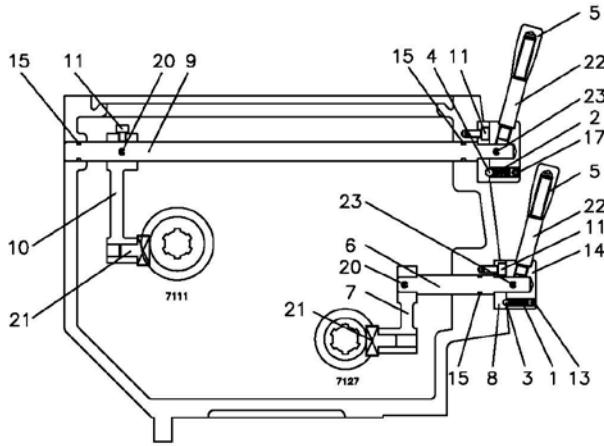
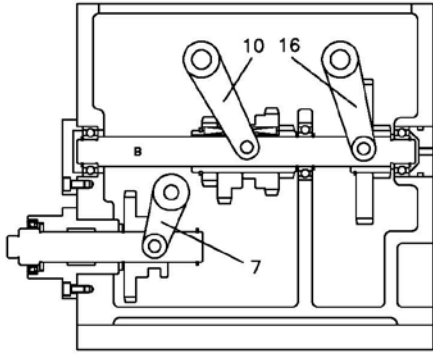
ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
37	PARALLEL KEY		6*6*15	2
38	PARALLEL KEY		6*6*20	1
39	PARALLEL KEY		6*6*50	2
40	PARALLEL KEY		6*6*60	1
41	PARALLEL KEY		8*7*55	1
42	BEARING		6004	3
43	BEARING		6005	1
44	BEARING		6205	1
45	BEARING		30211	1
46	BEARING		30212	1
47	OIL SEAL		TC24*42*08	1
48	OIL SEAL		TC30*45*08	1
49	SOCKET SCREW		M6*10	1
50	SOCKET SCREW		M6*12	6
51	SOCKET SCREW		M6*16	8
52	SOCKET SCREW		M6*20	1
53	SOCKET SCREW		M6*25	4
54	WASHER	7154		2
55	COLLAR	7155		1
56	WASHER	7156		1
57	CIRCLIP		S20	2
58	CIRCLIP		S24	1
59	CIRCLIP		S25	6
60	CIRCLIP		S35	2
61	CIRCLIP		S38	1
62	CIRCLIP		S55	2
63	CIRCLIP		S56	1
64	"O" RING		P26	2
65	"O" RING		P36	1
66	SET SCREW		M6*6	1





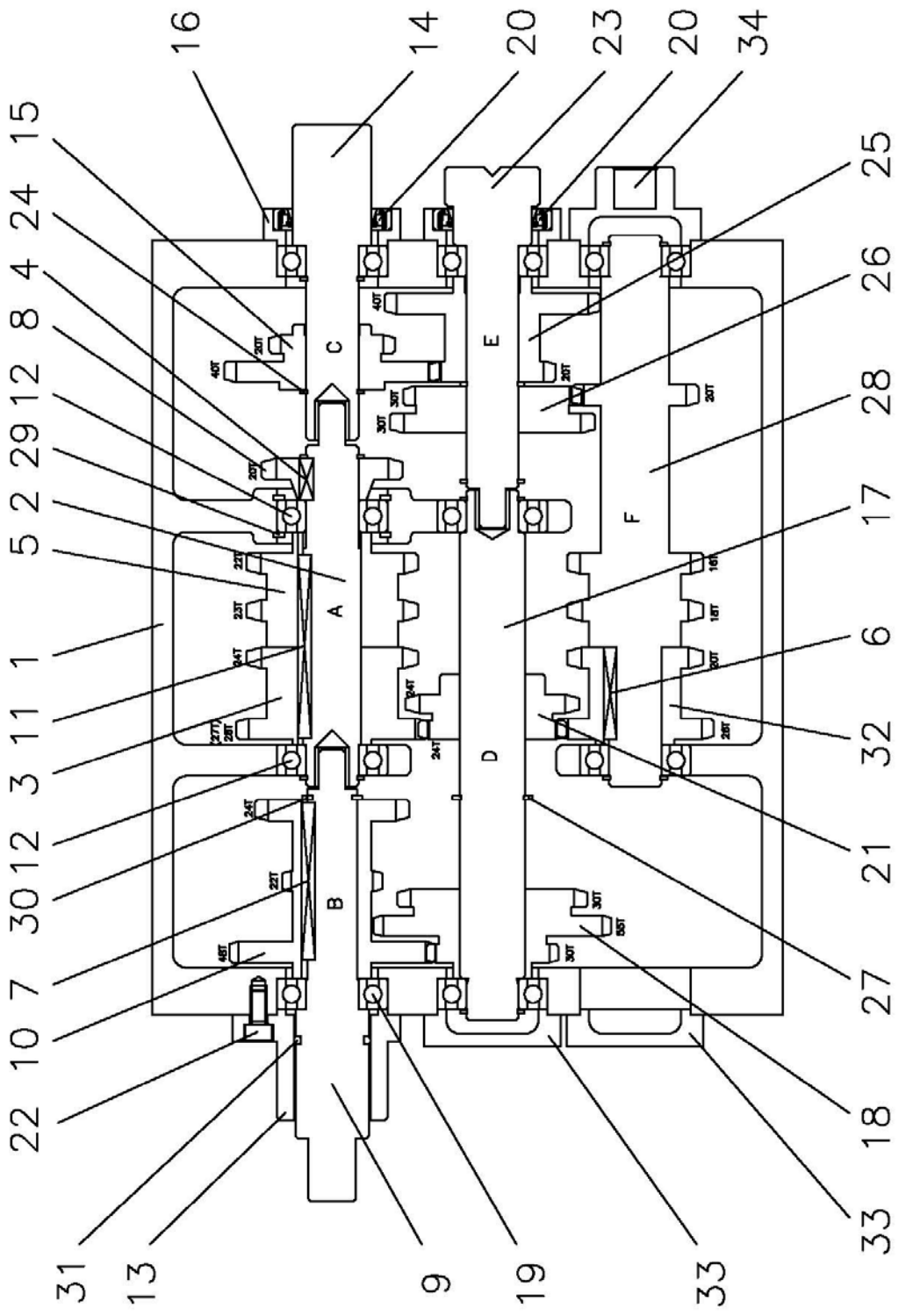
## HEAD STOCK

ITEM NO.	DESCRIPTION	PART NO.		NO.OFF	REMARK
1	COMPRESSION SPRING		ψ4.0*d1.0	1	
2	COMPRESSION SPRING		ψ6.0*d1.0	2	
3	STEEL BALL		3/16"	1	
4	STEEL BALL		1/4"	2	
5	SOCKET SCREW		M6*8	2	
6	SHAFT	7136		1	
7	LEVER	7137		1	
8	WASHER	7138		2	
9	SHAFT	5103		2	
10	LEVER	7140		1	
11	SOCKET SCREW		M6*12	6	
12	SOCKET SCREW		M6*20	8	
13	SET SCREW		M6*6	1	
14	AXLE CAP	7144		2	
15	"O" RING		P12	5	
16	FORK	7146		1	
17	SET SCREW		M8*6	2	
18	FORK	7148		1	
19	COVER	5102		1	
20	SPRING PIN		ψ5*30	3	
21	SPRING PIN		ψ5*40	1	
22	FORK	7152		2	
23	SPRING PIN		ψ5*50	2	
24	WASHER	7244		1	
25	AXLE CAP	7245		1	
26	HANDLE	7246		3	
27	HANDLE	7263		3	
28	FORK	7152-1		1	



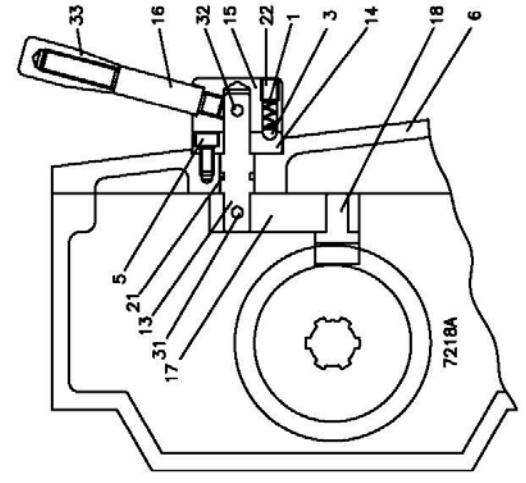
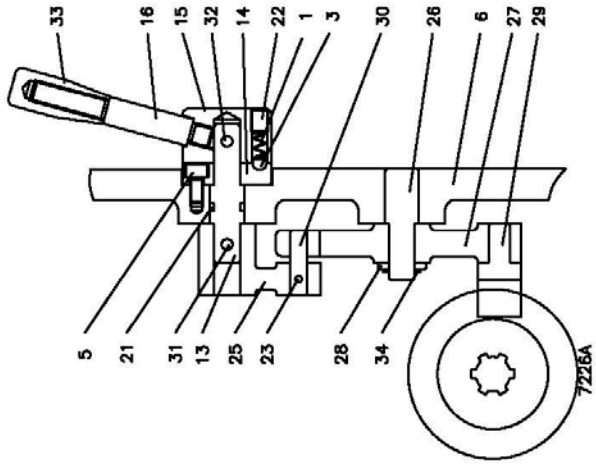
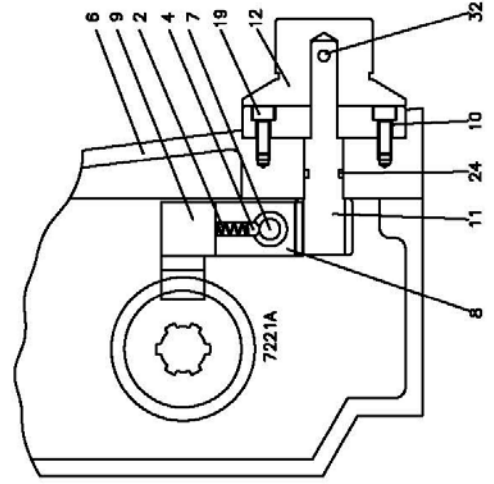
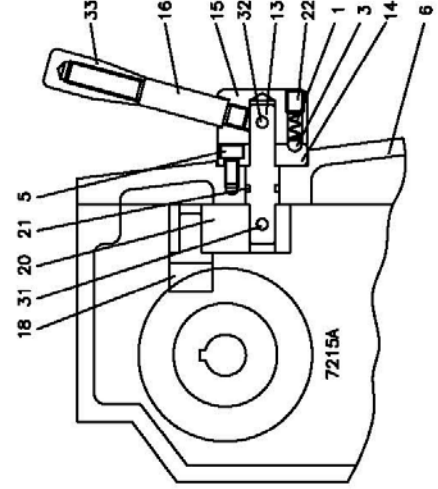
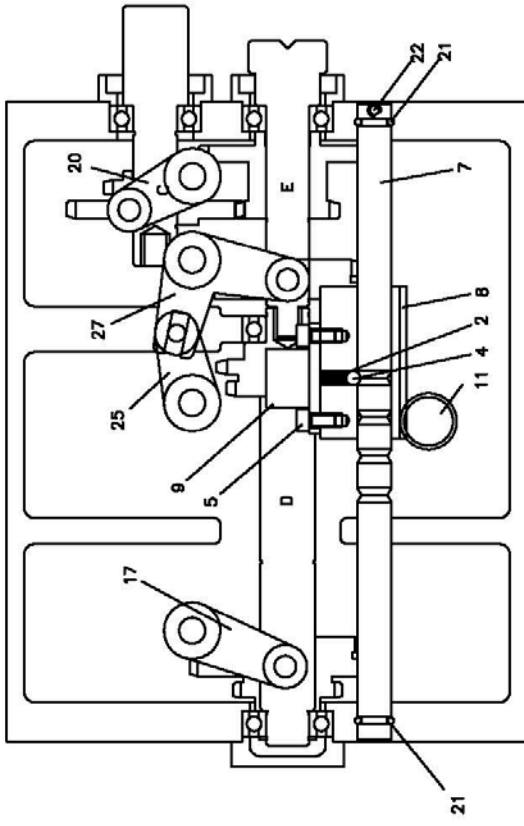
## GEAR BOX

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
1	CASTING	7201	1	
2	A SHAFT	7202	1	
3	GEAR	7203A	1	
4	PARALLEL KEY		5*5*15	1
5	GEAR	7205A	1	
6	PARALLEL KEY		5*5*35	1
7	PARALLEL KEY		5*5*60	1
8	GEAR	7208	1	
9	B SHAFT	7209	1	
10	GEAR	7210A	1	
11	PARALLEL KEY		5*5*70	1
12	BEARING		6004	9
13	COVER	7213	1	
14	C SHAFT	7214	1	
15	GEAR	7215A	1	
16	COVER	7216	2	
17	D SHAFT	7217	1	
18	GEAR	7218A	1	
19	COVER	7261	1	
20	OIL SEAL		TC30*45*08	2
21	GEAR	7221A	1	
22	SOCKET SCREW		M6*16	13
23	E SHAFT	7223	1	
24	CIRCLIP		S20	10
25	GEAR	7225A	1	
26	GEAR	7226A	1	
27	CIRCLIP		S25	1
28	F SHAFT	7228A	1	
29	CIRCLIP		R42	2
30	CIRCLIP		E15	1
31	"O" RING		AS-119	1
32	GEAR	7233A	1	
33	COVER	7235	2	



## GEAR BOX

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
1	COMPRESSION SPRING		ψ4.0*d1.0 3	
2	COMPRESSION SPING		ψ6.0*d1.0 1	
3	STEEL BALL		3/16" 3	
4	STEEL BALL		1/4" 1	
5	SOCKET SCREW		M6*12 8	
6	COVER	7236	1	
7	SHAFT	7237	1	
8	ROCK	7238	1	
9	FORK	7239	1	
10	WASHER	7240	1	
11	PINION	7241	1	
12	AXLE CAP	7242	1	
13	SHAFT	7243	3	
14	WASHER	7244	3	
15	AXLE CAP	7245	3	
16	HANDLE	7246	3	
17	LEVER	7247	1	
18	FORK	7248	2	
19	SOCKET SCREW		M6*16 2	
20	LEVER	7250	1	22L
21	"O" RING		P12 5	
22	SET SCREW		M6*6 4	
23	SPRING PIN		ψ3*20 1	
24	"O" RING	P14	1	
25	LEVER	7255	1	33L
26	SHAFT	7256	1	
27	LEVER	7257	1	
28	COLLAR	7258	1	
29	FORK	7259	1	
30	PIN	7260	1	
31	SPRING PIN		ψ5*30 3	
32	SPRING PIN		ψ5*40 4	
33	HANDLE	7263	3	
34	CIRCLIP		S12 1	



## APRON

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
1	CASTING	7301	1	
2	GEAR	7302	1	
3	BUSH	7303	1	
4	DIAL	7304	1	
5	HAND WHEEL	7305	1	
6	PINION	7306	1	
7	GEAR	7307	1	
8	SHAFT	7308	1	
9	WORM GEAR	7309	1	
10	GEAR	7310	1	
11	GEAR	7311	1	
12	GEAR	7312	1	
13	GEAR	7313	1	
14	GEAR	7314	1	
15	PIN	7315	1	
16	KEEP ASSY	7316	1	
17	SHAFT	7317	1	
18	WORM GEAR	7318	1	
19	HANDLE	7319	1	
20	INDICATOR SHAFT	7320	1	
21	PLATE	7321	1	
22	KEEP ASSY	7322	1	
23	SHAFT	7323	1	
24	PIN	7324	2	
25	HANDLE	7325	1	7514
26	GIB	7326	1	
27	HALF-NUT	7327	1	
28	HANDLE	7263	2	3/18"-16NC
29	GUARD	7329	1	
30	WORM	7330	1	
31	PLATE	7331	1	
32	SCREW	7332	1	
33				
34	WASHER	7610	1	
35	PILLAR	7335	3	
36	COMPRESSION SPRING		1	ψ4.0*d1.0

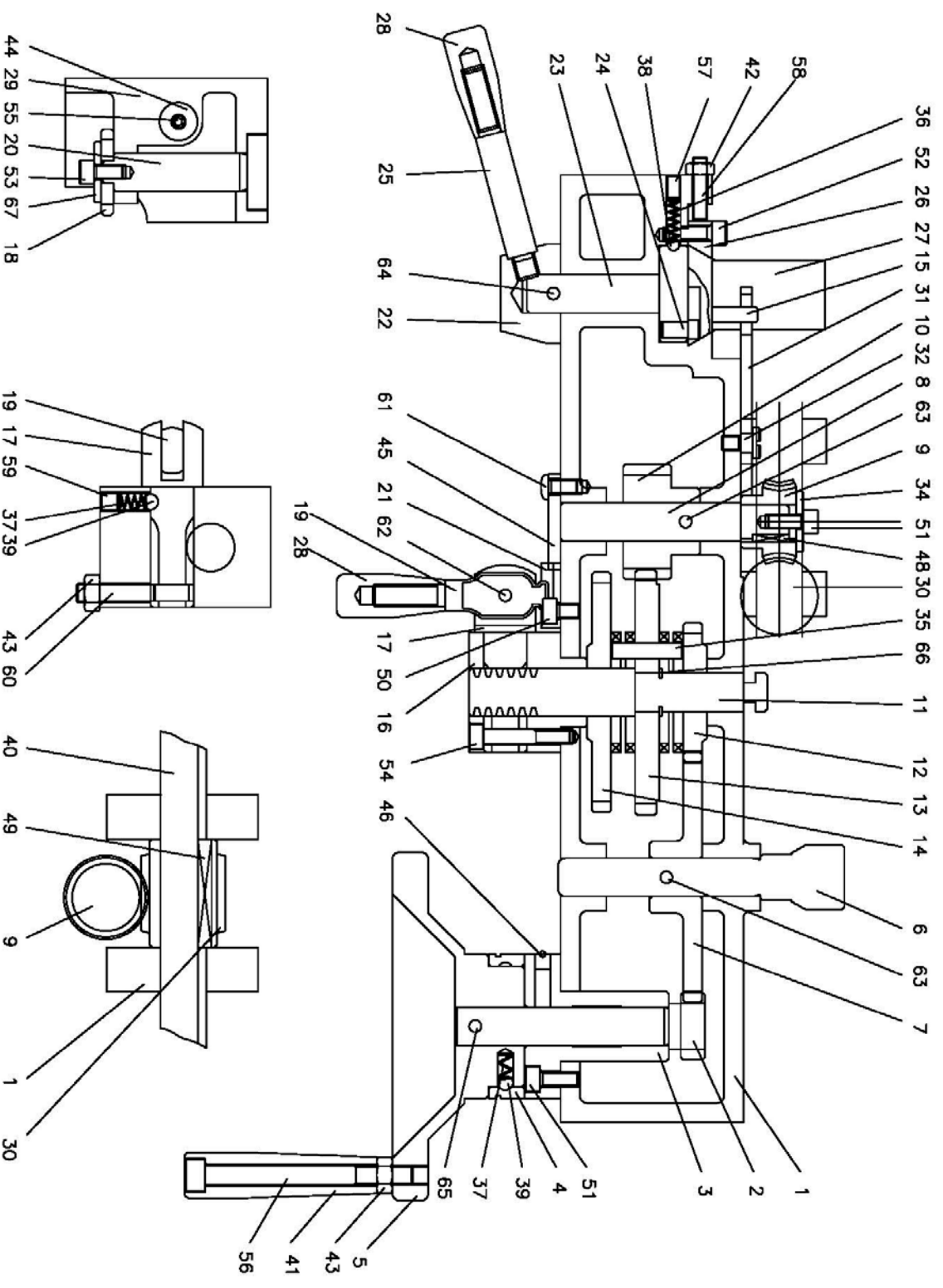


## APRON

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
37	COMPRESSION SPRING		ψ6.0*d1.0 2	
38	STEEL BALL		3/16'' 1	
39	STEEL BALL		1/4'' 2	
40	FEED ROD	7618	1	
41	HANDLE	10305	1	
42	NUT		M6 2	
43	NUT		M8 1	
44	WASHER	7344	1	
45	WASHER	7345	1	
46	OIL BALL		1/4'' 2	
47	SCREW		1/4''-TP 1	
48	PARALLEL KEY		4*4*15 1	
49	PARALLEL KEY		5*5*40 1	
50	SOCKET SCREW		M6*12 2	
51	SOCKET SCREW		M6*16 3	
52	SOCKET SCREW		M6*20 8	
53	SOCKET SCREW		M5*12 1	
54	SOCKET SCREW		M6*40 3	
55	SOCKET SCREW		M6*70 1	
56	SOCKET SCREW		M8*85 1	
57	SET SCREW		M6*6 1	
58	SET SCREW		M6*25 2	
59	SET SCREW		M8*6 1	
60	SET SCREW		M8*30 1	
61	SOCKET BUT.		M6*12 2	
62	SPRING PIN		ψ5*25L 1	
63	SPRING PIN		ψ5*30L 2	
64	SPRING PIN		ψ5*40L 1	
65	SPRING PIN		ψ5*60L 1	
66	CIRCLIP		E12 1	
67	WASHER	1002055	1	

## SADDLE AND TOP-SLIDE

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
1	CASTING	5105	1	
2	SCREW	5107	1	
3	NUT	7403	1	7446
4	NUT ASSY	7404	1	
5	PINION	5111	1	
6	KEEP ASSY	7406-1	1	
7	NUT	7407-1	1	
8	DIAL	7408-1	1	
9	HAND WHEEL	7409-1	1	
10	BRACKET	7410-1	1	
11	STRIP	7411	2	
12	STRIP	5109	1	
13	GIB	5110	1	
14	CROSS SLIDE	5106	1	
15	GIB	5108	1	
16	SCREW	7416	4	
17	HANDLE	10305	1	
18	BOLT	7418	1	
19	SWIVEL SLIDE	5113	1	
20	GIB	7420	1	
21	TOP SLIDE	7221	1	
22	NUT	8407-1	1	
23	SCREW	7423	1	
24	NUT	7424	1	
25	KEEP ASSY	7425	1	
26	DIAL	7426	1	
27	KEEP ASSY	7427	1	
28	HAND WHEEL	7428	1	
29	T-SLOTTED	7429	1	
30	HANDLE	7430	1	
31	SHAFT	7431	1	
32	TURRET BODY	7432	1	
33	SCREW	7433	8	
34	WASHER	7434	1	
35	NUT	7435	1	
36	HANDLE	7436	1	

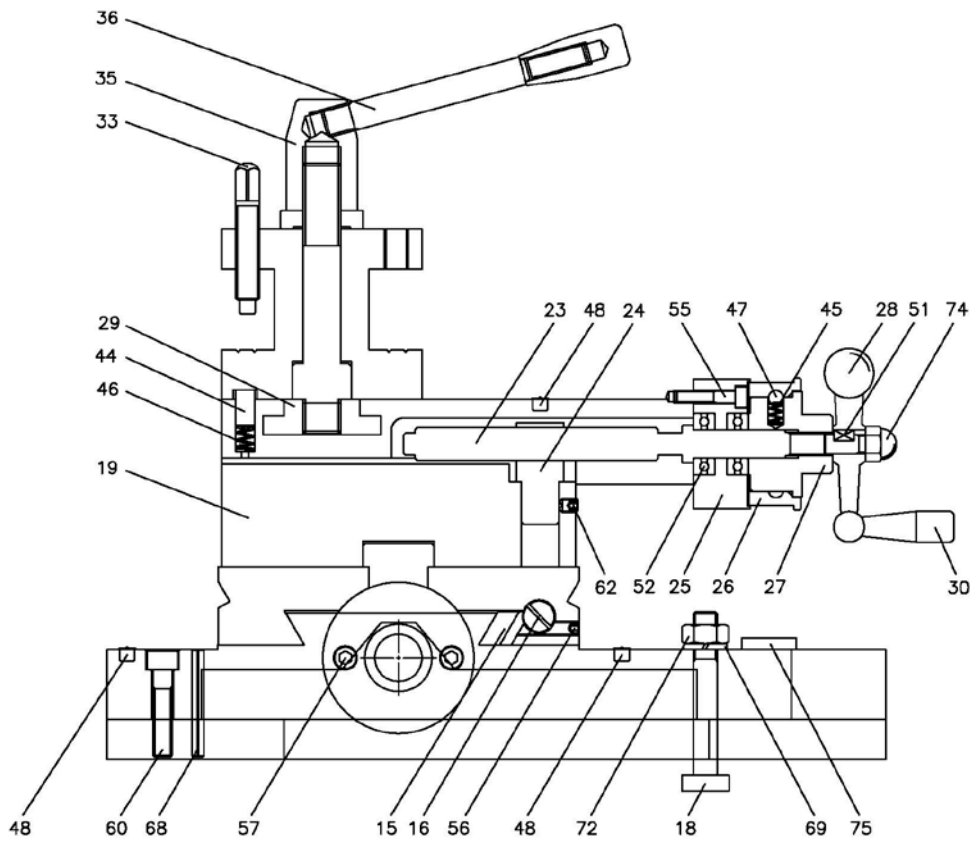
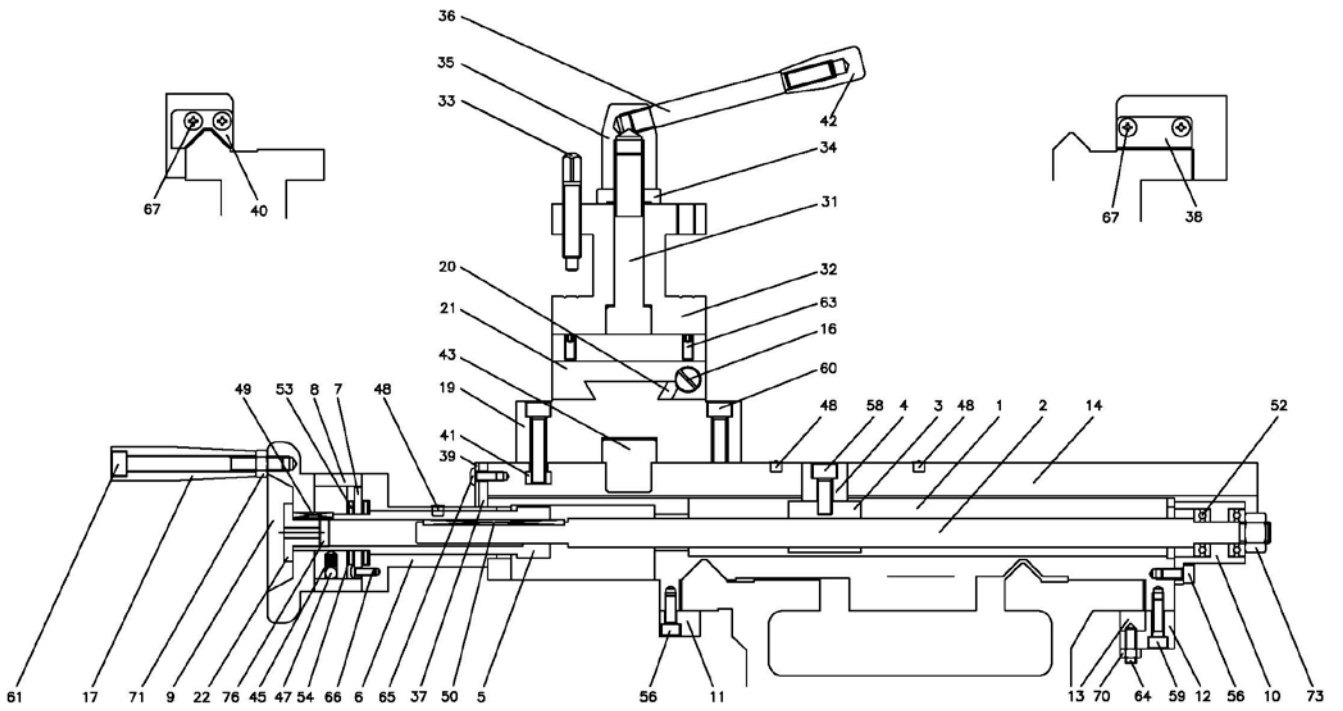


## SADDLE AND TOP-SLIDE

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
37	WIPER	5112	1	
38	WIPER	9439	1	
39	WIPER PROTECT	5112-1	1	
40	WIPER	7439	1	
41	BLOCK	7441	2	
42	HANDLE	7263	1	
43	PLUG	8440	1	
44	PILLAR	8442	1	
45	COMPRESSION SPRING	ψ6.0*d1.0	2	
46	COMPRESSION SPRING	ψ8.0*d1.0	1	
47	STEEL BALL	1/4"	2	
48	OIL BALL	1/4"	11	
49	PARALLEL KEY	3*3*20	1	
50	PARALLEL KEY	3*3*75	1	
51	PARALLEL KEY	4*4*8	1	
52	BEARING	51101	4	
53	BEARING	NTB2035	2	
54	BEARING	AS2035	4	
55	SOCKET SCREW	M5*30	2	
56	SOCKET SCREW	M6*16	6	
57	SOCKET SCREW	M6*75	2	
58	SOCKET SCREW	M8*20	2	
59	SOCKET SCREW	M8*30	3	
60	SOCKET SCREW	M8*35	4	
61	SOCKET SCREW	M8*85	1	
62	SET SCREW	M6*6	1	
63	SET SCREW	M6*16	3	
64	SET SCREW	M6*20	3	
65	SOCKET BUT.	M5*12	3	
66	COUNTERSUNK BOLT	3/16"*1/4"	2	
67	COUNTERSUNK BOLT	M5*12	8	
68	SPRING PIN	ψ5*36	1	
69	SPRING WASHER	M10	1	
70	NUT	M6	3	
71	NUT	M8	1	
72	NUT	M10	1	

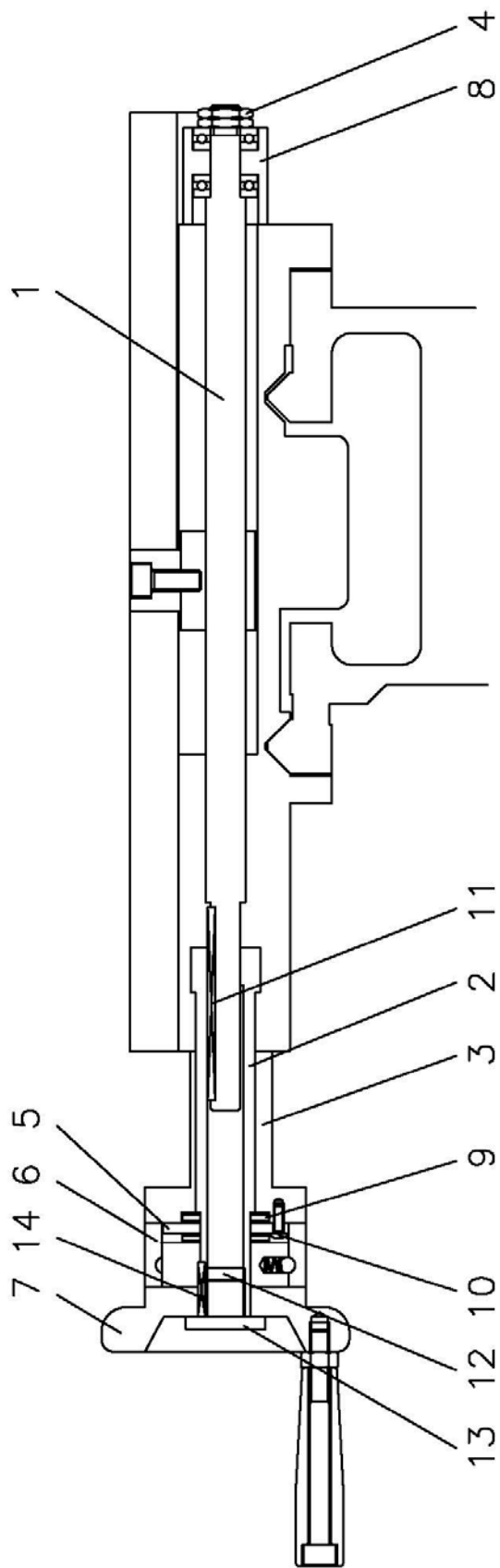
## SADDLE AND TOP-SLIDE

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
73	NUT	M12*P1.25	2	
74	CUP NUT	M8	1	
75	OIL COVER	5/8"-18NF	1	



## SADDLE AND TOP-SLIDE

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
1	SCREW	7402-1	1	
2	PINION	7405-1	1	
3	KEEP ASSY	7406-1	1	
4	NUT	7407	M12*P1.25	1
5	WASHER	7407-1		1
6	DIAL	7408-1		1
7	HAND WHEEL	7409-1		1
8	KEEP ASSY	7410-1		1
9	BEARING		AS2035	2
10	COUNTERSUNK BOLT		3/16"*1/2"	2
11	PARALLEY KEY		3*3*75	1
12	NUT	5111-1	5/8"-18NF	1
13	NUT	8407-1		1
14	PARALLEL KEY		3*3*20	1



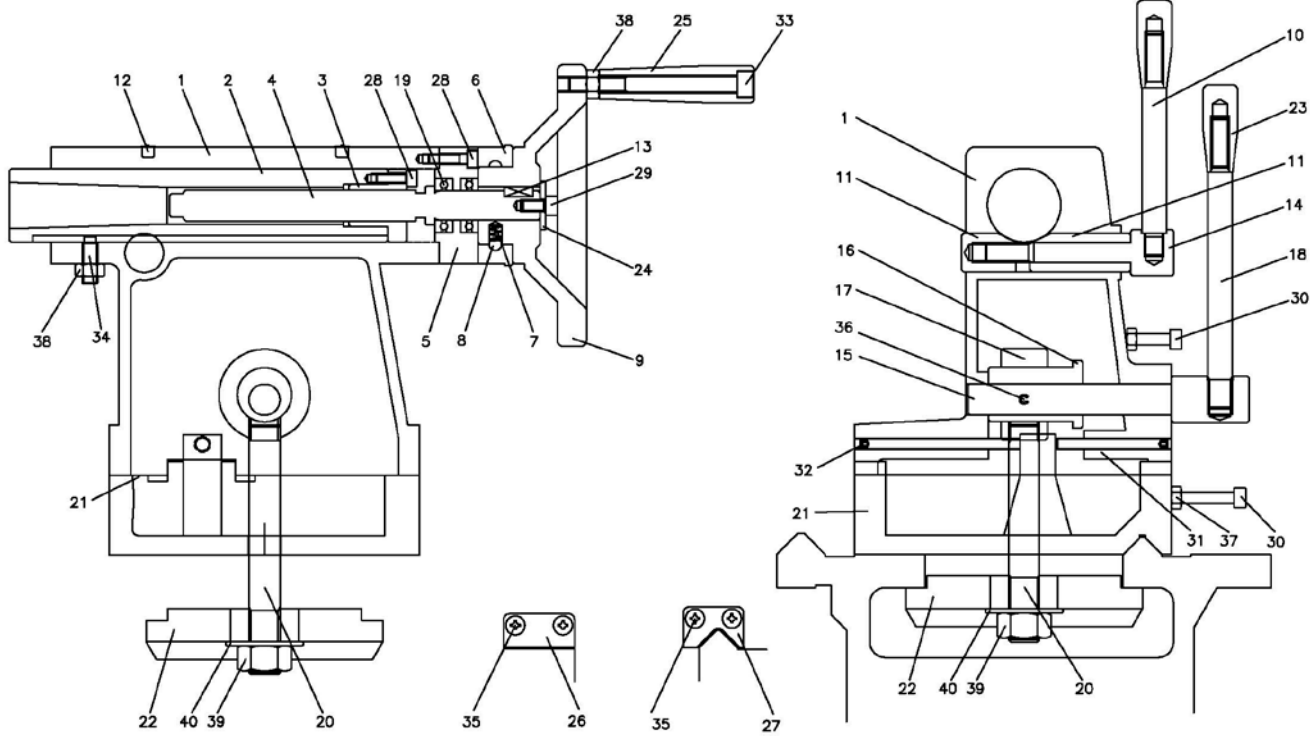


## TAIL STOCK

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
1	CASTING	5114	1	
2	BARREL	7502	1	
3	NUT	7503	1	
4	SCREW	7504	1	
5	KEEP ASSY	7505	1	
6	DIAL	7506	1	
7	COMPRESSION SPRING		1	ψ6.0*d1.0
8	STEEL BALL		1	1/4"
9	HAND WHEEL	7509	1	
10	SCREW	7510	1	
11	NUT	5117	1	
12	OIL BALL		2	1/4"
13	PARALLEL KEY		1	5*5*15
14	HANDLE	7514	1	
15	SHAFT	7515	1	
16	PIVOT BLOCK	7516	1	
17	SLEEVE	7517	1	
18	HANDLE	7518	1	
19	BEARING		2	51102
20	BOLT	5116	1	
21	BASE	5115	1	
22	CLAMP PLATE	5132	1	
23	HANDLE	7263	2	
24	WASHER	7610	1	
25	HANDLE	10305	1	
26	WIPER	7053	2	
27	WIPER	7439	2	
28	SOCKET SCREW		3	M5*25
29	SOCKET SCREW		1	M6*12
30	SOCKET SCREW		2	M6*40
31	SOCKET SCREW		1	M8*85
32	SET SCREW		1	M6*45
33	SET SCREW		1	M6*65
34	SET SCREW		1	M8*20
35	COUNTERSUNK SCREW		8	M5*12
36	SPRING PIN		1	ψ5*25

## TAIL STOCK

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
37	NUT		M6 2	
38	NUT		M8 2	
39	NUT		5/8"-11NC 1	
40	WASHER		5/8" 1	



## BED

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
1	BED	5118	1	
2	COMPRESSION SCREW	ψ6.0*d1.0	4	
3	COMPRESSION SCREW	ψ12*d2.0*100L	1	
4	COMPRESSION SCREW	ψ45*d5.0*20L	1	
5	STEEL BALL	1/4"	4	
6	PARALLEL KEY	7*7*70	1	
7	BEARING	51103	3	
8	HEX SCREW	M10*25	4	
9	HEX SCREW	1/2"*2"	8	
10	SOCKET	M5*12	2	
11	BOLT	7611	2	
12	NUT	7612	2	
13	SOCKET SCREW	M6*12	12	
14	SOCKET SCREW	M6*20	12	
15	SOCKET SCREW	M6*35	1	
16	SOCKET SCREW	M6*70	5	
17	LEAD SCREW	7617	1	
18	FEED ROD	7618	1	
19	THIRD-ROD	7619	1	
20	ROCK	7620	1	
21	BRACKET	7621	1	
22	FLOOR	5119	1	
23	OIL NET	5133	1	
24	SAFETY ASSY	7624	1	
25	COVER	7625	1	
26	BUSH	7626	1	
27	BUSH	7627	1	
28	LEVER	7628	1	
29	SHAFT	5123	1	
30	SELECTOR	7630	1	
31	BRACKET	7631	1	
32	BRACKET	7632	1	
33	BLOCK	7633	6	
34	PULLEY	7634	1	
35	MOTOR PLATE	5124	1	
36	FIXED RACK		1	

## BED

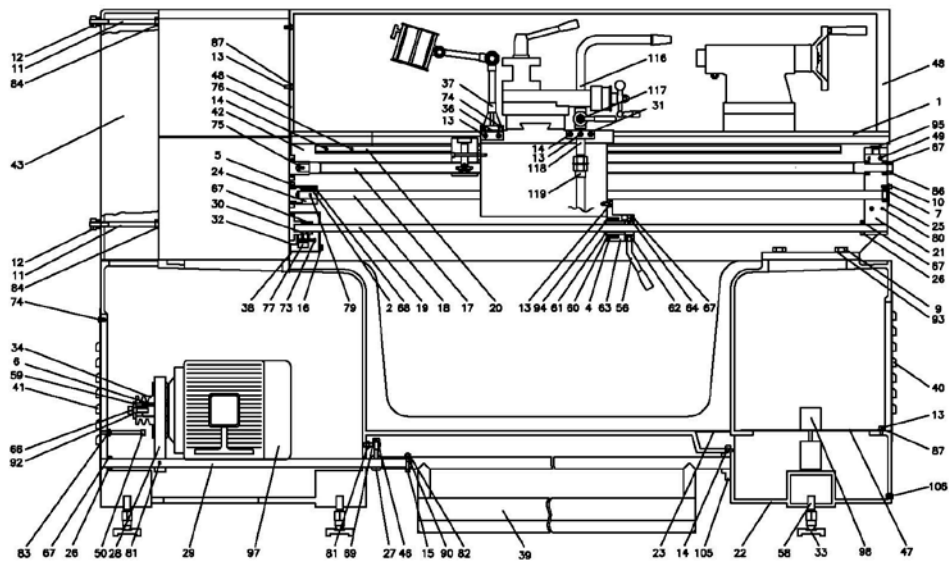
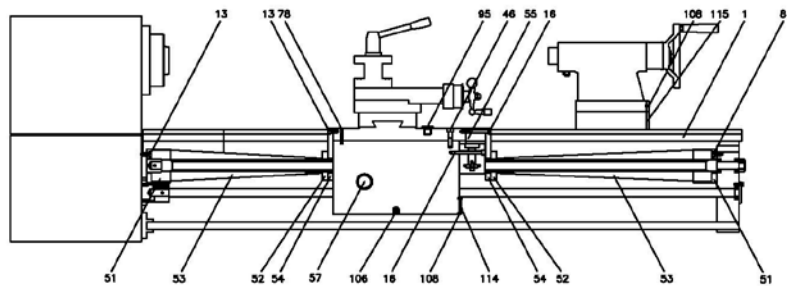
ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
37	HALOGEN LIGHT		1	
38	COVER	5134	1	
39	FOOT BRAKE	5122	1	
40	COVER	5120	2	
41	COVER	5121	2	
42	GAP	7642	1	
43	ENC COVER	5126	1	
44	BOX	7644	1	
45	ELECTRICAL BOX	5127	1	
46	SOCKET SCREW		M8*35	10
47	POMPU BOX	5125	1	
48	SPLASH GUARD	7648	1	
49	SOCKET SCREW		M8*55	2
50	SOCKET SCREW		M8*90	1
51	BLOCK	7651	1	
52	BLOCK	7652	1	
53	SPRING COVER	7653	2	
54	PLANK	7654	1	
55	BLOCK	7655	1	
56	HANDLE	7656	1	
57	FUEL LEVER		ψ29	3
58	SCREW	7658	1	
59	WASHER	8143	1	
60	WASHER	8618	1	
61	BUSH	8619	1	
62	KEEP ASSY	8620	1	
63	BRACKET	8621	1	
64	PLUG	8622	1	
65	SCREW	8635	1	
66	SOCKET SCREW		M10*35	5
67	SET SCREW		M6*6	9
68	SET SCREW		M8*6	4
69	SET SCREW		M8*30	2
70	COUNTERSUNK SCREW		3/16"*3/8"	1
71	COUNTERSUNK SCREW		3/16"*1/4"	2
72	COUNTERSUNK SCREW		3/16"*1/2"	2

## BED

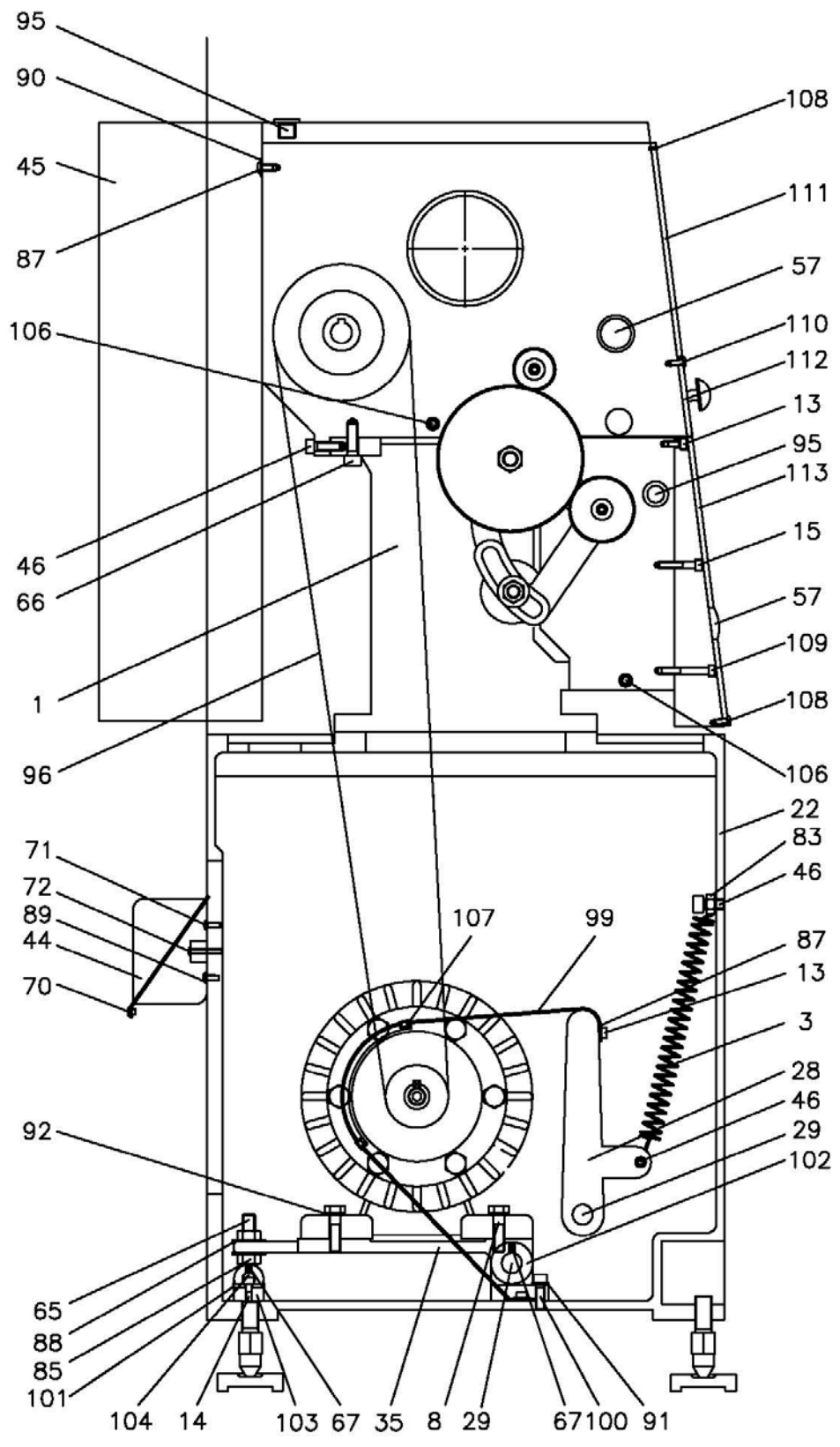
ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
73	COUNTERSUNK SCREW		M4*40	2
74	COUNTERSUNK SCREW		M6*12	16
75	TAPER PIN		3#*32	1
76	SPRING PIN		ψ5*20	7
77	LIMIT SWICH			1
78	SPRING PIN		ψ5*36	2
79	SPRING PIN		ψ5*40	1
80	SPRING PIN		ψ5*55	2
81	SPRING PIN		ψ6*40	1
82	NUT		M6	1
83	NUT		M8	2
84	NUT		3/8"-16NC	2
85	NUT		1/2"-14NC	2
86	NUT		5/8"-11NF	1
87	WASHER		M6	9
88	WASHER		ψ1/2"	2
89	WASHER		ψ3/16"	1
90	SPRING WASHER		M6	1
91	SPRING WASHER		ψ8	3
92	SPRING WASHER		M10	4
93	SPRING WASHER		ψ1/2"	8
94	CIRCLIP		S30	1
95	OIL SEAL		3/8"-16NF	3
96	V-BELT		A67	2
97	MOTOR			1
98	POMPU			1
99	BRAKE LINING			1
100	SOCKET SCREW		M8*25"	3
101	WASHER	7116		4
102	KEEP ASSY	8632		1
103	KEEP ASSY	8634		2
104	SHAFT	8636		2
105	BRACKET	8617		1
106	SET SCREW		PT1/2"	4
107	SCREW		ψ5	2
108	SCREW		ψ2	10

## BED

ITEM NO.	DESCRIPTION	PART NO.	NO. OFF	REMARK
109	SOCKET		M6*45 3	
110	SOCKET SCREW		M5*8 10	
111	PLATE OF HEADSTOCK	7151	1	
112	PLATE OF ELECTRIC	7162	1	
113	PLATE OF GEAR BOX	7262	1	
114	PLATE OF APRON	7341	1	
115			1	
116	OIL PIPE		1	
117	OIL CONTROL VALVE		1	
118	DUCT		1	
119	PROTECT PIPE		1	
	BRAKE LINING	7636	1	

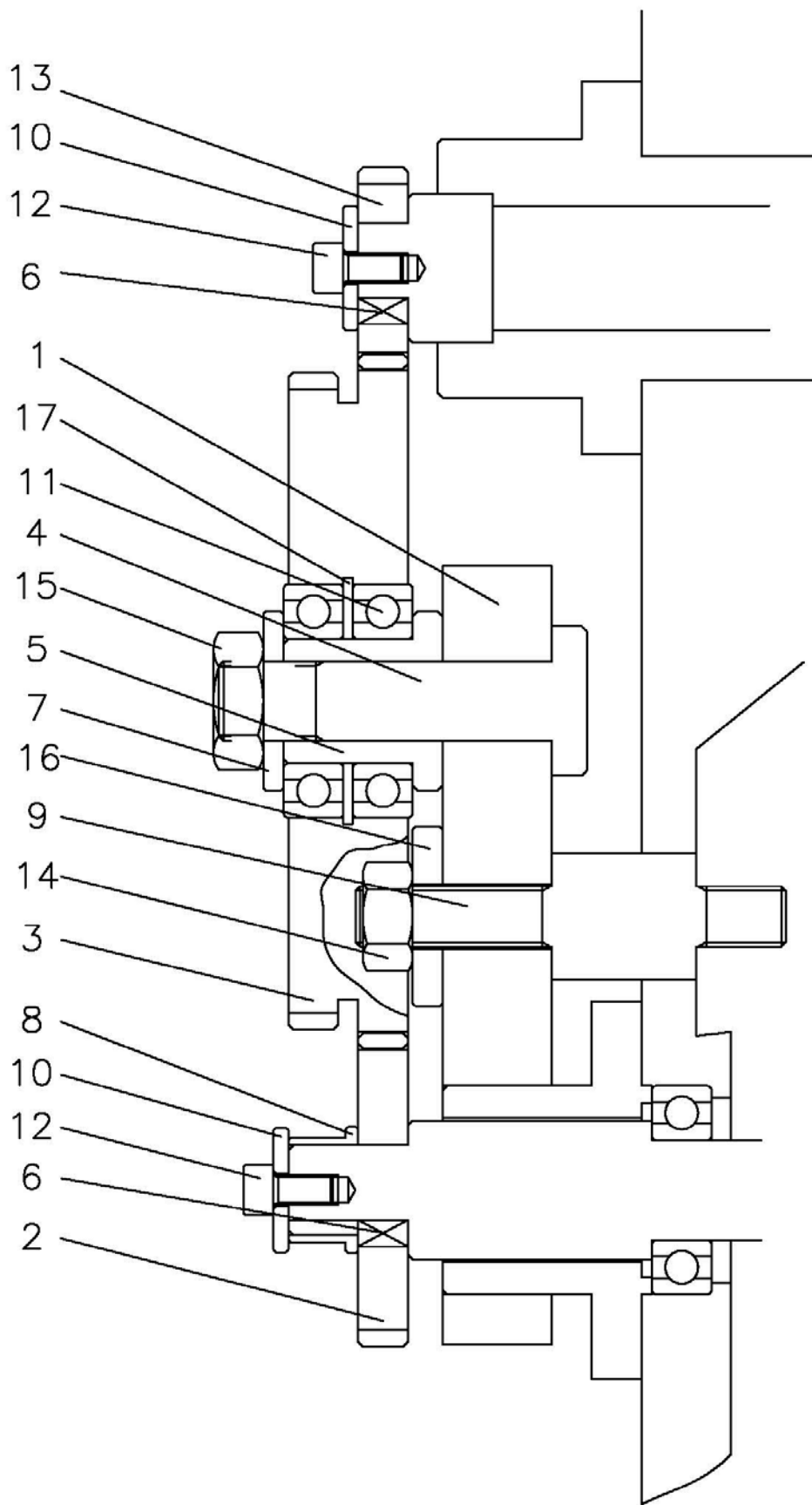






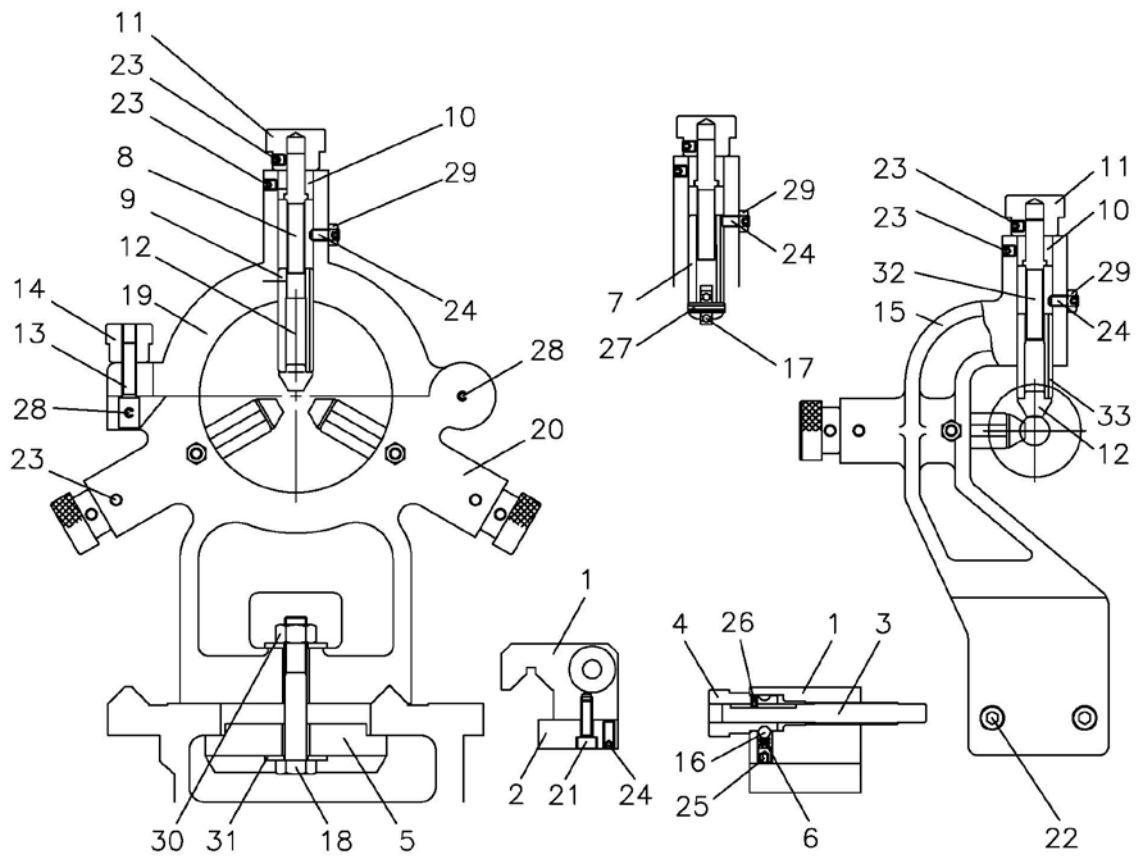
## GEAR TRAIN

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
1	SWING FRAME	7616	1	
2	GEAR	7602	1	
3	GEAR	7603	1	
4	SHAFT	7604	1	
5	BUSH	7605	1	
6	PARALLEL KEY		5*5*10	2
7	WASHER	7607	1	
8	COLLAR	7608	1	
9	BOLT	7609	1	
10	WASHER	7610	2	
11	BEARING		6005ZZ	2
12	SOCKET SCREW		M6*16	2
13	GEAR		7613	1
14	NUT		1/2"-12NC	1
15	NUT		M16*P2.0	1
16	WASHER		1/2"	1
17	CIRCLIP		R47	1



## STEADY/FOLLOW REST AND BED MICRO STOP SET

ITEM NO.	DESCRIPTION	PART NO.	NO.OFF	REMARK
1	BED MICRO STOP CASTING	7701	1	
2	PLANK	7702	1	
3	SCREW	7703	1	
4	DIAL	7704	1	
5	CLAMP PLATE	7522	1	
6	COMPRESSION SPRING	ψ6.0*d0.5	1	
7	SHAFT	8714	5	
8	SCREW	7708	5	
9	SHAFT	7709	5	
10	BUSH	7710	5	
11	HANDLE	7711	5	
12	PACKING	7712	5	
13	BOLT	7713	1	
14	NUT	7714	1	
15	FOLLOW REST CASTING	7715	1	
16	STEEL BALL	1/4"	1	
17	BEARING	635ZZ	5	
18	HEX SCREW	1/2"-12NC*3"	1	
19	STEADYREST TOP CASTING	7718	1	
20	STEADYREST SET CASTING	7719	1	
21	SOCKET SCREW	M6*25	2	
22	SOCKET SCREW	M8*35	2	
23	SET SCREW	M6*6	15	
24	SET SCREW	M6*16	7	
25	SET SCREW	M8*6	1	
26	SPRING PIN	ψ3*6	1	
27	WASHER	ψ1/2"	2	
28	SPRING PIN	ψ5*30	2	
29	NUT	M6	5	
30	NUT	1/2"-12NC	1	
31	WASHER	ψ1/2"	2	



## 1340G/1440G TOOL BOX DETAILED LIST

CONFIRMATION	DISCRIPTION	NO. OFF	REMARK
	HEXAGON SPANNER	1	六角板手
	SCREWDRIVER ⊕	1	螺絲起子 +
	SCREWDRIVER ⊖	1	螺絲起子 -
	FIXED SPANNER 17-19	1	固定板手
	OIL CAN	1	油壺
	SWITCH HANDLE	1	開關把手
	M.T.#3 CENTER	2	固定頂針 M.T.#3
	REDUCING SLEEVE	1	3*5 套筒
	TOOL SPANNER	1	刀架板手
	SPINDLE SPANNER	1	T 型板手
	CHANGE GEAR 24T	1	24T 齒輪
	CHANGE GEAR 30T	2	30T 齒輪
	CHANGE GEAR 32T	1	32T 齒輪
	CHANGE GEAR 35T	1	35T 齒輪
	CHANGE GEAR 45T	1	45T 齒輪
	CHANGE GEAR 21T	1	21T 齒輪(公制用)
	PACKING-UP BLOCK	6	7633 墊塊
	FOUNDATION BOLT	6	地基螺栓
	WHEEL HANDLE	2	手輪把手
	OIL PAINT JUG	1	小油漆罐
	INSTRUCTION MANUAL AND PARTS LIST	1	操作手冊