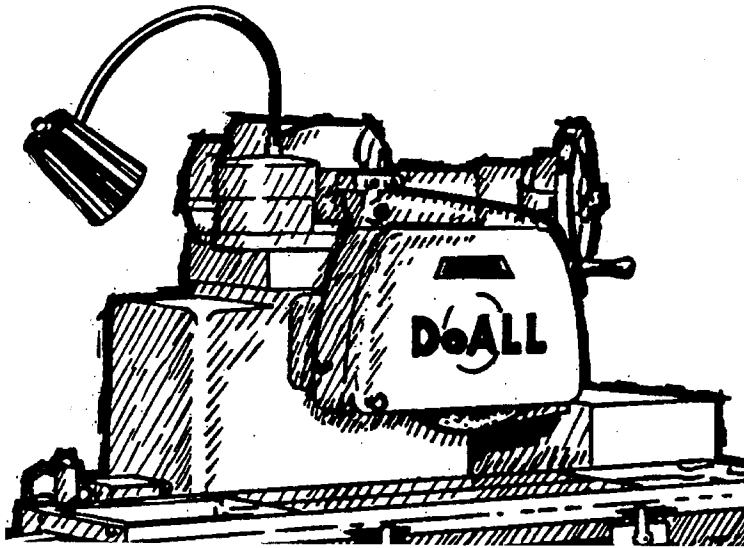


DoALL

PARTS MANUAL



MODEL: DH-618

SERIAL NO: 292-70101 to 292-76218

SURFACE GRINDER

MACHINE SPECIFICATIONS

MODEL SERIAL NO.

VOLTAGE CYCLE PHASE

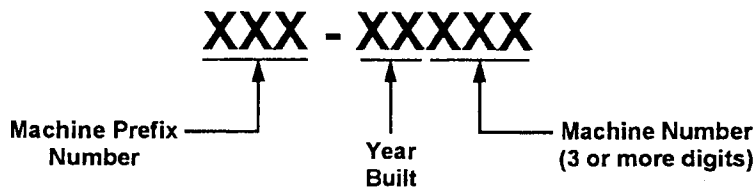
For your information and future reference, insert pertinent data concerning your machine in the spaces provided above. This information is stamped on the data plate attached to the machine frame.

Always specify machine model and serial number on all parts orders and correspondence concerning your machine. This will help avoid unnecessary delays and inconvenience during processing.

The specifications contained herein were in effect at the time this manual was approved for printing. The DoALL Company, whose policy is one of continuous product improvement, reserves the right, however, to change specifications or design at any time without notice and without incurring obligations.

How to read your serial number:

Example: 500-001234



DoALL COMPANY
254 NORTH LAUREL AVENUE
DES PLAINES, ILLINOIS 60016 U.S.A.

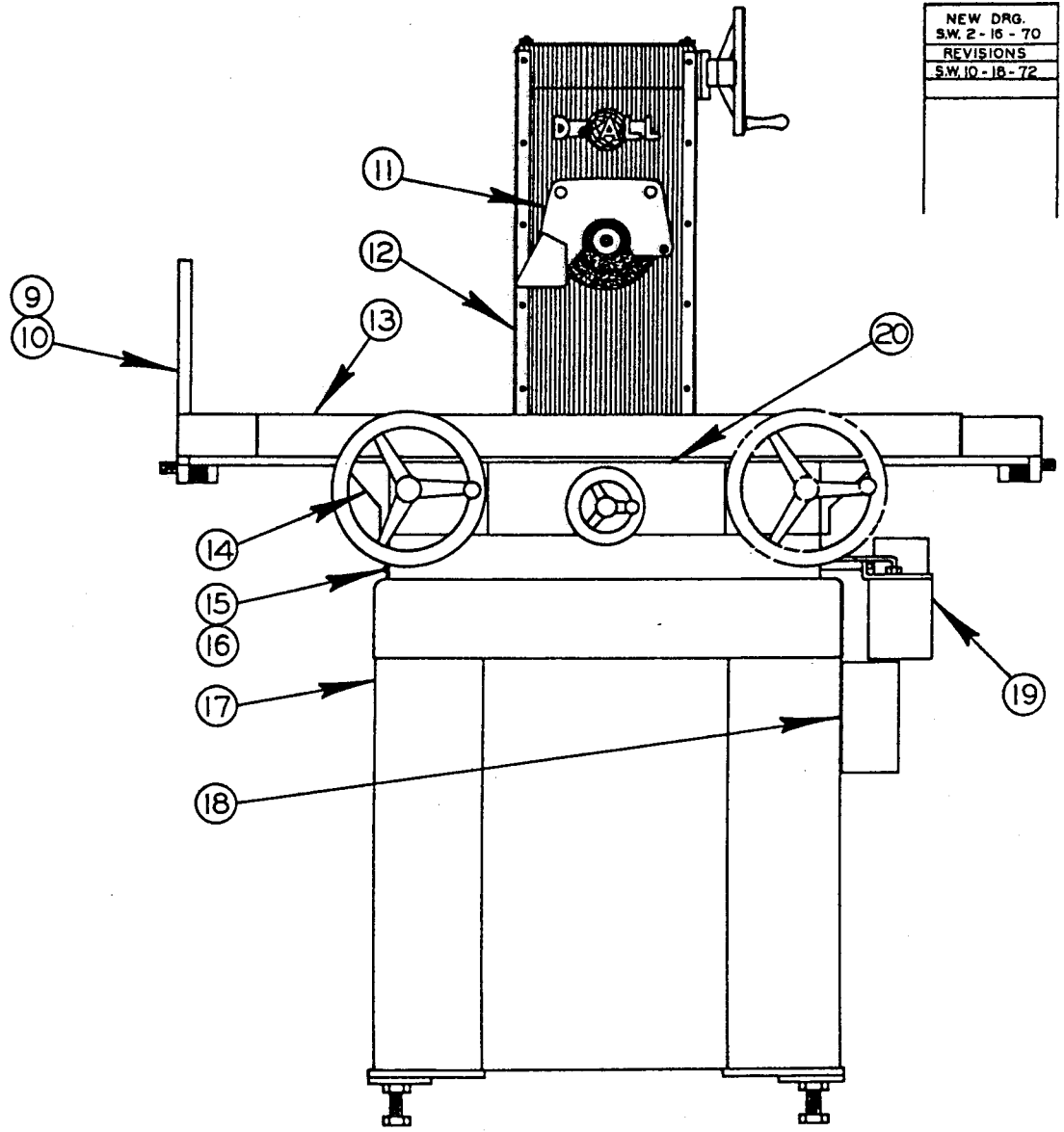
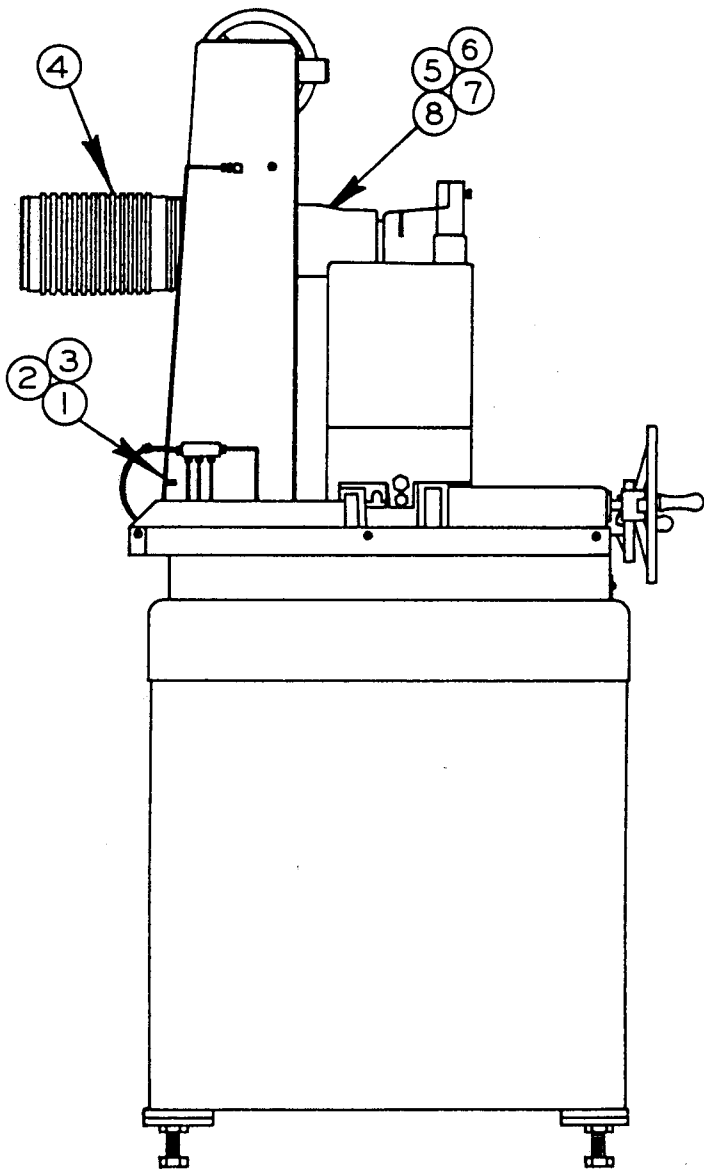
YOUR SERVICE REPRESENTATIVE:

INDEX A-1

FICHE NO. J-6 CLASS Grinder MODEL DH-618 SERIAL NO. 292-70101 TO PRESENT

PAGE NO.	DESCRIPTION	FIRST SERIAL	LAST SERIAL	FRAME NO.		FICHE NO.
				DWG.	P.LIST	
F1-1.8	Final Assembly	ALL		A-3	A-4	
F1-3.1	Base	ALL		A-5	A-6	
F1-2.2	Column 1 of 2	ALL		A-7	A-8	
F1-2.3	Column 2 of 2	ALL		A-9	A-10	
F8-5.8	Column Handwheel Extension	ALL		A-11	A-12	
F3-1.6	Coolant Pump & Tank	ALL		A-13	A-14	
F4-2.2	Cool & Flood Grind System	292-70101	to 292-72137	B-1	B-2	
F4-2.4	Cool & Flood Grind System	292-72138	to	B-3	B-4	
F4-2.4.1	Cool & Flood Grind - Flood Detail	292-72138	to	B-5	B-6	
F4-2.3	Cool & Flood Grind System, Guard	292-72138	to	B-7	B-8	
F6-6.6	Crossfeed Screw	ALL		B-9	B-10	
F6-8.4	Crossfeed, Automatic Attach.	292-72138	to	B-11	B-12	
F6-7.0	Crossfeed Nut	ALL		B-13	B-13	
F6-8.2	Crossfeed, Vernier Attach.	ALL		C-1	C-2	
F4-3.5.1	Drive & Spindle, Std.	ALL		C-3	C-4	
F4-7.5.1	Drive, Optional Speeds	ALL		C-5	C-6	
F4-7.6	Drive, Dual Speed	ALL		C-7	C-8	
F6-2.8	Hydraulic 4-Way Valve	ALL		C-9	C-10	
F1-5.2	Hydraulic Pump & Tank	292-70101	to 292-74158	C-11	C-12	
F1-5.2.1	Hydraulic Pump & Tank	292-74159	to	C-13	C-14	
F8-4.3	Motorized Wheel Elevating	ALL		D-1	D-2	
F9-5.0	Optidress Adaptor	292-72138	to	D-3	D-4	
F6-4.5	Pilot Valve	ALL		D-5&6	D-5&6	
F5-1.10	Saddle 1 of 2	ALL		D-7	D-8	
F5-1.11	Saddle 2 of 2	ALL		D-9	D-10	
	Selectron	See Fiche J-18				
F4-3.5.1	Spindle, Std.	ALL		C-3	C-4	
F4-7.5.1	Spindle, Optional Speeds	ALL		C-5	C-6	
F4-7.6	Spindle, Dual Speed	ALL		C-7	C-8	
F4-5.0	Spindle Adaptors	ALL		D-13	D-14	
F7-5.10	Table	ALL		E-1	E-2	
F7-3.1	Table Hydraulic Attach.	ALL		E-3	E-4	
F7-2.7.2	Table Feed Cylinder	ALL		E-5	E-6	
F8-5.6.1	Vertical Rapid Feed, Dual Range	ALL		E-7	E-8	
F9-3.0	Wheel Balancing Stand	ALL		E-9	E-10	
F9-6.1	Work Lamp	ALL		E-11	E-12	

NEW DRG.
S.W. 2-16-70
REVISIONS
S.W. 10-18-72



FI-118

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MODEL FIRST MACH. LAST MACH.
DH618 292-70101 292-76218

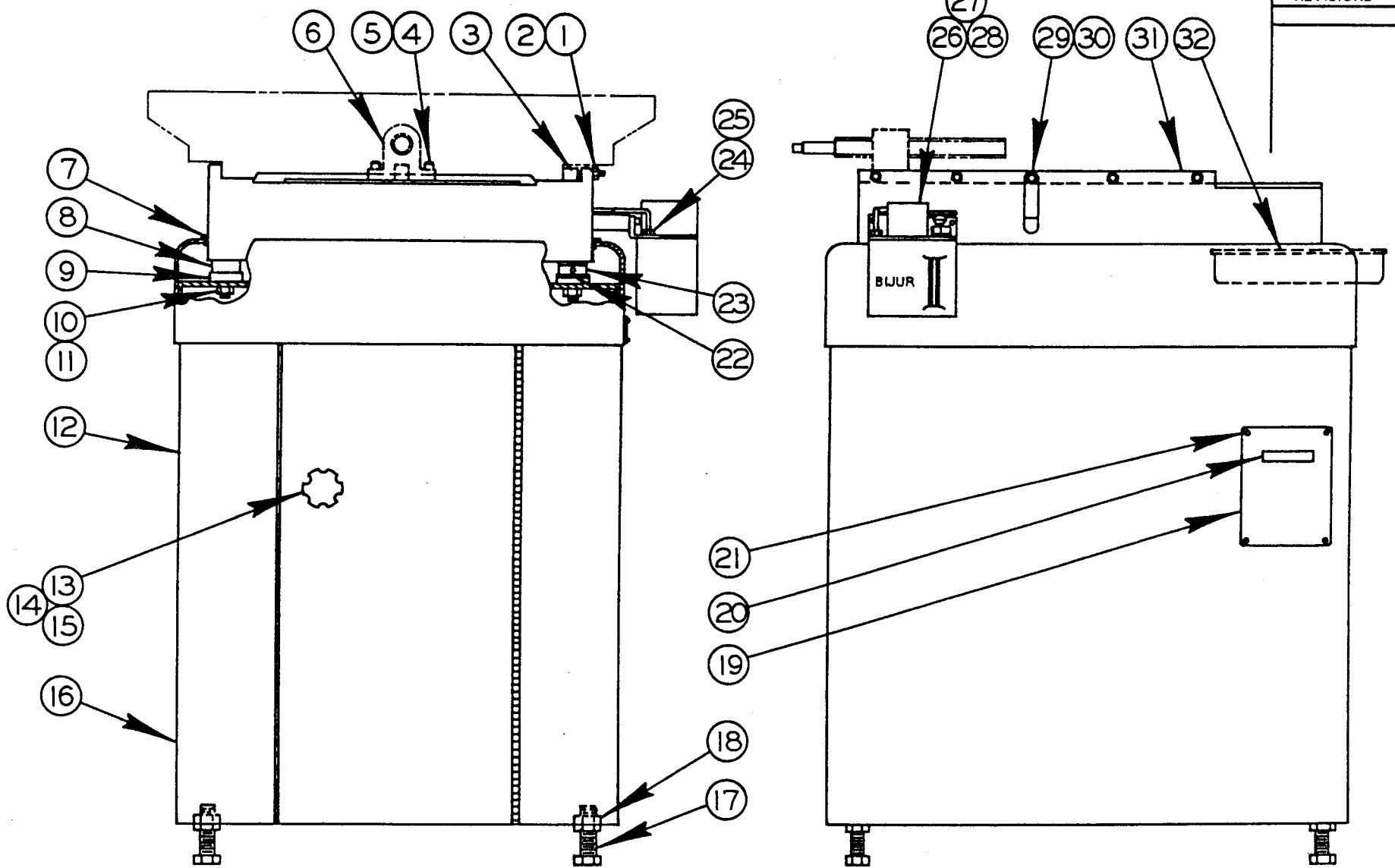
FINAL ASSEMBLY

CODE NO. F1-1.8

FINAL ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	500805	Final Assembly	
1	198295	. Screw, Soc. Hd. Cap 1/2-13NC x 1 1/2.....	4
2	35-445	. Dowel	2
3	4122	. "O" Ring.....	1
4	53283	. Spindle Assembly(See Detail).....	1
5	6191	. Spindle Lock.....	1
6	6190	. Spindle Lock.....	1
7	199264	. Washer 3/8 Std.....	1
8	198054	. Screw, Hex. Hd. Mach. 3/8-16NC x 3	1
9	402087	. L.H. Table Guard (Dry Grind).....	1
10	198366	. Screw, Button Hd. Cap 1/4-20NC x 3/8.....	2
11	54324	. Wheel Guard Line Assembly(See Detail)	1
12	54232	. Column Assembly(See Detail).....	1
13	500803	. Table Assembly(See Detail).....	1
14	500015	. Saddle Assembly (See Detail).....	1
15	100490	. Plate.....	1
16	198913	. Screw, Phillips Rd. Hd. Mach. #10-24NC x 3/8 .	2
17	402609	. Base Assembly(See Detail).....	1
18	54269	. Electrical Assembly(Manual Starter).....	Use
	400088	. Electrical Assembly (Magnetic Starter)	One
19	102420	. Decal.....	1
20	16487	. Tool Pad	1
	129273	. Escutcheon(Patent No's) (Not shown)	1

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REVISIONS



FI-3.1

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BASE ASSEMBLY

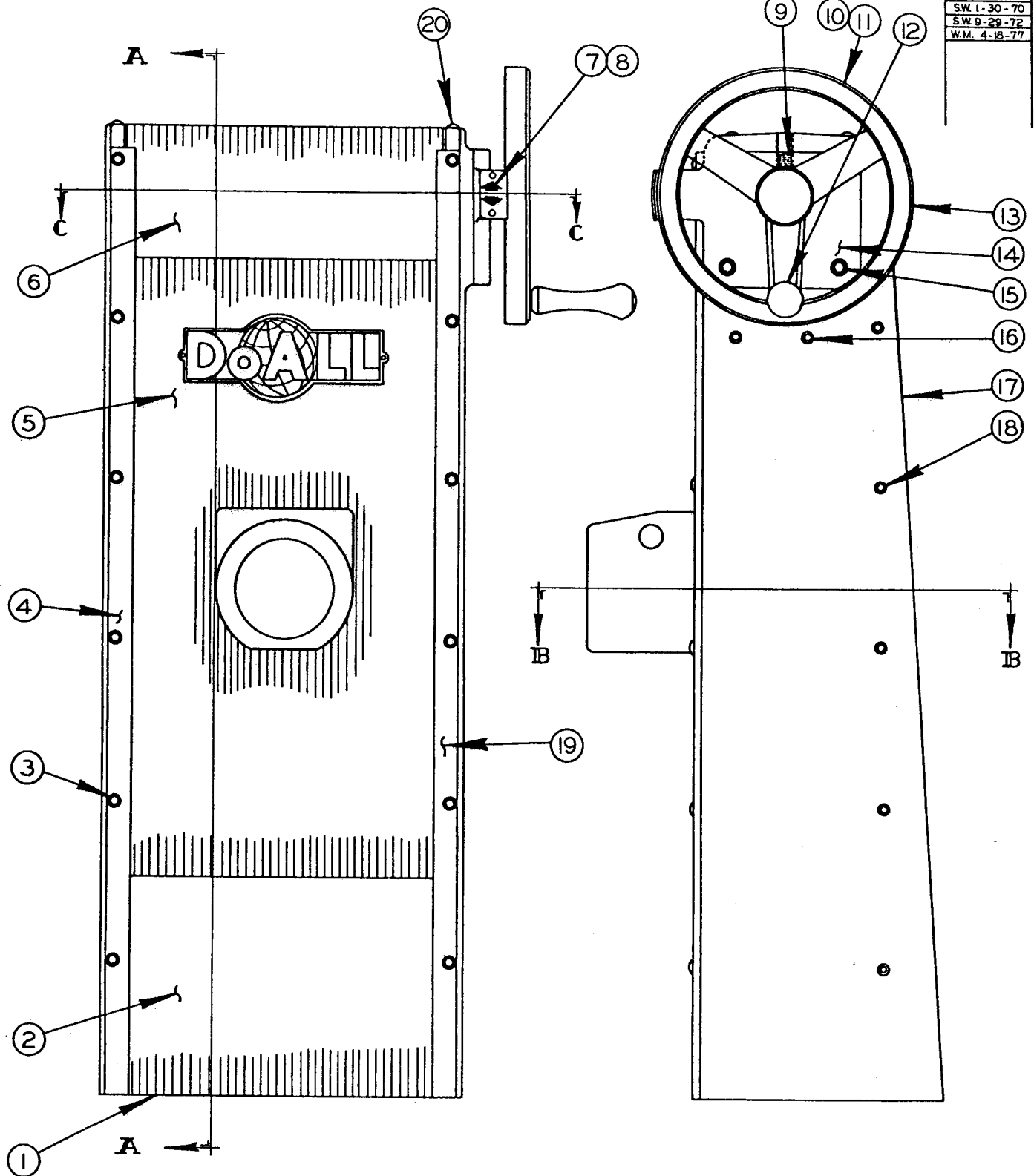
MODEL FIRST MACH. LAST MACH.
 DH618 292-70101 292-76218

CODE NO. F1-3.1

BASE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	402609	Base Assembly	
1	198440	. Screw, Soc. Hd. Set 5/16-18NC x 1 Fl. Pt.....	4
2	199123	. Nut, Hex. Jam 5/16-18NC.....	5
3	27890	. Gib.....	1
4	198261	. Screw, Soc. Hd. Cap 5/16-18NC x 1 1/4.....	4
5	1993	. Washer, Lock 5/16 Hi-Collar.....	4
6	14-115185	. Dowel Pin.....	2
7	Stk #020	. Channel Tubing.....	A.R.
8	18751	. Spacer.....	3
9	18863	. Fabreeka Pad.....	4
10	198443	. Screw, Soc. Hd. Set 5/16-18NC x 2 1/2	4
11	199122	. Nut, Hex. 5/16-18NC.....	4
12	40498	. Base Cabinet Assembly	1
13	14910	. . Knob.....	1
14	199122	. . Nut, Hex. 5/16-18NC.....	1
15	199323	. . Washer, Lock 5/16 Std.....	1
16	50318	. . Base Cabinet Weldment	1
17	198111	. . Screw, Hex. Hd. Cap 3/4-10NC x 2 1/2.....	4
18	199139	. . Nut, Hex 3/4-10NC.....	4
19	27052	. Data Plate.....	1
20	4804	. Label.....	1
21	199396	. Screw, Rd. Hd. Drive #2 x 3/16 Pk. Type "U"	4
22	18750	. Washer.....	1
23	18749	. Adjustable Spacer	1
24	14825	. Compression Bushing	1
25	14446	. Compression Sleeve.....	1
26	402344	. Lubricator.....	1
27	198249	. Screw, Soc. Hd. Cap 1/4-20NC x 2 1/2	2
28	116320	. Spacer.....	1
29	103384	. Saddle Lock Handle	1
30	198441	. Screw, Soc. Hd. Set 5/16-18NC x 1 1/4.....	1
31	45103	. Base Assembly.....	1
32	27899	. Pan.....	1

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SW. 1-30-70
SW. 9-29-72
W.M. 4-18-77



COLUMN ASSEMBLY

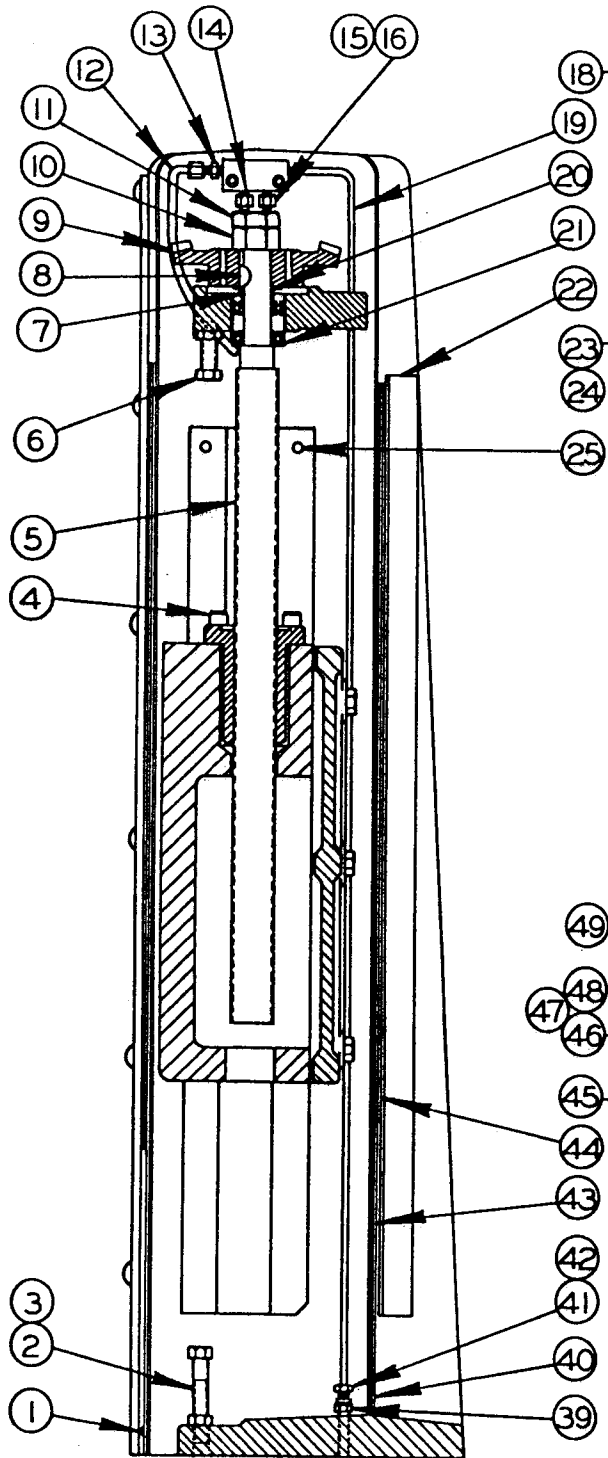
MODEL	FIRST MACH.	LAST MACH.
DH-612	138-59101	138-763745
DH618-7	292-70101	292-76218

CODE NO. FI-2.2

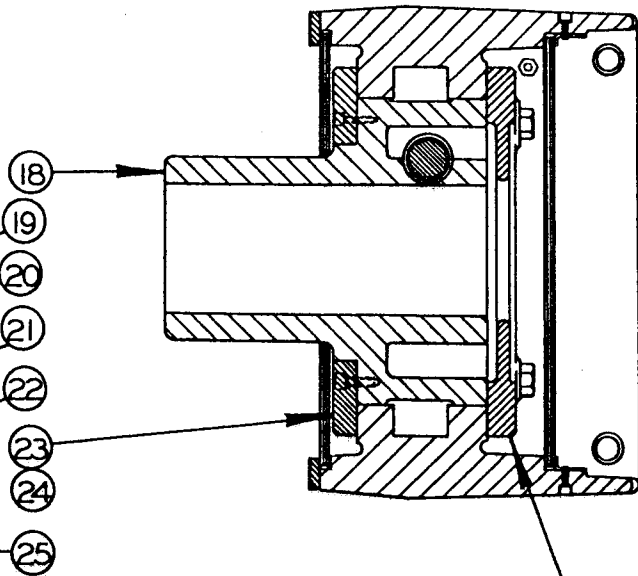
COLUMN ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	501422	Column Assembly (DH-612)	
Ref.	54232	Column Assembly (DH618-7)	
1	27893	. Guard.....	1
2	44954	. Guard.....	1
3	198219	. Screw, Soc. Fl. Hd. Cap #10-24NC x 3/8	12
4	27892	. Strip.....	1
5	28084	. Guard Sub-Assembly.....	1
6	44953	. Guard.....	1
7	18585	. Escutcheon.....	1
8	198910	. Screw, Phillips Rd. Hd. Mach. #6-32NC x 1/4.	2
9	198449	. Screw, Set 3/8-16 x 1/2.....	1
10	4235	. Roll Pin.....	1
11	101542	. Handwheel Sub-Assembly.....	1
12	34-05513	. . Handle.....	1
13	48702	. . Handwheel.....	1
14	28616	. Bracket.....	1
15	198258	. Screw, Soc. Hd. Cap 5/16-18NC x 3/4.....	4
16	11794	. Plug, Soc. Pipe.....	4
17	54059	. Column.....	1
18	199455	. Screw, Self Tap #8-3/4"Type F".....	10
19	300207	. Strip	1
20	198913	. Screw, Rd. Hd. Phillips #10-24NC x 3/8 Plated..	4

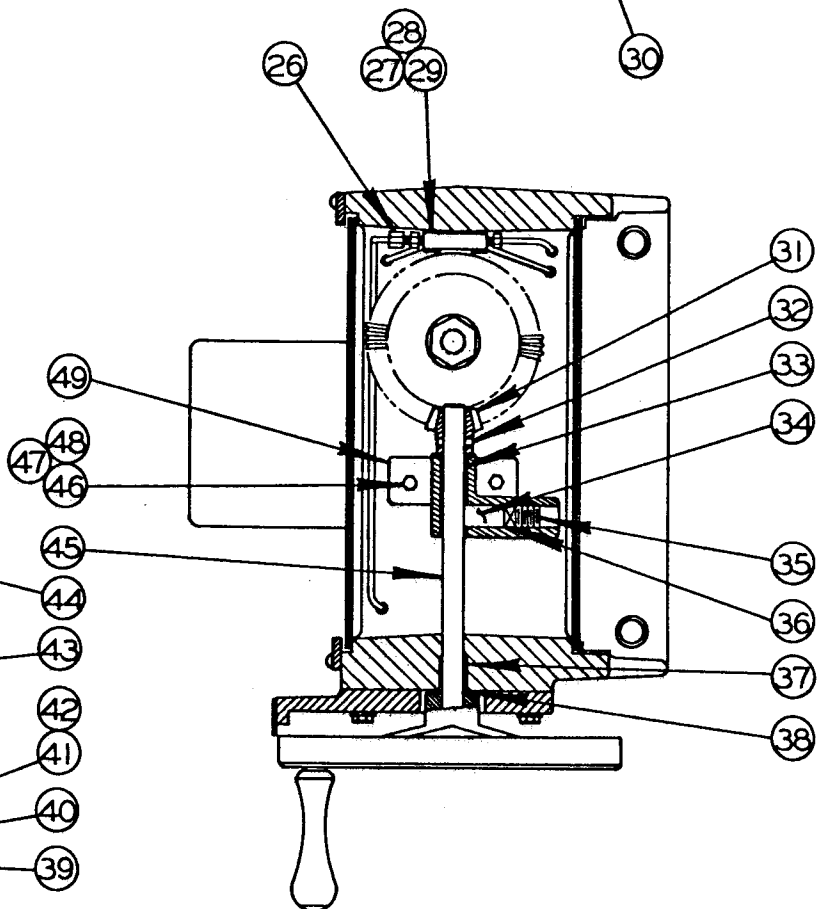
REVISED AND REDRAWN
S.W. 2-2-70
S.W. 9-29-72
W.M. 4-18-77



SECTION A-A



SECTION IB-IB



SECTION C-C

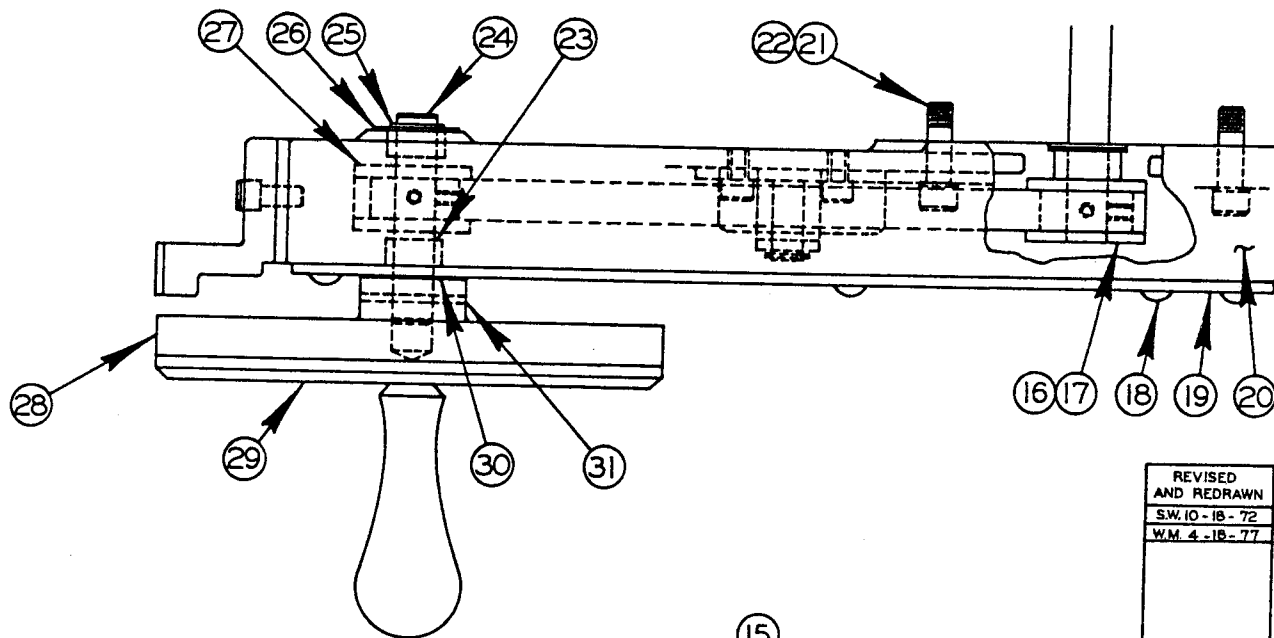
MODEL	FIRST MACH.	LAST MACH.
DH-612	138-59101	138-763745
DH618-7	292-70101	292-76218

COLUMN ASSEMBLY

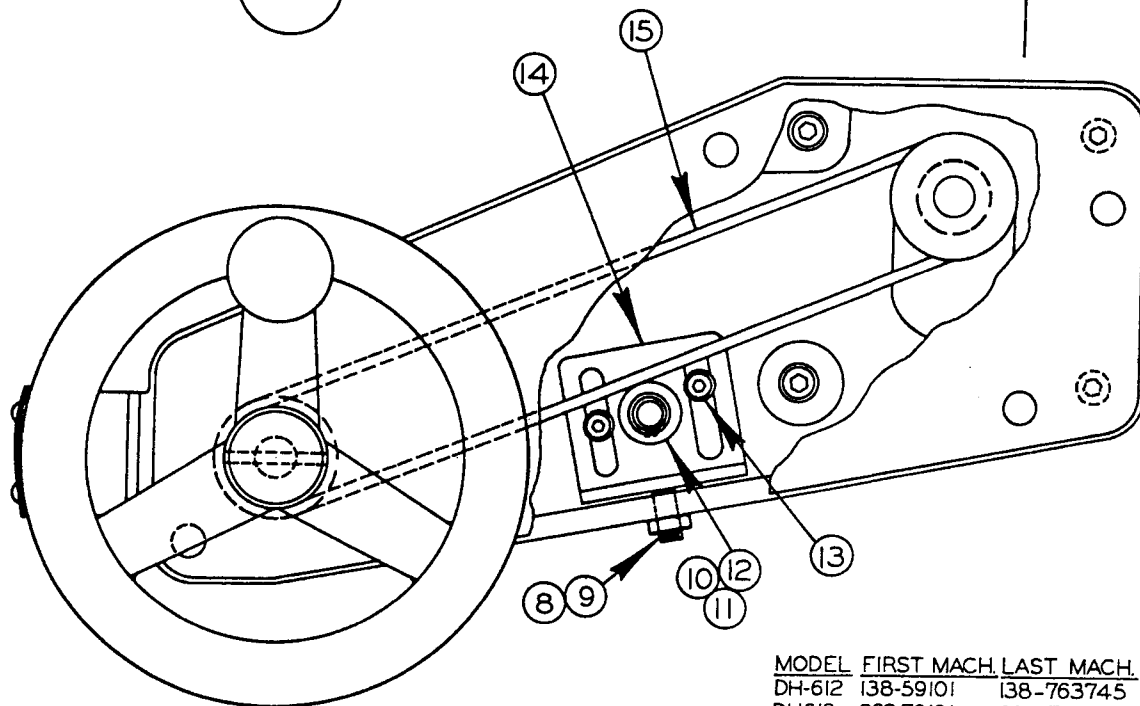
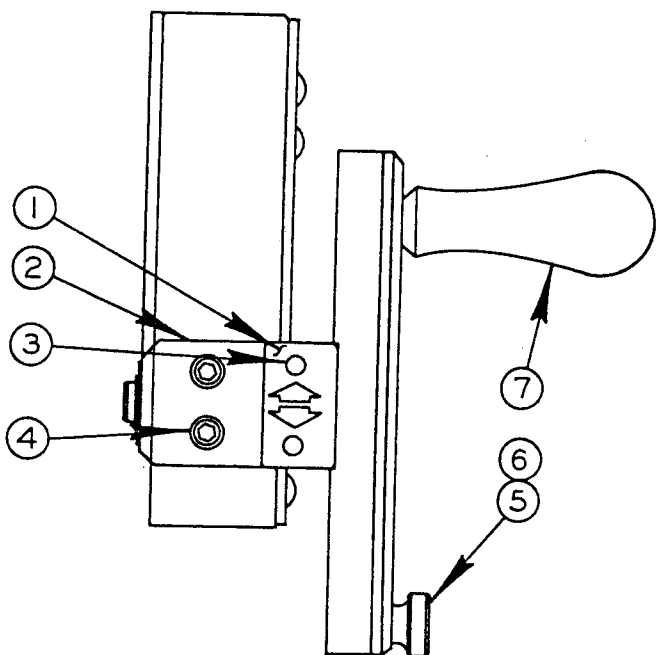
COLUMN ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
*** Ref.	501422	Column Assembly (Continued) (DH-612)	
Ref.	54232	Column Assembly(Continued) (DH618-7)	
1	198691	. Screw, Fil. Hd. Mach. #8-32NC x 1/4.....	4
2	198051	. Screw, Hex. Hd. Cap 3/8-16NC x 2 1/4.....	1
3	199127	. Nut, Hex. Jam 3/8-16NC Std.....	2
4	198260	. Screw, Soc. Hd. Cap 5/16-18 NC x 1.....	4
5	36472	. Screw, and Nut Sub-Assembly.....	1
6	198281	. Screw, Soc. Hd. Cap 3/8-16NC x 1 1/2.....	1
7	18459	. Collar.....	1
8	14-06519	. Key.....	1
*9	117158	. Gear.....	1
10	199137	. Nut, Hex. 5/8-18NF Std.....	1
11	199138	. Nut, Hex. Jam 5/8-18NF Std.....	1
***12	37540	. Tube.....	1
***13	109926	. Meter Unit.....	2
***14	37541	. Tube.....	1
***15	14827	. Meter Unit.....	1
***16	118806	. Tube.....	1
**18	56940	. Slide.....	1
***19	Stk # 208	. Steel Tubing 5/32 O.D.....	A.R.
20	133667-133669	. Shim.....	A.R.
21	4310	. Bearing.....	2
22	28655	. Strip.....	2
23	29270	. PLate.....	2
24	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8.....	8
25	116561	. Wick.....	8
***26	14447	. Compression Nut.....	3
***27	117164	. Junction.....	1
***28	198011	. Screw, Hex. Hd. Mach. 1/4-20NC x 1 1/4.....	2
***29	199321	. Washer, Lock 1/4 Std.....	2
30	44956	. Slide Cover.....	1
*31	17818	. Gear.....	1
32	4230	. Roll Pin.....	1
33	100408	. Bearing.....	1
34	17822	. Plug.....	1
35	198464	. Screw, Soc. Hd. Set 1/2-13NC x 3/8.....	1
36	35-7804	. Spring.....	1
37	100707	. Bearing.....	1
38	35-1204	. Shim.....	A.R.
***39	14680	. Thru Adaptor.....	1
40	27897	. Guard.....	1
***41	14446	. Compression Sleeve.....	5
***42	14825	. Compression Bushing.....	2
43	44955	. Guard.....	1
44	27896	. Guard.....	1
45	17823	. Shaft.....	1
46	199332	. Washer, Lock 3/8 Std.....	2
47	133653-133655	. Shim.....	1
48	198048	. Screw, Hex. Hd. Cap 3/8-16NC x 1 1/2.....	8
49	27942	. Shaft Support Lock.....	1
	Stk # .060	. Felt Wipers (Not Shown).....	A.R.

*Note: Between Serial #138-59121 and 138-59212 on DH612 117158 was 18806 and 17818 was 18805. To Replace gears order both 117158 and 17818.
 **Note: Before Serial #138-641680 on DH612, slide was 54060.
 ***Note: Triple Starred Items used only on Ass'y #54232 (DH618-7).



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S.W. 10-18-72
W.M. 4-18-77



COLUMN
HANDWHEEL EXTENSION ASSEMBLY

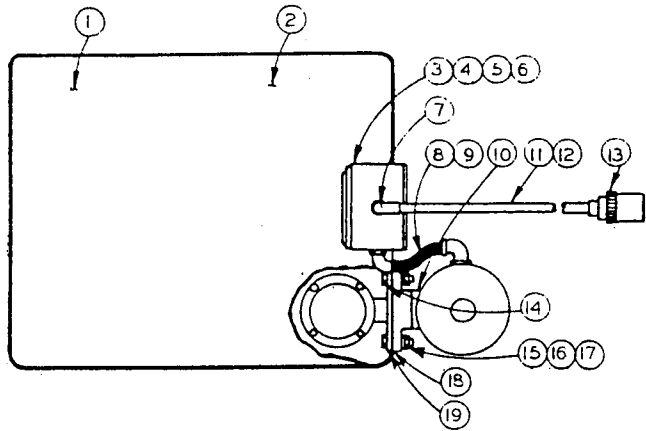
MODEL	FIRST MACH.	LAST MACH.
DH-612	138-59101	138-763745
DH618	292-70101	292-76218
L618-7	247-68101	247-69112
L618-12	246-68101	246-75172

CODE NO. F8-5.8

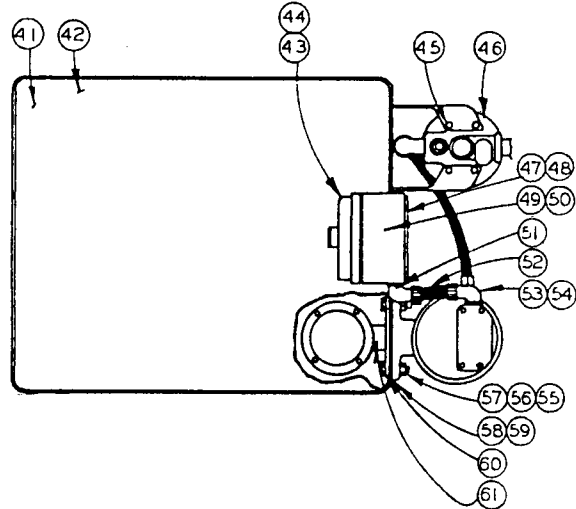
HANDWHEEL EXTENSION ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	54551	Handwheel Extension Assembly	
1	18585	. Escutcheon.....	1
2	28524	. Bracket.....	1
3	198910	. Screw, Phillips Slot Rd. Hd. Cap #6-32NC x 1/4	2
4	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2.....	2
5	18889	. Knob.....	1
6	18171	. Clamp Stud.....	1
7	34-05513	. Handle.....	1
8	199114	. Nut, Jam 1/4-20NC Std	1
9	198426	. Screw, Soc. Set 1/4-20NC x 5/8.....	Use
	Comm.	. Screw, Soc. Set 1/4-20NC x 7/8.....	
	Comm.	. Screw, Soc. Set 1/4-20NC x 1 1/8	One
10	100082	. Bearing.....	1
11	2271	. Spacer.....	1
12	3276	. Retaining Ring	1
13	198235	. Screw, Soc. Hd. Cap 1/4-20NC x 3/8.....	2
14	100022	. Slide Assembly.....	1
15	100004	. Timing Belt.....	1
16	100006	. Pulley.....	1
17	198410	. Screw, Soc. Hd. Set #10-24NC x 1/4	4
18	198913	. Screw, Phillips Rd. Hd. Slot #10-24NC x 3/8	4
19	45327	. Cover.....	1
20	54588	. Housing.....	1
21	198440	. Screw, Soc. Hd. Cap 5/16-18NC x 1	4
22	199323	. Washer, Lock 5/16 Std.....	4
23	17806	. Bearing.....	2
24	100005	. Shaft.....	1
25	35-9613	. Snap Ring.....	1
26	35-1204B	. Shim.....	3
27	17815	. Pulley.....	1
28	28047	. Ring.....	1
29	28042	. Handwheel.....	1
30	35-1204C	. Shim.....	1
31	6-25529	. Taper Pin.....	1

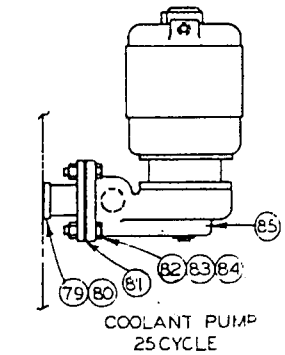
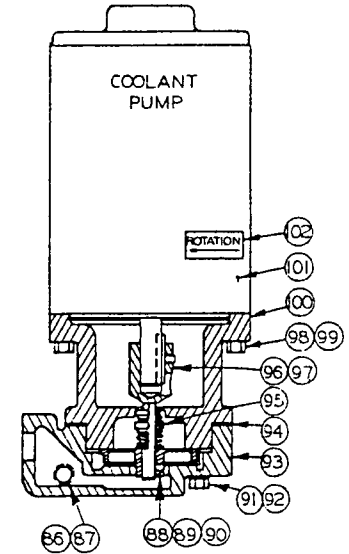
REVISIONS



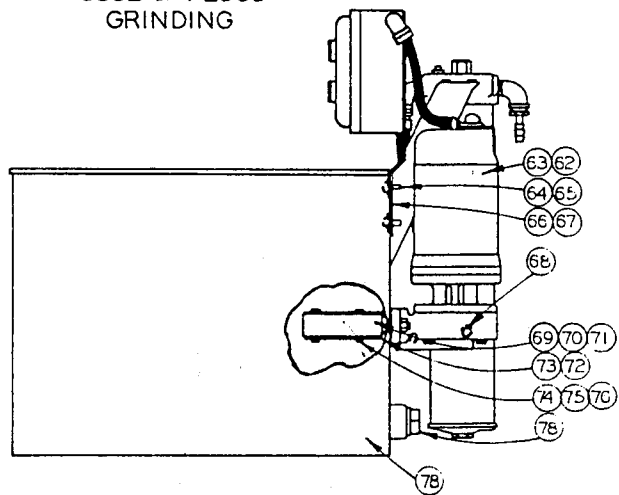
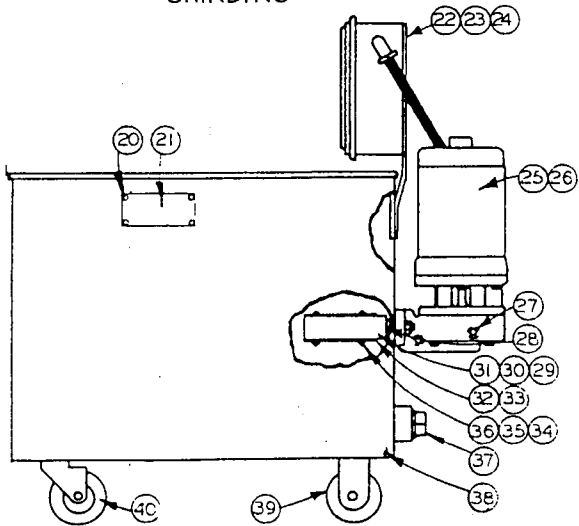
FLOOD GRINDING



COMBINATION COOL & FLOOD GRINDING



COOLANT PUMP 25 CYCLE



COOLANT PUMP & TANK ASSEMBLIES

MODEL FIRSTMACH LASTMACH
DH-612 138-59101 138-753745

F3-1.6

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TITLE

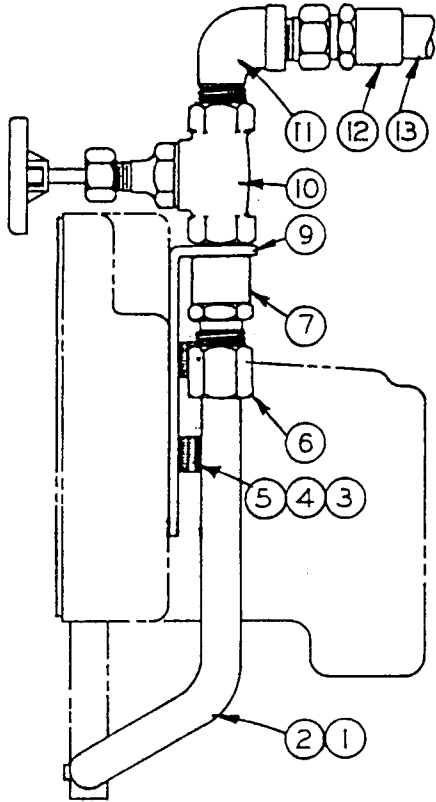
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COOLANT PUMP & TANK ASSEMBLIES

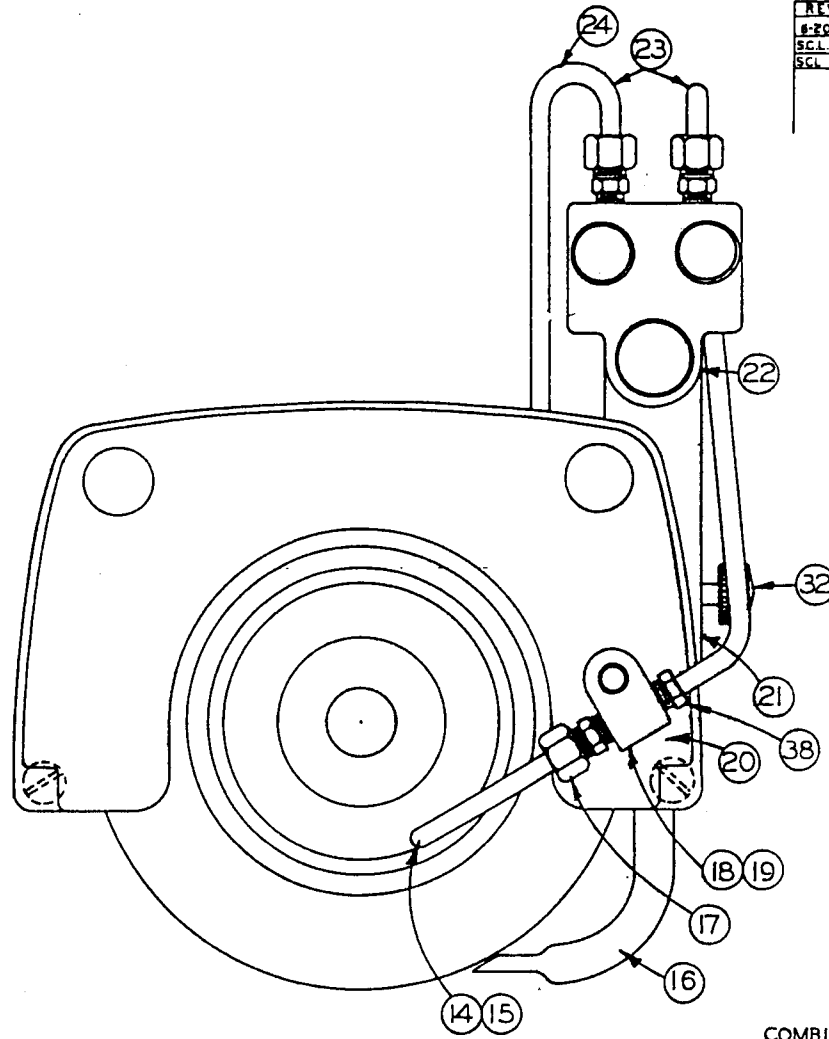
INDEX NO.	PART NO.	DESCRIPTION	UNITS				INDEX NO.	PART NO.	DESCRIPTION	UNITS				
			PER ASS'Y.	1	2	3				4	PER ASS'Y.	1	2	3
1	42306	Cover Assembly	1				53	15142	Cord Grip Connector	2				
2	43099	Coolant Pump & Tank Assembly	1				54	11112	Connector Seal Assembly	2				
3	19504CC	. Starter Switch	1				55	198048	. Hex Hd. Cap Scr. 3/8-16 x 1-1/2	2				
4	Comm.	. Heater Coil	2				56	199332	. Lockwasher 3/8 Std.	2				
5	Comm.	. Screw #10-32 NF	4				57	199126	. Hex. Nut 3/8-16	2				
6	19571-B	. Terminal Clips	3				58	1980	. Gasket	1				
7	19508-E	. 90° Connector	1				59	1536	. O-Ring	2				
8	Comm.	. Conduit Sealrite #519	1				60	6920	. Plate	1				
9	10585	. Connector	2				61	1912	. Pipe Nipple	1				
10	35-7957	. Pipe Plug	1				62	41878	. Coolant Pump Ass'y. (see viewA)	1				
11	7635	. Terminal Clips	8				63	13884	. Coolant Pump Ass'y. (25 cycle)					
12	12731	. Electric Cord	1						(see view B)	1				
13	3618	. Electric Plug	1				64	198890	. Rd. Hd. Mach. Scr. 1/4-20 x 1/4	2				
14	1536	. O-Ring (between tank & gasket)	2				65	14-115205	Washer	2				
15	199332	. Lockwasher 3/8 Std. Med.	2				66	9526	. Data Plate	1				
16	199126	. Hex Nut 3/8-16	2				67		. Drive Screw #4 PK x 3/16	4				
17	198048	. Hex Hd. Cap Scr. 3/8-16 x 1-1/2	2				68	9667	. Hose Nipple	3				
18	1980	. Gasket	1				69	20921	. Coolant Strainer Assembly	1				
19	6920	. Plate	1				70	198410	. Skt. Hd. Set Scr. #10-24 x 1/4	1				
20	199398	. Drive Screw #4x3/16 P-K Type "U"	4				71	3620	. Strainer Body	1				
21	9526	. Data Plate	1				72	3808	. Retaining Ring	2				
22	14-115205	. Washer	2				73	3619	. Screen	2				
23	198005	. Hex. Hd. Cap Scr. 1/4-20 x 3/8	2				74	198879	. Rd. Hd. Mach. Scr. #10-24 x 1-3/4	4				
24	25417	. Switch Bracket	1				75	199111	. Hex Nut #10-24 Std.	4				
25	41878	. Coolant Pump Ass'y. (see view A)	1				76	199258	. Washer #10	4				
26	13884	. Coolant Pump Ass'y. (25 cycle) (see view B)	1				77	2899	. Pipe Plug	1				
27	8212	. Hose Nipple	1				78	54909	. Coolant Tank Ass'y. (use on 45726 only)	1				
28	1912	. Pipe Nipple	1					54538	. Coolant Tank Ass'y. (use on 45324 only)	1				
29	20921	. Coolant Strainer Assembly	1				79	13884	. Coolant Pump Assembly (25 cycle)	1				
30	3620	. Strainer Body	1				80	25695	. Adaptor Assembly	1				
31	198440	. Skt. Hd. Set Scr. #10-24 x 1/4	1				81	26202	. Gasket	1				
32	3808	. Retaining Ring	2				82	198067	. Hex Hd. Mach. Scr. 1/2-13 x 1-1/2	4				
33	3619	. Screen	2				83	199327	. Lockwasher 1/2 Std.	4				
34	198879	. Rd. Hd. Mach. Scr. #10-24 x 1-3/4	4				84	199131	. Hex Nut 1/2-13NC.	4				
35	199111	. Hex Nut #10-24 Std.	4				85	26255	. Coolant Pump	1				
36	199258	. Washer #10	4				86	41878	. Coolant Pump Assembly	1				
37	2899	. Pipe Plug	1				87	35-7957	. Pipe Plug	1				
38	52570	. Coolant Tank Assembly	1				88	2929	. Impeller	use one				
39	22487	. Fixed Caster	2				89	25106	. Impeller (25V)	one				
40	22486	. Swivel Caster	2				90	198417	. Skt. Set Scr. #10-32 NF x 1/4	1				
41	42306	Cover Assembly	1				91	198033	. Hex. Hd. Cap Scr. 5/16-18 x 2	4				
42	45324	Coolant Pump & Tank Assembly W/Filter	1				92	199323	. Lockwasher 5/16	4				
	45726	Coolant Pump & Tank Assembly W/O Filter	1				93	40449	. Impeller Housing	1				
43	16984	. Starter Manual	use one				94	2928	. Gasket	1				
44	28541	. Magnetic Starter Assembly	one				95	2930	. Roto Flex Seal	1				
45	198006	. Hex. Hd. Mach. Scr. 1/4-20 x 1/2 (use on 45324 only)	4				96	7110	. Stub Shaft	1				
*46	6860	. Coolant Filter (use on 45324 only)	1				97	Comm.	. Skt. Set Screw	1				
47	198865	. Rd. Hd. Mach. Scr. #10-24 x 1/4	3				98	198047	. Hex Hd. Cap Scr. 3/8-16 x 1-1/4	4				
48	28456	. Bracket	1				99	199332	. Lockwasher 3/8	4				
49	11687	. Wire Terminals	3				100	41886	. Adapter	1				
50	103764	. Marr Caps	3				101	7040	. Motor	1				
51	19543	. Bond Nut	3				102	4655	. Rotation Decal	1				
52	Comm.	. Electric Cord	1											

* NOTE: Use #6860A Replacement Element for item 46, Coolant Filter #6860.

F4-2.2

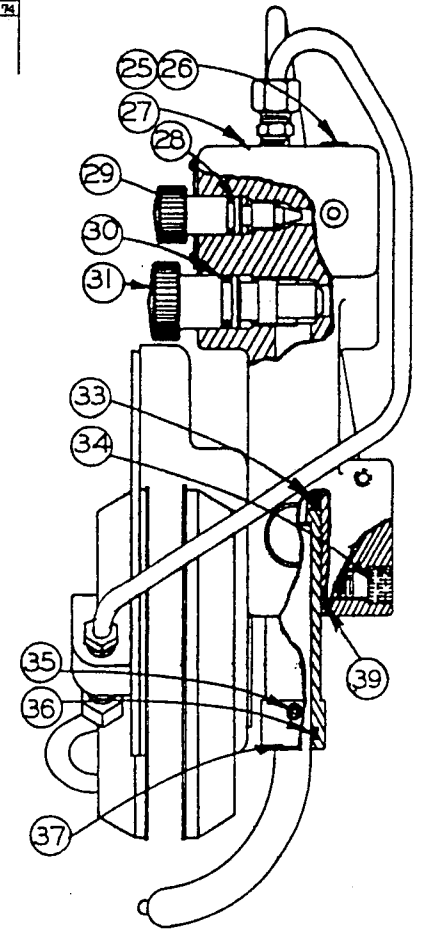


FLOOD GRIND ASS'Y



COMBINATION
COOL & FLOOD GRIND ASS'Y

REVISIONS	
8-20-68	BW
5-1-73	T-25-73
9-18-74	



FLOOD & COOL GRIND ASSEMBLIES

MODEL	FIRST MACH	LAST MACH
DH-612	138-59101	138-763745
DH-618	292-70101	292-72137

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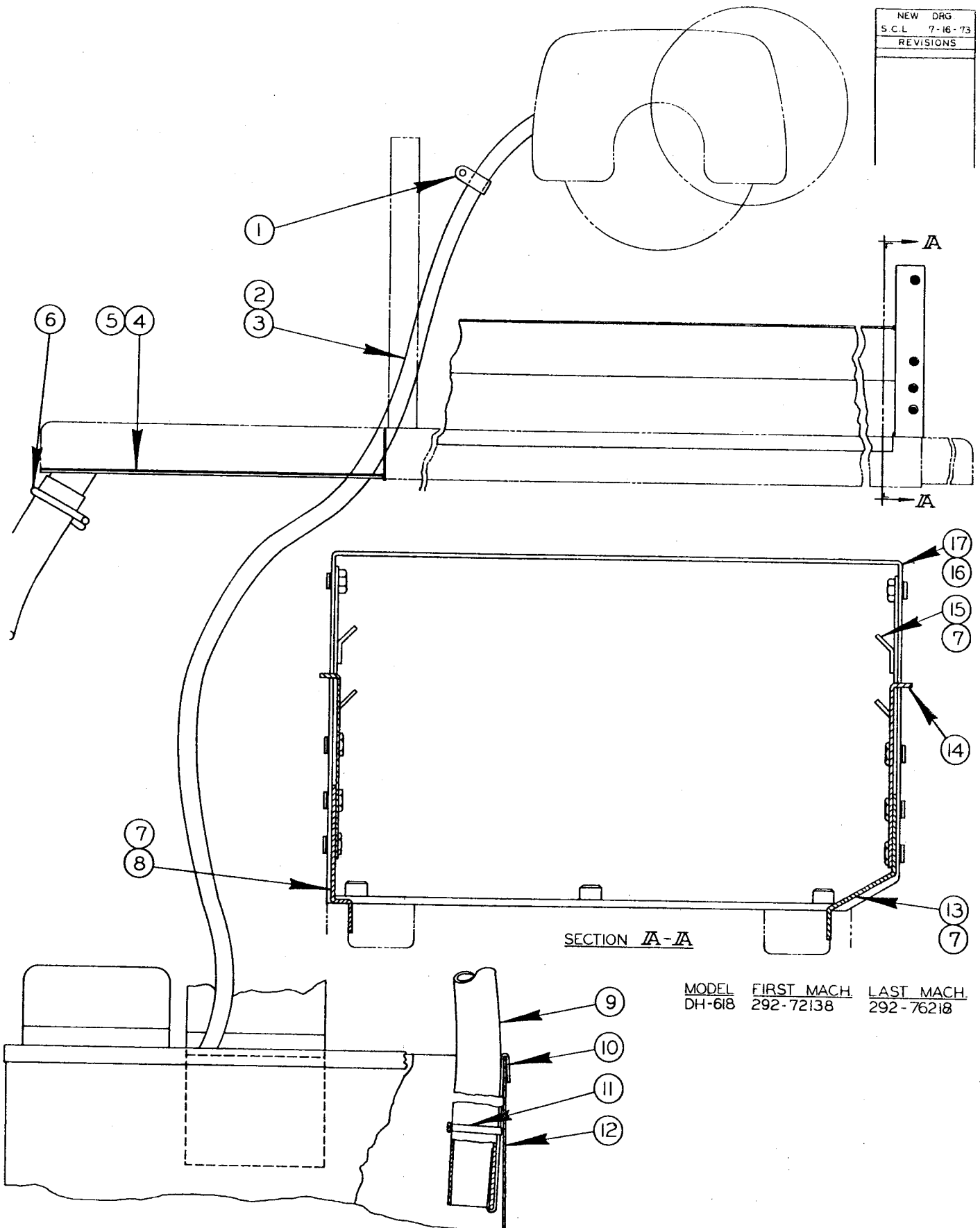
FLOOD AND COOL GRINDING ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
1	54591	Flood Grind Assembly W/O Casters.....	1
	55245	Flood Grind Assembly W/Casters	1
2	18756	. Nozzle	1
3	199262	. Washer, Flat 5/16 Std.	2
4	198256	. Screw, Soc. Hd. Cap 5/16-18NC x 1/2	2
5	199323	. Washer, Lock 5/16 Std.	2
6	16540	. Female Connector	1
7	14-03507	. Close Nipple	1
9	100091	. Bracket	1
10	35-853	. Globe Valve.....	1
11	17-13521	. 90° Street Elbow	1
12	2004	. Hose Connector	2
13	18251	. Neoprene Hose.....	1
14	54278	Flood & Cool Grind Assembly W/Filter W/O Casters	1
	55244	Flood & Cool Grind Assembly W/O Filter W/Casters	1
15	129584	. Tube.....	1
16	18756	. Nozzle	1
17	6-23509	. Male Connector	2
18	100024	. Junction Block	1
19	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8	1
20	28163	. Cover.....	1
21	18843	. Tube (Not Shown)	1
22	17-13521	. 90° Street Elbow	1
23	Stk. #221	. Tubing 3/8 O.D.	A.R.
24	6-23510	. Compression Bushing	1
25	28455	. Valve Assembly	1
26	Comm.	. . Soc. Hd. Pipe Plug 1/2-27NPT	2
27	45187	. . Valve Body.....	1
28	35-9176	. . O-Ring	2
29	111940	. . Valve Stem Assembly	2
30	35-8727	. . O-Ring	1
31	111934	. . Valve Stem Assembly	1
32	18304	. . Thumb Screw	1
33	35-9176	. . O-Ring.....	1
34	198264	. Screw, Soc. Hd. Cap 5/16-18NC x 2.....	2
35	198405	. Screw, Soc. Hd. Set #8-32NC x 3/16.....	2
36	35-8727	. O-Ring	1
37	18841	. Adapter	1
38	16001	. Barbed Insert.....	3
39	108116	. 90° Barbed Insert	1

Following Items Not Shown:

54636	. Splash Guard Assembly	1
18182	. Hose Clamp.....	1
5114	. Nipple.....	1
18181	. Neoprene Hose.....	1
41714	. Coolant Tank and Pump Assembly	1
55428	. 6 x 12 Grinder Table Assembly (Wet Grind)	1

NEW DRG
S.C.L. 7-16-73
REVISIONS



SECTION A-A

MODEL	FIRST MACH.	LAST MACH.
DH-618	292-72138	292-76218

FLOOD AND COOL GRIND ASSEMBLY

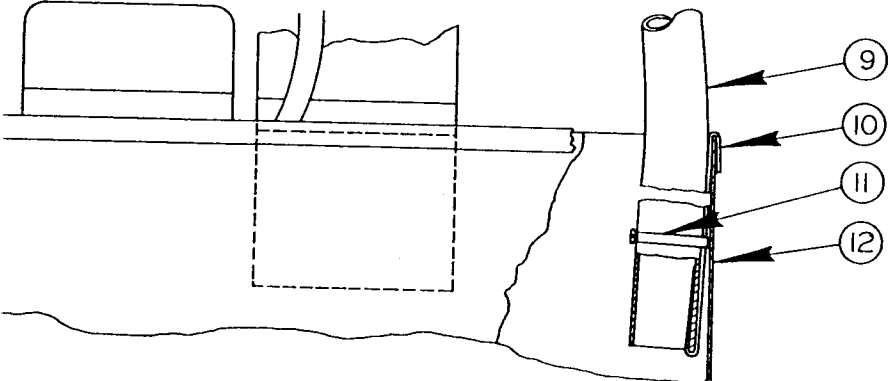
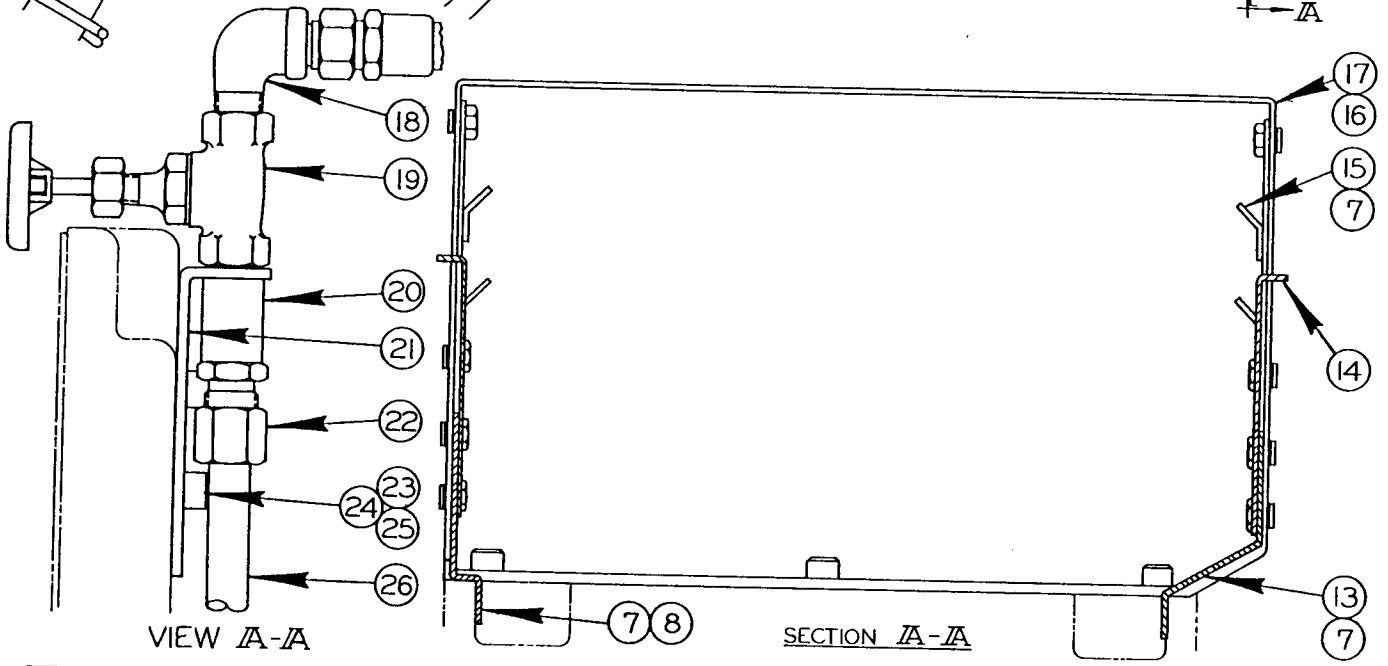
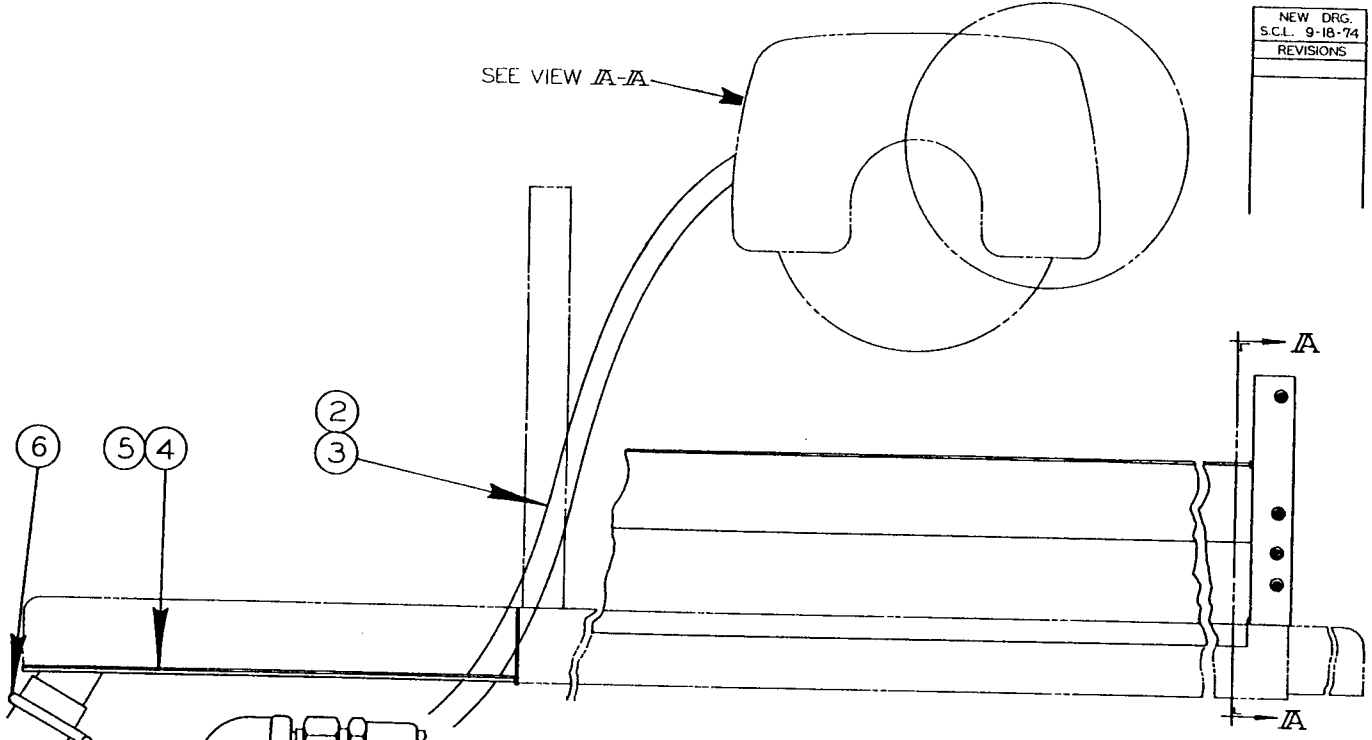
CODE NO. F4-2.4

FLOOD AND COOL GRIND ASSEMBLY
(Continued)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	500856	Flood and Cool Grind Assembly	
1	16559	. Hose Clamp.....	1
2	2004	. Hose Connector	2
3	18251	. Neoprene Hose.....	1
4	39760	. Cover and Spout Weldment.....	1
5	198346	. Screw, Button Hd. Cap #8-32NC x 3/8	8
6	112876	. Hose Clamp.....	1
7	198346	. Screw, Button Hd. Cap #8-32NC x 1/4	16
8	402575	. Rear Fixed Splash Guard.....	1
9	117239	. Hose.....	1
10	301992	. Hanger	1
11	107637	. Cable Tie	1
12	41714	. Coolant Tank and Pump Ass'y (See Detail).....	1
13	402608	. Front Fixed Splash Guard.....	1
14	402607	. Adj. Splash Guard.....	2
15	123254	. Hanger Weldment.....	4
16	402449	. R. H. Table Guard Weldment	1
17	198235	. Screw, Soc. Hd. Cap 1/4-20NC x 3/8	3

NEW DRG.
S.C.L. 9-18-74
REVISIONS

SEE VIEW A-A



MODEL	FIRST MACH.	LAST MACH.
DH-618	292-72138	292-76218

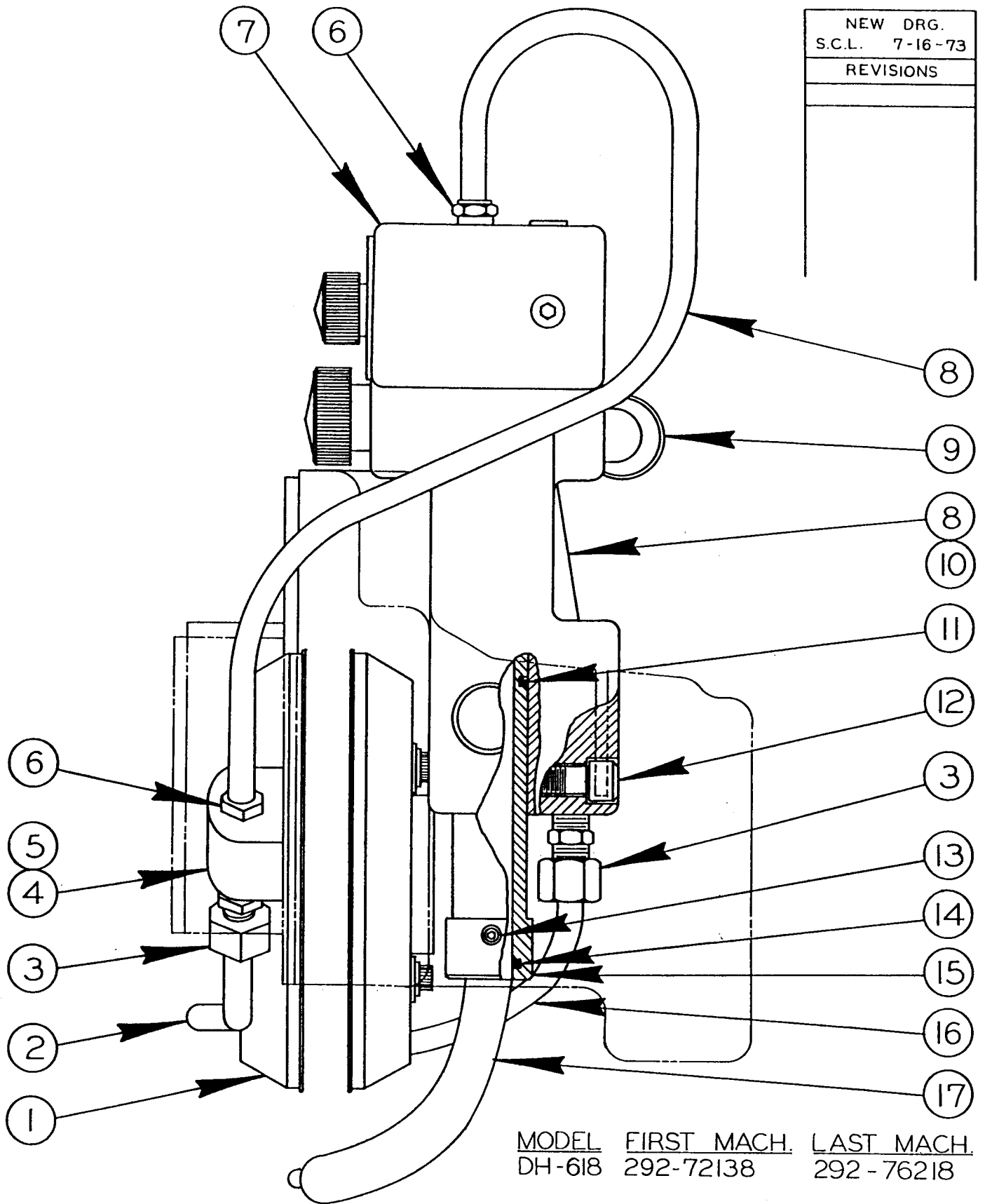
FLOOD GRIND ATTACHMENT
F4-2.4.1

CODE NO. F4-2.4.1

FLOOD GRIND ATTACHMENT

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	500855	Flood Grind Attachment	
2	2004	. Hose Connector.....	2
3	18251	. Neoprene Hose.....	1
4	39760	. Cover and Spout Weldment.....	1
5	198346	. Screw, Button Hd. Cap #8-32NC x 3/8.....	8
6	112876	. Hose Clamp.....	1
7	Comm.	. Screw, Button Hd. Cap #8-32NC x 1/4.....	16
8	402575	. Rear Fixed Splash Guard.....	1
9	117239	. Hose.....	1
10	301992	. Hanger.....	1
11	107637	. Cable Tie.....	1
12	41714	. Coolant Tank and Pump Assembly (See Detail).....	1
13	402608	. Front Fixed Splash Guard.....	1
14	402607	. Adj. Splash Guard.....	2
15	123254	. Hanger Weldment.....	4
16	402449	. R.H. Table Guard Weldment.....	1
17	198366	. Screw, Button Hd. Cap 1/4-20NC x 3/8.....	3
18	17-13521	. 90° Street Elbow.....	1
19	35-853	. Globe Valve.....	1
20	14-03507	. Close Nipple.....	1
21	100091	. Bracket.....	1
22	16540	. Female Connector.....	1
23	199262	. Washer 5/16 Std.	2
24	198256	. Screw, Soc. Hd. Cap 5/16-18NC x 1/2.....	2
25	199323	. Washer, Lock 5/16 Std.	2
26	18756	. Nozzle.....	1

NEW DRG.
S.C.L. 7-16-73
REVISIONS



MODEL FIRST MACH. LAST MACH.
 DH-618 292-72138 292-76218

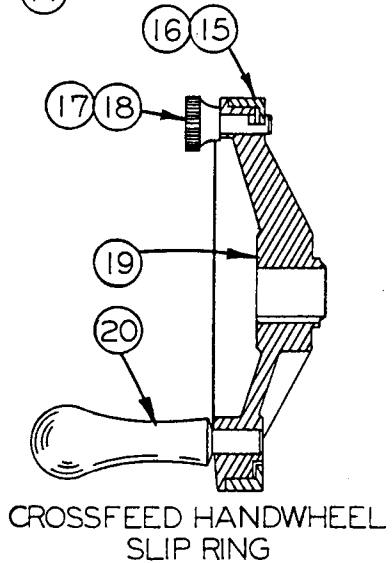
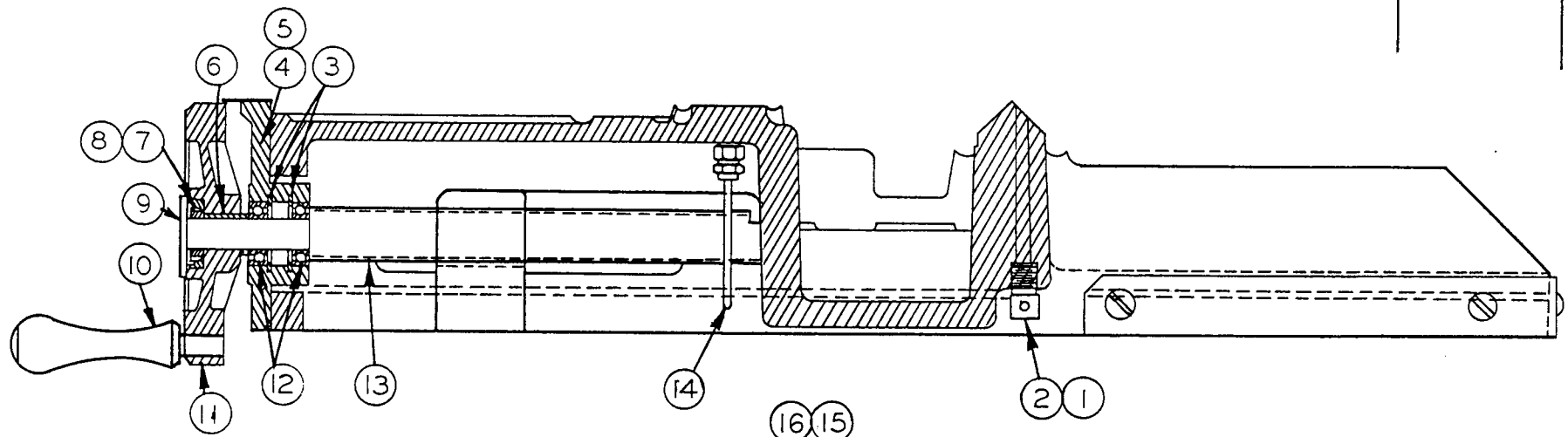
FLOOD AND COOL GRIND
 ASSEMBLY

CODE NO. F4-2.3

FLOOD AND COOL GRIND ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	500856	Flood and Grind Assembly	
1	129665	. Wheel Adapter Assembly.....	1
2	129584	. Tube.....	1
3	6-23509	. Pipe Union	2
4	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8.	1
5	100024	. Junction Block.....	1
6	16001	. Barbed Insert.....	3
7	28455	. Valve Assembly	1
8	Stk #221	. Tubing.....	A.R.
9	17-13521	. 90° Street Elbow	1
10	108116	. 90° Barbed Insert	1
11	35-9176	. O-Ring.....	1
12	198264	. Screw, Soc. Hd. Cap 5/16-18NC x 2	2
13	198405	. Screw, Soc. Hd. Set #8-32NC x 3/16.....	1
14	35-8727	. O-Ring.....	1
15	18841	. Adaptor	1
16	18843	. Tube.....	1
17	18756	. Nozzle.....	1
Following items not shown:			
	41714	. Coolant Tank and Pump Ass'y (Not Shown)(See Detail)....	1

REVISIONS
SW. 10-25-72
SW. 4-27-73
S.C.L. 9-20-74
W.M. 4-18-77



CROSSFEED HANDWHEEL
SLIP RING

CROSSFEED SCREW

MODEL FIRSTMACH. LASTMACH.
DH-612 138-621036 138-763745
MTM-612 184-62116 184-71158

F6-6.6 G5-6.1

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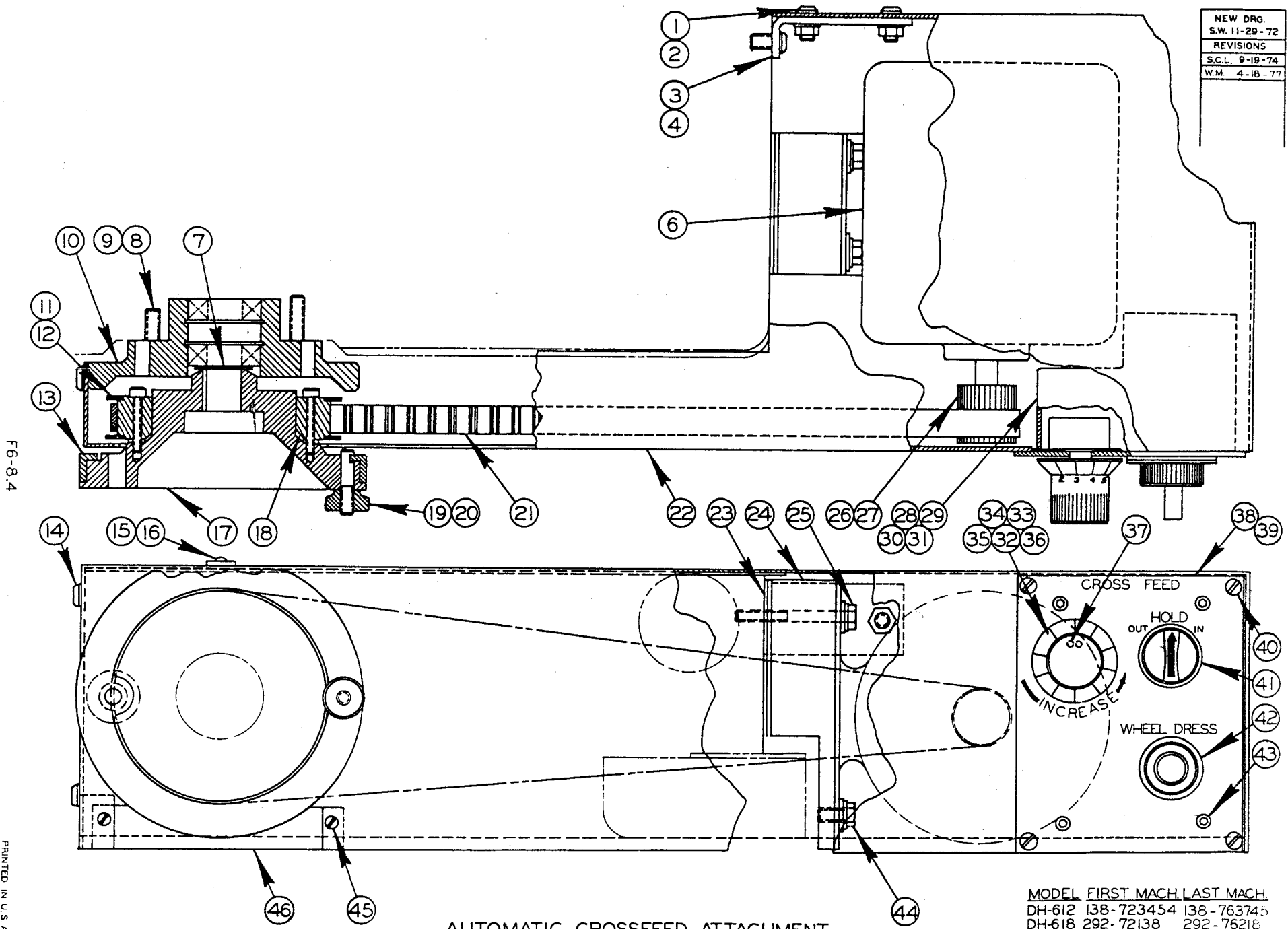
CODE NO. G5-6.1
F6-6.6

CROSSFEED SCREW

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	54622	Saddle Assembly.	
1	14825	. Compression Bushing.....	8
2	18198	. Elbow Adapter.....	4
3	1530	. Retaining Ring.....	2
4	27956	. Housing	1
5	35-516	. Dowel Pin	2
6	13076	. Plain Key.....	1
7	17-05507	. Bearing Locknut	1
8	17-05508	. Bearing Lockwasher	1
9	18233	. Button Plug	1
10	101451	. Handle	1
11	27541	. Crossfeed Handwheel	1
12	18888	. Bearing	2
13	300428	. Crossfeed Screw and Nut Assembly (See Note)	1
14	300500	. Tube	1
15	18170	. Handwheel Assembly Crossfeed-Slip Ring (Optional) ..	1
16	28046	. Ring	1
17	18889	. Knob.....	1
18	18171	. Clamp Stud	1
19	28045	. Handwheel.....	1
20	101451	. Handle	1

NOTE: 300428 Was 29518 Before Serial Numbers
 DH 612 - 138-713409
 DH 618-7 - 292-71113
 MTM 612 - 184-62116
 300428 Has 2 Mounting Holes - 2 Dowels
 29518 Has 4 Mounting Holes - 2 Dowels

NEW DRG.
S.W. 11-29-72
REVISIONS
S.C.L. 9-19-74
W.M. 4-18-77



F6-8.4

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AUTOMATIC CROSSFEED ATTACHMENT

MODEL FIRST MACH. LAST MACH.
 DH-612 138-723454 138-763745
 DH-618 292-72138 292-76218

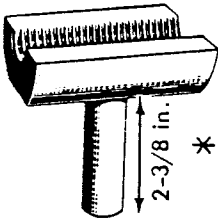
AUTOMATIC CROSSFEED ATTACHMENT

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	501444	Automatic Crossfeed Attachment	
1	198349	. Screw, Button Hd. Cap 1/4-20NC x 1/2.....	4
2	199321	. Washer, Lock 1/4 Std.	6
3	127918	. Hanger.....	1
4	199115	. Nut, Hex. 1/4-20NC.....	2
5	198244	. Screw, Soc. Hd. Cap 1/4-20NC x 1 1/4	1
6	124863	. Torque Motor	1
7	133667-133669	. Shim.....	A.R.
8	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1	3
9	199260	. Washer, 1/4 S.A.E. Std.	8
10	403443	. Housing.....	1
11	124862	. Timing Belt Pulley	1
12	198216	. Screw, Soc. Hd. Cap #8-32NC x 1	4
13	28046	. Crossfeed Ring	1
14	Comm.	. Screw, Button Hd. Cap #10-24NC x 5/16.....	2
15	115896	. Pointer.....	1
16	198735	. Screw, Fl. Hd. Mach. #4-40NC x 3/16	2
17	403138	. Crossfeed Handwheel.....	1
18	16566	. Spacer	4
19	18889	. Knob	1
20	18171	. Clamp Stud	1
21	127917	. Timing Belt	1
22	501732	. Cover.....	1
23	127919	. Shim.....	A.R.
24	300942	. Motor Mount.....	1
25	198014	. Screw, Hex. Hd. Cap 1/4-20NC x 2.....	2
26	128603	. Pulley	1
27	198405	. Screw, Soc. Set #8-32NC x 3/16.....	1
28	404246	. Crossfeed Control Assembly	1
	128601	. . Box Weldment Assembly	1
29	5154	. . Cord Grip Connector	1
30	Stk. #801	. . Connector Cord #16-8	A.R.
31	130089	. . Push-On Terminal Connector.....	15
32	128970	. . Knob	1
33	198402	. . Screw, Soc. Set #6-32NC x 1/4	1
34	4223	. . Roll Pin.....	1
35	128304	. . Potentiometer.....	1
36	122619	. . Hex. Nut	1
37	4227	. . Roll Pin.....	1
38	128572	. . Gasket	1
39	129579	. . Panel.....	1
40	Comm.	. Screw, Binding Hd. Self Tap #6 x 1/4 Type Z	4
41	130084	. . Selector Switch.....	1
42	130085	. . Pushbutton Switch	1
43	Comm.	. . Screw, Button Soc. Hd. Cap #6-32NC x 3/8.....	4
44	198006	. Screw, Hex. Hd. Cap 1/4-20NC x 1/2.....	2
45	199425	. Screw, Pan Hd. Sheet Metal #4-40NC x 1/4	2
46	128702	. Insert Weldment Assembly.....	1

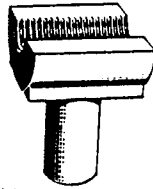
Following Items Not Shown:

301503	. Switch Assembly.....	1
20911	. Hydraulic Hose.....	2
8084R	. Orifice	1
120311	. 90° Swivel Adapter Union	2
14-14528	. Close Nipple	3
35-5800	. Tee.....	2
14-115195	. Male Connector	1
9520	. 45° Male Elbow	1
35-2456	. Reducer Bushing	2
198002	. Screw, Hex. Hd. Mach. #10-24NC x 3/8	2
1927	. Spacer	1

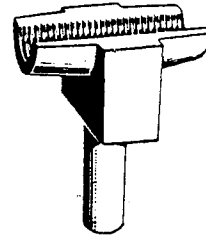
CROSS FEED SCREW NUTS



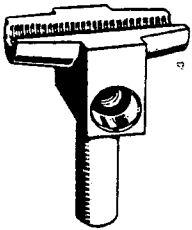
14-434 Standard Thread
14-682 Metric Thread
1 in. - 10 R.H. Acme Thread
First used in 1944 through to
the last G-10



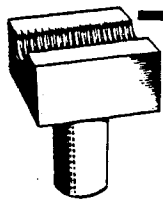
14-683 Metric Thread
26205 Metric Thread
2.5 MM Acme Thread
Serial No. same as G-1 Grinders
that use #14-117



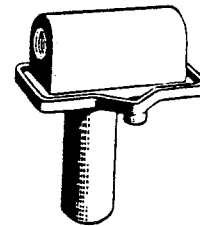
14-11212 Standard Thread
1 in. - 10 R.H. Acme Thread
G-7 & G-10 First Ser. #4215255
Last Ser. #43813



14-11211 Standard Thread
3/4 in. - 10 R.H. Acme Thread
G-7 & G-10 First Ser. #4215082
Last Ser. #4215254



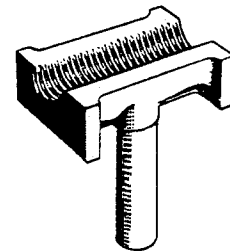
14-117 Standard Thread
1 in. - 10 R.H. Acme Thread
G-1 First Ser. #44100
Last Ser. #50785
D6-1-3, D8-1-3, D10-1-3



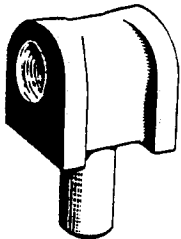
14-02206 Standard Thread
3/4 in. - 10 R.H. Acme Thread
G-6 & G-7 First Ser. #4002005
Last Ser. #4214254



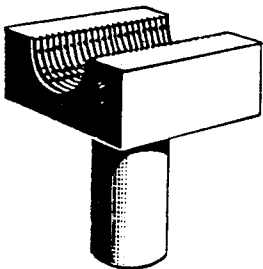
40539 Standard Thread
21140 Metric Thread
1 in. - 10 R.H. Acme Thread
G-1 First Ser. #50786
Last Ser. #521431
G-10 First Ser. #501430
Last Ser. #531840
D-6 First Ser. #39-52101
Last Ser. #39-53338
D-8 First Ser. #38-52101
Last Ser. #38-53308
D-10 First Ser. #40-52101
Last Ser. #40-53154



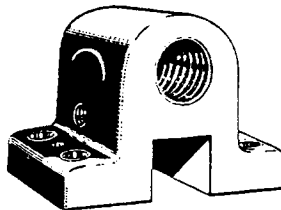
14-434 Standard Thread
(Old Style G-10)
Before 1944
1 in. - 10 R.H. Acme Thread



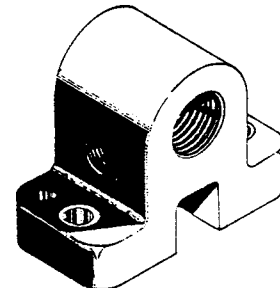
14-707 Standard Thread
1 in. - 10 R.H. Acme Thread
GH-1



27805 Half Nut
27806 Metric
1-1/4 in. Acme Thread



27821 Full Nut
1 in. - 10 Acme Thread
DH-612 - First Ser. No.138-69101
Last Ser. No.138-713408
DH-618 - First Ser. No.292-70101
Last Ser. No.292-71112
MTM-612 - First Ser. No.184-60101
Last Ser. No.184-62115



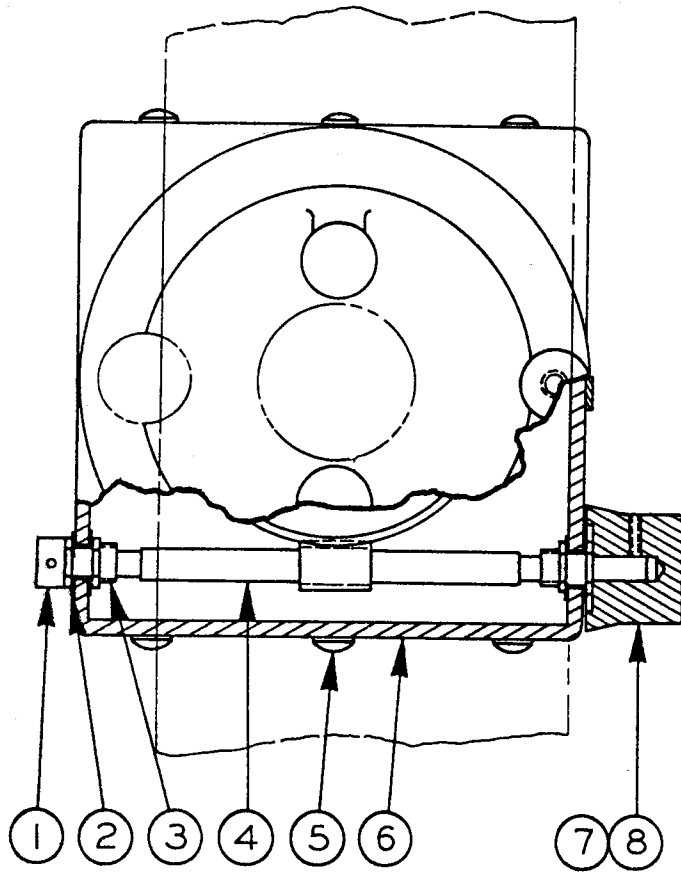
300427 Full Nut
1 in. - 10 Acme Thread
DH-612 - First Ser. No.138-713409
DH-618 - First Ser. No.292-71113
MTM-612 - First Ser. No.184-62116

Before 5-28-46
* 2-3/8 in. was 2-3/4 in.

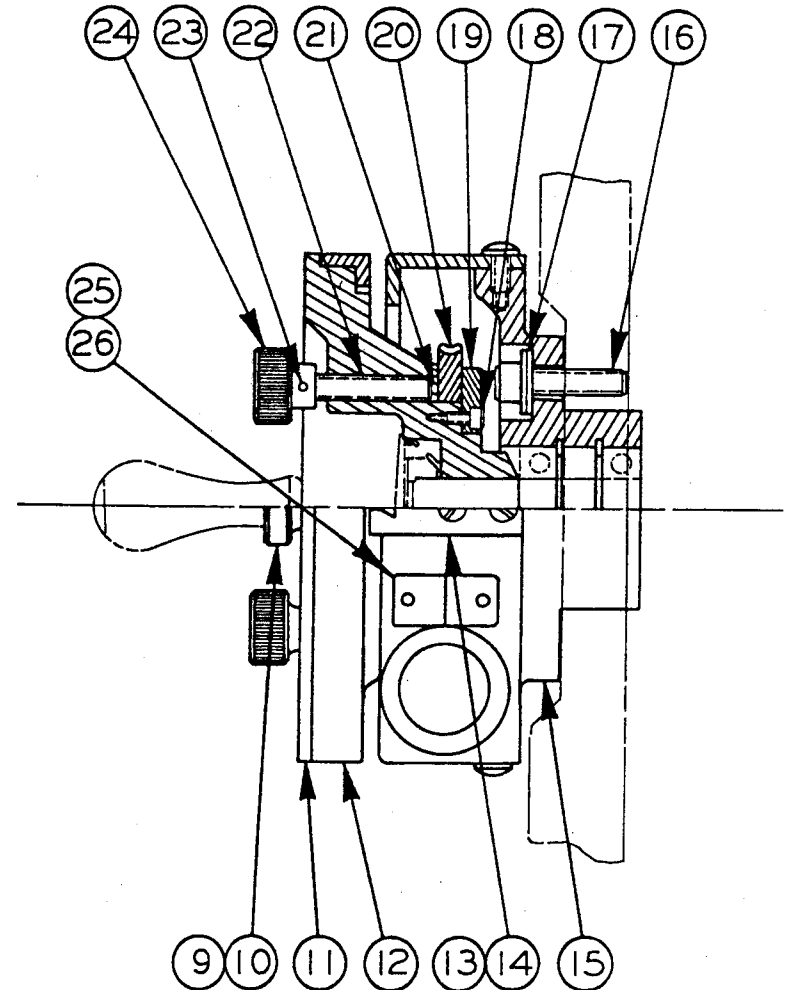
F6-7.0 G5-6.4

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F6-8.2



REVISIONS
6-20-68 BW
S.W. 1-23-70
W.M. 4-18-77



MODEL	FIRST MACH.	LAST MACH.
DH-612	138-621036	138-763745
L618-7	247-68101	247-69112
L618-12	246-68101	246-75172
DH618-7	292-70101	292-76218

VERNIER CROSSFEED ATTACHMENT ASSEMBLY

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CODE NO. F6-3.2

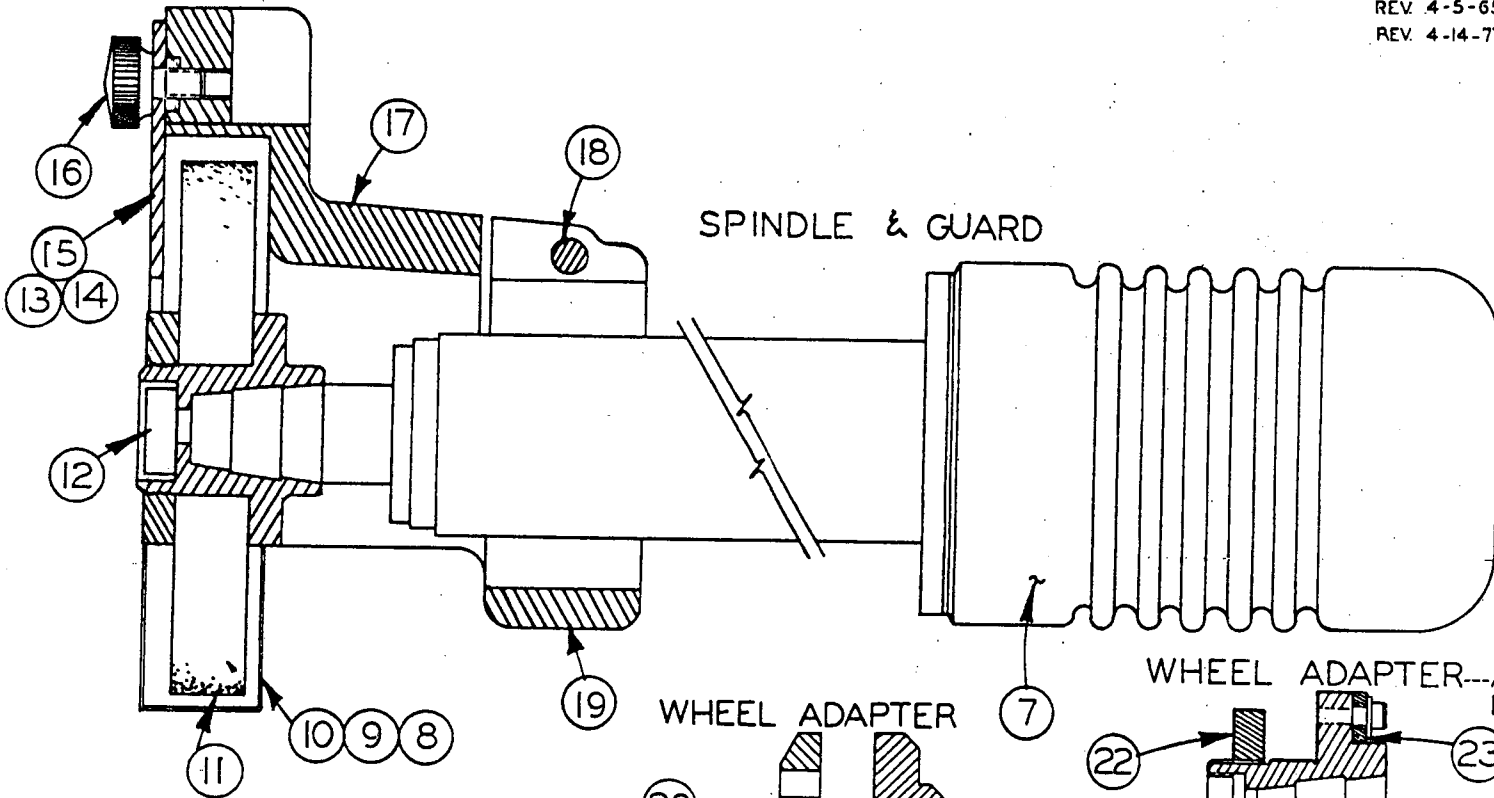
VERNIER CROSSFEED ATTACHMENT ASSY.

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	49323	Vernier Crossfeed Attachment Assembly	
1	4190	. Shaft Collar.....	1
2	6-04312	. Spacer.....	4
3	115894	. Panel Bearing.....	2
4	36441	. Worm.....	1
5	198321	. Screw, Button Hd. Cap #10-24NC x 3/8.....	6
6	49320	. Shroud Weldment.....	1
7	114291	. Vernier Knob.....	1
8	198418	. Screw, Soc. Set #10-32NC x 3/8.....	1
9	18889	. Knob.....	1
10	18171	. Clamp Stud.....	1
11	49311	. Crossfeed Handwheel.....	1
12	28046	. Crossfeed Ring.....	1
13	115896	. Pointer.....	1
14	198735	. Screw, Ft. Hd. Mach. #4-40NC x 3/16.....	2
15	49317	. Housing.....	1
16	198242	. Screw, Soc. Hd. Cap 1/4-20NC x 1.....	4
17	199260	. Washer 1/4 SAE Std.....	8
18	198331	. Screw, Soc. Hd. Cap #6-32NC x 1/4.....	6
19	36096	. Guide Ring.....	1
20	36440	. Worm Gear.....	1
21	103779	. Plug.....	2
22	114289	. Screw.....	2
23	4212	. Roll Pin.....	2
24	114290	. Knob.....	2
25	111236	. Indicator.....	1
26	199396	. Screw, Rd. Hd. Drive #2 x 3/16 Type "V".....	2

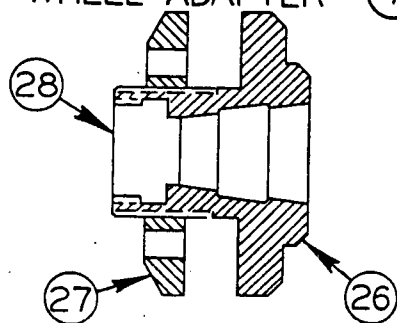
ADH. 3-25-63

REV. 4-5-65

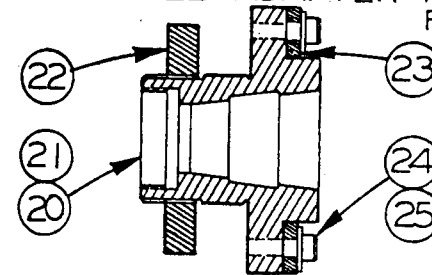
REV. 4-14-77



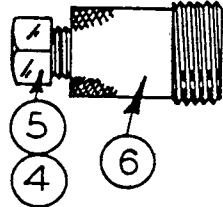
WHEEL ADAPTER



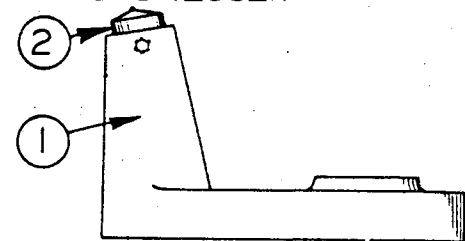
WHEEL ADAPTER---ATTACH FOR FLOOD GRINDING.



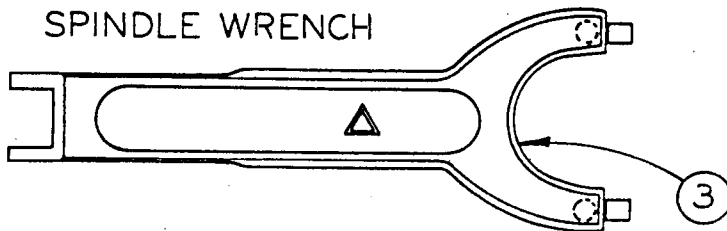
WHEEL PULLER



DIAMOND DRESSER



SPINDLE WRENCH



MODEL FIRST MACH LAST MACH
 DH-612 138-621145 138-763745

F4-3.5.1

PRINTED IN USA

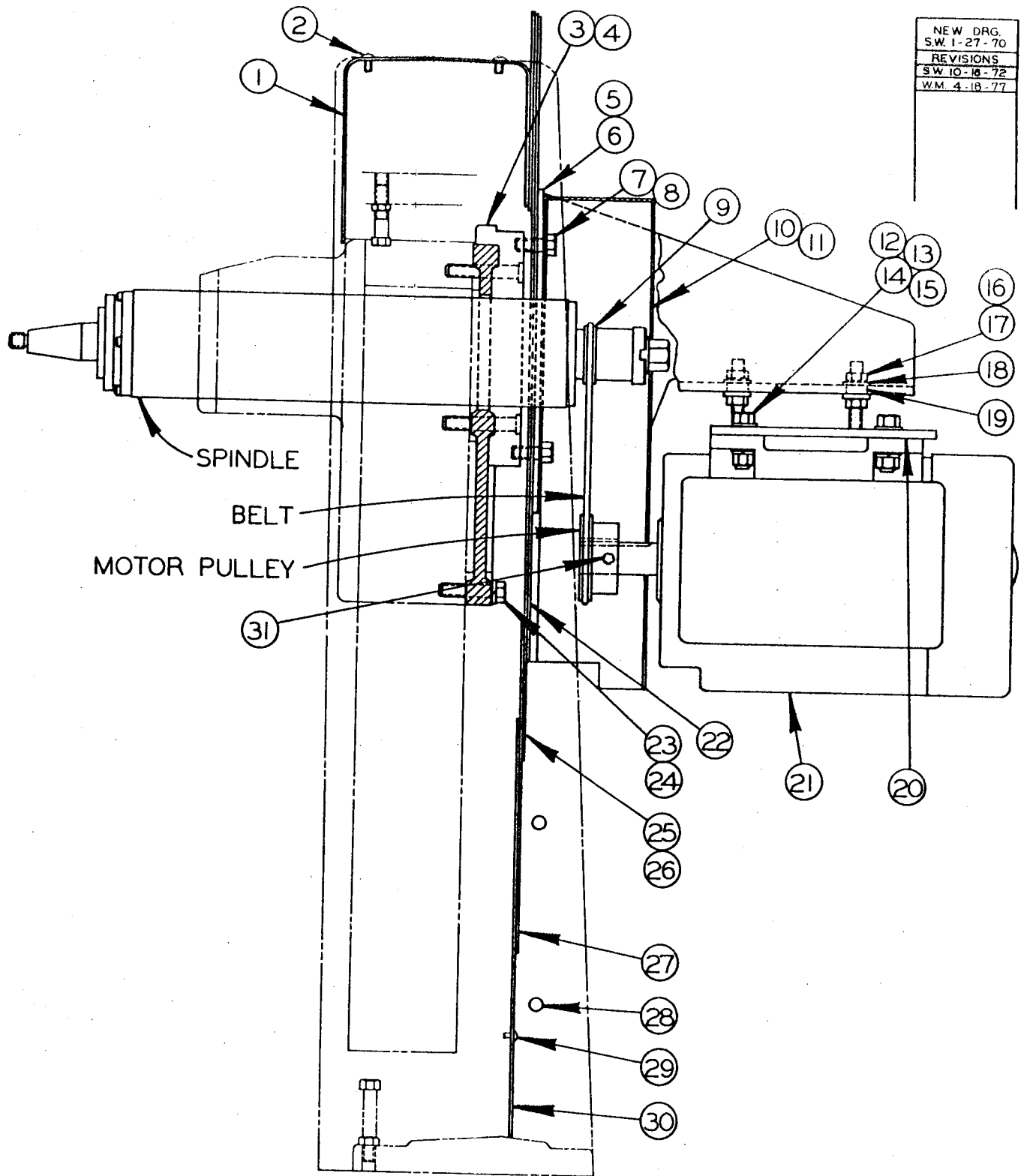
TITLE

F4-3.5.1

SPINDLE & GUARD ASSEMBLY

CODE NO.

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.							
			1	2	3	4	5	6	7	
1	14-163	Diamond Holder (Accessory)								1
2	14-166	Diamond Dresser								1
3	3235	Spindle Wrench								1
4	22748	Wheel Adaptor Puller Assembly								1
5	198467	. Soc. Hd. Set Scr. 1/2-13 x 1-1/2 Half Dog Point								1
6	7136	. Puller								1
7	53283	Spindle Assembly								1
8	54324	Wheel Guard Line Assembly								1
9	45311	. Splash Guard								1
10	18890	. Knob (not shown)								1
11	-----	. Wheel- Specify Size, Type, Etc. when ordering								1
12	14-0655A	. Spindle Nose Nut								1
13	54264	. Guard Assembly								1
14	27901	. . Cover								1
15	198707	. . Fil. Hd. Mach. Scr. 5/16-18 x 3/4 (not shown)								2
16	17854	. . Knob								2
17	54262	. . Spindle Guard								1
18	198266	. . Soc. Hd. Cap Scr. 5/16-18 x 2-1/2								1
19	198406	. . Soc. Hd. Set Scr. #8-32 x 1/4 (not shown)								1
20	10030	Wheel Adapter Ass'y.								1
21	24366	. Wheel Adapter Ass'y.								1
22	4678	. Adapter Nut								1
23	10032	. Balance Weight								2
24	Comm.	. Socket Cap Scr.								2
25	Comm.	. Plain Washer								2



NEW DRG.
S.W. 1-27-70
REVISIONS
S.W. 10-18-72
W.M. 4-18-77

SPINDLE
 BELT
 MOTOR PULLEY

OPTIONAL SPEED DRIVE ASSEMBLY

MODEL	FIRST MACH.	LAST MACH.
DH618	292-70101	292-76218
DH612	138-703300	138-763745

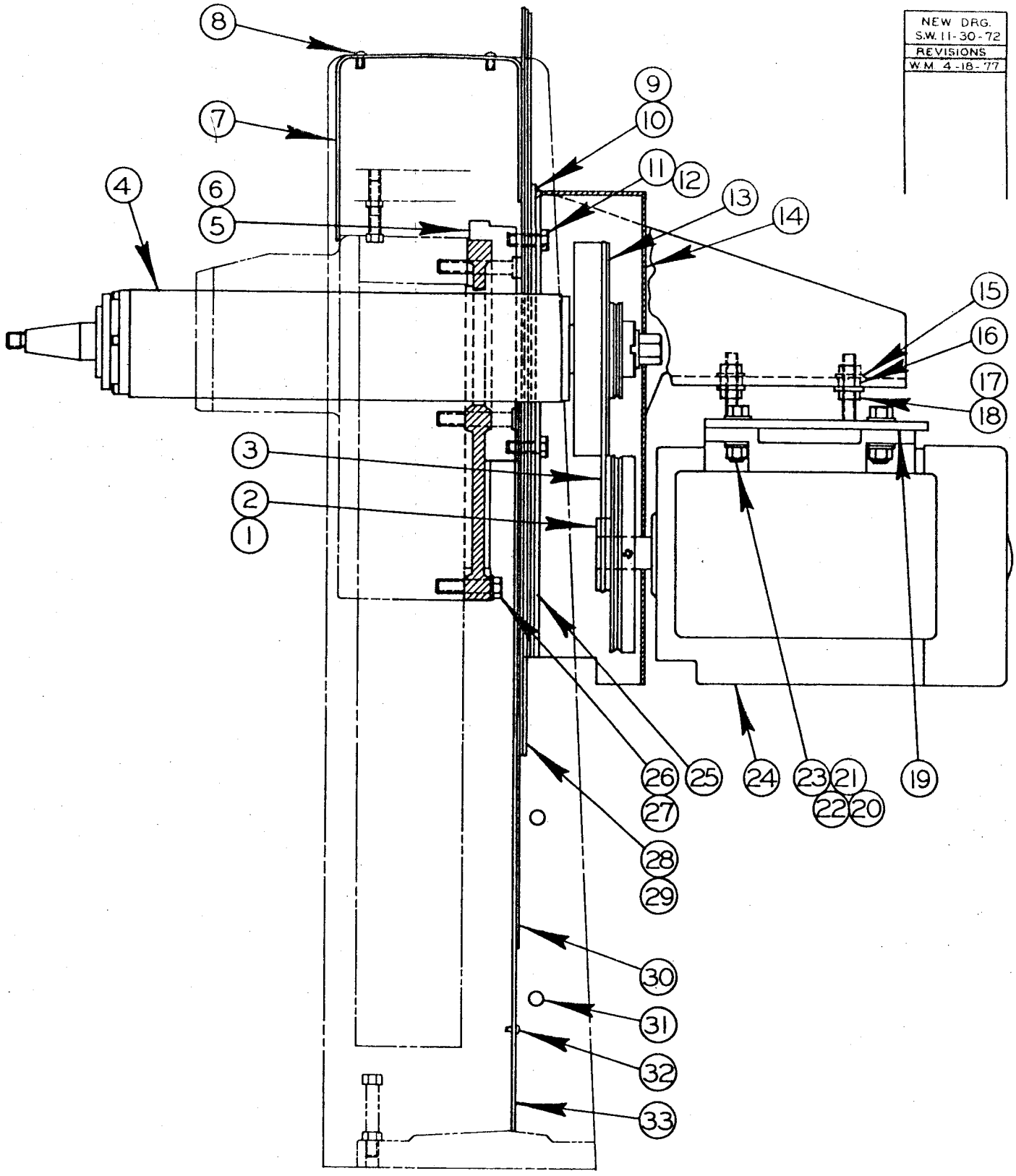
OPTIONAL SPEED DRIVE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	59217	Optional Speed Drive Assembly	
1	45491	. Guard.....	1
2	198913	. Screw, Phillips Rd. Hd. Mach. #10-24NC x 3/8.....	4
3	54706	. Slide Plate.....	1
4	198283	. Screw, Soc. Hd. Cap 3/8-16NC x 2.....	4
5	45463	. L.H. Motor Bracket.....	1
6	45493	. R.H. Motor Bracket.....	1
7	198044	. Screw, Hex. Hd. Mach. 3/8-16NC x 3/4.....	4
8	107431	. Fabreka Washer.....	4
9	117959	. Spindle Pulley.....	1
10	501440	. Belt Guard Weld't.....	1
11	198912	. Screw, Phillips Rd. Hd. Mach. #10-24NC x 5/16.....	4
12	198030	. Screw, Hex. Hd. Cap 5/16-18NC x 1 1/4.....	4
13	199122	. Nut, Hex. 5/16-18NC Std.....	4
14	199323	. Washer, Lock 5/16 Std.....	4
15	199262	. Washer, Plain 5/16 Std.....	4
16	199127	. Nut, Hex. Jam 3/8-16NC Std.....	8
17	199264	. Washer 3/8 Std.....	12
18	107430	. Fabreka Washer.....	8
19	107432	. Washer, Fabreka.....	4
20	36455	. Motor Plate Weld't.....	1
21	117972	. Motor (3600RPM 3 Phase).....	Use
	119567	. Motor (3000RPM 3 Phase 50 Cycle).....	One
22	28955	. Guard.....	1
23	198048	. Screw, Hex. Hd. Cap 3/8-16NC x 1 1/2.....	2
24	199332	. Washer, Lock 3/8 Std.....	6
25	28954	. Guard.....	1
26	Comm.	. Felt(Adhesive).....	A.R.
27	45481	. Guard.....	1
28	13545	. Plug Button.....	10
29	198911	. Screw, Phillips Rd. Hd. Mach. #8-32NC x 1/4.....	2
30	27534	. Guard.....	1
31	198422	. Screw, Soc. Set 1/4-20NC x 1/4.....	1

Note: Listed below are part numbers of spindles, pulleys, and belts for optional speeds.

	3,000 Spindle RPM	
44476	. Spindle Assembly.....	1
117960	. Motor Pulley.....	1
117965	. Belt.....	1
	3,450 Spindle RPM	
44476	. Spindle Assembly.....	1
117961	. Motor Pulley.....	1
117966	. Belt.....	1
	4,000 Spindle RPM	
44476	. Spindle Assembly.....	1
117962	. Motor Pulley.....	1
117966	. Belt.....	1
	5,000 Spindle RPM	
46199	. Spindle Assembly.....	1
117963	. Motor Pulley.....	1
116735	. Belt.....	1
	6,000 Spindle RPM	
46199	. Spindle Assembly.....	1
117964	. Motor Pulley.....	1
117967	. Belt.....	1
	7,000 Spindle RPM	
46199	. Spindle Assembly.....	1
37154	. Motor Pulley.....	1
117971	. Belt.....	1
	8,000 Spindle RPM	
46199	. Spindle Assembly.....	1
37155	. Motor Pulley.....	1
117968	. Belt.....	1
	9,000 Spindle RPM	
46199	. Spindle Assembly.....	1
37156	. Motor Pulley.....	1
117969	. Belt.....	1
	10,000 Spindle RPM	
46199	. Spindle Assembly.....	1
37157	. Motor Pulley.....	1
117970	. Belt.....	1

NEW DRG.
S.W. 11-30-72
REVISIONS
W.M. 4-18-77



DUAL SPEED DRIVE ASSEMBLY

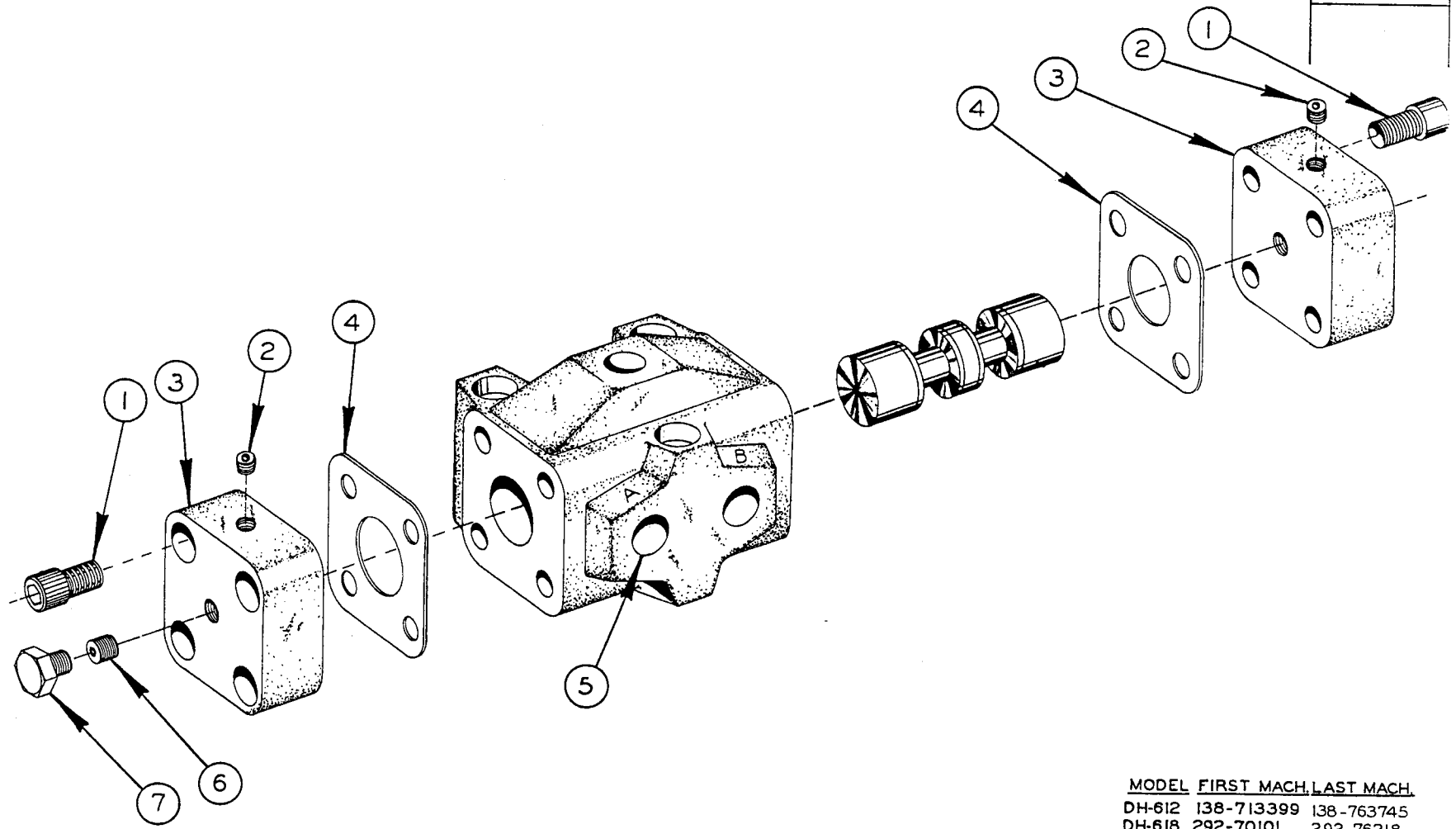
MODEL FIRST MACH LAST MACH
 DH-612 138-723454 138-763745
 DH-618 292-72138 292-76218

CODE NO. F4-7.6

DUAL SPEED DRIVE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	501441	Dual Speed Drive Assembly	
1	300407	. Motor Pulley.....	1
2	198422	. Screw, Soc. Set 1/4-20NC x 1/4.....	1
3	124810	. Belt.....	1
4	44476	. Spindle Assembly (DoALL #BD3-4)	1
5	54706	. Slide Plate.....	1
6	198283	. Screw, Soc. Hd. Cap 3/8-16NC x 2	4
7	45491	. Guard.....	1
8	198913	. Screw, Phillips Rd. Hd. Mach. #10-24NC x 3/8...	4
9	45463	. L. H. Motor Bracket.....	1
10	45493	. R. H. Motor Bracket.....	1
11	198044	. Screw, Hex. Hd. Mach. 3/8-16NC x 3/4	4
12	107431	. Fabreeka Washer.....	4
13	300430	. Spindle Pulley.....	1
14	501440	. Belt Guard Weldment.....	1
15	107430	. Fabreeka Washer.....	8
16	107432	. Fabreeka Washer.....	4
17	199127	. Nut, Hex. Jam 3/8-16NC.....	8
18	199264	. Washer, 3/8 Std.....	12
19	301675	. Motor Plate Weldment Assembly	1
20	198030	. Screw, Hex. Hd. Cap 5/16-18NC x 1 1/4	4
21	199122	. Nut, Hex. 5/16-18NC.....	4
22	199323	. Washer, Lock 5/16 Std	4
23	199262	. Washer 5/16 Std.....	4
24	14922	. Motor (3/4 H.P., 1800 RPM, 3 Phase).....	1
25	28955	. Guard.....	1
26	198048	. Screw, Hex. Hd. Cap 3/8-16NC x 1 1/2	2
27	199332	. Washer, Lock 3/8 Std.....	6
28	28954	. Guard.....	1
29	.060	. Felt (Adhesive Backed).....	A.R.
30	45481	. Guard.....	1
31	13545	. Plug Button	10
32	198911	. Screw, Phillips Rd. Hd. Mach. #8-32NC x 1/4 ..	2
33	27534	. Guard.....	1

NEW DRG.
S.W. 11-28-72
REVISIONS
S.W. 8-2-76
W.M. 4-18-77
SCL 4-24-80



4 - WAY VALVE ASSEMBLY

MODEL	FIRST MACH.	LAST MACH.
DH-612	138-713399	138-763745
DH-618	292-70101	292-76218
VS-612	355-76101	355-80634
VS-618	357-76101	357-80551

FG-2.8

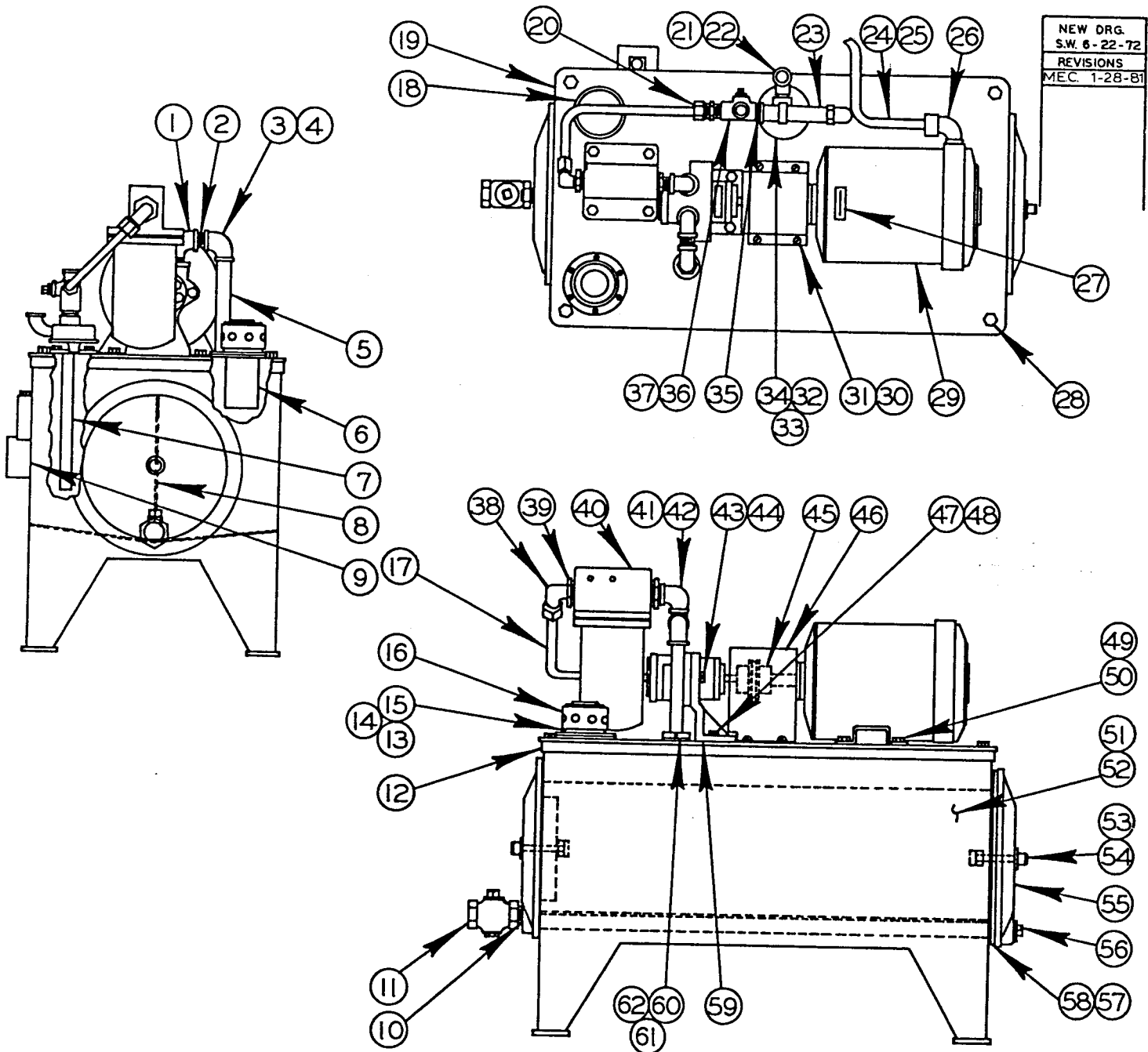
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CODE NO. F6-2.8

4-Way Valve Assembly

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	402777	4-Way Valve Assembly	
Ref.	39765	. 4-Way Valve.....	1
1	198371	. . Screw, Soc. Hd. Cap 3/8-16NC x 1.....	8
2	8446	. . Caplug.....	2
3	39766	. . End Cap.....	2
4	101297	. . Gasket.....	2
5	8346	. . Caplug.....	4
6	123164	. . Screw, Soc. Set.....	2
7	124428	. . Hex. Hd. Bolt.....	2
Following items not shown and used only on ass'y #402777			
	35-982	. Service Tee.....	1
	5-11517	. Reducer Bushing.....	2
	9273	. Male Connector.....	2
	10409	. Elbow.....	1
	5-11513	. 90° Street Elbow.....	2
	14-366	. Pipe Nipple.....	1
	17-13521	. 90° Street Elbow.....	1
	35-847	. Service Tee.....	1
	5-04520	. 90° Street Elbow.....	1
	14-14528	. Close Nipple.....	1
	112318	. Flow Control Valve.....	2
	17110	. 90° Elbow.....	1
	11658	. Pipe Nipple.....	1
	14-115194	. 90° Elbow.....	2

*Note: When replacing valve body or valve spool order complete valve ass'y #39765



HYDRAULIC PUMP & TANK ASSEMBLY

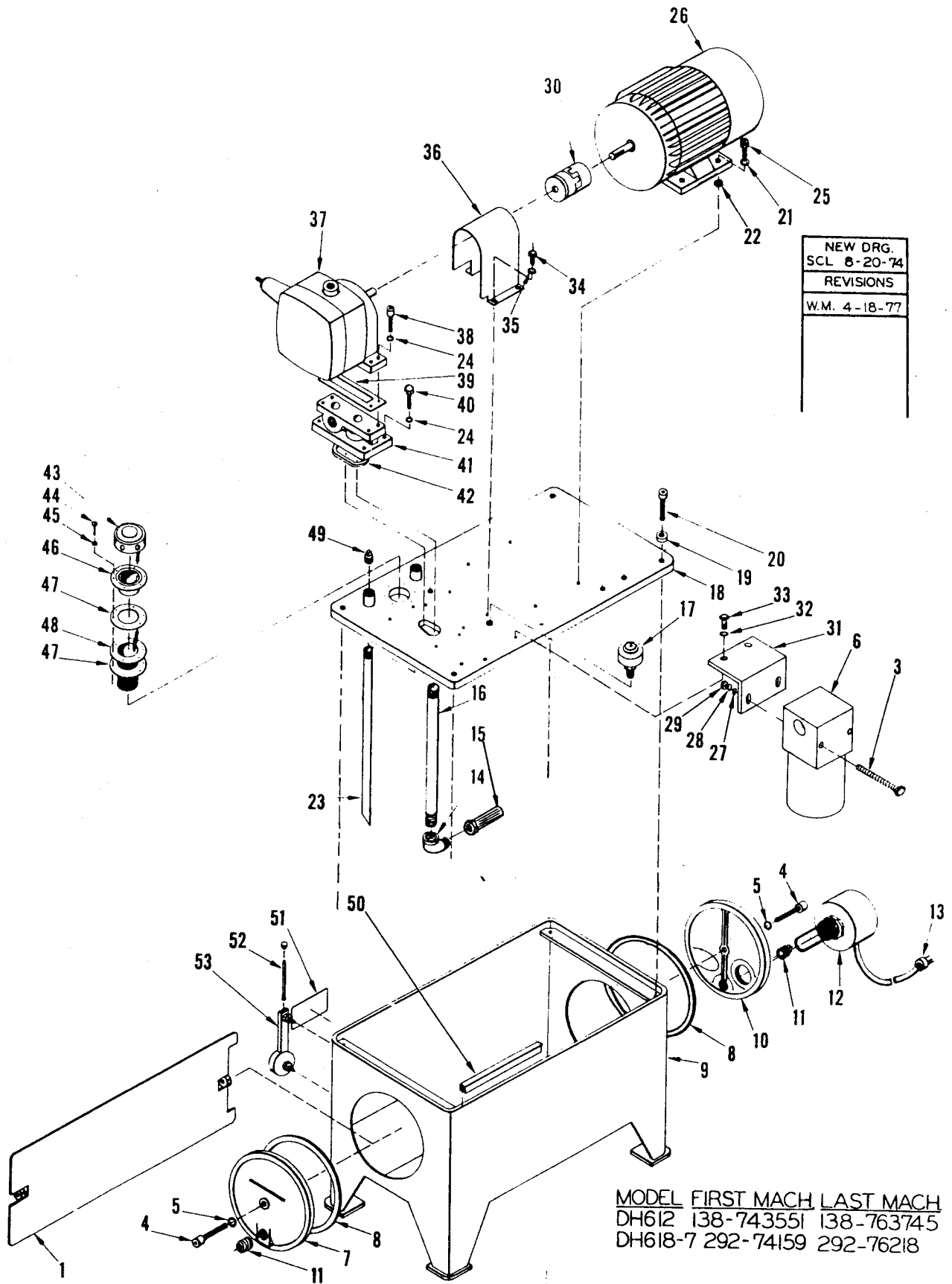
MODEL	FIRST MACH.	LAST MACH.
DH-612	138-703352	138-743550
MTA-612	184-71158	184-71158
MTM-612		
TF-20	273-70117	273-72143
DH-618	292-70101	292-74158
TF-18RT	323-72101	323-77104

FI-5.2 TF-4-51 GI-3.1.2

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HYDRAULIC PUMP & TANK ASSEMBLY

INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
REF.	090-566308	Hydraulic Pump & Tank Assembly	
1	114-003478	. 90° Street Elbow	2
2	114-006612	. Close Nipple	2
3	114-003486	. 90° Elbow	2
4	090-118035	. Plastic Plug	1
5	091-129791	. Nipple	1
6	091-022855	. Screen & Adaptor Assembly	1
7		. Nipple	1
8	090-382862	. Baffle Weldment	1
9	091-205922	. View Gauge	1
10	135-034999	. Close Nipple	1
11	090-146309	. Iron Cock	1
12	091-077695	. Channel	1
13	090-138553	. Filler Neck	1
14	091-055905	. Gasket	2
15	091-988758	. Screw, Rd. Hd. Mach., #10 - 24 NC x 1	6
16	090-138561	. Filter Cap	1
17	091-971317	. Steel Tubing	A.R.
18	105-115109	. Breather	1
19	090-475955	. Reservoir Cover	1
20	091-338863	. Male Connector	1
21	105-115133	. 90° Street Elbow	1
22	090-083460	. Plastic Plug	3
23	091-236521	. Relief Valve	1
24	091-972182	. Electrical Cord	1
25	090-158353	. Cord Grip Connector	1
26	090-161605	. Cord Grip Connector	1
27	090-046558	. Decal	1
28	091-980490	. Screw, Hex. Hd. Cap, 3/8 - 16 NC x 1-3/4	4
29	090-149220	. Electric Motor	1
30	091-988956	. Screw, Rd. Hd. Cap, 1/4 - 20NC x 1/2	4
31	091-993212	. Washer, Lock, 1/4 Std.	7
32	090-208364	. Manifold	1
33	090-033200	. Gasket	1
34	091-980060	. Screw, Hex. Hd. Cap, 1/4 - 20 NC x 1/2	3
35	135-011278	. Nipple	2
36	135-071827	. 4 Way Tee	1
37	106-335185	. Pipe Plug	1
38	090-103334	. 90° Elbow	1
39	091-235127	. Reducer Bushing	2
40	091-211128	. Filter	1
41	091-338772	. Pump	1
42	090-089624	. Nipple	1
43	091-980482	. Screw, Hex. Hd. Cap 3/8 - 16NC x 1-1/2	2
44	091-991265	. Nut, Hex., 3/8 - 16 NC	2
45	135-008948	. Coupling	1
46	090-478330	. Guard	1
47	091-980441	. Screw, Hex. Hd. Cap, 3/8 - 16 NC x 3/4	2
48	091-993329	. Washer, Lock	4
49	091-980250	. Screw, Hex. Hd. Cap, 5/16 - 18NC x 1/2	4
50	091-993238	. Washer, Lock, 5/16 Std.	4
51	094-013331	. Reservoir Weldment	1
52	091-420505	. Hydraulic Oil S.A.E. #10	A.R.
53	091-983007	. Screw, Soc. Hd. Cap, 1/2 - 13 NC x 2-3/4	2
54	091-092478	. Seal Washer	2
55	090-588989	. Cleanout Cover	2
56	105-046189	. Pipe Plug, Square Hd.	1
57	091-206963	. Cover Gasket	2
58	091-371195	. Adhesive, AD-151	A.R.
59	090-250507	. Pump Bracket	1
60	090-033176	. Collar	1
61	091-017442	. Washer	1
62	091-954112	. Screw, Soc. Set, #10 - 24 NC x 3/8	1



NEW DRG.
SCL 8-20-74
REVISIONS
W.M. 4-18-77

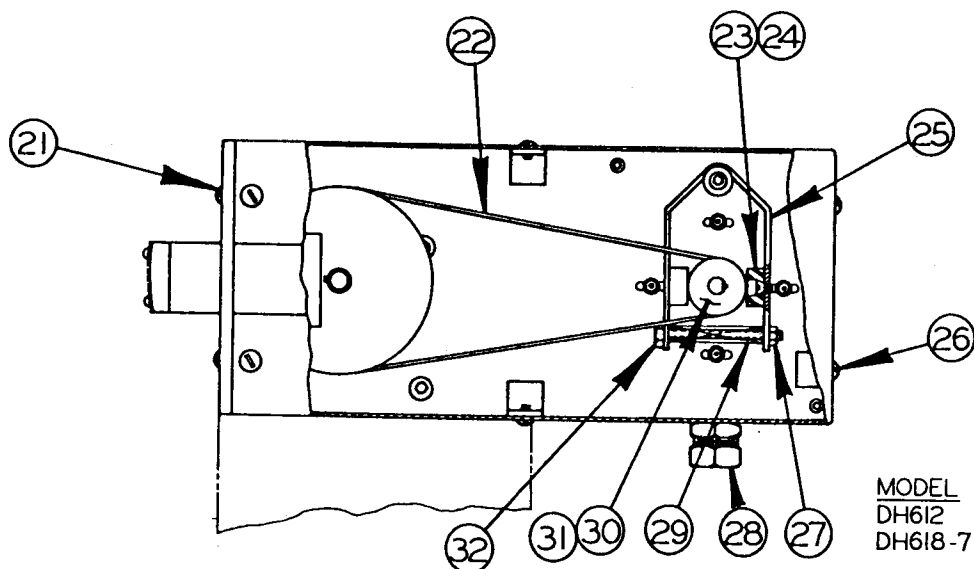
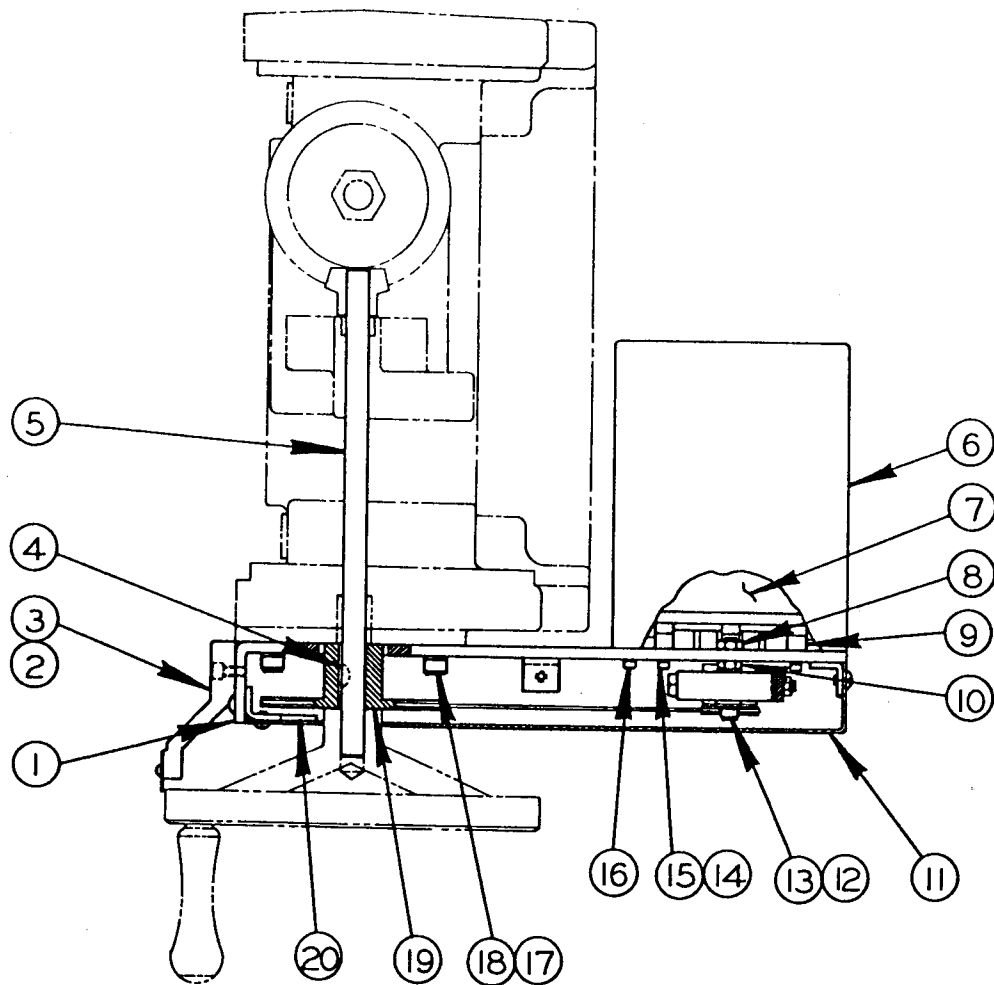
MODEL FIRST MACH LAST MACH
 DH612 138-743551 138-763745
 DH618-7 292-74159 292-76218

HYDRAULIC POLYPAC ASSEMBLY

HYDRAULIC POLYPAC ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	130890	Polypac Assembly	
1	38286	. Baffle Weldment.....	1
3	198058	. Screw, Hex. Hd. Cap 3/8-16NC x 5.....	2
4	198381	. Screw, Soc. Hd. Cap 1/2-13NC x 2 3/4 (Cad. Pltd.).....	2
5	109247	. Seal Washer.....	2
6	119457	. Filter.....	1
	115540	. Filter Element.....	1
7	58898	. Cleanout Cover.....	2
8	120596	. Cover Gasket.....	2
9	401333	. Reservoir Weldment.....	1
10	501679	. Cleanout Cover.....	1
11	5-04618	. Sq. Hd. Pipe Plug.....	2
12	125887	. Immersion Heater (Optional).....	1
13	7678	. Plug 3 Prong.....	1
14	103738	. Street Elbow.....	1
15	120806	. Strainer.....	1
16	104687	. Intake Pipe (10 Gal.).....	Use
	125727	. Intake Pipe (20 Gal.).....	
	125728	. Intake Pipe (35 Gal.).....	
	112882	. Intake Pipe (55 Gal.).....	One
17	115707	. Breather.....	1
18	404388	. Top Plate Weldment.....	1
19	115804	. Rubber Washer.....	4
20	103841	. Shoulder Screw.....	4
21	199324	. Washer, Lock 5/16 Std. (Cad. Pltd.).....	4
22	199122	. Nut, Hex. 5/16-18NC.....	4
23	123488	. Return Pipe (10 Gal.).....	2
	123493	. Return Pipe (20 Gal.).....	2
	125731	. Return Pipe (35 Gal.).....	2
	125732	. Return Pipe (55 Gal.).....	2
24	199325	. Washer, Lock 3/8 Std.....	8
25	198664	. Screw, Sq. Hd. Set 5/16-18NC x 2 1/2 (Cad. Pltd.).....	4
26	116132	. Electric Motor 1 1/2 H.P. 1800 R.P.M.....	1
27	199264	. Washer, Flat 3/8 Std.....	2
28	199332	. Washer, Lock 3/8 Std.....	2
29	199126	. Nut, Hex. 3/8-16NC.....	2
30	107964	. Flexible Coupling.....	1
31	36491	. Bracket.....	1
32	199332	. Washer, Lock 3/8 Std.....	2
33	198044	. Screw, Hex. Hd. Cap 3/8-16NC x 3/4.....	2
34	198895	. Screw, Rd. Hd. Mach. 1/4-20NC x 1/2.....	3
35	199321	. Washer, Lock 1/4 Std.....	3
36	49956	. Guard.....	1
37	112440	. Hydraulic Pump (PVR1).....	1
38	198279	. Screw, Soc. Hd. Cap 3/8-16NC x 1 (Cad. Pltd.).....	4
39	114992	. Gasket.....	1
40	198046	. Screw, Hex. Hd. Cap 3/8-16NC x 1.....	4
41	48165	. Manifold.....	1
42	120802	. Manifold Gasket (PVR1).....	Use
	121923	. Manifold Gasket (PVR15).....	One
43	13856	. Filler Cap.....	1
44	198869	. Screw, Rd. Hd. Mach. #10-24NC x 1/2.....	6
45	199373	. Washer, Lock #10 Shakeproof Ext.....	6
46	13855	. Filler Neck.....	1
47	105590	. Gasket.....	2
48	102285	. Screen and Adapter Assembly.....	1
49	5-04618	. Sq. Hd. Pipe Plug.....	1
50	107769	. Channel.....	1
51	109363	. Escutcheon.....	1
52	128833	. Replacement Thermometer.....	1
53	120594	. Liquid Level Gauge (20 Gal.).....	Use
	120592	. Liquid Level Gauge (10 Gal.).....	One

NEW DRG.
S.W. 1-28-70
REVISIONS
W.M. 4-18-77



MODEL	FIRST MACH.	LAST MACH.
DH612	138-703300	138-763745
DH618-7	292-70101	292-76218

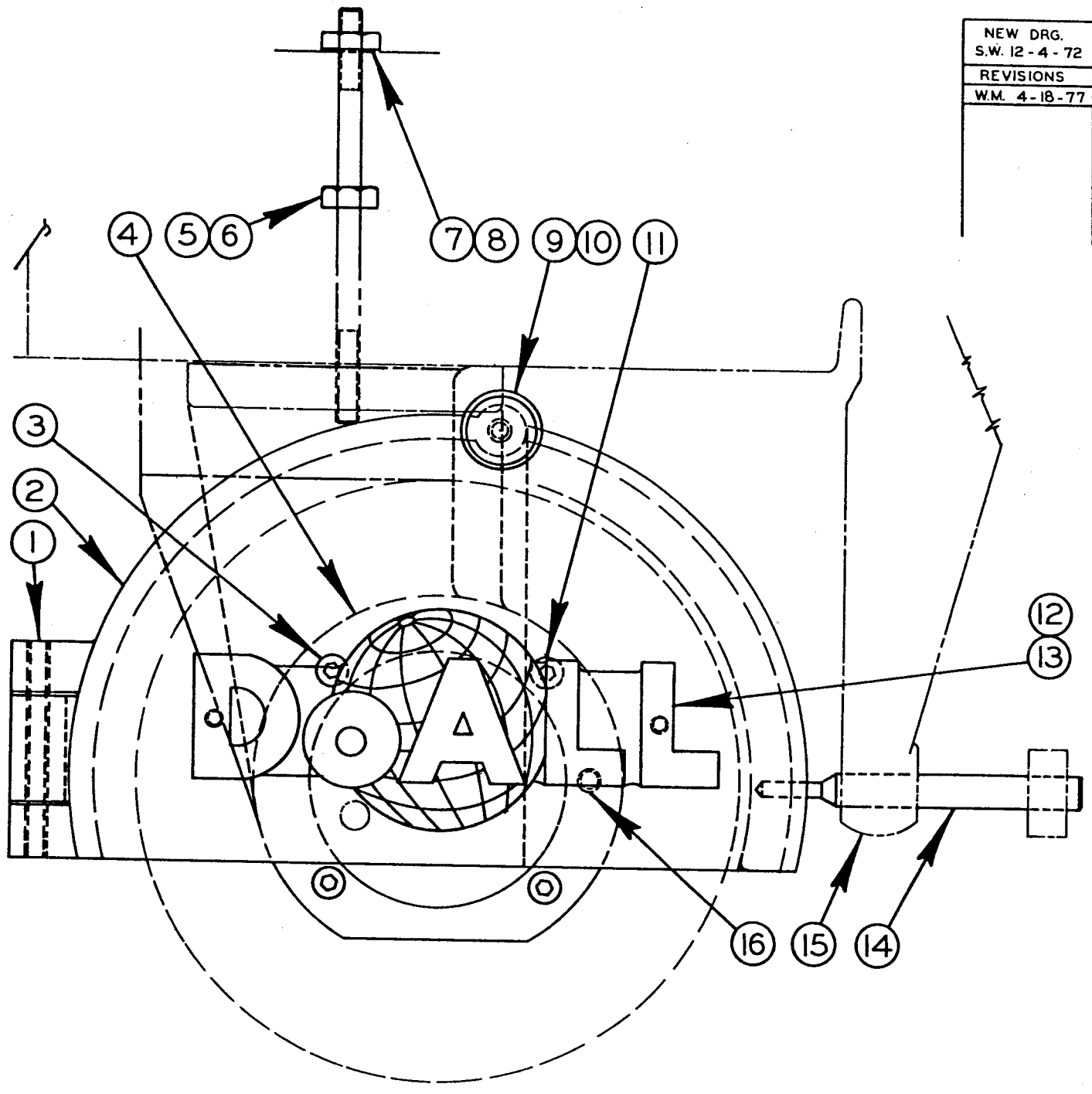
MOTORIZED WHEEL ELEVATING ASSEMBLY

CODE NO. F8-4.3

MOTORIZED WHEEL ELEVATING ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	59646	Motorized Wheel Elevating Assembly	
1	401657	. Bracket Weldment.....	1
2	38471	. Bracket.....	1
3	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2.....	2
4	4325	. Woodruff Key.....	1
5	120532	. Shaft.....	1
6	401653	. Motor Cover Weldment.....	1
7	119158	. Motor.....	1
8	199115	. Nut, Hex. 1/4-20NC.....	1
9	4061	. Spacer.....	4
10	199114	. Nut, Hex. Jam 1/4-20NC.....	1
11	401650	. Cover.....	1
12	198245	. Screw, Soc. Hd. Cap 1/4-20NC x 1 1/2.....	1
13	199260	. Washer 1/4" S.A.E.....	1
14	198215	. Screw, Soc. Hd. Cap #8-32NC x 7/8.....	4
15	199318	. Washer, Lock #8 Std.....	4
16	198341	. Screw, Soc. Hd. Cap #10-24NC x 1/2.....	2
17	198259	. Screw, Soc. Hd. Cap 5/16-18NC x 7/8.....	4
18	199323	. Washer, Lock 5/16 Std.....	4
19	120530	. Pulley.....	1
20	120535	. Plate.....	1
21	198321	. Screw, Soc. Button Hd. Cap #10-24NC x 3/8...	2
22	120528	. Belt.....	1
23	120527	. Brake Block.....	2
24	198748	. Screw, Flat Hd. Mach. #10-24NC x 3/8.....	2
25	38470	. Bracket Weldment.....	1
26	199013	. Screw, Truss Hd. Mach. #10-24NC x 1/4.....	6
27	199120	. Nut, Hex. Jam 1/4-28NF.....	1
28	14483	. Connector.....	2
29	12682	. Spring.....	1
30	120529	. Motor Pulley.....	1
31	198411	. Screw, Soc. Set #10-24NC x 3/8.....	1
32	Comm.	. Screw, Hex. Hd. Cap 1/4-28NF x 2 1/2.....	1
	Following items not shown:		
	Stk #519	. Sealtite.....	A.R.
	Stk #734	. Stranded Red Wire.....	A.R.
	Stock	. Wire Marker (Brady Type).....	A.R.
	103764-Y	. Wire Connector.....	3

NEW DRG.
S.W. 12-4-72
REVISIONS
W.M. 4-18-77



OPTIDRESS ADAPTER ASSEMBLY

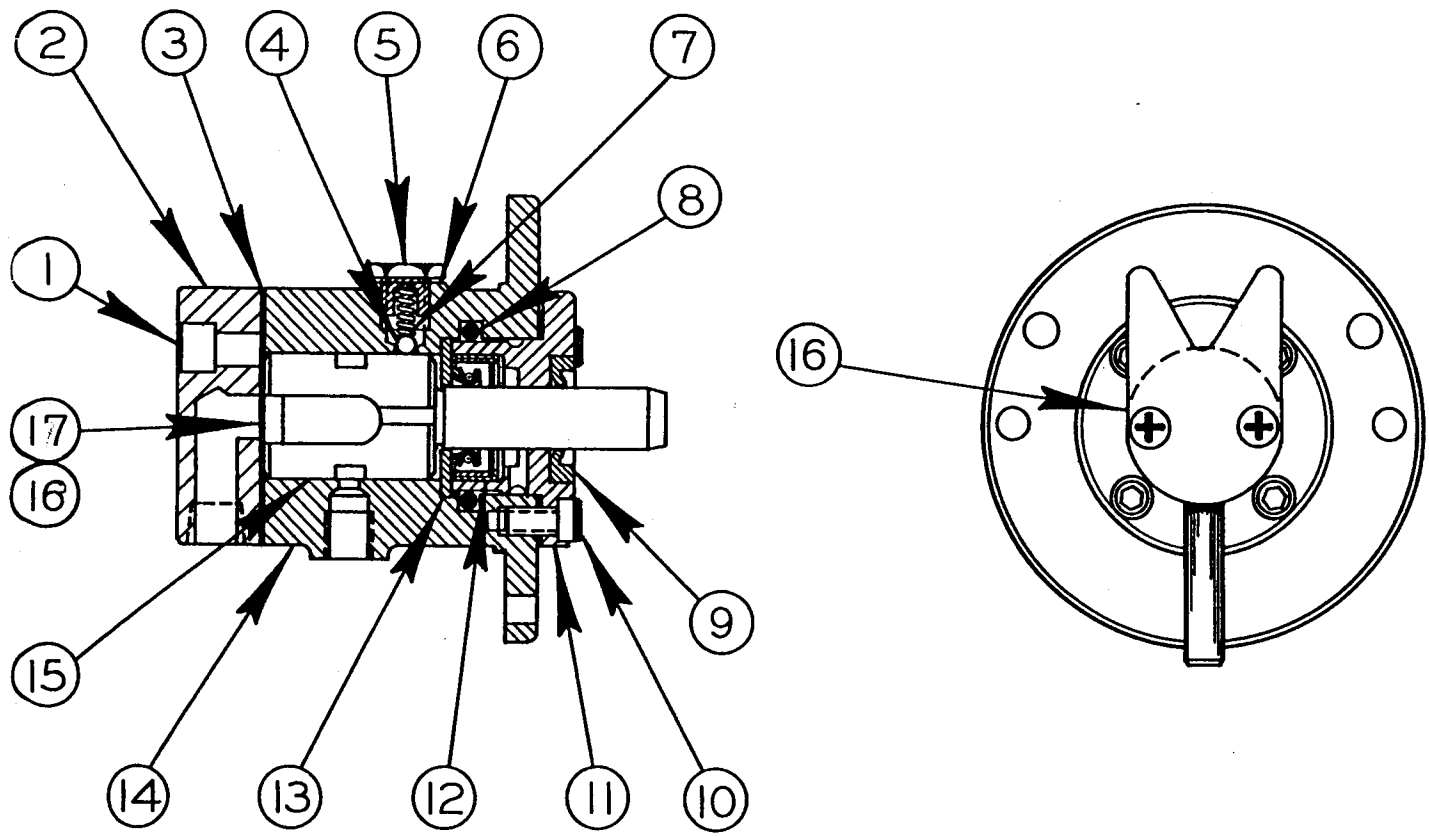
<u>MODEL</u>	<u>FIRST MACH.</u>	<u>LAST MACH.</u>
DH-612	138-723454	138-763745
DH-618	292-72138	292-76218

CODE NO. F9-5.0

OPTIDRESS ADAPTOR ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	54621	Optidress Adapter Assembly	
1	4281	. Roll Pin.....	1
2	31685	. Guard Weldment.....	1
3	198244	. Screw, Soc. Hd. Cap 1/4-20NC x 1 1/4.....	1
4	57332	. Adapter.....	1
5	198034	. Screw, Hex. Hd. Cap 5/16-18NC x 2 1/2.....	1
6	199262	. Washer 5/16 Std. S.A.E.....	2
7	111666	. Stud.....	1
8	199123	. Nut, Hex. 5/16-18NC.....	1
9	18890	. Knob.....	1
10	35-9616	. Retaining Ring.....	1
11	198248	. Screw, Soc. Hd. Cap 1/4-20NC x 2 1/4.....	3
12	28254	. Name Plate.....	1
13	198741	. Screw, Fl. Hd. Mach. #8-32 x 3/8.....	2
14	2975	. Diamond Tool.....	1
15	111570	. Optidress.....	1
16	100673	. Dowel Pin.....	1
	Following items not shown:		
	57331	. Slide.....	1
	32666	. Guard.....	1

NEW DRG. S.W. 8-27-76
REVISIONS
W.M. 4-18-77
S.C.L. 4-24-80



PILOT VALVE ASSEMBLY

MODEL	FIRST MACH.	LAST MACH.
DH-612	138-59101	138-763745
MTA-612	184-60101	184-71158
MTM-612		
L618-12	246-68101	246-75172
L618-7	247-68101	247-69112
DH-618	292-70101	292-76218
VS-612	355-76101	355-80634
VS-618	357-76101	357-80551

CODE NO. F6-4.5
G5-4.2

PILOT VALVE ASSEMBLY

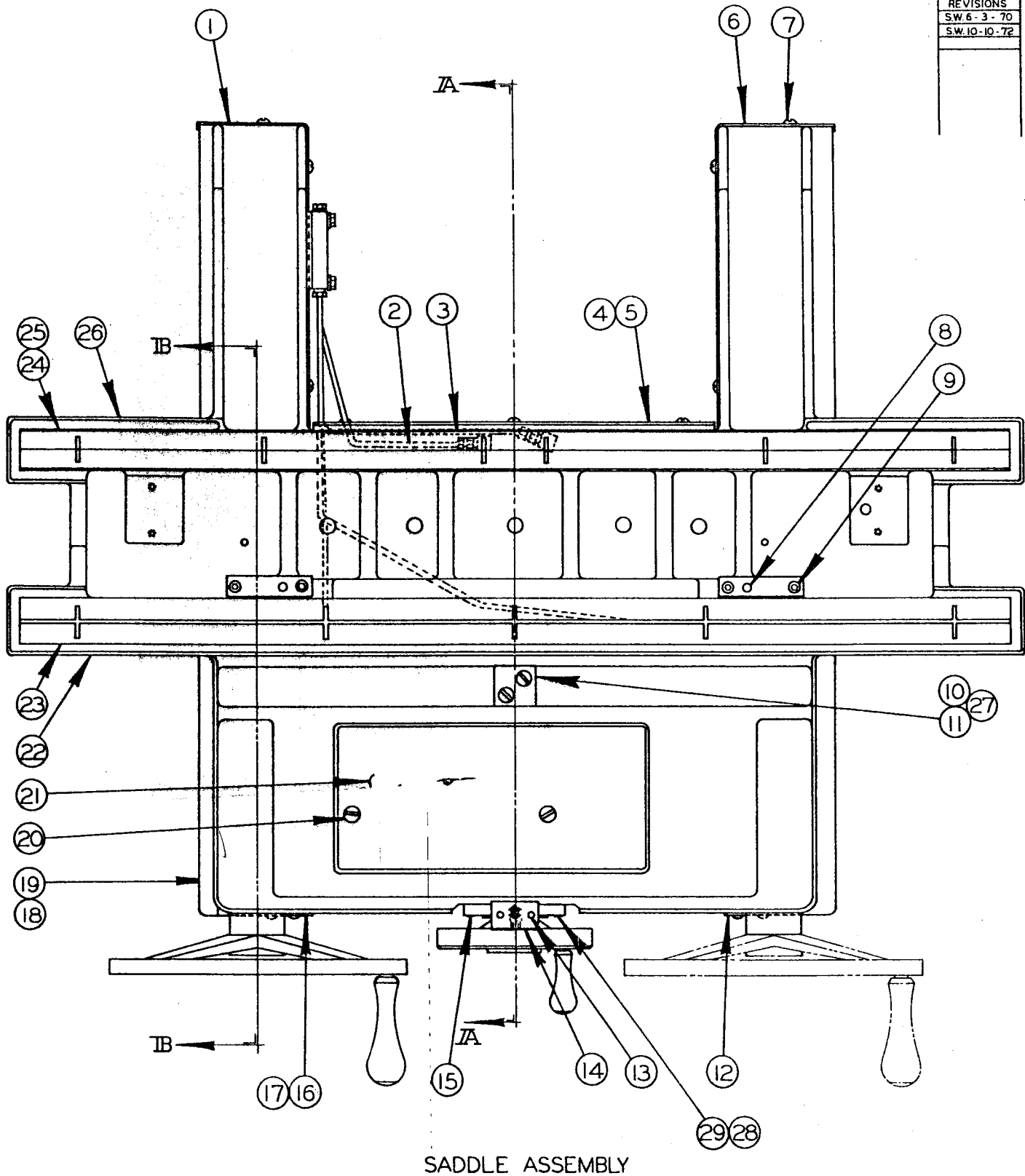
INDEX NO.	CATALOG NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	090-289307	Pilot Valve Assembly	
1	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8	4
2	091-014712	. Pilot Valve Cap	1
3	114-113889	. Valve Gasket	1
4	134-015189	. Ball	1
5	114-007347	. Spring Screw	1
6	114-007354	. Copper Washer	1
7	114-002504	. Spring	1
*8	135-085397	. "O" Ring	1
9	090-110172	. Clipper Seal	1
10	091-982199	. Screw, Soc. Hd. Cap #10-24NC x 3/8	4
11	114-002421	. Valve Cap	1
12	090-068024	. Oil Seal	1
13	114-002488	. Thrust Washer	1
14	See Note:	. Valve Body	1
15	See Note:	. Valve Stem	1
**16	091-024315	. Reverse Lever Assembly	1
17	091-334706	. Spacer(.0149).....	1
18	091-334714	. Spacer(.0299).....	1

Note: To replace valve body & valve stem order complete valve assembly 090-289307.

*Note: Before Ser. #138-62954 on DH-612, 135-085397 "O"-Ring was 114-002496 gasket.

**Note: Assembly #091-024315, not included in pilot valve assembly #090-289307, & before Ser. #138-60473, 091-024315 was 091-022970.

NEW DRG.
S.W. 2 - 3 - 70
REVISIONS
S.W. 6 - 3 - 70
S.W. 10 - 10 - 72



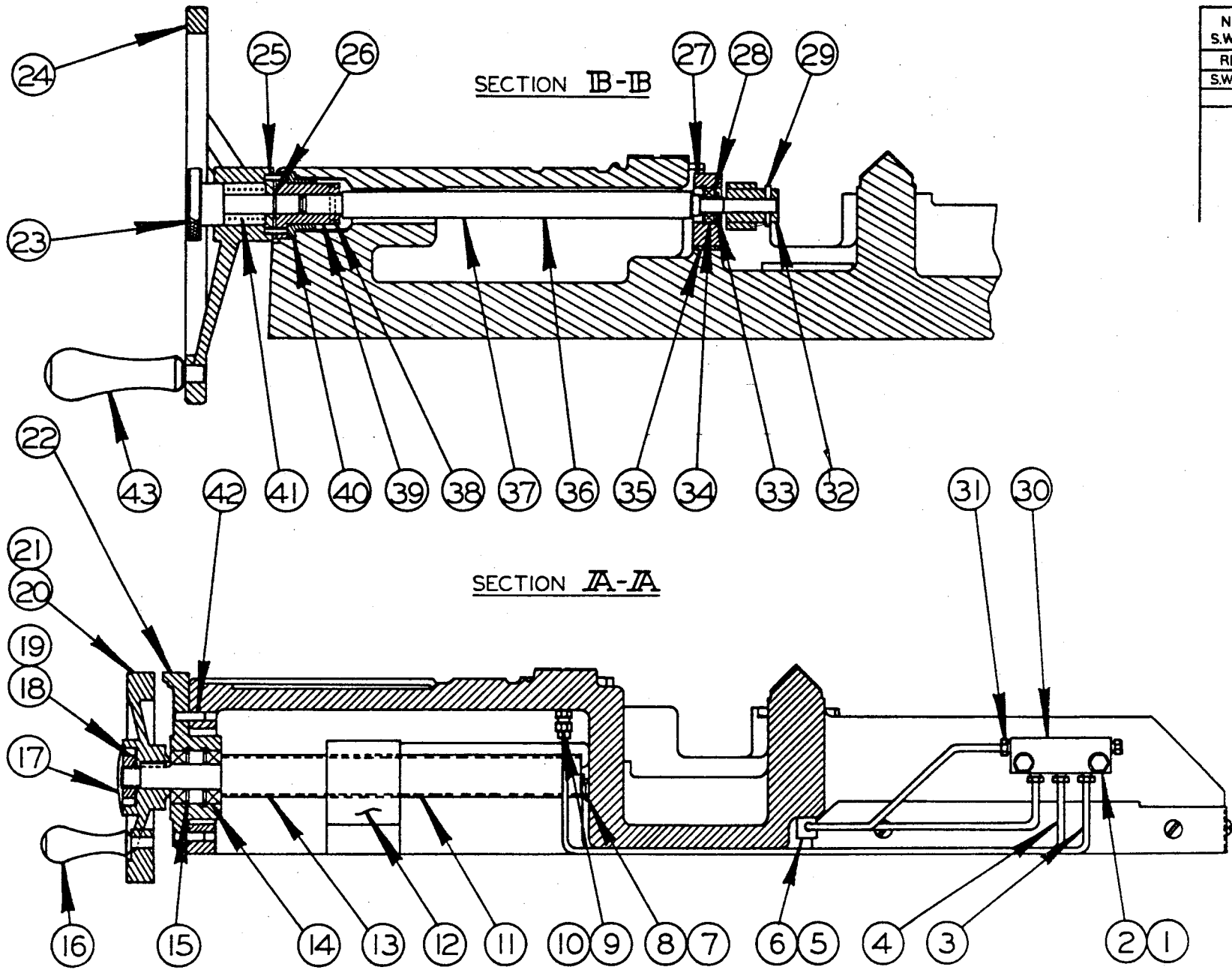
MODEL FIRST MACH LAST MACH
 DH618-7 292-70101 292-76218

CODE NO. F5-1.10

SADDLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	500015	Saddle Assembly	
1	402775	. L. H. Saddle Way Cover.....	1
2	37850	. Tube.....	1
3	37851	. Tube.....	1
4	32949	. Rear Saddle Curtain Bracket.....	1
5	32950	. Curtain.....	1
6	402774	. R. H. Saddle Way Cover.....	1
7	199016	. Screw, Truss. Hd. Mach. #10-24NC x 1/2...	13
8	35-443	. Dowel Pin.....	2
9	198246	. Screw, Soc. Hd. Mach. 1/4-20NC x 1 3/4...	4
10	122194	. Table Stop.....	1
11	198761	. Screw, Flat. Hd. Mach. 1/4-20NC x 5/8.....	2
12	38468	. R. H. Front Saddle Way Cover Weld't.....	1
13	198910	. Screw, Phillips Slot Rd. HD Mach. #6-32NC x 1/4	2
14	17491	. Escutcheon.....	1
15	198259	. Screw, Soc. Hd. Mach. 5/16-18NC x 7/8...	4
16	38467	. L. H. Front Saddle Way Cover Weld't.....	1
17	Stk #063	. Gasket.....	A.R.
18	198869	. Screw, Rd. Hd. Mach. #10-24NC x 1/2.....	2
19	1019	. Shim.....	6
20	198759	. Screw, Fl. Hd. Mach. 1/4-20NC x 1/2.....	2
21	101844	. Cover.....	1
22	500804	. Saddle Sub-Ass'y.....	1
23	123509	. . Teflon Skid	1
24	123508	. . Teflon Skid	1
25	Comm.	. . Adhesive (Fullers #4 Rigid Ratio).....	A.R.
26	500002	. . Saddle.....	1
27	199374	. Washer, Lock 1/4 x 82° C' Sunk-External	2
28	198261	. Screw, Soc. Hd. Cap 5/16-18NC x 1 1/4	1
29	199115	. Nut, Hex. 1/4 -20NC	1

NEW DRG.
S.W. 2-4-70
REVISIONS
S.W. 10-10-72



SADDLE ASSEMBLY

MODEL FIRST MACH. LAST MACH.
 DH618-7 292-70101 292-76218

F5-111

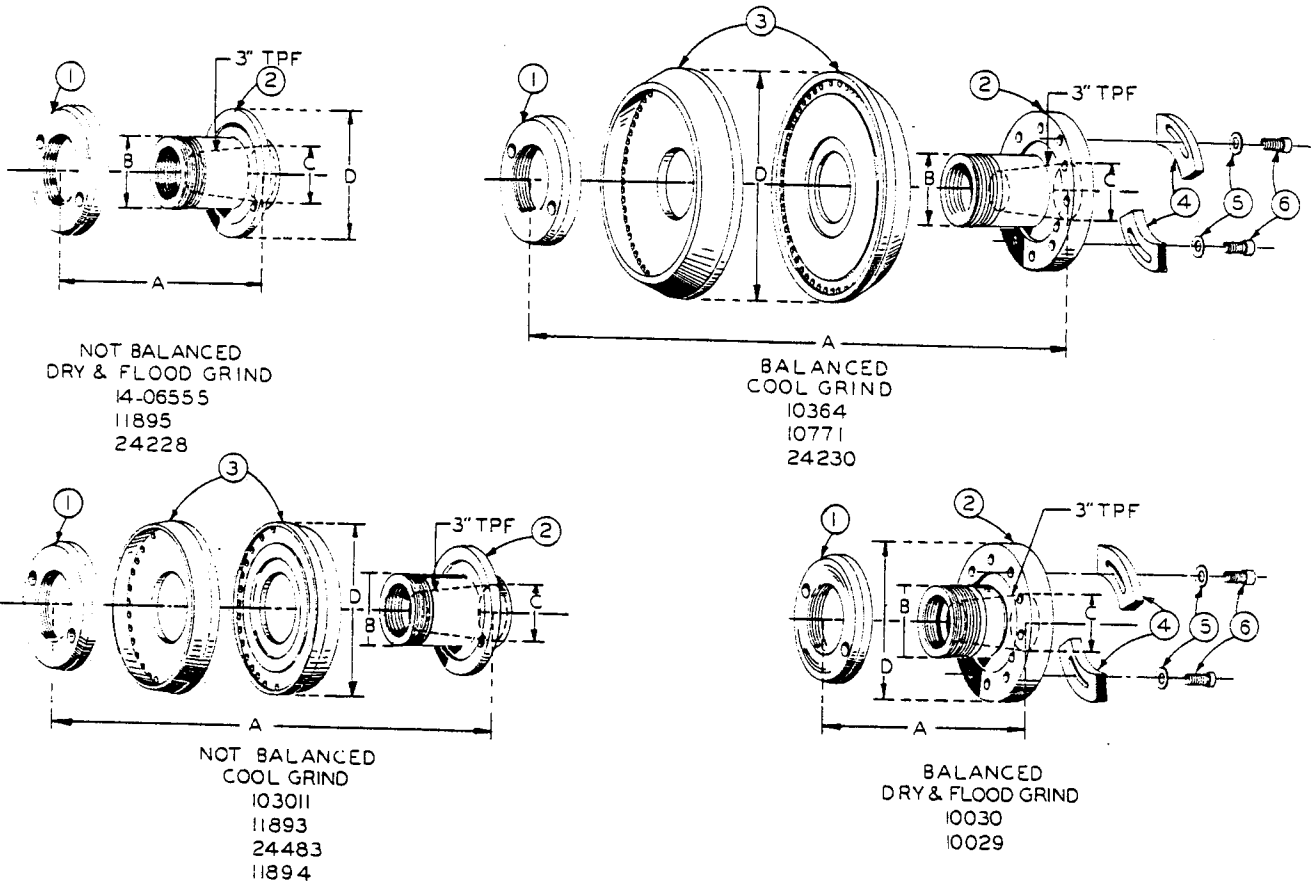
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SADDLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	500015	Saddle Assembly (Continued).....	
1	198010	. Screw, Hex. Hd. Mach. 1/4-20NC x 1.....	2
2	199321	. Washer, Lock 1/4 Std.....	2
3	31713	. Tube.....	1
4	105668	. Tube.....	1
5	18194	. Metering Unit.....	4
6	17110	. Elbow.....	2
7	14873	. Tubing Clip.....	1
8	198865	. Screw, Rd. Hd. Mach. #10-24NC x 1/4.....	1
9	14447	. Compression Nut.....	4
10	14446	. Compression Sleeve.....	7
11	300428	. Crossfeed Screw & Nut Sub-Ass'y.....	1
12	300427	. . Nut.....	1
13	27822	. . Crossfeed Screw.....	1
14	18888	. Bearing.....	2
15	1530	. Retaining Ring.....	2
16	101451	. Handle.....	1
17	18233	. Plug Button.....	1
18	17-05507	. Bearing Locknut.....	1
19	17-05508	. Bearing Lockwasher.....	1
20	27541	. Crossfeed Handwheel.....	1
21	13076	. Key.....	1
22	27956	. Housing.....	1
23	100894	. Screw.....	1
24	29165	. Table Handwheel.....	1
25	35-8371	. Dowel Pin.....	2
26	35-9613	. Snap Ring.....	1
27	100472	. Bearing Block.....	2
28	100474	. Snap Ring.....	4
29	124592	. Grooved Pin.....	2
30	14824	. Junction.....	1
31	14825	. Compression Bushing.....	3
32	124241	. Gear.....	2
33	3276	. Snap Ring.....	2
34	100476	. Bearing.....	2
35	101884	. Shim.....	A.R.
36	38466	. Feed Shaft Ass'y.....	2
37	38480	. . Shaft.....	1
38	4231	. . Roll Pin.....	1
39	100421	. . Drive Lug.....	1
40	100424	. Bearing.....	2
41	100895	. Spring.....	1
42	35-516	. Dowel Pin.....	2
43	101450	. Handle.....	1

Following items not shown:

14-115158	. Soc. Pipe Plug.....	4
35-4528	. Plug Button.....	1



MODEL	WHEEL SIZE	NOT BALANCED			BALANCED			SPECIFICATIONS									
		DRY	FLOOD	COOL	DRY	FLOOD	COOL	PART NO.	A	B	C	D					
DH-612 & D6	7 x 1/2 x 1-1/4	4-06555	4-06555	103011 11893	10030	10030	10364	4-06555	3/4	1-1/4	1	2-1/4	24-483	2-5/16	3	1-1/2	5-5/16
D6	8 x 3/4 x 1-1/4	11895	11895	11894	10029	10029	10771	11895	1-7/8	1-1/4	1	2-1/4	10364	1-5/16	1-1/4	1	2-3/4
D8	8 x 3/4 x 1-1/4	11895	11895	11894	10029	10029	10771	24228	2-5/16	3	1-1/2	5-5/16	10771	2-3/16	1-1/4	1	2-3/4
D8	10 x 3/4 x 3	24228	24228	24483	USE COOL GRIND ADAPT. 24230		24230	103011	1-7/8	1-1/4	1	3-1/16	24230	2-5/16	3	1-1/2	5-5/16
D8	12 x 1 x 3	24228	24228	24483			24230	11893	1-7/8	1-1/4	1	4-1/4	10030	1-3/4	1-1/4	1	2-3/4
D8	12 x 3/4 x 3	24228	24228	24483			24230	11894	2-3/16	1-1/4	1	2-1/4	10029	1-5/16	1-1/4	1	2-3/4
D8	12 x 1 x 3	24228	24228	24483			24230										
D10	12 x 1 x 3	24228	24228	24483			24230										
D10	14 x 1 x 3	24228	24228	24483			24230										

A = ADAPTOR WIDTH
 B = WHEEL BORE
 C = SHAFT DIAMETER
 D = ADAPTOR OR FLANGE DIAMETER

SPINDLE ADAPTORS

CODE NO. F4-5.0

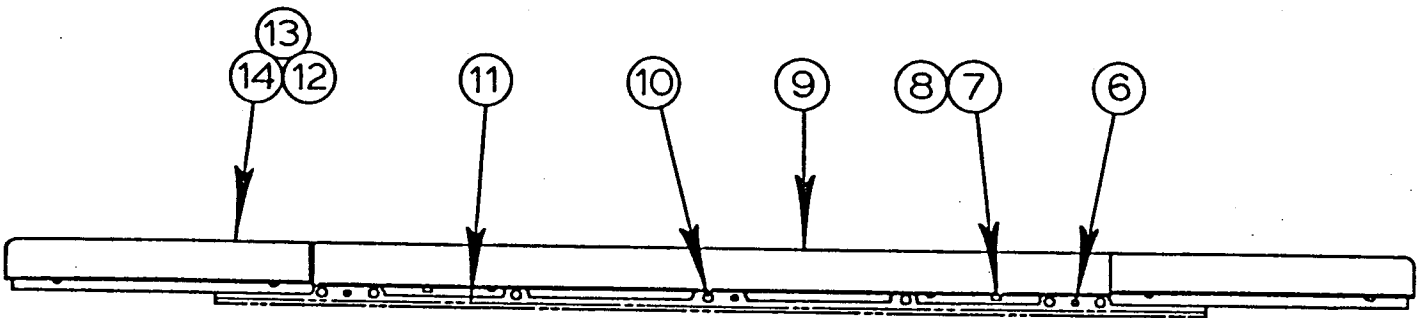
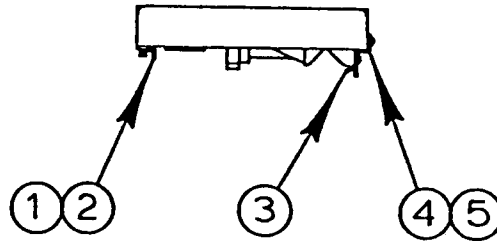
SPINDLE ADAPTORS

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
1	4678	L. H. Wheel Adaptor Nut (Used in Assemblies:) 14-06555, 11895, 11893, 103011, 11894, 10364, 10771, 10030 & 10029	1
	24231	Wheel Retainer (Used in Ass'y #24230)	1
	24484	Wheel Retainer (Used in Ass'y #24483)	1
	24227	Wheel Retainer (Used in Ass'y #24228)	1
2	23736	Wheel Adaptor (Used in Ass'y #14-06555)	1
	4677	Wheel Adaptor (Used in Ass'y #11895, #11893 & #103011)	1
	5803	Wheel Adaptor (Used in Ass'y #11894)	1
	24364	Wheel Adaptor (Used in Ass'y #10364 & #10029)	1
	24839	Wheel Adaptor (Used in Ass'y #10771)	1
	24366	Wheel Adaptor (Used in Ass'y #10030)	1
	42856	Wheel Adaptor (Used in Ass'y #24230 & #24483)	1
	42780	Wheel Adaptor (Used in Ass'y #24228)	1
3	10033	Adaptor Flange (Used in Assemblies 11893, 11894, 10364 & 10771)	2
	18266	Adaptor Flange (Used in Ass'y #103011)	2
4	10032	Balance Weight (Used in Assemblies #10364, #10771, #10029, & 10030)	2
5	199257	Washer #8 Medium (Used in Assemblies #10364, #10771, #10029, & 10030)	2
	199258	Washer #10 (Used in Ass'y #24230)	2
6	198210	Screw, Soc. Hd. Cap #8-32NC x 3/8 (Used in Assemblies #10364, #10771, #10029, & #10030)	2
		Screw, Soc. Hd. Cap 1/4-28NF x 1 3/4 (Used in Assemblies #24230, #24228, & #24483)	
		Screw, Soc. Hd. Cap #10-24NC x 3/8 (Used in Ass'y #24230)	2

REVISED AND
REDRAWN

S.C.L. 7-10-85

RIGHT SIDE VIEW



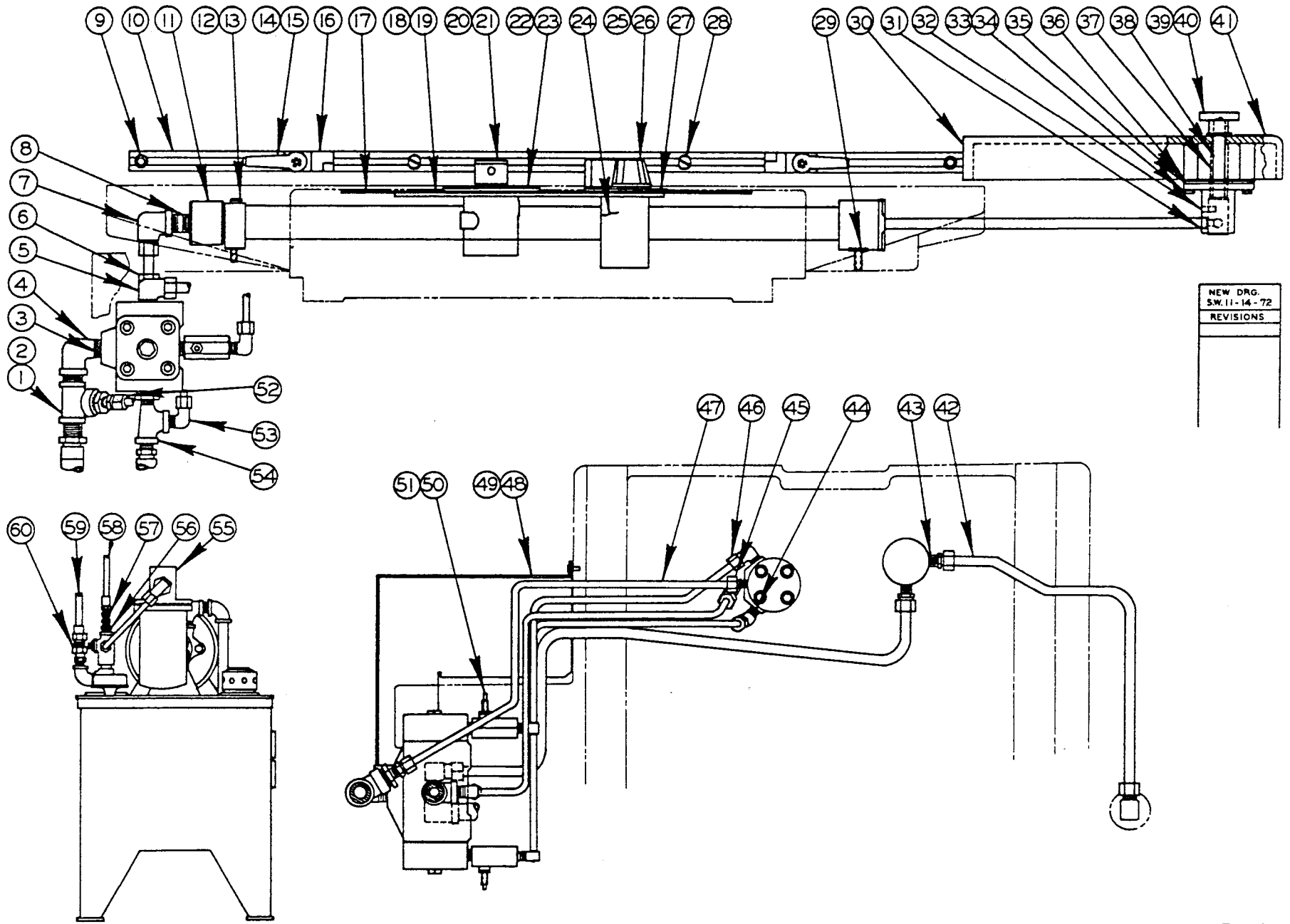
<u>MODEL</u>	<u>FIRST MACH.</u>	<u>LAST MACH.</u>
DH-618	292-70101	292-76218
G-618M	453-85101	453-90266

TABLE ASSEMBLY

CODE NO. F7-5.10

TABLE ASSEMBLY

INDEX Ref.	PART	DESCRIPTION	UNITS PER
1	095-008033	Table Assembly	
2	094-042223	. Dust Guard.....	1
3	091-988519	. Screw, Rd. Hd. Mach. #8-32NC X 1/4.....	7
4	090-396391	. Table Skirt.....	1
5	093-019115	. Dust Guard.....	2
6	091-988675	. Screw, Rd. Hd. Mach. #10-24NC X 3/8.....	12
7	135-005163	. Dowel Pin.....	3
8	091-982355	. Screw, Soc. Hd. Cap 1/4-20NC X 3/8.....	2
9	090-035593	. Washer, Lock 1/4 Hi-Collar.....	A.R.
10	095-008017	. Table.....	1
11	091-982389	. Screw, Soc. Hd. Cap 1/4-20NC X 5/8.....	7
12	090-391434	. Rack.....	1
13	094-024734	. Apron.....	2
14	091-221937	. Seal Plate (Remove when cool & flood grind option is supplied).....	1
	091-980086	. Screw, Hex. Hd. Cap 1/4-20NC X 3/4.....	6



NEW DRG.
SW.11-14-72
REVISIONS

F7-31

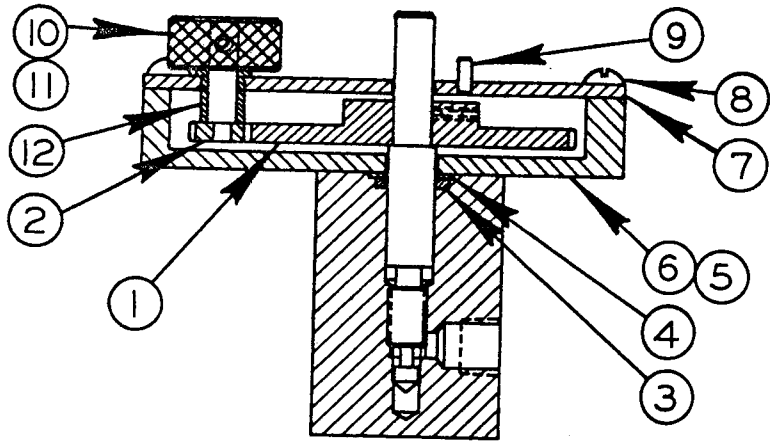
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HYDRAULIC TABLE ASSEMBLY

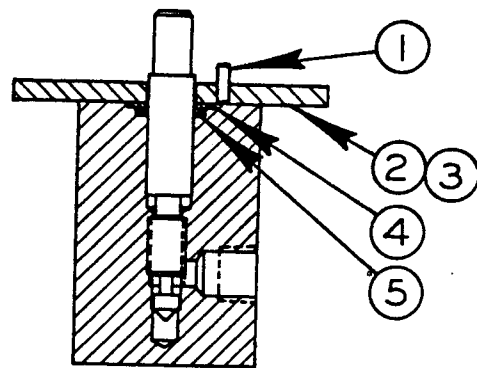
MODEL FIRST MACH. LAST MACH.
DH-618 292-70101 292-76216

HYDRAULIC TABLE ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	501278	Hydraulic Table Assembly	
1	35-983	. Tee.....	1
2	35-1127	. Close Nipple	1
3	39765	. 4-Way Valve Assembly(See Detail).....	1
4	5-11513	. 90° Street Elbow.....	1
5	10409	. 90° Male Elbow.....	2
6	8138	. Male Connector.....	1
7	124427	. 90° Female Elbow	1
8	35-986	. Nipple.....	1
9	198238	. Screw, Soc. Hd. Cap 1/4-20NC x 5/8.....	2
10	39959	. Tee Bar Weldment.....	1
11	401664	. Table Cylinder Assembly(See Detail).....	1
12	198247	. Screw, Soc. Hd. Cap 1/4-20NC x 2.....	4
13	3559	. Washer, Lock.....	4
14	13809	. Locking Lever	2
15	124243	. T-Bolt.....	2
16	124242	. Slide Block.....	2
17	29266	. Tool Pad.....	1
18	101868	. Plate.....	1
19	198319	. Screw, Flat., Soc. Hd. Mach. 1/4-20NC x 1/2	5
20	102431	. Reverse Lever Assembly.....	1
21	198411	. Screw, Soc. Set #10-24NC x 3/8.....	1
22	28930	. Pilot Valve Sub-Assembly(See Detail).....	1
23	198236	. Screw, Soc. Hd. Cap 1/4-20NC x 1/2.....	3
24	300209	. Valve Assembly(See Detail).....	1
25	300208	. Knob.....	1
26	4237	. Roll Pin.....	1
27	124240	. Table Speed Escutcheon.....	1
28	198761	. Screw, Flat Hd. Mach. 1/4-20NC x 5/8.....	2
29	35-8541	. "O"-Ring.....	1
30	403059	. Apron.....	1
31	101496	. Bracket	1
32	16352	. Dowel.....	1
33	198241	. Screw, Soc. Head Cap 1/4-20NC x 7/8.....	4
34	3559	. Washer, Lock 1/4 High Collar.....	4
35	124429	. Plate.....	1
36	1966	. Shim.....	A.R.
37	101296	. Spring.....	1
38	100650	. Shaft.....	1
39	101295	. Knob.....	1
40	198409	. Screw, Soc. Set #10-24NC x 3/16.....	2
41	113515	. Escutcheon.....	1
42	Stk #203	. Tube.....	A.R.
43	35-3521	. Male Connector.....	2
44	9520	. 45° Male Elbow.....	1
45	14-115195	. Male Connector.....	1
46	14-115194	. 90° Male Elbow.....	4
47	Stk #202	. Tube.....	A.R.
48	403062	. Cover Weldment.....	1
49	198346	. Screw, Button Hd. Cap #8-32NC x 3/8.....	3
50	112318	. Flow Control Valve.....	2
51	14-14528	. Close Nipple.....	2
52	9273	. Male Connector.....	1
53	12086	. 90° Male Elbow.....	1
54	35-847	. Service Tee.....	1
55	56630	. Hyd. Tank & Pump Assembly (See Detail)	1
56	5-11517	. Reducer Bushing.....	3
57	8151	. Adapter Union.....	1
58	101221	. Hose 3/8 I.D.....	1
59	119343	. Hydraulic Hose 1/2 I.D.....	1
60	14-115109	. Adapter Union.....	1



301816
VALVE ASSEMBLY



300209
VALVE ASSEMBLY

NEW DRG.
S.W. 11-8-72
REVISIONS
S.W. 8-2-76
W.V.M. 4-18-77

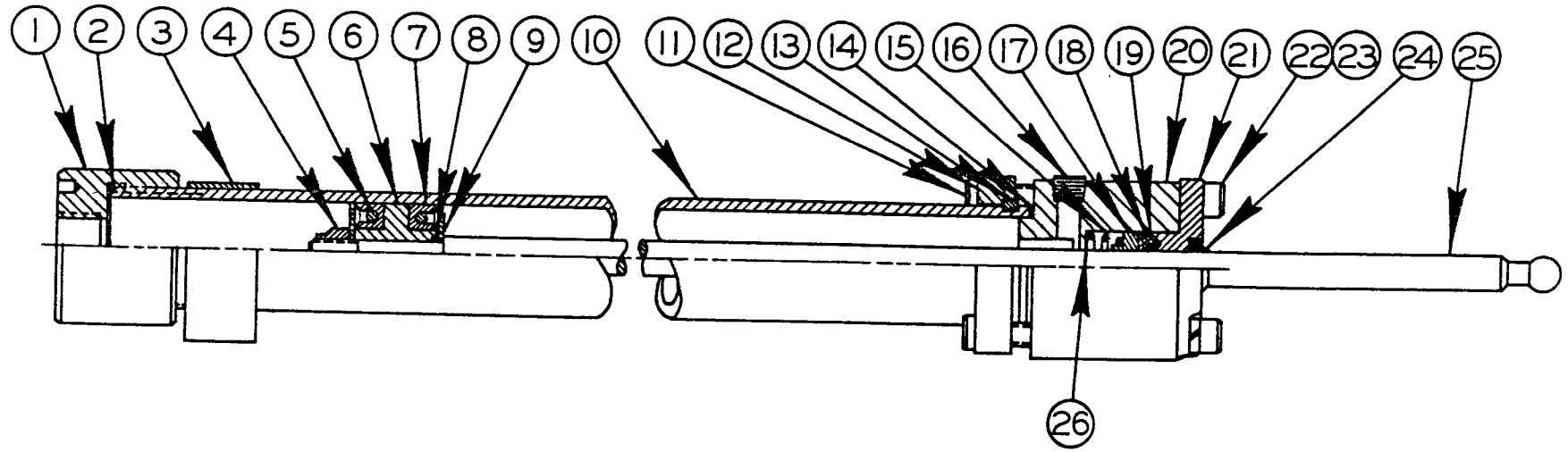


TABLE CYLINDER ASSEMBLY

MODEL	FIRST MACH.	LAST MACH.
DH612	138-713399	138-763745
DH618	292-70101	292-76218

F7-2.7.2

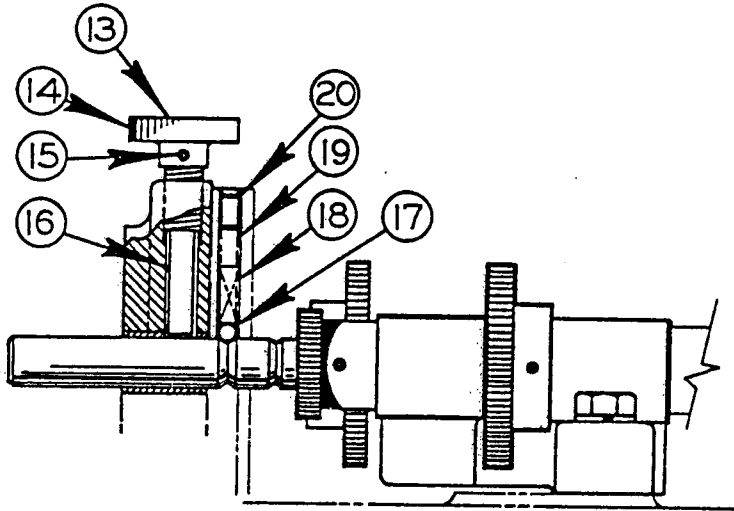
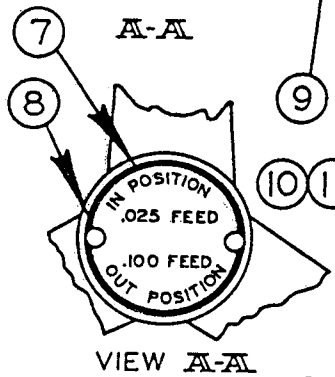
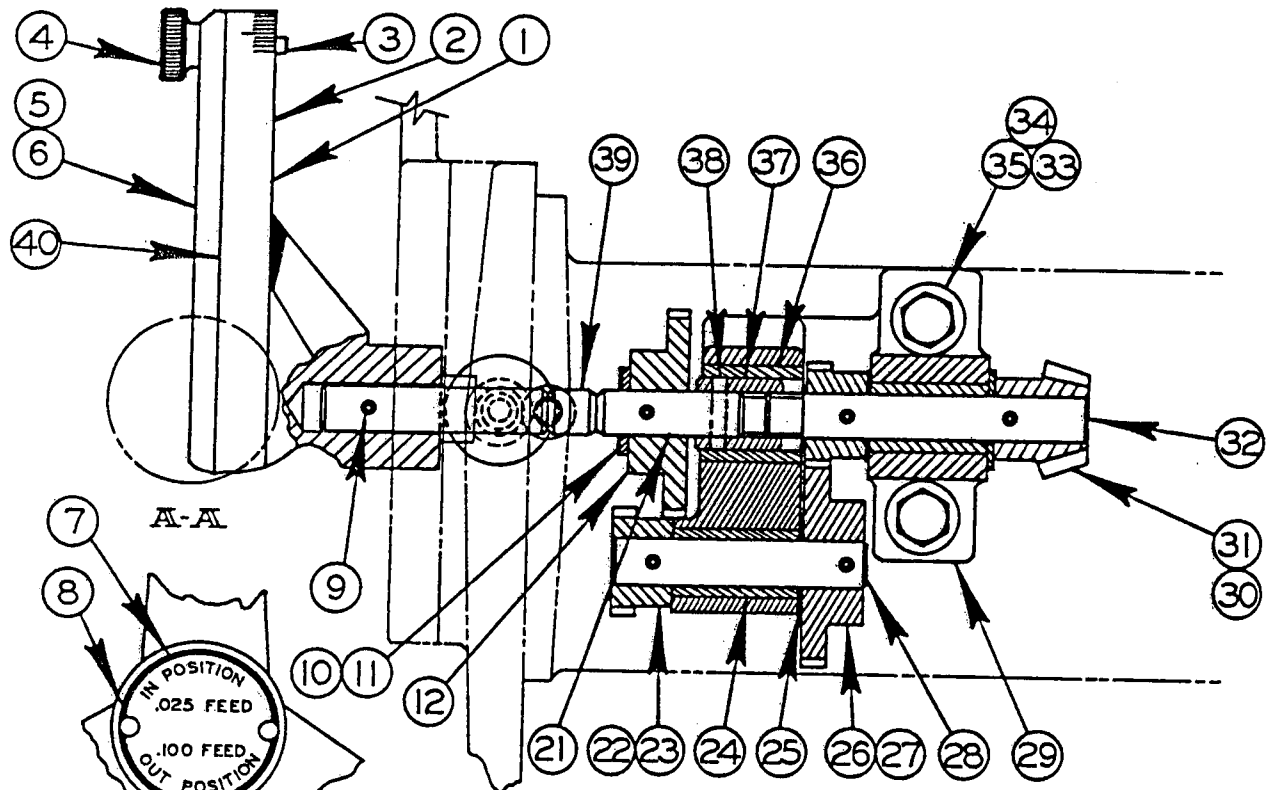
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CYLINDER AND VALVE ASSEMBLIES

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	300209	Valve Assembly (DH612 & DH618)	
1	4223	. Roll Pin.....	1
2	101504	. Plate.....	1
3	198759	. Screw, Flat Hd. Mach. 1/4-20NC x 1/2.....	3
4	101505	. Washer.....	1
5	4122	. "O" Ring.....	1
Ref.	301816	Valve Assembly (DH612 only)	
1	129472	. Gear.....	1
2	17482	. Shaft and Pinion Assembly.....	1
3	35-8727	. "O" Ring.....	1
4	130884	. Washer.....	1
5	301679	. Gear Box.....	1
6	198759	. Screw, Flat Hd. Mach. 1/4-20NC x 1/2.....	3
7	129471	. Plate.....	1
8	198867	. Screw, Rd. Hd. Mach. #10-24NC x 3/8.....	4
9	4223	. Roll Pin.....	1
10	129470	. Knob.....	1
11	4233	. Roll Pin.....	1
12	121275	. Bearing.....	1
Ref.	47271	Table Cylinder Assembly(DH612)	
Ref.	401664	Table Cylinder Assembly(DH618)	
1	100901	. Cylinder Cap.....	1
2	8022	. "O" Ring.....	1
3	106811	. Mounting Block.....	1
4	100902	. Locknut.....	1
5	110149	. "O" Ring.....	2
6	103131	. Piston.....	1
7	110141	. "U" Cup.....	2
8	1512	. "O" Ring.....	1
9	11222	. Washer.....	2
10	30318	. Cylinder (Use on Ass'y #47271).....	Use
	38472	. Cylinder (Use on Ass'y #401664).....	One
11	198239	. Screw, Soc. Hd. Cap 1/4-20NC x 3/4.....	4
12	101421	. Cylinder Collar.....	1
13	101420	. Retainer Ring.....	2
14	101422	. Gasket.....	1
15	100896	. Spring.....	1
16	11794	. Pipe Plug.....	1
17	103121	. Adaptor Ring.....	1
18	109881	. Fab Chevron Packing Ring.....	1
19	109882	. Homo Chevron Packing.....	2
20	103132	. Cylinder Head.....	1
21	103123	. Packing Cap.....	1
22	198238	. Screw, Soc. Hd. Cap 1/4-20 x 5/8.....	4
23	3559	. Lock Washer.....	8
24	100925	. Scraper Ring.....	1
25	100924	. Rod (Use on Ass'y #47271).....	Use
	120653	. Rod (Use on Ass'y #401664).....	One
26	133328-133331	. Spacer.....	A.R.

NOTE: To replace valve body and valve stem, order complete valve assembly.

REVISED AND REDRAWN
S.W. 10-12-72
W.M. 4-18-77



DUAL RANGE
VERTICAL FEED CONTROL

MODEL	FIRST MACH.	LAST MACH.
DH-612	138-61645	138-763745
MTM-612	184-61108	184-71158
DH618	292-70101	292-76218

FB-5.6.1 G6-14

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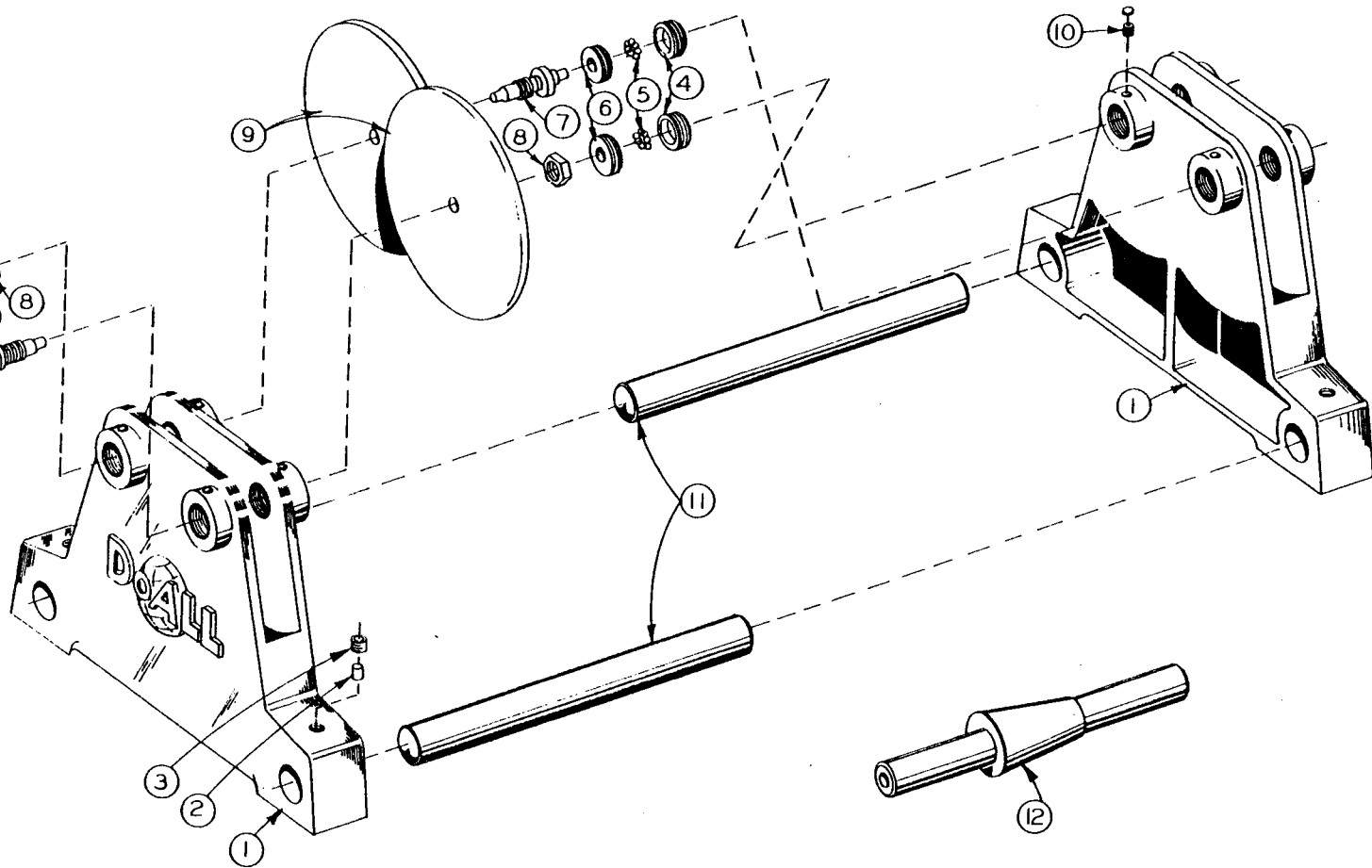
CODE NO. F8-5.6.1
G6-1.4

DUAL RANGE

VERTICAL FEED CONTROL

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	46354	Dual Range Vertical Feed Control	
1	105608	. Handwheel Sub-Assembly.....	1
2	101873	. . Handwheel Sub-Assembly	1
3	18171	. . . Clamp Stud.....	1
4	18889	. . . Knob.....	1
5	49185	. . . Handwheel.....	1
6	34-05513	. . . Handle.....	1
7	104179	. . Escutcheon.....	1
8	Comm.	. . Screw, Drive #2 x 3/16 PK Type "U".....	2
9	4235	. Roll Pin.....	2
10	35-7708	. Spacer.....	A.R.
11	Comm.	. Washer, Flat 1/2 S.A.E.....	1
12	103160	. Spur Gear.....	1
13	105609	. Knob Sub-Assembly.....	1
14	104851	. . Knob.....	1
15	4225	. . Roll Pin	1
16	104759	. . Lock Screw	1
17	34-01518	. Ball.....	1
18	2329	. Spring.....	1
19	Comm.	. Screw, Soc. Set 5/16-18NC x 3/8(Cone Pt.).....	1
20	Comm.	. Screw, Soc. Hd. Set 5/16-18NC x 3/8.....	1
21	31666	. Gear and Shaft Sub-Assembly.....	1
22	103159	. . Spur Gear.....	2
23	4231	. . Roll Pin.....	2
24	104048	. . Bearing	2
25	35-7708	. . Spacer	A.R.
26	103160	. . Spur Gear.....	1
27	4235	. . Roll Pin.....	1
28	103158	. . Shaft.....	1
29	46466	. . Support Block.....	1
30	17818	. . Pinion Gear.....	1
31	4230	. . Roll Pin.....	1
32	30753	. . Spline Shaft.....	1
33	Comm.	. Screw, Hex. Hd. Cap 3/8-16NC x 1 1/2.....	2
34	Comm.	. Washer, Lock 3/8 Std.....	2
35	17819	. Shim.....	A.R.
36	104047	. . Bearing.....	1
37	30749	. . Spline.....	1
38	4227	. Roll Pin.....	1
39	103801	. . Connecting Shaft	1
40	28481	. . . Ring.....	1

F9-3.0



WHEEL BALANCING STAND

FOR ALL GRINDERS

PRINTED IN U.S.A.

ADH 1-14-62

CODE NO. F9-3.0

WHEEL BALANCING STAND

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y
Ref.	51633	Wheel Balancing Stand Assembly	
1	52005	. Bracket.....	2
2	10305	. Brass Plug.....	4
3	198434	. Screw, Soc. Set 5/16-18NC x 1/4.....	4
4	7666	. Outer Nut.....	8
5	34-01518	. Steel Ball.....	48
6	7667	. Inner Nut.....	8
7	7915	. Spindle.....	4
8	199128	. Nut, Hex. Jam 3/8-24NF.....	4
9	7913	. Wheel.....	4
10	101023	. Set Screw.....	8
	101024	. Plug.....	8
11	7668	. Rod.....	2
*12	23152	. Arbor (1 9/16" Dia. x 8 1/2").....	1
	23153	. Arbor (1" Dia. x 7").....	1
	26161	. Arbor (2" Taper 2 1/8" Dia. x 8 1/2").....	1

*NOTE: Starred items are not part of wheel balancing #51633. Order as required.

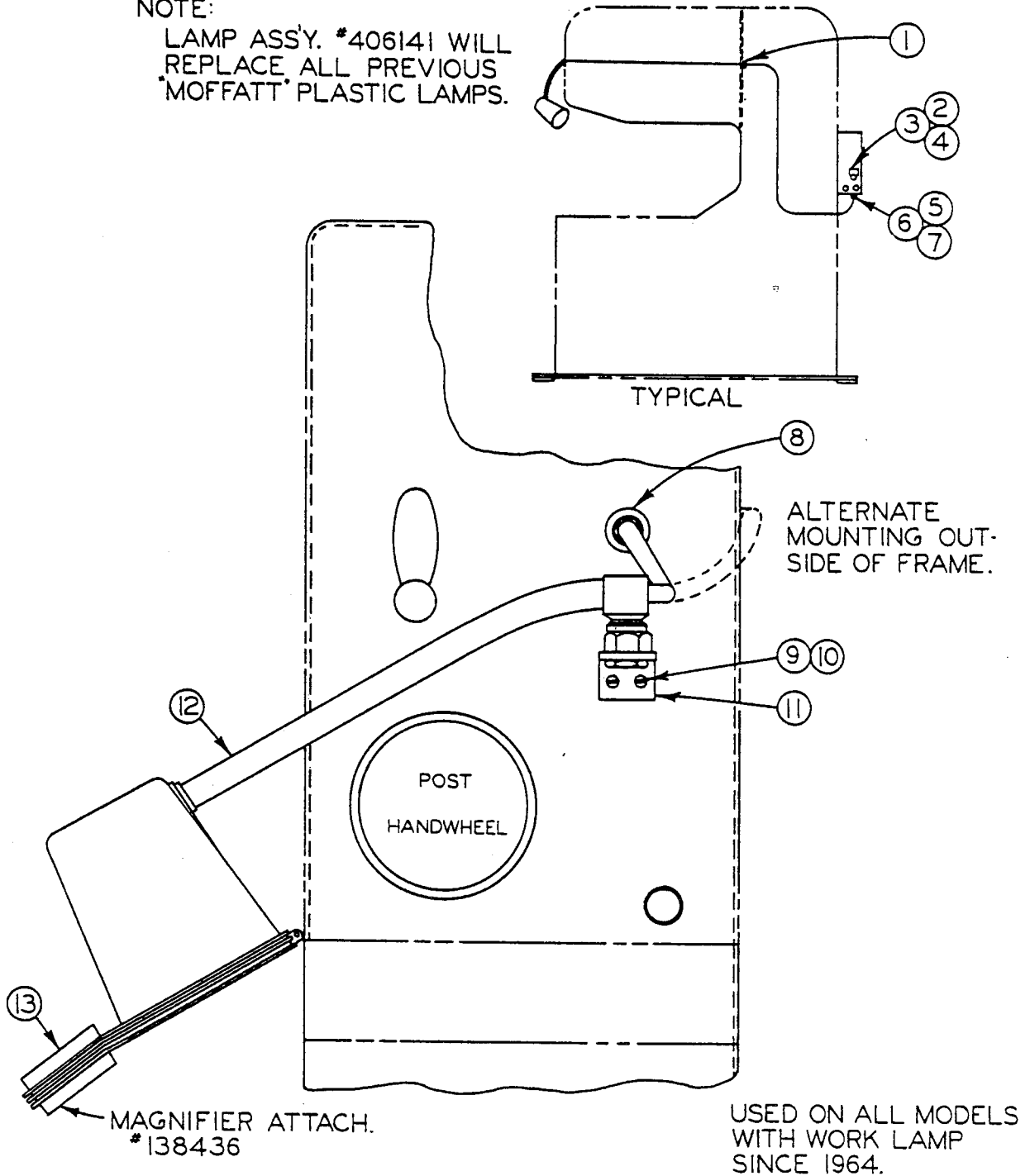
Q.S.H.A. REQUIREMENT:

WIRE WORK LAMP DIRECT TO CONTROL BOX. MOUNT LAMP SWITCH ON SIDE OF CONTROL BOX OR THE CONTROL PANEL.

REVISIONS
REDRN
5-23-75 W.S.

NOTE:

LAMP ASS'Y. #406141 WILL REPLACE ALL PREVIOUS 'MOFFATT' PLASTIC LAMPS.



LAMP & MAGNIFIER ASSEMBLIES

C-8-8 CM-8-31 PS-8-103 TF-4-100 F9-6.1 Z-7-61

PRINTED IN U.S.A.

CODE NO.	C-8-8
	CM-8-31
	PS-8-103
	TF-4-100
	F9-6.1
	Z-7-61

LAMP & MAGNIFIER

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	406141	Lamp Ass'y.	
1	15745	. Bushing	1
2	15245	. Selector Switch, 2-Postion	1
3	104820	. Contact Block	1
4	133359	. Legend Plate	1
5	14545	. Cord Grip Connector	1
6	14411	. Washer	1
7	14505	. O-Ring	1
8	15139	. Cord Grip	1
9	198865	. Screw, Rd. Hd. Mach. #10-24UNC x 1/4	2
10	199319	. Washer, Lock #10 Std.	2
11	102504	. Bracket	1
12	138452	. Lamp Sub-Ass'y., 19" Flexible Cable, 11'-1/2" Connecting Cord	1
13	138436	Magnifier Attachment, Mounts to Lampshade on Lamp Part #138452.	1

