

PARTS LIST

FOR

BARDONS & OLIVER

No. 312 & No. 314

CUTTING-OFF LATHES

When Ordering:

1. Specify the number of parts required.
2. Give the code number, name, and drawing number of the part exactly as shown in the Parts List.
3. Give the size and serial number of the machine. *
4. Give the purchase order covering the original machine.

Example:

Required: Rapid Forward Dog for the Hydraulic Cutoff - Unit D

Order:

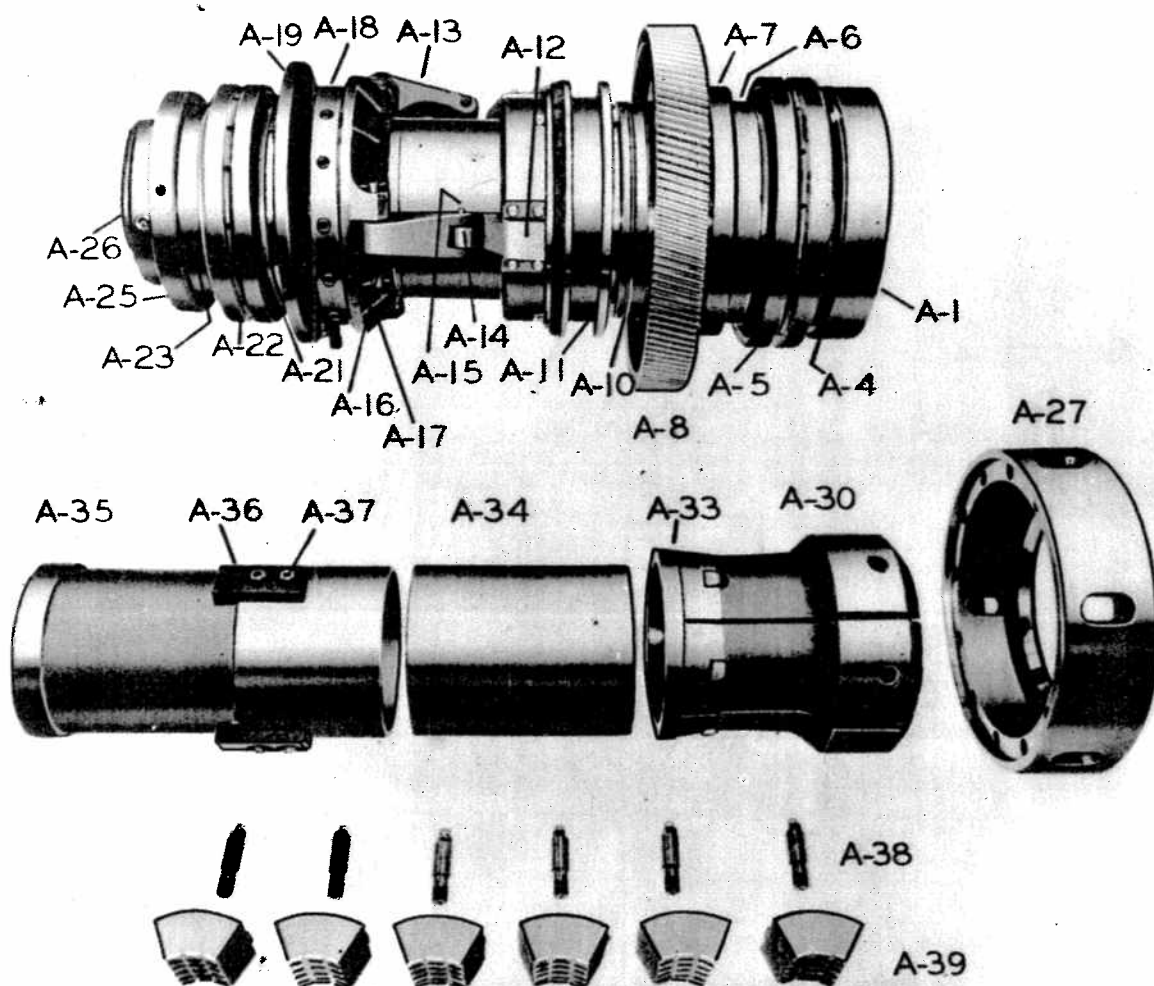
1 D-24 Rapid Forward Dog, B-66067 for No. 312 Cutting-Off Lathe, Serial No. 18760, Purchase Order S-2272.

* The serial number is stamped on the speed plate and the motor housing flange.

Note: N.S. after a part name indicates the part is not shown on the accompanying photo.

BARDONS & OLIVER INC.
1133 WEST 9TH. ST.
CLEVELAND 13, OHIO

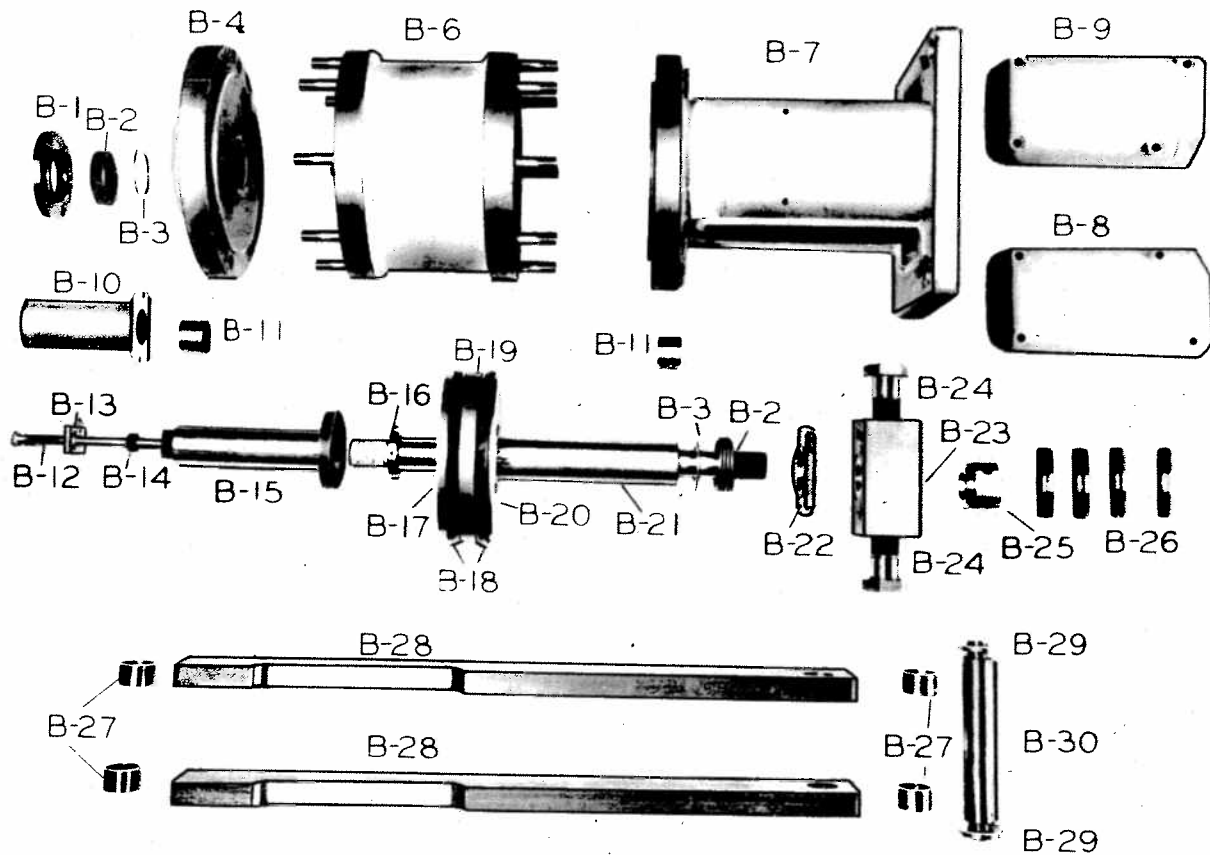
SPINDLE - UNIT 'A'



A-1	Spindle		A-65952	A-21	Rear Brg. Ring		B-65956
A-2	Front Brg. Retainer	N.S.	A-65943	A-22	Rear Bearing	(2)	EE-241701
A-3	Front Brg. Ret. Gasket	N.S.	A-66769			(1)	242377-D
A-4	Front Brg. Oil Thrower		B-65955	A-23	Rear Nut Spacer		A-65949
A-5	Front Bearing	(2)	EE-243190	A-24	Rear Brg. Ret. Outer	N.S.	A-65946
		(1)	243251-D	A-25	Rear Bearing Nut		A-65950
A-6	Front Nut Spacer		A-65947	A-26	Spindle End Bushing		A-65965
A-7	Front Brg. Nut & Shoe		A-65948	A-27	Collet Ring		A-65974
A-8	Head Gear		A-65953	A-28	Collet Ring Stud	N.S. (12)	C-2158
A-9	Head Gear Key	N.S.	B-65957	A-29	Stud Nut	N.S. (12)	B-54198
A-10	Head Gear Nut & Screws		A-65954	A-30	Collet		A-65973
A-11	Wedge Assembly		A-65967	A-31	Loading Ring	N.S.	B-65972
A-12	Wedge Roller Shoe	(3)	A-65944	A-32	Collet Spring	N.S. (12)	B-60167
A-13	Finger	(3)	A-66443	A-33	Hinge Ring		A-65975
A-14	Finger Roller	(3)	B-52692	A-34	Plunger		A-66007
A-15	Roller Pin	(3)	B-63244	A-35	Follower & Extension Assem.		A-65964
A-16	Finger Pivot Pin	(3)	B-63242	A-36	Follower Shoe	(3)	A-65966
A-17	Finger Holder		A-65960	A-37	Follower Shoe Screw	(6)	B-69416
A-18	Adjusting Nut & Shoe		A-65963	A-38	Collet Pad Screw	(6)	B-65977
A-19	Rear Brg. Ret. Inner		A-65945	A-39	Collet Pads		* A-65976
A-20	Rear Brg. Ret. Gasket	N.S. (2)	A-66770	A-40	Inner Plunger	N.S.*	A-67788

* Specify O.D. of Pipe or Tube

AIR CYLINDER - UNIT 'B'



B-1	Front Packing Gland		A-67380	B-19	Packing Plate	B-31244
B-2	Packing	(2)	B-67374	B-20	Piston	A-52941
B-3	Packing Plate	(2)	B-67371	B-21	Piston Rod	A-67377
B-4	Cylinder Head		A-67381	B-22	Packing Gland	A-68295
B-5	Cylinder Gasket	N.S. (2)	B-52727	B-23	Slide Block	A-67376
B-6	Cylinder		A-38941	B-24	Link Lock Screw	(2) A-52519
B-7	Bracket		A-67382	B-25	Piston Rod Lock Nut	B-31142
B-8	Link Cover Front		A-31316	B-26	Stud	1911
B-9	Link Cover Rear		A-31339	B-27	Bushing	(4) B-52518
B-10	Adj. Sleeve Guard		A-67378	B-28	Link	(2) A-53535
B-11	Bushing	(2)	B-67373	B-29	Stud Collar	(2) B-52517
B-12	Lock Screw		B-70594	B-30	Link Stud	B-52516
B-13	Packing Gland		B-67372	B-31	Yoke	N.S. A-38715
B-14	Adj. Sleeve Packing		B-65687	B-32	Yoke Shoes	N.S. Note 1
B-15	Adj. Sleeve		A-67379	B-33	Yoke Shoe Stud	N.S. Note 1
B-16	Piston Lock Nut		A-67375	B-34	Yoke Shaft	N.S. A-38716
B-17	Follower		B-31245	B-35	Link Stud Bushing	N.S. (2) B-32310
B-18	Packing Cup	(2)	68579	B-36	Solenoid Air Valve	N.S.

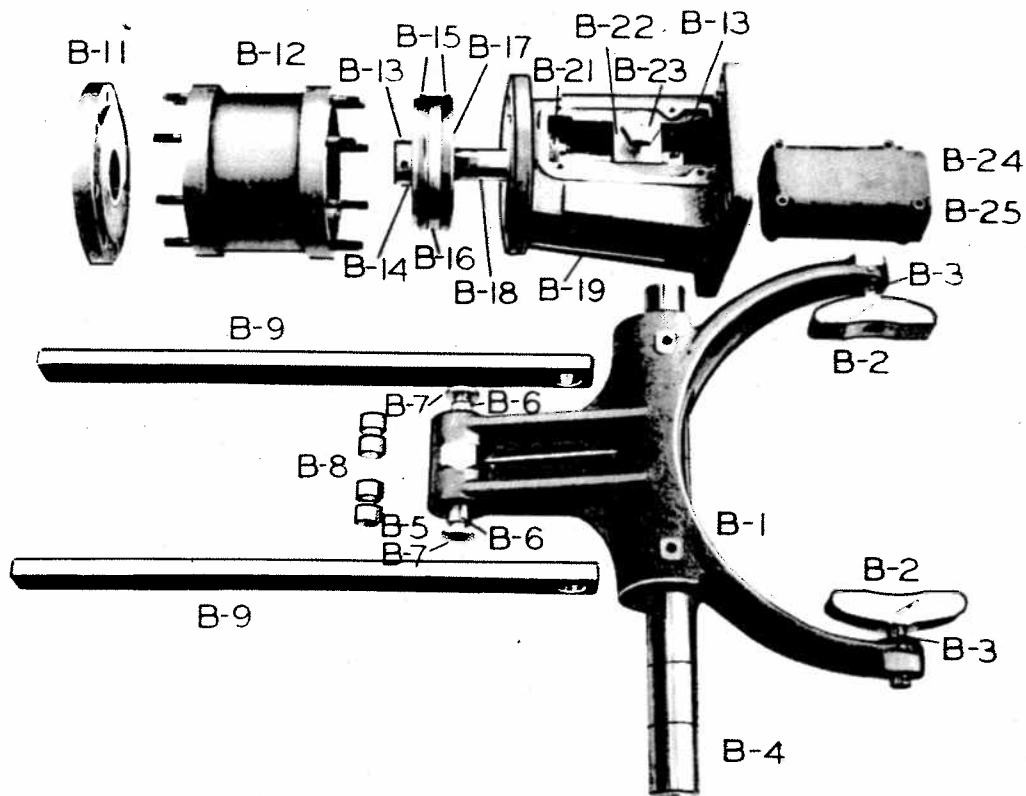
Note 1

B-32	Yoke Shoe
B-33	Yoke Shoe Stud

No. 312 No. 314

B-65961	B-58330
B-65970	B-65934

AIR CYLINDER - UNIT 'B'



B-1	Yoke		A-38715	B-15	Packing Cup	(2)	66573
B-2	Yoke Shoes	(2)	Note 1	B-16	Packing Plate		B-31244
B-3	Yoke Shoe Stud		Note 1	B-17	Piston		A-52941
B-4	Yoke Shaft		A-38716	B-18	Piston Rod		A-38942
B-5	Link Stud		B-52516	B-19	Bracket		A-31290
B-6	Link Stud Bushing	(2)	B-32310	B-20	Packing	N.S.	B-31597
B-7	Stud Collar	(2)	B-52517	B-21	Packing Gland		B-31243
B-8	Link Bushing	(4)	B-52518	B-22	Slide Block		A-31269
B-9	Link	(2)	A-53535	B-23	Link Lock Screw	(2)	B-52519
B-10	Solenoid Air Valve	N.S.		B-24	Link Cover Front		A-31316
B-11	Cylinder Head		B-31283	B-25	Link Cover Rear		A-31339
B-12	Cylinder		A-36941	B-26	Packing Gasket	N.S. (4)	B-52729
B-13	Piston Rod Nut	(2)	B-31142	B-27	Cylinder Gasket	N.S. (2)	B-52727
B-14	Follower		B-31245				

Note 1

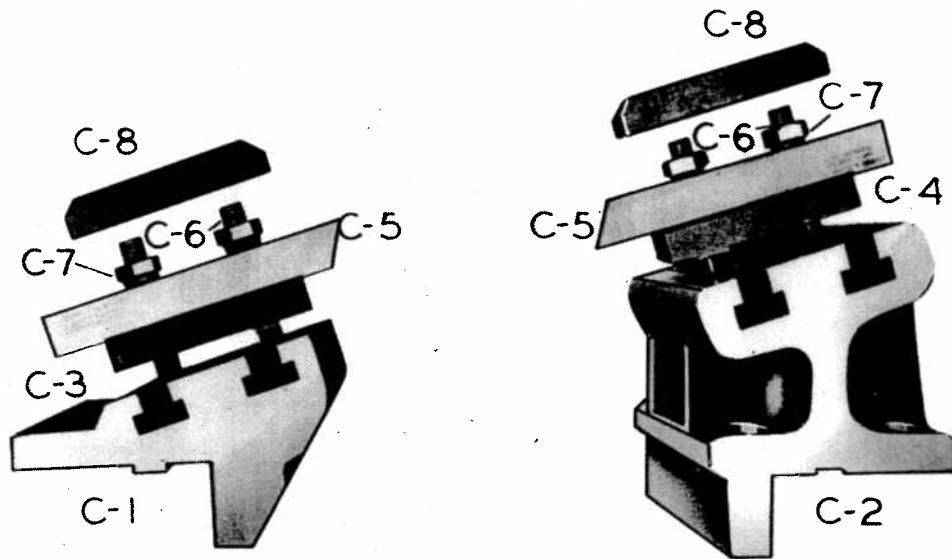
No. 312

No. 314

Yoke Shoe (2) B-65961
Yoke Shoe Stud (2) B-65970

(2) B-56330
(2) B-65934

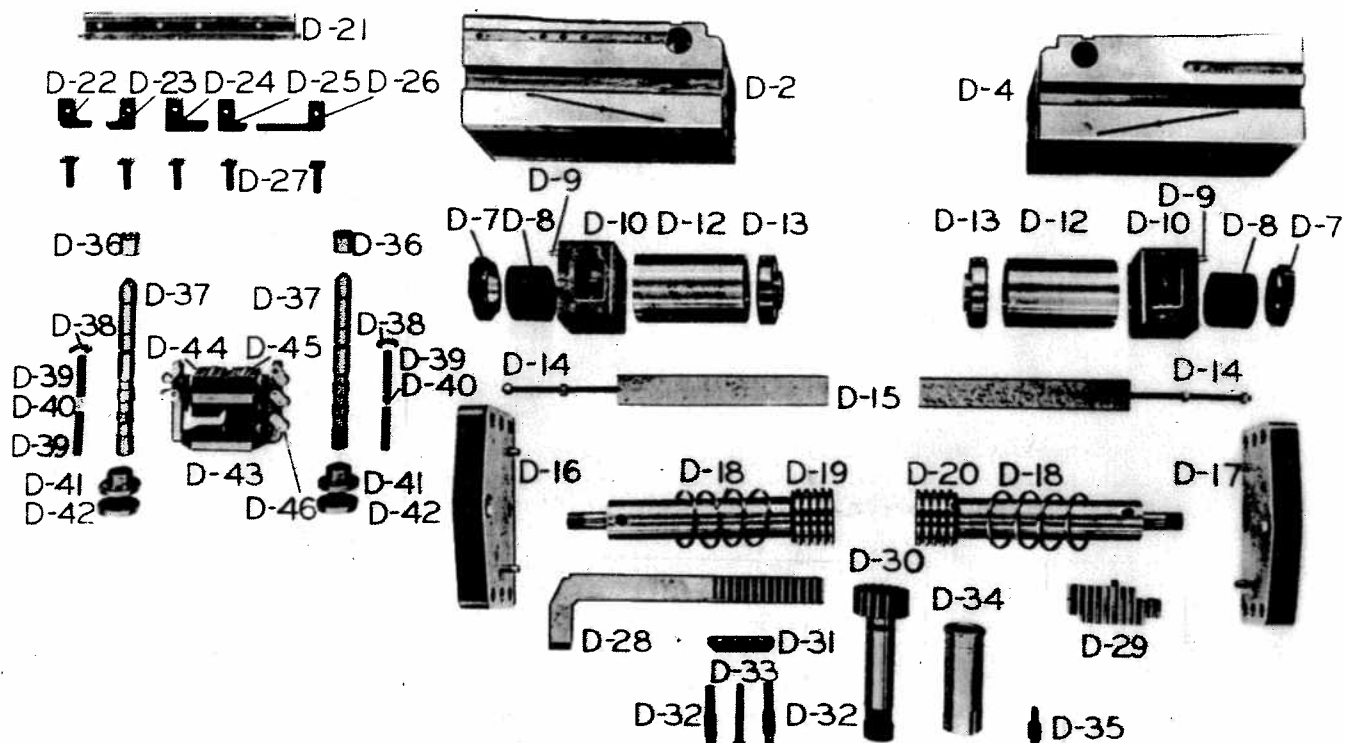
TOOL HOLDERS - UNIT 'C'



C-1 Front Tool Holder Base
 C-2 Rear Tool Holder Base
 C-3 Front Tool Holder
 C-4 Rear Tool Holder
 C-5 Blade
 C-6 Tee Bolt
 C-7 Clamp Nut
 C-8 Front & Rear Cap

	No.312-314	No.316
	A-40133	A-61227
	A-40134	A-61226
	A-31049	A-31049
	A-30936	A-30936
	B-27793	B-27793
(4)	B-60462	B-60462
(4)	B-31072	B-31072
(2)	B-30937	B-30937

HYDRAULIC CUTOFF - UNIT 'D'



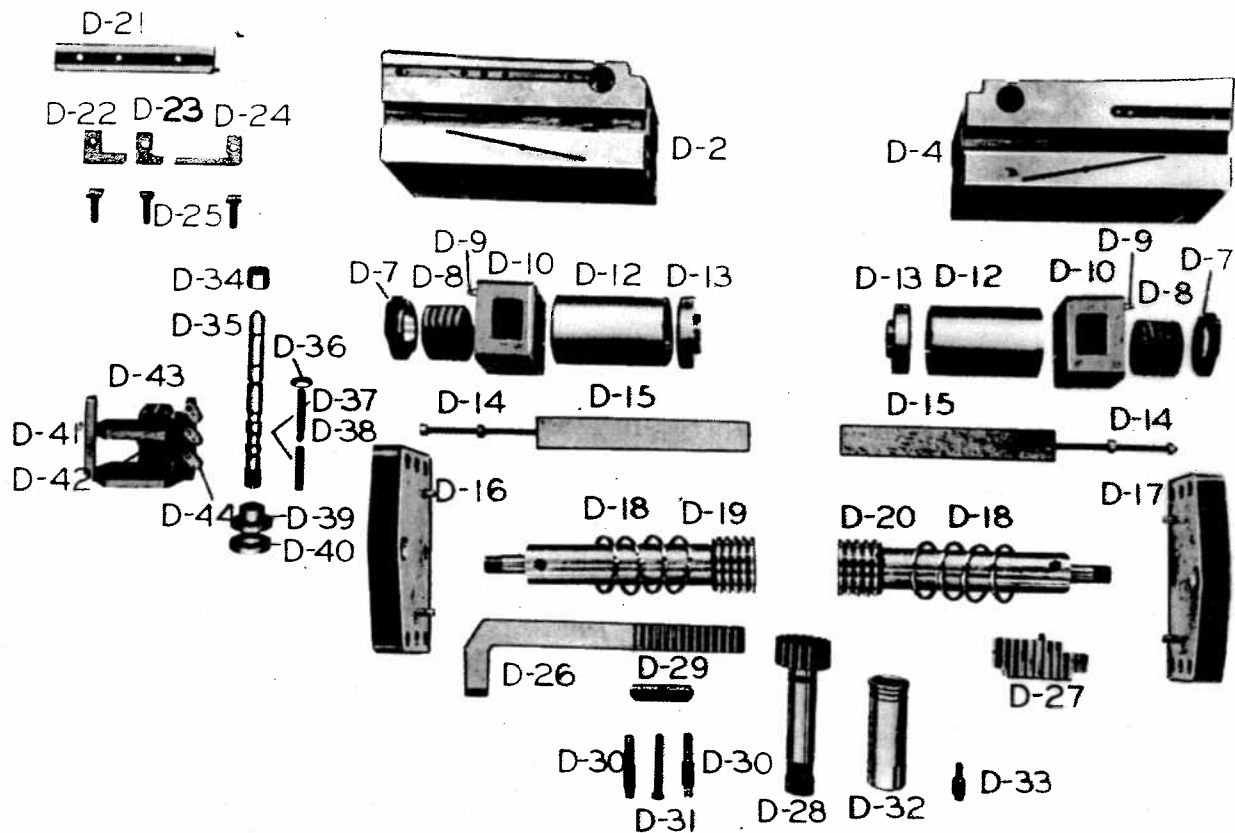
D-1	Saddle	N.S.	L-66560	D-26	Rapid Forward Dog		B-60067
D-2	Front Slide		L-66558	D-27	Tee Bolt	(5)	B-52522
D-3	Front Slide Caps	N.S.	A-66569-70	D-28	Equalizing Rack Long		A-66579
D-4	Rear Slide		L-66559	D-29	Equalizing Rack Short		A-32536
D-5	Rear Slide Caps	N.S.	A-66571-2	D-30	Equalizing Pinion		A-38881
D-6	Slide Wear Strips	N.S. (4)	A-64397	D-31	Rack Shoe		B-32526
D-7	Packing Gland	(2)	B-32790	D-32	Rack Shoe Stud	(2)	B-60983
D-8	Packing	(2)	B-32866	D-33	Hex Head Cap Screw		5/8 x 6
D-9	Air Cock	(4)	201-E	D-34	Pinion Bushing		B-32529
D-10	Cylinder Head	(2)	A-38887	D-35	Bushing Lock Screw		B-31308
D-11	Cyl. Hd. Bushing	N.S. (2)	B-32791	D-36	Control Rod Bushing	(2)	B-60085
D-12	Oil Cylinder	(2)	A-32530	D-37	Control Rod	(2)	A-66575
D-13	Cyl. Head Inner	(1 Ea.)	A-32534	D-38	Washer	(2)	B-60078
D-14	Gib Adj. Stud	(2)	B-66564	D-39	Spring	(4)	B-60090
D-15	Taper Gib	(2)	A-61079	D-40	Spacer	(2)	B-56285
D-16	Front End Plate		A-66561	D-41	Rod Locator	(2)	B-60084
D-17	Rear End Plate		A-66562	D-42	Spring Cap	(2)	B-60086
D-18	Piston Rings	(8)	B-33366	D-43	Switch Bracket		A-60061
D-19	Front Piston Rod	Note 1		D-44	Micro-Switch L.H.	(2)	
D-20	Rear Piston Rod	Note 1		D-45	Micro-Switch R.H.	(3)	
D-21	Tee Slot Bracket		A-66578	D-46	Roller Assembly	(5)	B-60072
D-22	Stock Stop Dog		B-60068	D-47	Roller Spring	N.S. (3)	B-60070
D-23	Collet Dog		B-60069	D-48	Roller Spring	N.S. (2)	B-39812
D-24	Rapid Return Dog		B-60066	D-49	Oil Pot	N.S.	A-56288
D-25	Feed Dog		B-60065	D-50	Front Cover	N.S.	A-60077

Note 1

No. 312 No. 314

D-19	Front Piston Rod	A-66576	A-67771
D-20	Rear Piston Rod	A-66577	A-67772

HYDRAULIC CUTOFF - UNIT 'D'



D-1	Saddle	N.S.	L-66560	D-25	Tee Bolt	(3)	B-52522
D-2	Front Slide		L-66558	D-26	Equalizing Rack Long		A-66579
D-3	Front Slide Caps	N.S.	A-66569-70	D-27	Equalizing Rack Short		A-32536
D-4	Rear Slide		L-66559	D-28	Equalizing Pinion		A-38881
D-5	Rear Slide Caps	N.S.	A-66571-2	D-29	Rack Shoe		B-32526
D-6	Slide Wear Strips	N.S.	(4) A-64397	D-30	Rack Shoe Stud	(2)	B-60983
D-7	Packing Gland		(2) B-32790	D-31	Hex Head Cap Screw		5/8 x 6
D-8	Packing		(2) B-32866	D-32	Pinion Bushing		A-32529
D-9	Air Cock		(4) 201-E	D-33	Bushing Lock Screw		B-31308
D-10	Cylinder Head		(2) A-38887	D-34	Control Rod Bushing		B-60085
D-11	Cyl. Hd. Bushing	N.S.	(2) B-32791	D-35	Control Rod		A-66575
D-12	Oil Cylinder		(2) A-32530	D-36	Washer		B-60078
D-13	Cyl. Head Inner	(1 Ea.)	A-32534	D-37	Spring		B-60080
D-14	Gib Adj. Stud		(2) B-66564	D-38	Spacer		B-56285
D-15	Taper Gib		(2) A-61079	D-39	Rod Locator		B-60084
D-16	Front End Plate		A-66561	D-40	Spring Cap		B-60086
D-17	Rear End Plate		A-66562	D-41	Switch Bracket		A-60061
D-18	Piston Rings	(8)	B-33366	D-42	Micro-Switch L.H.	(1)	
D-19	Front Piston Rod		Note 1	D-43	Micro-Switch R.H.	(2)	
D-20	Rear Piston Rod		Note 1	D-44	Roller Assembly	(3)	B-60072
D-21	Tee Slot Bracket		A-66578	D-45	Roller Spring	N.S.	(3) B-60070
D-22	Rapid Return Dog		B-60066	D-46	Oil Pot	N.S.	A-56288
D-23	Feed Dog		B-60065	D-47	Front Cover	N.S.	A-60077
D-24	Rapid Forward Dog		B-60067				

Note 1

D-19	Front Piston Rod
D-20	Rear Piston Rod

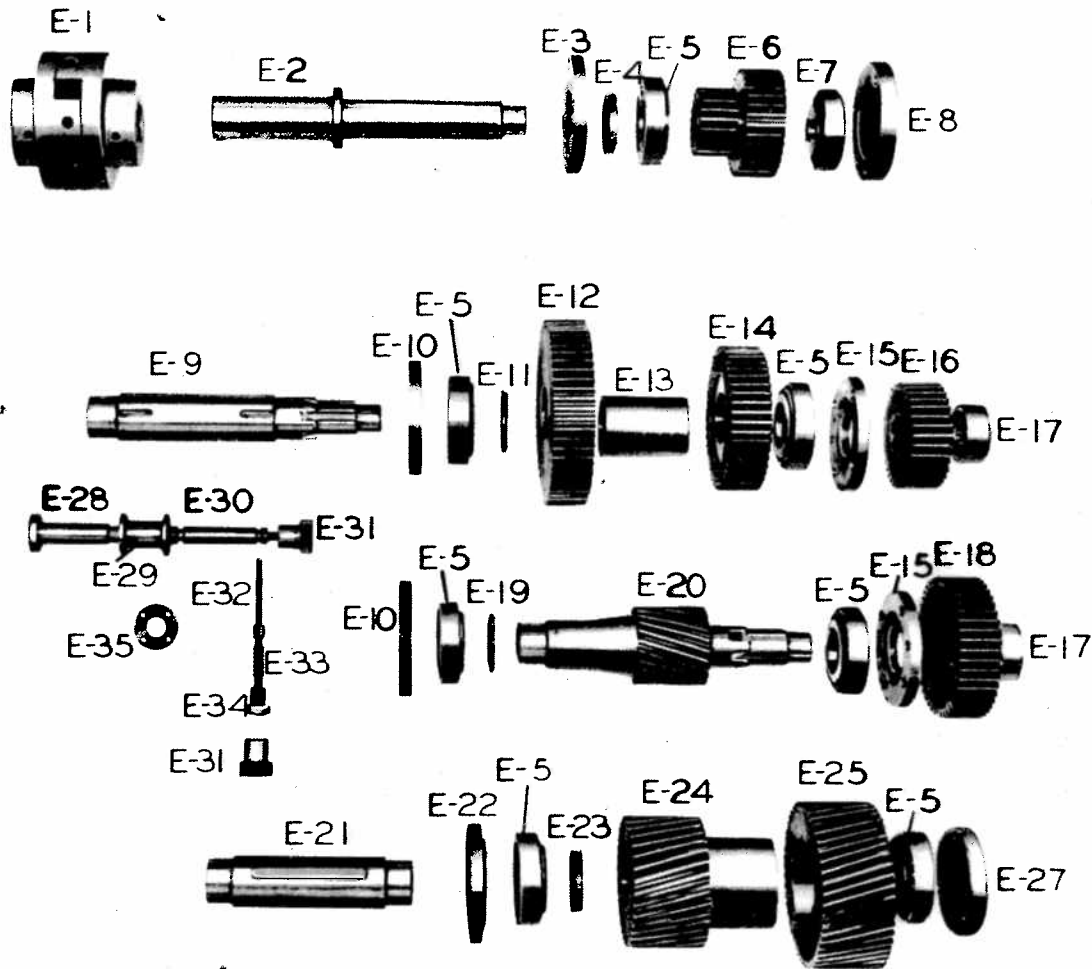
No. 312

A-66576
A-66577

No. 314

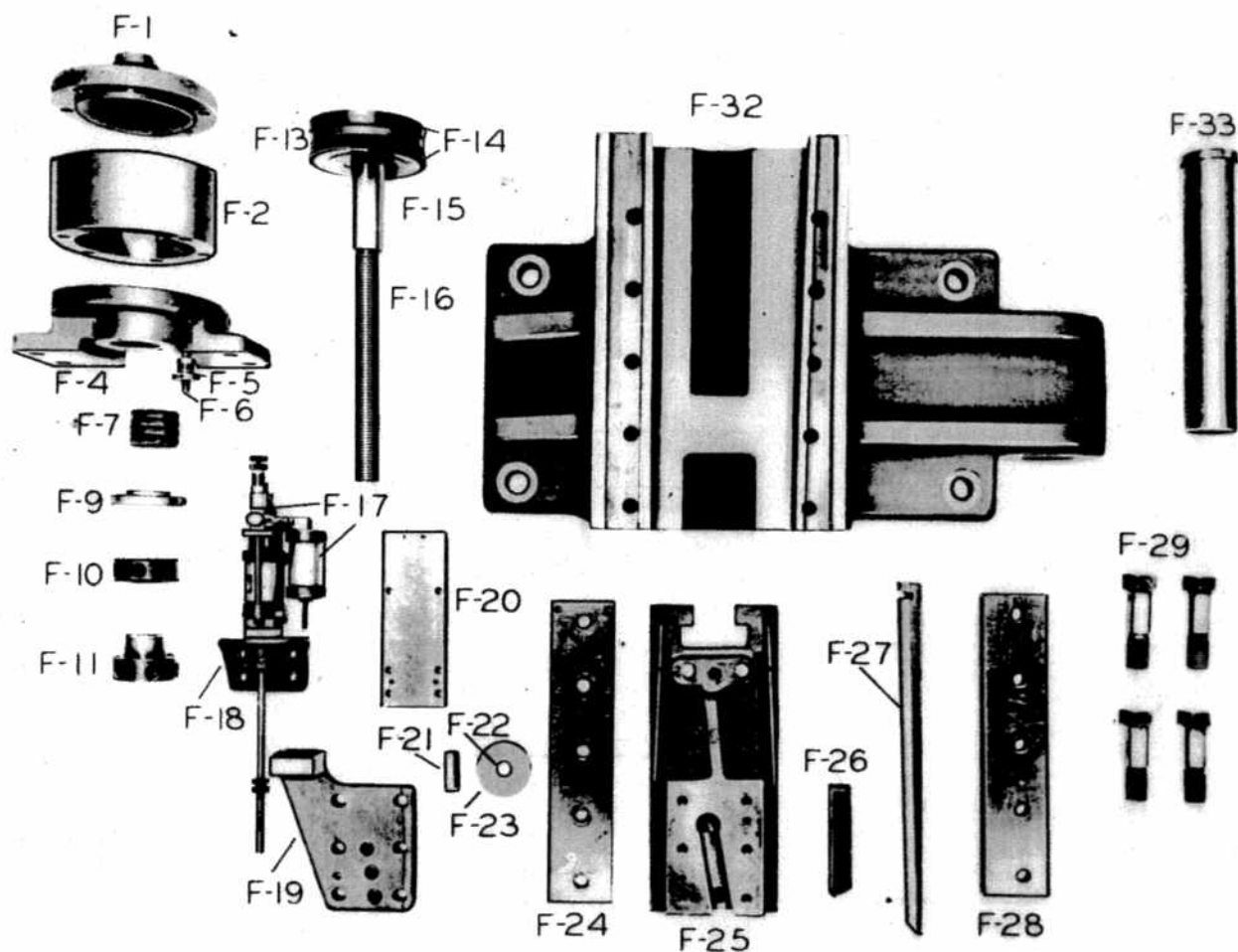
A-67771
A-67772

MOTOR DRIVE - UNIT 'E'



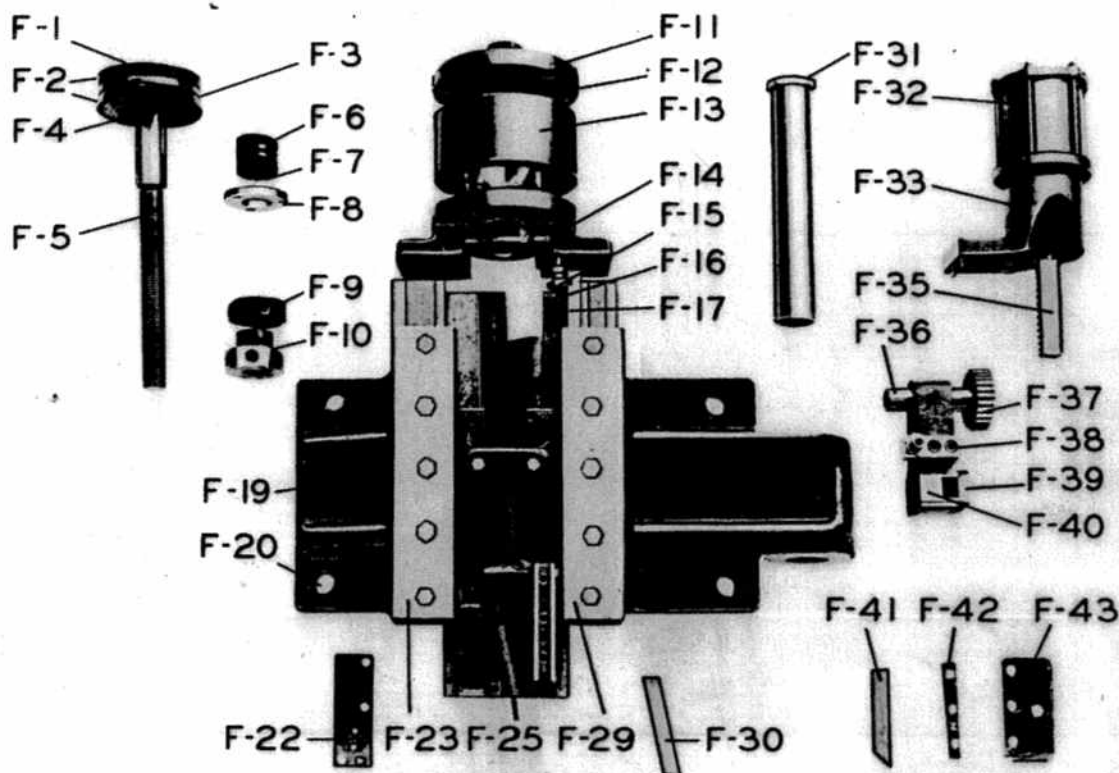
E-1	Coupling	To Suit	E-19	Spacer	B-64216
E-2	Drive Shaft	A-66112	E-20	Pinion Shaft 24T	A-66411
E-3	Bearing Closer	A-64197	E-21	Shaft	A-64218
E-4	Oil Seal	60918	E-22	Bearing Closer	A-64201
E-5	Roller Bearing	(7) 552A/559	E-23	Spacer	B-64217
E-6	Sliding Gear 21T & 34T	A-66113	E-24	Gear 32T	A-68565
E-7	Roller Bearing	532A/535	E-25	Gear 50T	A-66409
E-8	Bearing Closer	A-64202	E-26	Retaining Ring	N.S. 5100-500
E-9	Change Gear Shaft	A-66114	E-27	Bearing Closer	A-64200
E-10	Bearing Closer	(2) A-66407	E-28	Sleeve	B-66105
E-11	Spacer	B-64213	E-29	Shifter	B-66104
E-12	Gear 60T	A-66410	E-30	Shifter Rod	A-66111
E-13	Spacer	B-66108	E-31	Knob	(2) B-66103
E-14	Gear 47T	A-66115	E-32	Detent	B-66106
E-15	Bearing Closer	(2) A-64199	E-33	Spring	B-42975
E-16	Change Gear	To Suit	E-34	Bushing	B-66107
E-17	Roller Bearing	(2) 5307	E-35	Oil Flow Gage Assembly	
E-18	Change Gear	To Suit	E-36	Needle Valve Control	(2) 1768

O.D. CHAMFER ATTACHMENT - UNIT 'F'



F-1	Upper Cylinder Head	A-60468	F-18	Hydrocheck Bracket	B-69262
F-2	O. D. Cylinder	A-60470	F-19	Slide Cutter Cap	A-69330
F-3	Cylinder Gasket	N.S. (2)	F-20	Spacer Block	A-64772
F-4	Cylinder Head	A-60467	F-21	O. D. Roller Pin	B-64763
F-5	Gib Adjusting Nut	B-61367	F-22	O. D. Bushing	B-64762
F-6	Gib Adjusting Stud	B-61408	F-23	O. D. Roller	B-64761
F-7	Packing	B-60351	F-24	Slide Cap (straight)	A-61299
F-8	Packing Washer	N.S. (5)	F-25	Slide	A-69329
F-9	Packing Gland	B-61346	F-26	O. D. Cutter	B-53363
F-10	Slide Locknut	B-60484	F-27	Taper Gib	A-61301
F-11	Slide Adjusting Nut	B-31249	F-28	Slide Cap (taper)	A-61300
F-12	Piston Plate	N.S.	F-29	Bracket Screw	(4) B-52777
F-13	Packing Plate	B-60480	F-30	Bracket Screw	(2) N.S. B-52776
F-14	Piston Packing Cup	(2) B-60471	F-31	Angle Plate	N.S. A-68979
F-15	Piston	68577	F-32	Bracket	N.S. A-61294
F-16	Piston Rod	A-60479	F-33	Hinge Pin	B-31248
F-17	Hydrocheck Unit	A-61302	F-34	Solenoid Valve	N.S.

O.D. & I.D. CHAMFER ATTACHMENT - UNIT 'F'



F-1	Piston Plate	N.S.	B-60480	F-25	Slide	A-61295
F-2	Piston Packing Cup	(2)	68577	F-26	O. D. Roller	N.S. B-64761
F-3	Packing Plate		B-60471	F-27	O. D. Bushing	N.S. B-64762
F-4	Piston		B-60479	F-28	O. D. Roller Pin	N.S. B-64763
F-5	Piston Rod		A-61302	F-29	Slide Cap (taper)	A-61300
F-6	Piston Rod Packing		B-60351	F-30	O. D. Cutter	B-53363
F-7	Packing Washer	(5)	B-61346	F-31	Hinge Pin	B-31248
F-8	Packing Gland		B-60484	F-32	I. D. Cylinder	21010
F-9	Tool Slide Lock Nut		B-31249	F-33	Cylinder Bracket	A-61296
F-10	Tool Slide Adj. Nut		B-31118	F-34	Piston Check Block	N.S. A-64773
F-11	Upper Cyl. Head		A-60468	F-35	Rack	B-61303
F-12	Cylinder Gasket	(2)	A-60485	F-36	Pinion Shaft	B-61305
F-13	Cylinder		A-60470	F-37	Pinion	B-61304
F-14	Lower Cyl. Head		A-60467	F-38	Stop Block	B-61307
F-15	Gib Adj. Nut		B-61367	F-39	Tool Holder Cap	B-61309
F-16	Gib Adj. Stud		B-61408	F-40	Tool Holder	A-64733
F-17	Taper Gib		A-61301	F-41	I. D. Cutter	B-53364
F-18	Angle Plate	N.S.	Note 1	F-42	Rack Bracket Key	B-61308
F-19	Bracket		A-61294	F-43	Rack Bracket	A-61297
F-20	Bracket Screw	(4)	B-52777	F-44	I. D. Roller	N.S. B-64764
F-21	Bracket Screw	(2)	B-52778	F-45	I. D. Bushing	N.S. B-64765
F-22	Cutter Cap		B-61314	F-46	I. D. Pin	N.S. B-64766
F-23	Slide Cap (straight)		A-61299	F-47	Sol. Valve (specify voltage)	N.S. (2)
F-24	Spacer Block (Hydrocheck)		A-64772	F-48	Hydrocheck Unit	N.S.

Note 1

No. 312

No. 314

No. 316

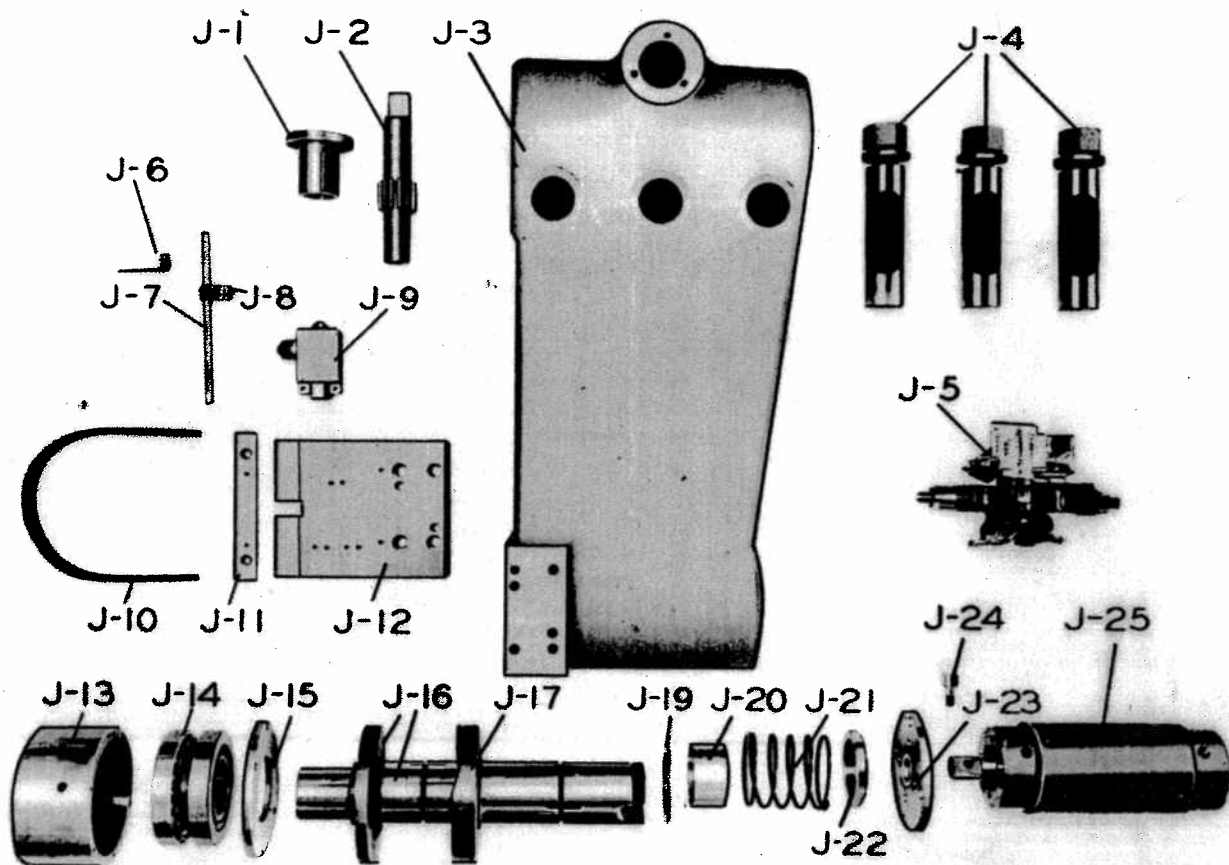
F-18 Angle Plate

A-66417

A-66417

A-68979

STOCK STOP - UNIT 'J'



J-1	Pinion Bushing	B-52720	J-19	Washer	B-69813
J-2	Pinion	B-52725	J-20	Spring Spacer	B-67393
J-3	Arm	Note 1	J-21	Spring	B-67392
J-4	Binder Belt (3)	B-52722	J-22	Lock Nut	
J-5	Sol. Valve (specify voltage)		J-23	Adapter	B-69814
J-6	Spring	B-39812	J-24	Cam Follower	CF-1
J-7	Lever Pivot	B-65694	J-25	Rotary Actuator	A-69815
J-8	Actuator & Adj. Screw	B-71693	J-26	Bar Support	N.S. Note 1
J-9	Micro-Switch R.H.		J-27	Bar	N.S. Note 1
J-10	Lever	A-71692	J-28	Binder Bolt	N.S. B-57462
J-11	Lever Stop	B-65692	J-29	Bar Bushing	N.S. (2) B-40041
J-12	Mounting Plate	A-65693	J-30	Swinging Arm Stud	N.S. B-40043
J-13	Stop	A-56381	J-31	Adjusting Nut	N.S. (2) B-40044
J-14	Roller Bearing (2)	78551	J-32	Pivot Pin	N.S. B-40045
		(1) 78251-D	J-33	Hack	N.S. A-40048
J-15	Bearing Retainer	A-56376	J-34	Adjusting Rod Nut	N.S. B-40062
J-16	Shaft & Cam Assembly	A-69811	J-35	Adjusting Rod	N.S. B-40063
J-17	Inner Cam	A-69809	J-36	Bushing	N.S. (2) B-40064
J-18	Bushing	N.S. (2) B-67391			

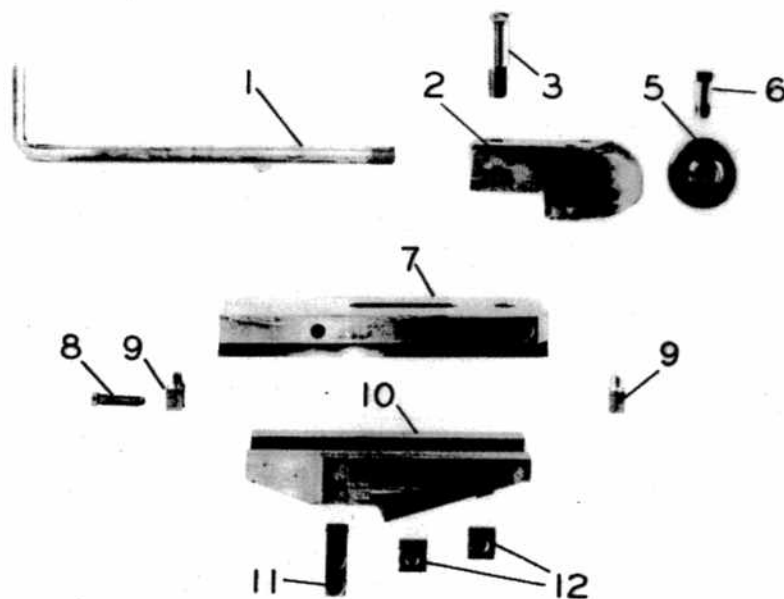
Note 1

J-3	Arm
J-26	Bar Support
J-27	Bar

Right Hand Left Hand

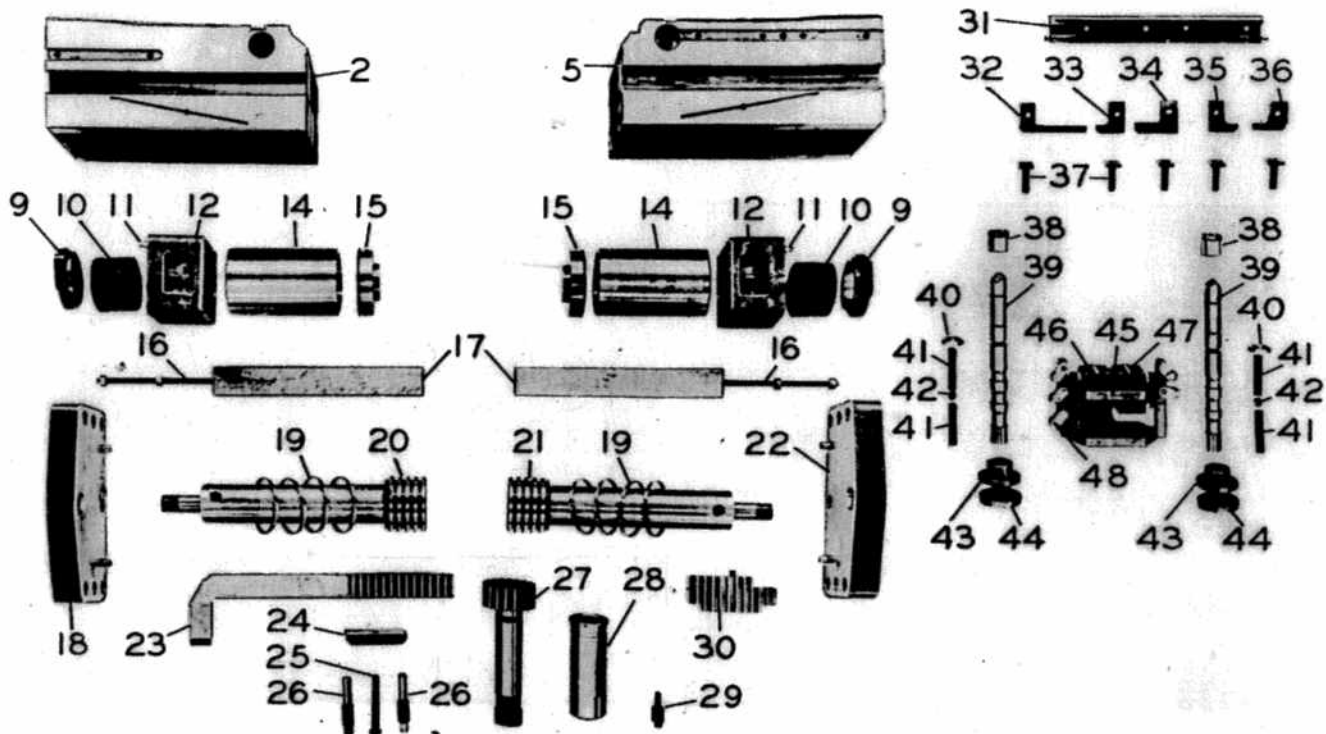
A-67385	A-69816
A-66602	A-65696
A-69497	A-69498

INSIDE CHAMFER ATTACHMENT-UNIT 'N'



- | | | |
|------|--------------------------------|------|
| N-1 | Tool Holder Lever | |
| N-2 | Tool Holder | |
| N-3 | Tool Holder Stud | |
| N-4 | Chamfer Tool | N.S. |
| N-5 | Roller | |
| N-6 | Roller Stud | |
| N-7 | Slide | |
| N-8 | 1/2 x 2 1/2 L. Sq. Hd. Dog Pt. | |
| N-9 | Adjust. Scr. Block | |
| N-10 | Saddle | |
| N-11 | Stop Block | |
| N-12 | Tee Nut | |

HYDRAULIC CUTOFF - UNIT 'D' (LEFT HAND CONTROL)



D-1	Saddle	N.S.	L-72202	D-28	Pinion Bushing	B-32529
D-2	Front Slide		L-72191	D-29	Bushing Lock Screw	B-31308
D-3	Front Slide Cap-Front	N.S.	A-66570	D-30	Short Equalizing Rack	A-32536
D-4	Front Slide Cap-Rear	N.S.	A-72203	D-31	Tee Slot Bracket	A-72240
D-5	Rear Slide		L-72192	D-32	Rapid Forward Dog	B-72205
D-6	Rear Slide Cap-Front	N.S.	A-66572	D-33	Feed Dog	B-72206
D-7	Rear Slide Cap-Rear	N.S.	A-72204	D-34	Rapid Return Dog	B-72207
D-8	Slide Wear Strip	N.S.	(4) A-64397	D-35	Collet Dog	B-72208
D-9	Packing Gland	(2)	B-32790	D-36	Stock Stop Dog	B-72209
D-10	Packing	(2)	B-32866	D-37	Tee Bolt	(5) B-52522
D-11	Air Cock	(4)	201-E	D-38	Control Rod Bushing	(2) B-60085
D-12	Cylinder Head	(2)	A-38887	D-39	Control Rod	(2) A-66575
D-13	Cyl. Hd. Bushing	N.S.	(2) B-32791	D-40	Washer	(2) B-60078
D-14	Oil Cylinder	(2)	A-32530	D-41	Spring	(4) B-60090
D-15	Inner Cyl. Head	(2)	A-32534	D-42	Spacer	(2) B-56285
D-16	Gib Adj. Stud	(2)	B-66564	D-43	Rod Locator	(2) B-60084
D-17	Taper Gib	(2)	A-61079	D-44	Spring Cap	(2) B-60086
D-18	Front End Plate		A-66561	D-45	Switch Bracket	A-60061
D-19	Piston Rings	(8)	B-33366	D-46	Limit Switch L.H.	(3) BAF 1-2RN
D-20	Front Piston Rod	Note 1		D-47	Limit Switch R.H.	(2) BAF 1-2RN
D-21	Rear Piston Rod	Note 1		D-48	Roller Assembly	(5) B-60072
D-22	Rear End Plate		A-66562	D-49	Roller Spring	N.S. (2) B-60070
D-23	Long Equalizing		A-66579	D-50	Roller Spring	N.S. (3) B-39812
D-24	Rack Shoe		B-32526	B-51	Oil Pot	N.S. L-72171
D-25	5/8" x 6" L. Cap Screw			D-52	Front Cover	N.S. A-60077
D-26	Rack Shoe Stud	(2)	B-60983	D-53	Rear Cover	N.S. A-72211
D-27	Equalizing Pinion		A-38881	D-54	Cover Gasket	N.S. A-72212

Note 1

D-20 Front Piston Rod
D-21 Rear Piston Rod

No. 312

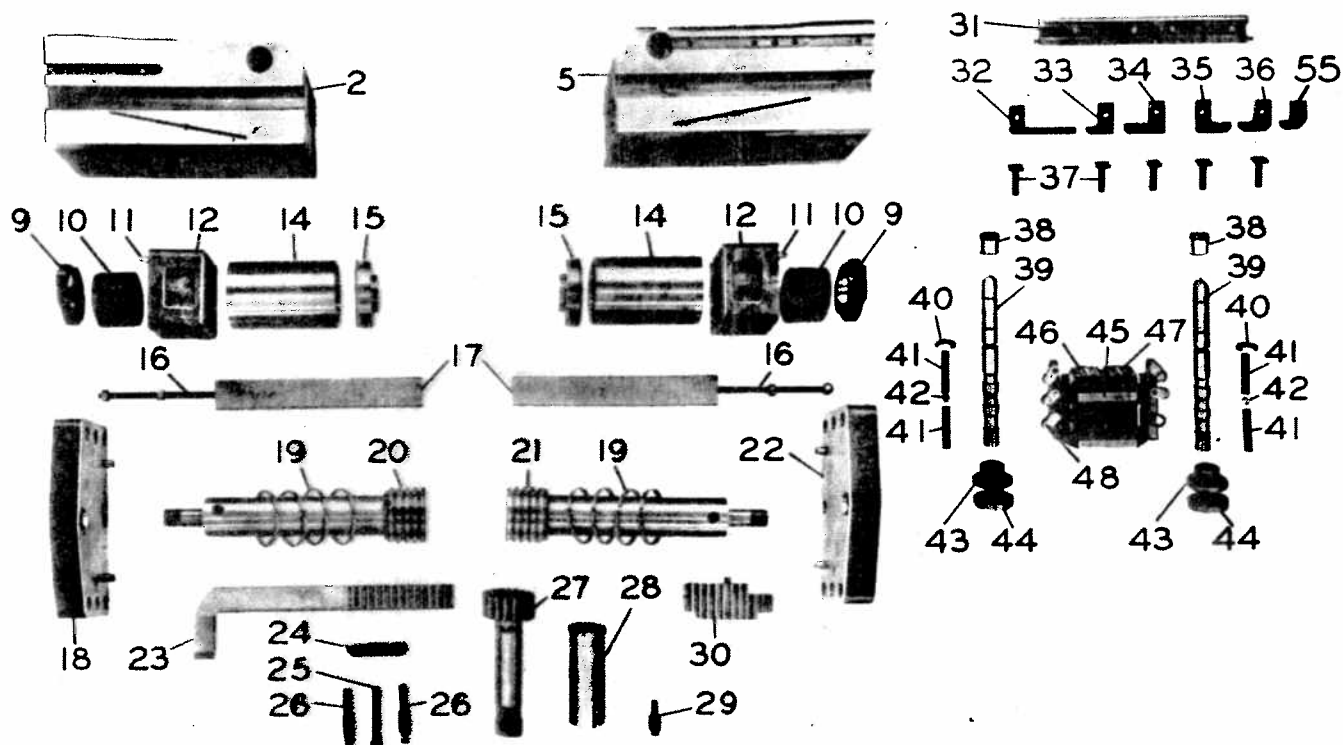
A-66576
A-66577

No. 314

A-67771
A-67772

HYDRAULIC CUTOFF - UNIT 'D'

(LEFT HAND CONTROL)



D-1	Saddle	N.S.	L-72202	D-28	Pinion Bushing	B-32529
D-2	Front Slide		L-72191	D-29	Bushing Lock Screw	B-31308
D-3	Front Slide Cap-Front	N.S.	A-66570	D-30	Short Equalizing Rack	A-32536
D-4	Front Slide Cap-Rear	N.S.	A-72203	D-31	Tee Slot Bracket	A-72240
D-5	Rear Slide		L-72192	D-32	Rapid Forward Dog	B-72205
D-6	Rear Slide Cap-Front	N.S.	A-66572	D-33	Feed Dog	B-72206
D-7	Rear Slide Cap-Rear	N.S.	A-72204	D-34	Rapid Return Dog	B-72207
D-8	Slide Wear Strip	N.S. (4)	A-64397	D-35	Collet Dog	B-60086
D-9	Packing Gland	(2)	B-32790	D-36	Stock Stop Dog	B-60085
D-10	Packing	(2)	B-32866	D-37	Tee Bolt	(5) B-32522
D-11	Air Cock	(4)	201-E	D-38	Control Rod Bushing	(2) B-60085
D-12	Cylinder Head	(2)	A-38887	D-39	Control Rod	(2) A-66575
D-13	Cyl. Hd. Bushing	N.S. (2)	B-32791	D-40	Washer	(2) B-60078
D-14	Oil Cylinder	(2)	A-32530	D-41	Spring	(4) B-60090
D-15	Inner Cyl. Head	(2)	A-32534	D-42	Spacer	(2) B-56285
D-16	Gib Adj. Stud	(2)	B-66564	D-43	Rod Locator	(2) B-60084
D-17	Taper Gib	(2)	A-61079	D-44	Spring Cap	(2) B-60086
D-18	Front End Plate		A-66561	D-45	Switch Bracket	A-60061
D-19	Piston Rings	(8)	B-33366	D-46	Limit Switch L.H.	(3) BAP 1-2RN
D-20	Front Piston Rod		Note 1	D-47	Limit Switch R.H.	(3) BAP 1-2RN
D-21	Rear Piston Rod		Note 1	D-48	Roller Assembly	(5) B-60072
D-22	Rear End Plate		A-66562	D-49	Roller Spring	N.S. (2) B-60070
D-23	Long Equalizing		A-66579	D-50	Roller Spring	N.S. (3) B-39812
D-24	Rack Shoe		B-32526	D-51	Oil Pot	N.S. L-72171
D-25	5/8" x 6" L. Cap Screw			D-52	Front Cover	N.S. A-60077
D-26	Rack Shoe Stud	(2)	B-60983	D-53	Rear Cover	N.S. A-72211
D-27	Equalizing Pinion		A-38881	D-54	Cover Gasket	N.S. A-72212
				D-55	O.D. Chamfer Dog	B-72430

Note 1

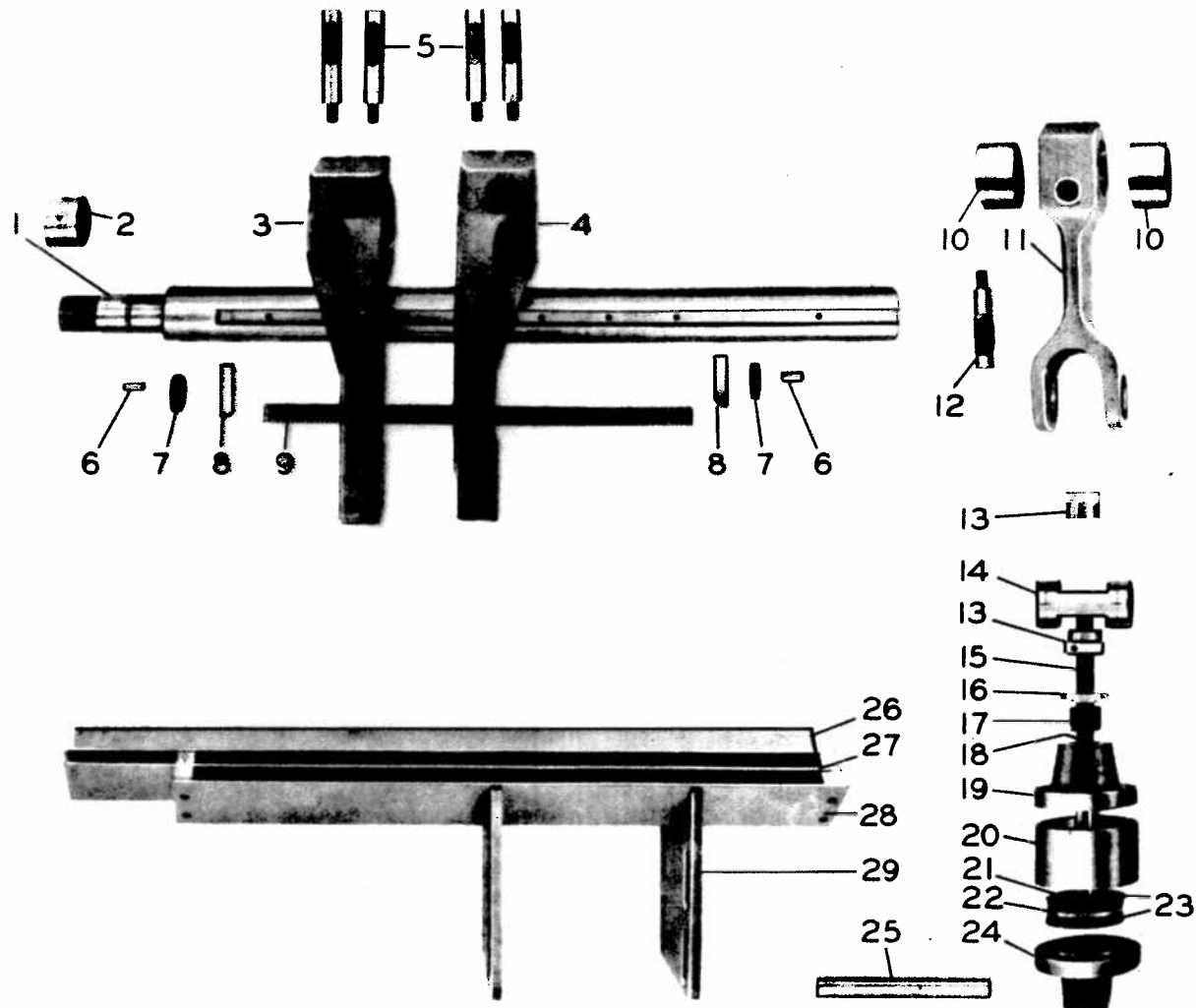
D-20 Front Piston Rod
D-21 Rear Piston Rod

No. 312

A-66576 A-67771
A-66577 A-67772

No. 314

O.D. ARM CHAMFER ATTACHMENT - UNIT 'G'



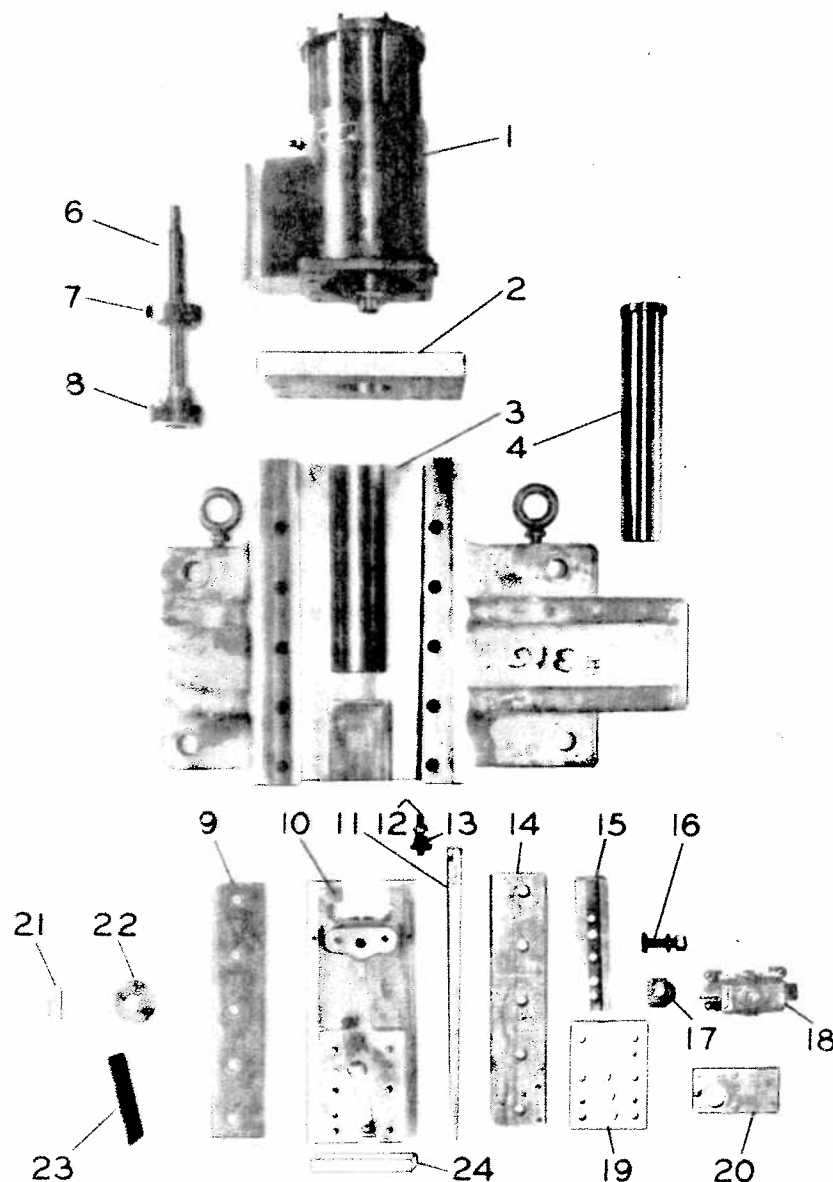
G-1	Bar	Note 1	G-16	Packing Nut	B-39036
G-2	Bar Nut	A-40036	G-17	Rod Packing	B-35166
G-3	Arm - Right Hand	Note 1	G-18	Bushing	B-39997
G-4	Arm - Left Hand	Note 1	G-19	Outer Cyl. Head	A-40038
G-5	Binder Bolt	(4) B-40050	G-20	Air Cylinder	B-40039
G-6	Pin	(2) B-39996	G-21	Piston Plate	(2) B-31114
G-7	Stop Block	(2) B-36314	G-22	Piston	B-39035
G-8	Chamfering Cutter	(2) B-27842	G-23	Cylinder Packing	(2) #68577
G-9	Rack	A-40048	G-24	Inner Cyl. Head	B-40040
G-10	Bar Bushing	(2) B-40041	G-25	Pivot Pin	B-40045
G-11	Swinging Arm	A-40037	G-26	Small Trough	(Note 2) A-67717
G-12	Binder Bolt	B-57462	G-27	Liner Trough	(Note 2) A-67716
G-13	Adjusting Nut	(2) B-40044	G-28	Master Trough	A-67715
G-14	Swinging Arm Stud	B-40043	G-29	Support Plate	(2) A-54375
G-15	Piston Rod	A-40042			

Note 1:

		Right Hand Control	Left Hand Control
G-1	Bar	A-69497	A-69498
G-3	Arm - R. H.	A-39992	A-72165
G-4	Arm - L. H.	A-39993	A-72166

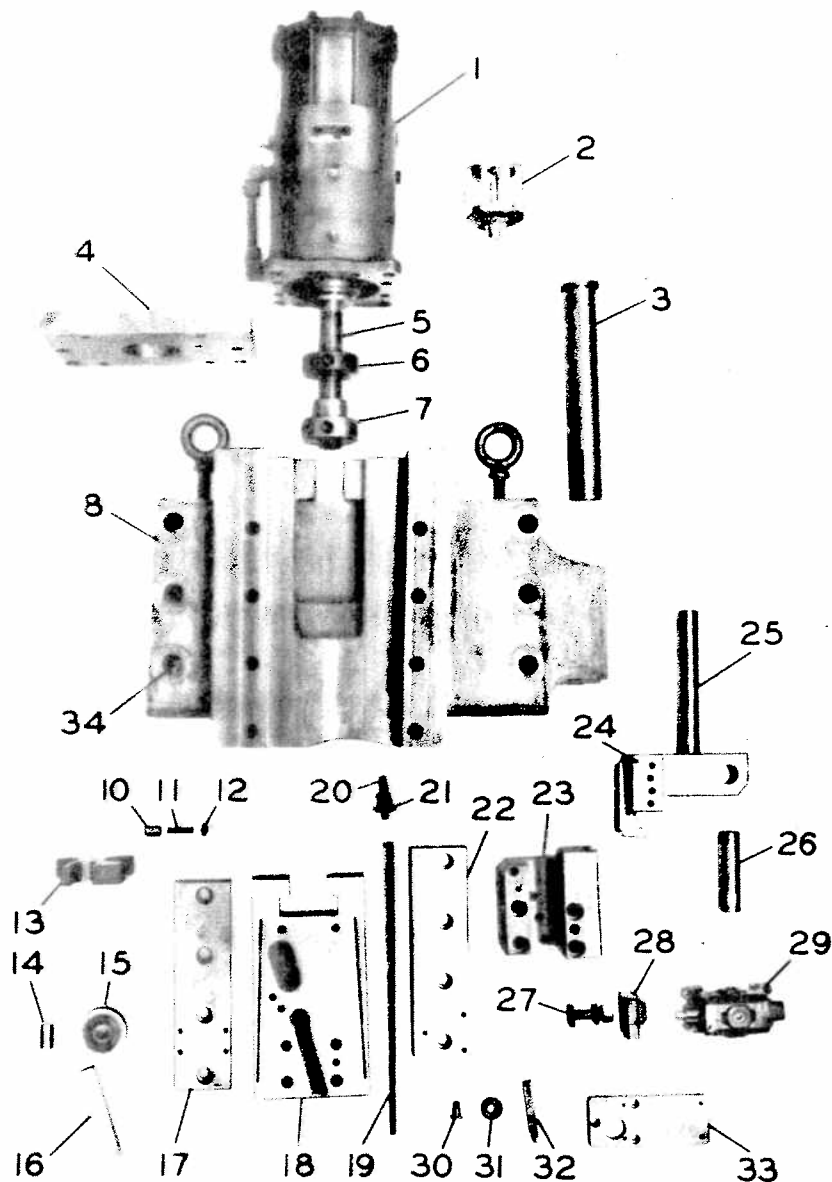
Note 2: Specify pipe size to be cut.

O.D. CHAMFER ATTACHMENT - UNIT 'F'



F-1	Air-Draulic Cylinder	#2560	F-14	Taper Slide Cap	A-72216
F-2	Mounting Plate	A-72214	F-15	Tee Slot Brkt.	A-72219
F-3	Bracket	A-61294	F-16	Tee Bolt	B-52522
F-4	Hinge Pin	B-31248	F-17	Dog	B-72218
F-5	Bracket Screw	B-52777	F-18	Hydraulic Valve	#6295
F-6	Piston Rod	A-72215	F-19	Tool Cap	A-72220
F-7	Slide Locknut	B-31249	F-20	Valve Mtg. Plate	B-72217
F-8	Slide Adjusting Nut	B-31118	F-21	O.D. Roller Pin	B-64763
F-9	Straight Slide Cap	A-61299	F-22	O.D. Roller	B-64761
F-10	Slide	A-69329	F-23	Chamfer Tool	B-53363
F-11	Taper Gib	A-61301	F-24	Stop Plate (Bronze)	B-71702
F-12	Gib Adj. Stud	B-61408	F-24A	Stop Plate (Graph-Mo)	B-71050
F-13	Gib Adj. Nut	B-61367			

O.D. & I.D. CHAMFER ATTACHMENT - UNIT 'F'



F-1 Air-Draulic Cylinder
F-2 Oil Filler
F-3 Hinge Pin
F-4 Mounting Plate
F-5 Piston Rod
F-6 Slide Lock Nut
F-7 Slide Adjusting Nut
F-8 Bracket
F-10 Detent
F-11 Spring
F-12 Screw
F-13 Strap
F-14 Roller Pin
F-15 Roller
F-16 O.D. Chamfer Tool
F-17 Straight Slide Cap
F-18 Slide
F-19 Taper Pin

#2560
#100
B-31248
A-72214
A-72215
B-31249
B-31118
A-61294
B-55194
B-49839
B-34175
A-72618
B-64763
B-64761
B-63363
A-61299
A-69329
A-61301

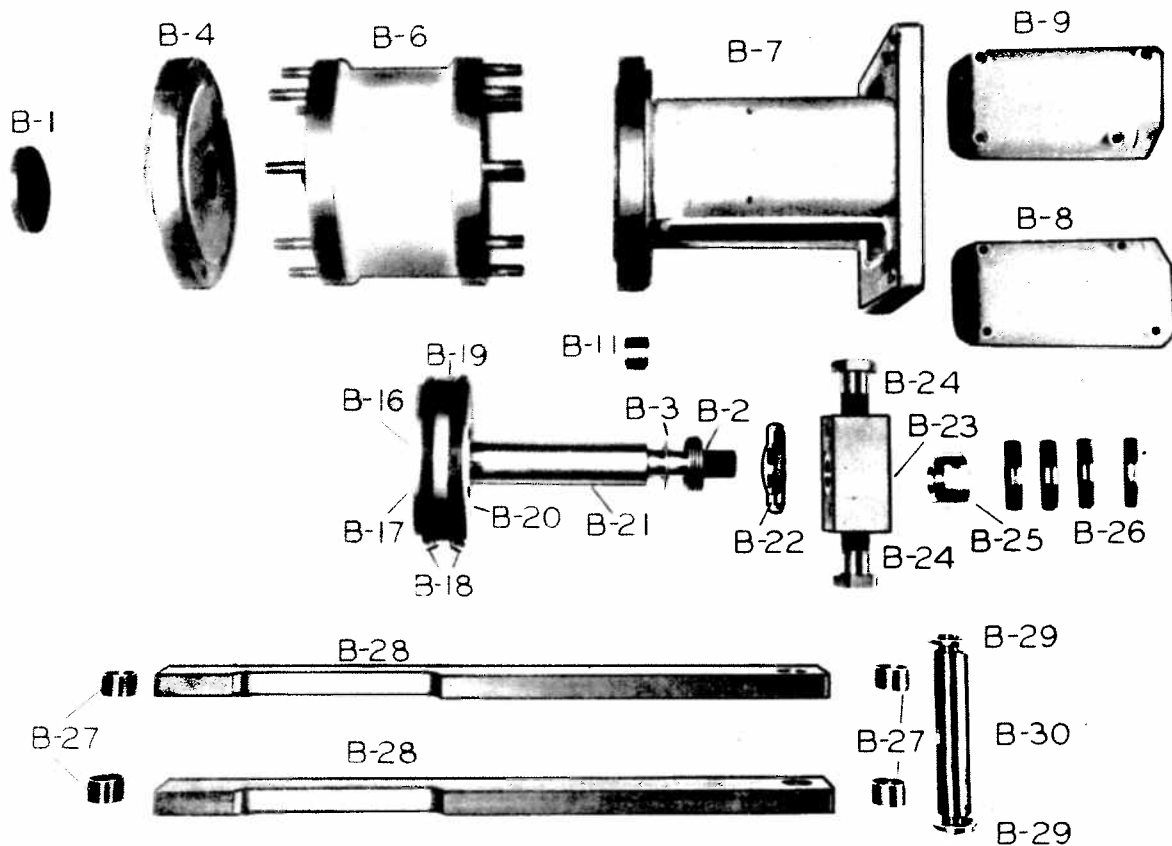
F-20 Adjusting Stud
F-21 Adjusting Nut
F-22 Taper Slide Cap
F-23 Tool Holder Bracket
F-24 Tool Holder
F-25 Handle
F-26 Stud
F-27 Tee Bolt
F-28 Dog
F-29 Two Way Valve
F-30 Roller Screw
F-31 Roller
F-32 I.D. Chamfer Tool
F-33 Valve Mounting Plate
F-34 Bracket Screw
F-35 Stop Plate (Bronze)
F-35A Stop Plate (Graph-Mo)

B-61408
B-61367
A-72216
A-72617
A-72621
A-61596
B-72623
B-62522
A-72622
B-72628
B-72627
B-53364
B-72625
B-62777
B-1702
B-71050

(4)
N.S.
N.S.

312-17-P

AIR CYLINDER - UNIT 'B'



B-1	Front Cap	B-73109	B-19	Packing Plate	B-31244
B-2	Packing	B-67374	B-20	Piston	A-52941
B-3	Packing Plate	B-67371	B-21	Piston Rod	A-73108
B-4	Cylinder Head	A-73219	B-22	Packing Gland	A-68295
B-5	Cylinder Gasket	B-52727	B-23	Slide Block	A-67376
B-6	Cylinder	A-38941	B-24	Link Lock Screw	(2) A-52519
B-7	Bracket	A-67382	B-25	Piston Rod Lock Nut	B-31142
B-8	Link Cover Front	A-31316	B-26	Stud	(4) 1911
B-9	Link Cover Rear	A-31339	B-27	Bushing	(4) B-52518
B-11	Bushing	B-67373	B-28	Link	(2) A-70889
			B-29	Stud Collar	(2) B-52517
			B-30	Link Stud	B-52516
			B-31	Yoke	N.S. A-38715
			B-32	Yoke Shoes	N.S. Note 1
			B-33	Yoke Shoe Stud	N.S. Note 1
B-16	Piston Lock Nut	A-67375	B-34	Yoke Shaft	N.S. A-38716
B-17	Follower	B-31245	B-35	Link Stud Bushing	N.S. (2) B-32310
B-18	Packing Cup	(2) 68579	B-36	Solenoid Air Valve	N.S.
			B-37	Piston Stop	N.S. B-73110

Note 1

B-32	Yoke Shoe
B-33	Yoke Shoe Stud

No. 312

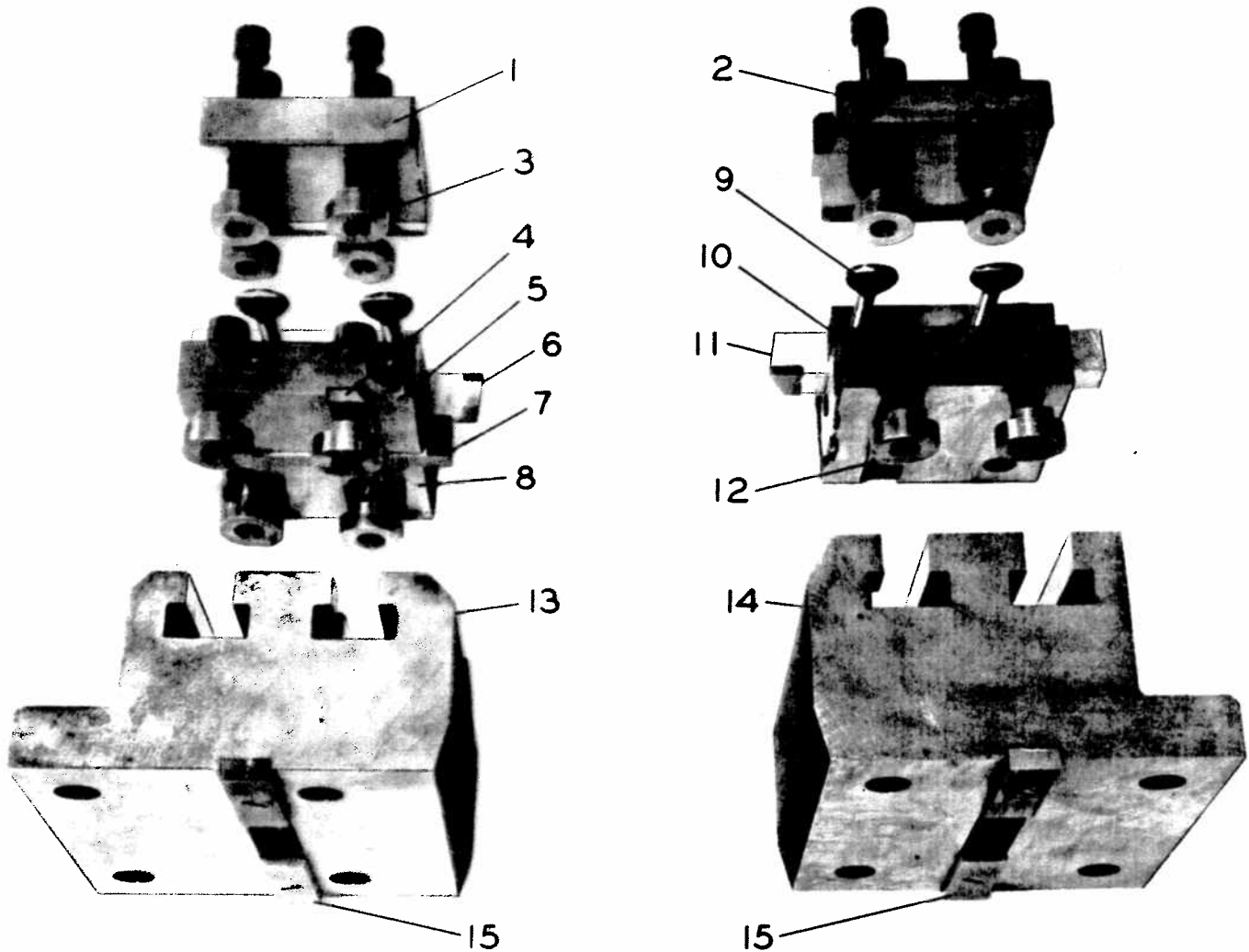
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B-65970

No. 314

B-56330
B-65934

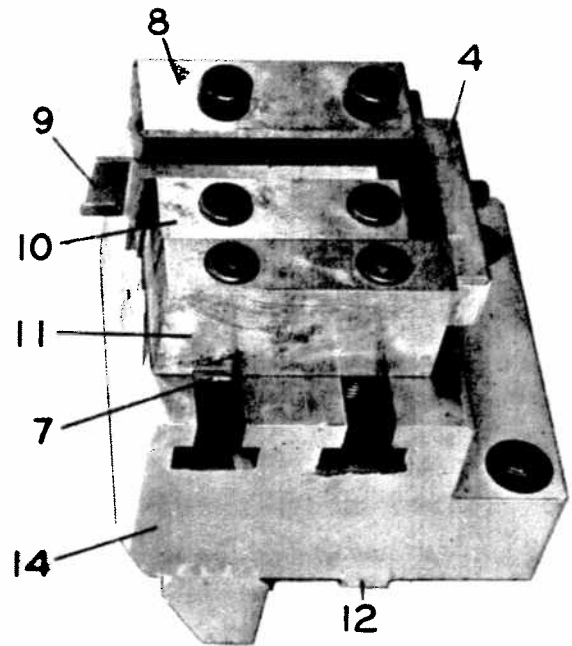
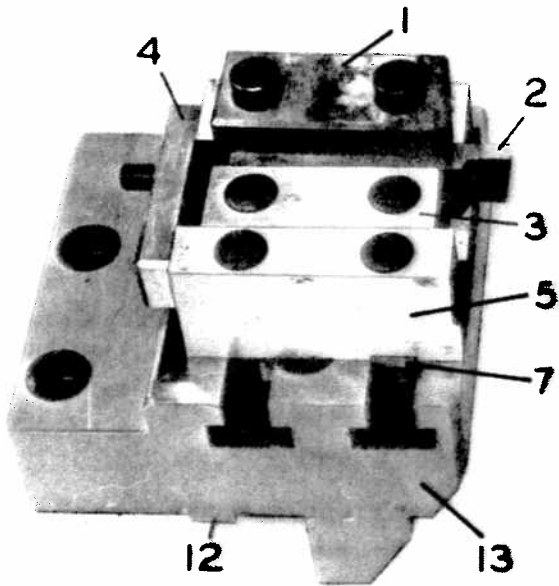
312-18-P

TOOL HOLDERS - UNIT 'C' (CARBIDE)



- | | | |
|------|-------------------------|------|
| C-1 | Front Cap | |
| C-2 | Rear Cap | |
| C-3 | Tee Nut | (12) |
| C-4 | Key | (2) |
| C-5 | Right Front Tool Holder | |
| C-6 | Carbide Cutoff Tool | |
| C-7 | Support | |
| C-8 | Left Front Tool Holder | |
| C-9 | Thumb Screw | |
| C-10 | Rear Tool Holder | |
| C-11 | Carbide Chamfering Tool | |
| C-12 | Key | |
| C-13 | Front Base | |
| C-14 | Rear Base | |
| C-15 | Key | (4) |

TOOL HOLDERS - UNIT 'C' (CARBIDE)



- | | | |
|------|-------------------|----------|
| C-1 | Front Cap | |
| C-2 | Front Cutoff Tool | |
| C-3 | Front Wedge | |
| C-4 | Backing Plate | (2) |
| C-5 | Front Tool Holder | |
| C-6 | Tee Nut | N.S. (8) |
| C-7 | Tool Holder Key | (2) |
| C-8 | Rear Cap | |
| C-9 | Rear Cutoff Tool | |
| C-10 | Rear Wedge | |
| C-11 | Rear Tool Holder | |
| C-12 | Base Key | (2) |
| C-13 | Front Base | |
| C-14 | Rear Base | |

NO. 314 CUTTING-OFF LATHE

AIR O.D. & I.D. CHAMFER ATTACHMENT - UNIT "P"

F-1	UPPER CYLINDER HEAD		A-31113
F-2	CYLINDER		A-31105
F-3	CYLINDER GASKET UPPER	N.S.	B-52717
F-4	LOWER CYLINDER HEAD		A-39070
F-5	WIB ADJUSTING NUT		B-61367
F-6	WIB ADJUSTING STUD		B-61368
F-7	PACKING		B-35166
F-8	CYLINDER GASKET LOWER	N.S.	B-52718
F-9	PACKING NUT	N.S.	B-39036
F-10	SLIDE LOCKNUT		B-31249
F-11	SLIDE ADJUSTING NUT		B-31118
F-12	PISTON PLATE	N.S. (2)	B-31114
F-13	PISTON		B-39035
F-14	PISTON PACKING CUP	(2)	68577
F-15	AIR GOVERNOR	N.S.	1215-K
F-16	PISTON ROD		A-39067
F-17	STOP PLATE	N.S.	B-31121
F-18	PIN WRENCH	N.S.	B-31598
F-19	TOOLHOLDER	N.S.	A-48900
F-20	BRACKET	N.S.	A-52685
F-21	HANDLE	N.S.	A-52686
F-22	LATCH	N.S.	B-52687
F-23	LATCH STUD	N.S.	B-52688
F-24	SLIDE CAP	(1 EA.)	A-39068
F-25	SLIDE		A-53100
F-26	O.D. CUTTER		B-53363
F-27	TAPER WIB		A-39066
F-28	PIN	N.S.	B-52689
F-29	BRACKET SCREW	(4)	B-52777
F-30	BRACKET SCREW	N.S. (2)	B-52778
F-31	ANGLE PLATE	N.S.	A-64179
F-32	BRACKET		A-39064
F-33	HINGE PIN		B-31248
F-34	INSIDE CUTTER	N.S.	B-53364
F-35	4-WAY AIR VALVE	N.S.	1401-R4

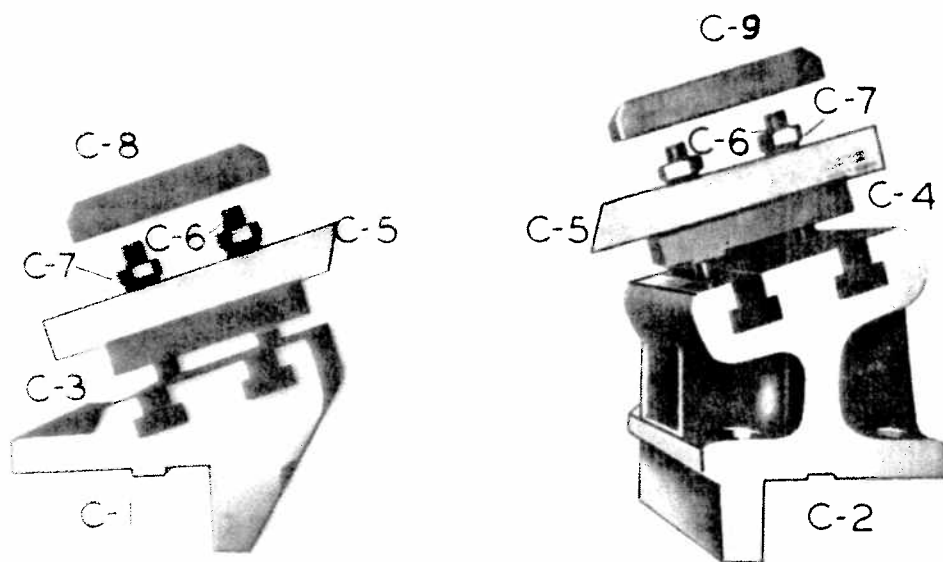
NO. 314 CUTTING-OFF LATHE
HYDRAULIC CUT-OFF - UNIT "D"

D-1	SADDLE	N.S.	L-76157
D-2	FRONT SLIDE		L-80991
D-3	FRONT SLIDE	N.S. (1-EA.)	A-64394
D-4	REAR SLIDE		L-86559
D-5	REAR SLIDE WPS	N.S. (1-EA.)	A-64395
D-6	SLIDE WEAR STRIP	N.S. (4)	A-64397
D-7	PACKING PLAND	(2)	B-32790
D-8	PACKING	(2)	B-32866
D-9	AIR COCK	(4)	201-E
D-10	CYLINDER HEAD	(2)	A-38887
D-11	CYL. HEAD BUSHING	N.S. (2)	B-32791
D-12	CTL CYLINDER	(2)	A-32530
D-13	CYL. HEAD INNER	(1-EA.)	A-32534
D-14	GR. ADJ. STUD	(2)	#1401
D-15	PAPER W/B	(2)	A-31238
D-16	PISTON ROD BKKT.	(2)	A-38883
D-17	PUMP CONTROL BRKT.		A-37426
D-18	PISTON RING	(3)	B-33366
D-19	PISTON ROD	(2)	A-52964
D-20	PISTON	(2)	A-52963
D-21	TEE SLOT BRACKET		A-32535
D-22	NEUTRAL RETURN DOG	N.S.	B-29784
D-23	FEED TRIP DOG	N.S.	B-52521
D-24	RETURN TRIP DOG	N.S.	B-52520
D-25	TEE BOLT	(3)	B-52522
D-26	EQUALIZING BACK LONG		A-32531
D-27	EQUALIZING BACK SHORT		A-32536
D-28	EQUALIZING PINION		A-38881
D-29	BACK SHOE		B-32526
D-30	BACK SH. E. STUD	(2)	B-80983
D-31	HEX. HEAD CAP SCREW		5/8 x 6
D-32	PINION BUSHING		B-32529
D-33	BUSHING LOCK SCREW		B-31308
D-34	CONTROL ROD BKKT.	N.S.	A-37388
D-35	PUMP CONTROL ROD	N.S.	A-38890
D-36	CONTROL CRANK	N.S.	B-29924
D-37	TRIP CRANK STOP	N.S.	B-30664
D-38	NEUTRAL CONT. STUD	N.S.	B-30754
D-39	PUMP CONT. TRIP CRANK	N.S.	B-35648
D-40	CONTROL ROD SPRING	N.S.	B-36491
D-41	CONTROL ROD COLLAR	N.S.	B-37339
D-42	CONT. ROD SPRING PLATE	N.S.	B-37389
D-43	CRANK SHAFT	N.S.	B-37429
D-44	BUSHING	N.S. (2)	B-37432
D-45	PACKING WASHER	N.S. (16)	B-37941
D-46	LEVER PIN	N.S.	B-38014
D-47	CONT. ROD LEVER	N.S.	B-38041
D-48	PISTON ROD BKKT. PIN	N.S. (4)	B-38121
D-49	GUARD SCREW SPACER	N.S. (2)	B-38165
D-50	SPRING BRACKET	N.S.	B-38885

HYDRAULIC SWITCH - UNIT "D" CONT'D.

D-51	PUMP CONT. LINK	N.S.	(2)	B-52523
D-52	PUMP CONT. LINK	N.S.	(2)	B-52524
D-53	PUMP CONT. CRANK	N.S.		B-52666
D-54	GASKET	N.S.	(4)	B-52690
D-55	STEEL WAY SCREW	N.S.	(51)	B-58225
D-56	PUMP CONT. ROD	N.S.		B-54126
D-57	KEY	N.S.	(2)	B-60073
D-58	OIL PIST	N.S.		A-76153
D-59	VALVE	N.S.	(4)	A-116
D-60	SCREW	N.S.		3.6 P.D.
D-61	SHEATH	N.S.		6.0 P.D.

TOOL HOLDERS - UNIT 'C'



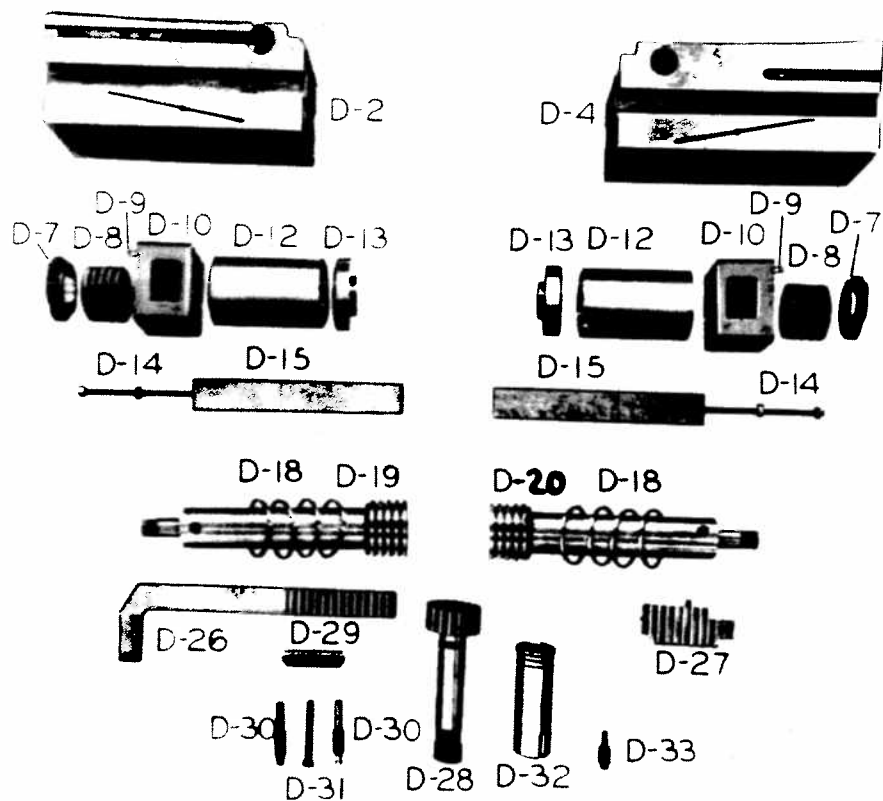
C-1	Front Tool Holder Base	A-40133
C-2	Rear Tool Holder Base	A-40134
C-3	Front Tool Holder	A-54414
C-4	Rear Tool Holder	A-54415
C-5	Blade	B-27793
C-6	Tee Bolt	(4) B-60462
C-7	Clamp Nut	(4) B-31072
C-8	Front Cap	A-54426
C-9	Rear Cap	A-54425

NO. 314 CUTTING-OFF LATHE
HYDRAULIC CUTOFF - UNIT "D"

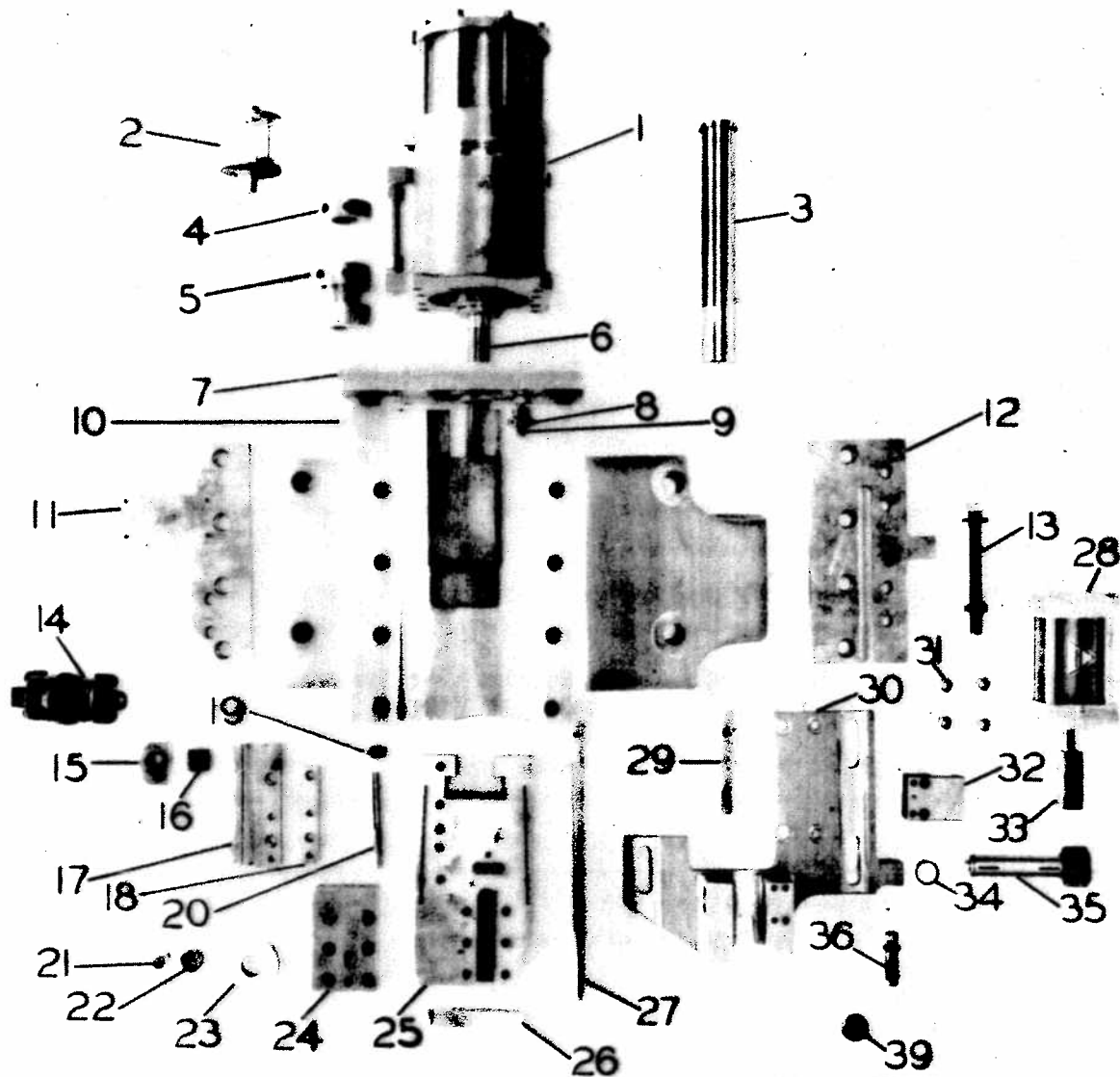
D-1	SADDLE	N.S.	A-38884
D-2	FRONT SLIDE		A-38823
D-3	FRONT SLIDE CAPS	N.S. (1-EA.)	A-32522
D-4	REAR SLIDE		A-38824
D-5	REAR SLIDE CAPS	N.S. (1-EA.)	A-32523
D-7	PACKING GLAND	(2)	B-32790
D-8	PACKING	(2)	B-32866
D-9	AIR COCK	(4)	201-E
D-10	CYLINDER HEAD	(2)	A-38887
D-11	CYL. HEAD BUSHING	N.S. (2)	B-32791
D-12	OIL CYLINDER	(2)	A-32530
D-13	CYL. HEAD INNER	(1-EA.)	A-32534
D-14	GIB ADJ. STUD	(2)	#1401
D-15	TAPER GIB	(2)	A-31238
D-16	PISTON ROD BRKT.	N.S. (2)	A-38883
D-17	PUMP CONTROL BRKT.	N.S.	A-37426
D-18	PISTON RING	(8)	B-33366
D-19	PISTON ROD	(2)	A-52964
D-20	PISTON	(2)	A-52963
D-21	TEE SLOT BRACKET	N.S.	A-32535
D-22	NEUTRAL RETURN DOG	N.S.	B-29784
D-23	FEED TRIP DOG	N.S.	B-52521
D-24	RETURN TRIP DOG	N.S.	B-52520
D-25	TEE BOLT	N.S. (3)	B-52522
D-26	EQUALIZING RACK LONG		A-32531
D-27	EQUALIZING RACK SHORT		A-32536
D-28	EQUALIZING PINION		A-38881
D-29	RACK SHOE		B-32526
D-30	RACK SHOE STUD	(2)	B-31601
D-31	HEX. HEAD CAP SCREW		5/8 x 6
D-32	PINION BUSHING		B-32529
D-33	BUSHING LOCK SCREW		B-31308
D-34	CONTROL ROD BRKT.	N.S.	A-37388
D-35	PUMP CONTROL ROD	N.S.	A-38890
D-36	CONTROL CRANK	N.S.	B-29924
D-37	TRIP CRANK STOP	N.S.	B-30664
D-38	NEUTRAL CONT. STUD	N.S.	B-30754
D-39	PUMP CONT. TRIP CRANK	N.S.	B-35648
D-40	CONTROL ROD SPRING	N.S.	B-36491
D-41	CONTROL ROD COLLAR	N.S.	B-37339
D-42	CONT. ROD SPRING PLATE	N.S.	B-37389
D-43	CRANK SHAFT	N.S.	B-37429
D-44	BUSHING	N.S. (2)	B-37432
D-45	PACKING WASHER	N.S. (16)	B-37941
D-46	LEVER PIN	N.S.	B-38014
D-47	CONT. ROD LEVER	N.S.	B-38041
D-48	PISTON ROD BRKT. PIN	N.S. (4)	B-38121
D-49	GUARD SCREW SPACER	N.S. (2)	B-38165
D-50	SPRING BRACKET	N.S.	B-38985

HYDRA LIG SWITCH - UNIT "D" CONT'D.

D-31	PUMP CONT. LINK	N.S.	(2)	B-52523
D-32	PUMP CONT. LINK	N.S.	(2)	B-52524
D-33	PUMP CONT. CRANK	N.S.		B-52666
D-34	GASKET	N.S.	(4)	B-52690
D-35	STEEL WAX SCREW	N.S.	(51)	B-42368
D-36	PUMP CONT. ROD	N.S.		B-38889
D-37	KEY	N.S.	(2)	B-60073
D-38	SH. ROD	N.S.		A-35600



O.D. & I.D. CHAMFER ATTACHMENT - UNIT 'F'



F-1	Air-Draulic Cylinder	#2560	F-23	Roller	B-76042
F-2	Oil Filler	#100	F-24	Tool Cap	A-76283
F-3	Hinge Pin	B-31246	F-25	Slide	A-76223
F-4	Locknut	B-76036	F-26	O.D. Chamfer Tool	Carbide
F-5	Adjusting Nut	B-76032	F-27	Taper Gib	A-61301
F-6	Piston Rod	A-76226	F-28	Air Cylinder	B-76004
F-7	Mounting Plate	A-72214	F-29	Key	B-76050
F-8	Adjusting Nut	B-61387	F-30	Toolholder & Support	A-76229
F-9	Adjusting Stud	B-61408	F-31	Spacer	(4) B-76060
F-10	Bracket	A-76222	F-32	Rack Guide	B-76059
F-11	Slide Cap L.H.	A-76224	F-33	Rack	B-76058
F-12	Slide Cap R.H.	A-76230	F-34	Retaining Ring	#5100-125
F-13	Stop Screw	B-76233	F-35	Pinion Shaft	B-76057
F-14	Two-Way Valve	#6295	F-36	Binder Bolt	(3) B-36452
F-15	Dog	B-72218	F-37	Toolholder	N.S. A-76231
F-16	Tee Bolt	B-52522	F-38	Roller Support	N.S. A-76232
F-17	Tee Slot Bracket	A-76225	F-39	Roller	B-76234
F-18	Spacer	B-76227	F-40	I.D. Chamfer Tool	N.S. Carbide
F-19	Tool Adjusting Nut	B-76038	F-41	Angle Plate	N.S.
F-20	Tool Adjusting Screw	B-76037	F-42	Rack Guard	N.S.
F-21	Roller Pin	B-76043	F-43	Bracket Screw	N.S. (4) A-76154
F-22	Bearing	#HR-1312	F-44	Set Screw	N.S. (2) B-52777
					B-76291