

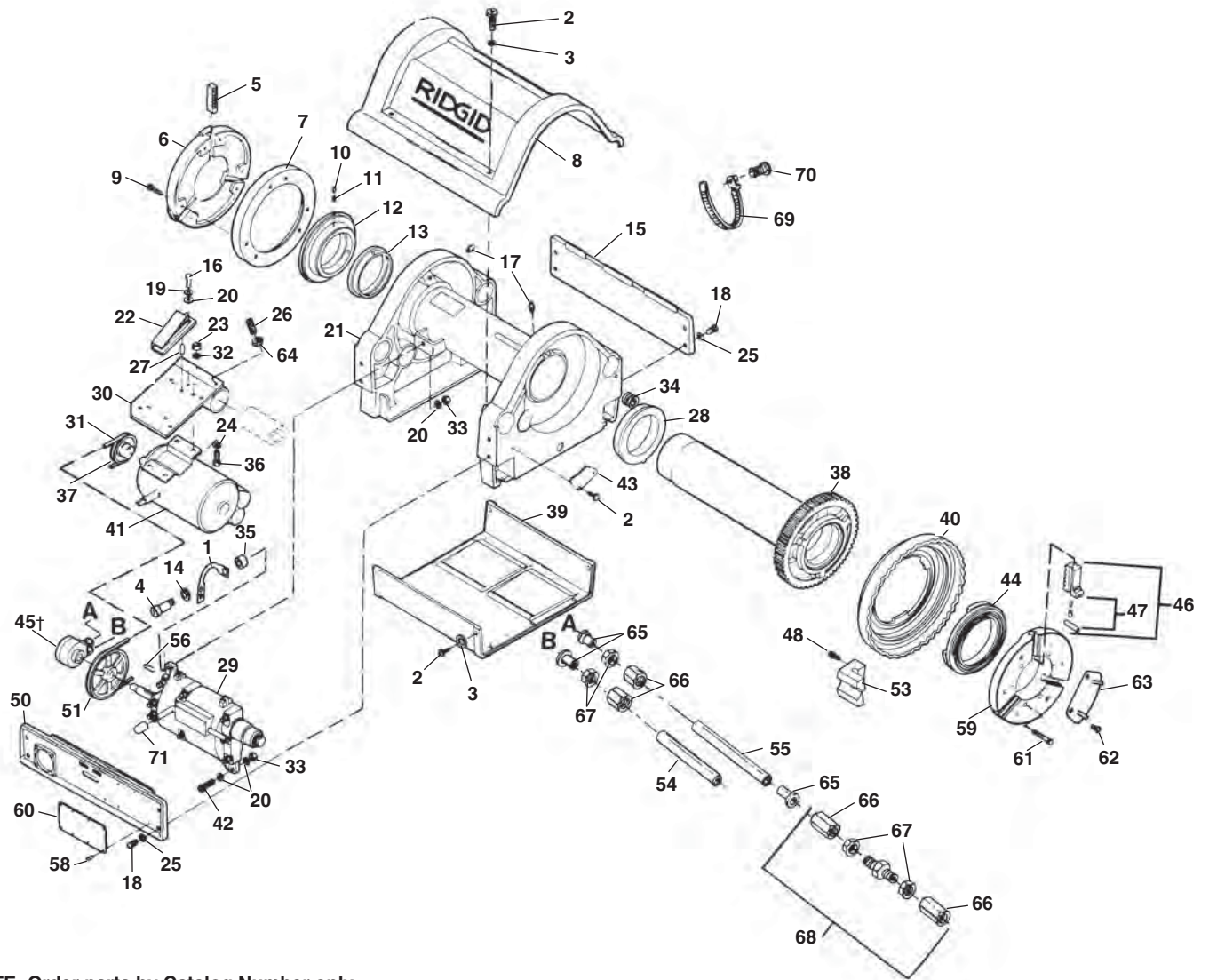


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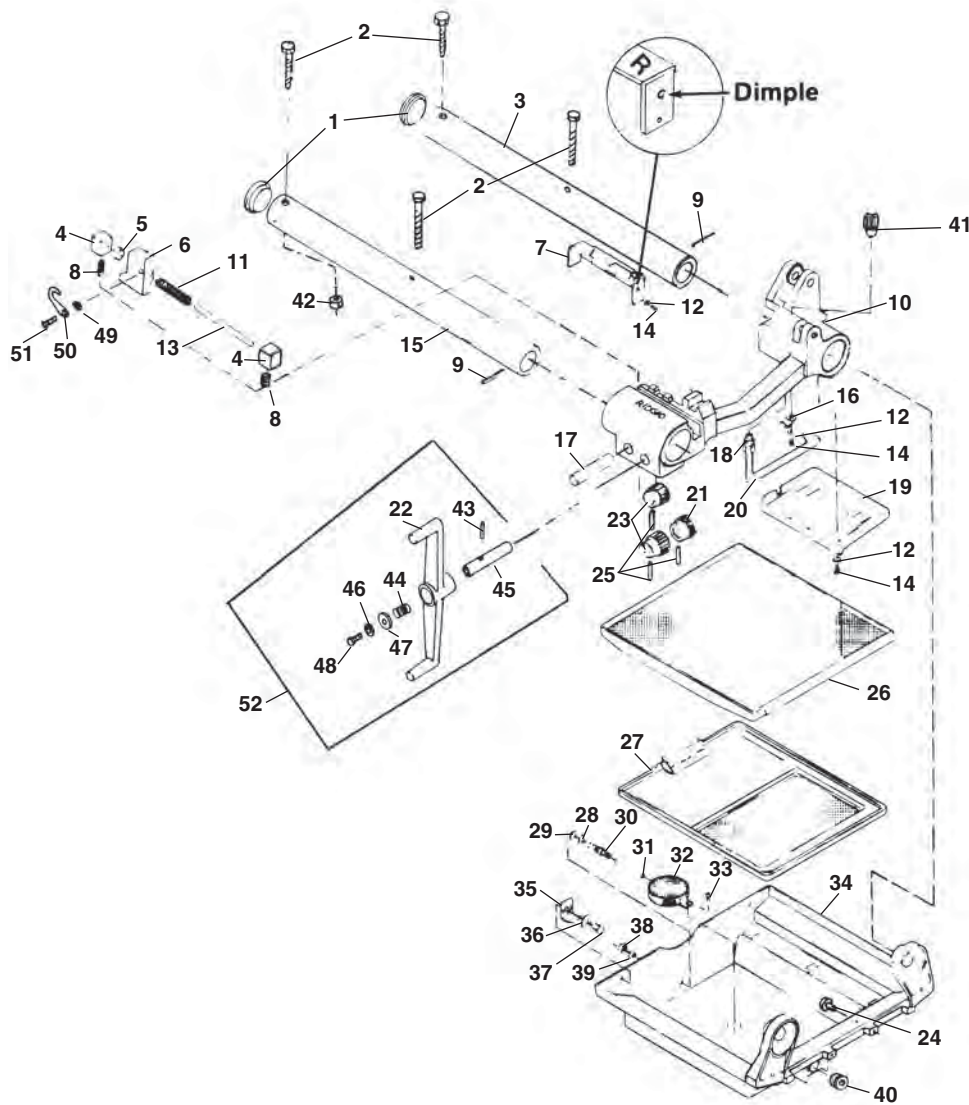
**Main Drive Components**



**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
1	33622	Pump Bracket	26	88265	Set Screw $\frac{3}{8}$ " - 16 x 1"	46	40087	Chuck Jaw Set
2	41597	Screw (12)	27	88230	Roll Pin $\frac{1}{4}$ " x $\frac{9}{16}$ "	47	47517	Chuck Jaw Set Pl. Ctd. Pipe
3	41592	Washer (10)	28	26767	Front Bearing	47	26242	Jaw Insert Set
4	33627	Screw	29	26362	Gear Box Assy.	47	26247	Jaw Insert Set F/Coated Pipe
5	32412	Centering Jaw Set	30	27062	Motor Bracket	48	27067	Self-Tapping Screw (2 Req. f/G.S.)
6	26537	Centering Head	31	26832	V-Belt	50	59722	Front Side Plate
7	26542	Back Plate	32	40770	Lock Washer $\frac{5}{16}$ " (4)	51	26852	Gear Box Pulley
8	26477	Top Cover	33	27517	Lock Nut $\frac{5}{16}$ " - 18	53	26507	Pinch Point Boss (2 Req. f/G.S.)
	46867	Die Head Decal (Not Shown)	34	47080	Grommet	54	27007	Inlet Hose
9	40910	Screw $\frac{1}{4}$ " - 20 x $\frac{3}{4}$ " (6)	35	33617	Spacer	55	26822	Output Hose
10	45300	Set Screw $\frac{5}{16}$ " - 24 x $\frac{1}{4}$ " (3)	36	85910	Bolt $\frac{5}{16}$ " - 18 x 1 $\frac{1}{4}$ "	56	27002	Key
11	45265	Set Screw $\frac{5}{16}$ " - 24 x $\frac{1}{2}$ " (3)	37	26857	Motor Pulley (60 Hz)	58	85920	Rivets (8)
12	32407	Scroll		27082	Motor Pulley (50 Hz)	59	26332	Chuck Cap
13	26352	Rear Bearing	38	26347	Drive Gear/Spindle Assy.	60	88690	Safety Plate
14	26307	Washer	39	26482	Bottom Cover	61	26522	Screw $\frac{5}{16}$ " - 24 x 2 $\frac{1}{4}$ " (6)
15	26487	Rear Side Plate	40	26337	Handwheel	62	27242	Screw 10 - 32 (6)
16	32145	Screw $\frac{1}{4}$ " - 20 x $\frac{1}{2}$ "	41	26237	Motor w/Capacitor 120V, 60 Hz	63	33612	Set of 3 Cover Plates
17	46860	Grease Fitting (2)		27287	Motor w/Capacitor 110V, 50 Hz	64	83545	Jam Nut $\frac{5}{8}$ " - 16
18	26997	Screw $\frac{3}{8}$ " - 16 x $\frac{3}{4}$ " (8)		26232	Motor w/Capacitor 240V, 60 Hz	65	35117	Tube Insert (3)
19	44740	Lock Washer $\frac{1}{4}$ "		27282	Motor w/Capacitor 220/240V, 50 Hz	66	40602	Compression Nut
20	96740	Washer $\frac{5}{16}$ "		28052	Motor w/Capacitor 220V, 50 Hz GS	67	40607	Ferrule
21	26357	Base	42	27037	Shoulder Bolt	68	26972	Union
22	26492	Belt Tensioner	43	27012	Pinion Guard	69	43552	Tie Down Strap
23	96730	Nut $\frac{5}{16}$ " - 18 (4)	44	26517	Scroll	70	45275	Screw 10 - 24 x $\frac{1}{2}$ "
24	27402	Washer $\frac{5}{16}$ " (4)	45†	27307	Oil Pump	71	27032	Shifter Knob
25	40930	Lock Washer $\frac{3}{8}$ " (8)						

Carriage and Chip Pan



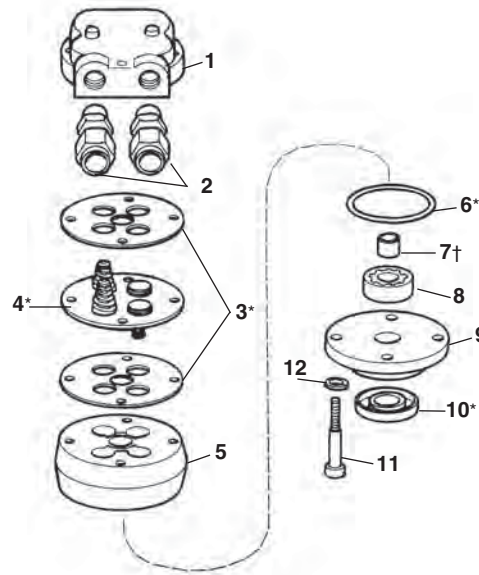
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Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
—	49992	Carriage Assembly (Includes Ref. #4-8, 10-14, 17, 21, 23, 25, 41, 49-52)	17	26777	Sine Bar/Pinion Shaft (2)	36	40930	Lock Washer 3/8" (2)
1	26502	Rail Plug (2)	18	26562	Supply Line Fitting	37	26997	Screw 3/8" - 16 x 3/4" (2)
2	40167	Bolt 5/16" - 18 x 3 1/2" (4)	19	26772	Drip Plate	38	83545	Hex Nut 3/8" - 16
3	49982	Rear Rail	20	26812	Die Lubrication Tube	39	26307	Washer
4	26787	Guide Block (2)	21	26587	Sine Bar Pinion	40	48337	Drain Plug
5	26792	Sine Bar Spacer	22	40147	Carriage Handwheel		26842	Drain Plug (Rubber-Early Style)
6	40242	Sine Bar	23	26572	Carriage Pinion (2)	41	28462	Ball Detente
7	26912	Sine Bar Cover Assembly	24	26837	Stud (2)	42	27517	Lock Nut 5/16" - 18 (4)
8	26582	Guide Block Spring (2)	25	74965	Roll Pin 1/4" x 1 1/4" (3)	43	74965	Pin
9	27052	Roll Pin (2)	26	26802	Draw Tray Assembly	44	89530	Spring
10	49987	Carriage (Includes Ref. #41)	27	26807	Insert Assembly	45	40157	Handwheel Shaft
11	26592	Sine Bar Return Spring	28	27252	Washer	46	41582	Lock Washer
12	41592	Washer #10 (2)	29	41715	Seal Washer	47	40152	Washer
13	26577	Guide Bar	30	26697	Bulk Head Fitting	48	26997	Screw
14	79965	Screw #10 - 32 x 1/2" (5)	31	26927	Tubing	49	40227	Spring Washer
15	49977	Front Rail	32	27262	Screen Assembly	50	40237	Latch
16	26652	Oil Supply Clamp	33	26797	Screw #10 - 32 x 5/16"	51	49472	Spiral Pin
			34	26847	Chip Pan Hanger Assembly	52	42027	Handwheel Kit
			35	26817	Chip Pan Bracket (2)			

### “ML” Oil Pump

**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description
—†	27307	“ML” Oil Pump
1	33442	Pump Valve Body
2	33432	Compression Fitting (2)
3*	33457	Gasket (Set of 2)
4*	33452	Valve Retainer Assy.
5	33482	Gerotor Housing w/Bearing
6*	33477	O-Ring
7†	33462	Sleeve Bearing
8	33467	Gerotor Set
9	33447	Pump Cap w/Seal
10*	33472	Oil Seal
11	44510	Soc. Hd. Cap Screw 1/4" - 20 x 2"
12	45150	Lock Washer 1/4"
*	33422	“ML” Service Kit



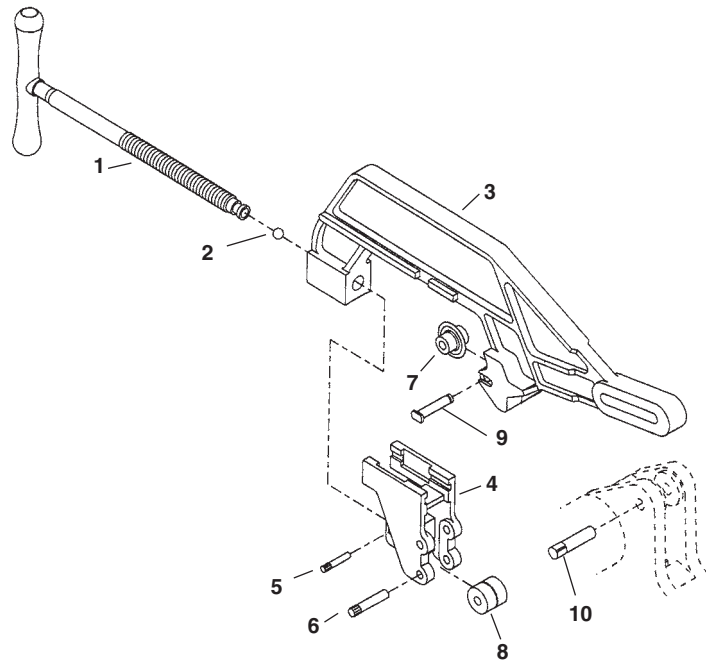
Note: Ref. 7 Sleeve Bearing used on older Gerotor Housings, not required on new pumps.

\* Indicates Part is Included in Service Kit.

† See Service Note

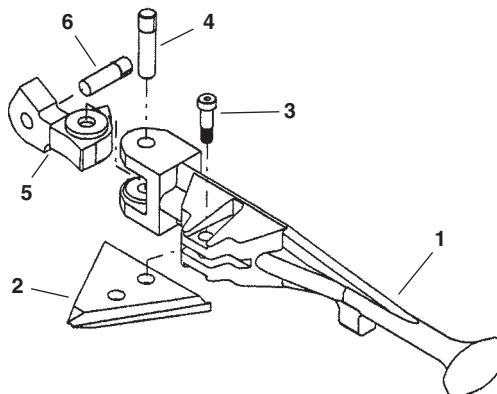
### No. 764 Pipe Cutter

Ref. No.	Catalog No.	Description
—	26212	764 Pipe Cutter
1	26752	Screw Handle
2	41730	Ball Bearing
3	26742	Cutter Frame
4	26747	Roll Housing
5	26757	Groove Pin
6	26762	Groove Pin (2)
7	33125	Cutter Wheel
8	34785	Roll (2)
9	26252	Roll F/Coated Pipe (2 per set)
9	34790	Wheel Pin
10	27072	Groove Pin



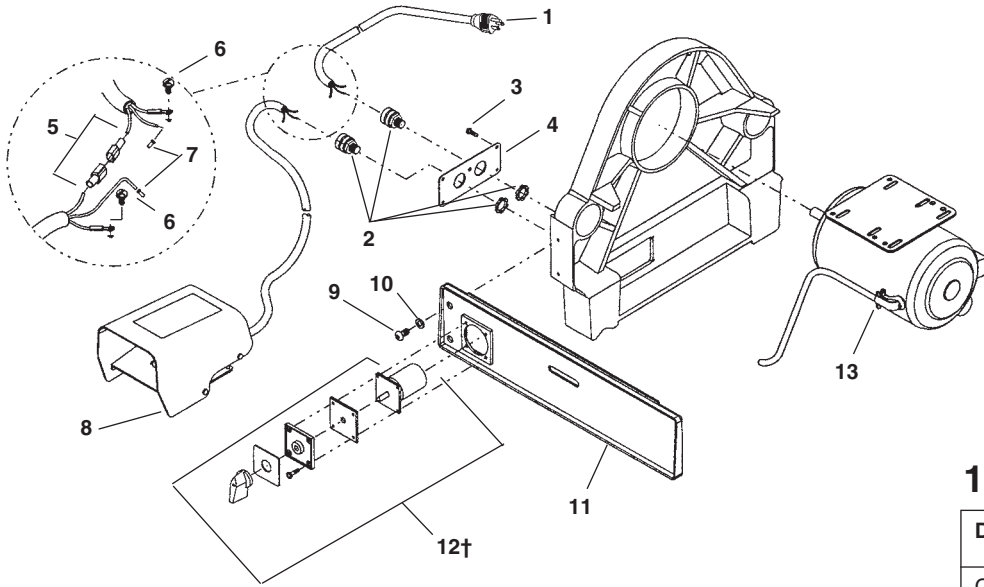
### No. 744 Reamer Assembly

Ref. No.	Catalog No.	Description
—	26217	744 Reamer Assembly
1	26602	Reamer Arm
2	34577	Reamer Blade 1/4" - 4"
3	27037	Shoulder Bolt
4	27072	Groove Pin
5	26607	Pivot Block
6	26727	Groove Pin (2)



60 Hz Electrical Components

NOTE: Order parts by Catalog Number only.  
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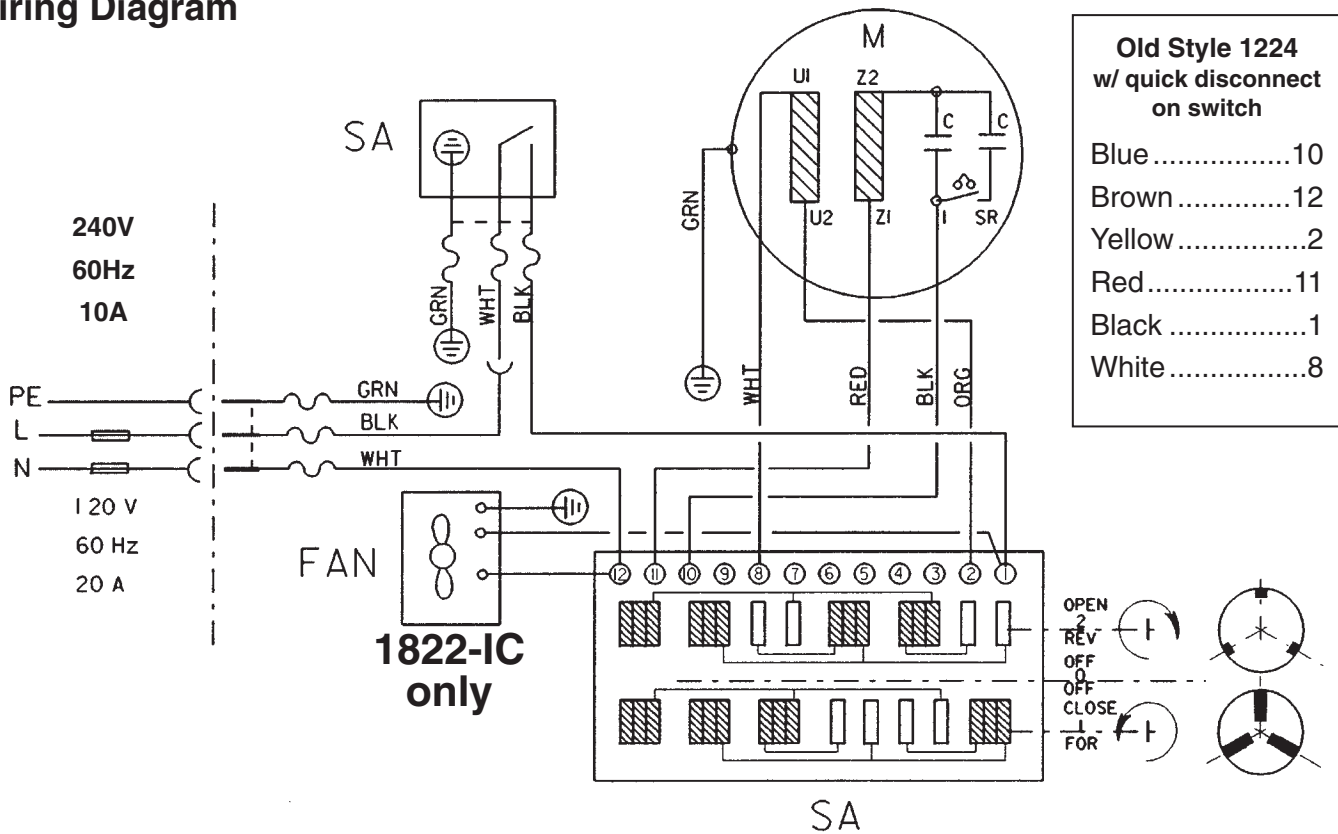


Ref. No.	Catalog No.	Description
1	46740	Power Cord
	46410	Power Cord
2	75977	Strain Relief (2)
3	41597	Self Tapping Screw (4)
4	27162	Strain Relief Bracket
5	56407	Quick Disconnect Set
6	45420	Ground Screw
7	36222	Wire Terminal
8	36642	B-294 Foot Switch
9	26997	Screw 3/8" - 16 x 3/4" (8)
10	40930	Lock Washer 3/8" (8)
11	59722	Front Side Plate
12†	20113	Switch Assembly
13	26237	Motor 120V 60 Hz
	26232	Motor 240V 60 Hz

1224 Motor Parts

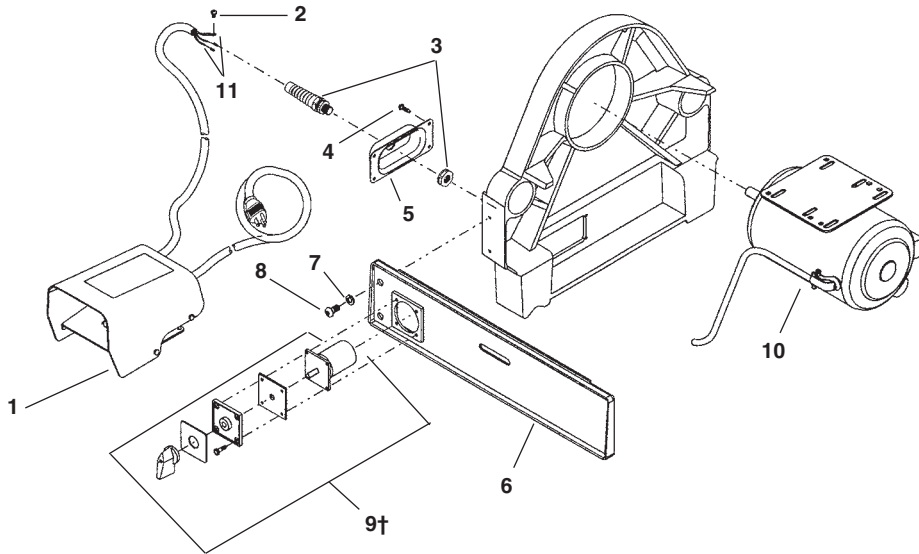
Description	120V 60Hz	240V 60Hz
Contact Start Switch	21148	—
Start Capacitor	54332	—
Run Capacitor	46807	46807

1224 & 1822-I Replacement Switch Wiring Diagram



### 50 Hz Electrical Components

**NOTE: Order parts by Catalog Number only. DO NOT order by Reference Number.**



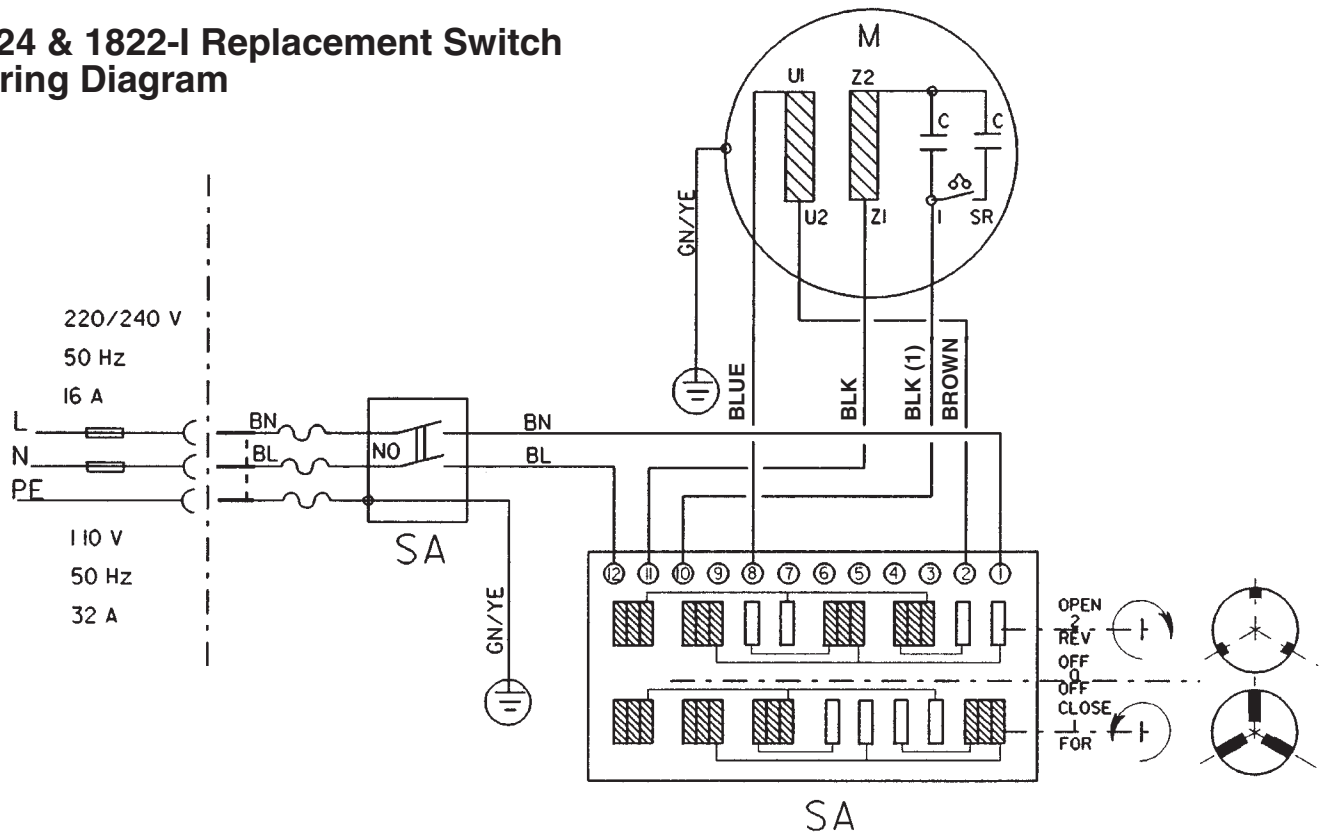
Ref. No.	Catalog No.	Description
1	36652	B-296 Foot Switch
	36657	B-297 Foot Switch
2	45420	Ground Screw
3	27187	Strain Relief
4	41597	Self Tapping Screw (4)
5	27197	Strain Relief Bracket
6	59722	Front Side Plate
7	40930	Lock Washer 3/8" (8)
8	26997	Screw 3/8" - 16 x 3/4" (8)
9†	20113	Switch Assembly
10	27282	Motor 220/240V 50 Hz
	27287	Motor 110V 50 Hz
11	36222	Wire Terminal

### 1224 Motor Parts

Description	220V/240V 50Hz	110V 50Hz
Dual Contact Start Switch	46772	46772
Start Capacitor	46792	—
Run Capacitor	46807	—

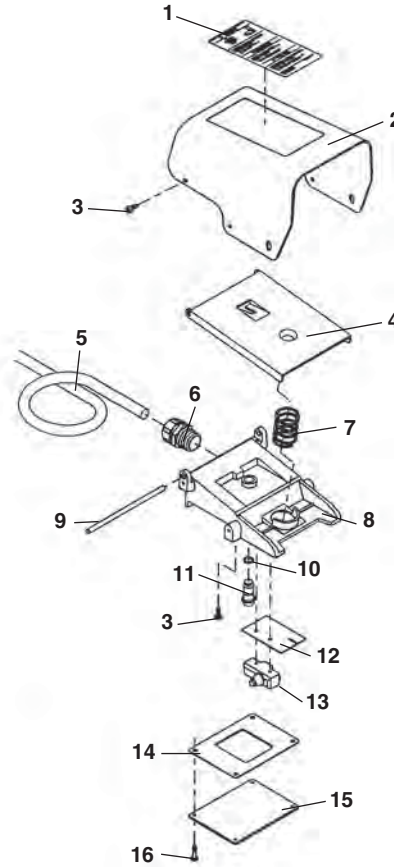
† Ref. No. 12 – When replacing early style switches, which have a black body, order Switch Kit, Catalog No. 59762. Kit includes 59757 Switch Assembly and 59742 Switch Adapter Plate

### 1224 & 1822-I Replacement Switch Wiring Diagram



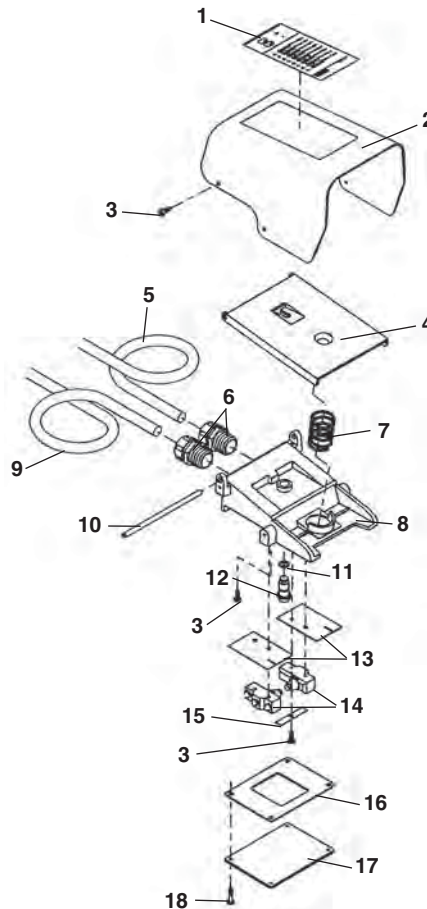
NOTE: Order parts by Catalog Number only.  
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Ref. No.	Catalog No.	Description
—	36642	B-294 Foot Switch
—	36647	B-295 Foot Switch
—	36662	301-A Foot Switch
—	75962	B-294 HD Foot Switch
1	36667	Warning Label (B-294)
	36672	Warning Label (B-295)
	36687	Warning Label (301-A)
	76352	Warning Label (B-294 HD)
2	36692	Cover
3	36787	Screw #10 Self-tapping (5)
4	36697	Foot Pedal
5	68880	Cord (B-294)
	36712	Cord (B-295)
	36727	Cord (301-A)
	75972	Cord (B-294 HD)
6	36732	Cord Connector
	75977	Cord Connector (B-294 HD)
7	36702	Spring
8	54347	Base
9	36747	Pivot Pin
10	36767	O-Ring
11	36772	Poppet
12	54367	Insulator
13	36762	Micro Switch
14	54372	Seal
15	54362	Bottom Cover
16	54357	Bottom Cover Screw (4)



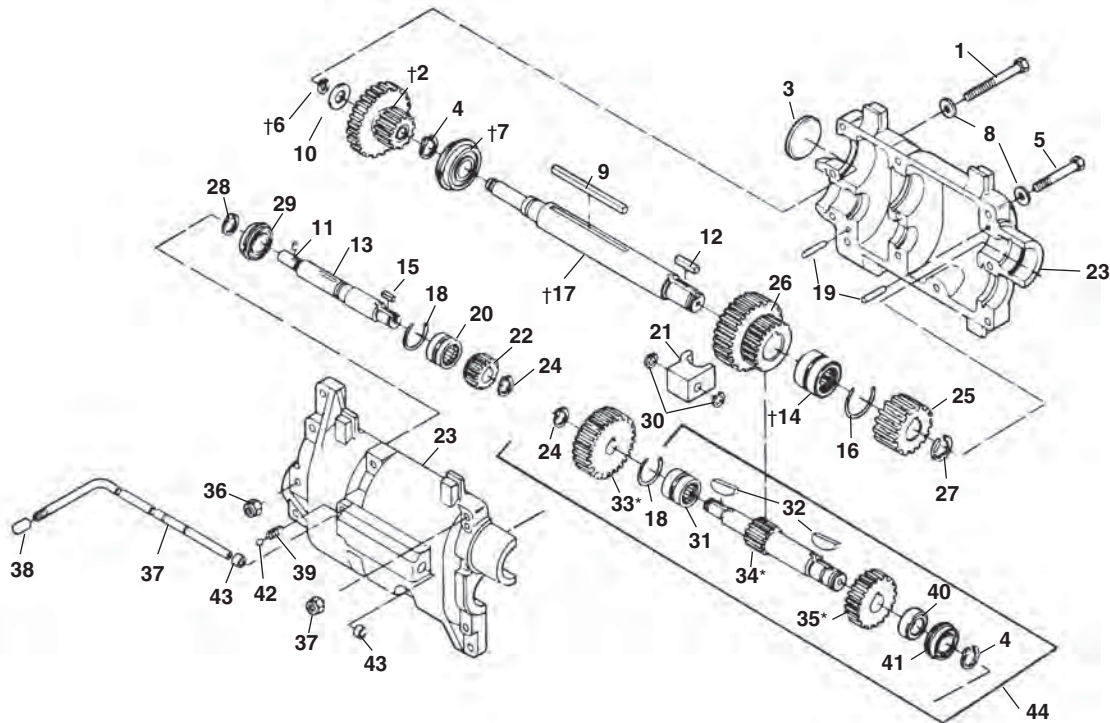
**B-294**  
**B-295**  
**301-A**  
**B-294 HD**

Ref. No.	Catalog No.	Description
—	36652	B-296 Foot Switch
—	36657	B-297 Foot Switch
—	40017	B-298 Foot Switch (U.K.)
—	40022	B-299 Foot Switch (Australia)
1	36677	Warning Label (B-296)
	36682	Warning Label (B-297)
	54392	Warning Label (B-298)
	45017	Warning Label (B-299)
2	54382	Cover
3	36787	Screw #10 Self-tapping (6)
4	36697	Foot Pedal
5	36717	Cord (B-299)
	18906	Cord (B-296)
	36722	Cord (B-297)
	45027	Cord (B-298)
6	36732	Cord Connector (2)
7	36702	Spring
8	54352	Base
9	18916	Line Cord (B-296)
	36797	Line Cord (B-297)
	45022	Line Cord (B-298)
	93210	Line Cord (B-299)
10	36747	Pivot Pin
11	36767	O-Ring
12	36772	Poppet
13	54367	Insulator (2)
14	36762	Micro Switch (2)
15	54377	Switch Bracket
16	54372	Seal
17	54362	Bottom Cover
18	54357	Bottom Cover Screw (4)



**B-296**  
**B-297**  
**B-298**  
**B-299**

**Gear Box**



**NOTE: Order parts by Catalog Number only.  
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
—	26362	Gear Box Assembly	16	26922	Wire Ring	32	33982	Woodruff Key (2)
1	27102	Screw 5/16" - 18 x 3 1/4" (2)	†17	26382	Output Shaft	33*	33992	1st Gear Constant Speed
†2	26702	Fixed Gear Cluster Assembly	18	26917	Wire Ring (2)	34*	33987	Constant Speed Shaft
3	26667	Freeze Plug	19	26662	Dowel Pin (2)	†35*	33997	Large Constant Speed Gear
4	26412	Snap Ring (2)	20	26367	Front Input Bearing	36	75110	Stop Nut 5/16" - 18 (11)
5	27107	Screw 5/16" - 18 x 2 1/2" (9)	21	26437	Shifting Fork	37	26442	Shift Slide
†6	27117	Snap Ring	22	26377	1st Input Gear	38	27032	Shifter Knob
†7	26417	Rear Output Bearing	23	26647	Gear Box	39	26692	Shifter Detente Spring
8	96740	Washer 5/16" (11)	24	26677	Snap Ring	40	26452	Spacer
9	26552	Shift Cluster Key	†25	26432	Output Pinion Gear	41	26407	Front Constant Speed Bearing
10	26672	Thrust Washer	26	26422	Cluster Shift Gear	42	46925	Steel Ball
11	26907	Spiral Pin	27	26557	Snap Ring	43	26447	Shift Slide Sleeve Bearing
12	26457	Output Pinion Key	28	44430	Retaining Ring		26707	Grease (1 lb. can)
13	26902	Input Shaft Assembly	†29	26372	Input Rear Bearing	44	28047	Constant Speed Assembly
†14	26427	Front Output Bearing	30	34245	Rings Set of 5			
15	26657	Input Pinion Key	31	26397	Rear Bearing			

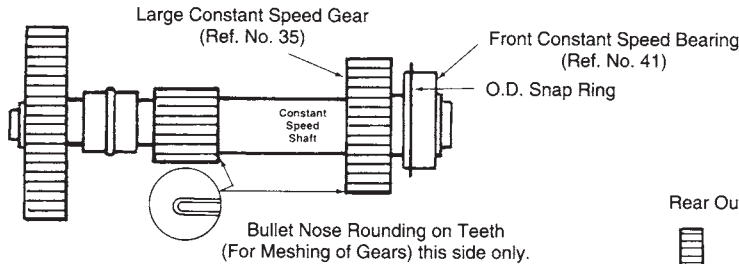
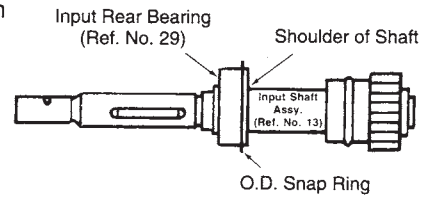
†See Service Notes

\*When replacing early style parts, using square keys, a complete shaft assembly (Ref. No. 44) should be used.

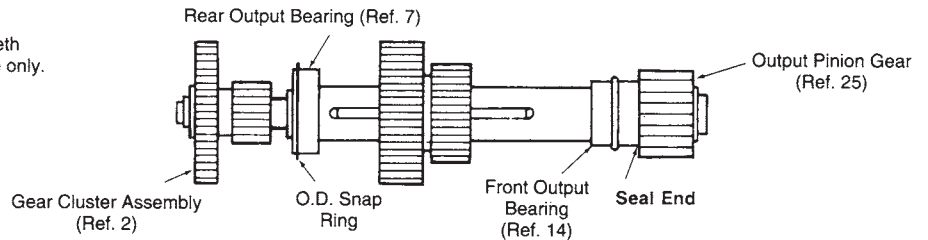


**Service Notes  
Transmission**

Position Bearing (Ref. No. 29) with O.D. Snap Ring towards shoulder of Input Shaft.



Position Large Constant Speed Gear Ref. No. 35 so that bullet nose side of gear teeth are facing toward center of shaft. Position O.D. Snap Ring towards Large Constant Speed Gear.



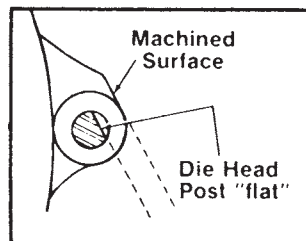
Position Bearing (Ref. No. 7) with O.D. Snap Ring towards Gear Cluster (Ref. No. 2)

Position Seal End of Front Output Bearing (Ref. No. 14) towards Output Pinion Gear (Ref. No. 25)

**Replacement Instructions for Die Head Post  
All 1224 Die Heads— 541, 542, 711, 713, 714, 911, 913, 914**

**—IMPORTANT—**

Post must be properly oriented to insure oil flow through head. Insert illustrates proper relationship (parallel) of "flat" on die head post to flat "machined surface" of die head casting.



**Oil Pump**

**Installing Oil Pump Onto Input Shaft Assembly**

1. Align Square Slot (behind seal) in the No. 27307 Oil Pump with the Drive Pin in the No. 26902 Gear Box Input Shaft Assembly.
2. Slide Oil Pump onto Input Shaft Assembly.
3. When Pump is properly engaged onto Shaft, the distance between Pump body and Keyway Slot should not exceed 1/8 inch.

