

# Parts Manual



**SAWING PRODUCTS**

## C-916M

**Serial No: 527-96101 to 527-102304**

## Band Sawing Machine

# MACHINE SPECIFICATIONS

MODEL   SERIAL NO.  
VOLTAGE  CYCLE  PHASE

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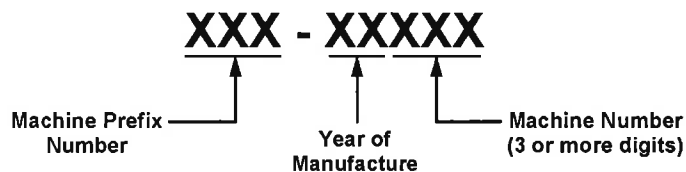
For your information and future reference, insert pertinent data concerning your machine in the spaces provided above. This information is stamped on the data plate attached to the machine frame.

Always specify model and serial numbers 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 to change specifications or design at any time without notice and without incurring obligations.

How to read your serial number:

Example: 500-001234



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**For Sales, Parts and Service, call 1-888-362-5572.**



**DoALL SAWING PRODUCTS**  
2375B TOUHY AVENUE  
ELK GROVE, ILLINOIS 60007 U.S.A.

**YOUR SERVICE REPRESENTATIVE:**

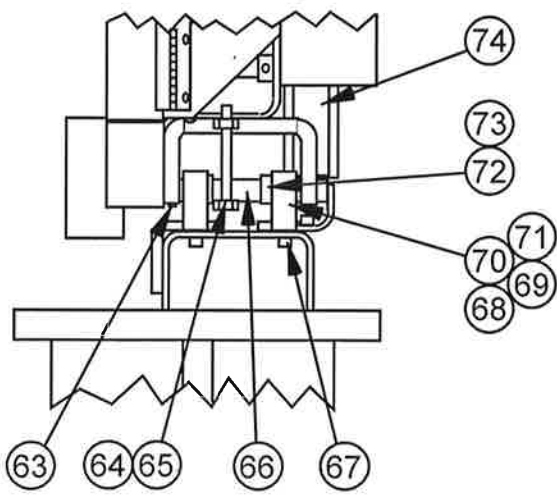
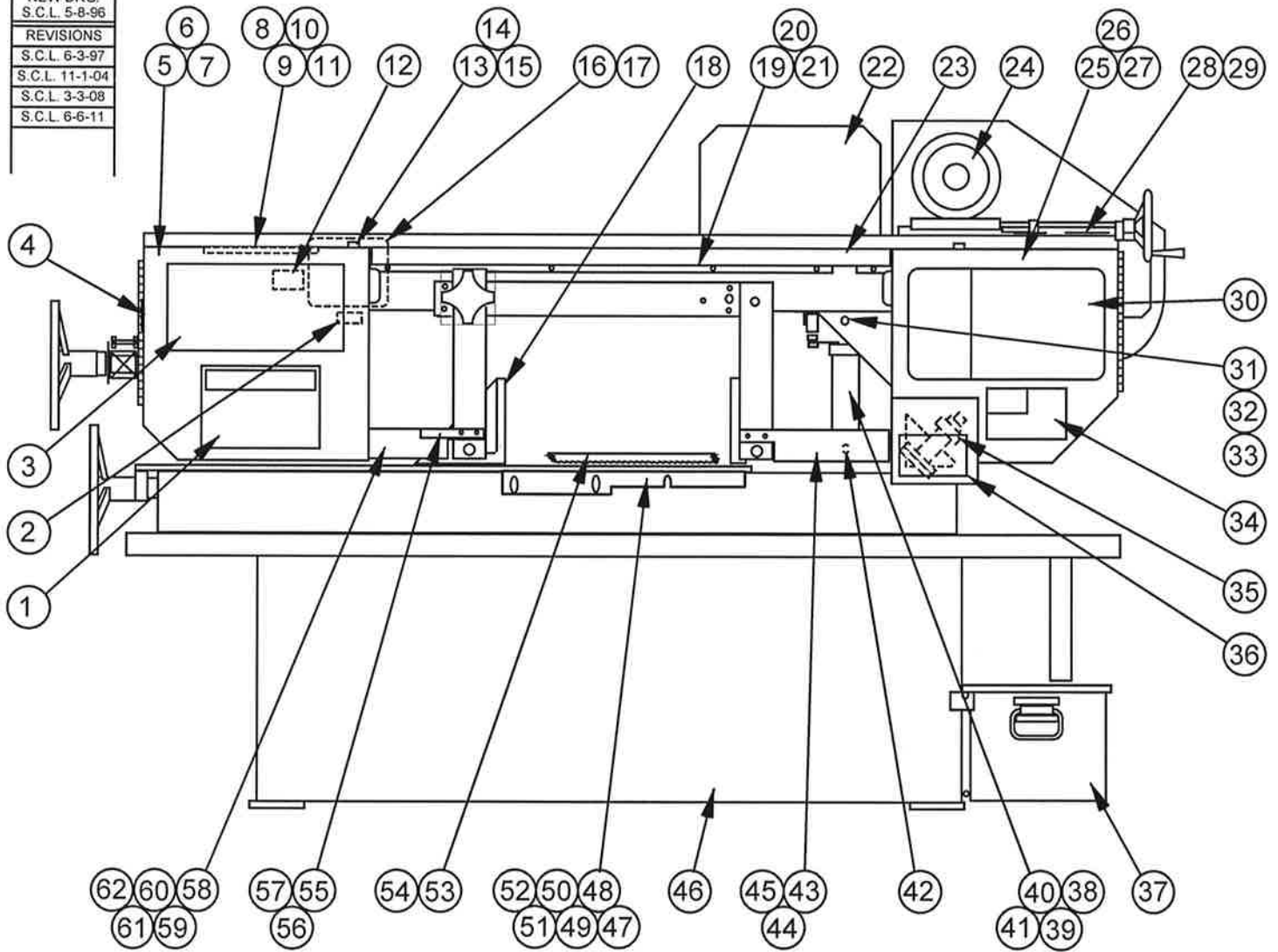
## PARTS MANUAL INDEX

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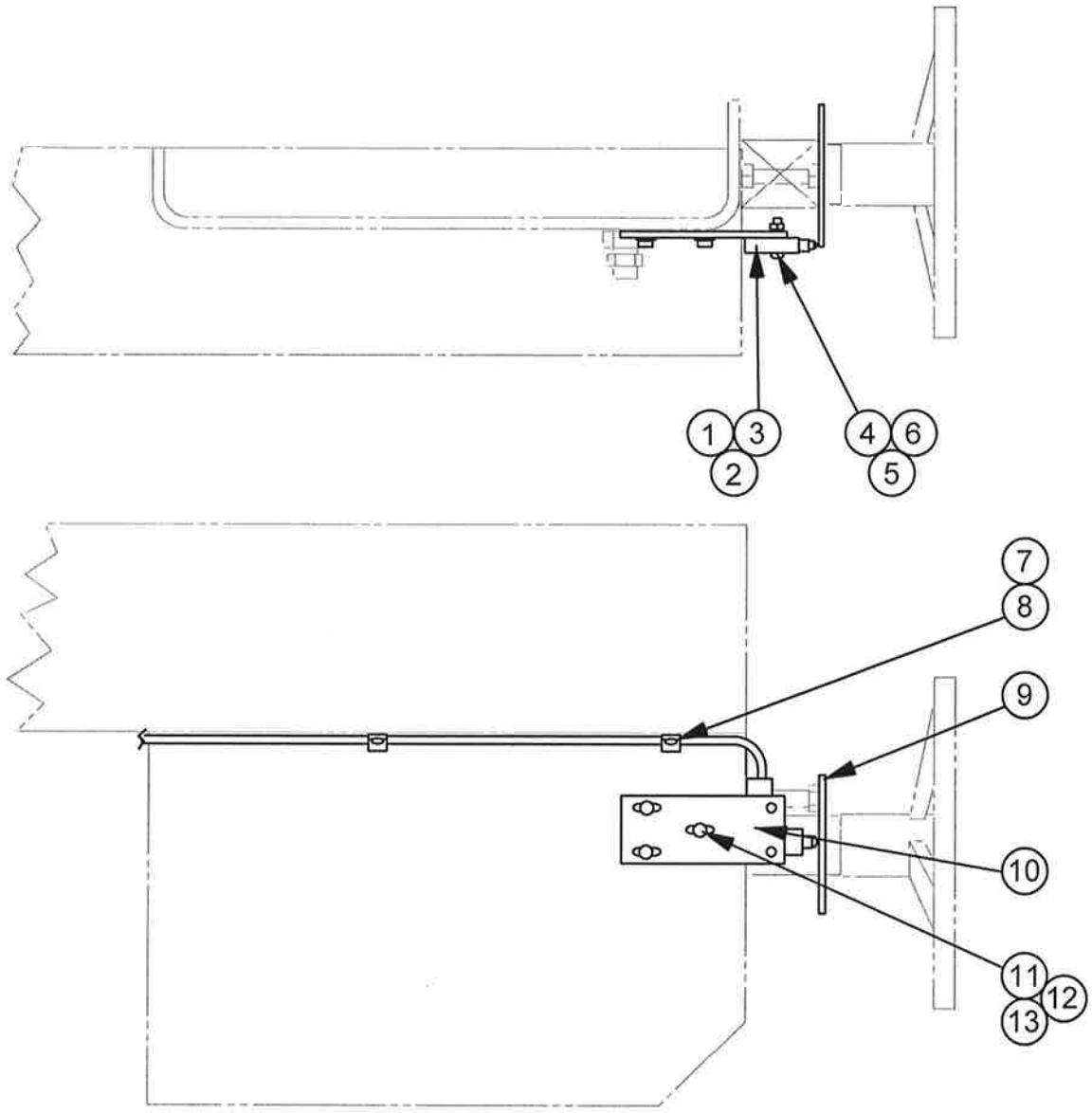
MODEL FIRST MACH. LAST MACH.  
 C-916M 527-96101 527-102304

### FINAL ASSEMBLY

**FINAL ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	190081	Final Assembly		55	320595	. L.H. Blade Guard Weldment .....	1
Ref.	517074	Main Saw Assembly		56	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 ...	2
1	404478	. Escutcheon (Warning) .....	1	57	199258	. Washer, Flat #10 S.A.E. Std. ....	2
2	203032	. Escutcheon (Gross Weight) (Optional).	1	58	319174	. Shield .....	1
3	416163	. Escutcheon (DoALL) .....	2	59	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 ...	2
4	176072	. Escutcheon (Band Tension) .....	1	60	199258	. Washer, Flat #10 S.A.E. Std. ....	2
5	319175	. L.H. Door Weldment .....	1	61	199202	. Nut, Hex. M5-0.8 .....	2
6	199299	. Self Drilling Fasterner M4.8 x 13 .....	4	62	198022	. Nylon Edging .....	A.R.
7	197022	. Nylon Edging .....	A.R.	63	199251	. Screw, Soc. Set M10-1.5 x 12 (Cone Point) .....	1
8	175478	. Door Stop .....	1	64	199249	. Screw, Hex. Hd. Cap M10-1.5 x 120 ...	1
9	199899	. Screw, Button Hd. Soc. M6-1.0 x 16 ...	1	65	199976	. Nut, Hex. Jam M10-1.5 .....	1
10	199245	. Locknut M6-1.0 .....	1	66	176727	. Shaft .....	1
11	199965	. Washer, Flat M6 .....	1	67	199680	. Screw, Soc. Hd. Cap M10-1.5 x 30 ....	4
12	206698	. CE Label .....	1	68	326124	. Bearing Block .....	2
13	316583	. Spring Latch .....	2		201914	. Bearing .....	2
14	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 ...	4	69	176476	. Shim (.003) .....	A.R.
15	198258	. Washer, Flat #10 S.A.E. Std. ....	4	70	176477	. Shim (.005) .....	A.R.
16	323891	. Escutcheon (Machine Specifications) ..	1	71	176478	. Shim (.007) .....	A.R.
17	199397	. Screw, Rd. Hd. Drive #2 x 1/4 .....	1	72	126535	. Bronze Thrust Bearing .....	2
18	517259	. Swivel Vise Jaw Assembly (See Detail)	1	73	201915	. Shaft Collar .....	2
19	417800	. Band Cover Weldment .....	1	74	517253	. Counter Balance Mechanism Assembly (See Detail) .....	1
20	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 ...	5			Following Not Shown:	
21	198258	. Washer, Flat #10 S.A.E. Std. ....	5	406872	. Instruction Tag .....	1	
22	517261	. Electrical Assembly (See Detail) .....	1	199045	. Screw, Soc. Set M10-1.5 x 16 (Pivot Shaft) .....	1	
23	517251	. Head Assembly (See Detail) .....	1	416770	. Shipping Bracket (Head to Base) .....	1	
24		. Drive Assembly (See Detail) .....	1	319328	. Shipping Bracket (Pawl Hold Down - Pneumatic Vise Option Only) .....	1	
25	313217	. R.H. Door Weldment .....	1	199966	. Screw, Soc. Hd. Cap M6-1.0 x 16 .....	6	
26	199299	. Self Drilling Fasterner M4.8 x 13 .....	4	199965	. Washer, Flat M6 .....	6	
27	197022	. Nylon Edging .....	A.R.	199347	. Washer, Lock M6 .....	6	
28	175268	. Cover .....	1	208092	. Shipping Pallet and Hardware .....	1	
29	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 ...	2	214769	. DoALL Cutting Fluid .....	1	
30	415169	. Job Selector .....	1	042490	. Shovel/Rake .....	1	
31	175144	. Pin .....	1	199253	. Screw, Hex. Hd. Cap M16 x 2.0 x 70 ..	4	
32	6-004415	. Set Screw Collar .....	1	199955	. Nut, Hex. Jam M16 x 2.0 .....	4	
33	35-006426	. Retaining Ring .....	4	206888	. Documentation CD .....	1	
34	201469	. Decal (American Flag) .....	1	209656	. T-Frame Assy (Saw to Conveyor) (Optional) .....	1	
35	417836	. Band Brush Assembly (See Detail) .....	1	217376	. Lubrication Chart (Optional) .....	1	
36	209652	. Label (Diameters/X-Section Area) .....	1				
37	517260	. Coolant Assembly (60 Hz) (See Detail)	1				
	219825	. Coolant Assembly (50 Hz) (See Detail)	1				
38	417919	. Head Feed Cylinder & Control Valve Sub-Assembly (Standard) (See Detail) .....	1				
	207504	. Head Feed Cylinder & Control Valve Sub-Assembly (Full Cycle Option) (See Detail)	1				
39	320619	. Bracket .....	1				
40	198161	. Screw, Hex. Hd. Cap M10-1.5 x 20 .....	2				
41	199346	. Washer, Lock M10 .....	2				
42	320620	. Pin .....	1				
43	318438	. R.H. Blade Guard .....	1				
44	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 ...	2				
45	199258	. Washer, Flat #10 Std. S.A.E. ....	2				
46	517247	. Base Weldment .....	1				
47	325466	. Discharge Tray .....	1				
48	199246	. Screw, Button Hd. Soc. M6-1.0 x 12 ...	3				
49	326601	. Mounting Angle .....	1				
50	199239	. Screw, Soc. Hd. Cap M8-1.25 x 20 .....	3				
51	199968	. Washer, Lock M8 .....	3				
52	199967	. Washer, Flat M8 .....	3				
53	209790	. Saw Band (Imperial Bi-MetalSuper Silencer) .....	1				
54	304525	. Saw Band Tag .....	1				

NEW DRG. S.C.L. 5-3-96
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S.C.L. 6-12-06
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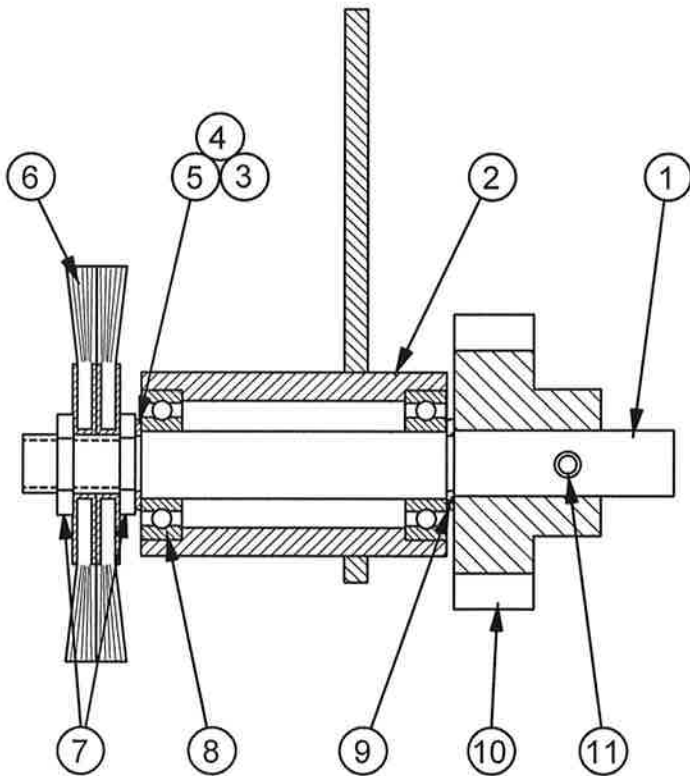
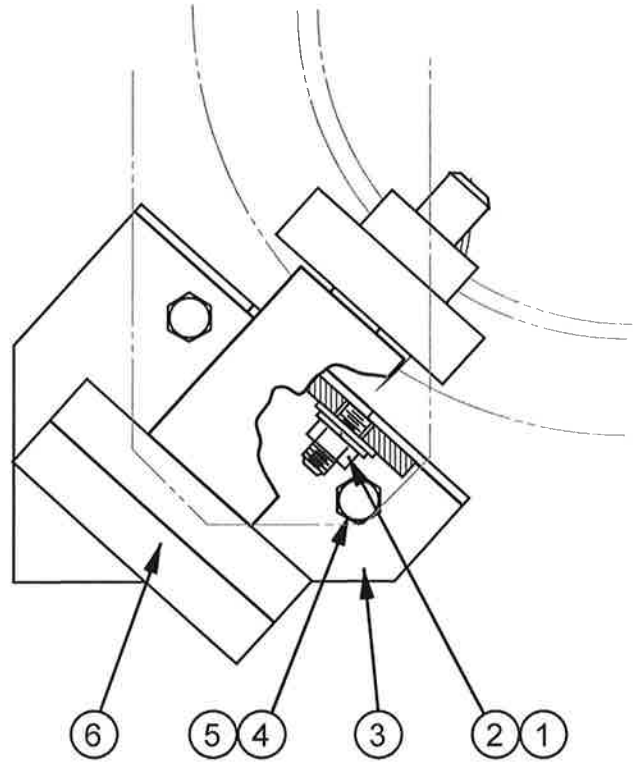
MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916A	528-96101	528-02725
C-916S	529-96101	529-101762
C-916SA	532-96101	532-02139
C-916SA	533-96101	533-04353
C-916DS	537-98101	537-03219
C-916A (VFD-3)	547-00101	547-12471
C-1321DS	550-01101	550-10231

## BAND BREAK LIMIT SWITCH ASSEMBLY

**BAND BREAK LIMIT SWITCH ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	417925	Band Break Limit Switch Assembly	
1	176768	. Limit Switch (Band Break) .....	1
2	197332	. Electrical Cord (#18-2 Conductor) .....	A.R.
3	201266	. Cord Grip Connector (.200-.354) .....	1
4	199389	. Screw, Soc. Hd. Cap M4-0.7 x 30 .....	2
5	199214	. Nut, Hex. M4-0.7 .....	2
6	199297	. Washer, Lock M4 .....	2
7	017247	. Tube Clamp .....	2
8	199408	. Screw, Pan Hd. Mach. M4-0.7 x 10 .....	2
9	204138	. Washer .....	1
10	204139	. Mounting Plate .....	1
11	199243	. Screw, Button Hd. Soc. M5-0.8 x 12 .....	3
12	199244	. Washer, Flat M5 .....	3
13	199348	. Washer, Lock M5 .....	3
Following Not Shown:			
	106966	. Cable Tie (4") .....	2
	200615	. Terminal Block (Control Box) .....	1

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S.C.L. 10-22-09
S.C.L. 6-6-11



MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916A	528-96101	528-02725
C-916S	529-96101	529-101762
C-916SA	532-96101	532-02139
C-916SA	533-96101	533-04353
C-916DS	537-98101	537-03219
C-916A (VFD-3)	547-00101	547-12471
C-330NC	552-01101	552-06173

## BAND BRUSH ASSEMBLY

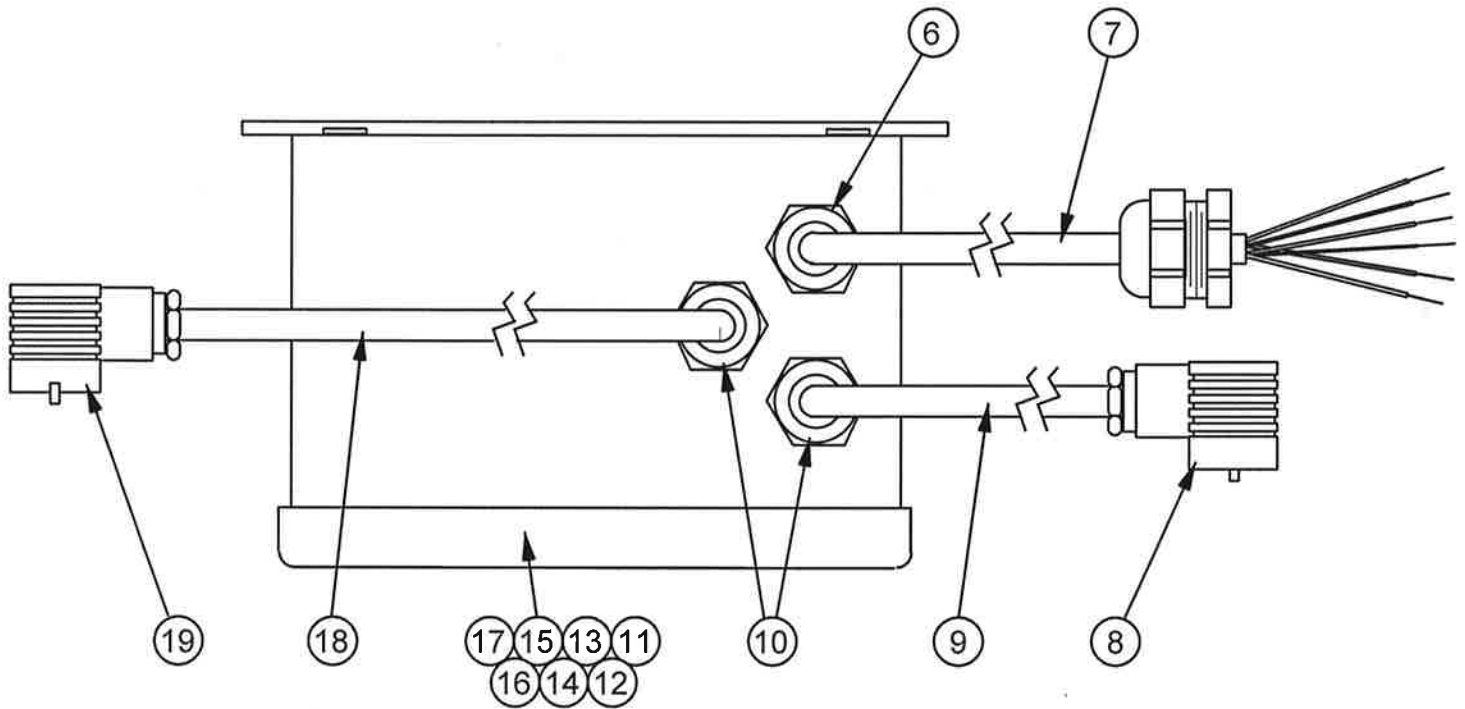
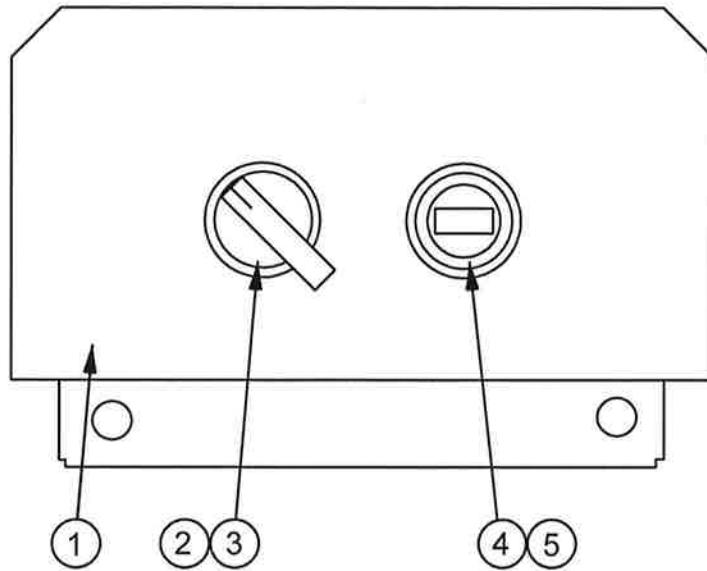


**BAND BRUSH ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	417836	Band Brush Assembly (Powered)	
1	199188	. Nut, Hex. M6-1.0 .....	2
2	199579	. Washer, Flat M6 Wrought .....	4
3	320802	. Bracket Weldment .....	1
4	199899	. Screw, Button Hd. Soc. M6-1.0 x 16 .....	2
5	199347	. Washer, Lock M6 .....	4
6	320800	. Band Brush Assembly (See Detail) .....	1
Ref.	320800	. Band Brush Assembly	
1*	209672	. . Shaft .....	1
2	320799	. . Bracket Weldment .....	1
3	208826	. . Retaining Ring .....	1
4	133470	. . Spacer (.0149) .....	A.R.
5	133471	. . Spacer (.0299) .....	A.R.
6	010983	. . Wire Brush .....	2
7*	199222	. . Nut, Hex. Jam M12-1.75 .....	2
8	207462	. . Bearing .....	2
9	35-009613	. . Retaining Ring If Supplied) .....	1
10	320801	. . Pinion .....	1
11	004260	. . Spring Pin .....	1

\*NOTE: Order #080181 - Shaft Service Kit To Replace Shaft and Hardware on C-916 Series Machines Only.

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MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916S	529-96101	529-101762

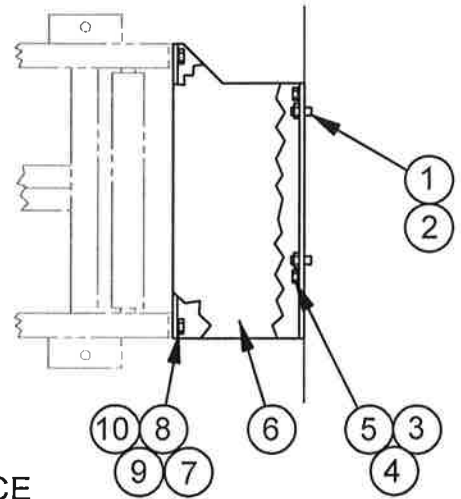
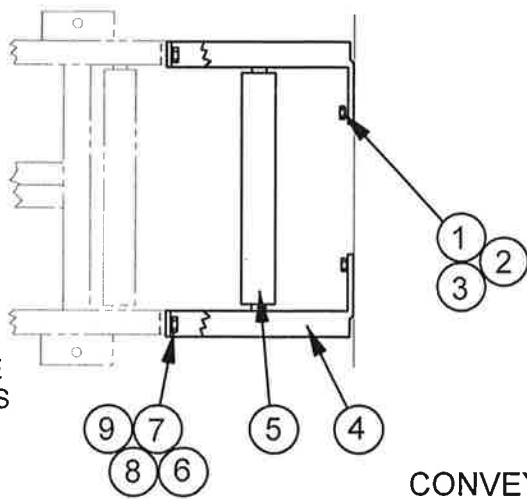
## CONTROL PANEL ASSEMBLY (FULL CYCLE)

**CONTROL PANEL ASSEMBLY**  
(Full Cycle Option)

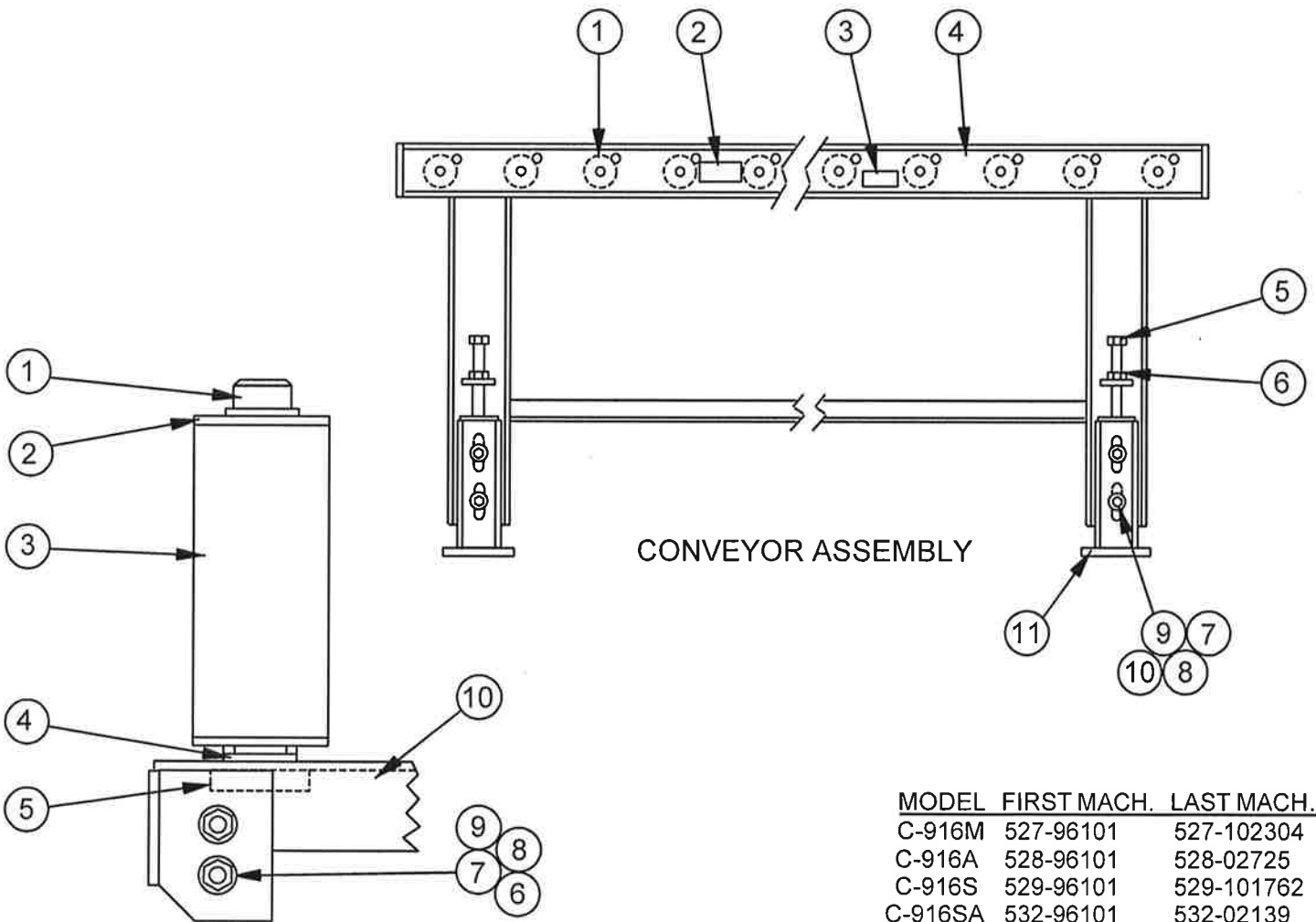
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	417921	Control Panel Assembly (Full Cycle Option)	
1	319397	. Escutcheon .....	1
2	207181	. Selector Switch (2 Position) .....	1
3	207185	. Contact Block (1-NO) .....	1
4	207578	. Toggle Switch (3 Position) .....	1
5	207187	. Contact Block (1-NO, 1-NC) .....	2
6	201696	. Cord Grip Connector (.394-.551) .....	2
7	197331	. Electrical Cord (#18-6 Conductor) .....	A.R.
8	177054	. Solenoid Plug Connector Kit .....	1
9	197332	. Electrical Cord (#18-2 Conductor) .....	A.R.
10	201688	. Cord Grip Connector (.200-.394) .....	2
11	417923	. Enclosure Weldment .....	1
12	417445	. Enclosure Cover .....	1
13	203925	. Gasket Strip .....	A.R.
14	207171	. Rivet Nut M5-0.8 .....	6
15	207170	. Screw, Hex. Hd. Slotted M5-0.8 x 20 .....	4
16	204152	. Nylon Washer .....	4
17	204150	. Retaining Ring .....	4
18	197332	. Electrical Cord (#18-2 Conductor) .....	A.R.
19	177054	. Solenoid Plug Connector Kit .....	1
Following Not Shown:			
	199312	. Screw, Pan Hd. Slotted M5-0.8 x 30 .....	1
	199244	. Washer, Flat M5 .....	1
	199089	. Washer, Lock M5 Shakeproof .....	1
	199202	. Nut, Hex. M5-0.8 .....	1
	197197	. Wire, #16 Red (19 Strand) .....	A.R.
	197325	. Wire, #16 White (19 Strand) .....	A.R.
	007635	. Ring Terminal (#10) .....	2
	201679	. Spade Terminal (1/4") .....	4

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ON SOME MACHINES



CONVEYOR INTERFACE



CONVEYOR ASSEMBLY

VERTICAL GUIDE ROLLER ASSEMBLY

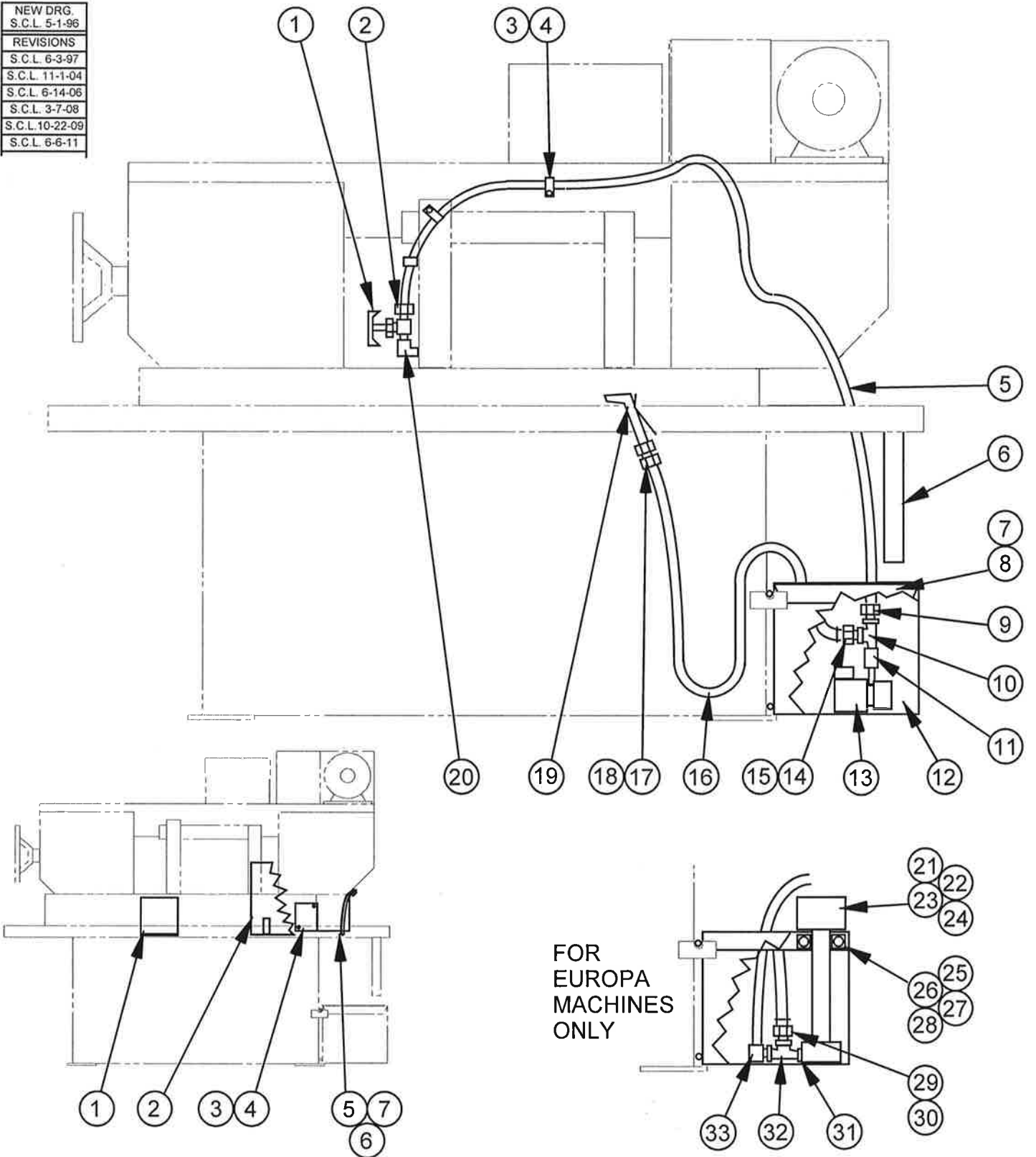
MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916A	528-96101	528-02725
C-916S	529-96101	529-101762
C-916SA	532-96101	532-02139
C-916SA	533-96101	533-04353
C-916DS	537-98101	537-03219
C-916A (VFD-3)	547-00101	547-12471

## CONVEYOR ASSEMBLY (AND RELATED ITEMS)

## CONVEYOR ASSEMBLY (And Related Items)

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	206889	5' Conveyor Assembly (C-916A, C-916M, C-916A [VFD-3])		Ref.	220612	Conveyor Interface	
Ref.	207709	5' Conveyor Assembly (C-916S, C-916SA, C-916DS)		1	205186	. Screw, Soc. Set M8-1.25 x 20 .....	4
1	202786	. Roller .....	5	2	199250	. Nut, Hex. Jam M8-1.25 .....	4
2	203025	. Label (DoALL Logo) .....	2	3	198161	. Screw, Hex. Hd. Cap M10-1.5 x 20 .....	4
3	203035	. Label (Conveyor Capacity) .....	2	4	199346	. Washer, Lock M10 .....	4
4	517266	. Frame Weldment (C-916A, C-916M, C-916A [VFD-3]) .....	1	5	199308	. Washer, Flat M10 Wrought .....	4
	517488	. Frame Weldment (C-916S, C-916SA, C-916DS) .....	1	6	517491	. Interface Plate .....	1
5	199288	. Screw, Hex. Hd. Cap M12-1.75 x 150 .....	4	7*	199975	. Screw, Hex. Hd. Cap M10-1.25 x 35 ...	4
6	199933	. Nut, Hex. M12-1.75 .....	4	8*	199346	. Washer, Lock M10 .....	8
7	199581	. Screw, Hex. Hd. Cap M12-1.75 x 35 ...	8	9*	198976	. Washer, Flat M10 .....	4
8	199289	. Washer, Flat M12 Wrought .....	16	10*	199939	. Nut, Hex. M10 x 1.5 .....	4
9	199345	. Washer, Lock M12 .....	8				
10	199933	. Nut, Hex. M12-1.75 .....	8				
11	417100	. Foot Weldment .....	4				
Ref.	206890	10' Conveyor Assembly (C-916A, C-916M, C-916A [VFD-3])		*NOTE: These Items Are For Conveyor Mounting to Interface and/or to Additional Conveyors and Are Furnished With Conveyors.			
Ref.	207710	10' Conveyor Assembly (C-916S, C-916SA, C-916DS)		Ref.	517268	Vertical Guide Roller Assembly	
1	202786	. Roller .....	10	1	199295	. Screw, Hex. Hd. Cap M16-2.0 x 220 ...	2
2	203025	. Label (DoALL Logo) .....	2	2	850900	. Roller End Bearing .....	4
3	203035	. Label (Conveyor Capacity) .....	2	3	206750	. Roller .....	2
4	517267	. Frame Weldment (C-916A, C-916M, C-916A [VFD-3]) .....	1		206861	. Roller Shaft .....	2
	517489	. Frame Weldment (C-916S, C-916SA, C-916DS) .....	1	4	199296	. Clevis Pin Washer .....	2
5	199288	. Screw, Hex. Hd. Cap M12-1.75 x 150 .....	6	5	206893	. Nut M16-2.0 .....	2
6	199933	. Nut, Hex. M12-1.75 .....	6	6	199975	. Screw, Hex. Hd. Cap M10-1.5 x 35 .....	8
7	199581	. Screw, Hex. Hd. Cap M12-1.75 x 35 ...	12	7	199346	. Washer, Lock M10 .....	8
8	199289	. Washer, Flat M12 Wrought .....	24	8	198976	. Washer, Flat M10 .....	16
9	199345	. Washer, Lock M12 .....	12	9	199939	. Nut, Hex. M10-1.5 .....	8
10	199933	. Nut, Hex. M12-1.75 .....	12	10	516029	. Base Weldment .....	8
11	417100	. Foot Weldment .....	6				
Not Shown:							
	217236	. Filler Plate (6.97 Long) (Optional) .....	1				
	217233	. Filler Plate (9.25 Long) (Optional) .....	A.R.				
Ref.	206864	Conveyor Interface (On Some Older Machines)					
1	198161	. Screw, Hex. Hd. Cap M10-1.5 x 20 .....	4				
2	199346	. Washer, Lock M10 .....	4				
3	198976	. Washer, Flat M10 .....	4				
4	516237	. Roller Interface Bracket .....	2				
5	202786	. Roller .....	1				
6*	199975	. Screw, Hex. Hd. Cap M10-1.5 x 35 .....	4				
7*	199346	. Washer, Lock M10 .....	8				
8*	198976	. Washer, Flat M10 .....	4				
9*	199939	. Nut, Hex. M10-1.5 .....	4				

NEW DRG.	S.C.L. 5-1-96
REVISIONS	
S.C.L. 6-3-97	
S.C.L. 11-1-04	
S.C.L. 6-14-06	
S.C.L. 3-7-08	
S.C.L. 10-22-09	
S.C.L. 6-6-11	



COOLANT RETAINER ASSEMBLY  
(C-916S ONLY)

FOR  
EUROPA  
MACHINES  
ONLY

MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916S	529-96101	529-101762

## COOLANT ASSEMBLY

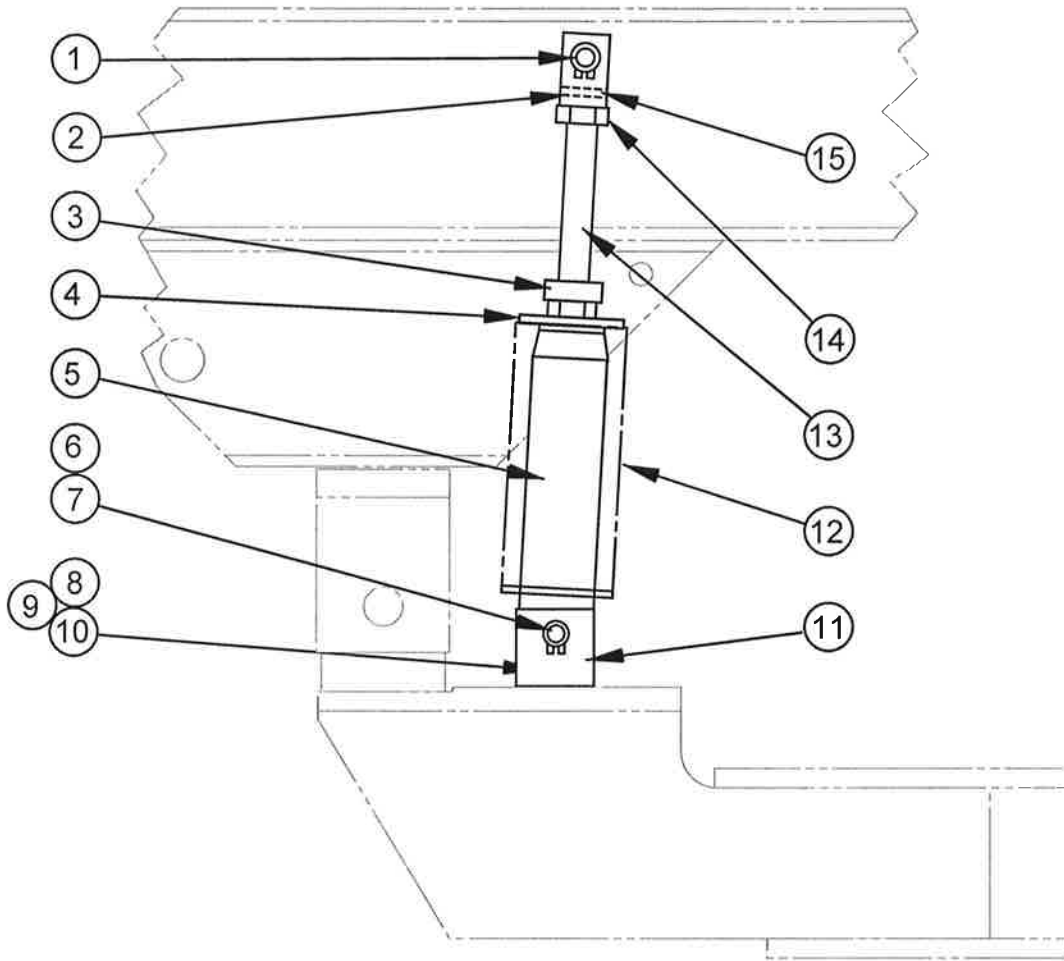
**COOLANT ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	517260	Coolant Assembly (60 Hz)	
Ref.	219825	Coolant Assembly (50 Hz - Europa)	
1	120241	. Valve .....	1
2	016001	. Barbed Insert .....	1
3	009955	. Tubing Clamp .....	A.R.
4	199974	. Screw, Button Hd. Soc.M5-0.8 x 10 .....	A.R.
5	197144	. Plastic Tubing 1/4 I.D. (Clear) .....	A.R.
6	175450	. Drop Coolant Tube .....	1
7	417759	. Coolant Chip Tray .....	1
8	175272	. Strainer (Brass Mesh) .....	1
9	103316	. Barbed Insert .....	1
10*	120857	. Service Tee (Brass) .....	1
11	204233	. Pipe Coupling (Brass) .....	1
12	415144	. Coolant Reservoir Weldment .....	1
13	110263	. Coolant Pump (110/120V, 50/60 Hz) .....	1
	136530	. Coolant Pump (220/240V, 50/60 Hz) .....	1
	172623	. Coolant Pump (CSA Approved) .....	1
14*	002004	. Barbed Insert .....	1
15*	017902	. Hose Clamp .....	1
16*	197094	. Neoprene Hose 11/16 O.D. (Black) .....	A.R.
17*	176816	. Barbed Insert (Plastic) .....	1
18*	176827	. Hose Clamp .....	1
19*	176420	. Hoze Nozzle .....	1
20	5-027506	. 90° Street Elbow (Brass) .....	1
	For Europa:		
21	205472	. Coolant Pump (Europa) .....	1
	209507	. Replacement Impeller .....	1
22	016160	. 90° Cord Grip Connector .....	1
23	019543	. Bond Nut .....	1
24	014411	. Flange Washer .....	1
25	207728	. Mounting Bracket Weldment .....	2
26	199529	. Screw, Soc. Hd. Cap M6-1.0 x 25 .....	2
27	199254	. Washer, Lock M6 Hi-Collar .....	2
28	207588	. Knurled Knob .....	2
29	103316	. Barbed Insert .....	1
30	017902	. Hose Clamp .....	1
31	017537	. Reducer Bushing (Brass) .....	1
32	120857	. Service Tee (Brass) .....	1
33	133439	. 90° Barbed Insert .....	1

\*NOTE: These Items Marked Used on Flushing Hose Option, #178639 and Not Part of Any Assembly Listed Above.

Ref.	207717	Coolant Retainer Assembly (C-916S Only)	
1	319699	. Deflector .....	1
2	319640	. Splash Shield Weldment .....	1
3	319709	. Splash Shield .....	1
4	199299	. Self-Drilling Fastener M4.8 x 13 .....	2
5	220149	. Neoprene Deflector .....	1
6	204225	. Bar .....	1
7	160699	. Pop Rivet (1/8 x 1/4) .....	2

NEW DRG. S.C.L. 5-3-96
REVISIONS
S.C.L. 6-3-97
S.C.L. 1-27-99
S.C.L. 10-15-04
S.C.L. 12-6-06
S.C.L. 3-7-08
S.C.L. 10-22-09
S.C.L. 6-6-11



MODEL C-916S SHOWN.

MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916A	528-96101	528-02725
C-916S	529-96101	529-101762
C-916SA	532-96101	532-02139
C-916SA	533-96101	533-04353
C-916DS	537-98101	537-03219
C-916A (VFD-3)	547-00101	547-12471

## COUNTER BALANCE MECHANISM ASSEMBLY

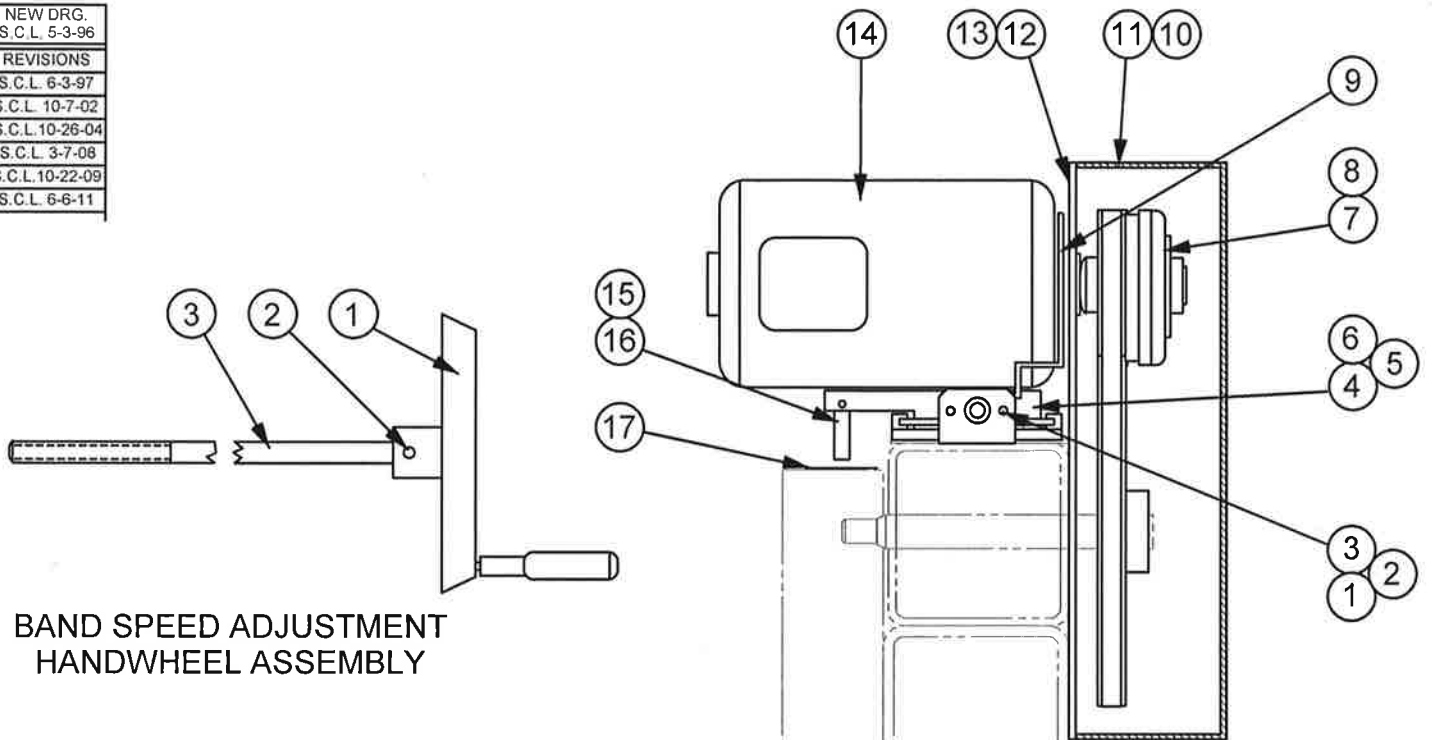


**COUNTER BALANCE MECHANISM ASSEMBLY**

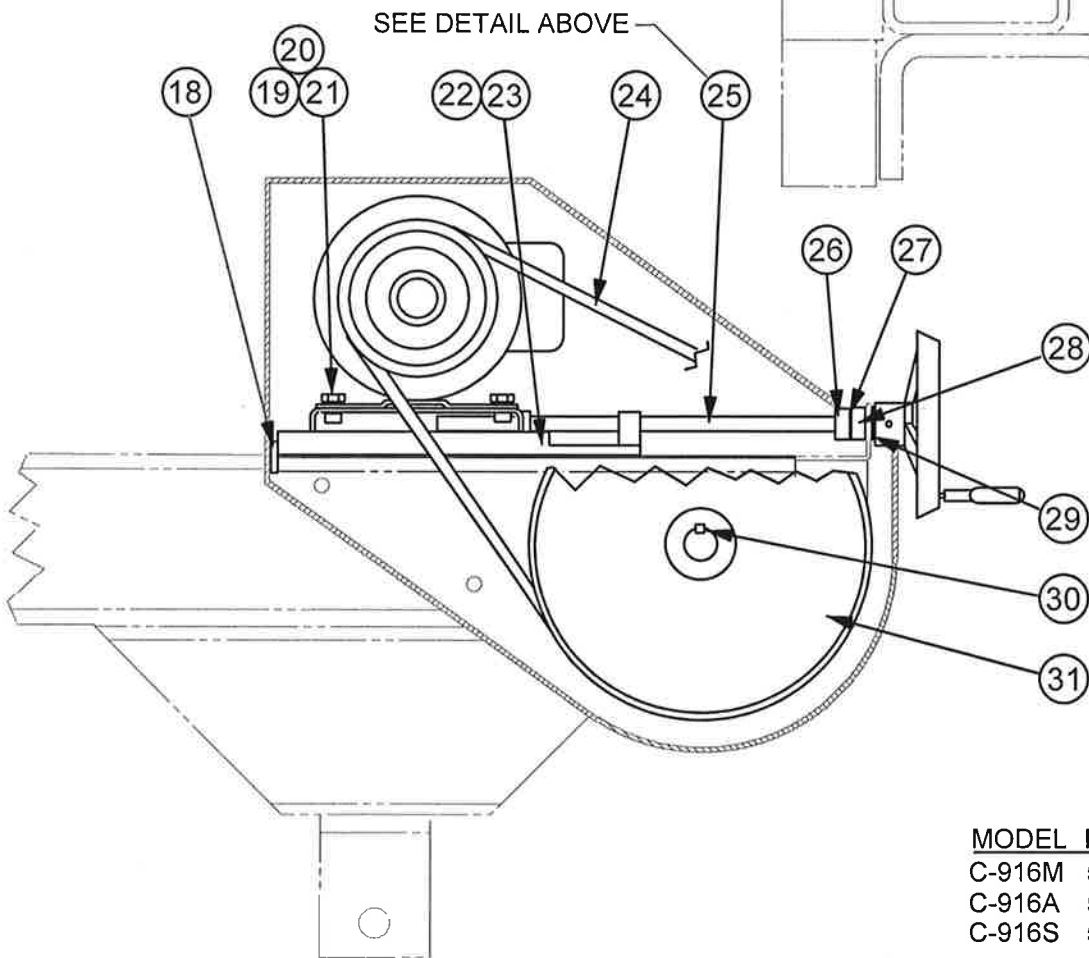
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	517253	Counter Balance Mechanism Assembly (C-916M, C-916A, C-916A(VFD-3))	
Ref.	517499	Counter Balance Mechanism Assembly (C-916S, C-916SA, C-916DS)	
1	35-008688	. Retaining Ring .....	1
2*	178683	. Clevis .....	1
3*	201366	. Shaft Collar .....	1
4	179576	. Top Washer .....	1
5	318126	. Rod Guide Weldment .....	1
6	179579	. Pin .....	1
7	35-009613	. Retaining Ring .....	2
8	198161	. Screw, Hex. Hd. Cap M10-1.5 x 20 .....	2
9	199346	. Washer, Lock M10 .....	2
10	198976	. Washer, Flat M10 .....	2
11	200152	. Bracket Weldment (C-916M, C-916A, C-916A(VFD-3)) .....	1
	318127	. Bracket (C-916S, C-916SA, C-916DS) .....	1
12	178236	. Compression Spring .....	1
13*	179577	. Threaded Rod .....	1
14*	199140	. Nut, Hex. Jam 3/4-10NC .....	2
15*	004261	. Spring Pin .....	1

\*NOTE: Marked Items are Part of Assembly #326829 - Screw and Lug Assembly.

NEW DRG.
S.C.L. 5-3-96
REVISIONS
S.C.L. 6-3-97
S.C.L. 10-7-02
S.C.L. 10-26-04
S.C.L. 3-7-08
S.C.L. 10-22-09
S.C.L. 6-6-11



**BAND SPEED ADJUSTMENT  
HANDWHEEL ASSEMBLY**



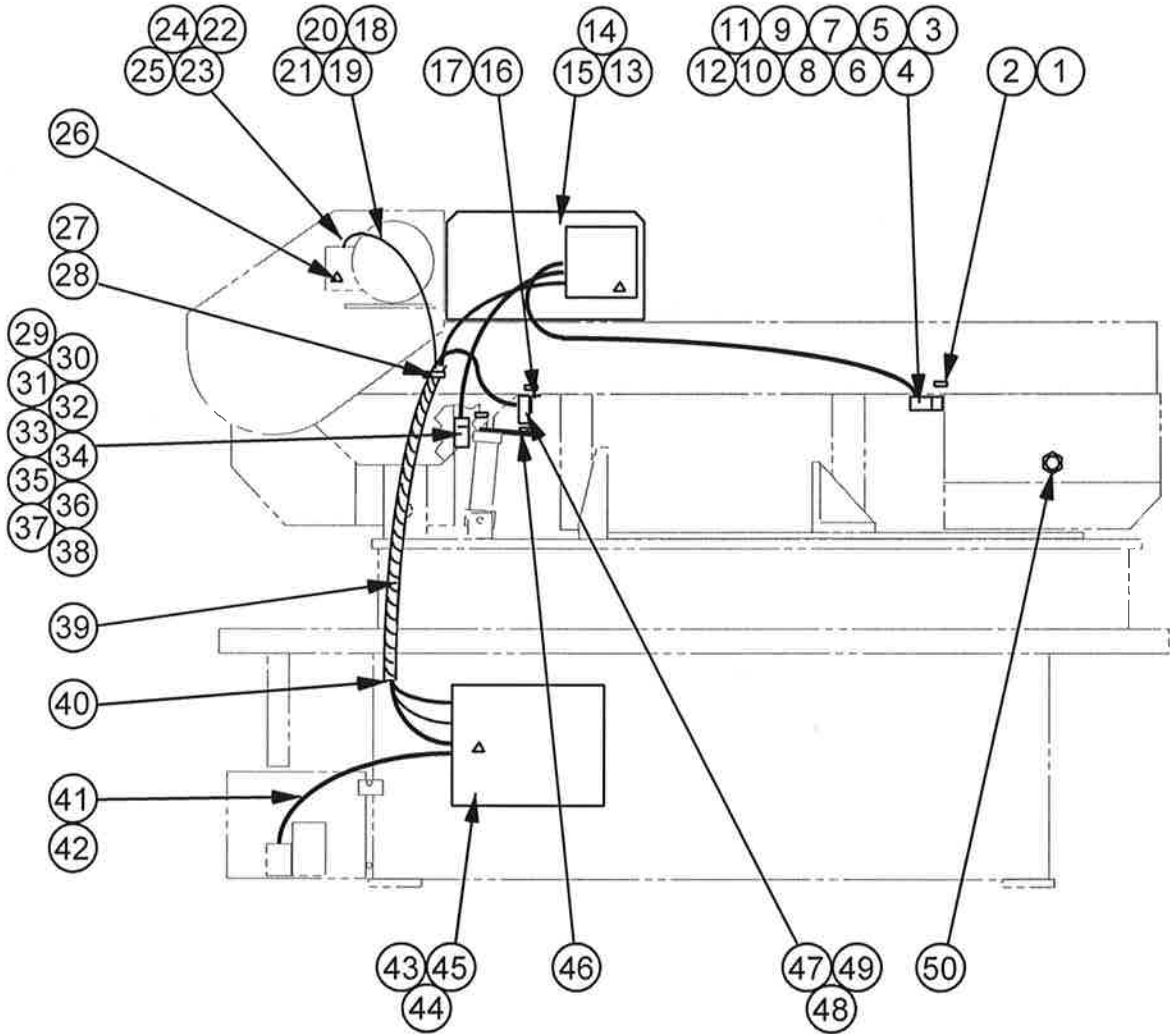
**DRIVE ASSEMBLY**

MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916A	528-96101	528-02725
C-916S	529-96101	529-101762

**DRIVE ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Drive Assembly	
1	199899	. Screw, Button Hd., Soc. M6-1.0 x 16 .....	2
2	199347	. Washer, Lock M6 .....	2
3	199188	. Nut, Hex. M6-1.0 .....	2
4	417913	. Motor Slide Weldment .....	1
	415163	. Motor Slide Weldment (Single Phase Motor Only) .....	1
5	417914	. Adaptor Plate (Low Speed Option) .....	1
6	199920	. Screw, Flat Hd. Soc. M8-1.25 x 20 (Low Speed Option) .....	4
7	207433	. Variable Pulley .....	1
	175280	. Variable Pulley (Single Phase Motor Only) .....	1
8	198986	. Key (3 Phase Motors Only) .....	1
9	320833	. Cover .....	2
10	514776	. Cover Weldment .....	1
11	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 .....	6
12	517254	. Cover Mounting Plate .....	1
13	199969	. Screw, Button Hd. Soc. M6-1.0 x 10 .....	4
14	209621	. Electric Motor (200V, 208V, 220V, 230V, 400V, 460V) .....	1
	209622	. Electric Motor (575V) .....	1
	209639	. Electric Motor (200V, 208V, 220V, 230V, 400V, 460V) (Low Speed Option) .....	1
	209640	. Electric Motor (575V) (Low Speed Option) .....	1
	133879	. Electric Motor (Single Phase) .....	1
15	206879	. Pointer .....	1
16	198979	. Screw, Button Hd. Soc. M5-0.8 x 6 .....	1
17	179480	. Escutcheon (Band Speed) (60 Hz) .....	1
	179482	. Escutcheon (Band Speed) (50 Hz) .....	1
	179476	. Escutcheon (Band Speed) (60 Hz) (Low Speed Option) .....	1
	209449	. Escutcheon (Band Speed) (50 Hz) (Low Speed Option) .....	1
18	199551	. Spring Pin (Low Speed Option) .....	1
19	199239	. Screw, Hex. Hd. Cap M8-1.25 x 20 .....	4
	198026	. Screw, Hex. Hd. Cap 5/16-18NC x 5/8 (Single Phase Motor Only) .....	4
20	199968	. Washer, Lock M8 .....	4
	199323	. Washer, Lock 5/16 Std. (Single Phase Motor Only) .....	4
21	198574	. Washer, Flat M8 Wrought .....	4
	199262	. Washer, Flat 5/16 S.A.E. Std. (Single Phase Motor Only) .....	4
22	417748	. Base Motor Slide .....	1
23	199056	. Screw, Soc. Hd. Cap M8-1.25 x 16 (Low Head) .....	4
24	158815	. V-Belt .....	1
	211937	. V-Belt (Low Speed Option) .....	1
25	318133	. Band Speed Adjustment Handwheel Assembly (See Detail) .....	1
26	34-005410	. Set Screw Collar .....	1
27	199289	. Washer, Flat M12 Wrought .....	1
28	142408	. Flanged Bearing .....	1
29	199289	. Washer, Flat M12 Wrought .....	1
30	004443	. Key .....	1
31	158659	. Pulley .....	1
Following Not Shown:			
	206885	. Bar (Idler End of Head, Low Speed Option) .....	1
	199243	. Screw, Button Hd. Soc. M5-0.8 x 12 (w/Last Item Above) .....	2
	326647	. Louvered Motor Cover (Single Phase Motors Only) .....	1
Ref.	318133	. Band Speed Adjustment Handwheel Assembly	
1	216098	. Handwheel (W/Fold-In Handle) .....	1
2	004263	. Spring Pin .....	1
3	317323	. Screw .....	1

NEW DRG. S.C.L. 6-3-97
REVISIONS
S.C.L. 6-3-97
S.C.L. 11-1-04
S.C.L. 6-14-06
S.C.L. 3-11-08
S.C.L. 10-22-09
S.C.L. 6-6-11



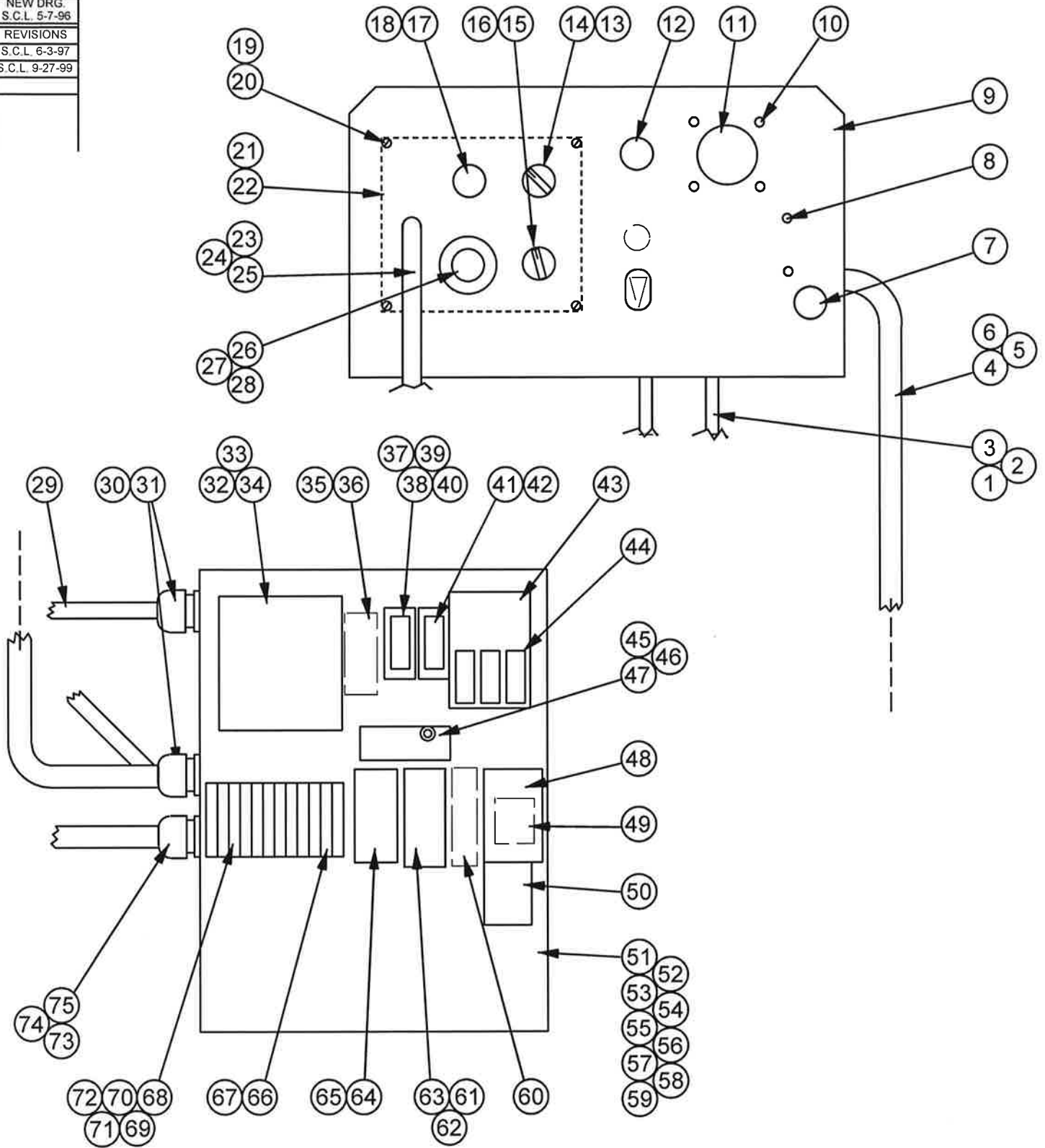
MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916S	529-96101	529-101762

## ELECTRICAL ASSEMBLY

**ELECTRICAL ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	517261	Electrical Assembly	
1	009135	. Escutcheon (Limit Switch No.) .....	3
2	199396	. Screw, Rd. Hd. Drive #2 x 3/16 .....	6
3	215624	. Limit Switch (Door Interlock) .....	1
4	217229	. Limit Switch Bracket .....	1
5	199389	. Screw, Button Hd. Soc. M4-0.7 x 30 .....	2
6	199214	. Nut, Hex. M4-0.7 .....	4
7	199248	. Washer, Flat M4 .....	4
8	221855	. Interlock Key Bracket .....	1
9	221854	. Shim (Key Bracket) .....	1
10	199728	. Screw, Button Hd. Soc. M4-0.7 x 10 .....	4
11	215619	. Cord Grip Connector (.236-.472) .....	1
12	197332	. Electrical Cord (#18-2 Conductor) .....	A.R.
13		. Electrical Control/Panel Assembly (See Detail) .....	1
14	199969	. Screw, Button Hd. Soc. M6-1.0 x 10 .....	3
15	176528	. Escutcheon (Electrical Hazard) .....	1
16	320597	. Bracket .....	1
17	199974	. Screw, Button Hd. Soc. M5-1.0 x 10 .....	2
18	197218	. Electrical Cord (#14-4 Conductor) .....	A.R.
19	139194	. Wire Terminal Lug .....	8
20	167329	. Cable Clamp .....	2
21	199728	. Screw, Button Hd. Soc. M4-0.7 x 10 .....	2
22	016160	. 90° Cord Grip Connector .....	1
23	014411	. Flange Washer .....	1
24	019543	. Bond Nut .....	1
25	133827	. Wire Connector (Red) .....	A.R.
26	176528	. Escutcheon (Electrical Hazard) .....	1
27	016560	. Cable Hanger Clamp .....	1
28	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 .....	1
29	215624	. Limit Switch (Door Interlock) .....	1
30	217229	. Limit Switch Bracket .....	1
31	199389	. Screw, Button Hd. Soc. M4-0.7 x 30 .....	2
32	199214	. Nut, Hex. M4-0.7 .....	4
33	199248	. Washer, Flat M4 .....	4
34	221855	. Interlock Key Bracket .....	1
35	221854	. Shim (Key Bracket) .....	1
36	199728	. Screw, Button Hd. Soc. M4-0.7 x 10 .....	4
37	215619	. Cord Grip Connector (.236-.472) .....	1
38	197332	. Electrical Cord (#18-2 Conductor) .....	A.R.
39	197388	. Wire Wrap (1" Black Poly) .....	A.R.
40	107637	. Cable Tie .....	3
41	197218	. Electrical Cord (#14-4 Conductor) (400V Only) .....	A.R.
42	015835	. Cord Grip Connector (400V Only) .....	2
43		. Electrical Control/Panel Assembly (See Detail) .....	1
44	198618	. Screw, Hex. Locking M6-1.0 x 16 (w/Washer) .....	3
45	176528	. Escutcheon (Electrical Hazard) .....	1
46	207502	. Elevator Bolt M6-1.0 x 25 .....	1
47	176768	. Limit Switch (Head Down) .....	1
48	199439	. Screw, Button Hd. Soc. M4-0.7 x 25 .....	2
49	197332	. Electrical Cord (#18-2 Conductor) .....	A.R.
50	188113	. Motion Detector (Optional) .....	1

NEW DRG.
S.C.L. 5-7-96
REVISIONS
S.C.L. 6-3-97
S.C.L. 9-27-99



MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-011524
C-916S	529-96101	529-011160

## ELECTRICAL CONTROL/PANEL ASSEMBLY

**ELECTRICAL CONTROL/PANEL ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Electrical Control/Panel Assembly		49	207221	Auxiliary Contact (Full Cycle Option) ...	1
1	201688	Cord Grip Connector (.200-.394) .....	2	50	207299	Overload Relay (115V; Single Phase) .	1
2	197332	Electrical Cord (#18-2 Conductor) .....	A.R.		207295	Overload Relay (230V; Single Phase) .	1
3	207692	Locknut .....	2		207293	Overload Relay (200V, 208V, 220V, 230V)1	1
4	201696	Cord Grip Connector (.394-.551) .....	2		207291	Overload Relay (380V, 400V, 415V, 460V, 575V) .....	1
5	207693	Locknut .....	2				
6	197436	Electrical Cord (#18-8 Conductor) .....	A.R.	51	517296	Control Box Enclosure Weldment .....	1
7*	200127	Dome Plug .....	1	52	203925	Gasket Strip .....	A.R.
8*	200130	Dome Plug .....	2	53	201780	Label (Overload/Fuse Schedule) .....	1
9	417734	Escutcheon .....	1	54	207170	Screw, Pan Hd. Captive M5-0.8 x 12	2
10*	200130	Dome Plug .....	4	55	204152	Washer, Flat #10 Nylon .....	2
11*	200129	Dome Plug .....	2	56	204150	Pushnut Retainer #10 .....	2
12*	200128	Dome Plug .....	1	57	207171	Rivet Nut M5-0.8 .....	2
13	207181	Selector Switch (2 Position) .....	1	58	199578	Screw, Pan Hd. Mach. M5-0.8 x 8 .....	2
14	207185	Contact Block (1-NO) .....	1	59	206694	Escutcheon (Electrical Info) .....	1
15**	207184	Selector Switch (4 Position) .....	1	60	203166	Timer (Full Cycle Option) .....	1
16**	207187	Contact Block (1-NO, 1-NC) .....	2	61	177057	Control Relay .....	1
17	207190	Pushbutton Operator (Green) .....	1	62	177099	Relay Socket .....	1
18	207185	Contact Block (1-NO) .....	1	63	204146	Relay Retainer .....	1
19	199243	Screw, Button Hd. Soc. M5-0.8 x 12 ...	4	64	207288	Overload Relay (380V, 400V, 415V Only)	1
20	207171	Rivet Nut M5-0.8 .....	4	65	207314	Relay Mounting Support (380V, 400V, 415V Only) .....	1
21	417974	Junction Box .....	1				
22	319398	Gasket .....	1	66	200615	Terminal Block (380V, 400V, 415V Only)	3
23	206668	Worklamp .....	1	67	200994	Terminal Block Marker (380V, 400V, 415V Only) .....	A.R.
	135106	Hole Seal (Europa) .....	1				
24	207784	Self-Locking Nut 3/8-18NPT .....	1	68	200615	Terminal Block .....	9
25	199361	Washer, Lock 5/8 Shakeproof .....	1	69	200617	Terminal Block End Section .....	1
26	207191	Pushbutton Operator (Twist Release)	1	70	200618	Terminal Block End Stop .....	2
27	207186	Contact Block (1-NC) .....	1	71	205369	Terminal Block Marker Set .....	1
28	200093	E-Stop Marker (Yellow) .....	1	72	202922	Jumper Bar .....	A.R.
29	197332	Electrical Cord (#18-2 Conductor) .....	A.R.	73	201687	Cord Grip Connector (.545-.709) .....	2
30	201688	Cord Grip Connector (.200-.394) .....	2	74	207694	Locknut .....	2
31	207692	Locknut .....	2	75	197218	Electrical Cord (#14-4 Conductor) .....	A.R.
32	320079	Transformer (200V, 208V) .....	1		197367	Electrical Cord (#10-3 Conductor) (Single Phase Only) .....	A.R.
	320078	Transformer (230V, 460V, 575V) .....	1				
	320080	Transformer (380V, 400V, 415V) .....	1				
33	199202	Nut, Hex. M5-0.8 .....	4				
34	199089	Washer, Lock M5 Shakeproof .....	4				
35	177057	Control Relay (Full Cycle Option) .....	1				
36	177099	Relay Socket (Full Cycle Option) .....	1				
37	133852	Fuse (25 Amp) (115V - 1 Phase Only)	1				
38	110062	Fuse Block (115V - 1 Phase Only) .....	1				
39	203791	Rail Adaptor (115V - 1 Phase Only) ....	1				
40	199420	Screw, Rd. Hd. Sheet Metal #10 x 1/2 .	2				
41	203159	Fuse (2-1/2 Amp) .....	1				
42	205368	Fuse Block .....	1				
43	205359	Disconnect Switch .....	1				
	203912	Disconnect Switch (Single Phase Only)	1				
44	206176	Fuse (20 Amp) (220/230V, 1 Phase)....	2				
	205036	Fuse (15 Amp) (200V, 208V, 230V) ....	3				
	203162	Fuse (10 Amp) (380V, 400V, 415V) ....	3				
	205038	Fuse (6 Amp) (460V) .....	3				
	203161	Fuse (5 Amp) (575V) .....	3				
45	320740	Grounding Bus .....	1				
46	199232	Nut, Hex. Jam M6-1.0 .....	2				
47	199311	Washer, Flat M6 Shakeproof .....	2				
48	207210	Magnetic Contactor (Single Phase) .....	1				
	207206	Magnetic Contactor (3 Phase) .....	1				

Following Not Shown:

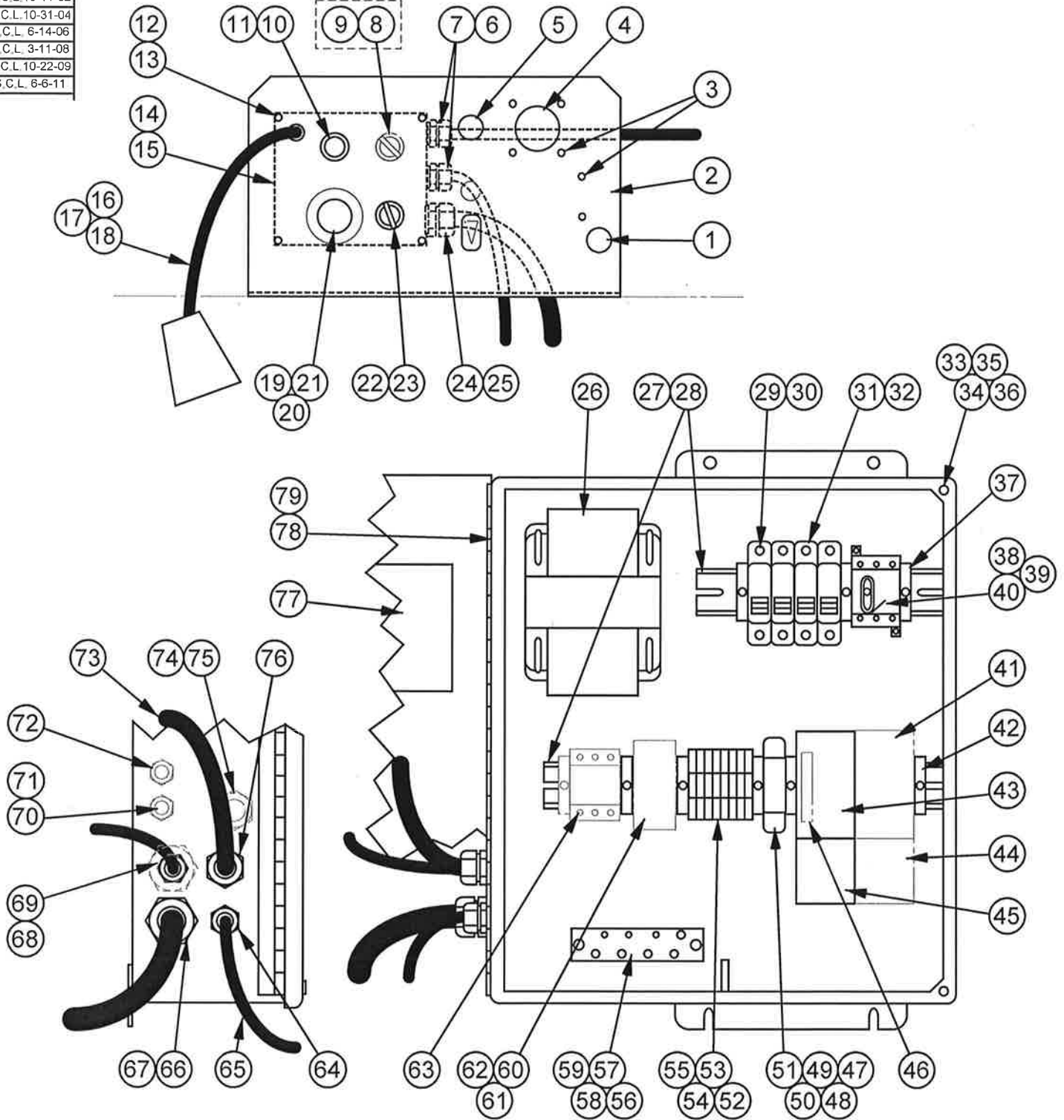
197197	Wire, #16 Red (19 Strand) .....	A.R.
197325	Wire, #16 White (19 Strand) .....	A.R.
197341	Wire, #12 Black (19 Strand) .....	A.R.
197195	Wire, #14 Green/Yellow (19 Strand) ...	A.R.
203542	Wire Terminal Ring #4 .....	6
205488	Spade Terminal #6 .....	6
007635	Wire Terminal Ring #10 .....	8
207752	Cable Tie Mount .....	2
176528	Escutcheon (Electrical Warning) .....	1
201679	Wire Terminal (Full Cycle Option) .....	4

\*NOTE: See Pneumatic Vise Option and/or Pneumatic Head Lift Option for Controls.

\*\*NOTE: Items #15 and #16 Used After Serial #537-96194 on C-916M and #529-96168 on C-916S.

NEW DRG.
S.C.L. 6-6-01
REVISIONS
S.C.L. 10-11-02
S.C.L. 10-31-04
S.C.L. 6-14-06
S.C.L. 3-11-08
S.C.L. 10-22-09
S.C.L. 6-6-11

IF SUPPLIED



MODEL	FIRST MACH.	LAST MACH.
C-916M	527-011525	527-102304
C-916S	529-011161	529-101762

# ELECTRICAL CONTROL/PANEL ASSEMBLY

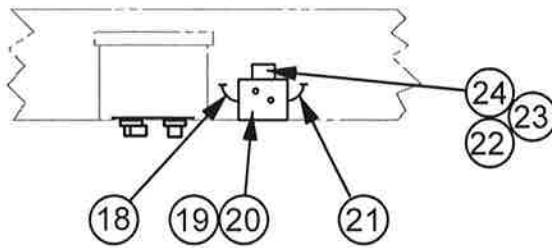


## ELECTRICAL CONTROL/PANEL ASSEMBLY

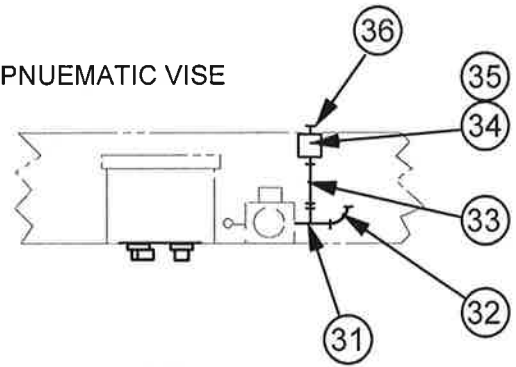
INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.		Electrical Control/Panel Assembly		49	209939	Relay Socket .....	1
1*	200127	Dome Plug .....	1	50	209942	Relay Retaining Clip .....	1
2	417734	Panel Escutcheon .....	1	51	209943	Relay Marking Tag .....	1
3*	200130	Dome Plug .....	6	52	200615	Terminal Block .....	8
4*	200129	Dome Plug .....	1	53	200617	Terminal Block End Section .....	2
5*	200128	Dome Plug .....	1	54	200618	Terminal Block End Stop .....	2
6	201688	Cord Grip Connector (.200-.394) .....	2	55	205369	Terminal Block Marker Set .....	1
7	197332	Electrical Cord (#18-2 Conductor) .....	A.R.	56	320740	Grounding Bus .....	1
8**	207181	Selector Switch (2 Position) (If Supplied) .....	1	57	141639	Wire Terminal Lug .....	1
9**	207185	Contact Block (1-NO) (If Supplied) .....	1	58	199232	Nut, Hex. Jam M6-1.0 .....	2
10	207190	Pushbutton Operator (Green) .....	1	59	199311	Washer, Lock M6 Shakeproof .....	2
11	207185	Contact Block (1-NO) .....	1	60	177057	Relay (Full Cycle Option) .....	1
12	199243	Screw, Button Hd. Soc. M5-0.8 x 12 ...	4	61	177099	Relay Socket (Full Cycle Option) .....	1
13	207171	Rivet Nut M5-0.8 .....	4	62	007635	Wire Terminal Ring #10 (Full Cycle Option).....	2
14	417974	Junction Box .....	1	63	219338	Power Supply (Laser Option) .....	1
15	319398	Gasket .....	1	64	201688	Cord Grip Connector (.200-.394) .....	1
16**	221545	Worklamp (Optional) .....	1	65	197332	Electrical Cord (#18-2 Conductor) .....	A.R.
	135106	Hole Seal (Europa) .....	1	66	201687	Cord Grip Connector (.545-.709) .....	2
17	207784	Self-Locking Nut 3/8-18NPT .....	1	67	197218	Electrical Cord (#14-4 Conductor) .....	A.R.
18	199361	Washer, Lock 5/8 Shakeproof .....	1	68	197332	Electrical Cord (#18-2 Conductor)(60 Hz) .....	A.R.
19	207191	Pushbutton Operator (Twist Release) .....	1	69	197218	Electrical Cord (#14-4 Conductor)(50 Hz) .....	A.R.
20	207186	Contact Block (1-NC) .....	1	70	201688	Cord Grip Connector (.200-.394) (60 Hz) .....	1
21	200093	E-Stop Marker (Yellow) .....	1	71	197332	Electrical Cord (#18-2 Conductor) .....	A.R.
22	207184	Selector Switch (4 Position) .....	1	72	201686	Cord Grip Connector (.157-.314) (Motion Detector Option) .....	1
23	207187	Contact Block (1-NO, 1-NC) .....	2	73	197436	Electrical Cord (#18-8 Conductor) .....	A.R.
24	201696	Cord Grip Connector (.394-.551) .....	1	74	201696	Cord Grip Connector (.394-.551) (Full Cycle Option) .....	1
25	197436	Electrical Cord (#18-8 Conductor) .....	A.R.	75	197331	Electrical Cord (#18-6 Conductor) .....	A.R.
26	320079	Transformer (200V, 208V) .....	1	76	201696	Cord Grip Connector (.394-.551) .....	1
	320078	Transformer (220V, 230V, 460V, 575V) .....	1	77	201780	Label (Fuse/Overload Schedule) .....	1
	217752	Transformer (400V) .....	1	78	520806	Control Box Enclosure Weldment .....	1
27	169674	Mounting Channel .....	A.R.	79	203925	Gasket Strip .....	A.R.
28	199578	Screw, Pan Hd. Mach. M5-0.8 x 8 (Slotted) 5		<b>Following Not Shown:</b>			
29	215212	Fuse Block (60 Hz) .....	1	1003427	U.L. Label .....	1	
	420355	Circuit Breaker (50Hz) .....	1	176768	Hour Meter (Optional) .....	1	
30	203159	Fuse (2-1/2 Amp) (60 Hz) .....	1	197339	Wire, #14 Black (19 Strand) .....	A.R.	
31	215212	Fuse Block (Single Phase) .....	A.R.	197195	Wire, #14 Green/Yellow (19 Strand) ...	A.R.	
	215213	Fuse Block (60 Hz) .....	1	197197	Wire, #16 Red (19 Strand) .....	A.R.	
	420393	Circuit Breaker (200V, 220V; 50 Hz) ...	1	197325	Wire, #16 White (19 Strand) .....	A.R.	
	420395	Circuit Breaker (400V; 50 Hz) .....	1	203542	Wire Terminal Ring #4 .....	6	
32	205335	Fuse (25 Amp) (115V, 1 Phase).....	1	205488	Spade Terminal #6 .....	12	
	206176	Fuse (20 Amp) (230V, 1 Phase) .....	2	007635	Wire Terminal Ring #10 .....	9	
	205036	Fuse (15 Amp) (208V, 230V) .....	3	202922	Jumper Bar .....	A.R.	
	205038	Fuse (6 Amp) (460V) .....	3	207752	Cable Tie Mount .....	2	
	203161	Fuse (5 Amp) (575V) .....	3	176528	Escutcheon (Electrical Warning) .....	1	
33	207170	Screw, Hex. Hd. Captive M5-0.8 x 12 ...	2	201679	Wire Terminal (Full Cycle Option) .....	4	
34	204152	Washer, Flat #10 Nylon .....	2	219480	Wire Connector .....	2	
35	204150	Pushnut Retainer #10 .....	2	<b>*NOTE:</b> See Pneumatic Vise Option and/or Pneumatic Head Lift Option for Controls.			
36	207171	Rivet Nut M5-0.8 .....	2	<b>**NOTE:</b> Item #17 was #206688 With Items 8 and 9 Control Panel On-Off Switch.			
37	200618	End Stop .....	3	<b>†NOTE:</b> To Replace: Order Disconnect Switch Service Kit - #1007668 If Electrical Schematic Has Rev. #20 or Less. Otherwise, Use Part Numbers Listed.			
38†	1007434	Disconnect Switch .....	1				
39†	1007441	Disconnect Switch Shaft .....	1				
40†	1007437	Disconnect Switch Handle .....	1				
41	207206	Contact (50 Hz Only) .....	1				
42	200618	End Stop .....	4				
43	207206	Contact .....	1				
	207210	Contact (Single Phase) .....	1				
44	207290	Overload Relay (200V, 220V; 50 Hz) ...	1				
	207288	Overload Relay (400V, 50 Hz) .....	1				
45	207298	Overload Relay (115V; Single Phase) .	1				
	207294	Overload Relay (230V; Single Phase) .	1				
	207293	Overload Relay (200V, 208V, 220V) ...	1				
	207292	Overload Relay (230V) .....	1				
	207291	Overload Relay (400V, 460V, 575V) ...	1				
46	207221	Auxiliary Contact (Full Cycle Option) ...	1				
47	209937	Control Relay .....	1				
48	209941	Relay Indicator (Green) .....	1				

NEW DRG.
S.C.L. 5-6-96
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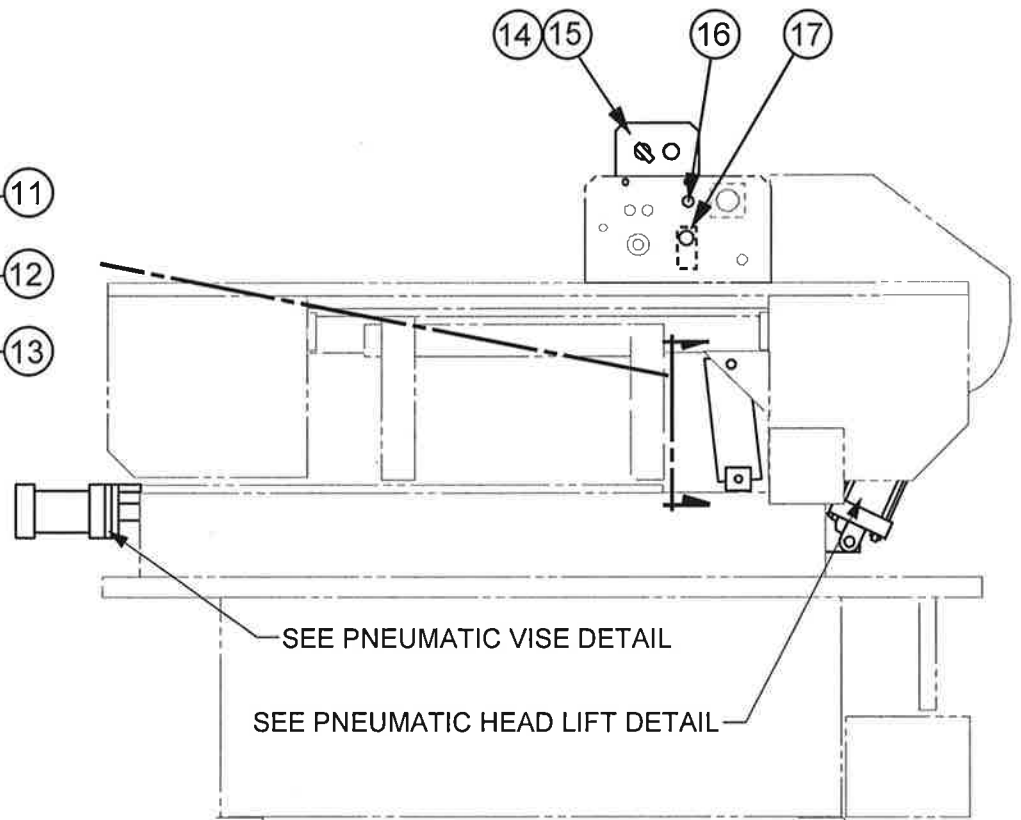
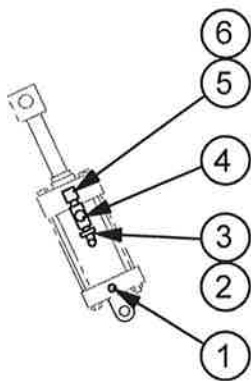
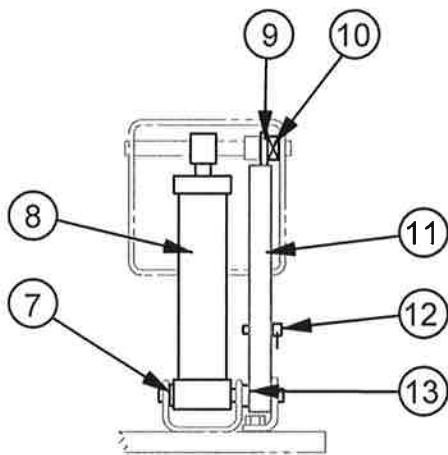
WITH PNEUMATIC HEAD LIFT



WITH PNEUMATIC VISE



TOP VIEW OF CONTROL PANEL AREA



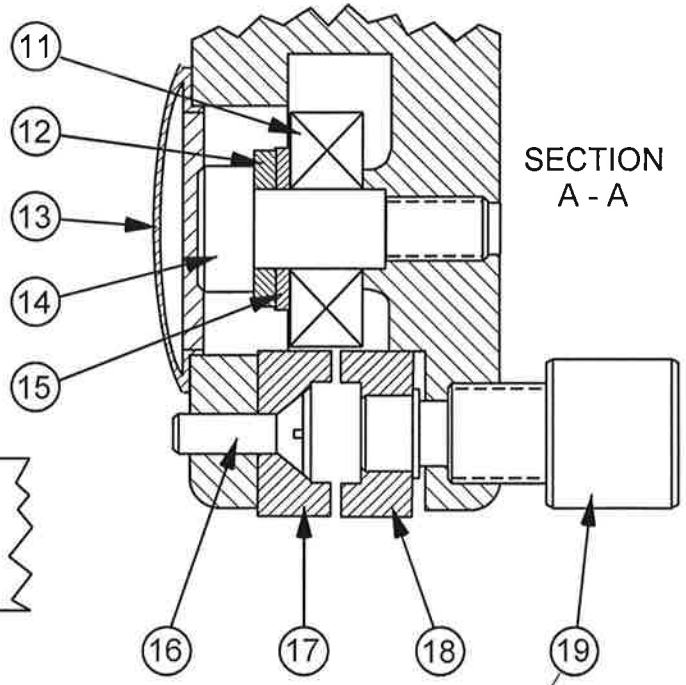
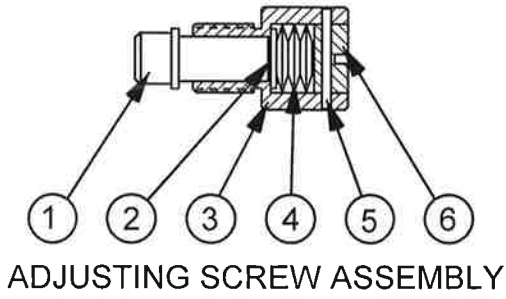
MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916S	529-96101	529-101762

## FULL CYCLE OPTION

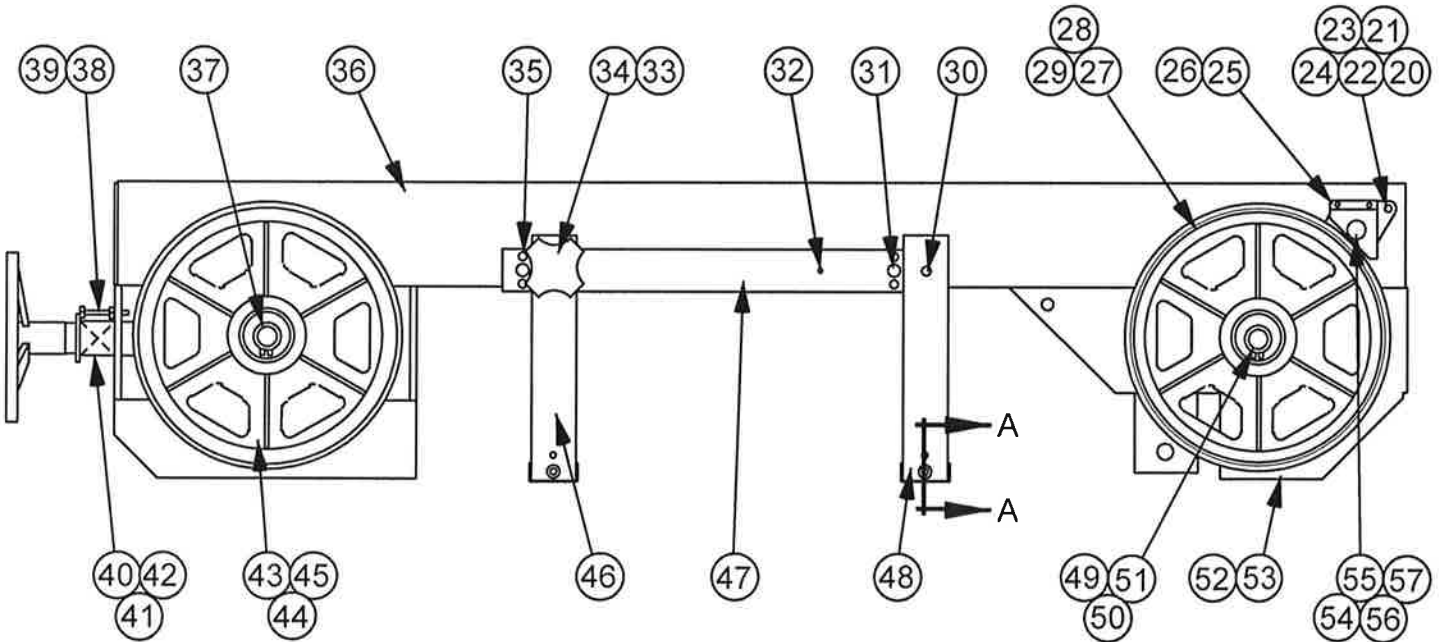
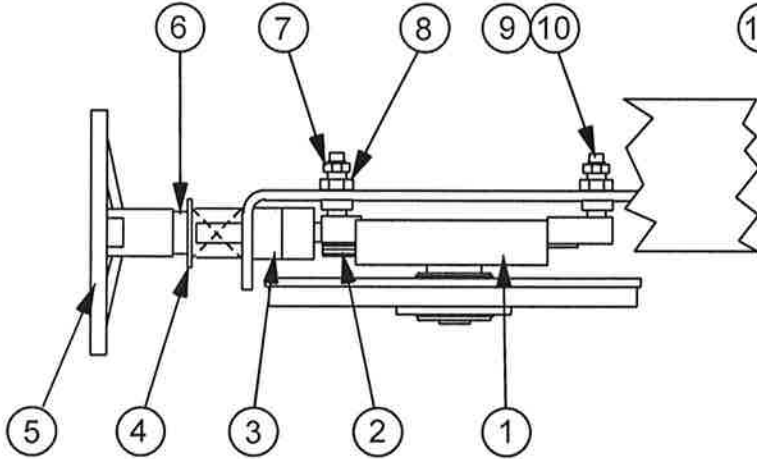
**FULL CYCLE OPTION**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	206898	Full Cycle Option (C-916M)	
Ref.	206896	Full Cylce Option (C-916S)	
Ref.	206899	Full Cylce Option w/Pneumatic Vise (C-916M)	
Ref.	206897	Full Cycle Option w/Pneumatic Vise (C-916S)	
1	176811	. Vent Filter Breather .....	1
2	200135	. 90° Male Swivel Elbow .....	1
3	203219	. Hex. Reducer Bushing (If Supplied) .....	1
4	203809	. Right Angle Flow Control Valve .....	1
5	010923	. Hex Nipple (If Supplied) .....	1
6	008254	. 90° Street Elbow (If Supplied) .....	1
7	199296	. Washer (If Supplied) .....	1
8	207504	. Head Feed Cylinder And Control Valve Assembly (Full Cycle)(See Detail) 1	
9	319536	. Plate Stop .....	1
10	110171	. Compression Spring .....	1
11	417221	. Slide Weldment .....	1
12	203146	. Detent Pin .....	1
13	002526	. Compression Spring .....	1
14	417921	. Control Panel Assembly (Full Cycle) (See Detail) .....	1
15	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 .....	2
16	200128	. Dome Plug (If Supplied) .....	1
17	203003	. Cover .....	1
18	200135	. 90° Male Swivel Elbow .....	1
19	320608	. Bracket .....	1
20	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 .....	4
21	200135	. 90° Male Swivel Elbow .....	1
22	176829	. Solenoid Valve (3-Way) .....	1
23	176811	. Vent Filter Breather .....	1
24	198398	. Screw, Button Hd. Soc. #8-32NC x 1/4 .....	2
For Full Cycle Option With Pneumatic Vise:			
31	112043	. Street Tee .....	1
32	200135	. 90° Male Swivel Elbow .....	1
33	203144	. Pipe Nipple (Brass) .....	1
34	176829	. Solenoid Valve (3-Way) .....	1
35	176811	. Vent Filter Breather .....	1
36	200133	. Male Connector .....	1
Following Not Shown:			
	197438	. Polyethylene Tubing 1/4 O.D. (Blue) .....	A.R.

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SEE DETAIL - UPPER LEFT



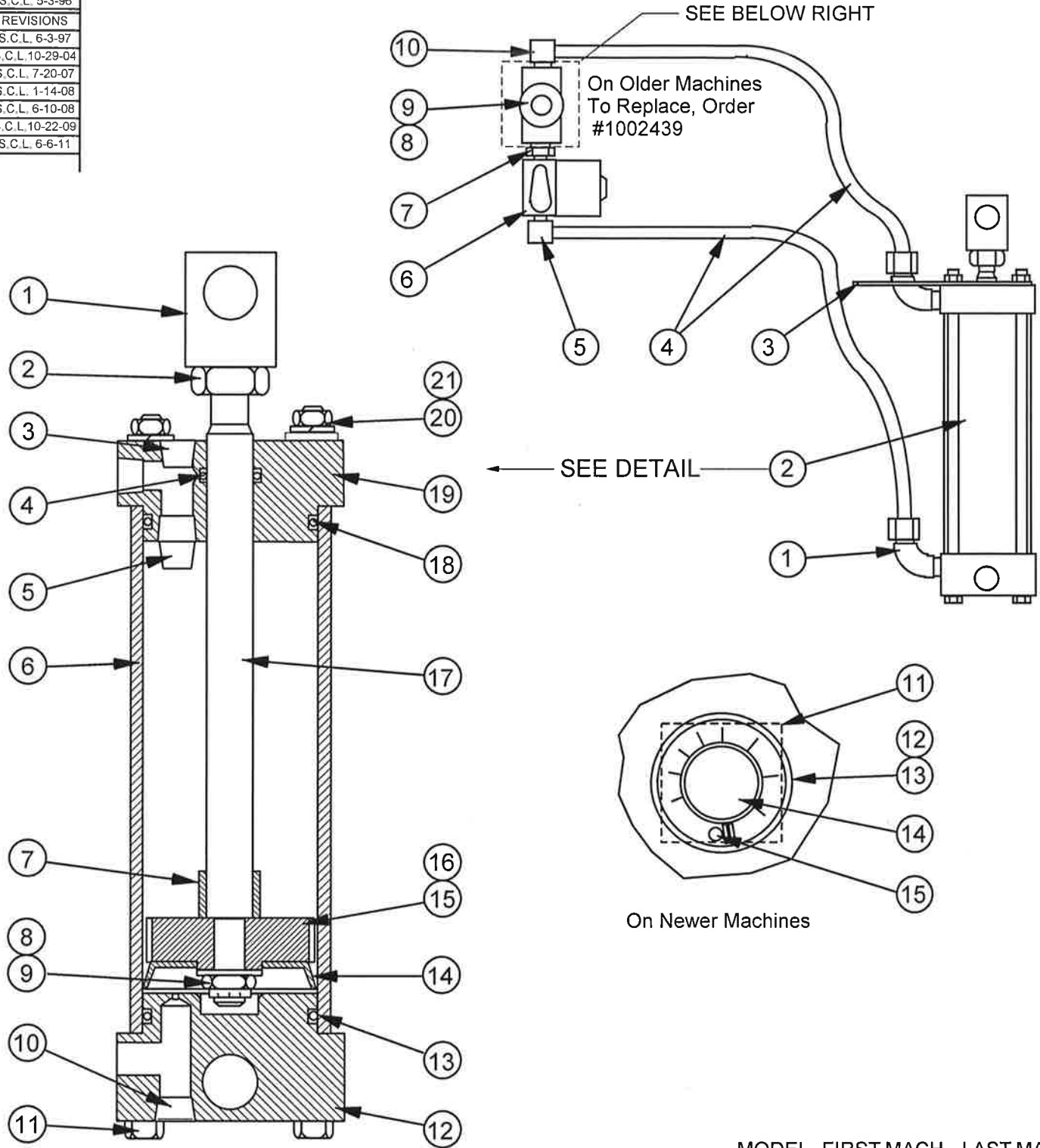
MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916A	528-96101	528-02725
C-916S	529-96101	529-101762
C-916SA	532-96101	532-02139
C-916SA	533-96101	533-04353
C-916DS	537-98101	537-03219
C-916A (VFD-3)	547-00101	547-12471

# HEAD ASSEMBLY

**HEAD ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	
Ref.	517251	Head Assembly (C-916A, C-916M, C-916S, C-916A(VFD-3))		31	199918	Screw, Soc. Hd. Cap M12-1.75 x 45 ...	2	
Ref.	517553	Head Assembly (C-916SA, C-916DS)		32	004269	Spring Pin .....	1	
1	517542	Head Casting .....	1	33	206877	Saw Guide Arm Lock Handwheel .....	1	
2	513889	Head Slide and Shaft Sub-Assembly ..	1	34	175449	Brass Plug .....	1	
	316591	Idler Shaft .....	1	35	199559	Screw, Soc. Set M12-1.75 x 25 (Flat Point) .....	4	
	198562	Screw, Soc. Set 3/8-16NC x 5/8 (Cone Point) .....	1	36	517250	Head Weldment (C-916A, C-916M, C-916S, C-916A(VFD-3)) .....	1	
	131806	Loctite (#290) .....	A.R.		517555	Head Weldment (C-916SA, C-916DS)	1	
3	157703	Rubber Bushing .....	2	37	204455	Retaining Ring .....	1	
4	149978	Washer .....	1	38	199238	Screw, Hex. Hd. Cap M10-1.5 x 60 .....	1	
5	175439	Band Tension Handwheel Assembly ...	1	39	199939	Nut, Hex. M10-1.5 .....	1	
	313997	Handwheel .....	1	40	108750	Compression Spring .....	1	
	175440	Screw .....	1	41	108748	Tube .....	1	
	004277	Spring Pin .....	1	42	199306	Washer, Flat 3/4 Wrought .....	1	
6	108749	Thrust Ball Bearing .....	1	43	176858	Bandwheel Assembly (Idler) .....	1	
7	005956	Adjusting Screw 3/4-16NF x 2-5/16 (.42 Dia.) .....	3		503489	Bandwheel (Idler) .....	1	
		Nut, Hex. Jam 3/4-16NF .....	3	44	137905	Ball Bearing .....	2	
8	199142	Screw, Soc. Hd. Cap M10-1.5 x 80 .....	3	45	122652	Shim (.010) .....	A.R.	
9	199980	Washer, Lock M10 .....	3	46	122653	Shim (.020) .....	A.R.	
10	199346	Bearing .....	2	47	517255	Saw Guide Arm .....	1	
11	011529	Washer, Lock M10 .....	2		320590	Mounting Bar (C-916A, C-916M, C-916S, C-916A(VFD-3)) .....	1	
12	199346	Plug Button .....	2		320819	Mounting Bar (C-916SA, C-916DS) ....	1	
13	35-004528	Screw, Soc. Hd. Shoulder M8-1.25 x 16 .....	2	48	517255	Saw Guide Arm .....	1	
14	176077	Washer, Flat M10 .....	2	49	320598	Shaft .....	1	
15	198976	Screw, Flat Hd. Mach. #10-24NC x 1/2 .....	2	50	199251	Screw, Soc. Set M10-1.5 x 12 (Cone Point) .....	1	
16	198749	Insert Assembly (Fixed) .....	2		51	204455	Retaining Ring .....	1
17	137158	Insert Assembly (Adjustable) .....	2	52	514467	Door Support .....	1	
18	137155	Adjusting Screw Assembly (See Detail)	2	53	199969	Screw, Button Hd. Soc. M6-1.0 x 10 ...	5	
19	124419	Flange Bearing (C-916A, C-916M, C-916S, C-916A(VFD-3)) .....	2	54	132475	Pinion Gear .....	1	
20	132474	Flange Bearing (C-916SA, C-916DS) .	2	55	35-008688	Retaining Ring .....	1	
	205862	Screw, Hex. Hd. Cap M10-1.5 x 40 (C-916A, C-916M, C-916S, C-916A(VFD-3)) .....	4	56	314622	Pinion Shaft .....	1	
21	199240	Screw, Hex. Hd. Cap 9/16-12NC x 1-1/4 (C-916SA, C-916DS) .....	4	57	014214	Key .....	1	
	199452	Washer, Lock M10 (C-916A, C-916M, C-916S, C-916A(VFD-3)) .....	4	Ref.	124419	Adjusting Screw Assembly .....	1	
22	199346	Washer, Lock 9/16 Std. (C-916SA, C-916DS) .....	4	1	124417	Plunger .....	1	
	199453	Nut, Hex. M10 x 1.5 .....	4	2	199257	Washer, Flat #8 S.A.E. Std. ....	1	
23	199939	Washer, Flat M10 (C-916A, C-916M, C-916S, C-916A(VFD-3)) .....	4	3	124418	Housing .....	1	
24	198976	Washer, Flat 9/16 S.A.E. Std. (C-916SA, C-916DS) .....	4	4	104632	Belleville Washer .....	6	
	199454	Pinion Guard .....	1	5	004217	Spring Pin .....	1	
25	415710	Screw, Button Hd. Soc. M5-0.8 x 10 ...	2	6	124033	Plug .....	1	
26	198979	Bandwheel Assembly (Driver) .....	1					
27	317088	Bandwheel (Driver) .....	1					
	505879	Ball Bearing .....	2					
	137905	Shim (.010) .....	A.R.					
28	122652	Shim (.020) .....	A.R.					
29	122653	Screw, Soc. Set M12-1.75 x 45 .....	1					
30	199237							

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S.C.L. 1-14-08	
S.C.L. 6-10-08	
S.C.L. 10-22-09	
S.C.L. 6-6-11	



HEAD FEED CYLINDER ASSEMBLY

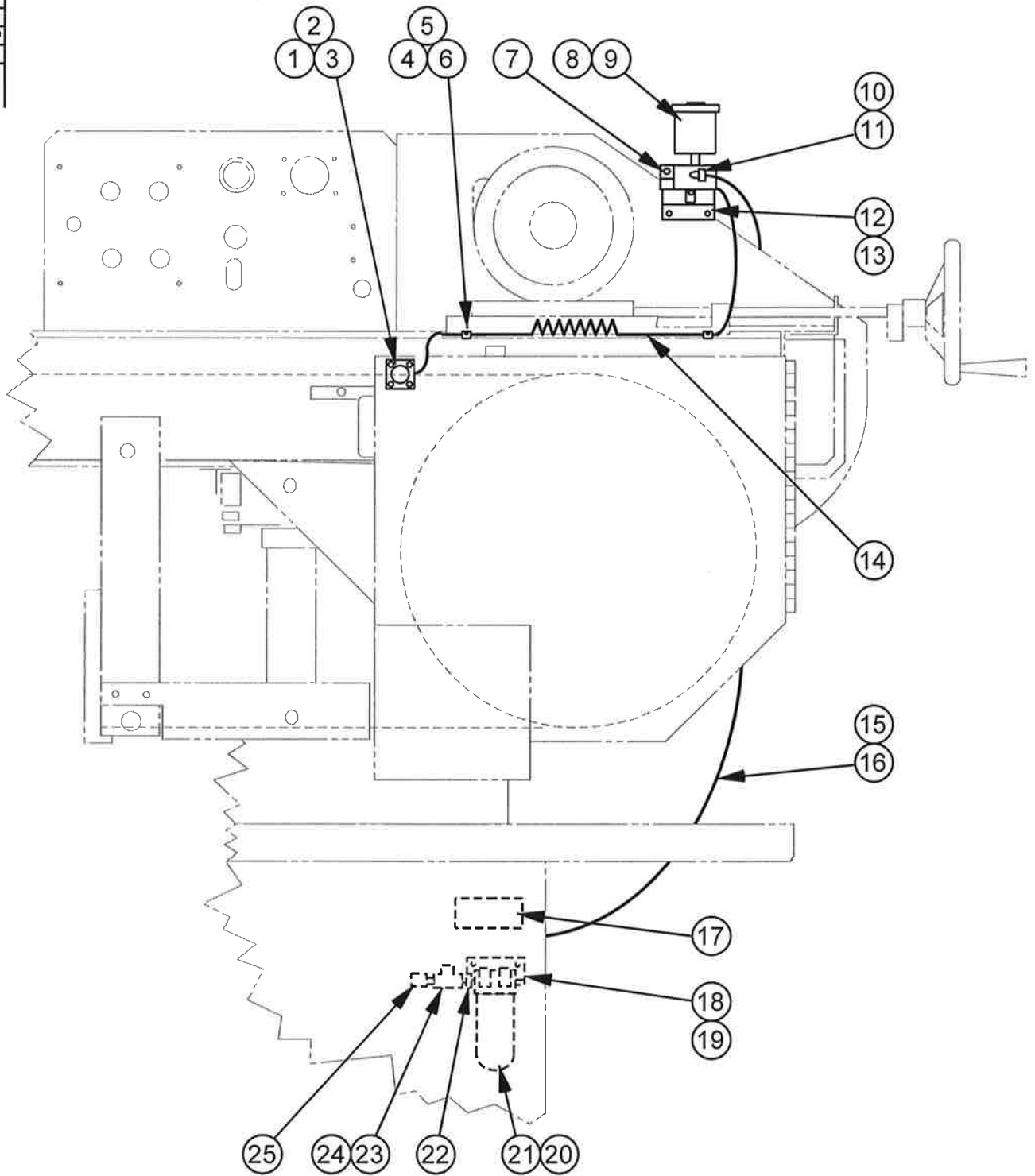
MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916S	529-96101	529-101762

## HEAD FEED CYLINDER AND CONTROL VALVE SUB-ASSEMBLY

**HEAD FEED CYLINDER and CONTROL VALVE SUB-ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	417919	Head Feed Cylinder and Control Valve Sub-Assembly (Standard)	
Ref.	207504	Head Feed Cylinder and Control Valve Sub-Assembly (Full Cycle Option)	
1	6-023510	. 90° Male Elbow (Brass) .....	2
2	416087	. Head Feed Cylinder Assembly (See Detail) .....	1
3	207503	. Actuator Bracket .....	1
4	197264	. Nylon Tubing 1/4 O.D. ....	A.R.
5	175279	. 90° Male Elbow (Brass) (Standard) .....	1
	6-023510	. 90° Male Elbow (Brass) (Full Cycle Option) .....	1
6	178934	. Ball Valve (Standard) .....	1
	224061	. Solenoid Valve (2-Way) (Full Cycle Option) .....	1
7	010923	. Hex. Nipple (Standard) .....	1
	203144	. Close Nipple (Brass) (Full Cycle Option) .....	1
8		. Needle Valve (Order #1002439 - Feed Valve Kit) .....	1
9	179694	. Panel Nut 1-20NF (On Older Valves If Supplied) .....	1
10	6-023510	. 90° Male Elbow (Brass) (1/8 NPT x 1/4 Tube) .....	1
	175279	. 90° Male Elbow (Brass) (1/4 NPT x 1/4 Tube) (Older Machines) .....	1
<b>Current Machines:</b>			
11	201987	. Needle Valve .....	1
12	1002272	. Spacer .....	1
13	1002427	. Escuthcheon .....	1
14	176012	. Knob .....	1
15	004235	. Spring Pin .....	1
<b>Following Not Shown:</b>			
	201030	. Transmission Fluid (ATF) .....	A.R.
	142051	. Hydraulic Oil (ASTM 215 Anti-Wear) (Older Machines) .....	A.R.
Ref.	416087	. Head Feed Cylinder Assembly	
1	175273	. Lug .....	1
2	199130	. Nut, Hex. Jam 7/16-14NC .....	1
3	123333	. Pipe Plug .....	1
4	203799	. Quad Ring .....	1
5	14-014528	. Close Nipple .....	1
6	316346	. Cylinder .....	1
7	175586	. Spacer .....	1
8	013245	. Locknut 3/8-16NC .....	1
9	199302	. Washer, Flat 3/8 Wrought .....	1
10	123333	. Pipe Plug .....	1
11	175476	. Tie Rod .....	4
12	316349	. End Cap .....	1
13	001508	. O-Ring .....	1
14	204981	. Piston Seal Cup .....	1
15	319876	. Piston .....	1
16	202383	. Adhesive Sealant (Loctite #242-31 Threadlok) .....	A.R.
17	319533	. Rod .....	1
18	001508	. O-Ring .....	1
19	316348	. End Cap .....	1
20	199176	. Nut, Hex. 1/4-20NC .....	4
21	199321	. Washer, Lock 1/4 Std. ....	4

NEW DRG.
S.C.L. 10-21-04
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S.C.L. 6-14-06
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MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916S	529-96101	529-101762

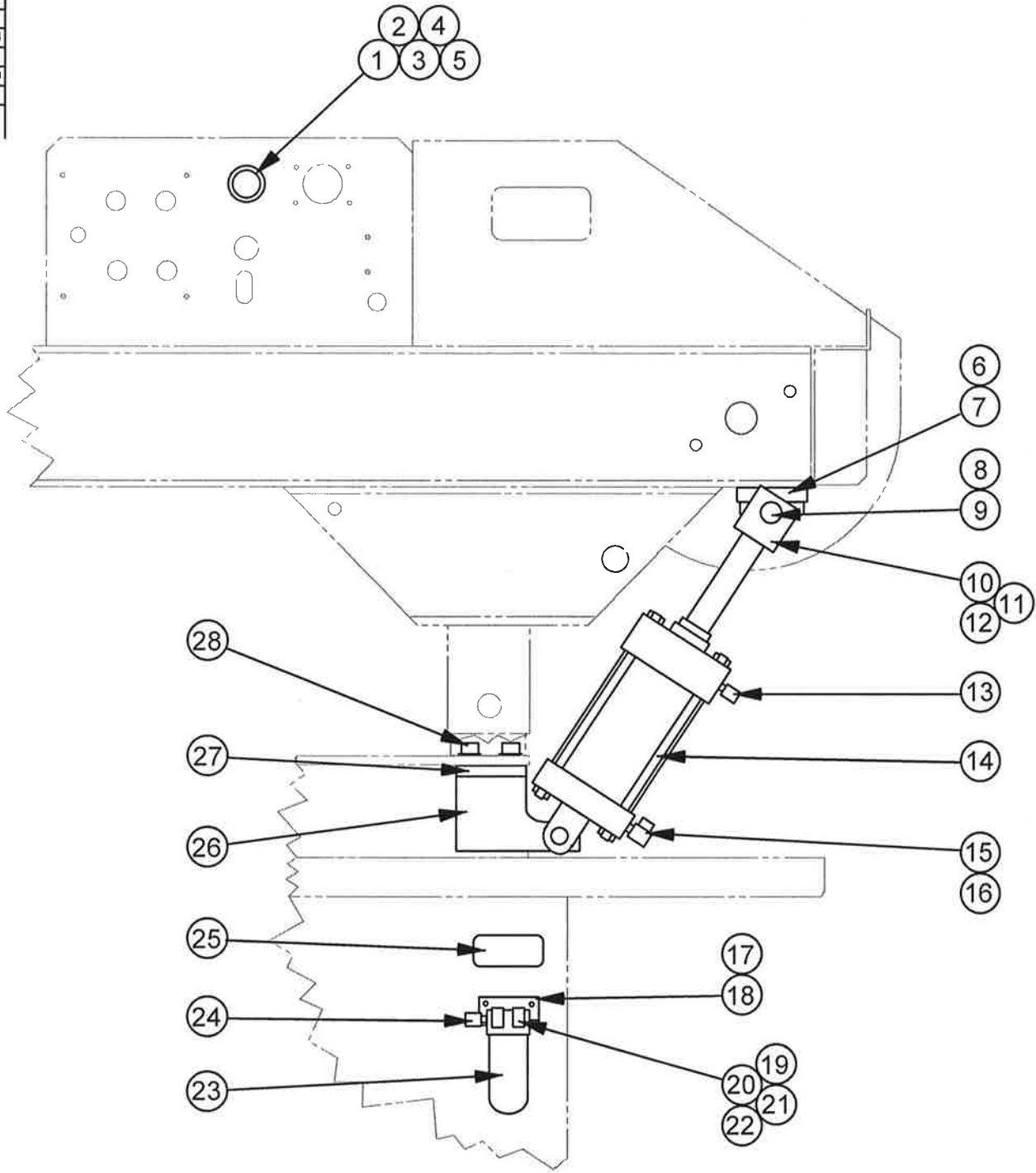
# MIST LUBRICATOR ASSEMBLY



**MIST LUBRICATOR ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	214936	Mist Lubricator Assembly (Without Pneumatics)	
Ref.	214935	Mist Lubricator Assembly (With Pneumatics)	
1	208833	. Lubricator Nozzle .....	1
2	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 .....	4
3	199202	. Nut, Hex. M5-0.8 .....	4
4	209458	. Clip Half .....	2
5	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 .....	2
6	199202	. Nut, Hex. M5-0.8 .....	2
7	176811	. Vent Filter Breather .....	1
8	208833	. Lubricator (Includes Nozzle) .....	1
9	199824	. Screw, Soc. Hd. Cap M6-1.0 x 55 .....	2
10	5-027506	. 90° Street Elbow .....	1
11	203144	. Hex. Nipple (Brass) .....	1
12	214906	. Bracket .....	1
13	199246	. Screw, Button Hd. Soc. M6-1.0 x 12 .....	2
14	197143	. Plastic Tubing 1/4 O.D. (Clear) .....	A.R.
15	197408	. Cable Tie (15") .....	4
16	197438	. Polyethelene Tubing 1/4 O.D. (Blue) .....	A.R.
17	176879	. Escutcheon (Air Supply) .....	1
18	325199	. Mounting Bracket .....	1
19	199299	. Screw, Self-Drilling M4.8 x 13 .....	2
20	217843	. Air Filter .....	1
	217844	. . Filter Element .....	1
21	009955	. Tubing Clamp .....	2
22	260426	. Reducer Bushing .....	1
23	112043	. Tee .....	1
24	200133	. Male Connector .....	1
25	200135	. 90° Swivel Male Elbow .....	1
Following Not Shown:			
	214124	. Heavy Duty Fluid (AL-2000) .....	A.R.
	201688	. Cord Grip Connector (.200-.394) .....	1

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S.C.L. 10-22-09
S.C.L. 6-6-11



MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916S	529-96101	529-101762

## PNEUMATIC HEAD LIFT ASSEMBLY

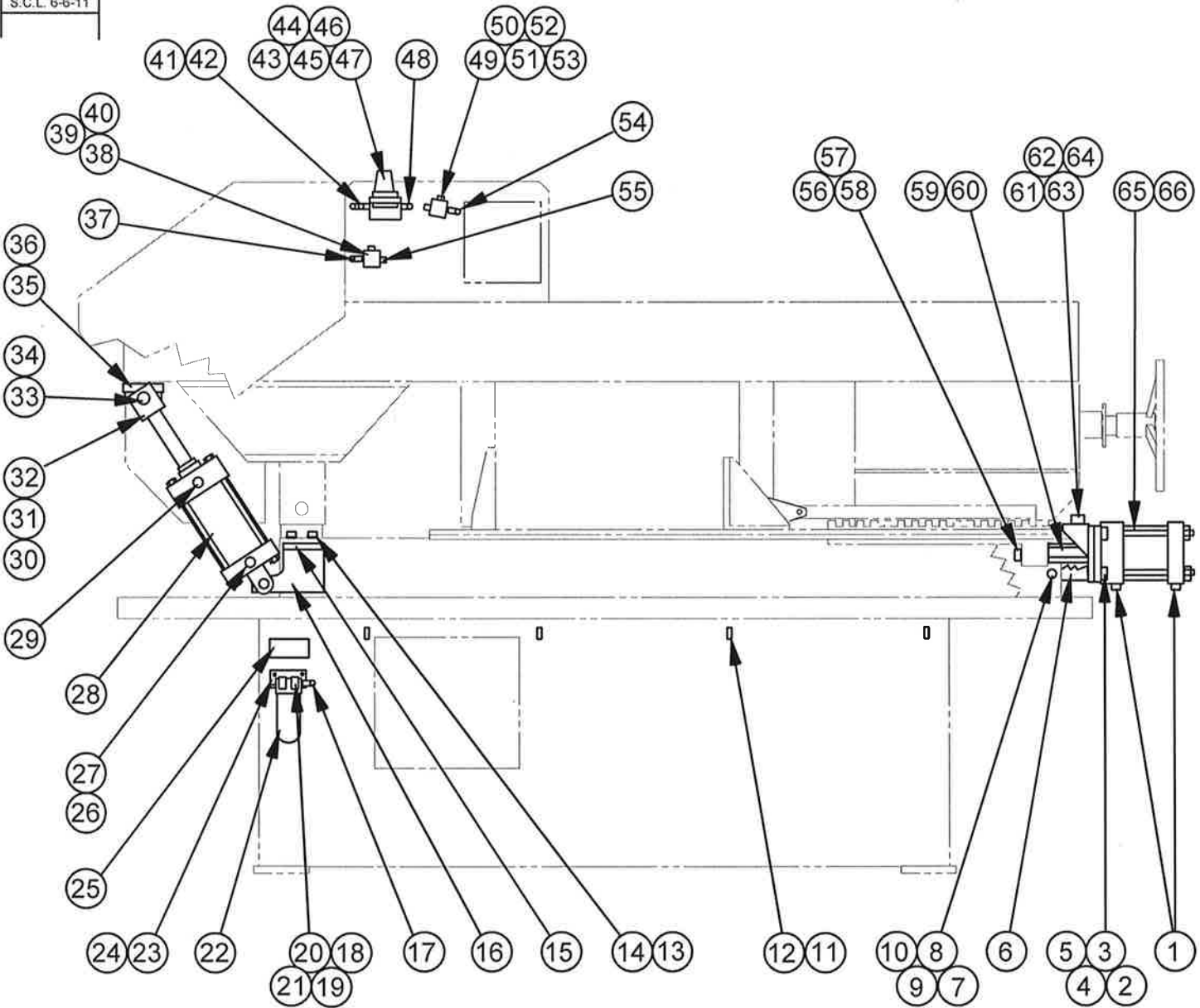
**PNEUMATIC HEAD LIFT ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	517270	Pneumatic Head Lift Assembly (C-916M)	
Ref.	517493	Pneumatic Head Lift Assembly (C-916S)	
1	206109	. Pneumatic Valve (3-Way) .....	1
2	199189	. Nut, Hex. Jam 3/4-16NF (Black Oxide) .....	1
3	176811	. Vent Filter Breather .....	1
4	176880	. Tag (Attention) .....	1
5	200135	. 90° Swivel Male Elbow .....	2
6	179584	. Mounting Block Weldment .....	1
7	199896	. Screw, Soc. Hd. Cap M10-1.5 x 25 .....	2
8	179586	. Pin .....	1
9	35-007558	. Retaining Ring .....	2
10	316604	. Pivot Bracket .....	1
11	198186	. Screw, Hex. Hd. Cap 3/4-16NF x 1-1/4 .....	1
12	202383	. Adhesive (Loctite #242-31 Threadlock) .....	A.R.
13	200133	. Male Connector .....	1
14	176228	. Pneumatic Head Lift Cylinder .....	1
15	203809	. Right Angle Flow Control Valve .....	1
16	176811	. Vent Filter Breather .....	1
17	324821	. Filter Mounting Bracket (Parker Filter) .....	1
	320285	. Filter Mounting Bracket (ARO Filter) .....	1
18	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13 .....	2
19	206103	. Tubing Clamp .....	2
20	199899	. Screw, Soc. Hd. Cap M6-1.0 x 16 .....	2
21	199347	. Washer, Lock M6 (Some Machines) .....	2
22	199188	. Nut, Hex. M6-1.0 (Some Machines) .....	2
23	217843	. Air Filter (Parker) .....	1
	206111	. Air Filter (ARO) .....	1
	217844	. Filter Element (Parker) .....	1
	206112	. Filter Element (ARO) .....	1
24	200135	. 90° Swivel Male Elbow .....	1
	200133	. Male Connector (Some Machines) .....	1
25	176879	. Escutcheon (Air Supply) .....	1
26	320605	. Cylinder Mount Bracket .....	1
27	204140	. Spacer (C-916M Only) .....	1
28	199918	. Screw, Soc. Hd. Cap M12-1.75 x 45 (C-916M) .....	2
	199742	. Screw, Soc. Hd. Cap M12-1.75 x 35 (C-916S) .....	2

Following Not Shown:

197438 . Polyethylene Tubing 1/4 O.D. (Blue) ..... A.R.

NEW DRG.
S.C.L. 5-5-96
REVISIONS
S.C.L. 6-3-97
S.C.L. 10-29-04
S.C.L. 3-11-08
S.C.L. 10-22-09
S.C.L. 6-6-11



MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916S	529-96101	529-101762

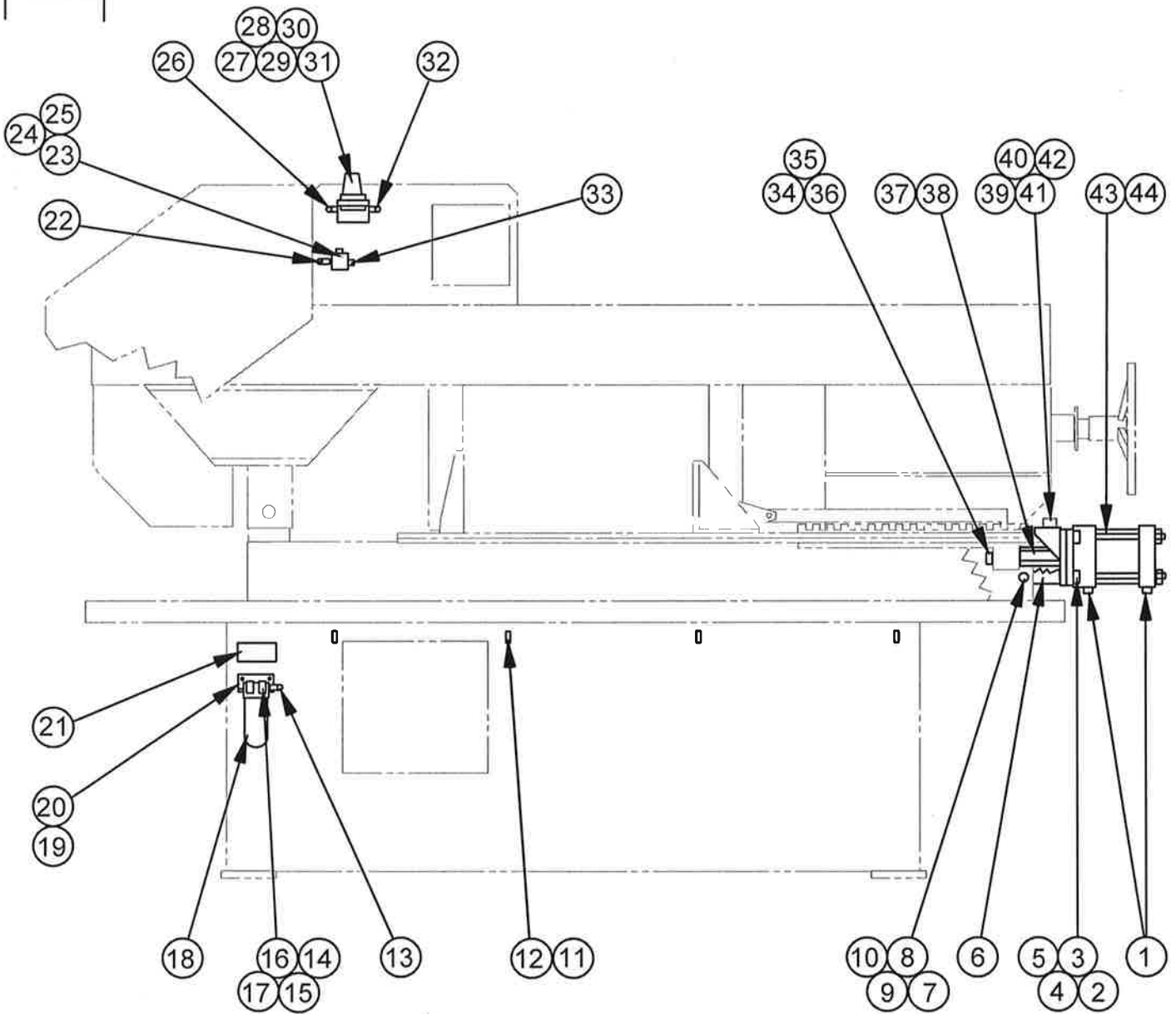
## PNEUMATIC HEAD LIFT ASSEMBLY WITH PNEUMATIC VISE OPTION

**PNEUMATIC HEAD LIFT ASSEMBLY  
With PNEUMATIC VISE OPTION**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.	INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	517263	Pneumatic Head Lift Assembly with Pneumatic Vise Option (C-916M)		36	199896	Screw, Soc. Hd. Cap M10-1.5 x 25	2
Ref.	517494	Pneumatic Head Lift Assembly with Pneumatic Vise Option (C-916S)		37	200135	90° Swivel Male Elbow	2
1	200133	Male Connector	2	38	206110	Pneumatic Valve (4-Way)	1
2	199921	Screw, Soc. Hd. Cap M10-1.5 x 45	4	39	176811	Vent Filter Breather	2
3	198976	Washer, Flat M10	4	40	199189	Nut, Hex. Jam 3/4-16NF (Black Oxide)	1
4	199346	Washer, Lock M10	4	41	112043	Street Tee	1
5	199939	Nut, Hex. M10-1.5	4	42	200135	90° Swivel Male Elbow	1
6	319327	Bracket	1	43	206114	Air Regulator	1
7	199680	Screw, Soc. Hd. Cap M10-1.5 x 30	1	44	200137	Gauge	1
8	199346	Washer, Lock M10	1	45	199974	Screw, Button Hd. Soc. M5-0.8 x 10	2
9	198976	Washer, Flat M10	1	46	320608	Mounting Bracket	1
10	199939	Nut, Hex. M10-1.5	1	47	206113	Panel Mounting Nut	1
11	009955	Tube Clamp	6	48	200135	90° Swivel Male Elbow	1
12	199299	Screw, Hex. Hd. Self-Drilling M4.8 x 13	3	49	206109	Pneumatic Valve (3-Way)	1
13	199918	Screw, Soc. Hd. Cap M12-1.75 x 45 (C-916M)	2	50	199189	Nut, Hex. Jam 3/4-16NF (Black Oxide)	1
	199742	Screw, Soc. Hd. Cap M12-1.75 x 35 (C-916S)	2	51	176811	Vent Filter Breather	1
14	199345	Washer, Lock M12	2	52	176880	Tag (Attention)	1
15	204140	Spacer (C-916M Only)	1	53	200133	Male Connector	1
16	320605	Cylinder Mount Bracket	1	54	200135	90° Swivel Male Elbow	1
17	200135	90° Swivel Male Elbow	1	55	200133	Male Connector	1
18	206103	Tubing Clamp	2	56	199051	Screw, Soc. Hd. Cap 1/4-20NC x 1/2	1
19	199899	Screw, Button Hd. Soc. M6-1.0 x 16	2	57	199254	Washer, Lock M6 Hi-Collar	1
20	199347	Washer, Lock M6 (Some Machines)	2	58	109993	Washer	1
21	199188	Nut, Hex. M6 x 1.0 (Some Machines)	2	59	206894	Adaptor	1
22	217843	Air Filter (Parker)	1	60	199268	Washer, Flat 3/4 S.A.E. Std.	1
	206111	Air Filter (ARO)	1	61	320606	Bracket Weldment	1
	217844	Filter Element (Parker)	1	62	199918	Screw, Soc. Hd. Cap M12-1.75 x 45	2
	206112	Filter Element (ARO)	1	63	199933	Nut, Hex. M12-1.75	2
23	324821	Filter Mounting Bracket (Parker)	1	64	199345	Washer, Lock M12	2
	320285	Filter Mounting Bracket (ARO)	1	65	318130	Pneumatic Vise Clamp Cylinder	1
24	199299	Screw, Hex. Hd. Self-Drilling M4.8 x 13	2	66	199896	Screw, Soc. Hd. Cap M10-1.5 x 25	3
25	176879	Escutcheon (Air Supply)	1				
26	203809	Right Angle Flow Control Valve	1				
27	176811	Vent Filter Breather	1				
28	176228	Pneumatic Head Lift Cylinder	1				
29	200135	90° Swivel Male Elbow	1				
30	316604	Pivot Bracket	1				
31	198186	Screw, Hex. Hd. Cap 3/4-16NF x 1-1/4	1				
32	202383	Adhesive (Loctite #242-31 Threadlock)	A.R.				
33	179586	Pin	1				
34	35-007558	Retaining Ring	2				
35	179584	Mounting Block Weldment	1				

Following Not Shown:  
197438 Polyethylene Tubing 1/4 O.D. A.R.

NEW DRG.
S.C.L. 5-6-96
REVISIONS
S.C.L. 6-3-97
S.C.L. 10-29-04
S.C.L. 3-11-08
S.C.L. 10-22-09
S.C.L. 6-6-11



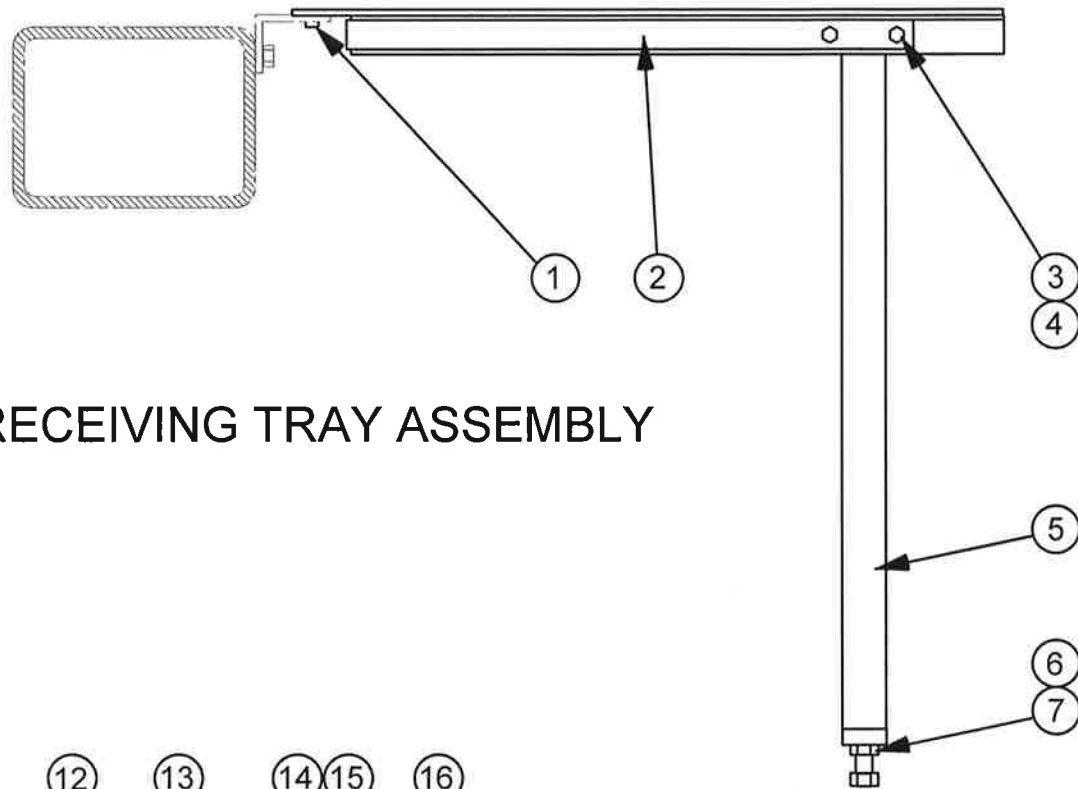
MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916S	529-96101	529-101762

# PNEUMATIC VISE ASSEMBLY

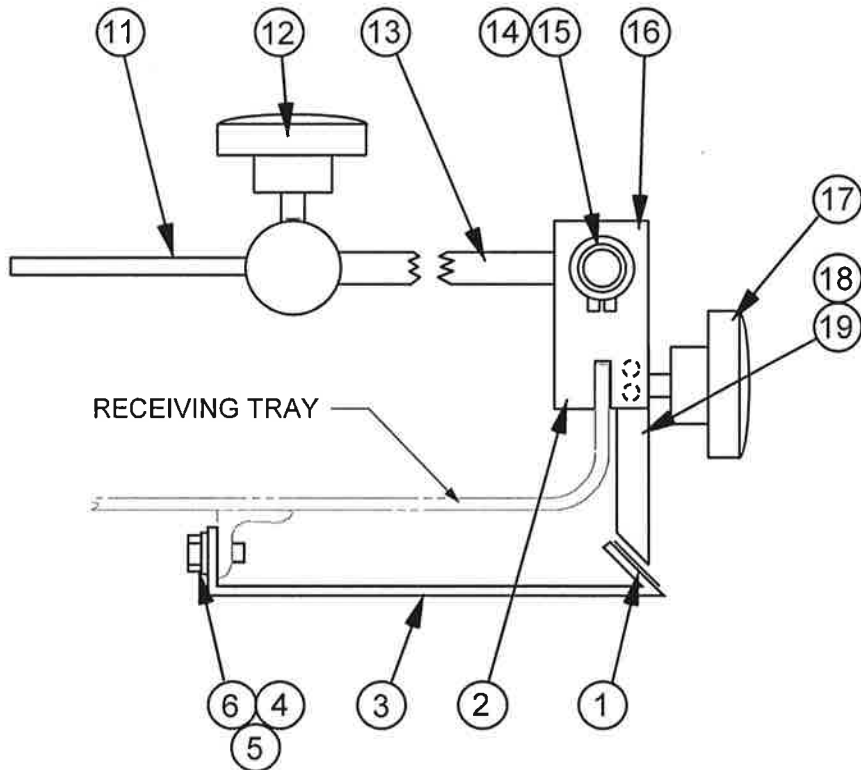
**PNEUMATIC VISE ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	517262	Pneumatic Vise Assembly (C-916M)	
Ref.	517492	Pneumatic Vise Assembly (C-916S)	
1	200133	. Male Connector .....	2
2	199921	. Screw, Soc. Hd. Cap M10-1.5 x 45 .....	4
3	198976	. Washer, Flat M10 .....	4
4	199346	. Washer, Lock M10 .....	4
5	199939	. Nut, Hex. M10-1.5 .....	4
6	319327	. Bracket .....	1
7	199680	. Screw, Soc. Hd. Cap M10-1.5 x 30 .....	1
8	199346	. Washer, Lock M10 .....	1
9	198976	. Washer, Flat M10 .....	1
10	199939	. Nut, Hex. M10-1.5 .....	1
11	009955	. Tube Clamp .....	4
12	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13 .....	4
13	200135	. 90° Swivel Male Elbow .....	1
14	206103	. Tubing Clamp .....	2
15	199899	. Screw, Button Hd. Soc. M6 x 1.0 x 16 .....	2
16	199347	. Washer, Lock M6 (Some Machines) .....	2
17	199188	. Nut, Hex. M6 x 1.0 (Some Machines) .....	2
18	217843	. Air Filter (Parker) .....	1
	206111	. Air Filter (ARO) .....	1
	206112	. Filter Element (ARO) .....	1
	217844	. Filter Element (Parker) .....	1
19	324821	. Filter Mounting Bracket (Parker Filter) .....	1
	320285	. Filter Mounting Bracket (ARO) .....	1
20	199299	. Screw, Hex. Hd. Self-Drilling M4.8 x 13 .....	2
21	176879	. Escutcheon (Air Supply) .....	1
22	200135	. 90° Swivel Male Elbow .....	2
23	206110	. Pneumatic Valve (4-Way) .....	1
24	176811	. Vent Filter Breather .....	2
25	199189	. Nut, Hex. Jam 3/4-16NF (Black Oxide) .....	1
26	200135	. 90° Swivel Male Elbow .....	2
27	206114	. Air Regulator .....	1
28	200137	. Gauge .....	1
29	199974	. Screw, Button Hd. Soc. M5-0.8 x 10 .....	2
30	320608	. Mounting Bracket .....	1
31	206113	. Panel Mounting Nut .....	1
32	200135	. 90° Swivel Male Elbow .....	1
33	200133	. Male Connector .....	1
34	199051	. Screw, Soc. Hd. Cap M6-1.0 x 12 .....	1
35	199254	. Washer, Lock M6 Hi-Collar .....	1
36	109993	. Washer .....	1
37	206894	. Adaptor .....	1
38	199268	. Washer, Flat 3/4 S.A.E. Std. ....	1
39	320606	. Bracket Weldment .....	1
40	199918	. Screw, Soc. Hd. Cap M12-1.75 x 45 .....	2
41	199933	. Nut, Hex. M12-1.75 .....	2
42	199345	. Washer, Lock M12 .....	2
43	318130	. Pneumatic Vise Clamp Cylinder .....	1
44	199896	. Screw, Soc. Hd. Cap M10-1.5 x 2.5 .....	3
Following Not Shown:			
	197438	. Polyethylene Tubing 1/4 O.D. (Blue) .....	A.R.
	167329	. Nylon Clamp .....	1

NEW DRG.
S.C.L. 5-1-96
REVISIONS
S.C.L. 6-3-97
S.C.L. 10-29-04
S.C.L. 6-14-06
S.C.L. 3-11-08
S.C.L. 10-22-09
S.C.L. 6-6-11



## RECEIVING TRAY ASSEMBLY



## WORKSTOP ASSEMBLY

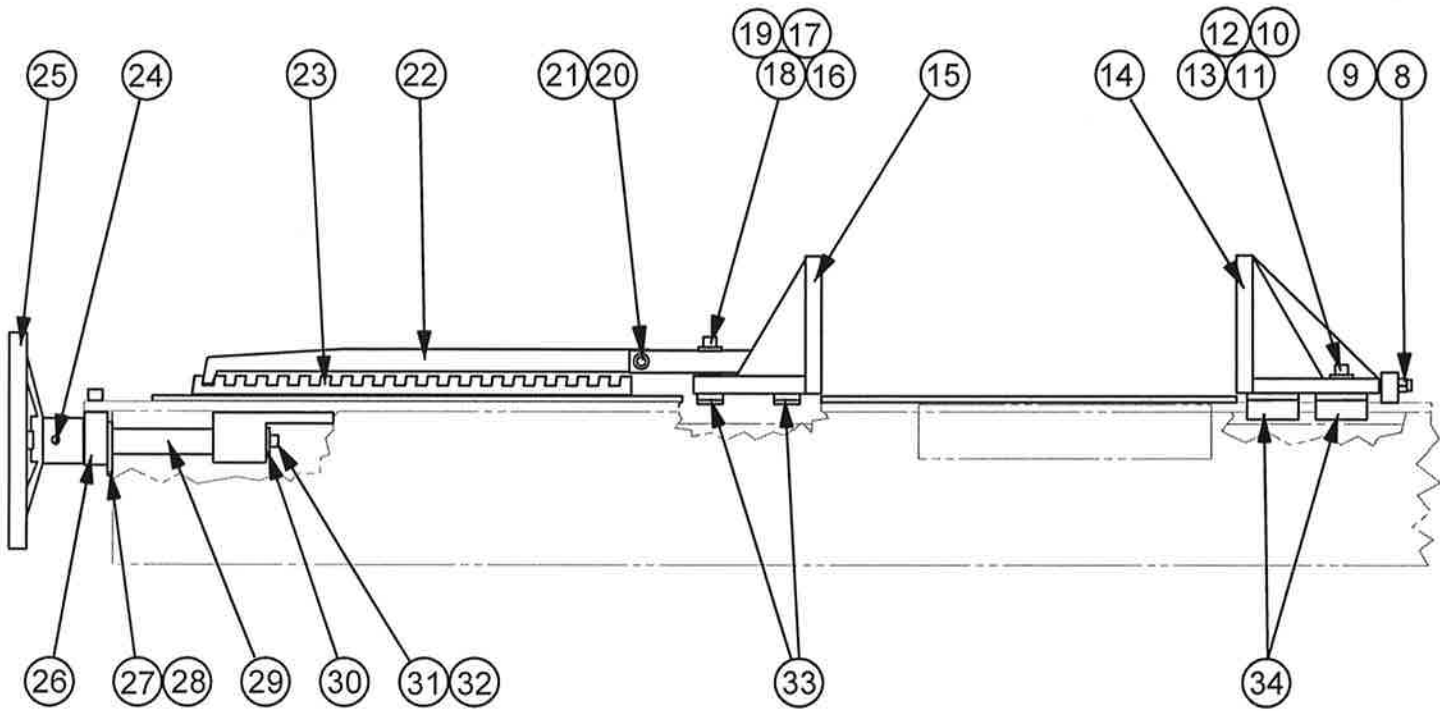
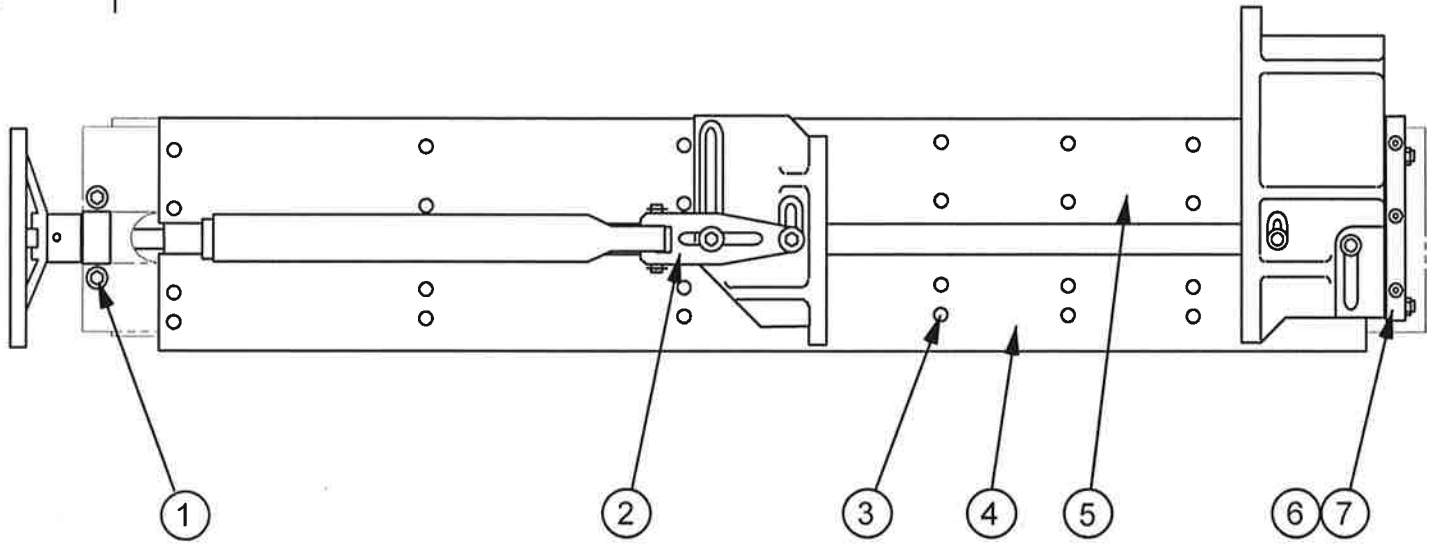
MODEL	FIRST MACH.	LAST MACH.
C-916M	527-96101	527-102304
C-916S	529-96101	529-101762



**RECEIVING TRAY ASSEMBLY  
WORKSTOP ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	517256	Receiving Tray Assembly (18"/455 mm) (C-916M)	
Ref.	517496	Receiving Tray Assembly (18"/455 mm) (C-916S)	
Ref.	517907	Receiving Tray Assembly (48"/1220 mm) (C-916M)	
Ref.	517906	Receiving Tray Assembly (48"/1220 mm) (C-916S)	
1	199241	. Screw, Flat Hd. Mach. M6-1.0 x 12 .....	3199246
		. Screw, Button Hd. Soc. M6-1.0 x 12 (Some Machines) .....	3
2	517258	. Tray Weldment (18"/455 mm) (C-916M) .....	1
	517497	. Tray Weldment (18"/455 mm) (C-916S) .....	1
	517908	. Tray Weldment (48"/1220 mm) (C-916M) .....	1
	517905	. Tray Weldment (48"/1220 mm) (C-916S) .....	1
3	199239	. Screw, Hex. Hd. Cap M8-1.25 x 20 .....	4
4	199968	. Washer, Lock M8 .....	4
5	320592	. Leg Weldment .....	1
6	198165	. Screw, Hex. Hd. Cap M12-1.75 x 45 (C-916M) .....	2
	199288	. Screw, Hex. Hd. Cap M12-1.75 x 150 (C-916S) .....	2
7	199222	. Nut, Hex. Jam M12-1.75 .....	2
Ref.	208128	Workstop Assembly (18"/455 mm) (C-916M)	
Ref.	208127	Workstop Assembly (18"/455 mm) (C-916S)	
Ref.	209133	Workstop Assembly (42"/1065 mm) (C-916M)	
Ref.	209110	Workstop Assembly (42"/1065 mm) (C-916S)	
1	176463	. Rule (18"/455 mm) .....	1
	209108	. Rule (42"/1065 mm) .....	1
2	320602	. Workstop Sub-Assembly (See Detail) .....	1
3	320837	. Support (C-916M) .....	1
	320838	. Support (C-916S) .....	1
	418466	. Support (42"/1065 mm) (C-916M) .....	1
	418465	. Support (42"/1065 mm) (C-916S) .....	1
4	198972	. Screw, Hex. Hd. Cap M6-1.0 x 16 .....	2
5	199347	. Washer, Lock M6 .....	2
6	199579	. Washer, Flat M6 Wrought .....	2
Ref.	320602	. Workstop Sub-Assembly	
11	200506	. . Adjusting Rod Weldment .....	1
12	206892	. . Knob .....	1
13	320603	. . Pivot Weldment .....	1
14	200510	. . Pivot Shaft .....	1
15	35-008688	. . Retaining Ring .....	2
16	320604	. . Pivot Block Weldment .....	1
17	206892	. . Knob .....	1
18	208030	. . Pointer .....	1
19	198722	. . Screw, Button Hd. Soc. M4-0.7 x 6 .....	2

NEW DRG. S.C.L. 5-3-96
REVISIONS
S.C.L. 6-3-97
S.C.L. 10-29-04
S.C.L. 3-11-08
S.C.L. 10-22-09
S.C.L. 6-6-11



MODEL FIRST MACH. LAST MACH.  
C-916M 527-96101 527-102304

## SWIVEL VISE JAW ASSEMBLY

**SWIVEL VISE JAW ASSEMBLY**

INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASS'Y.
Ref.	517259	Swivel Vise Jaw Assembly	
1*	198990	. Screw, Soc. Hd. Cap M12-1.75 x 25 .....	2
2	023157	. Link .....	1
3	199246	. Screw, Button Hd. Soc. M6-1.0 x 12 .....	32
4	415159	. Front Wear Plate .....	1
5	415161	. Rear Wear Plate .....	1
6	320594	. Alignment Bar .....	1
7	199919	. Screw, Soc. Hd. Cap M10-1.5 x 35 .....	3
8	199242	. Screw, Soc. Set M8-1.25 x 40 .....	2
9	199250	. Nut, Hex. Jam M8-1.25 .....	2
10	199911	. Screw, Soc. Hd. Cap M10-1.25 x 40 .....	2
11	199346	. Washer, Lock M10 .....	2
12	206875	. Washer .....	2
13	201817	. Knurled Washer .....	2
14	513897	. Fixed Jaw .....	1
15	512648	. Movable Jaw .....	1
16	199847	. Screw, Soc. Hd. Cap M10-1.5 x 70 .....	2
17	199346	. Washer, Lock M10 .....	2
18	206875	. Washer .....	2
19	201817	. Knurled Washer .....	2
20	179579	. Pin .....	1
21	35-009613	. Retaining Ring .....	2
22	314884	. Pawl .....	1
23	417077	. Rack .....	1
24*	004277	. Spring Pin .....	1
25*	313997	. Handwheel .....	1
26*	320599	. Bearing Block Assembly .....	1
	104284	. Bearing .....	1
27*	108749	. Thrust Bearing .....	1
28*	176759	. Hardened Washer .....	1
29*	320601	. Vise Lock Screw .....	1
30*	109993	. Washer .....	1
31*	199993	. Screw, Soc. Hd. Cap M6-1.0 x 20 .....	1
32*	199254	. Washer, Lock M6 Hi-Collar .....	1
33	206876	. Tee .....	2
34	320593	. Tee .....	2

\*NOTE: Items Marked Used On Assembly #206887 Vise Clamp Handwheel and Screw Sub-Assembly with Mounting Hardware.