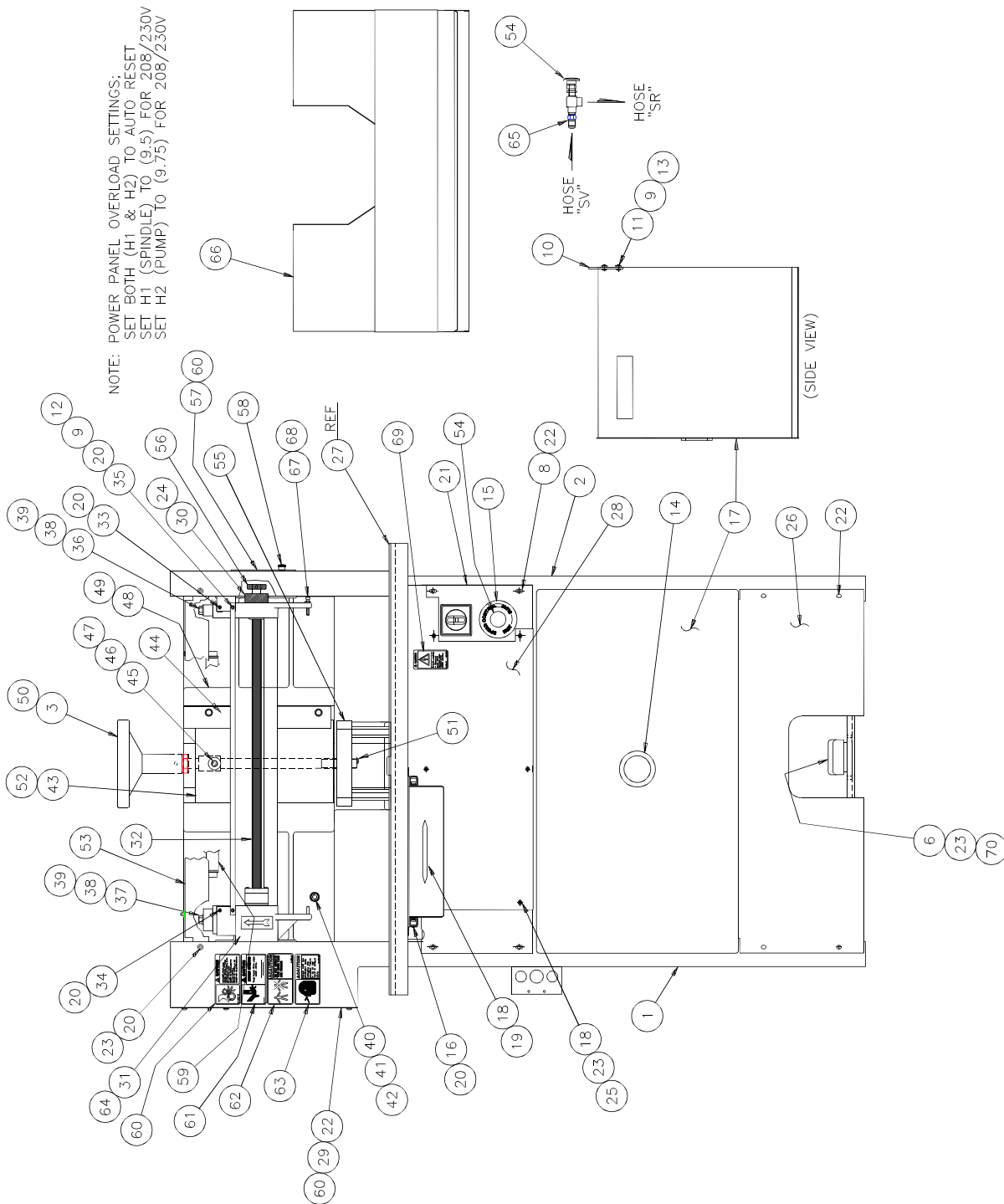


5.0 Main Assemblies

5.1 Main Assembly – Front View

A-6500-7 Rev. B



Main Assembly – Front View – Parts List

A-6500-7 Rev. B

NO.	PART NO.	DESCRIPTION	QTY
1	6501-1	SIDE FRAME - RIGHT HAND	1
2	6502-2	SIDE FRAME - LEFT HAND	1
3	6520-1	HANDWHEEL	1
4			
5			
6	EE-3246	FOOTSWITCH ASSEMBLY	1
7	H-6913-406	SCREW - 1/4-20 X 3/4 HEX HD	2
8	H-7324-8	WASHER - 1/4 INT TOOTHLOCK	6
9	H-6423-4	NUT - 1/4-20 HEX	8
10	6685	DRAWER STOP	2
11	H-7325-6	WASHER - 3/16 LOCK	4
12	H-7321-#10	WASHER - #10 FLAT POLISHED	2
13	H-6925-102406	SCREW - #10-24 X 3/8 TRUSS HO	4
14	S-1678	RUBBER GROMMET	1
15	S-1684	DECAL - SPEED CONTROL	1
16	A-6558-1	SLIDE ASSEMBLY – DRAWER	2
17	A-6523	DRAWER ASSEMBLY - CHIP	1
18	H-6910-102403	SCREW - #10-24 X 3/8 BUT HD SOC CAP	8
19	S-1738	DRAWER PULL	1
20	H-6910-102404	SCREW - #10-24 X 1/2 BUT HD SOC CAP	10
21	EE-3232	ENCLOSURE ASSEMBLY - ELECTRICAL	1
22	H-6910-403	SCREW - 1/4-20 X 3/8 BUT HD CAP	15
23	H-7324-#10	WASHER - #10 SHAKEPROOF	8
24	H-21S-187-0750	PIN - 3/16 X 3/4 ROLL	1
25	S-1864-2	#10 CAPTIVE RETAINING DEVICE	4
26	6522-2	COVER - FRONT, LOWER	1
27	6503-1	TABLE - WELDMENT	REF
28	6578-1	COVER - FRONT, ELECTRICAL ENCLOSURE	1
29	6537	COVER - BELT GUARD	1
30	A-6528	BEARING HOUSE ASSEMBLY - RIGHT HAND	1
31	A-6531	BEARING HOUSE ASSEMBLY - LEFT HAND	1
32	6535	SHAFT - SPLINE	1
33	16505	BRACKET - SCALE, RIGHT HAND	1
34	16505-1	BRACKET - SCALE, LEFT HAND	1
35	6545	SCALE	1
36	6601	CLAMP - HOUSING, RIGHT HAND	1
37	6601-1	CLAMP - HOUSING, LEFT HAND	1
38	H-6913-612	SCREW - 3/8-16 X 1-1/2 HEX HD CAP	2
39	H-7327-12	WASHER - 3/8 MEDIUM LOCK	2
40	S-1727	SPRING	1
41	6592	SCREW - MOTOR PLATE ADJUSTMENT	1
42	H-6424-12	NUT - 3/4-10 HEX JAM	1
43	6516-3	DOVETAIL – SPINDLE	1
44	6517-1	GIB - VERTICAL DOVETAIL	1
45	H-6951-808	SCREW - 1/2-13 X 1/2" NYLOC SET	1
46	S-1255-1	SPRING	1
47	6609-1	PLUNGER - TEFLON	1
48	H-6424-6	NUT - 3/8-16 HEX JAM	3
49	H-6938-632	SCREW - 3/8-16 X 2" SOC SET	3
50	A-6519-1	HANDWHEEL ASSEMBLY	1

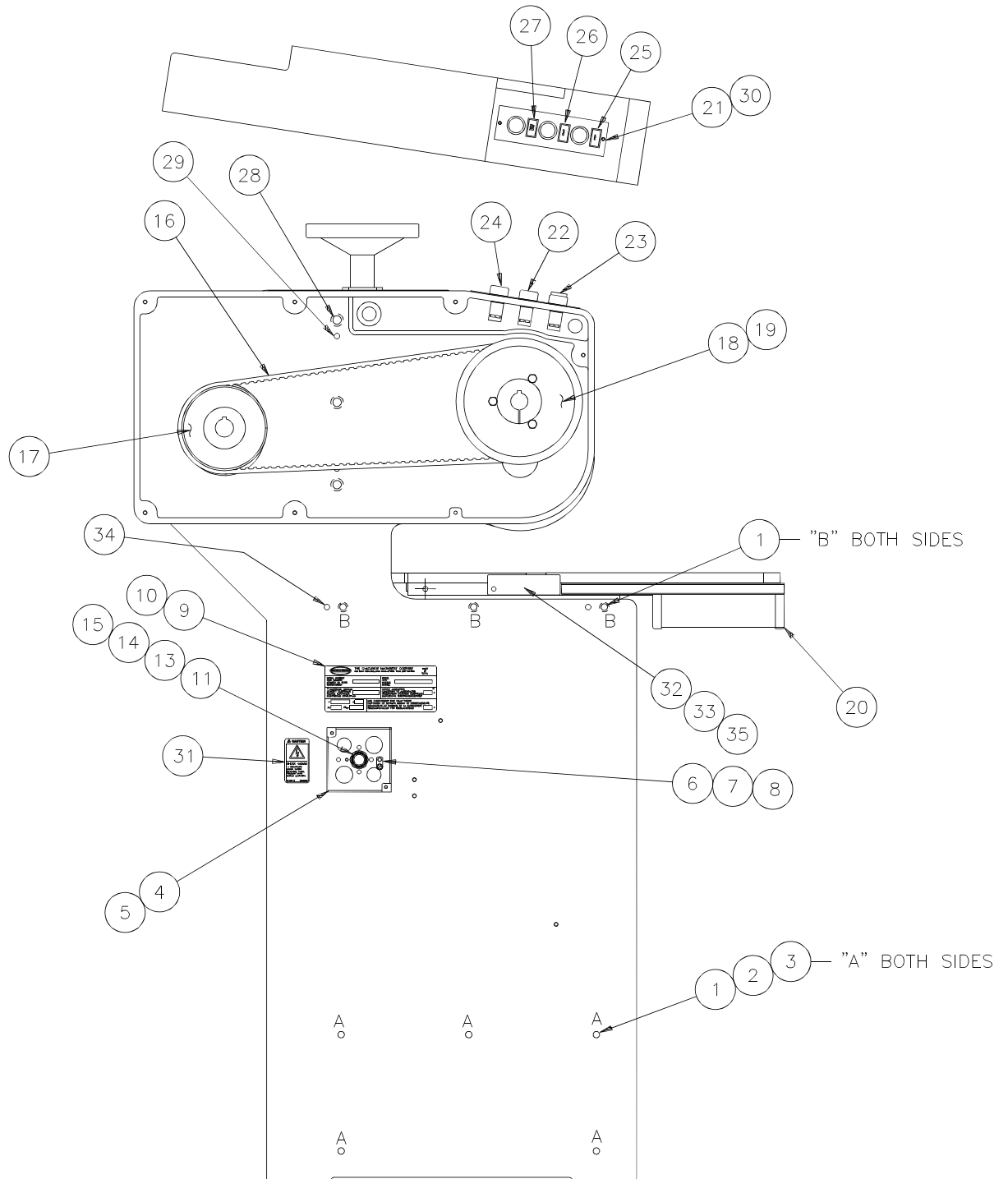
Main Assembly – Front View – Parts List

A-6500-7 Rev. B

NO.	PART NO.	DESCRIPTION	QTY
51	H-6903-404	SCREW - 1/4-20 X 1/2" NYLOC BUT HD CAP	1
52	P-325-F	FELT - 2 X 2-1/8"	2
53	EE-1489-3	LIGHT ASSEMBLY - TABLE/INTERLOCK SWITCH	1
54	4771-1	VALVE - BRONZE NEEDLE	1
55	6511	PULL DOWN BAR	1
56	6536	KNOB - SPLINE	1
57	6575	COVER - R.H. SIDE, PLEXIGLASS	1
58	7957-5	KNOB – ADJUSTMENT	2
59	S-845	BULB - FLORESCENT	1
60	S-1781-16	WARNING LABEL - CRUSH HAZARD (GEARS)	3
61	S-1781-3M	WARNING LABEL - CRUSH HAZARD (CLAMP)	1
62	S-1781-31	WARNING LABEL - SINGLE OPERATOR	1
63	S-1781-82	WARNING LABEL - EYE WEAR	1
64	S-1106	LABEL - DIRECTION ARROW	1
70	H-6910-102406	SCREW - #10-24 X 3/4 BUT HD SOC CAP	2
69	S-1781-12	LABEL - SHOCK WARNING	1
68	H-6423-#10	NUT - #10-24 HEX (KEP)	1
67	H-6918-102410	SCREW - #10-24 X 1-1/4 SOC HD CAP	1
66	A-6538	ASSEMBLY - CHIP CHUTE	1
65	H-241-5	ADAPTER - PIPE (EXT.) TO TUBE	1

5.2 Main Assembly – Left Side Elevation

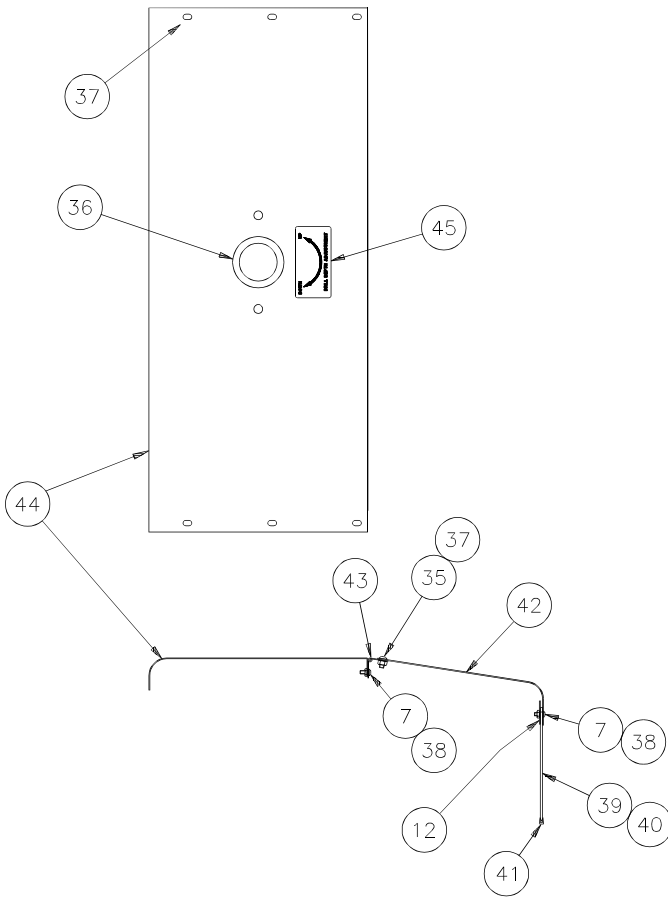
A-6500-7 Rev. A



Main Assembly – Left Side Elevation – Parts List

A-6500-7 Rev. A

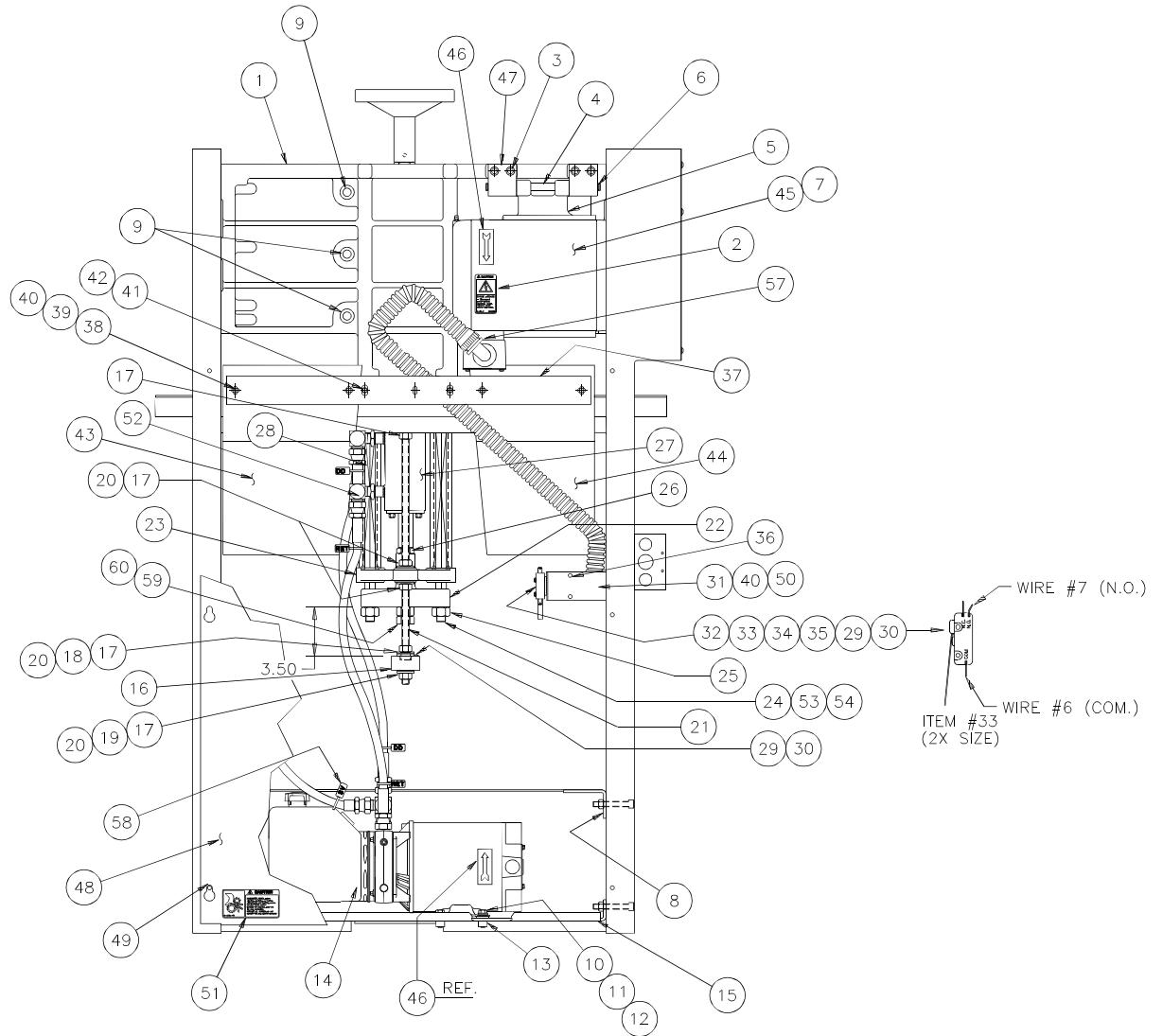
TOP COVER ASSEMBLY DETAIL



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	H-6918-620	SCREW - 3/8-16 X 2-1/2 SOC HD CAP	16
2	H-6424-6	NUT - 3/8-16 HEX JAM	10
3	H-7327-12	WASHER - 3/8 MEDIUM LOCKWASHER	10
4	E-1369-1	BOX - JUNCTION	1
5	E-1370-1	COVER - ELECTRICAL JUNCTION BOX	1
6	E-640-1	GROUND LUG	1
7	H-6910-102404	SCREW - #10-24 X 1/2 BUT HD CAP	10
8	H-7324-#10	WASHER - #10 SHAKE PROOF	2
9	41130	LABEL - SPECIFICATION	1
10	H-6924-004	SCREW - #0 X 1/4 RD HD DRIVE	2
11	E-1459	BUSHING - 1/2 CONDUIT	1
12	6642	SUPPORT - SHIELD	1
13	E-519	LOCK NUT - 1/2 CONDUIT	1
14	H-6405-1-816	PIPE NIPPLE - 1/2 X 2	1
15	H-5350-8	PIPE COUPLING - 1/2 X 1-1/2	1
16	S-1716	TIMING BELT	1
17	S-1714	PULLEY - DRIVE	1
18	S-1714-1	PULLEY - DRIVEN	1
19	S-426	KEY - 1/4 X 1/4 X 1-1/4	1
20	A-6555-1	DRAWER ASSEMBLY - TOOL	1
21	E-1088-2	PLATE - SWITCH	1
22	E-3129	SWITCH - PUSHBUTTON, GREEN (1) N.O.	1
23	E-3129-2	SWITCH - PUSHBUTTON, RED (1) N.C.	1
24	E-3129-3	SWITCH - PUSHBUTTON, BLACK (1) N.O.	1
25	E-1103-4	LABEL - SWITCH, "STOP"	1
26	E-1103-3	LABEL - SWITCH, "START"	1
27	E-1103-2	LABEL - SWITCH, "TABLE LIGHT"	1
28	H-6918-820	SCREW - 1/2-13 X 2-1/2 SOC HD CAP	6
29	H-6633-722	PIN - #7 X 2-3/4 TAPER	4
30	H-6910-83203	SCREW - #8-32 X 3/8 BUT HD SOC CAP	2
31	S-1781-12	LABEL - SHOCK WARNING	1
32	H-6910-406	SCREW - 1/4-20 X 3/4 BUT HD SOC CAP	2
33	6590	INSERT STOP - TABLE SLOT	2
34	S-1574-1	TAPER PIN	4
35	H-6423-4	NUT - 1/4-20 (KEP) HEX	7
36	S-1678	GROMMET - RUBBER	1
37	H-6910-404	SCREW - 1/4-20 X 1/2 BUT HD SOC CAP	5
38	H-6423-#10	NUT - #10-24 (KEP) HEX	8
39	4956-1	DECAL - CHALLENGE	1
40	6640	SHIELD - FRONT	1
41	7032-M	TRIM - BLACK, PLASTIC 29-3/8" LONG	1
42	6639	COVER - FRONT (STD)	1
43	6553	HINGE	1
44	6552	COVER - TOP	1
45	S-1781-86	LABEL - DRILL DEPTH ADJUSTMENT	1

5.3 Main Assembly – Rear Elevation

A-6500-7 Rev. D



Main Assembly – Rear Elevation – Parts List

A-6500-7 Rev. D

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	6504	DOVETAIL - VERTICLE	1
2	S-1781-12	LABEL - SHOCK WARNING	1
3	H-6918-608	SCREW - 3/8-16 X 1" SOC HD CAP	4
4	6593-1	SHAFT - SPINDLE MOTOR MOUNT	1
5	6584-2	PLATE - SPINDLE MOTOR	1
6	S-1193-50	RETAINING RING - .500 DIA. STYLE 'E'	2
7	H-6913-608	SCREW - 3/8-16 X 1-1/2" HEX HD CAP	4
8	6509	SLIDE - CHIP DRAWER	2
9	H-6918-818	SCREW - 1/2-13 X 2-1/4" SOC HD CAP	3
10	H-6913-508	SCREW - 5/16-18 X 1" HEX HD	4
11	H-7327-10	WASHER - 5/16 MEDIUM LOCK	4
12	H-7321-5	WASHER - 5/16 PLAIN	4
13	A-10042	BUSHING - 5/16-18 THR'D ANTI-VIB	4
14	H-566	HYDRAULIC UNIT ASSEMBLY	1
15	6506-2	BASE	1
16	6539	PLATE - AUTO RETURN	1
17	H-6424-8	NUT - 1/2-13 HEX JAM	10
18	47214-3	WASHER - SHOULDER, NYLON	2
19	11288-2	WASHER - NYLON	2
20	H-7321-8	WASHER - 1/2 PLAIN	7
21	6510-2	STUD - CYLINDER MOUNTING, 1/2-13 THR'D	2
22	6515	BRACKET - GUIDE ROD	1
23	6514-1	SPRING PLATE	1
24	6512	PULLDOWN ROD	2
25	H-6423-10	NUT - 5/8-11 HEX	2
26	H-6428-12	NUT - 3/4-16NF HEX JAM	1
27	H-340	CYLINDER ASSEMBLY - HYDRUALIC	1
28	6513-2	SPRING	2
29	H-6910-102403	SCREW - #10-24 X 3/8 BUT HD CAP	3
30	H-7324-#10	WASHER - #10 INT. TOOTHLOCK	1
31	3982-1	BRACKET - CHIP DRAWER INTERLOCK	1
32	41034-1	BRACKET - MICRO SWITCH	1
33	E-3112	SWITCH - SNAP ACTION (SPST)	1
34	H-6918-44008	SCREW - #4-40 X 1" SOC HD	2
35	H-7324-#4	WASHER - #4 INT. TOOTHLOCK	2
36	S-1694	TYRAP - WIRE	1
37	6648	BRACKET - CHIP CHUTE MOUNT	1
38	H-6910-406	SCREW - 1/4-20 X 3/4" BUT HD SC cAP	4
39	H-6423-4	NUT - 1/4-20 HEX	4
40	H-7327-8	WASHER - 1/4 MED. LOCK	6
41	H-6405-1-612	PIPE NIPPLE - 3/8 X 1-1/2"	2

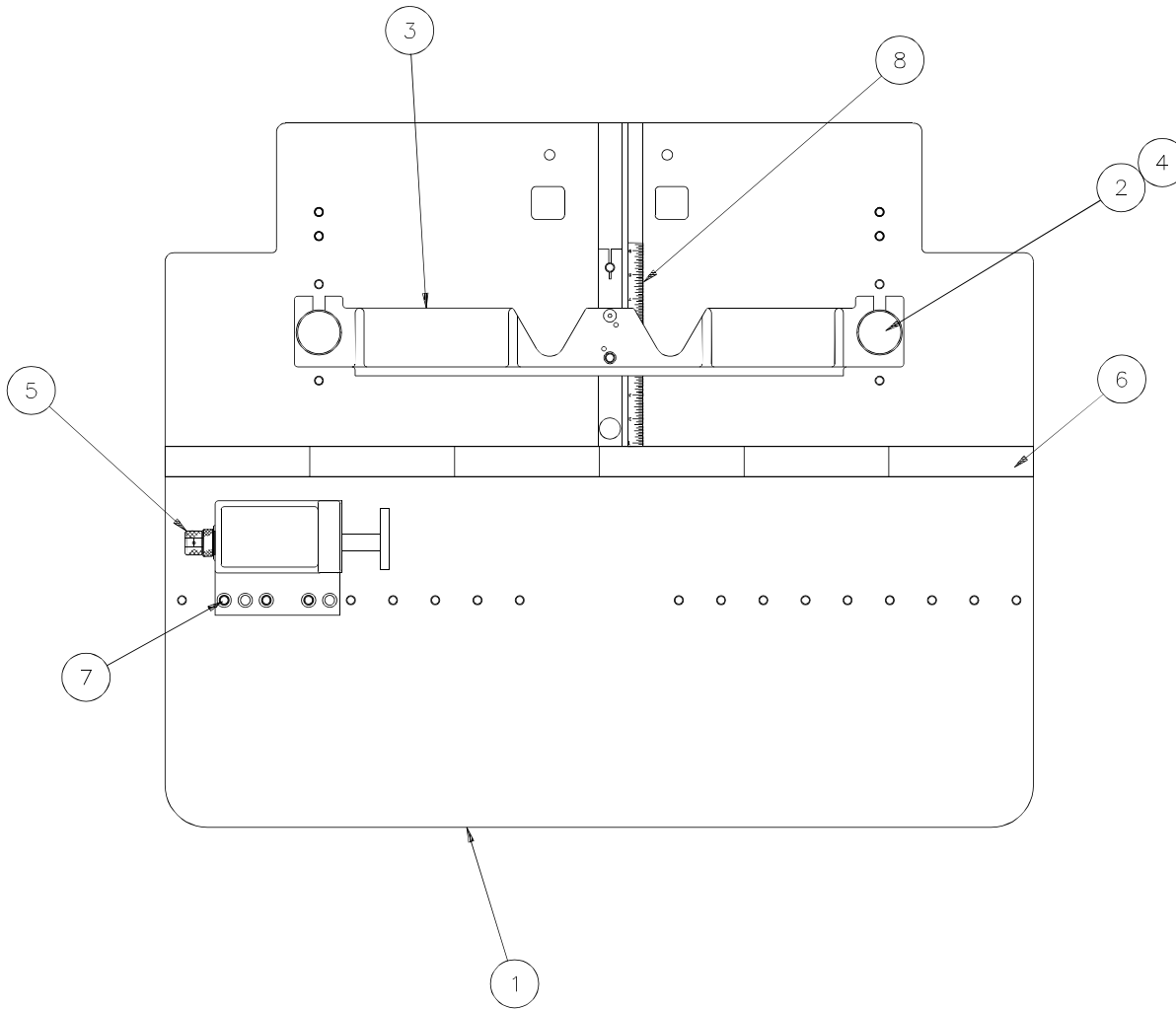
Main Assembly – Rear Elevation – Parts List – (cont.)

A-6500-7 Rev. D

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
42	H-6918-620	SCREW - 3/8-16 X 2-1/2" SOC HD CAP	2
43	6547	CHIP CHUTE - LOWER, RIGHT HAND	1
44	6550	CHIP CHUTE - LOWER, LEFT HAND	1
45	E-1600-113	MOTOR- SPINDLE, 230V 3PH 50HZ	1
45	E-1600-112	MOTOR- SPINDLE, 208/230V 3PH 60HZ	1
45	E-1600-110	MOTOR- SPINDLE, 208V 3PH 50HZ	1
46	S-1106	DECAL - ARROW	1
47	6591-1	BRACKET - MOTOR PLATE MOUNTING	2
48	6551	PANEL - BACK	1
49	H-6923-604	SCREW - 3/8-16 X 1/2" RD HD MACH.	6
50	H-6910-404	SCREW - 1/4-20 X 1/2" BUT HD SOC CAP	2
51	S-1781-16	WARNING LABEL - CRUSH HAZARD	1
52	H-230	90%° ELBOW - SAE 'O' RING TO TUBE	2
53	6589	WASHER - SPECIAL	2
54	H-5246-410	PIN - 1/4 X 1-1/4 DOWEL	2
55	S-1694-3	TYRAP - 1/4" SCREW MOUNT	3
56			
57	E-2190-1	CONDUIT CONNECTOR - 90 1/2" ELBOW	1
58	S-1694-5	TYRAP - IDENTIFICATION TAG	4
59	H-6913-810	BOLT - 1/2-13 X 1-1/4" HEX	1
60	H-6424-8	NUT - 1/2-13 HEX JAM	1

5.4 Main Assembly – Table

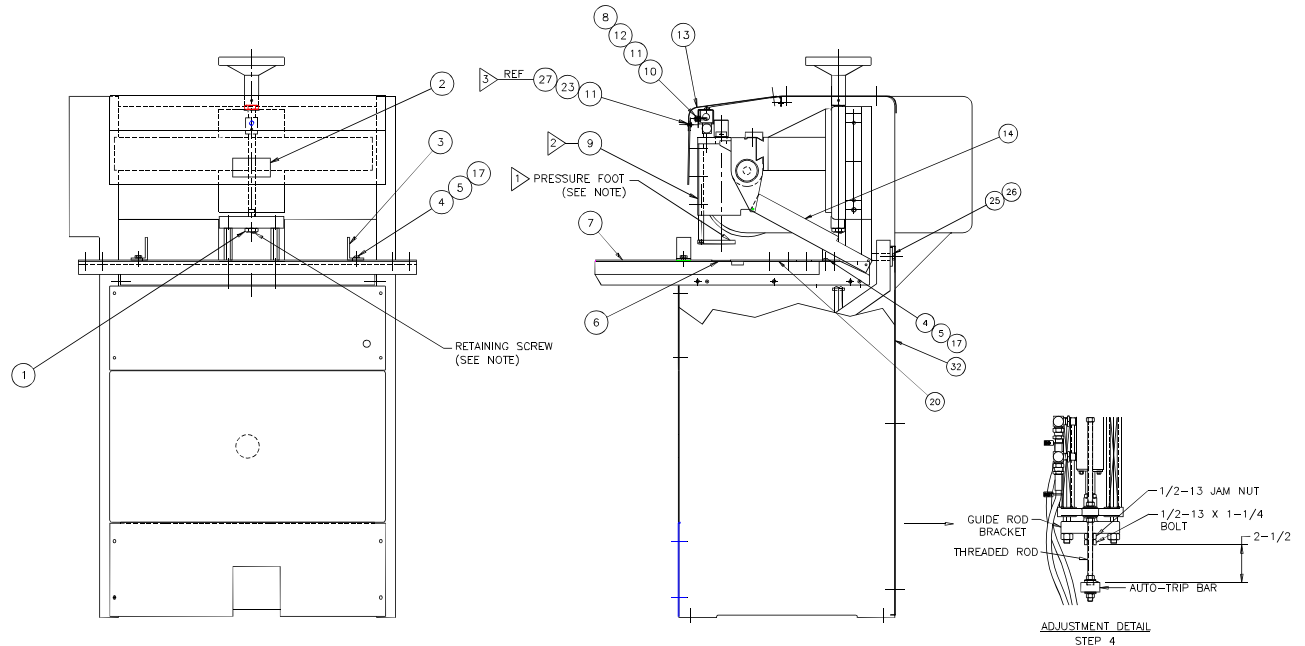
A-6500-7 Rev. A



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	6503-1	TABLE – WELDMENT	1
2	S-1770-1	KNOB – BACKGAGE	2
3	A-6561-2	ASSEMBLY – KEY & BACKGAGE	1
4	8815	WASHER – BACKGAGE KNOB	2
5	A-6565	SIDE GUIDE ASSEMBLY (STD.)	1
6	6564	DRILL STICK – WOOD	6
7	H-6918-606	SCREW – 3/8-16 X 3/4" SOC HD	3
8	2236-6	SCALE – TABLE, BRASS	1

5.5 Main Assembly – Large Diameter Drill Head Field Conversion

A-6500-7 Rev. B



INSTRUCTIONS FOR LARGE DIA DRILL FIELD CONVERSION:

- | | | | |
|---------------------------------|--------------|---------------------------|------------------|
| 1. REMOVE THE FOLLOWING PARTS: | PART NO. | STEP 3 CONT'D: | PART NO. |
| A. COVER | 6639 | D. (6) PLASTIC CUT STRIPS | 6669 |
| B. SCALE | 6545 | E. FRONT TABLE ADAPTOR | 6667 |
| C. HEADS | A-6594-6 | F. STOPS FOR DRILL BLOCKS | (SEE NOTE BELOW) |
| D. CHIP CHUTE | A-6538 | G. CHIP CHUTE | 6590 |
| E. SIDE GUIDE | A-6565 | H. BACKGAGE | A-6538 |
| F. BACKGAGE | A-6561-2 | I. HAND KNOBS | A-6561-2 |
| G. B.G. KNOBS | S-1770-1 | J. DRILL HEAD | S-1770-1 |
| H. STOPS FOR DRILL BLOCKS | 6590 | K. COVER | A-6594-7 |
| I. TABLE LIGHT ASSY | EE-1489-2 | L. (2) SCREWS (ITEM 26) | 6639-1 |
| J. RETAINING SCREW | (SEE DWG) | M. (2) NIPPLES (ITEM 25) | H-6913-624 |
| K. (2) CHIP CHUTE BRKT MTG SCRS | H-6918-620 | | H-6405-1-616 |
| L. (2) NIPPLES - 3/8 X 1-1/2 | H-6405-1-612 | | |
2. CLEAN TABLE – BE SURE WOOD CUTTING BLOCKS ARE FLUSH WITH TABLE.
3. INSTALL THE FOLLOWING PARTS:
- | | | |
|------------------------------|--|-----------|
| A. TABLE LIGHT ASSY | (MOUNTS OUTSIDE OF FRAME) | EE-1489-2 |
| B. REAR TABLE ADAPTER | | 6668 |
| M. 3/4-16 THIN FLEX LOCK NUT | (TURN HANDWHEEL CW TO EXPOSE ROD & INSTALL NUT FLUSH WITH END OF ROD.) | H-5239-12 |
| N. RETAINING SCREW | (TURN HANDWHEEL CCW UNTIL NUT HITS BRKT) | (SEE DWG) |
4. ADJUSTMENT
ON THE REAR ON THE MACHINE – LOCATE THE BOLT AND JAM NUT ON THE BOTTOM OF THE GUIDE ROD BRACKET. TURN THE BOLT OUT SO THAT IT IS 2-1/2 INCHES FROM THE TOP SURFACE OF THE TRIP BAR – TIGHTEN THE JAM NUT TO LOCK THE BOLT IN PLACE. (SEE DETAIL ABOVE)
5. ADJUST DRILLING DEPTH:
FOLLOW NORMAL PROCEDURE FOR NEW DRILL ADJUSTMENT.
- NOTE: WHEN USING TWO DRILL HEADS, DO NOT USE (6672) PAPER GUIDES. USE THE STANDARD SIDE GUIDE (P/N A-6565).

NOTES:

MAX. BACK MARGIN = 2-5/8" (67mm)

- 1. WHEN CHANGING DRILLS, REMOVE PRESSURE FOOT.
- 2. TWO DRILL HEADS ARE NOT RECOMMENDED FOR SINGLE PHASE MACHINES.
- 3. REQUIRED OF MACHINES PRIOR TO 10-1-89.

Main Assembly – Large Diameter Drill Head Field Conversion – Parts List
A-6500-7 Rev. B

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
28	A-6500-7 SHT 5	BLUEPRINT OF ASSEMBLY	1
1	H-5239-12	3/4-16 LT TH FLEX LOCK NUT	1
2	6670	LABEL	1
3	6672	PAPER GUIDE	2
4	H-6910-606	3/8-16 X 3/4 BUTT HD SCR	4
5	H-7324-12	3/8 SHAKEPROOF LOCKWASHER	4
6	6669	CUTTING BLOCK - PLASTIC	6
7	6667	TABLE ADAPTOR - FRONT	1
8	H-7322-#10	WASHER - #10 POLISHED FL	4
9	A-6594-7	LARGE DIA DRILL HD ASSY	1
10	H-6923- 102420	#10-24 X 1-1/4 LG RD HD SCR	2
11	H-6423-#10	#10-24 HEX NUT	6
12	H-7324-#10	#10 INT TOOTH LOCK WASHER	6
13	6639-1	COVER - FRONT	1
14	A-6538	CHUTE - CHIP	REF
15	S-887	3/8 X 90%%D CONN (NOT SHOWN)	1
16	S-1122-1	3/8 INS. SLEEVE AS -1 (NOT SHOWN)	2
17	H-7322-6	WASHER - 3/8 POLISHED FL	4
18	B-180	3 X 5 MAIL BAG (NOT SHOWN)	1
19	E-2196-11	KNOCK-OUT PLUG (NOT SHOWN)	1
20	6668	TABLE ADAPTER - REAR	1
21	W-134	WRENCH - 7/32 (NOT SHOWN)	1
22	4687	DRIFT (NOT SHOWN)	2
23	6642	SUPPORT - SHIELD (SEE NOTE #3)	REF
24	E-807	3/8" EX. FLEX CONDUIT (NOT SHOWN)	0.5
25	H-6405-1-616	3/8 X 2" NIPPLE, BLK EX HVY	2
26	H-6913-624	3/8-16 X 3" HEX HD SCR	2
27	H-6910- 102403	#10-24 X 3/8 BUTT HD SCR (QTY 3)	REF