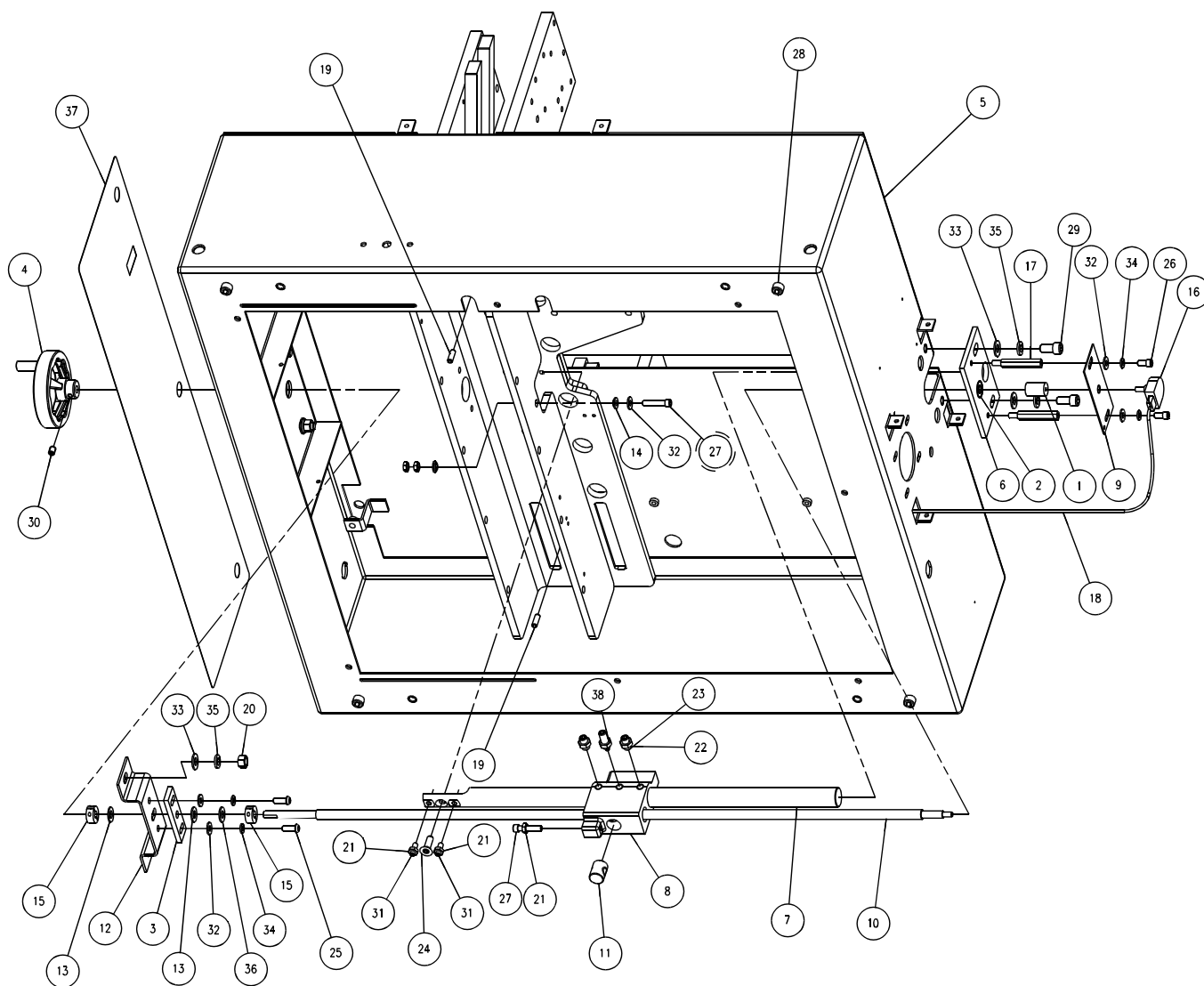


4.0 Parts Lists

4.1 Main Asm. – Backgauge Drive (Models: SA, 120/230V, 50/60 Hz)

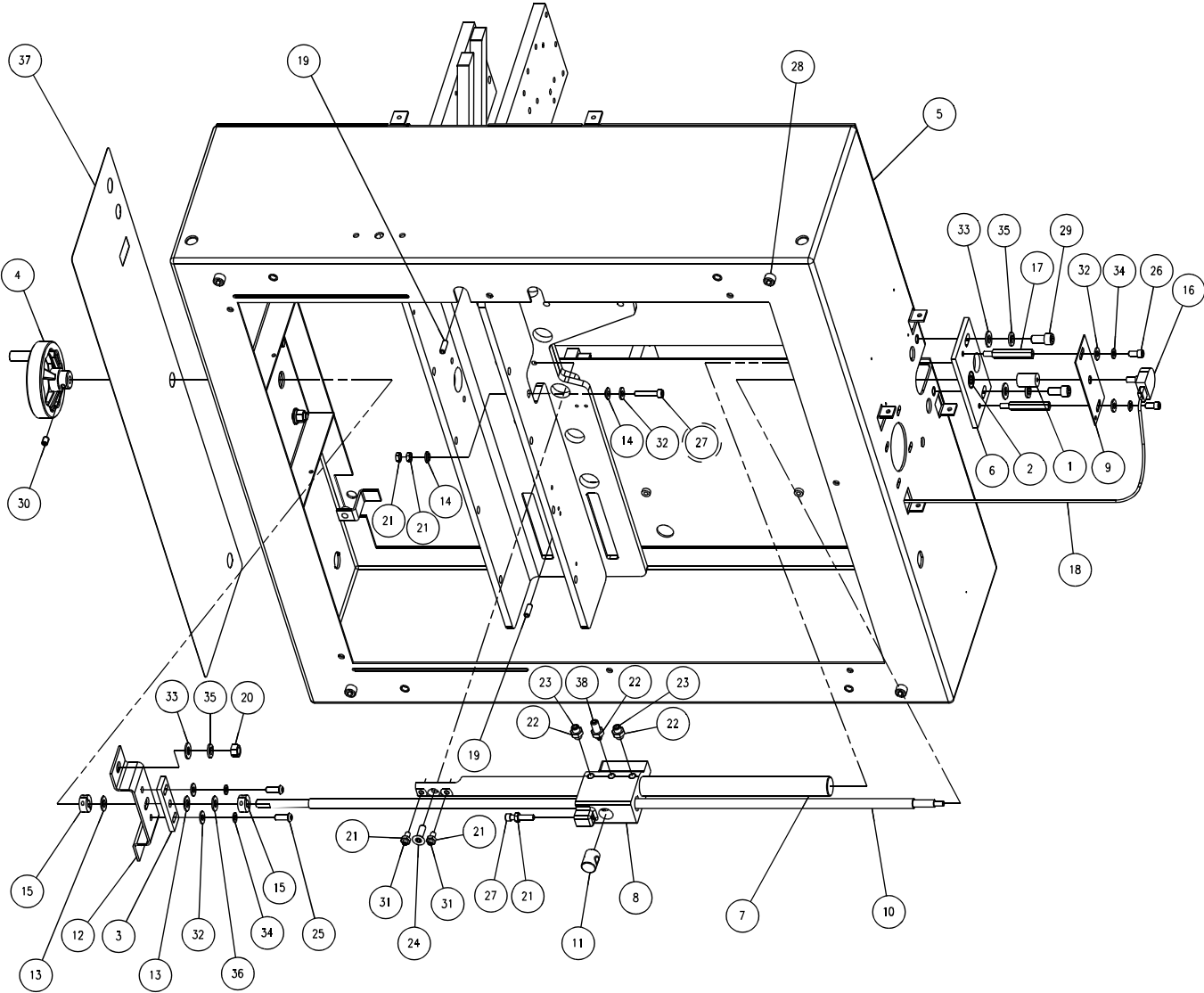
63000 Sheet 1



NO.	PART NO.	DESCRIPTION	QTY
1	47053	COUPLING	1
2	56552	BALL BEARING- 3/8 X .875	1
3	60115	ADJUSTABLE PILLOW BLOCK	1
4	63047	HAND WHEEL - 4 INCH	1
5	63100	BASE WELDMENT	1
6	63201	GUIDE ROD BRACKET- FRONT	1
7	63202	GUIDE SHAFT	1
8	63203	BACKGAUGE CARRIER	1
9	63208	ENCODER PLATE	1
10	63215	LEADSCREW- MANUAL BACKGAUGE	1
11	63216	LEADSCREW NUT- MANUAL BACKGAUGE	1
12	63219	PILLOW BLOCK BRACKET	1
13	11288-5	NYLON WASHER	2
14	47214-2	SHOULDER WASHER	2
15	A-10081-4	SPLIT COLLAR	2
16	E-2467	ENCODER	1
17	E-1152-104	STANDOFF	2
18	EE-2534-3	ENCODER CABLE	1
19	H-21S-250-0750	ROLL PIN - 1/4 X 3/4	2
20	H-6417-6	NUT - 3/8-16 HEX	2
21	H-6424-4	NUT - 1/4-20 HEX JAM	5
22	H-6424-6	NUT - 3/8-16 HEX JAM	3
23	H-6890-606	SCREW - 3/8-16 X 3/4 NYLON SOC SET	2
24	H-6909-508	SCREW - 5/16-18 X 1" FLAT HEAD CAP	1
25	H-6910-406	SCREW - 1/4-20 X 3/4 BUTTON HEAD CAP	2
26	H-6918-404	SCREW - 1/4-20 X 1/2 SOCKET HEAD CAP	2
27	H-6918-410	SCREW - 1/4-20 X 1-1/4 SOCKET HEAD CAP	2
28	H-6918-604	SCREW - 3/8-16 X 1/2 SOCKET HEAD CAP	4
29	H-6918-606	SCREW - 3/8-16 X 3/4 SOCKET HEAD CAP	2
30	H-6938-406	SCREW - 1/4-20 X 3/8 CUP SOC SET	1
31	H-6940-412	SCREW - 1/4-20 X 3/4 FLAT SOC SET	2
32	H-7321-4	WASHER - 1/4 SAE PLAIN	5
33	H-7321-6	WASHER - 3/8 SAE PLAIN	4
34	H-7327-8	WASHER - 1/4 MEDIUM LOCK	4
35	H-7327-12	WASHER - 3/8 MEDIUM LOCK	4
36	S-1681-3	WASHER- WAVE SPRING	1
37	S-1781-135	FRONT LABEL - 185 SA	1
38	S-2021-2	SPRING PLUNGER	1

4.2 Main Asm. – Backgauge Drive (Models: A, 120/230V, 50/60 Hz)

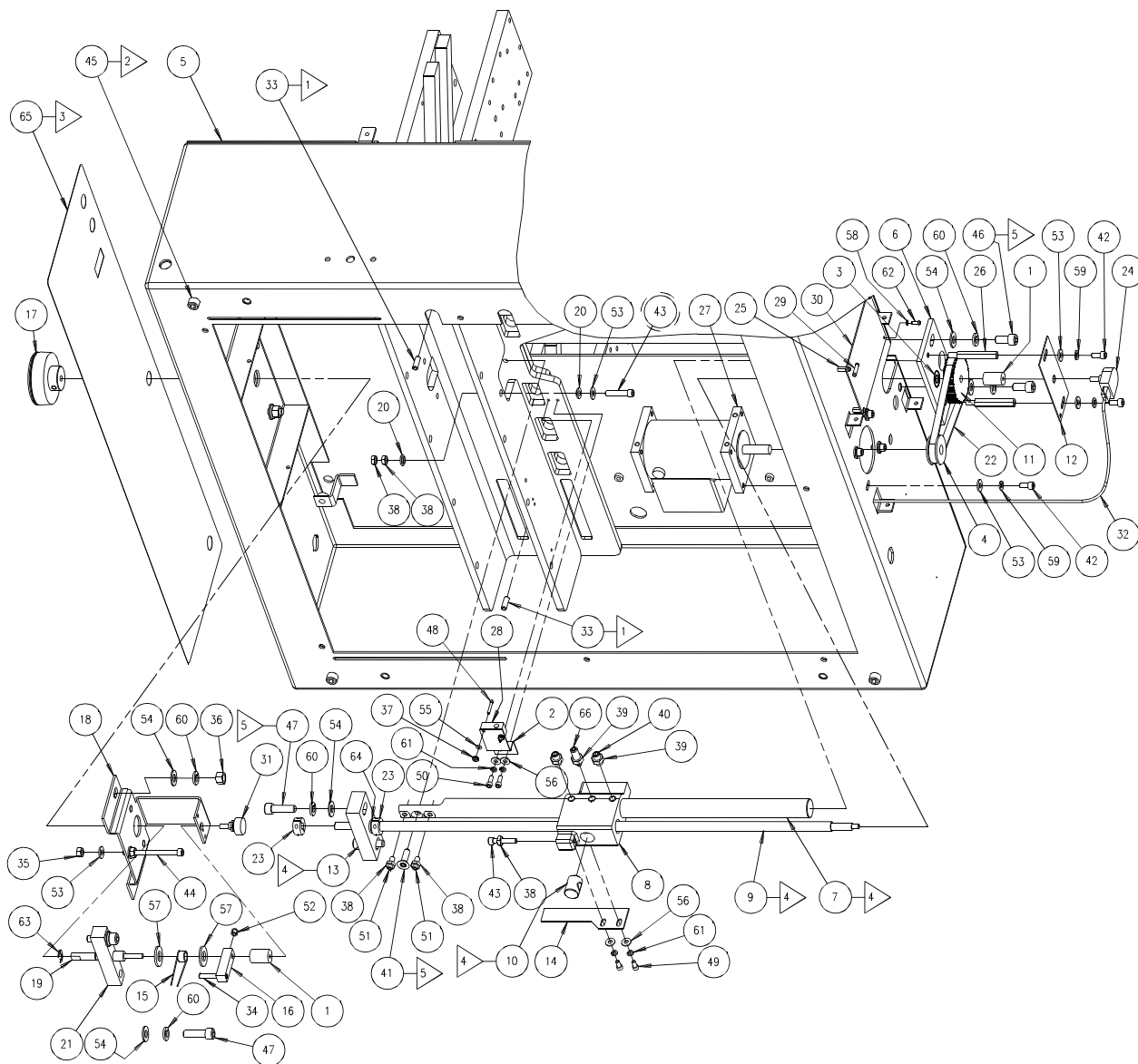
63000 Sheet 1



NO.	PART NO.	DESCRIPTION	QTY
1	47053	COUPLING	1
2	56552	BALL BEARING- 3/8 X .875	1
3	60115	ADJUSTABLE PILLOW BLOCK	1
4	63047	HAND WHEEL - 4 INCH	1
5	63100	BASE WELDMENT	1
6	63201	GUIDE ROD BRACKET- FRONT	1
7	63202	GUIDE SHAFT	1
8	63203	BACKGAUGE CARRIER	1
9	63208	ENCODER PLATE	1
10	63215	LEADSCREW- MANUAL BACKGAUGE	1
11	63216	LEADSCREW NUT- MANUAL BACKGAUGE	1
12	63219	PILLOW BLOCK BRACKET	1
13	11288-5	NYLON WASHER	2
14	47214-2	SHOULDER WASHER	2
15	A-10081-4	SPLIT COLLAR	2
16	E-2467	ENCODER	1
17	E-1152-104	STANDOFF	2
18	EE-2534-3	ENCODER CABLE	1
19	H-21S-250-0750	ROLL PIN - 1/4 X 3/4	2
20	H-6417-6	NUT - 3/8-16 HEX	2
21	H-6424-4	NUT - 1/4-20 HEX JAM	5
22	H-6424-6	NUT - 3/8-16 HEX JAM	3
23	H-6890-606	SCREW - 3/8-16 X 3/4 NYLON SOC SET	2
24	H-6909-508	SCREW - 5/16-18 X 1" FLAT HEAD CAP	1
25	H-6910-406	SCREW - 1/4-20 X 3/4 BUTTON HEAD CAP	2
26	H-6918-404	SCREW - 1/4-20 X 1/2 SOCKET HEAD CAP	2
27	H-6918-410	SCREW - 1/4-20 X 1-1/4 SOCKET HEAD CAP	2
28	H-6918-604	SCREW - 3/8-16 X 1/2 SOCKET HEAD CAP	4
29	H-6918-606	SCREW - 3/8-16 X 3/4 SOCKET HEAD CAP	2
30	H-6938-406	SCREW - 1/4-20 X 3/8 CUP SOC SET	1
31	H-6940-412	SCREW - 1/4-20 X 3/4 FLAT SOC SET	2
32	H-7321-4	WASHER - 1/4 SAE PLAIN	5
33	H-7321-6	WASHER - 3/8 SAE PLAIN	4
34	H-7327-8	WASHER - 1/4 MEDIUM LOCK	4
35	H-7327-12	WASHER - 3/8 MEDIUM LOCK	4
36	S-1681-3	WASHER- WAVE SPRING	1
37	S-1781-141	FRONT LABEL - 185A/AEP	1
38	S-2021-2	SPRING PLUNGER	1

4.3 Main Asm. – Backgauge Drive (Models: AEP, 120/230V, 50/60 Hz)

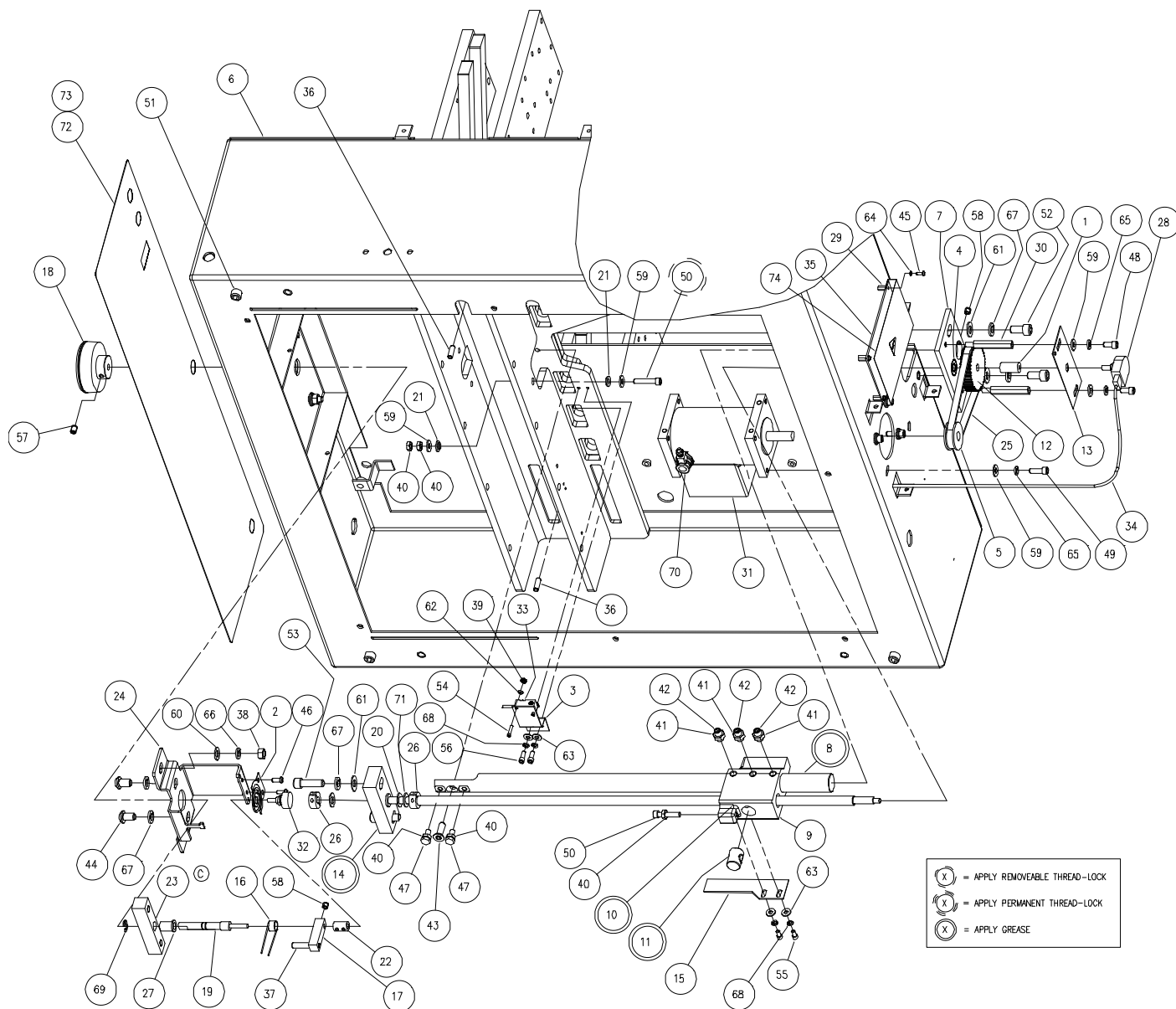
63000 Sheet 1
S/N 131411 and Below



NO.	PART NO.	DESCRIPTION	QTY
1	47053	COUPLING	2
2	56355	PROXIMITY BKT	1
3	56552	BALL BEARING- 3/8 X .875	1
4	56563	TIMING PULLEY- 20 GROOVE	1
5	63100	BASE WELDMENT	1
6	63201	GUIDE ROD BRACKET- FRONT	1
7	63202	GUIDE SHAFT	1
8	63203	BACKGAUGE CARRIER	1
9	63205	LEADSCREW - POWER BACKGAUGE	1
10	63206	LEADSCREW NUT - POWER BACKGAUGE	1
11	63207	TIMING PULLEY- 40 GROOVE, XL	1
12	63208	ENCODER PLATE	1
13	63211	FRONT PILLOW BLOCK ASSEMBLY	1
14	63212	PROXIMITY ACTUATOR- BACKGAUGE	1
15	63213	TORSION SPRING	1
16	63214	ACTUATOR	1
17	63218	KNOB	1
18	63220	PILLOW BLOCK BRACKET	1
19	63221	CONTROL KNOB SHAFT	1
20	47214-2	SHOULDER WASHER	2
21	63210-1	FRONT PILLOW BLOCK	1
22	A-11202	TIMING BELT- 160XL038	1
23	A-10081-4	SPLIT COLLAR	2
24	E-2467	ENCODER	1
25	E-1152-56	STANDOFF	4
26	E-1152-104	STANDOFF	2
27	E-1600-167	MOTOR- 1/15 HP, 90 VDC	1
28	E-2204-1	PROXIMITY SWITCH	1
29	E-2330-3	FUSE - METRIC, GLASS TUBE 2 AMP SLOW BLOW	1
30	EE-3151	P.C. BOARD - MOTOR CONTROL	1
31	EE-3167	POTENTIOMETER	1
32	EE-2534-3	ENCODER CABLE	1
33	H-21S-250-0750	ROLL PIN - 1/4 X 3/4	2
34	H-21S-250-1500	ROLL PIN - 1/4 X 1-1/2	1
35	H-6417-4	NUT - 1/4-20 HEX	2
36	H-6417-6	NUT - 3/8-16 HEX	2
37	H-6423-N4	NUT - #4-40 HEX KEP	2
38	H-6424-4	NUT - 1/4-20 HEX JAM	5
39	H-6424-6	NUT - 3/8-16 HEX JAM	3
40	H-6890-606	SCREW - 3/8-16 X 3/4 NYLON SOC SET	2
41	H-6909-508	SCREW - 5/16-18 X 1" FLAT HEAD CAP	1
42	H-6918-404	SCREW - 1/4-20 X 1/2 SOCKET HEAD CAP	6
43	H-6918-410	SCREW - 1/4-20 X 1-1/4 SOCKET HEAD CAP	2
44	H-6918-424	SCREW - 1/4-20 X 3 SOCKET HEAD CAP	1
45	H-6918-604	SCREW - 3/8-16 X 1/2 SOCKET HEAD CAP	4
46	H-6918-606	SCREW - 3/8-16 X 3/4 SOCKET HEAD CAP	2
47	H-6918-610	SCREW - 3/8-16 X 1-1/4 SOCKET HEAD CAP	4
48	H-6918-44006	SCREW - #4-40 X 3/4 SOCKET HEAD CAP	2
49	H-6918-102403	SCREW - #10-24 X 3/8 SOCKET HEAD CAP	2
50	H-6918-102404	SCREW - #10-24 X 1/2 SOCKET HEAD CAP	2
51	H-6940-412	SCREW - 1/4-20 X 3/4 FLAT SOC SET	2
52	H-6940-102404	SCREW - #10-24 X 1/4 FLAT SOC SET	1
53	H-7321-4	WASHER - 1/4 SAE PLAIN	9
54	H-7321-6	WASHER - 3/8 SAE PLAIN	8
55	H-7321-N4	WASHER - #4 SAE PLAIN	2
56	H-7321-N10	WASHER - #10 SAE PLAIN	4
57	H-7322-8	WASHER - 1/2 POLISHED	2
58	H-7324-N6	WASHER - #6 INT TOOTH	4
59	H-7327-8	WASHER - 1/4 MEDIUM LOCK	6
60	H-7327-12	WASHER - 3/8 MEDIUM LOCK	8
61	H-7327-N10	WASHER - #10 MEDIUM LOCK	4
62	H6910-6-3203	SCREW - #6-32 X 3/8 BUTTON HEAD CAP	4
63	S-1193-37	E-RING - 3/8"	1
64	S-1681-3	WASHER- WAVE SPRING	1
65	S-1781-141	FRONT LABEL - 185A/AEP	1
66	S-2021-2	SPRING PLUNGER	1
67	SU-30-107	GREASE- DAMPENING1200 VISCOSITY	1

4.4 Main Asm. – Backgauge Drive (Models: AEP, 120/230V, 50/60 Hz)

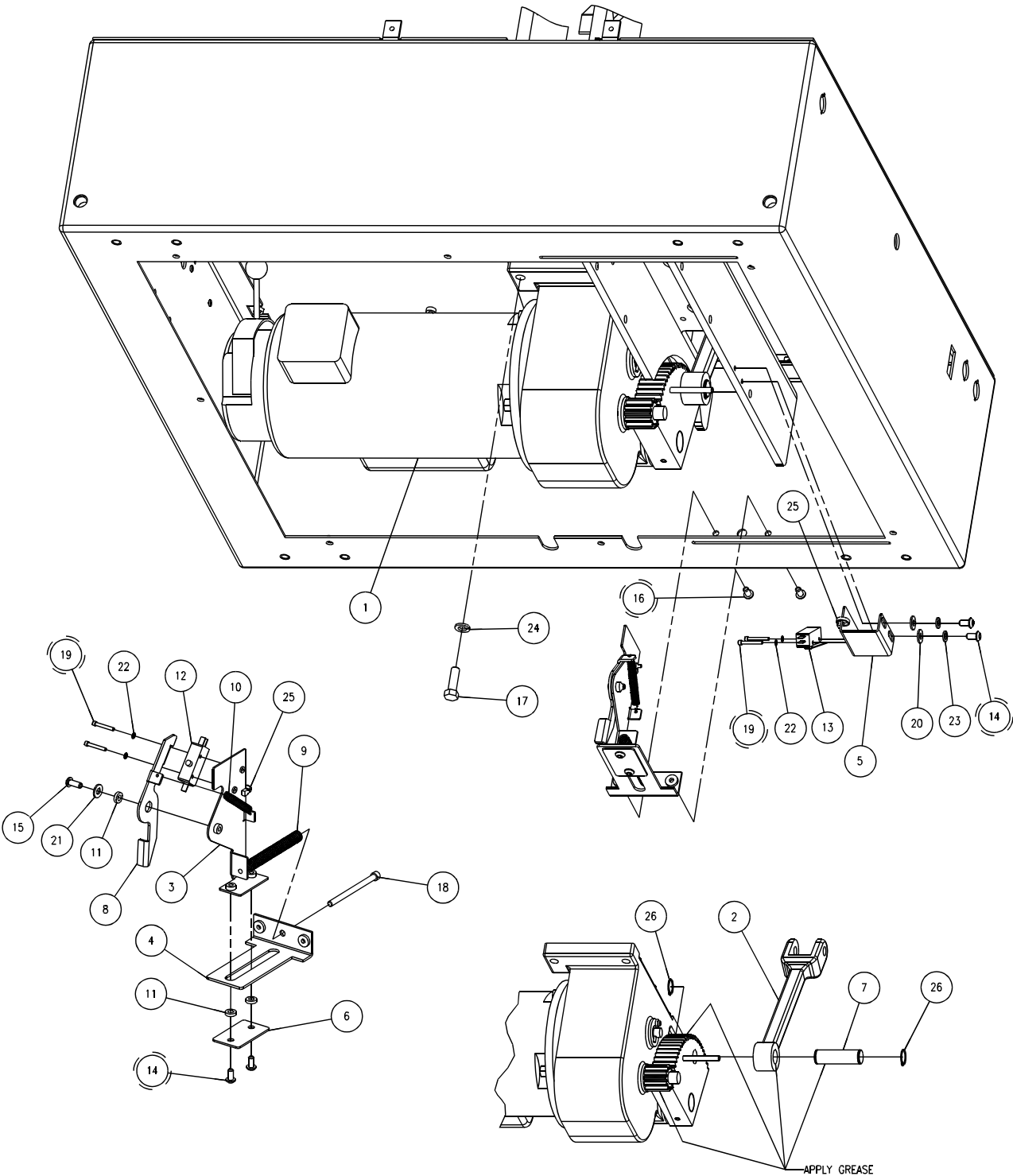
63000 Sheet 1
S/N 131412 and Above



NO.	PART NO.	DESCRIPTION	QTY
1	47053	COUPLING	1
2	49261	ENCODER MOUNTING BRACKET	1
3	56355	PROXIMITY BRACKET	1
4	56552	BALL BEARING- 3/8 X .875	1
5	56563	TIMING PULLEY- 20 GROOVE	1
6	63100	BASE WELDMENT	1
7	63201	GUIDE ROD BRACKET- FRONT	1
8	63202	GUIDE SHAFT	1
9	63203	BACKGAUGE CARRIER	1
10	63205	LEADSCREW - POWER BACKGAUGE	1
11	63206	LEADSCREW NUT	1
12	63207	TIMING PULLEY- 40 GROOVE, XL	1
13	63208	ENCODER PLATE	1
14	63211	FRONT PILLOW BLOCK ASSEMBLY	1
15	63212	PROXIMITY ACTUATOR- BACKGAUGE	1
16	63213	TORSION SPRING	1
17	63214	ACTUATOR	1
18	63218	KNOB	1
19	63221	CONTROL KNOB SHAFT	1
20	11288-5	WASHER/SPACER	2
21	47214-2	SHOULDER WASHER	2
22	56676-1	COUPLING	1
23	63210-3	FRONT PILLOW BLOCK	1
24	63220-1	PILLOW BLOCK BRACKET	1
25	A-11202	TIMING BELT- 160XL038	1
26	A-10081-4	COLLAR - CLAMP	2
27	A-10257-23	FLANGE BEARING	1
28	E-2467	ENCODER	1
29	E-1152-56	STANDOFF	4
30	E-1152-104	STANDOFF	2
31	E-1600-167	MOTOR- 1/15 HP, 90 VDC	1
32	EE-3167	POTENTIOMETER	1
33	EE-3169	PROX. ASM.	1
34	EE-2534-3	ENCODER CABLE	1
35	EE-3151-1	P.C. BOARD - MOTOR CONTROL	1
36	H-21S-250-0750	ROLL PIN - 1/4 X 3/4	2
37	H-21S-250-1500	ROLL PIN - 1/4 X 1-1/2	1
38	H-6417-5	NUT - 5/16-18 HEX	2
39	H-6423-#4	NUT - #4-40 HEX KEP	2
40	H-6424-4	NUT - 1/4-20 HEX JAM	5
41	H-6424-6	NUT - 3/8-16 HEX JAM	3
42	H-6890-606	SCREW - 3/8-16 X 3/4 NYLON SOC SET	3
43	H-6909-508	SCREW - 5/16-18 X 1" FLAT HEAD CAP	1
44	H-6910-605	SCREW - 3/8-16 X 5/8 BUTTON HEAD CAP	2
45	H-6910-63203	SCREW - #6-32 X 3/8 BUTTON HEAD CAP	4
46	H-6910-102404	SCREW - #10-24 X 1/2 BUTTON HEAD CAP	2
47	H-6913-405	SCREW - 1/4-20 X 5/8 HEX HEAD CAP	2
48	H-6918-404	SCREW - 1/4-20 X 1/2 SOCKET HEAD CAP	2
49	H-6918-406	SCREW - 1/4-20 X 3/4 SOCKET HEAD CAP	4
50	H-6918-410	SCREW - 1/4-20 X 1-1/4 SOCKET HEAD CAP	2
51	H-6918-604	SCREW - 3/8-16 X 1/2 SOCKET HEAD CAP	4
52	H-6918-606	SCREW - 3/8-16 X 3/4 SOCKET HEAD CAP	2
53	H-6918-610	SCREW - 3/8-16 X 1-1/4 SOCKET HEAD CAP	2
54	H-6918-44005	SCREW - #4-40 X 5/8 SOCKET HEAD CAP	2
55	H-6918-102403	SCREW - #10-24 X 3/8 SOCKET HEAD CAP	2
56	H-6918-102404	SCREW - #10-24 X 1/2 SOCKET HEAD CAP	2
57	H-6938-406	SCREW - 1/4-20 X 3/8 CUP SOC SET	1
58	H-6938-102404	SCREW - #10-24 X 1/4 CUP SOC SET	2
59	H-7321-4	WASHER - 1/4 SAE PLAIN	8
60	H-7321-5	WASHER - 5/16 SAE PLAIN	2
61	H-7321-6	WASHER - 3/8 SAE PLAIN	4
62	H-7321-#4	WASHER - #4 SAE PLAIN	2
63	H-7321-#10	WASHER - #10 SAE PLAIN	4
64	H-7324-#6	WASHER - #6 INT TOOTH	4
65	H-7327-8	WASHER - 1/4 MEDIUM LOCK	6
66	H-7327-10	WASHER - 5/16 MEDIUM LOCK	2
67	H-7327-12	WASHER - 3/8 MEDIUM LOCK	6
68	H-7327-#10	WASHER - #10 MEDIUM LOCK	4
69	S-1193-37	E-RING - 3/8"	1
70	S-1350-16	STRAIN RELIEF BUSHING	1
71	S-1681-3	WASHER - WAVE SPRING	1
72	S-1781-141	FRONT LABEL - 185A/AEP CMC	1
73			
74	S-1781-190	LABEL - SHOCK WARNING	1

4.5 Main Asm. – Knife Drive (All Models)

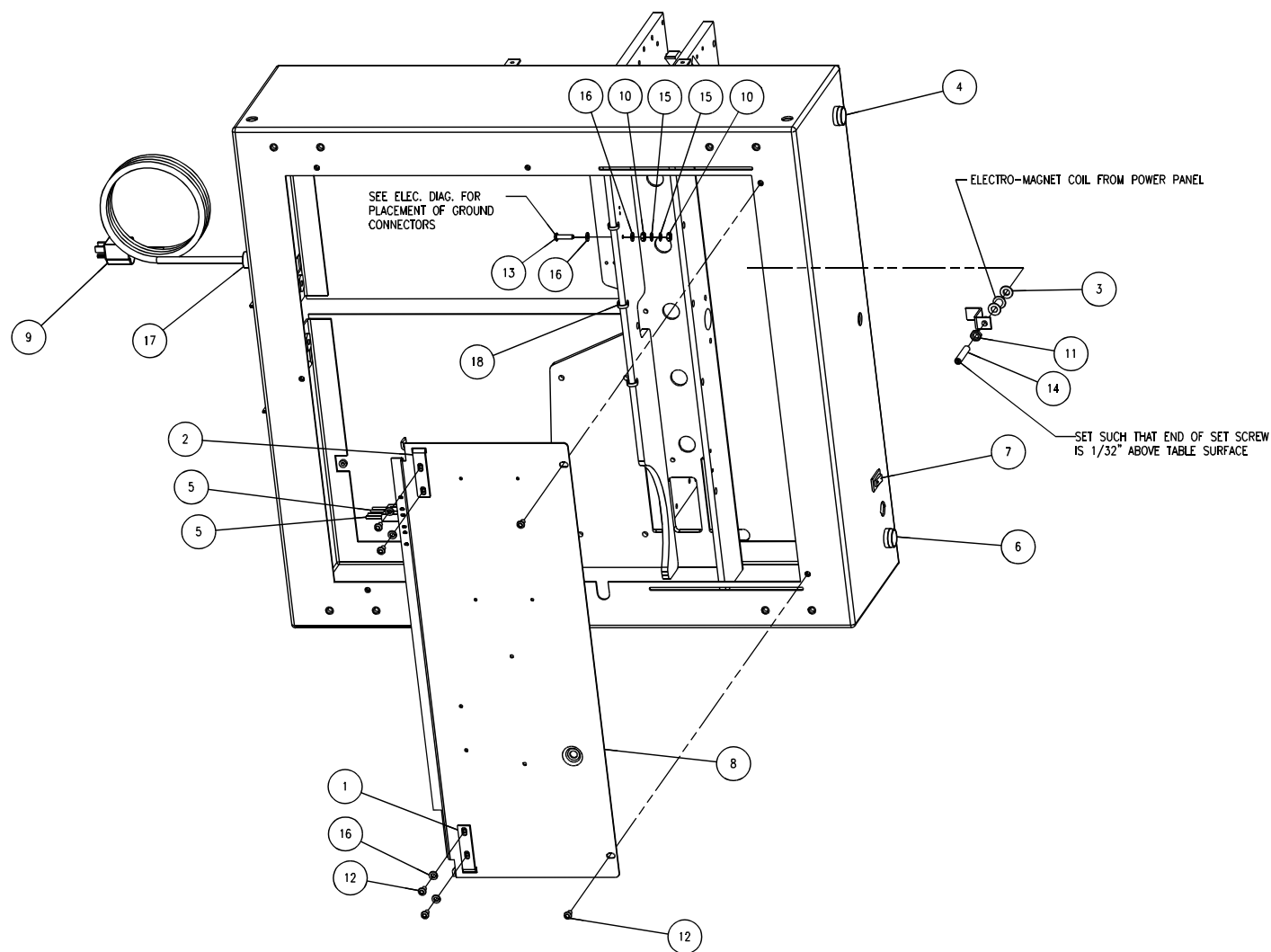
63000 Sheet 2



NO.	PART NO.	DESCRIPTION	QTY
1	63002	GEARBOX ASSEMBLY	1
2	63018	PULL-DOWN LINK	1
3	63062	LOWER LIMIT SWITCH BRACKET	1
4	63063	SWITCH ADJUSTMENT BRACKET	1
5	63064	UPPER LIMIT SWITCH BRACKET	1
6	63066	SLIDER BRACKET	1
7	63067	PIN - LOWER PULL DOWN	1
8	63086	ACTUATOR	1
9	35048-22	SPRING	1
10	47136-11	SPRING	1
11	E-1152-107	STANDOFF	3
12	E-3112-1	MICROSWITCH	1
13	E-3112-2	MICROSWITCH	1
14	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	4
15	H-6910-405	SCREW - 1/4-20 X 5/8 BUTTON HEAD CAP	1
16	H-6910-404SS	SCREW - 1/4-20 X 1/2 BUT. HEAD CAP STAINLESS	2
17	H-6913-610	SCREW - 3/8-16 X 1-1/4 HEX HEAD CAP	4
18	H-6918-428	SCREW - 1/4-20 X 3-1/2 SOCKET HEAD CAP	1
19	H-6918-63208	SCREW - #6-32 X 1 SOCKET HEAD CAP	4
20	H-7321-4	WASHER - 1/4 SAE PLAIN	2
21	H-7322-4	WASHER - 1/4 POLISHED	1
22	H-7324-N6	WASHER - #6 INT TOOTH	4
23	H-7327-8	WASHER - 1/4 MEDIUM LOCK	2
24	H-7327-12	WASHER - 3/8 MEDIUM LOCK	4
25	S-1694	TYRAP	2
26	S-1073-75	RETAINING RING	2

4.6 Main Asm. – Bottom Side Electrical (Models: SA, 120V, 60 Hz)

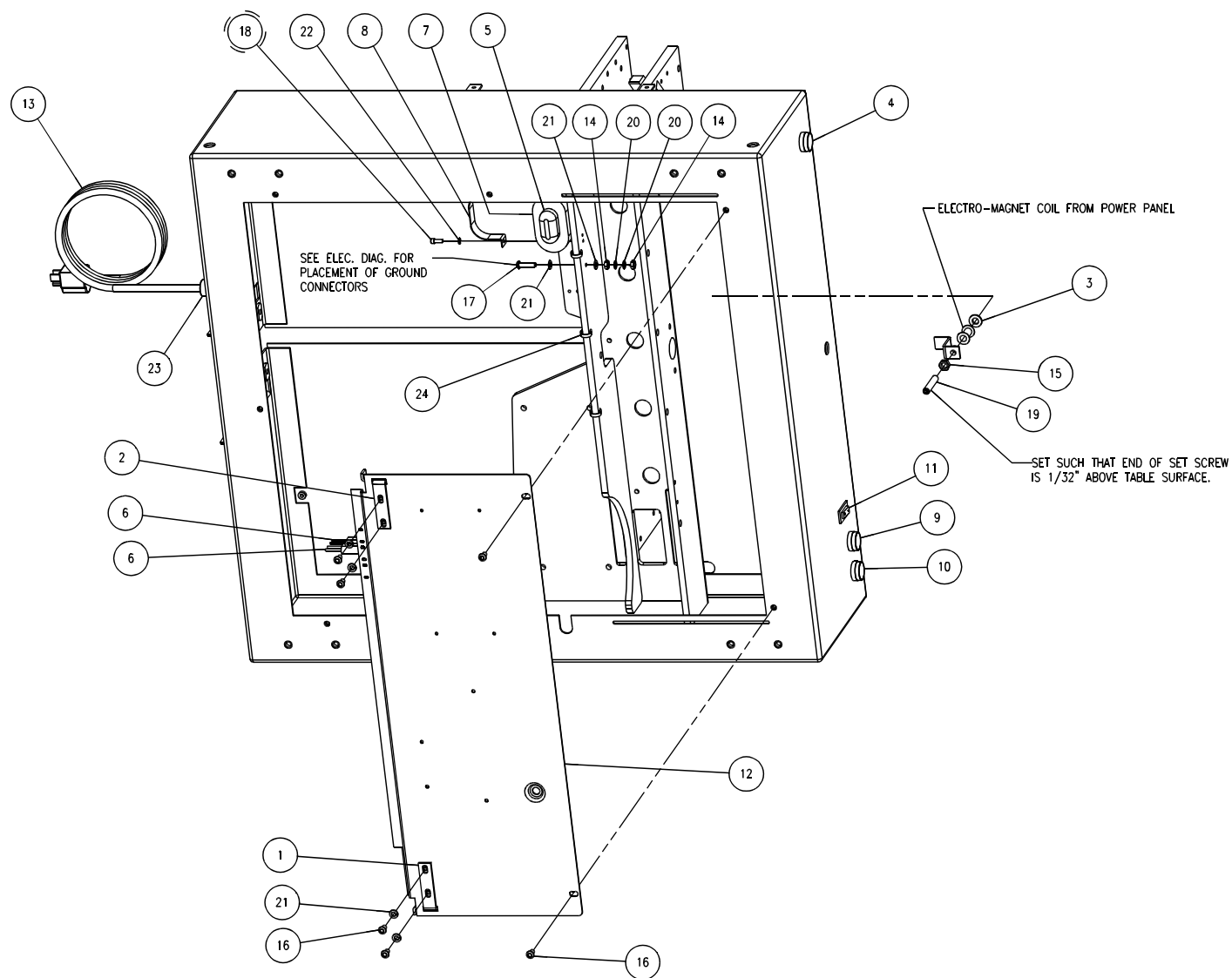
63000 Sheet 3



NO.	PART NO.	DESCRIPTION	QTY
1	63084	SLIDER BRACKET - RH	1
2	63085	SLIDER BRACKET - LH	1
3	47214-1	SHOULDER WASHER	1
4	E-3073	PUSHBUTTON SWITCH	1
5	E-1736-2	QUENCHARC	2
6	E-3073-3	PUSHBUTTON SWITCH	1
7	E-3074-6	CIRCUIT BREAKER AND ON/OFF SWITCH, 30A	1
8	EE-3154	ELEC. PANEL - 185 SA - 120V - 60HZ	1
9	EE-3163	POWER CORD - 120V	1
10	H-6424-4	NUT - 1/4-20 HEX JAM	2
11	H-6424-6	NUT - 3/8-16 HEX JAM	1
12	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	6
13	H-6910-408	SCREW - 1/4-20 X 1 BUTTON HEAD CAP	1
14	H-6940-632	SCREW - 3/8-16 X 2 FLAT SOC SET	1
15	H-7324-8	WASHER - 1/4 INT TOOTH	2
16	H-7327-8	WASHER - 1/4 MEDIUM LOCK	6
17	S-1350-16	STRAIN RELIEF BUSHING	1
18	S-1694-1	TYRAP	4

4.7 Main Asm. – Bottom Side Electrical (Models: A/AEP, 120V, 60 Hz)

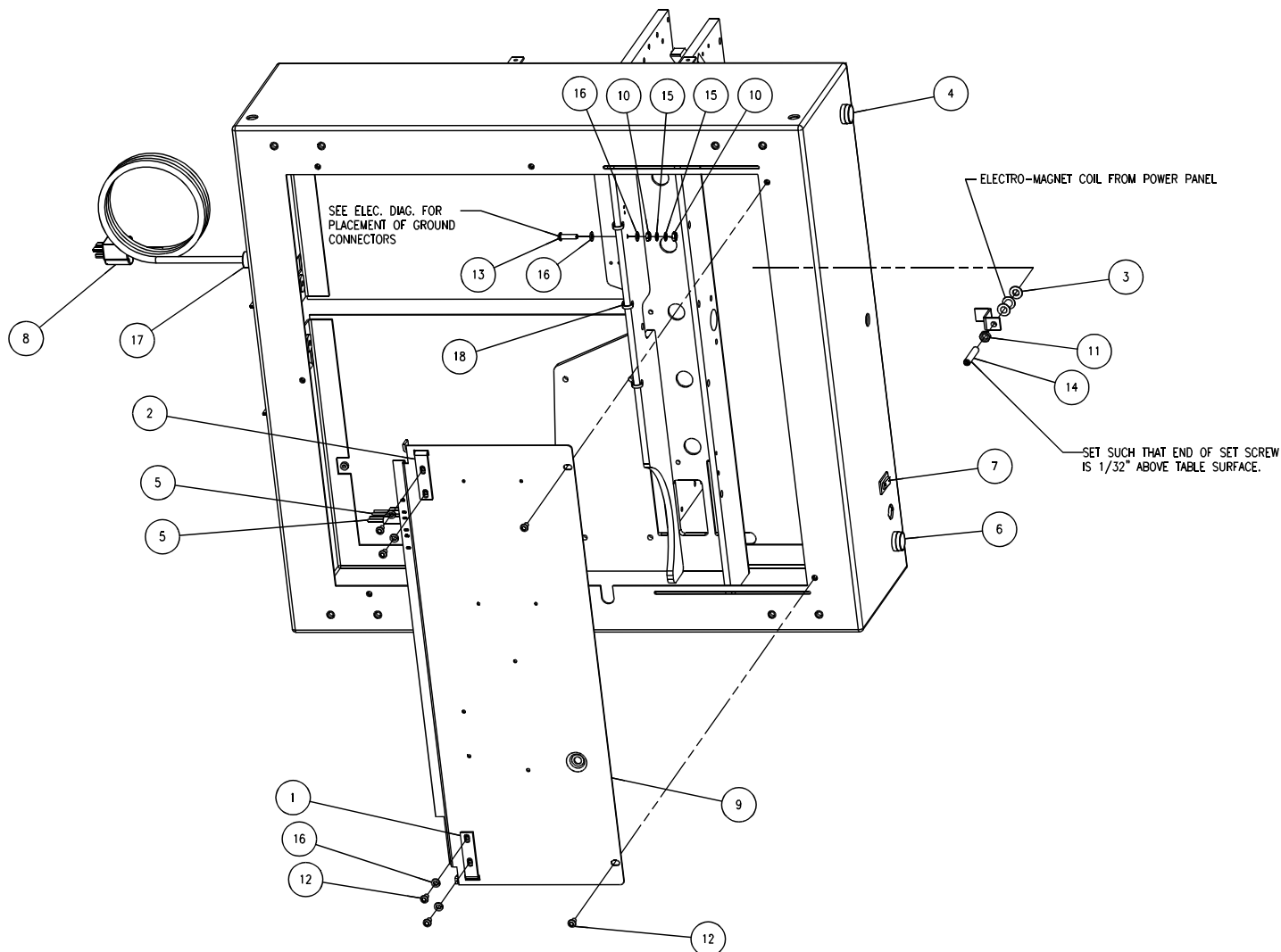
63000 Sheet 3



NO.	PART NO.	DESCRIPTION	QTY
1	63084	SLIDER BRACKET - RH	1
2	63085	SLIDER BRACKET - LH	1
3	47214-1	SHOULDER WASHER	1
4	E-3073	PUSHBUTTON SWITCH	1
5	E-3117	BOOT - RUBBER, MOTOR CAPACITOR	1
6	E-1736-2	QUENCHARC	2
7	E-2416-5	CAPACITOR - 80 MFD	1
8	E-2709-3	BRACKET - CAPACITOR	1
9	E-3073-1	PUSHBUTTON SWITCH	1
10	E-3073-3	PUSHBUTTON SWITCH	1
11	E-3074-6	CIRCUIT BREAKER AND ON/OFF SWITCH, 30A	1
12	EE-3133-2	ELECTRICAL PANEL	1
13	EE-3163	POWER CORD - 120V	1
14	H-6424-4	NUT - 1/4-20 HEX JAM	2
15	H-6424-6	NUT - 3/8-16 HEX JAM	1
16	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	6
17	H-6910-408	SCREW - 1/4-20 X 1 BUTTON HEAD CAP	1
18	H-6918-102404	SCREW - #10-24 X 1/2 SOCKET HEAD CAP	2
19	H-6940-632	SCREW - 3/8-16 X 2 FLAT SOC SET	1
20	H-7324-8	WASHER - 1/4 INT TOOTH	2
21	H-7327-8	WASHER - 1/4 MEDIUM LOCK	6
22	H-7327-N10	WASHER - #10 MEDIUM LOCK	2
23	S-1350-16	STRAIN RELIEF BUSHING	1
24	S-1694-1	TYRAP	4

4.8 Main Asm. – Bottom Side Electrical (Models: SA, 230V, 60 Hz)

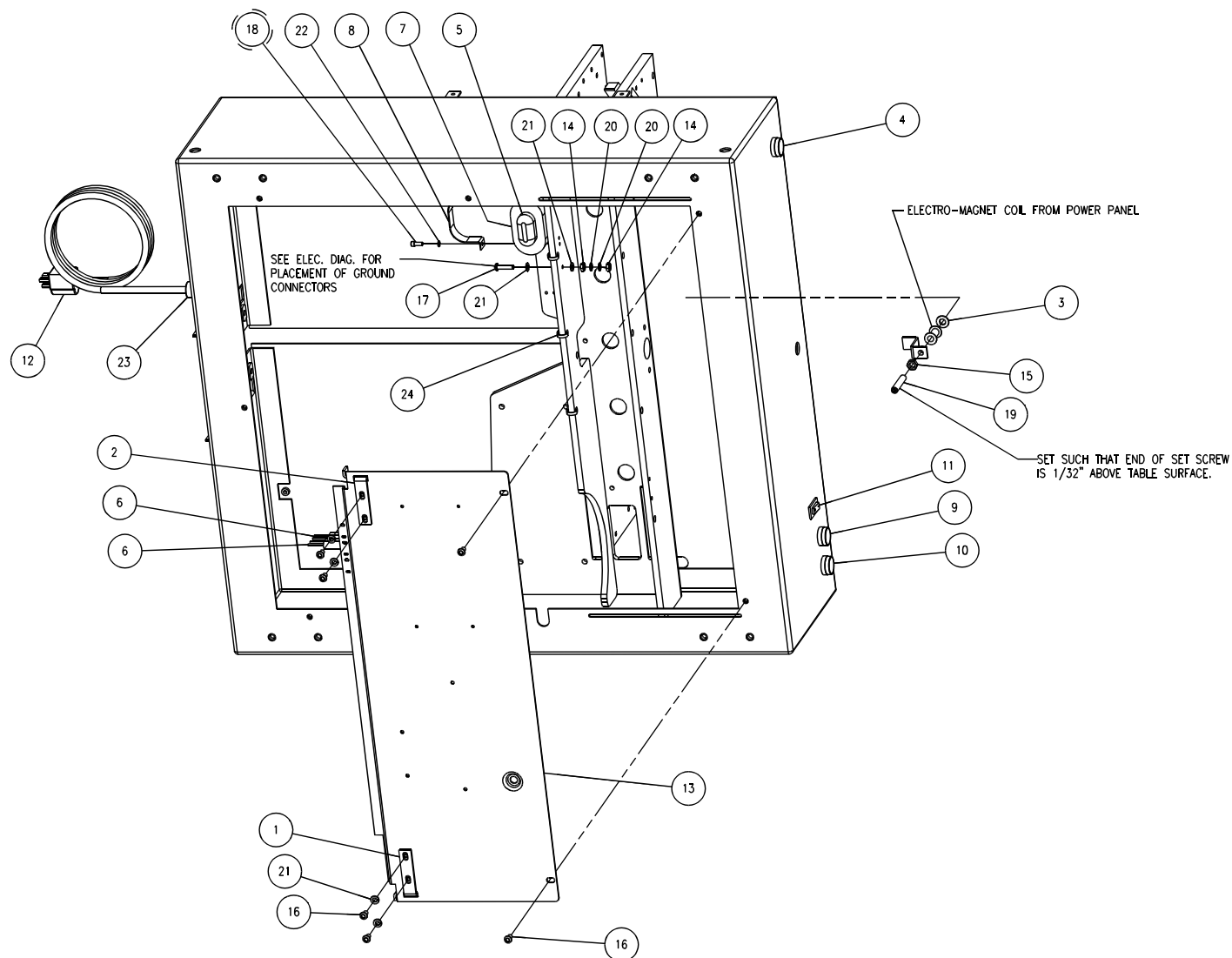
63000 Sheet 3



NO.	PART NO.	DESCRIPTION	QTY
1	63084	SLIDER BRACKET - RH	1
2	63085	SLIDER BRACKET - LH	1
3	47214-1	SHOULDER WASHER	1
4	E-3073	PUSHBUTTON SWITCH	1
5	E-1736-2	QUENCHARC	2
6	E-3073-3	PUSHBUTTON SWITCH	1
7	E-3074-1	CIRCUIT BREAKER AND ON/OFF SWITCH, 15A	1
8	EE-2778	POWER CORD – 230V 60HZ	1
9	EE-3154-1	ELEC. PANEL - 185 SA - 230V - 50/60	1
10	H-6424-4	NUT - 1/4-20 HEX JAM	2
11	H-6424-6	NUT - 3/8-16 HEX JAM	1
12	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	6
13	H-6910-408	SCREW - 1/4-20 X 1 BUTTON HEAD CAP	1
14	H-6940-632	SCREW - 3/8-16 X 2 FLAT SOC SET	1
15	H-7324-8	WASHER - 1/4 INT TOOTH	2
16	H-7327-8	WASHER - 1/4 MEDIUM LOCK	6
17	S-1350-16	STRAIN RELIEF BUSHING	1
18	S-1694-1	TYRAP	4

4.9 Main Asm. – Bottom Side Electrical (Models: A/AEP, 230V, 60 Hz)

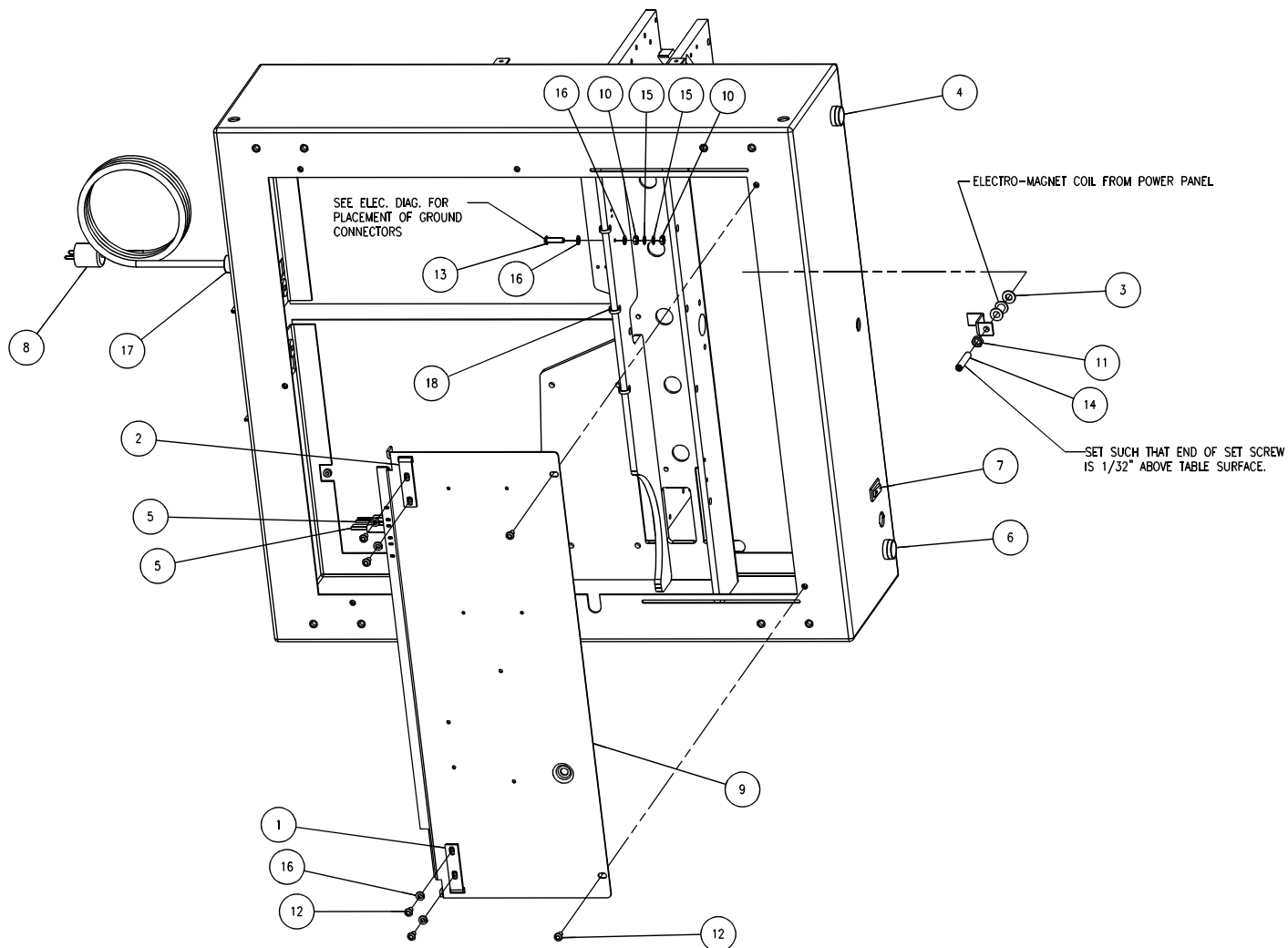
63000 Sheet 3



NO.	PART NO.	DESCRIPTION	QTY
1	63084	SLIDER BRACKET - RH	1
2	63085	SLIDER BRACKET - LH	1
3	47214-1	SHOULDER WASHER	1
4	E-3073	PUSHBUTTON SWITCH	1
5	E-3117	BOOT - RUBBER, MOTOR CAPACITOR	1
6	E-1736-2	QUENCHARC	2
7	E-2416-5	CAPACITOR - 80 MFD	1
8	E-2709-3	BRACKET - CAPACITOR	1
9	E-3073-1	PUSHBUTTON SWITCH	1
10	E-3073-3	PUSHBUTTON SWITCH	1
11	E-3074-1	CIRCUIT BREAKER AND ON/OFF SWITCH, 15A	1
12	EE-2778	POWER CORD – 230V 60HZ	1
13	EE-3133-1	ELEC. PANEL - 185 A/AEP - 230V - 50/60	1
14	H-6424-4	NUT - 1/4-20 HEX JAM	2
15	H-6424-6	NUT - 3/8-16 HEX JAM	1
16	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	6
17	H-6910-408	SCREW - 1/4-20 X 1 BUTTON HEAD CAP	1
18	H-6918-102404	SCREW - #10-24 X 1/2 SOCKET HEAD CAP	2
19	H-6940-632	SCREW - 3/8-16 X 2 FLAT SOC SET	1
20	H-7324-8	WASHER - 1/4 INT TOOTH	2
21	H-7327-8	WASHER - 1/4 MEDIUM LOCK	6
22	H-7327-N10	WASHER - #10 MEDIUM LOCK	2
23	S-1350-16	STRAIN RELIEF BUSHING	1
24	S-1694-1	TYRAP	4

4.10 Main Asm. – Bottom Side Electrical (Models: SA, 230V, 50 Hz)

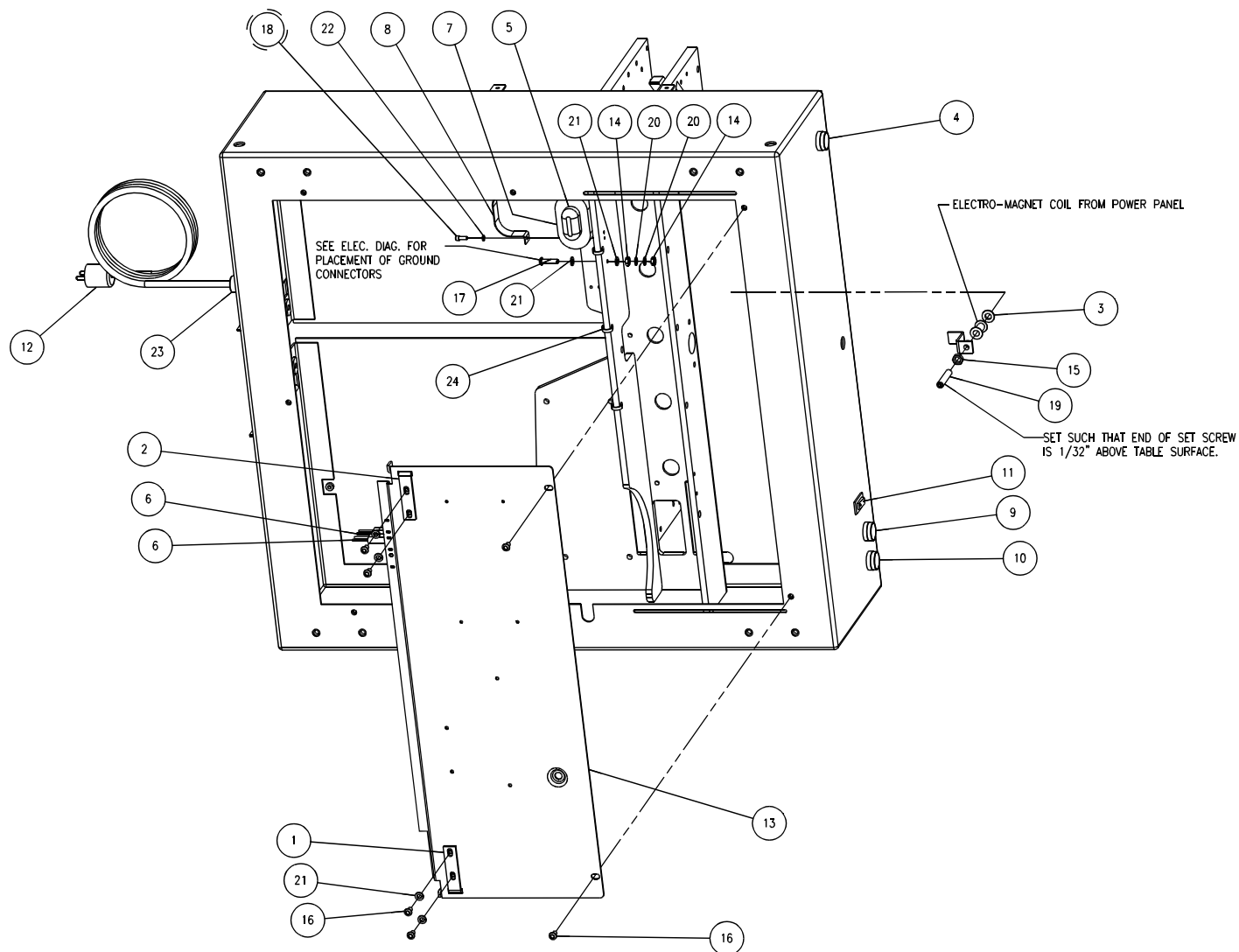
63000 Sheet 3



NO.	PART NO.	DESCRIPTION	QTY
1	63084	SLIDER BRACKET - RH	1
2	63085	SLIDER BRACKET - LH	1
3	47214-1	SHOULDER WASHER	1
4	E-3073	PUSHBUTTON SWITCH	1
5	E-1736-2	QUENCHARC	2
6	E-3073-3	PUSHBUTTON SWITCH	1
7	E-3074-1	CIRCUIT BREAKER AND ON/OFF SWITCH, 15A	1
8	EE-2778-1	POWER CORD - 230V EURO	1
9	EE-3154-1	ELEC. PANEL - 185 SA - 230V - 50/60	1
10	H-6424-4	NUT - 1/4-20 HEX JAM	2
11	H-6424-6	NUT - 3/8-16 HEX JAM	1
12	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	6
13	H-6910-408	SCREW - 1/4-20 X 1 BUTTON HEAD CAP	1
14	H-6940-632	SCREW - 3/8-16 X 2 FLAT SOC SET	1
15	H-7324-8	WASHER - 1/4 INT TOOTH	2
16	H-7327-8	WASHER - 1/4 MEDIUM LOCK	6
17	S-1350-16	STRAIN RELIEF BUSHING	1
18	S-1694-1	TYRAP	4

4.11 Main Asm. – Bottom Side Electrical (Models: A/AEP, 230V, 50 Hz)

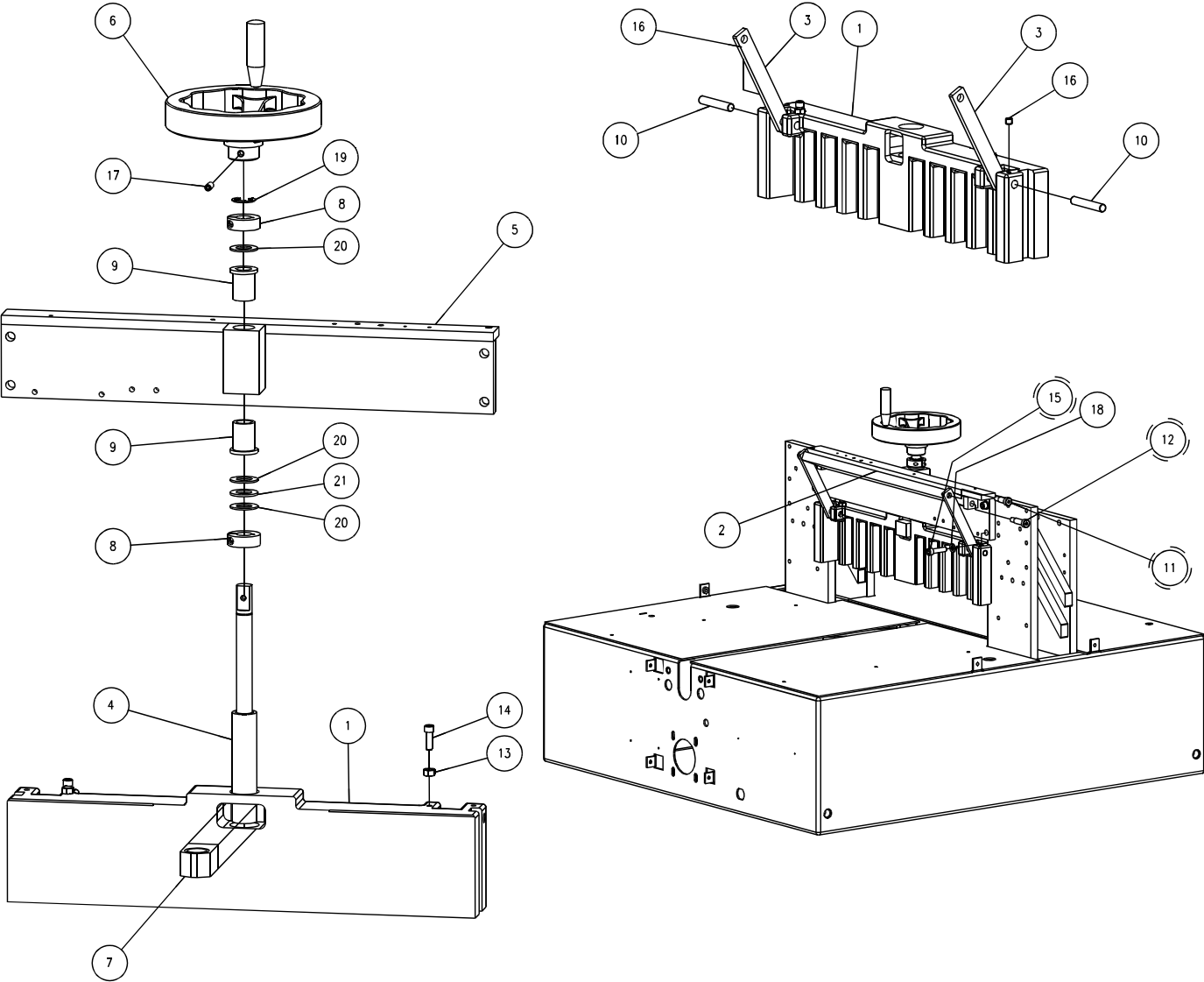
63000 Sheet 3



NO.	PART NO.	DESCRIPTION	QTY
1	63084	SLIDER BRACKET - RH	1
2	63085	SLIDER BRACKET - LH	1
3	47214-1	SHOULDER WASHER	1
4	E-3073	PUSHBUTTON SWITCH	1
5	E-3117	BOOT - RUBBER, MOTOR CAPACITOR	1
6	E-1736-2	QUENCHARC	2
7	E-2416-5	CAPACITOR - 80 MFD	1
8	E-2709-3	BRACKET - CAPACITOR	1
9	E-3073-1	PUSHBUTTON SWITCH	1
10	E-3073-3	PUSHBUTTON SWITCH	1
11	E-3074-1	CIRCUIT BREAKER AND ON/OFF SWITCH, 15A	1
12	EE-2778-1	POWER CORD - 230V EURO	1
13	EE-3133-1	ELEC. PANEL - 185 A/AEP - 230V - 50/60	1
14	H-6424-4	NUT - 1/4-20 HEX JAM	2
15	H-6424-6	NUT - 3/8-16 HEX JAM	1
16	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	6
17	H-6910-408	SCREW - 1/4-20 X 1 BUTTON HEAD CAP	1
18	H-6918-102404	SCREW - #10-24 X 1/2 SOCKET HEAD CAP	2
19	H-6940-632	SCREW - 3/8-16 X 2 FLAT SOC SET	1
20	H-7324-8	WASHER - 1/4 INT TOOTH	2
21	H-7327-8	WASHER - 1/4 MEDIUM LOCK	6
22	H-7327-N10	WASHER - #10 MEDIUM LOCK	2
23	S-1350-16	STRAIN RELIEF BUSHING	1
24	S-1694-1	TYRAP	4

4.12 Main Asm. – Clamp (Models: SA, 120/230V, 50/60 Hz)

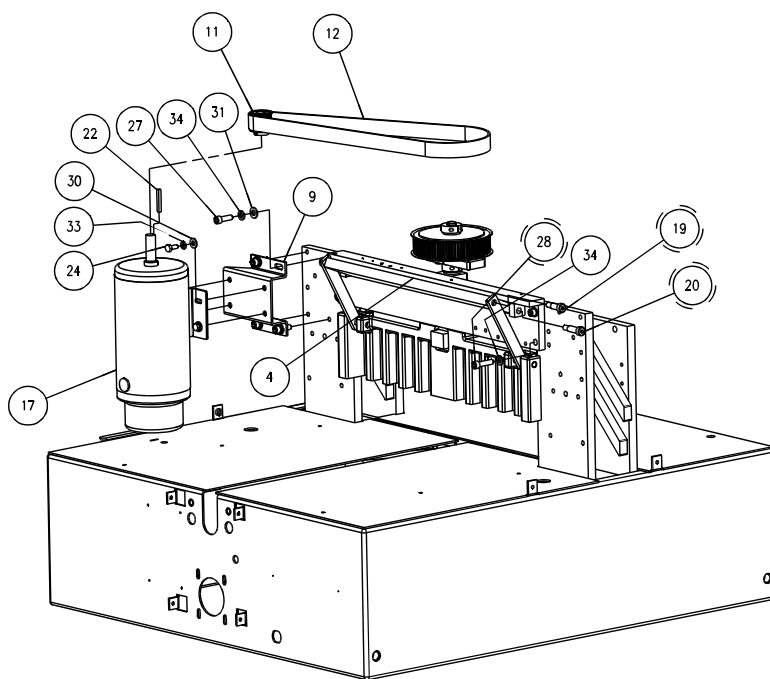
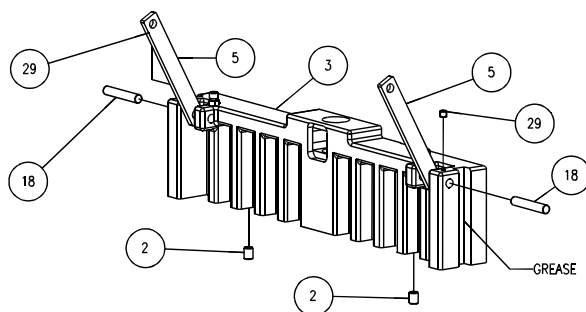
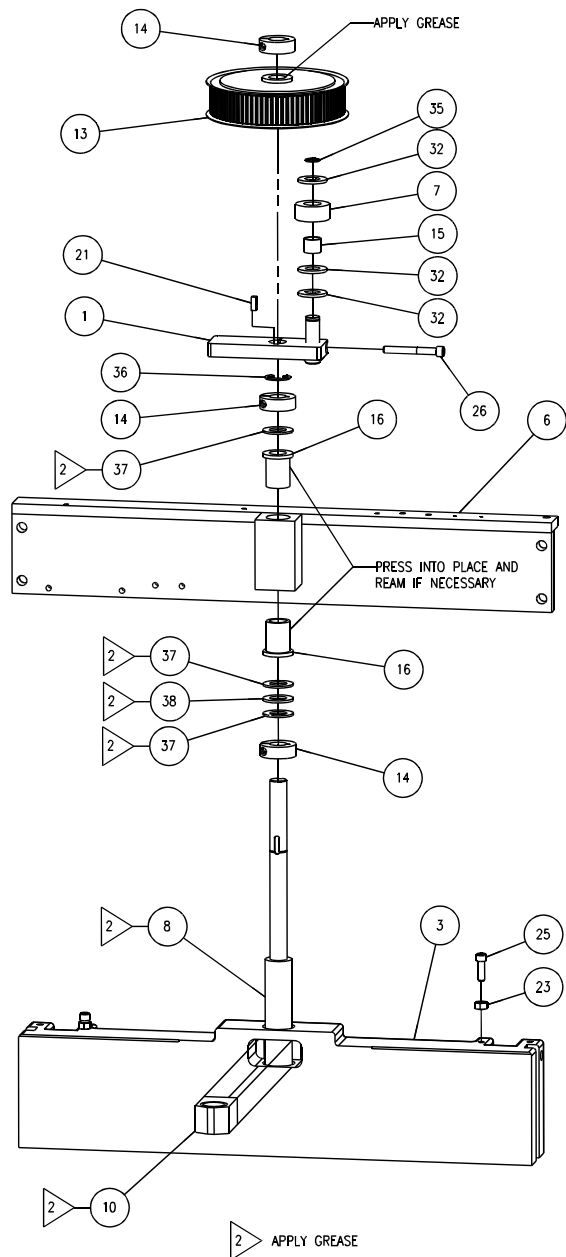
63000 Sheet 4



NO.	PART NO.	DESCRIPTION	QTY
1	63019	CLAMP	1
2	63021	TORSION BAR	1
3	63022	TORSION LINK	2
4	63023	CLAMP LEADSCREW	1
5	63024	ARCH WELDMENT	1
6	63045	HAND WHEEL - 6 INCH	1
7	63029-2	NUT - LEADSCREW, 1-1/4" WIDE X 2" LONG	1
8	A-10081-7	SPLIT COLLAR	2
9	A-10257-19	FLANGE BEARING	2
10	H-5246-618	DOWEL PIN - 3/8 X 2-1/4 HD GD	2
11	H-5254-606	SCREW - 3/8 X 3/4 SHSS	2
12	H-5254-610	SCREW - 3/8 X 1-1/4 SHSS	2
13	H-6417-4	NUT - 1/4-20 HEX	2
14	H-6918-406	SCREW - 1/4-20 X 3/4 SOCKET HEAD CAP	2
15	H-6918-510	SCREW - 5/16-18 X 1-1/4 SOCKET HEAD CAP	4
16	H-6938-404	SCREW - 1/4-20 X 1/4 CUP SOC SET	2
17	H-6947-406	SCREW - 1/4-20 X 3/4 FULL DOG POINT SOC SET	1
18	H-7327-10	WASHER - 5/16 MEDIUM LOCK	4
19	S-1193-62	E-RING - 5/8"	1
20	S-1295-8	THRUST WASHER	3
21	S-1300-4	THRUST BEARING	1

4.13 Main Asm. – Clamp (Models: A/AEP, 120/230V, 60 Hz)

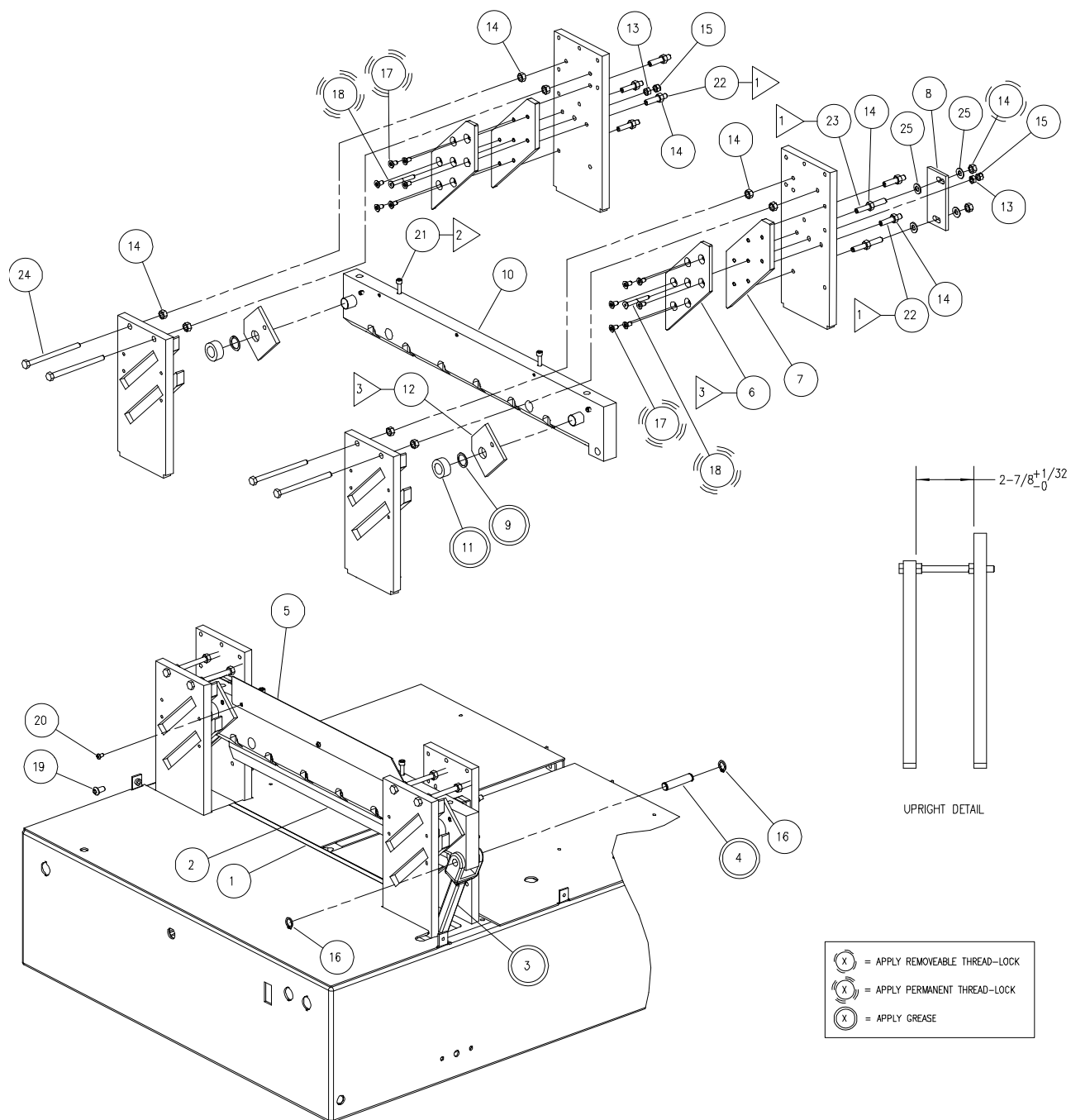
63000 Sheet 4



NO.	PART NO.	DESCRIPTION	QTY
1	60041	ACTUATOR WELDMENT	1
2	60053	MAGNET - RARE EARTH	2
3	63019	CLAMP	1
4	63021	TORSION BAR	1
5	63022	TORSION LINK	2
6	63024	ARCH WELDMENT	1
7	63037	BUMPER	1
8	63075	CLAMP LEADSCREW	1
9	63076	MOTOR BRACKET	1
10	63029-2	NUT - CLAMP LEADSCREW, 185A	1
11	63038-2	MOTOR PULLEY - 5MM GT2, 25MM X 22 GROOVE	1
12	63078-1	TIMING BELT - 5MM GT2, 25MM X 195T	1
13	63081-1	CLAMP PULLEY ASSEMBLY - 80 GROOVE	1
14	A-10081-7	SPLIT COLLAR	3
15	A-10172-27	BEARING - SLEEVE	1
16	A-10257-19	FLANGE BEARING	2
17	E-1600-39	1/2 HP 115/230 50/60 MOTOR	1
18	H-5246-618	DOWEL PIN - 3/8 X 2-1/4 HD GD	2
19	H-5254-606	SCREW - 3/8 X 3/4 SHSS	2
20	H-5254-610	SCREW - 3/8 X 1-1/4 SHSS	2
21	H-6123-30304	MACHINE KEY - .188 X .188 X .500	1
22	H-6123-30312	MACHINE KEY - .188 X .188 X 1.500	1
23	H-6417-4	NUT - 1/4-20 HEX	2
24	H-6913-405	SCREW - 1/4-20 X 5/8 HEX HEAD CAP	4
25	H-6918-406	SCREW - 1/4-20 X 3/4 SOCKET HEAD CAP	2
26	H-6918-416	SCREW - 1/4-20 X 2 SOCKET HEAD CAP	1
27	H-6918-508	SCREW - 5/16-18 X 1 SOCKET HEAD CAP	4
28	H-6918-510	SCREW - 5/16-18 X 1-1/4 SOCKET HEAD CAP	4
29	H-6938-404	SCREW - 1/4-20 X 1/4 CUP SOC SET	2
30	H-7321-4	WASHER - 1/4 SAE PLAIN	4
31	H-7321-5	WASHER - 5/16 SAE PLAIN	4
32	H-7322-8	WASHER - 1/2 POLISHED	3
33	H-7327-8	WASHER - 1/4 MEDIUM LOCK	4
34	H-7327-10	WASHER - 5/16 MEDIUM LOCK	8
35	S-1073-50	RETAINING RING	1
36	S-1193-62	E-RING - 5/8"	1
37	S-1295-8	THRUST WASHER	3
38	S-1300-4	THRUST BEARING	1

4.14 Main Asm. – Knife (All Models)

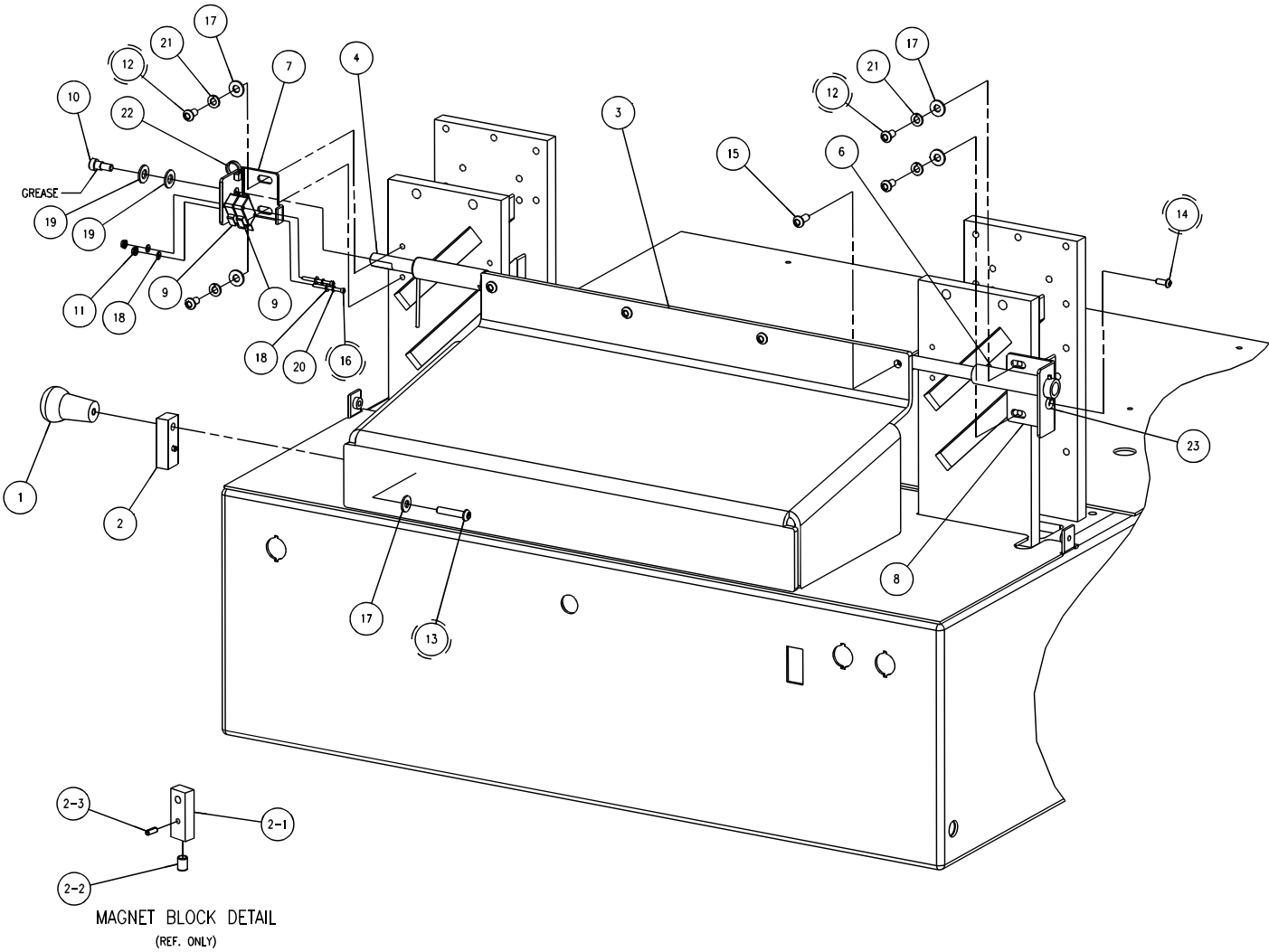
63000 Sheet 5



NO.	PART NO.	DESCRIPTION	QTY
1	63015	CUT STICK	1
2	63017	KNIFE	1
3	63018	PULL-DOWN LINK	1
4	63068	PIN - UPPER PULL DOWN	1
5	63069	KNIFE BAR MOUNTED GUARD	1
6	63087	GIB	2
7	63088	GIB SUPPORT	2
8	63091	CLAMP GUIDE BLOCK	1
9	61065-750032	SHLD SCR SHORTENING SHIM- 3/4	2
10	63016-1	KNIFE BAR W/PINS	1
11	63030-1	ROLLER	2
12	63031-1	SLIDE PLATE	2
13	H-6417-4	NUT - 1/4-20 HEX	1
14	H-6417-5	NUT - 5/16-18 HEX	18
15	H-6442-4	NUT - 1/4-20 NYLOC	1
16	H-6451-0500	RING - EXTERNAL GRIPPING	2
17	H-6909-404	SCREW - 1/4-20 X 1/2" FLAT HEAD CAP	13
18	H-6909-416	SCREW - 1/4-20 X 2" FLAT HEAD CAP	1
19	H-6910-505	SCREW - 5/16-18 X 5/8 BUTTON HEAD CAP	6
20	H-6910-102403SS	SCREW - #10-24 X 3/8 BUT. HEAD CAP STAINLESS	3
21	H-6918-428	SCREW - 1/4-20 X 3-1/2 SOCKET HEAD CAP	2
22	H-6940-528	SCREW - 5/16-18 X 1-3/4 FLAT SOC SET	6
23	H-6940-540	SCREW - 5/16-18 X 2-1/2 FLAT SOC SET	2
24	H-6992-536	SCREW - 5/16-18 X 4-1/2 FULL THD HEX HD	4
25	H-7321-5	WASHER - 5/16 SAE PLAIN	4

4.15 Main Asm. – Front Shield (All Models)

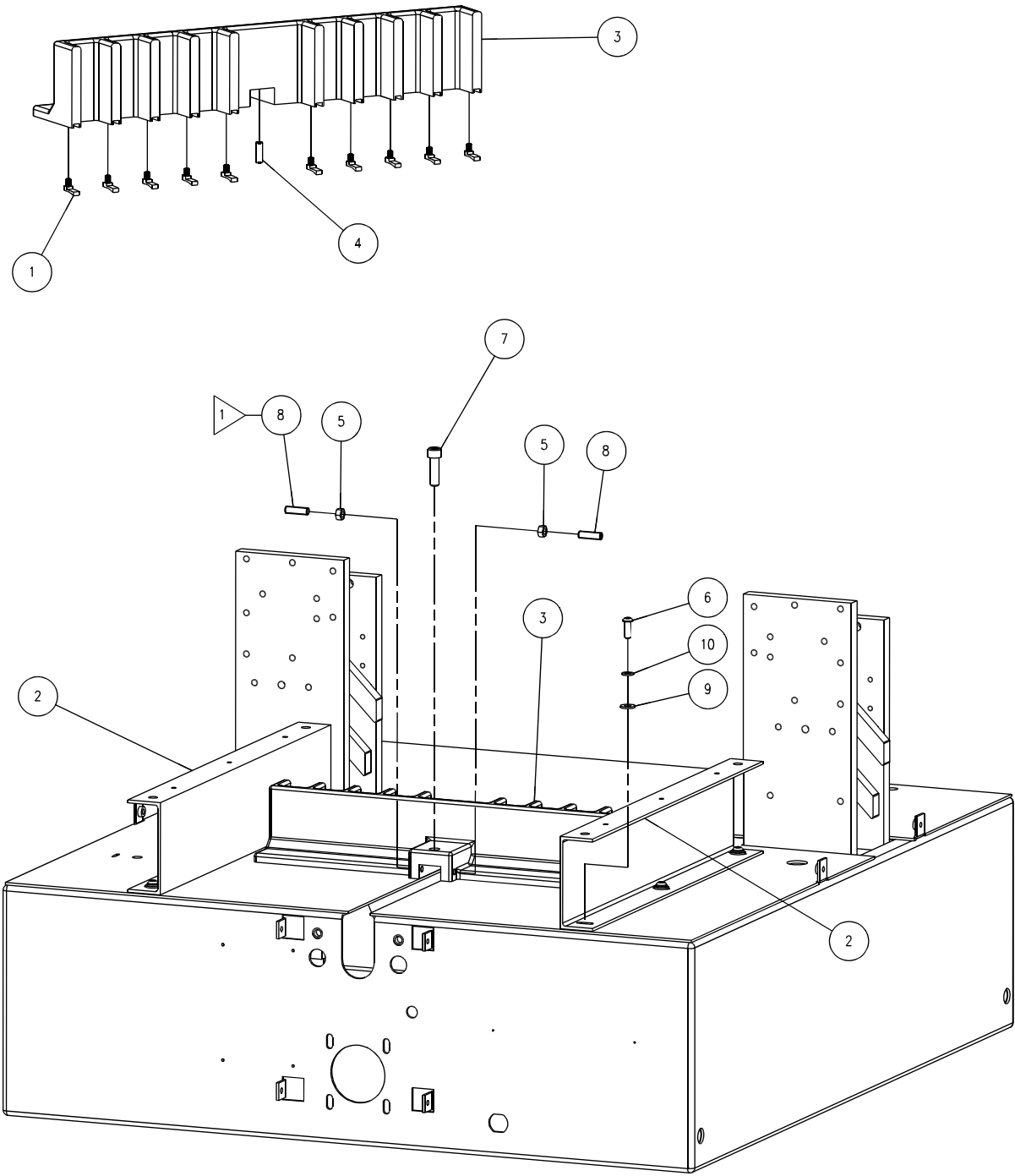
63000 Sheet 6



NO.	PART NO.	DESCRIPTION	QTY
1	60047	HANDLE - SHIELD	1
2	60052	MAGNET BLOCK ASSEMBLY	1
2-1	60046	BLOCK - HOOD HANDLE	REF.
2-2	60053	MAGNET - RARE EARTH	REF.
2-3	H-21S-187-0500	ROLL PIN - 3/16 X 1/2	REF.
3	63040	TILT SHIELD	1
4	63041	HINGE ROD	1
5	63042	TORSION SPRING	1
6	63043	DAMPENING TUBE	1
7	63060	SHIELD BRACKET - LH	1
8	63061	SHIELD BRACKET - RH	1
9	E-866-9	POSITIVE ACTION MICROSWITCH	2
10	H-5254-502	SCREW - 5/16 X 1/4 SHSS	1
11	H-6423-N4	NUT - #4-40 HEX KEP	2
12	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	4
13	H-6910-410	SCREW - 1/4-20 X 1-1/4 BUTTON HEAD CAP	1
14	H-6910-102404	SCREW - #10-24 X 1/2 BUTTON HEAD CAP	1
15	H-6910-405SS	SCREW - 1/4-20 X 5/8 BUT. HEAD CAP STAINLESS	4
16	H-6918-44010	SCREW - #4-40 X 1-1/4 SOCKET HEAD CAP	2
17	H-7321-4	WASHER - 1/4 SAE PLAIN	5
18	H-7321-N4	WASHER - #4 SAE PLAIN	4
19	H-7322-5	WASHER - 5/16 POLISHED	2
20	H-7324-N4	WASHER - #4 INT TOOTH	2
21	H-7327-8	WASHER - 1/4 MEDIUM LOCK	4
22	S-1694	TYRAP	1
23	S-1244-1	LOCK PIN	1
24	SU-30-106	GREASE - DAMPENING	1

4.16 Main Asm. – Backgauge (All Models)

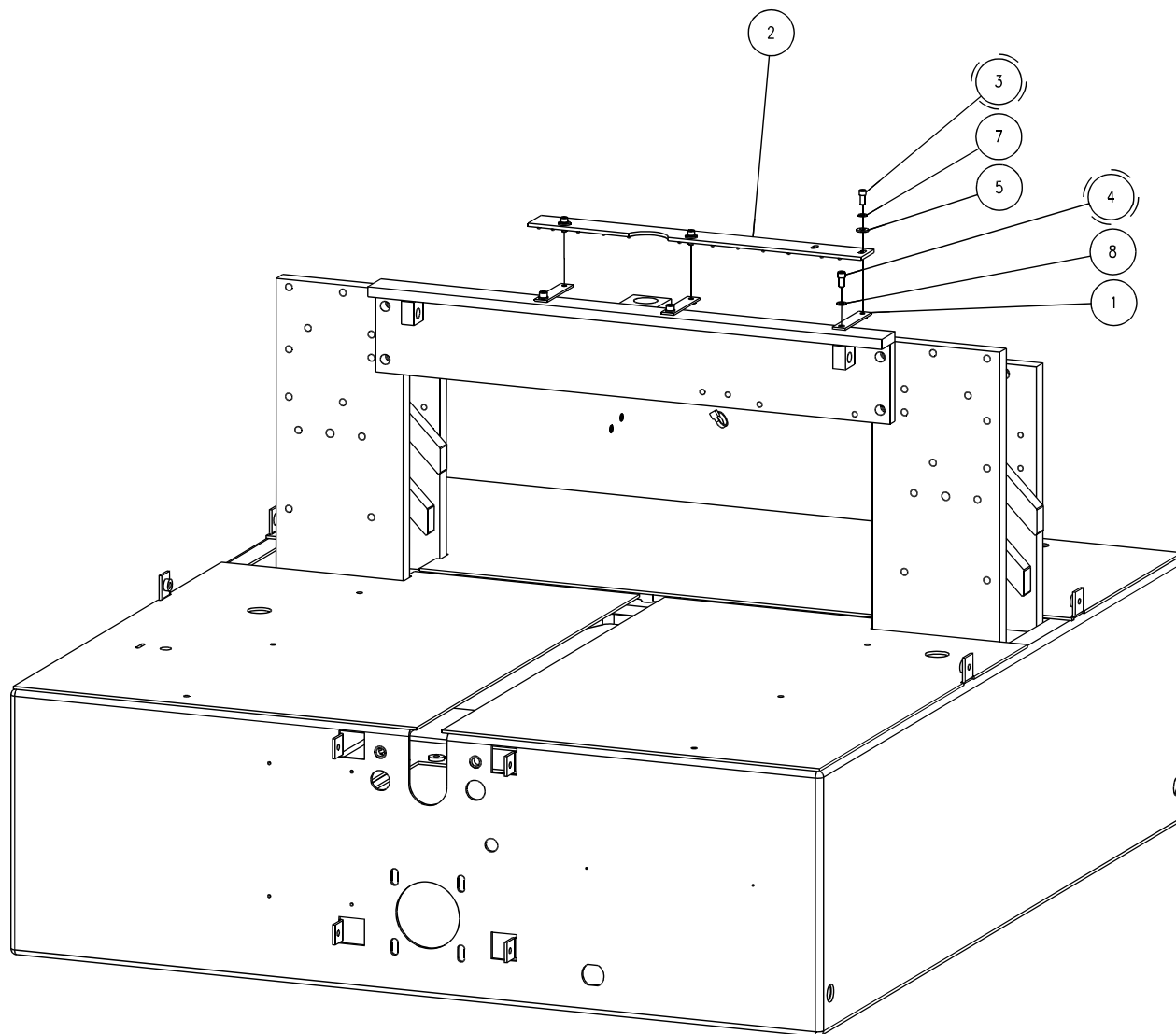
63000 Sheet 7



NO.	PART NO.	DESCRIPTION	QTY
1	60204	FLOATING FINGER	10
2	63020	SIDE GUIDE	2
3	63204	BACKGAUGE- MACHINED	1
4	H-5246-406	DOWEL PIN - 1/4 X 3/4 HD GD	1
5	H-6417-4	NUT - 1/4-20 HEX	2
6	H-6910-406	SCREW - 1/4-20 X 3/4 BUTTON HEAD CAP	6
7	H-6918-610	SCREW - 3/8-16 X 1-1/4 SOCKET HEAD CAP	1
8	H-6938-416	SCREW - 1/4-20 X 1 CUP SOC SET	2
9	H-7321-4	WASHER - 1/4 SAE PLAIN	6
10	H-7327-8	WASHER - 1/4 MEDIUM LOCK	6

4.17 Main Asm. – Top Side Elec. (Models: SA, 120/230V, 50/60 Hz)

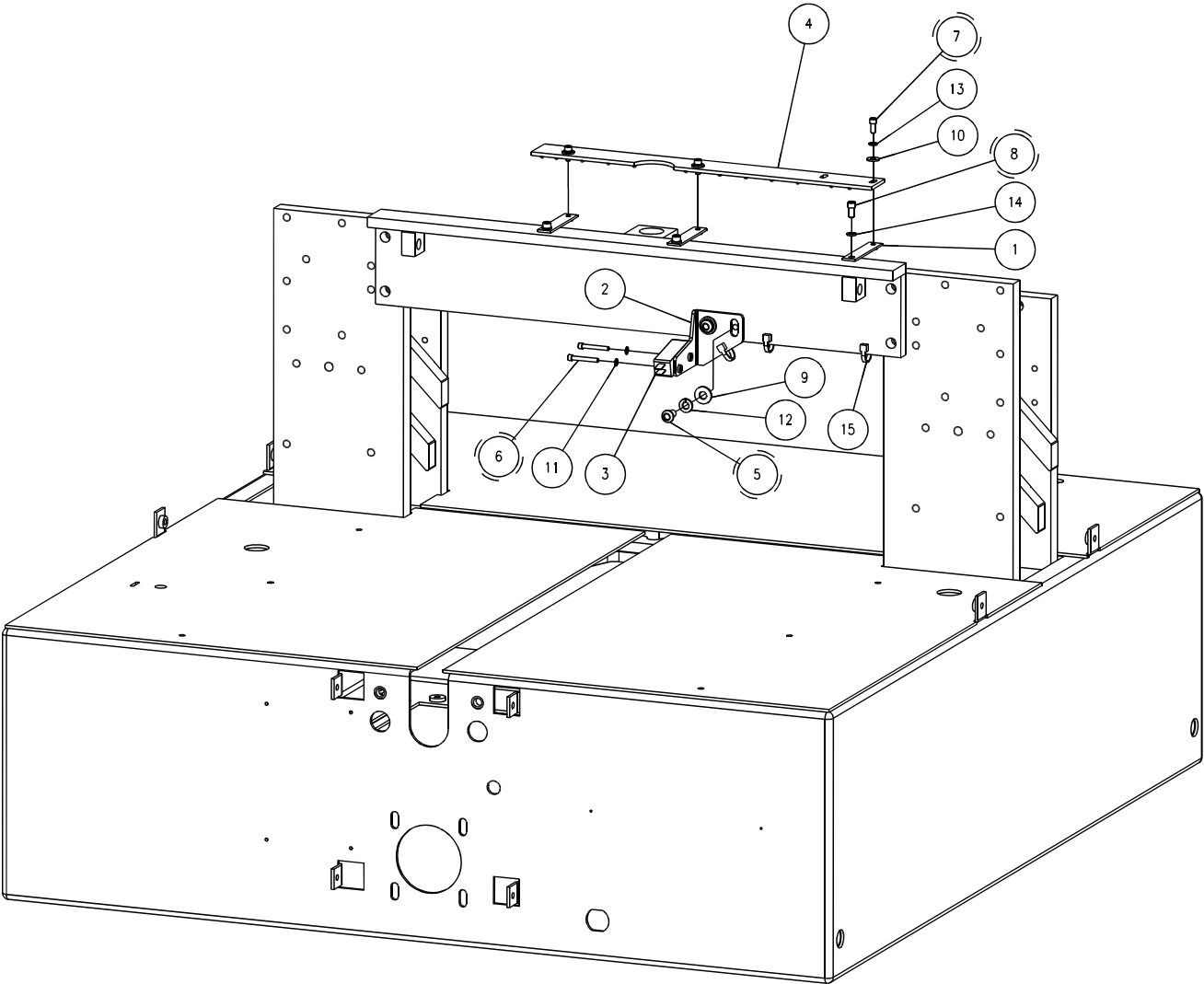
63000 Sheet 8



NO.	PART NO.	DESCRIPTION	QTY
1	63070	LINE LIGHT BRACKET	3
2	EE-3162	BOARD	1
3	H-6918-83203	SCREW - #8-32 X 3/8 SOCKET HEAD CAP	3
4	H-6918-102403	SCREW - #10-24 X 3/8 SOCKET HEAD CAP	3
5	H-7321-N8	WASHER - #8 SAE PLAIN	3
6	H-7324-N6	WASHER - #6 INT TOOTH	2
7	H-7327-N8	WASHER - #8 MEDIUM LOCK	3
8	H-7327-N10	WASHER - #10 MEDIUM LOCK	3
9	S-1694	TYRAP	1

4.18 Main Asm. – Top Side Elec. (Models: A/AEP, 120/230V, 50/60 Hz)

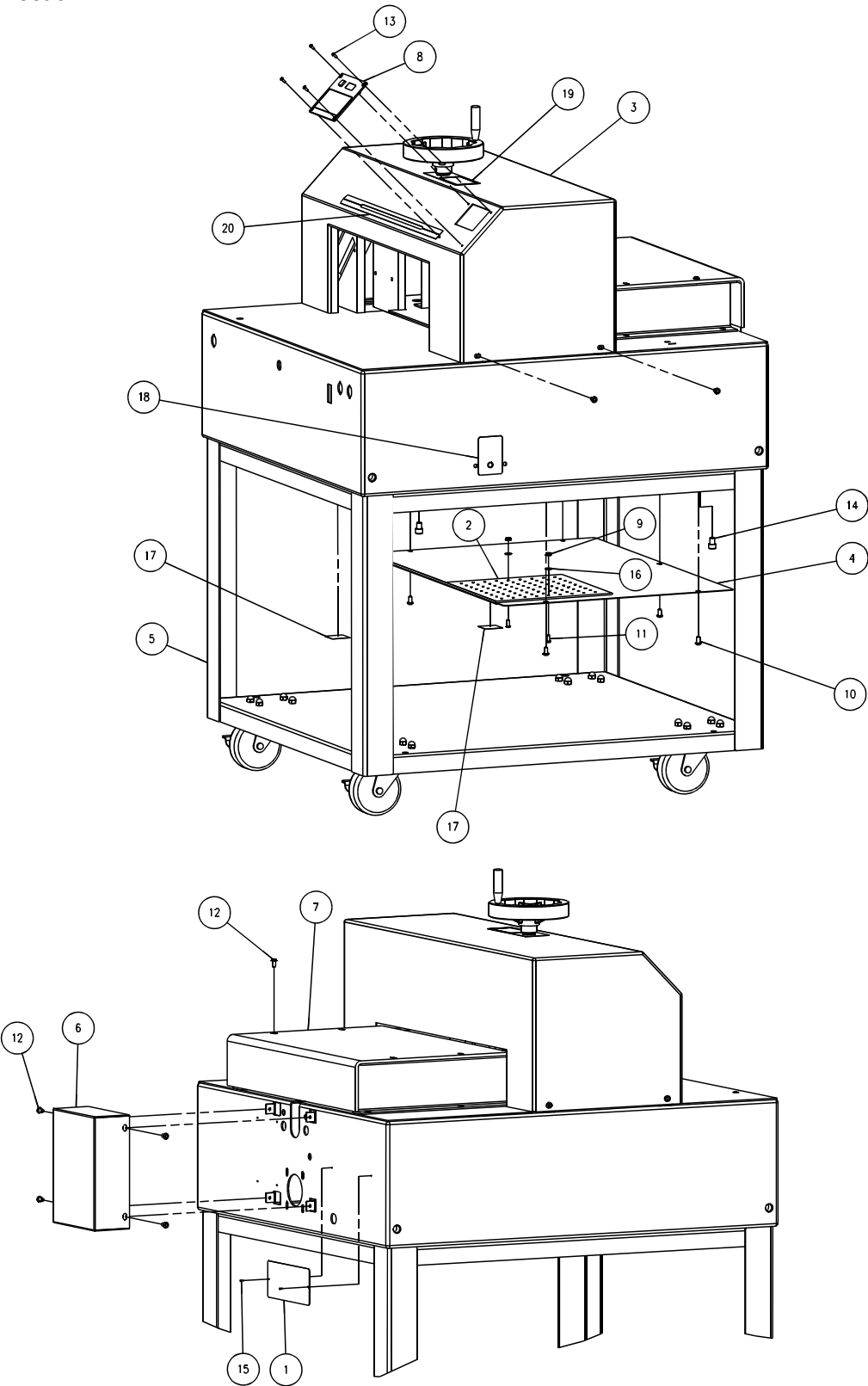
63000 Sheet 8



NO.	PART NO.	DESCRIPTION	QTY
1	63070	LINE LIGHT BRACKET	3
2	63080	BRACKET - CLAMP UP LIMIT SWITCH	1
3	E-3112	MICROSWITCH	1
4	EE-3162	BOARD	1
5	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	2
6	H-6918-63208	SCREW - #6-32 X 1 SOCKET HEAD CAP	2
7	H-6918-83203	SCREW - #8-32 X 3/8 SOCKET HEAD CAP	3
8	H-6918-102403	SCREW - #10-24 X 3/8 SOCKET HEAD CAP	3
9	H-7321-4	WASHER - 1/4 SAE PLAIN	2
10	H-7321-N8	WASHER - #8 SAE PLAIN	3
11	H-7324-N6	WASHER - #6 INT TOOTH	2
12	H-7327-8	WASHER - 1/4 MEDIUM LOCK	2
13	H-7327-N8	WASHER - #8 MEDIUM LOCK	3
14	H-7327-N10	WASHER - #10 MEDIUM LOCK	3
15	S-1694	TYRAP	3

4.19 Main Asm. – Covers and Labels (Models: SA, 120/230V, 50/60 Hz)

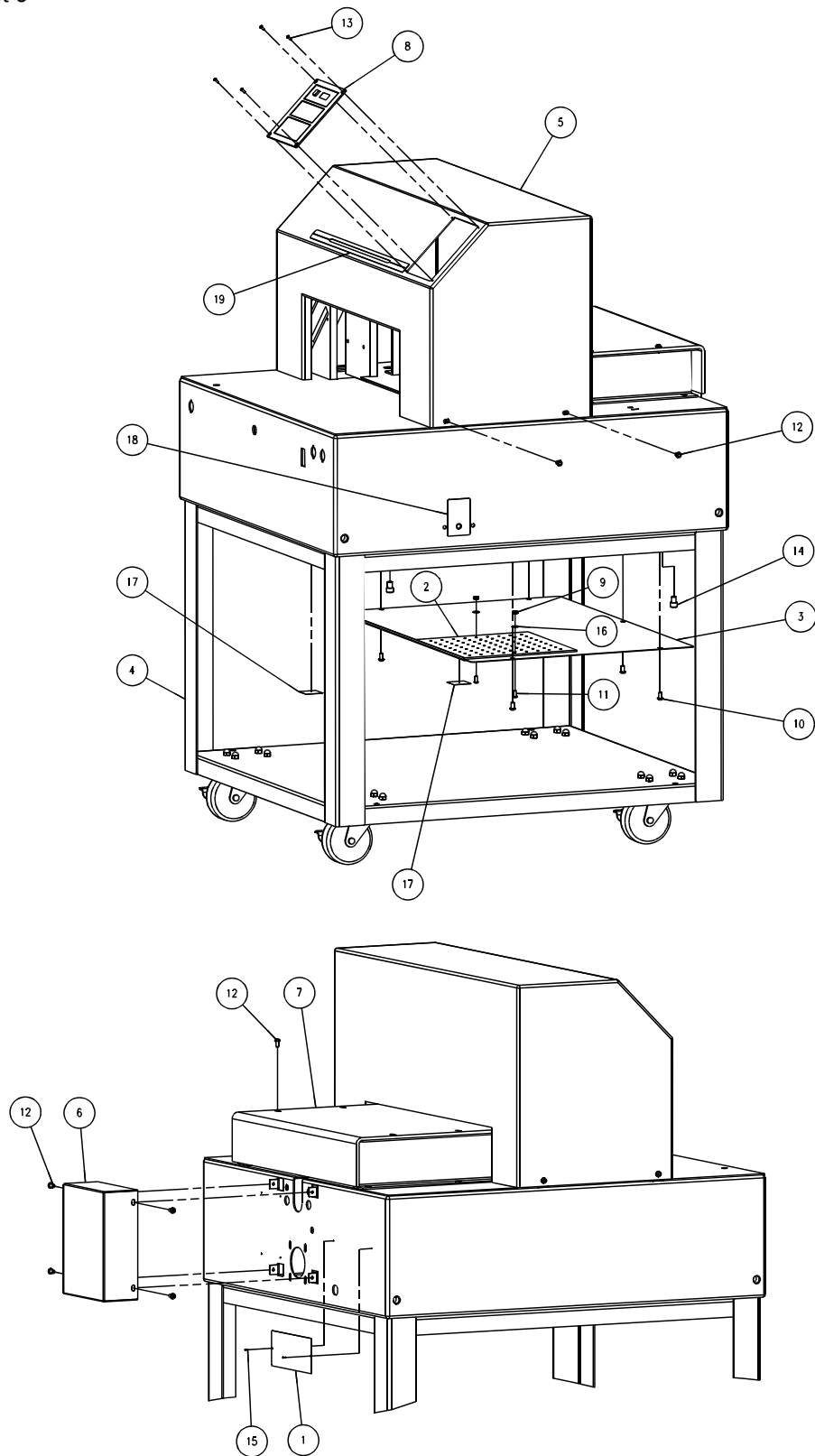
63000 Sheet 9



NO.	PART NO.	DESCRIPTION	QTY
1	41130	PLATE - SERIAL NUMBER	1
2	60073	ABSORBANT MAT	1
3	63034	TOP COVER - 185SA	1
4	63048	BOTTOM COVER	1
5	63050	STAND	1
6	63209	ENCODER COVER	1
7	63217	REAR TABLE COVER	1
8	EE-3164	DISPLAY ASM - DIGITAL	1
9	H-6423-N10	NUT - #10-24 HEX KEP	2
10	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	5
11	H-6910-102404	SCREW - #10-24 X 1/2 BUTTON HEAD CAP	2
12	H-6910-404SS	SCREW - 1/4-20 X 1/2 BUT. HEAD CAP STAINLESS	9
13	H-6918-63203SS	SCREW - #6-32 X 3/8 SOC. HEAD CAP STAINLESS	4
14	H-6918-604	SCREW - 3/8-16 X 1/2 SOCKET HEAD CAP	4
15	H-6924-004	SCREW - #0 X 1/4 DRIVE SCREW	2
16	H-7321-N10	WASHER - #10 SAE PLAIN	2
17	S-1781-50	LABEL - ELECTRIC SHOCK	2
18	S-1781-125	LABEL - KNIFE ADJUST	1
19	S-1781-131	LABEL - TOP COVER	1
20	S-1781-149	FRONT LABEL	1

4.20 Main Asm. – Covers and Labels (Models: A, 120/230V, 50/60 Hz)

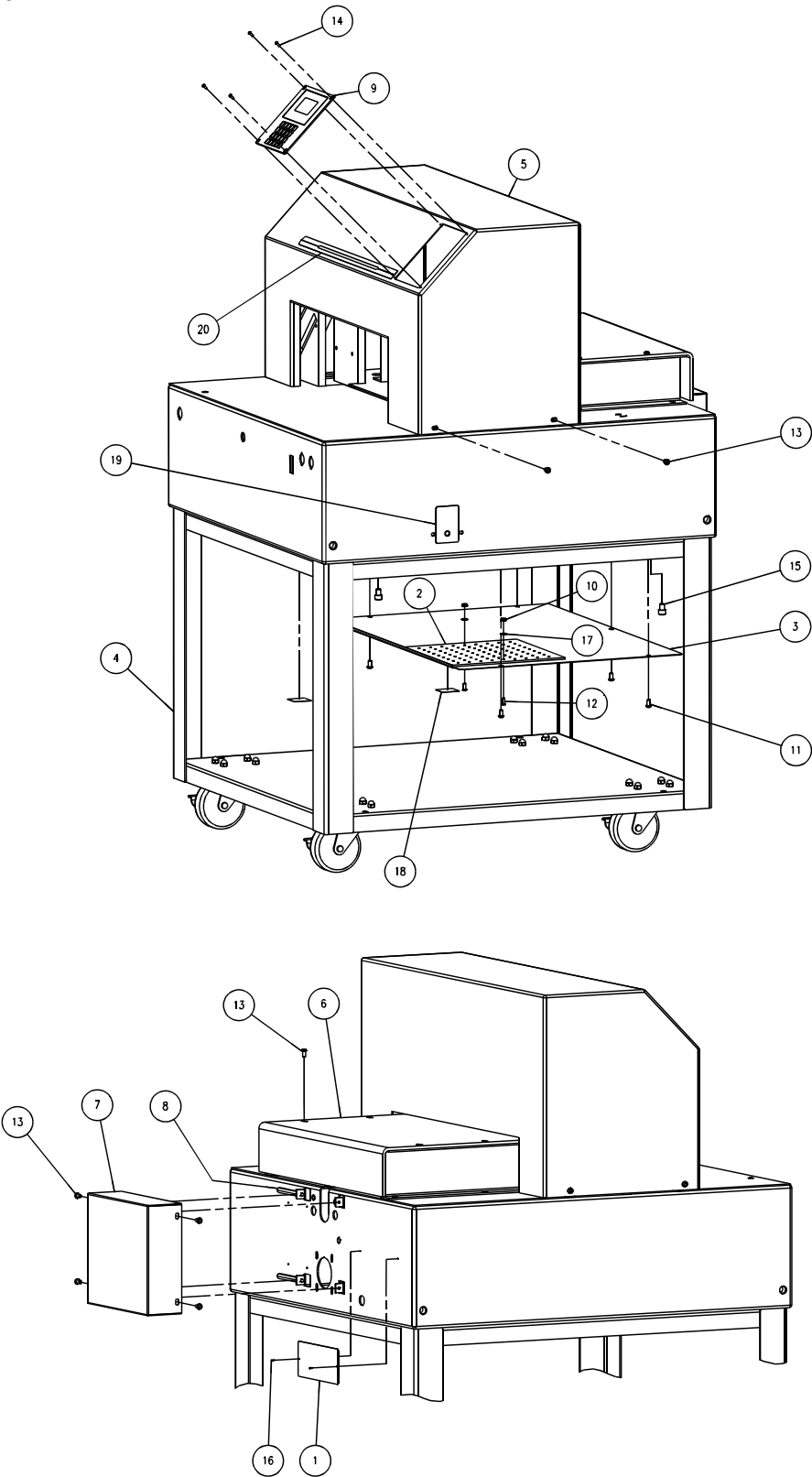
63000 Sheet 9



NO.	PART NO.	DESCRIPTION	QTY
1	41130	PLATE - SERIAL NUMBER	1
2	60073	ABSORBENT MAT	1
3	63048	BOTTOM COVER	1
4	63050	STAND	1
5	63077	TOP COVER - 185A/185AEP	1
6	63209	ENCODER COVER	1
7	63217	REAR TABLE COVER	1
8	EE-3158	DISPLAY ASM - DIGITAL	1
9	H-6423-N10	NUT - #10-24 HEX KEP	2
10	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	5
11	H-6910-102404	SCREW - #10-24 X 1/2 BUTTON HEAD CAP	2
12	H-6910-404SS	SCREW - 1/4-20 X 1/2 BUT. HEAD CAP STAINLESS	9
13	H-6918-63203SS	SCREW - #6-32 X 3/8 SOC. HEAD CAP STAINLESS	4
14	H-6918-604	SCREW - 3/8-16 X 1/2 SOCKET HEAD CAP	4
15	H-6924-004	SCREW - #0 X 1/4 DRIVE SCREW	2
16	H-7321-N10	WASHER - #10 SAE PLAIN	2
17	S-1781-50	LABEL - ELECTRIC SHOCK	2
18	S-1781-125	LABEL - KNIFE ADJUST	1
19	S-1781-149	FRONT LABEL	1

4.21 Main Asm. – Covers & Labels (Models: AEP, 120/230V, 50/60 Hz)

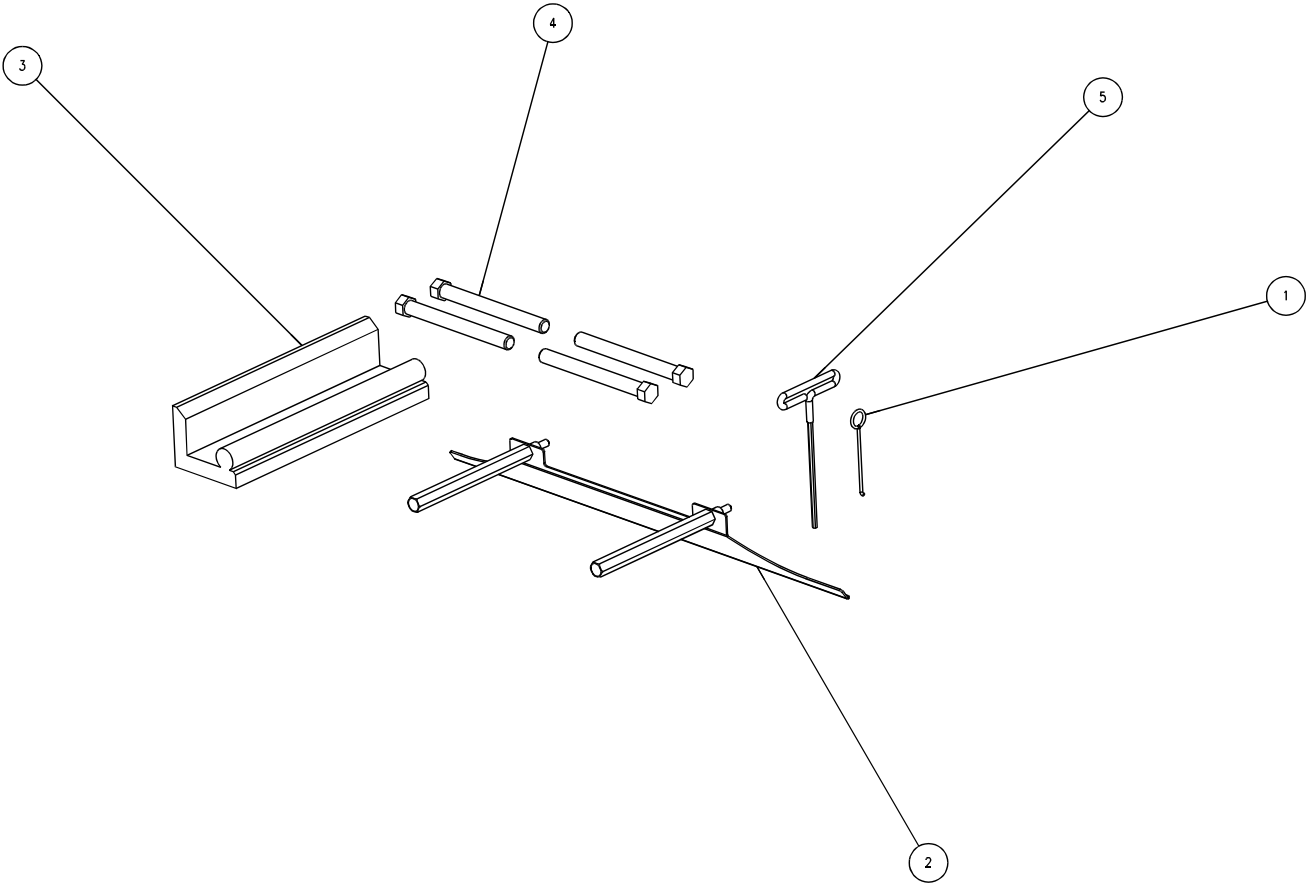
63000 Sheet 9



NO.	PART NO.	DESCRIPTION	QTY
1	41130	PLATE - SERIAL NUMBER	1
2	60073	ABSORBENT MAT	1
3	63048	BOTTOM COVER	1
4	63050	STAND	1
5	63077	TOP COVER - 185A/185AEP	1
6	63217	REAR TABLE COVER	1
7	63209-1	ENCODER COVER, 185AEP	1
8	E-1152-92	STANDOFF	2
9	EE-3157	DISPLAY ASM - PROGRAMMABLE	1
10	H-6423-N10	NUT - #10-24 HEX KEP	2
11	H-6910-404	SCREW - 1/4-20 X 1/2 BUTTON HEAD CAP	5
12	H-6910-102404	SCREW - #10-24 X 1/2 BUTTON HEAD CAP	2
13	H-6910-404SS	SCREW - 1/4-20 X 1/2 BUT. HEAD CAP STAINLESS	9
14	H-6918-63203SS	SCREW - #6-32 X 3/8 SOC. HEAD CAP STAINLESS	4
15	H-6918-604	SCREW - 3/8-16 X 1/2 SOCKET HEAD CAP	4
16	H-6924-004	SCREW - #0 X 1/4 DRIVE SCREW	2
17	H-7321-N10	WASHER - #10 SAE PLAIN	2
18	S-1781-50	LABEL - ELECTRIC SHOCK	2
19	S-1781-125	LABEL - KNIFE ADJUST	1
20	S-1781-149	FRONT LABEL	1

4.22 Main Asm. – Accessories (All Models)

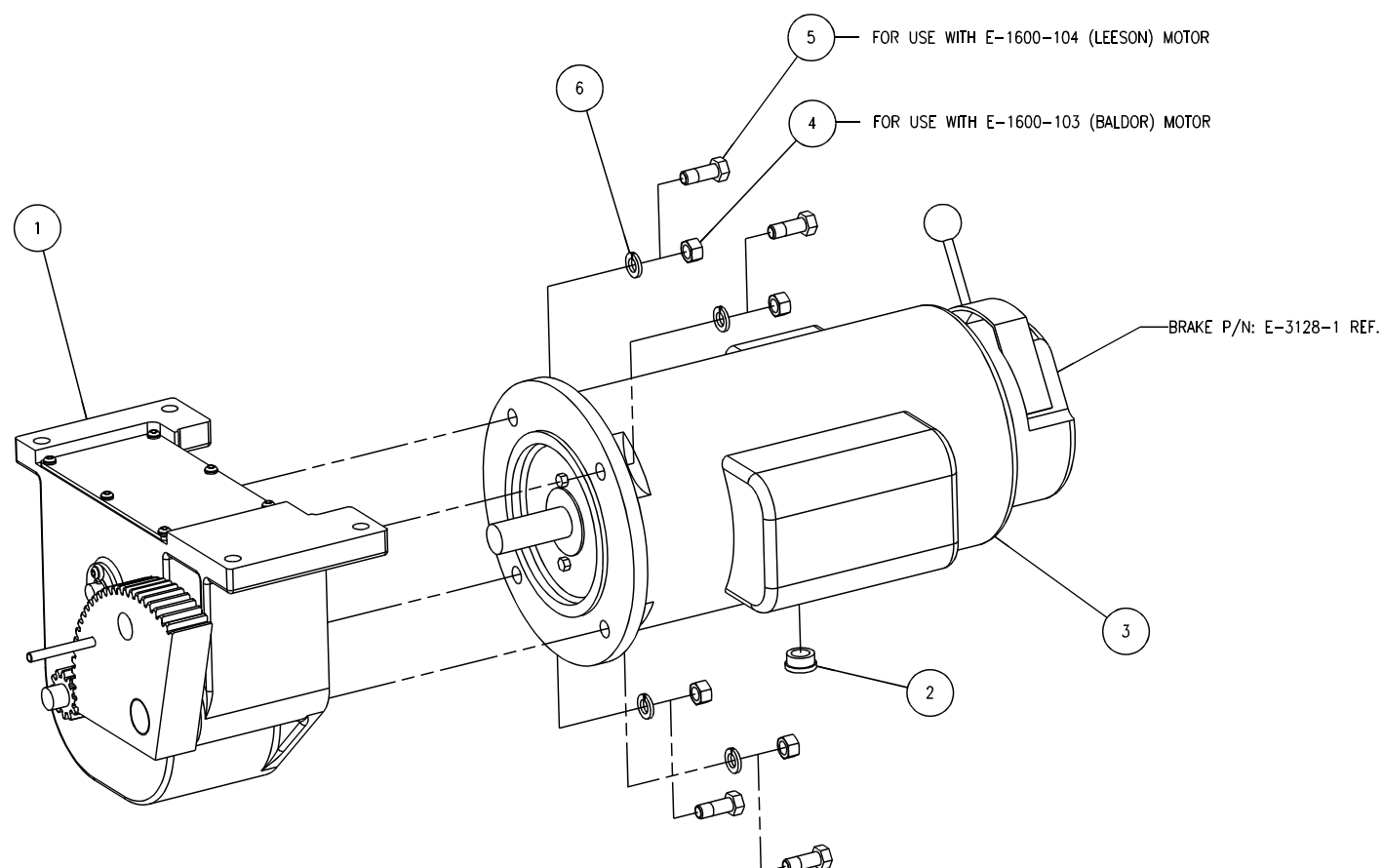
63000 Sheet 10



NO.	PART NO.	DESCRIPTION	QTY
1	5064	CUT STICK PULLER	1
2	63073	KNIFE LIFTER ASM	1
3	A-12608-2	JOGGING AID	1
4	H-6913-1048	SCREW - 5/8-11 X 6 HEX HEAD CAP	4
5	W-191	WRENCH - 3/16" T-HANDLE HEX ALLEN	1

4.23 Motor and Gearbox Assembly (All Models)

63002 Rev. B



NO.	PART NO.	DESCRIPTION	QTY
1	63002-GB	GEARBOX ASSEMBLY	1
2	E-1172-9	HOLE PLUG	1
3	EE-3155	MOTOR W/ BRAKE	1
4	H-6417-6	NUT - 3/8-16 HEX	4
5	H-6913-608	SCREW - 3/8-16 X 1 HEX HEAD CAP	4
6	H-7327-12	WASHER - 3/8 MEDIUM LOCK	4

4.24 Motor/Brake Assembly (All Models)

EE-3155 Rev. D

