

**TECHNICAL MANUAL**

**ORGANIZATIONAL, DIRECT SUPPORT AND  
GENERAL SUPPORT MAINTENANCE  
REPAIR PARTS AND SPECIAL TOOLS LIST**

**FOR**

**GRINDING MACHINE  
MODEL B2062  
(NSN 3415-01-060-8594)  
K. O. LEE COMPANY**

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**HEADQUARTERS, DEPARTMENT OF THE ARMY**

**JULY 1981**

Technical Manual }  
No. 9-3415-236-24P }

HEADQUARTERS  
DEPARTMENT OF THE ARMY  
Washington, DC, 31 July 1981

**ORGANIZATIONAL, DIRECT SUPPORT AND  
GENERAL SUPPORT MAINTENANCE  
REPAIR PARTS AND SPECIAL TOOLS LIST  
FOR  
GRINDING MACHINE  
MODEL B2062  
(NSN 3415-01-060-8594)**

**REPORTING OF ERRORS**

You can help improve this manual. If you find any mistakes or if you know of a way to improve the procedures, please let us know. Mail your letter, DA Form 2028 (Recommended Changes to Publications and Blank Forms), or DA Form 2028-2 located in back of this manual direct to: Commander, US Army Armament Materiel Readiness Command, ATTN: DRSAR-MAS, Rock Island, IL 61299. A reply will be furnished to you.

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This technical manual is an authentication of the manufacturers' commercial literature and does not conform with the format and content specified in AR 310-3, Military Publications. This technical manual does, however, contain available information that is essential to the operation and maintenance of the equipment.

## SECTION I. INTRODUCTION

### 1. Scope

This manual lists spares and repair parts; special tools; special test, measurement, and diagnostic equipment (TMDE); and other special support equipment required for the performance of organizational, direct support, and general support maintenance of the grinding machine, Model B2062, NSN 3415-01-060-8594, FSCM 35472.

### 2. General

a. *Refer to TM 9-3415-236-14 for operation and maintenance procedures.*

b. *Requisitioning Instructions.* When requisitioning parts not identified by National Stock Number, it is mandatory that the following information be furnished the supply officer.

- (1) Manufacturer's Federal Supply Code Number - 35472.
- (2) Manufacturer's Part Number exactly as listed herein.
- (3) Nomenclature exactly as listed herein, including dimensions, if necessary.
- (4) Manufacturer's Model Number -
- (5) Manufacturer's Serial Number (End Item).
- (6) Any other information such as Type, Frame Number, and Electrical Characteristics, if applicable.
- (7) If DD Form 1348 is used, fill in all blocks except 4, 5, 6, and Remarks field in accordance with AR 725-50.

Complete Form as Follows:

(a) In blocks 4, 5, 6, list manufacturer's Federal Supply Code Number - \_\_\_\_\_ followed by a colon and manufacturer's Part Number for the repair part.

(b) Complete Remarks field as follows:

Noun:	(nomenclature of repair part)
For:	NSN: 3415-01-060-8594
Manufacturer:	K. O. Lee Company, 200 South Harrison, Aberdeen, SD 57401
Model:	B2062
Serial:	(of end item)

Any other pertinent information such as Frame Number, Type, Dimensions, etc.

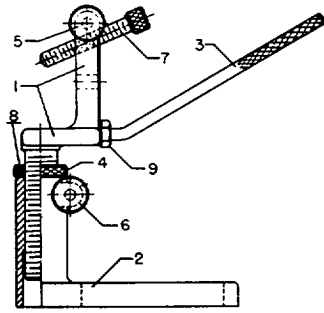
PARTS LIST  
FOR  
GRINDER FIXTURES

★

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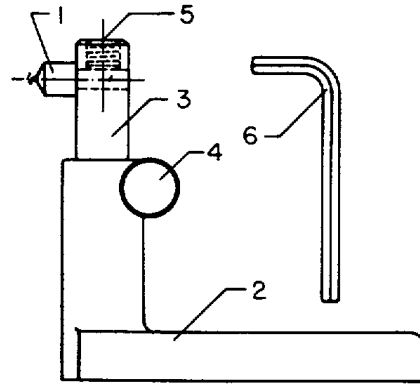
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B640K DIAMOND DRESSER..... 3  
B647 TAP GRINDING FIXTURE..... 3  
B820 HEADSTOCK..... 5  
B821 TAILSTOCK..... 5  
B840 UNIVERSAL TOOTH REST ..... 4  
B885 RADIAL GRINDING FIXTURE..... 4  
B892 SENSITIVE WORK HEAD..... 5  
B922 TAILSTOCK, MATCHED SET ..... 5  
B940 UNIVERSAL TOOTH REST ..... 6  
BA940 UNIVERSAL TOOTH REST ..... 6  
B942 SENSITIVE WORK HEAD..... 6  
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**B269 Radial Diamond Dresser**



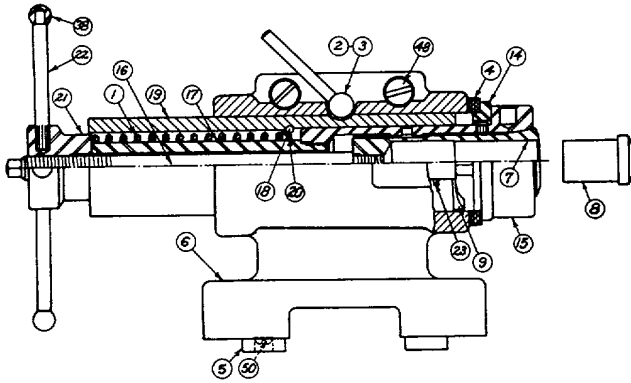
Index No.	Part No.	Quan Req.	Description
1	B269A	1	Swinging Arm
2	B269B	1	Base
3	A269H	1	Handle
4	A269N	1	Adjusting Nut
5	P117K	1	Knurled Thumb Screw
6	P119K	1	Knurled Thumb Screw
7	P176D	1	Diamond Screw
8	10-24x 3/16	1	Flat Point Hdle. Set Screw
9	1/4 USS	1	Hex Nut (H)

**B640K Diamond Dresser**



Index No.	Part No.	Quan Req.	Description
1	A173	1	Diamond
2	B269B	1	Base
3	B640KC	1	Column
4	P119K	1	Knurled Thumb Screw
5	7/16 x 3/8 USS	1	Hex Socket Flat Point Set Screw
6	32 Hex	1	Wrench

**B647 Tap Grinding Fixture**



**ACCESSORIES FOR B647 FIXTURE**

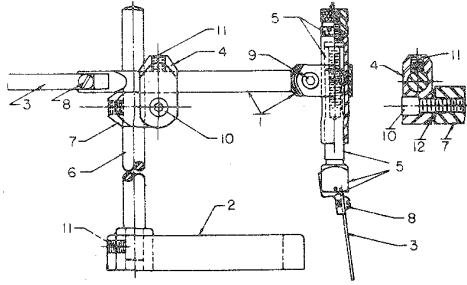
Index No.	Part No.	Quan Req.	Description
9	B647CAL	1	L. Hand Lift Cam (Taps up to 3/8")
9	B647CBL	1	L. Hand Lift Cam (Taps 3/8" to 3/4")
9	B647CCL	1	L. Hand Lift Cam (Taps over 3/4")
9	B647CSL	1	L. Hand Lift Cam - Spec. for 2 flute Taps
14	B647D	1	5 and 6 Fluted Index Discs
7	B647E	1	.800" Collet to fit 1" Tap
8	B647F	1	Bushings for B647E Collet to fit 11/16", 3/4" and 7/8" Taps
8	B647P	1	Driver for use in B647 Tap Grinding Fixture when grinding large Taps

**NOTE: Either A261G Spring Center or B621 "Quick Release" Spring Center Tail Stock must be used with B647P Driver.**

**B647 Tap Grinding Fixture**

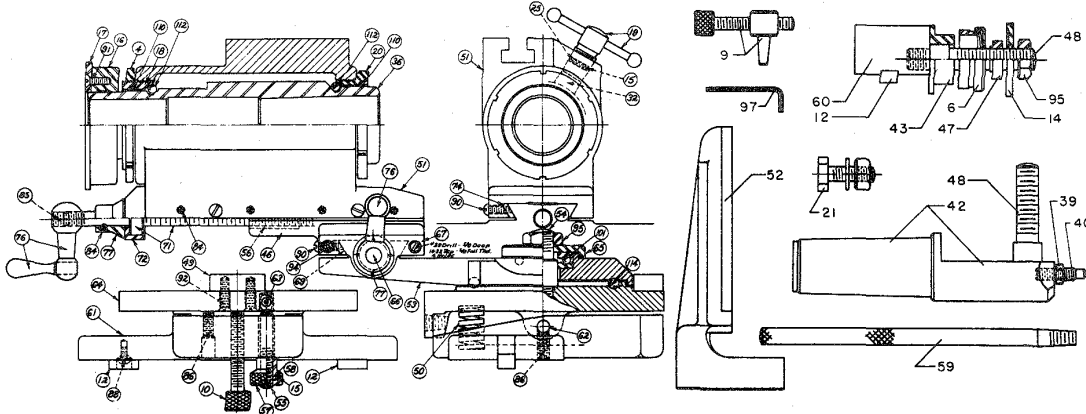
Index No.	Part No.	Quan Req.	Description
1	A261F	1	Coil Spring
2	A261L	1	Lock Screw Assembly
3	A261LN	1	Lock Nut
4	A261W	1	Fiber Thrust Washer
5	A623	2	T-Slot Block
6	A647B	1	Body
7	B647A	1	9/16" Collet
8	B647B	1	Bushing to take Nos. 0 thru 6, 7 and 8, 9 and 10, 12; sizes 1/4", 5/16", 3/8", 7/16", 1/2", 9/16", and 5/8" Taps
9	B647CA	1	Rt. Hd. Cam (A) (Taps up to 3/8")
9	B647CB	1	Rt. Hd. Cam (B) (Taps 3/8" to 3/4")
9	B647CC	1	Rt. Hd. Cam (C) (Taps over 3/4")
9	B647CS	1	Rt. Hd. Lift Cam - Spec. for 2 flute Taps
14	B647D2	1	Two Flute Index Disc
14	B647D3	1	Three Flute Index Disc
14	B647D4	1	Four Flute Index Disc
15	B647K	1	Collet Adapter Assembly
16	B647L	1	Draw Bolt
17	B647M	1	Draw Bolt Tube
18	B647R	1	Lock Ring
19	B647S	1	Spindle
20	B647T	1	Thrust Collar
21	B647WH	1	Hub
22	B647WS	4	Spoke for Hub
23	B647Y	1	Retainer Pin for Cam
38	P173CB	4	Ball for Spoke
	A659	2	T-Slot Bolt (3/8" x 1 7/8")
48		2	1/4" x 7/8" S.A.E. Fill. Hd. Mach. Screw
50		2	6-32x3/8" S.T. Round Head Screw

8840 Universal Tooth Rest



Index No.	Part No.	Quan Req.	Description
1	B240A	1	Cross Arm
2	B240C	1	Base
3	B240D	2	Blade
4	B840P	1	Swivel Block
5	B840R	1	Rocker Assembly
6	B840S	1	Shaft
7	B840T	1	Swivel Block
8	10-32 x 1/4	2	Round Head Screw (H)
9	5/16 x 3/4 SAE	1	Hex Socket Cap Screw
10	5/16 x 1 1/4 SAE	1	Hex Socket Cap Screw
11	7/16 x 3/8 USS	3	Hex Socket Set Screw Flat Point
12	5/16	1	Lock Washer (Lock Burred)

B885 Radial Grinding Fixture

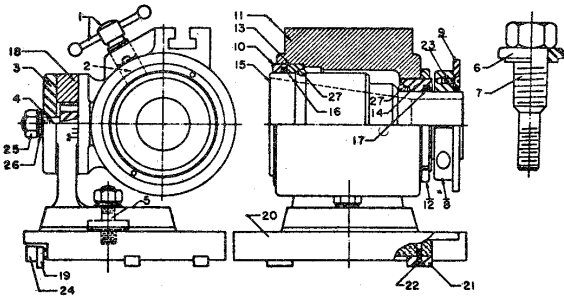


Index No.	Part No.	Quan Req.	Description
4	A54L	1	Lock Ring
6	A280	1	Friction Collar
6	A281	1	Friction Collar
9	A290A	2	Table Adj. Screw Assembly
10	A290AS	1	Knurled Thumb Screw
12	A623	2	T-Slot Block
14	A624F	1	Keyed Wheel Flange
15	A630BS	1	Compression Spring
16	A642P	1	Index Collar
17	B642R	1	Index Disc
18	A643A	1	Adjusting Race
19	A643D	1	Spindle Lock Assembly
20	A643M	1	Front Race
21	A657	2	T-Slot Bolt (3/8 x 1 5/8)
25	B629P	1	Plug
32	B643DP	1	Lock Pad
36	B643S	1	Spindle
39	B684N	1	Special Nut for Diamond Screw
40	B684S	1	Diamond Screw
42	B685A	1	Cutter and Dia. Holding Arbor
43	B685B1	1	1" Cutter Bushing
43	B685B2	1	1" Cutter Bushing
43	B685B3	1	1 1/4" Cutter Bushing
46	B685C	1	Cross Slide
47	B685D	1	Guide Bushing
48	B685E	2	Stud
49	B685F	1	Index Block
50	B685G	2	Spring
51	B685H	1	Housing
52	B685J	1	Centering Gauge
53	B685K	1	Swivel
54	B685KS	1	Swivel Stud
55	B685L	1	Angle Lock Screw

Index No.	Part No.	Quan Req.	Description
56	B685M	2	Feed Nut
21	A658	1	T-Slot Bolt (3/8" x 2 5/8")
21	A660	1	T-Slot Bolt (3/8" x 1 7/8")
57	B685N	1	Thumb Nut
58	B685NP	1	Plug
59	B685P	1	Handle
60	B685R	1	Raising Block for Cutters
61, 62			
& 64	B685TS	1	Table and Saddle Assembly
63	B685TP	1	Pin
65	B685V	1	Thrust Collar
66	B685W	1	Lower Feed Screw Assembly
67	B685WB	1	Lower Feed Screw Bearing
69	B685WG	1	Gib for Lower Slide
71	B685X	1	Upper Feed Screw Assembly
72	B685XB	1	Upper Feed Screw Bearing
74	B685XG	1	Gib for Upper Slide
76	B685Y	2	Ball Crank
77	B685Z	2	Index Collar
22		22	10-24 x 3/16" Socket St. Sc. (Hex Type)
85		2	3/8" x 3/8" S.A.E. Cone Pt. Bristo Set Sc.
86		4	5/16" x 5/16" U.S.S. Headless Set Screw
88		2	6-32 x 3/8" S. T. Round Head Screw
90		4	8-32 x 1/2" Round Head Screw
91		2	10-32 x 3/8" Flat Head Screw
92		2	10-32 x 3/4" Flat Head Screw
94		4	10-32 x 5/8" Fill. Head Screw
95		3	9/16" S.A.E. Hex Jam Nut
97		1	3/32" Hex Wrench, Across Flats
101		1	Thrust Bearing (2305-A)
110		15	3/16" Felt
112		53	7/32" Steel Ball (Set)
114		39	9/32" Steel Ball (Set)

ACCESSORIES FOR B885 RADIAL GRINDING FIXTURE

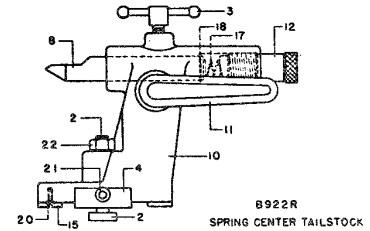
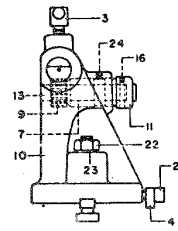
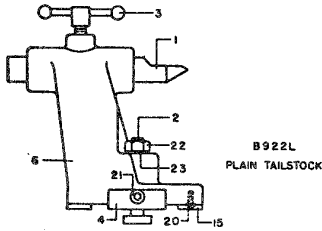
**B892  
Sensitive  
Work Head  
NO. 50  
MILLING MACHINE  
TAPER IN SPINDLE**



Index No.	Part No.	Quan Req.	Description
1	A643D	1	Lock Screw Assembly
2	A643DP	1	Lock Pad
3	B620D	1	Back Plate
4	B620G	1	Swivel Stud
5	B620R	1	Base Stud
6	B792BC	1	Collar
7	B792BD	1	Draw Bolt
8	B792C	1	Index Collar
9	B792D	1	Index Disc (24 Div.)
10	B792E	1	Front Lock Ring
11	B792H	1	Housing
12	B792L	1	Lock Ring
13	B792M	1	Front Race
14	B792R	1	Adjusting Race

Index No.	Part No.	Quan Req.	Description
15	B792S	1	Spindle
16	B792W	1	Front Wiper
17	B792Y	1	Rear Wiper
18	B820S	1	Swivel
19	B822B	1	Clamp Bar Assembly
20	B942B	1	Base
21	B942T	4	T-Slot Block
22	6-32 x 3/8	2	St. Round Head Screw
23	10-32 x 1/2	2	Flat Head Machine Screw (H.B.)
24	5/16 x 3/4 S.A.E.	1	Hex Socket Cap Screw
25	3/8 U.S.S.	2	Hex Nut (H)
26	3/8 Std.	1	Lock Washer (Lock Burred)
27	7/22	76	Chrome Steel Balls (set)

**B922 Tailstock Matched Set**



Index No.	Part No.	Quan Req.	Description
1	A250F	1	Center
1	A250FP	1	Special Carbide Center (Available)
2	A658B	2	T-Slot Bolt
3	B675	2	Lock Screw
4	B822B	2	Clamp Bar Assembly
6	B921LH	1	Housing
7	B921RB	1	Bushing
8	B921RC	1	Center
8	B921RCP	1	Special Carbide Center (Available)
9	B921RG	1	Gear
10	B921RH	1	Housing
11	B921RL	1	Lever Arm

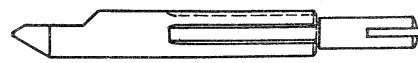
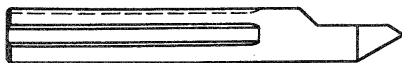
Index No.	Part No.	Quan Req.	Description
12	B921RP	1	Threaded Plunger
13	B921RS	1	Shaft for Gear
15	B942T	4	T-Slot Block
16	B985PP	1	Pin
17	P193	1	Spring
18	RS75	1	Spirolox External
20	No. 6-32 x 3/8	4	S. T. Round Head Screw
21	3/16 x 3/4 SAE	2	Hex Socket Cap Screw
22	3/8 U.S.S.	2	Hex Nut (H)
23	3/8 L. W.	2	Washer
24	10-32 x 3/16	1	Hex Socket Set Screw

**B820 Headstock**

Part No.	Description	Part No.	Description
A250F	Center	BS20C	Headstock Barrel
B942T	T-Stock Block	B820S	Swivel
B675	Lock Screw	B822B	Clamp Bar Assbly.
B620D	Back Plate	B843B	Base
B620G	Swivel Stud		

**B821 Tailstock**

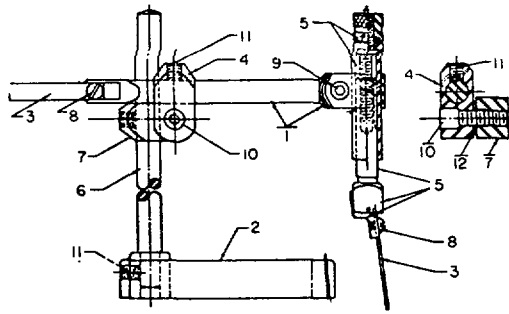
Part No.	Description	Part No.	Description
A622S	Spring	B621S	Comp. Spring
B942T	T-Slot Block	B675	Lock Screw
B621C	Center Assbly.	B805W	Washer
B621E	Short Cap	B821B	Body
B621D	Long Cap	B822B	Clamp Bar Assbly.
B621L	Lever		



Part No.	Description
A250F	Standard Center for Headstock
A250FP	Special Carbide Center for Headstock

Part No.	Description
B621C	Standard Center for Tailstock
B621CP	Special Carbide Center for Tailstock

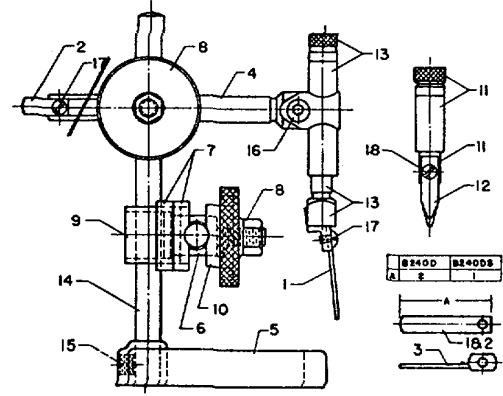
**B940 Universal Tooth Rest**



Index No.	Part No.	Quan Req.	Description
1	B940A	1	Cross Arm
2	B94DC	1	Base
3	B240D	1	Blade (3/8" x 2")
3	B240DS	1	Blade (3/8" x 1")
3	B240DT	1	Blade (3/32" Round)
4	B840P	1	Swivel Block
5	B940R	1	Rocker Assembly
6	B940S	1	Upright Shaft
7	B940T	1	Swivel Block
8	10-32 x 1/4	2	Round Head Screw (H)
9	5/16 x 3/4 SAE	1	Hex Socket Cap Screw
10	5/16 x 1 1/4SAE	1	Hex Socket Cap Screw
11	7/16 x 3/8 USS	3	Hex Socket Set Screw, Flat Point
12	3/8 L. W.	1	Wavy Spring Washer

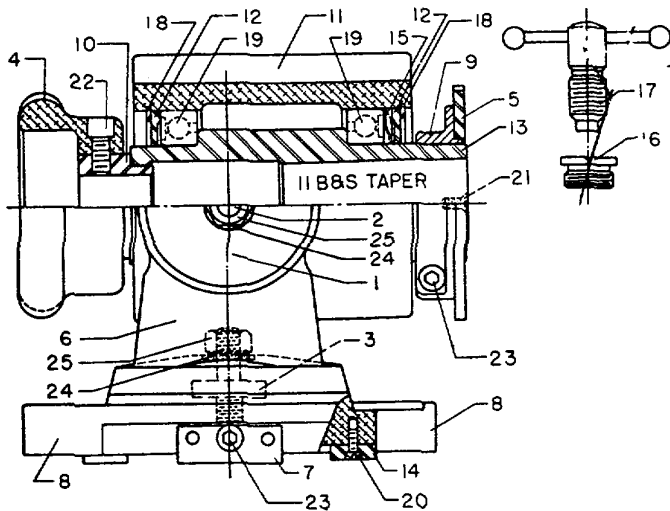
Index No.	Part No.	Quan Req.	Description
1	B240D	1	Blade (3/8 x 2)
2	B240DS	1	Blade (3/8 x 1)
3	B240DT	1	Blade (3/32 Round)
4	B940A	1	Cross Arm
5	B940C	1	Base
6	B940GB	1	Body
7	B940GC	2	Collar
8	B940GN	1	Hand Nut
9	B940GS	1	Swivel
10	B940GW	1	Washer
11	B940H	1	Micrometer Tooth Rest
12	B940HF	1	Tooth Rest Blade
13	B940R	1	Rocker Assembly
14	B940S	1	Upright Shaft
15	7/16 x 3/8 USS	1	Hex Socket Set Screw (Ft. Pt.)
16	5/16 x 3/4 SAE	1	Hex Socket Cap Screw
17	10-32 x 1/4	2	Rd. Hd. Mach. Sc. (H)
18	10-32 x 5/16	1	Rd. Hd. Mach. Sc. (H)

**BA940 Universal Tooth Rest**



Index No.	Part No.	Quan Req.	Description
1	B620D	1	Back Plate
2	B620G	1	Swivel Stud
3	B620R	1	Stud
4	B641H	1	Hand Nut
5	B792D24	1	Index Disc
6	B820S	1	Swivel
7	B822B	1	Clamp Bar Assembly
8	B942B	1	Base
9	B942C	1	Index Collar
10	B942DC	1	Spindle Drive Collar
11	B942H	1	Housing
12	B942R	2	Thrust Ring
13	B942S	1	Spindle
14	B942T	4	T-Slot Block
15	B942W	1	Wavy Spring Washer
16	P943HB	1	Threaded Bushing
17	B943L	1	Lock Screw Assembly
18	RR4-315	2	Spirolox Ring-Internal
19	91101PE6151	2	Ball Bearing
20	6-32 x 3/8	4	St. Round Head Screw
21	10-32 x 1/2	2	Flat Head Machine Screw (H.B.)
22	5/16 x 5/8 USS	1	Flex Socket Cap Screw
23	5/16 x 3/4 SAE	1	Hex Socket Cap Screw
24	3/8 Std.	2	Lock Washer (Lock Burred)
25	3/8 USS	2	Hex Nut (H)

**B942 Sensitive Workhead**



**ACCESSORIES FOR B942 SENSITIVE WORK HEAD**

Part No.	Description
B792D	Index Discs for B792C, B742C Collar, 4, 6, 8, 20, 24, 28, 30, 32, 34, 36, 38, 40, 42, 44, 48, 52, 54 and 56 Divisions. Special Index Discs with any number divisions will be furnished on request.
B941	Collet Fixture (For B942 only).
B641C	Collets for B641 and B941 Collet Fixture. Available sizes: 3/4" to 1" by 64ths, 1/8" to 11/64" inclusive by 64ths.
B641K	Straight Sleeves. Available sizes: 1 1/16", 1 1/8", 1 3/16", 1 1/4".

Part No.	Description
B642K	No. 11 B & S Adapter with standard Milling Machine Taper Socket for holding B & S Cam Lock Tapers. Available in Taper Nos. 10-20-30.
B642T	Taper Sleeves. Available sizes: Morse 1, 2, 3 and 4; B & S 5, 7, 8, 9 and 10.
B844E	Six inch Independent 4-jaw Chuck mounted on No. 11 B & S Arbor.
B944	4" 6-Jaw Adjustru Chuck mtd. on No. 11 B&S Arbor.
B946	4" 3-Jaw Adjustru Chuck mtd. on No. 11 B&S Arbor.



**B943, B2043  
MOTOR DRIVEN  
WORK HEADS**

**Available Voltages**

- 115V, 1 Phase, 60 Cycle
- 230V, 1 Phase, 60 Cycle
- 230V, 3 Phase, 60 Cycle
- 440V, 3 Phase, 60 Cycle

**PLEASE SPECIFY VOLTAGE**

**Spindle Speeds 150 and 250 RPM**

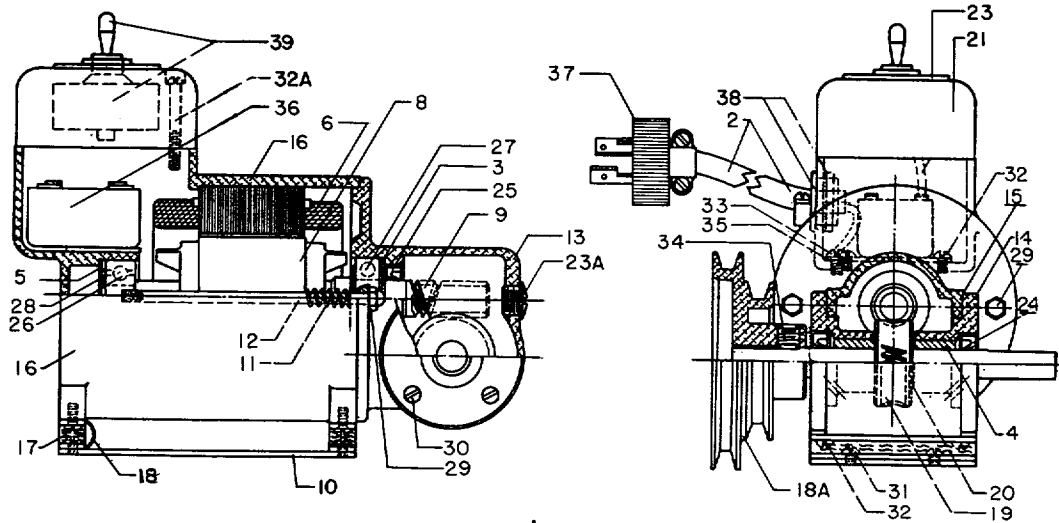
Other pulley combinations available:  
60 RPM to 450 RPM at extra cost



**ACCURACY**

**.0002 T.I.R.**

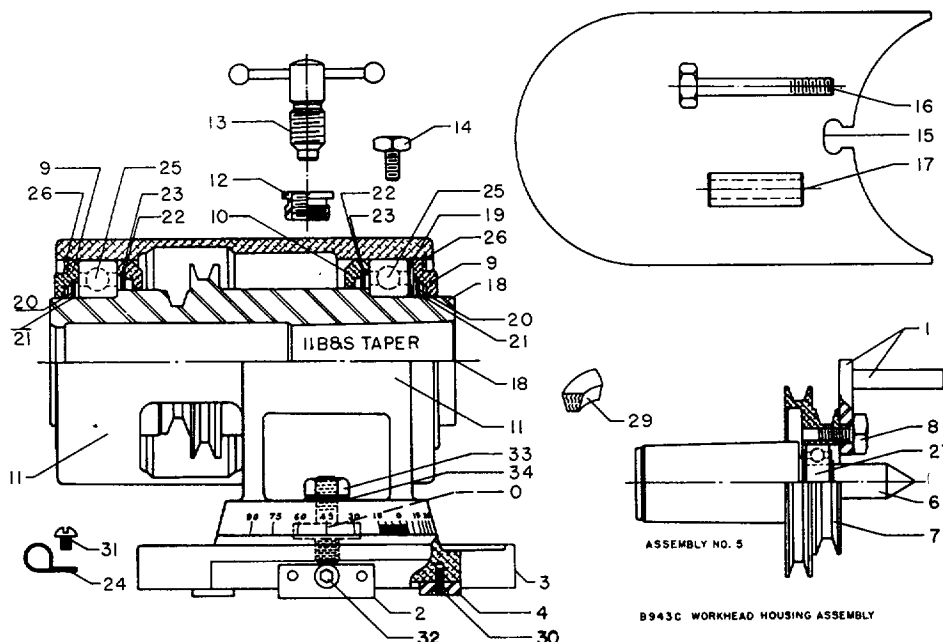
.0002 T.I.R. or less  
at spindle nose,  
.0005 or less on test  
arbor six inches from  
spindle nose.



Index No.	Part No.	Quan Req.	Description
2	A638E	1	Power Wire
3	B637W	1	Thrust Ring
4	B893BS	2	Bushing
5	B943AT	1	Thrust Washer
6	B943AF	1	Field (115V, 1 Phase)
6	B943EF	1	Field (230V, 3 Phase)
6	B943GAF	1	Field (440V, 3 Phase)
6	B943KF	1	Field (230V, 1 Phase)
6	B2043MF	1	Field (115V, 1 Phase) (B2043)
8	B943AR	1	Rotor (115V, 1 Phase)
8	B943ER	1	Rotor (230V, 3 Phase)
8	B943GAR	1	Rotor (440V, 3 Phase)
8	B943KR	1	Rotor (230V, 1 Phase)
8	B2043MA	1	Armature (115V, 1 Phase) (B2043)
9	B943MA	1	Armature Shaft
9	B2043MA	1	Armature Shaft (B2043)
10	B943MB	1	Saddle Plate
10	B2043MS	1	Saddle Plate (B2043)
11	B943EP	2	Field Positioner
11	B943MC	2	Spring
12	B943MDL	2	Stud
13	B943ME	1	End Bell
14	B943MF	2	Flange Bushing
15	B943MG	2	Gasket
16	B943MH	1	Motor Housing
17	B943MM	2	Resilient Motor Mount

Index No.	Part No.	Quan Req.	Description
18	B943MMG	1	Ground Strap
18A	B943MP	1	Motor Pulley
19	B943MW	1	Worm Wheel & Shaft Assembly
19	B2043MW	1	Worm Wheel & Sh. Assem. (B2043)
20	B943MX	1	Thrust Washer
21	B990B	1	Switch Box
23	KO-20	1	Plate
23A	P460S	1	Oil Plug
24	63 x49	2	Seal (1/2 x 1 x 5/16)
25	63 x 87	1	Seal (5/8 x 1 1/8 x 5/16)
26	39KVTD	1	Ball Bearing
27	202KLL3	1	Ball Bearing
28	5Z	1	Spring
29	8-32	2	Acorn Nut (N.P.)
30	6-32 x 3/8	8	Round Head Machine Screw N.P.
31	8-32 x 3/16	4	Round Head Machine Screw
32	8-32 x 5/8	4	Round Head Machine Screw
32A	8-32 x 1 5/8	2	Round Head Machine Screw H.B.
33	8-32 x 1/4	1	Round Head Brass Machine Screw
34	7/16 x 7/16 N.C.	1	Hex Socket Flat Point Set Screw
35	36 Std.	1	Lock Washer
36	91252-45	1	Starting Switch (115V)
36	91252-250	1	Starting Switch (230V)
37	9967	1	Gasket
38	6623	1	3/8 Romex Connector
39	7612K2	1	Switch

### B943C Work Head Housing Assembly



Index No.	Part No.	Quan Req.	Description
0	B620R	1	Stud
2	B822B	1	Clamp Bar Assembly
3	B942B	1	Base
4	B942T	4	T-Slot Block
5	B943D	1	Dead Center Assembly
9	B943F	2	Outer Bearing Seal
10	B943G	2	Inner Bearing Seal
11	B943H	1	Workhead Housing
12	B943HB	1	Threaded Bushing
13	B943L	1	Lock Screw Assembly
14	B943MR	2	Saddle Hold Down Screw
15	B943PG	1	Belt Guard
16	B943PS	1	Special Screw
17	B943PT	1	Guard Spacer
18	B943S	1	Spindle
19	B943W	1	Wavy Spring Washer
20	B943YA	2	Plya Seal
21	B943YB	2	Cap
22	B943YC	2	Plya Seal
23	B943YD	2	Cap
	2581-043	1	O-Ring (3 1/2 x 3 5/8 x 1/16)

Index No.	Part No.	Quan Req.	Description
24	EC8	1	Wire Clamp
25	2MM9112WICRDU	1 pr.	Ball Bearing Duplex
26	RR-375	2	Spirolox Ring-Internal
29	B943VB	1	Belt, Standard Belt
	B943VBL		Belt, Long Belt (for B943MPL)
	B943VBS		Belt, Short Belt (for B943MPL)
	1220	1	V-Belt
30	6-32 x 1/8	4	St. Round Head Screw
31	10-32 x 1/4	1	Round Head Machine Screw (H.B.)
32	5/16 x 3/4 SAE	1	Hex Socket Cap Screw
33	3/8 USS	1	Hex Nut (H)
34	3/8 SAE	1	Washer (H)

**B943D DEAD CENTER ASSEMBLY**

1	B643TR	1	Drive Pin Assembly
6	B943DC	1	Dead Center
7	B943DP	1	Dead Center Pulley
8	B943DS	1	Special Screw
27	202KLL3	1	Ball Bearing

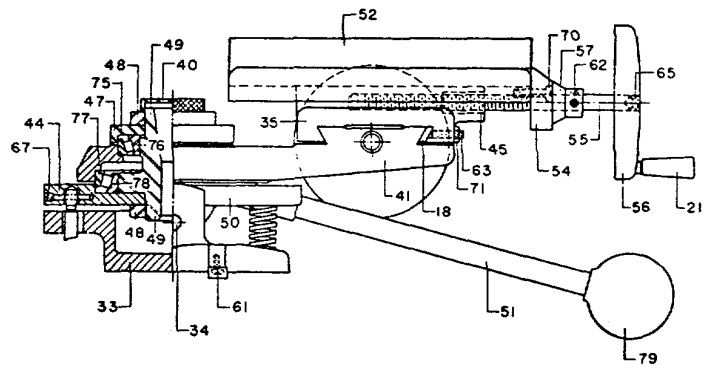
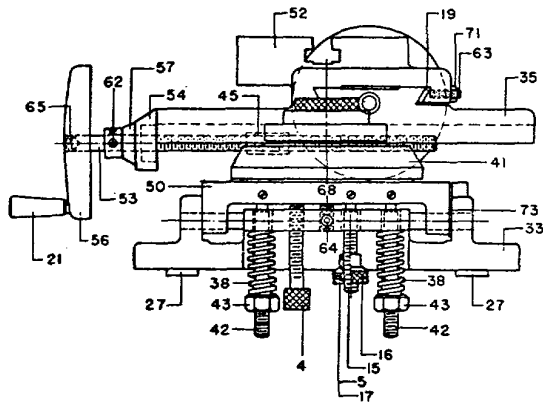
### ACCESSORIES FOR B943 MOTOR DRIVEN WORK HEAD

Part No.	Description
B641	Collet Fixture
B641C	Collets for B641 Collet Fixture. Available sizes: 3/16" to 1" by 64ths, 1/8" to 11/64" by 64ths.
B641K	Straight Sleeves. Available sizes: 1 1/16", 1 1/8", 1 3/16", 1 1/4".
B641B&S	No. 12 B&S Collet Fixture for B943 Head with No. 12 B&S Spindle.
B641AB&S	No. 12 B&S Adaptor, Collet nosepiece for 5C Collets, used with B641B&S.
B641M	No. 5 M.T. Collet Fixture required for B943 Head with No. 5 Morse Taper Spindle.
B641AM	No. 5 M.T. Adaptor, Collet nosepiece for 5C Collets, used with B641M.
B642TB&S	Taper Sleeves, 12 B&S Outside to 1, 2, 3, 4 Morse I.D.; 5, 7, 9, 10, 11 B&S I.D.
B642TM	Taper Sleeves, 5 Morse Outside to 1, 2, 3, 4 Morse I.D.; 5, 7, 9, 10, 11 B&S I.D.

Part No.	Description
B642K	No. 11 End Adaptor with standard Milling Machine Taper Socket for holding B&S Cam Lock Tapers. Available in taper Nos. 10, 20 and 30.
B642T	Taper Sleeves. Available sizes: Morse 1, 2, 3 and 4; Brown and Sharp 5, 7, 8, 9 and 10.
B643T	Center and Drive Plate Assembly can be used as live center and drive plate.
B844E	6" 4-Jaw Independent Chuck mounted on No. 11 B&S Arbor.
B943DF	No. 11 B&S Dead Center with Carbide Tip.
B943DB	No. 12 B&S Dead Center.
B943DM	No. 5 M.T. Dead Center.
B944	4" 6-Jaw Adjustru Chuck.
B946	4" 3-Jaw Adjustru Chuck mounted on A643P No. 11 B&S Arbor.
B981	Collet Fixture Quick Release.

**B985 and BA985 Radial Grinding Fixtures**

PARTS WITHOUT INDEX NUMBERS ARE SHOWN IN STANDARD EQUIPMENT PHOTO ON PAGE 9.  
REFER TO B942 PARTS LIST ON PAGE 5 FOR B985H HOUSING AND SPINDLE ASSEMBLY PARTS.



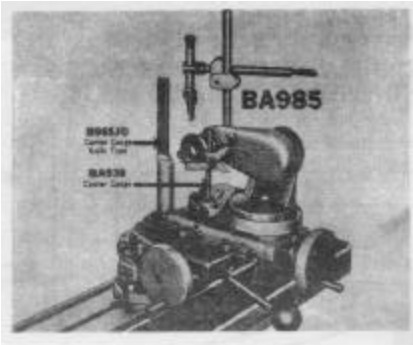
Index No.	Part No.	Quan Req.	Description
	A280	1	Friction Collar
	A281	1	Friction Collar
	A290A	2	Table Adjusting Screw Assembly
4	A290AS	1	Table Adjusting Screw
5	A630BS	1	Comp. Spring
	A657B	3	T-Slot Bolt
	A660B	1	T-Slot Bolt
	B620D	1	Back Plate
	B620G	1	Swivel Stud
	B684N	1	Nut
	B684S	1	Diamond Screw
	B685B1	1	Cutter Bushing, 7/8"
	B685B2	1	Cutter Bushing, 1"
	B685B3	1	Cutter Bushing, 1 1/4"
15	B685L	1	Lock Screw
16	B685N	1	Thumb Nut
17	B685NP	1	Plug
18	B685WG	1	Gib for Lower Slide
	B685WP	2	Gib Pin
19	B685XG	1	Gib for Upped Slide
21	B685YH	2	Ball Crank Handle
	B820S	1	Swivel
	B840P	1	Swivel Block
	B923EF	1	Keyed Wheel Flange
	B923EN	1	Special Nut
27	B942T	2	T-Slot Block
	B985A	1	Swinging Arm (B985)
	B985AA	1	Swinging Arm (BA985)
	B985AB	1	Swivel Index Bar
	B985AE	1	Diamond Holder
33	B985B	1	Base
34	B985BS	2	Base Stud
35	B985C	1	Cross Slide (B985)
	BA985C	1	Cross Slide (BA985)
	B985D	1	Guide Bushing
	B985E	1	Stud
	B985EA	1	Adjustable Stud (BA985)
38	B985G	4	Spring
	B985J	1	Center Gauge (V-Type)
	B985JG	1	Center Gauge (Knife Type)
	B985JP	1	Cap for Center Gauge
41	B985K	1	Turn Table (B985)
	BA985K	1	Turn Table (BA985)
42	B985L	2	Lock Screw

Index No.	Part No.	Quan Req.	Description
43	B985LN	2	Lock Screw Nut
44	B985LP	3	Lock Screw Pivot Pin
45	B985M	2	Feed Nut
47	B985PC	1	Pivot Cap
48	B985PN	2	Pivot Cap Nut
49	B985PS	1	Pivot Stud
50	B985S	1	Saddle
51	B985SA	1	Lever Arm
52	B985T	1	Table
53	B985W	1	Feed Screw Assembly
54	B985WB	2	Bearing Block (B985)
	BA985WB	2	Bearing Block (BA985)
55	B985X	1	Feed Screw Assembly (Long)
56	B985YA	2	Hand Wheel
57	B985Z	2	Index Collar
	BA985ZC	2	Thrust Collar (BA985)
	BA985ZH	2	Index Collar (BA985)
	BA985ZW	2	Wavy Spring Washer (BA985)
61	6-32 x 3/8	2	S. T. Round Head Screw
62	10-32 x 3/16	4	Socket Set Screw
63	10-32 x 3/4	9	Socket Set Screw (B985)
	BA985XA	4	Handle (BA985)
	BA985XH	4	Head (BA985)
	BA985XS	4	Screw (BA985)
64	1/4 x 1/4 SAE	1	Socket Set Screw
65	3/8 x 3/8 SAE	2	Socket Set Screw (Cone Point)
67	6-32 x 3/16	3	Headless Set Screw
68	5/16 x 5/8 USS	1	Headless Set Screw
70	10-32 x 5/8	4	Fill Head Machine Screw
71	10-32	9	Hex Nut (HB)
73	3/8 L. W.	4	Wavy Spring Washer
75	13836	1	Cup (Timken)
76	13889	1	Cone (Timken)
77	LL510710	1	Cup (Timken)
78	LL510749	1	Cone (Timken)
79	44E	1	Ball
	2 x 1/8	2	S. T. Rd. Head Screw N.P. (BA985)
	7/16 x 7/16 USS	1	Socket Set Screw
	5/16 x 5/16 USS	2	Socket Set Screw (Cup Pt.) (BA985)
	3/8 x 1 1/4 USS	1	Hex Socket Cap Screw
	3/8 USS	5	Hex Nut (H)
	3/8 SAE	3	Washer (H)
	RS75	2	Spirolox (BA985)

**ACCESSORIES FOR B986 AND BA986 RADIAL GRINDING FIXTURES**

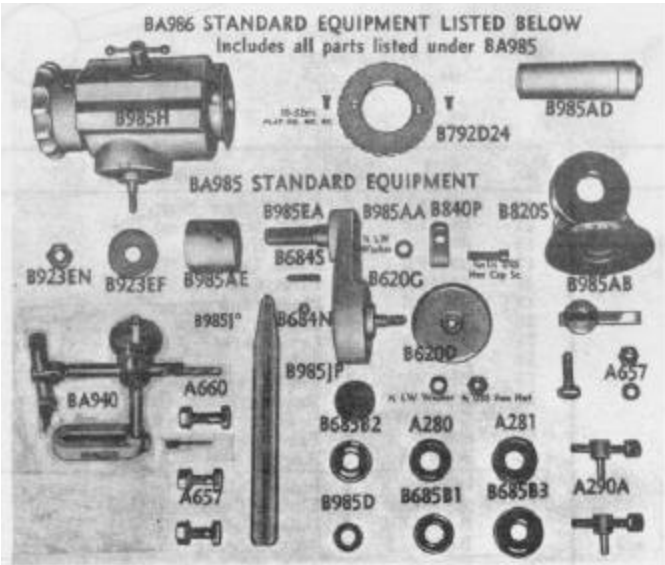
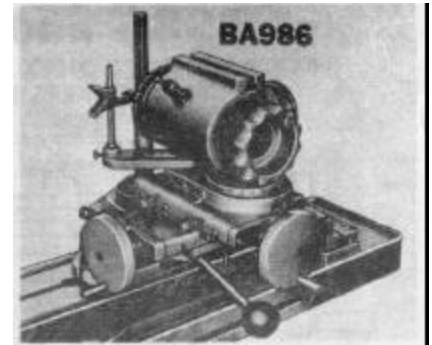
Part No.	Description
B792D	Index Discs 4, 6, 8, 20, 24, 28, 30, 32, 34, 36, 38, 40, 42, 44, 48, 52, 54 and 56 divisions available.
B941	Collet Fixture.
B641C	Collet for B941 Fixture. Available sizes: 3/16" to 1/2" by 64ths; 17/22" to 1" by 32nds.
B641K	Straight Sleeves. Available sizes: 1 1/16", 1 1/18", 1 3/16" and 1 1/4".
B642K	No. 11 B & S Adaptor with Standard Milling Machine Taper Socket for holding B & S Cam Lock Tapers. Available in taper Nos. 10, 20 and 30.

Part No.	Description
B642T	Adaptor Sleeves. Available sizes: Morse 1, 2, 3 and 4; B&S 5, 7, 8, 9 and 10.
B844E	6" 4-Jaw Independent Chuck mounted on No. 11 B&S Arbor.
B941	Collet Fixture
B944	Adjustu 4" 6-Jaw Chuck mounted on No. 11 B&S Arbor.
B946	4" 3-Jaw Universal Chuck mounted on No. 11 B&S Arbor.



**Radial Grinding Fixtures**

**REFER TO B942 PARTS LIST ON PAGE 5 FOR B985H HOUSING AND SPINDLE ASSEMBLY PARTS.**



**BA985 Radial Grinding Fixture Standard Equipment**

**A280** Friction Collar, **A281** Friction Collar, **A290A** Table Adjusting Screw, **A657** **A660** T-Slot Bolts, **B620D** Back Plate, **B620G** Swivel Stud. **B684N** Nut, **B684S** Diamond Screw, **8685B1** 7/8" Cutter Bushing, **8685B2** 1" Cutter Bushing, **8685B3** 1 3/4" Cutter Bushing. **B820S** Swivel, **B840P** Swivel Block, **B923EF** Keyed Wheel Flange, **8923EN** Special Nut, **BA940** Tooth Rest, **B985AA** Swinging Arm, **B985AB** Swivel Index Bar, **B985AE** Diamond Holder, **B985D** Guide Bushing, **B985EA** Stud 3/4", **B985J** Center Gauge (optional, not std.), **B985JP** Cap (**BA939** Center Height Gauge, **89851G** Center Gauge, Knife Type, are shown in **BA985** photo upper left.) Net Weight 51 lbs.

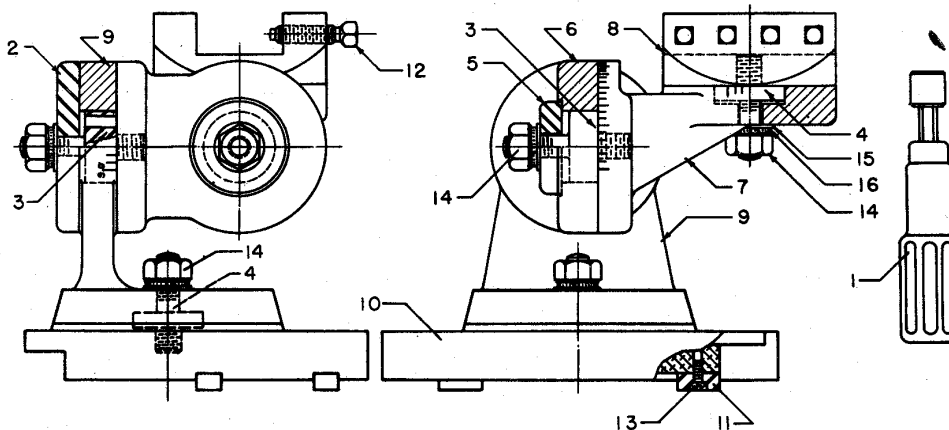
**BA986 Radial Grinding Fixture Standard Equipment**

**Includes all equipment listed for BA985 Model and the following: B792D24** Index Disc, **B985AD** Diamond Holding Arbor, **B985H** Housing and Spindle Assembly.

**Available Equipment**

**B792D** Index Discs 4, 6, 8, 20, 24, 28, 30, 32, 34, 36, 38, 40, 42, 44, 48, 52, 54, 56 divisions available. **B941** Collet Fixture, **B641C** Collets for B941 Fixture. Available sizes: 3/16" to 1" by 64ths, 1/64" to 11/64", by 64ths. **B641K** Straight Sleeves. Available sizes: 1 1/16", 1 1/8", 1 3/8" and 1 1/4". **B642K** No. 11 B & S Adaptor with Standard Milling Machine Taper Socket for holding B & S Cam Lock Tapers. Available in taper Nos. 10, 20 and 30. **B642T** Adaptor Sleeves. Available sizes: Morse 1, 2, 3 and 4; B & S 5, 7, 8, 9 and 10. **B844E** 6" 4-law Independent Chuck mounted on No. 11 B & S Arbor. **B944** Adjustu 4" 6-Jaw Chuck mounted on No. 11 B & S Arbor. **B946** 4" 3-Jaw Universal Chuck mounted on No. 11 B & S Arbor.

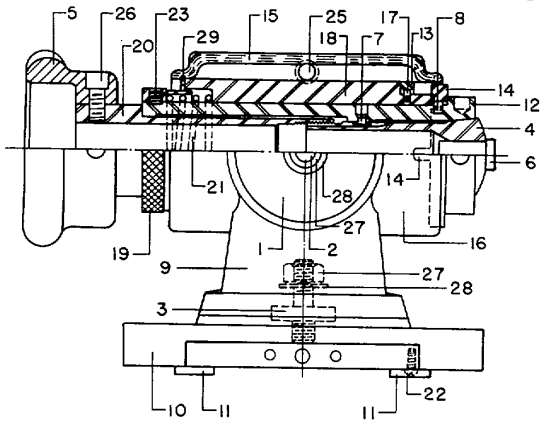
**B989 UNIVERSAL WORK HOLDING FIXTURE**



Index No.	Part No.	Quan Req.	Description
1	A264	1	Socket Wrench
2	B620D	1	Back Plate
3	B620G	2	Swivel Stud
4	B620R	1	Base Stud
5	B789E	1	Special Washer
6	B789S	1	Universal Swivel
7	B789V	1	Vise Swivel
8	B789XB	1	Vise Block (1-1/2)

Index No.	Part No.	Quan Req.	Description
9	B820S	1	Swivel
10	B942B	1	Base
11	B942T	4	T-Slot Block
12	5/16 x 2 USS	4	Square Head Cup Point Set Screw
13	6-32 x 3/8	2	St. Round Head Screw
14	3/8 USS	4	Hex Nut (H)
15	3/8 SAE	4	Washer (H)
16	3/8 Std.	4	Lock Washer (Lock Burred)

**B947 Tap Grinding Fixture**



**STANDARD EQUIPMENT**

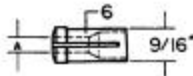
B641C	9/16 Collet	B647B54	Bushing - Tap 5/8
B647B8	Bushing-Taps 7 and 8	B947C2	Flute 0 to 12 Tap
B647B10	Bushing-Taps 9 and 10	B947C2	Flute 12 and over Tap
B647B12	Bushing-Taps 12	B947C3	to 6 Flute 0 to 12 Tap
B647B1/4	Bushing-Tap 1/4	B947C3	to 6 Flute 12 to 3/8 Tap
B647B5/16	Bushing-Tap 5/16	B947C3	to 6 Flute 3/4 and over Tap
B647B3/8	Bushing-Tap 3/8	B947C3	to 6 Flute 3/8 to 3/4 Tap
B647B7/16	Bushing-Tap 7/16	B947D2	Index Disc (2 Flute)
B647B1/2	Bushing-Tap 1/2	B947D3	Index Disc (3 Flute)
B647B9/16	Bushing-Tap 9/16	B947D4	Index Disc (4 Flute)

**AVAILABLE ACCESSORIES**

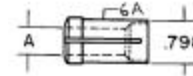
B641C800	.800" Collet to fit 1" Tap	B947CL2	Flute 0 to 12 Tap
B647F	Bushings for B641C800 Collet to fit 1 1/16", 3/4" and 7/8" Taps	B947CL2	Flute 12 and over Tap
B647B	Bushing Taps 0 to 6 incl.	B947CL3	to 6 Flute 0 to 12 Tap
B647P	Driver for Taps over 1"	B947CL3	to 6 Flute 12 to 3/8 Tap
A261G Spring Center, B821 or B922R		B947CL3	to 6 Flute 3/8 to 3/4 Tap
Tail Stock must be used with B647P.		B947CL3	to 6 Flute 3/4 and over Tap
		B947D5	Index Disc (5 Flute)
		B947D6	Index Disc (6 Flute)

Index No.	Part No.	Quan Req.	Description
1	B620D	1	Back Plate
2	B620G	1	Swivel Stud
3	B620R	1	Base Stud

Index No.	Part No.	Quan Req.	Description
7	B647KS	1	Key for Collet
8	B647KT	1	Key for Index Disc
9	B820S	1	Swivel



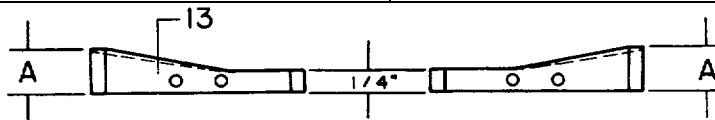
Index No.	Part No.	Quan Req.	A size Size	Description
6	B647B6	1	.140	Bushing - Taps 0 to 6
6	B647B8	1	.168	Bushing - Taps 7 and 8
6	B647B10	1	.194	Bushing - Taps 9 and 10
6	B647B12	1	.220	Bushing - Tap 12
6	B647B1/4	1	.255	Bushing - Tap 3/4
6	B647B5/16	1	.318	Bushing - Tap 5/16
6	B647B3/8	1	.381	Bushing - Tap 3/8



Index No.	Part No.	Quan Req.	A size Size	Description
6	B647B7/16	1	.323	Bushing - Tap 7/16
6	B647B1/2	1	.367	Bushing - Tap 1/2
6	B647B9/16	1	.429	Bushing - Tap 9/16
6	B647B5/8	1	.480	Bushing - Tap 5/8
6A	B647F11/16	1	.542	Bushing for B641C800 Collet
6A	B647F3/4	1	.590	Bushing for B641C800 Collet
6A	B647F7/8	1	.697	Bushing for B641C800 Collet

Index No.	Part No.	Quan Req.	Description
7	B647KS	1	Key for Collet
8	B647KT	1	Key for Index Disc
9	B820S	1	Swivel

Index No.	Part No.	Quan Req.	Description
10	B942B	1	Base
11	B942T	4	T-Slot Block
12	B947A	1	Collet Adapter



Right Hand Lift Cam

Left Hand Lift Cam

Index No.	Part No.	Description	A Size
13	B947C2	Flute 0 to 12 Tap	.275
13	B947C2	Flute 12 and over Tap	.355
13	B947C3	to 6 Flute 0 to 12 Tap	.281
13	B947C3	to 6 Flute 12 to 3/8 Tap	.375
13	B947C3	to 6 Flute 3/8 to 3/4 Tap	.468
13	B947C3	to 6 Flute 3/4 and over Tap	.562

Index No.	Part No.	Description	A Size
13	B947CL2	Flute 0 to 12 Tap	.275
13	B947CL2	Flute 12 and over Tap	.355
13	B947CL3	to 6 Flute 0 to 12 Tap	.281
13	B947CL3	to 6 Flute 12 to 3/8 Tap	.375
13	B947CL3	to 6 Flute 3/8 to 3/4 Tap	.468
13	B947CL3	to 6 Flute 3/4 and over Tap	.562

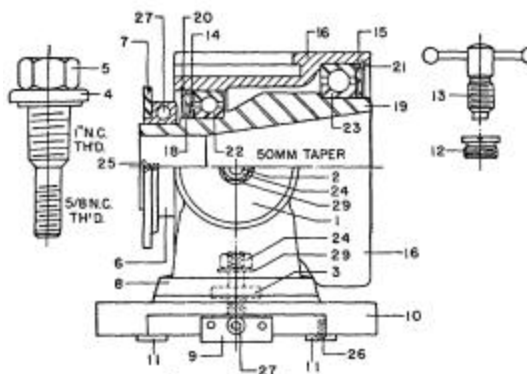


Index No.	Part No.	Quan Req.	Description
14	B947D2	1	Index Disc (2 Flute)
14	B947D3	1	Index Disc (3 Flute)
14	B947D4	1	Index Disc (4 Flute)
14	B947D5	1	Index Disc (5 Flute)
14	B947D6	1	Index Disc (6 Flute)
15	B947F	1	Felt
16	B947H	1	Housing

Index No.	Part No.	Quan Req.	Description
17	B947R	2	Cam Retainer Pin
18	B947S	1	Spindle
19	B947T	1	Thrust Collar
20	B947W	1	Draw Tube
21	B947Y	1	Coil Spring
22	6-32x 3/8	4	S. T. Round Head Screw (N.P.)
23	1/4 x 1/4 SAE	1	Socket Set Screw
25	5/16 x 1 SAE	1	Hex Socket Cap Screw
26	5/16 x 5/8 USS	1	Hex Socket Cap Screw
27	3/4 USS	2	Hex Nut (H)
28	3/8 Std.	2	Lock Washer (L.B.)
29	RR-275	1	Spirolox-Internal

**B992  
Sensitive  
Work Head**

**NO. 50  
MILLING MACHINE  
TAPER IN SPINDLE**



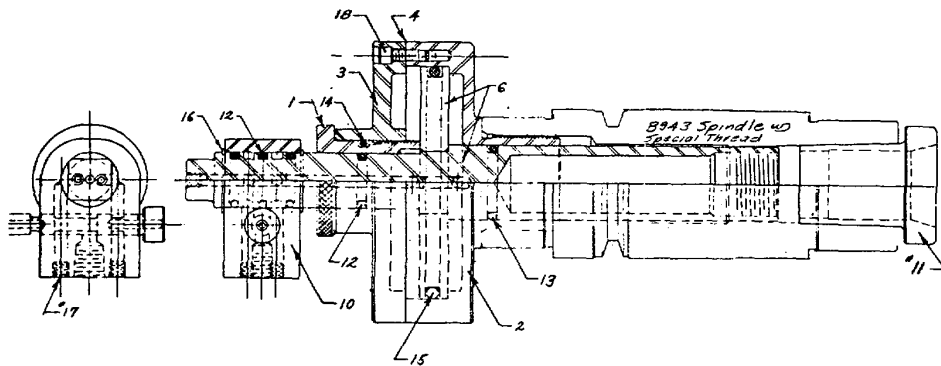
Index No.	Part No.	Quan Req.	Description
1	B620D	1	Back Plate
2	B620G	1	Swivel Stud
3	B620R	1	Stud
4	B792BC	1	Collar
5	B792BD	1	Draw Bolt
6	B792C	1	Index Collar
7	B792D24	1	Index Disc
8	B820S	1	Swivel
9	B822B	1	Clamp Bar Assembly
10	B942B	1	Base
11	B942T	4	T-Slot Block
12	B943HB	1	Threaded Bushing
13	B943L	1	Lock Screw Assembly
14	B943W	2	Wavy Spring

Index No.	Part No.	Quan Req.	Description
15	B992A	1	Bearing Shield
16	B992H	1	Housing
18	B992R	1	Thrust Ring
19	B992S	1	Spindle
20	RR.375	1	Spirolox Ring
21	RR-511	1	Spirolox Ring
22	2MM9112	1	Ball Bearing
23	2MM9117	1	Ball Bearing
24	3 USS	2	Hex Nut (H)
25	10-32 x 1/2	2	Flat Head Machine Screw
26	6-32 x 3/8	4	S. T. Round Head Screw
27	5/16 x 3/4 SAE	1	Hex Socket Cap Screw
29	3/8 L. W.	2	Wavy Spring
	2 x 1/8	2	S. T. Round Head Screw

**ACCESSORIES FOR B992 SENSITIVE WORK HEAD**

Part No.	Description
B792D	Index Discs for B792C, B942C Collar. 4, 6, 8, 20, 24, 28, 30, 32, 34, 36, 38, 40, 42, 44, 48, 52, 54 and 56 Divisions. Special Index Discs with any number divisions will be furnished on request.

Part No.	Description
B792F	50 to 40 Milling machine taper sleeve.
B792G	No. 50 Milling Machine to No. 11 B & S taper Sleeve with B792T drawing sleeve.
B792T	Drawing Sleeve for use with B792G Taper Sleeve.



**B994  
Air Chuck**

Index No.	Part No.	Quan Req.	Description
1	B994A	1	Adjustable Stop
2	B994B	1	Body
3	B994C	1	Cover
4	B994G	1	Gasket
5	B994N	1	Name Plate
6	B994P	1	Piston and Draw Sleeve Assembly
10	B994V	1	Valve Block Assembly

Index No.	Part No.	Quan Req.	Description
11	B641AA	1	Collet Adapter
12	8210	4	O-Ring (3/4 x 1 x 1/8)
13	8216	1	O-Ring (1 1/8 x 1 3/8 x 1/8)
14	8218	1	O-Ring (1 1/4 x 1 1/2 x 1/8)
15	8343	1	O-Ring (3 3/4 x 4 1/8 x 3/16)
16	RS100	2	External Spirolox
17	10-32 x 1/4	2	Socket Set Screw
18	10-32 x 5/8	6	Hex Socket Cap Screw

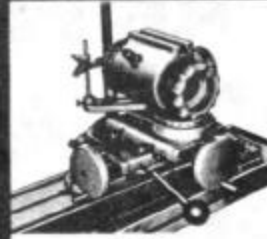
# K-O Engineers Make Available More Time-Tested Fixtures Than Any Other Grinder Manufacturer



**B942 SENSITIVE WORK HEAD**



**B943 MOTOR DRIVEN WORK HEAD**



**B996 RADIAL GRINDING FIXTURE**



**B992 SENSITIVE WORK HEAD**



**B945 TILTING TABLE ATTACHMENT**



**B989 UNIVERSAL WORK HOLDING FIXTURE**



**B947 TAP GRINDING FIXTURE**



**B979 UNIVERSAL ANGULAR MOTOR MOUNT**



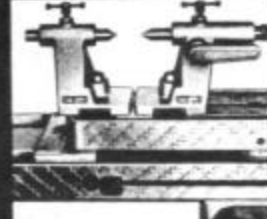
**CHUCKS  
B944 4" 6-JAW ADJUSTRU  
B946 4" 3-JAW ADJUSTRU**



**B844E 6" INDEPENDENT 4-JAW CHUCK  
NO. 11 B & S ARBOR**



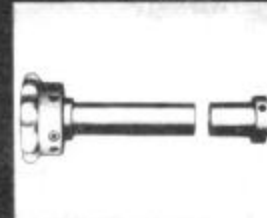
**2898 WAY LUBE QUART  
3890 WAY LUBE GALLON  
2870 SPINDLE OIL PINT  
3879 COOLANT CONCENTRATE PT.  
3842 GRAY HAMMER SPRAY CAN  
2822 WORN GEAR LUBE QUART**



**B922 TAILSTOCKS (MATCHED SET)**



**B948 SERIES CUTTER AND HOB GRINDING ARBORS**



**B641 AND B941 COLLET FIXTURE**



**B641C COLLETS FOR B641 & B941 FIXTURES**



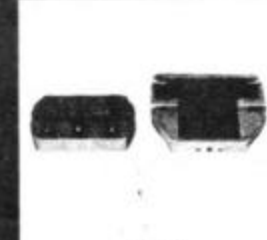
**SHELL END MILL AND CUTTER ARBOR**



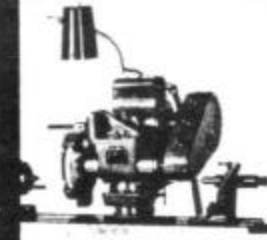
**B641K GHT SLEEVES**



**B269 RADIAL DIAMOND DRESSER WITH P1760 DIAMOND SCREW**



**B918 TWO 1" RAISING BLOCKS**



**B955 UNIVERSAL GRINDING HEAD**

**PARTS LIST  
FOR**

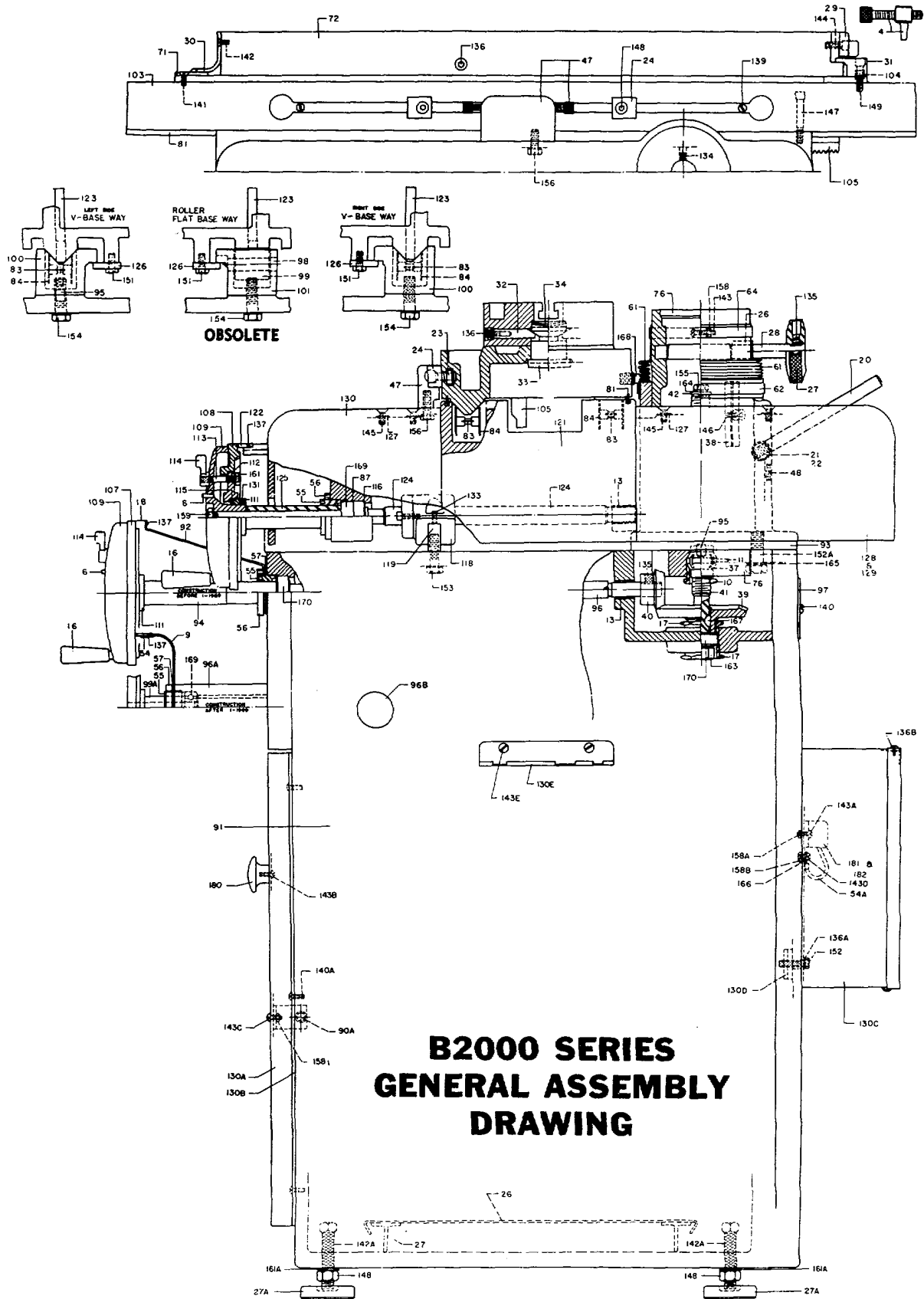
**B2000 SERIES**

★

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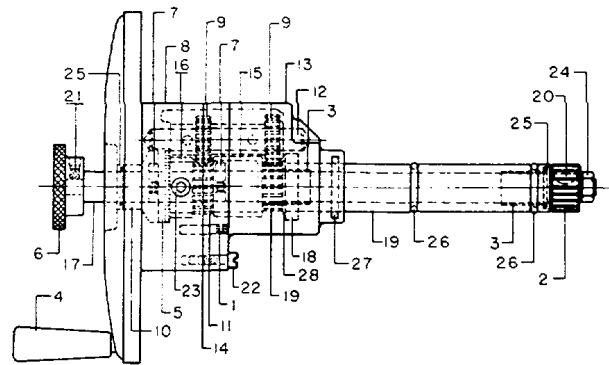


**B2000 SERIES  
GENERAL ASSEMBLY  
DRAWING**

Index No.	Part No.	Description
4	A290A	Table Adjusting Screw
6	A636P	Knurled Pin
9	B330BP	Pointer Bracket
10	B624S	Compression Nut
11	B625P	Knurled Plug
13	B629M	Bushing
16	B712H	Handle
17	B805M	Adjusting Nut
18	B805P	Indicator Plate
19	B805R	Base Stud (out)
20	B805SH	Handle
21	B805SS	Screw
22	B805W	Adjusting Washer
23	B810P	T-Slot Plate
24	B810W	Adjustable Stop
26	B813B	Bushing
27	B813H	Knurled Hand Nut
28	B813S	Eccentric Shaft
29	B815A	Adjusting Screw Pad
30	B815B	Pointer
31	B815C	Clamp Bar
32	B815P	Swivel Lock Pin
33	B815S	Swivel
34	B815X	Plug
37	B824N	Feed Nut
38	B825K	Key
39	S626G	Gear
40	S626P	Pinion
41	B826S	Elevating Screw
42	B826W	Stop Washer
47	B830B	Step Block
48	B830Y	Felt Strip
54	BA805P	Indicator Plate
54A	B865BG	Ground Wire (Green)
55	BA805N	Lock Nut
56	BA805R	Lock Ring
57	BA805Y	Washer
61	B905BA	Accordion Sleeve
62	B905BL	Long Clamp Band
64	B905BS	Short Clamp Band
71	B910T	Index Plate
72	B2015	Top Table
76	B925	Column
81	B930HE	Saddle Way Dust Shield
83	B930RP	Oil Roller Plate
84	B1030RR	Oil Roller
87	B9305W	Preload Washer
90	B960R	Rubber Pad (out)
90A	B965DC	Door Catch (old style)
	B965DD	Door Catch (new style)
90B	BA905BB	Plate for Tank
91	BA905B	Base
91A	BA905BT	
	or BA905BUS	Rail for Tank
92	BA905BP	Pointer Bracket
93	BA905C	Column Housing
94	BA905D	Spacer
95	BA905DP	Dowel Pin
96	BA905E	Handwheel Shaft
96A	BA905H	Housing
965	BA905HP	Hole Plug
90C	BA905GR	Leveling Pad
97	BA905	Back Plate
98	BA950RA	Roller Axle (out)
99	BA905RR	Roller (out)
99A	BA905S	Spacer
100	B2005WV	Baste Way - Vee
101	B2005WVVR	Base Way - Vee
102	BA905S	Base Stud
103	B2010	Sub Table
104	BA910B	Aligning Sleeve
105	B2010R	Rack
	BA912C	Handwheel Assembly (100 divisions)
107	BA912D40	Index Disc (40 divisions)
108	BA912D100	Index Disc (100 divisions)
109	BA912H	Handwheel
	BA912K	Handwheel Assembly (40 divisions)
111	BA912L	Lock Ring
112	BA912P	Lock Plate
113	BA912S	Stud

Index No.	Part No.	Description
14	BA912T	Thumb Nut
115	BA912W	Wavy Spring
116	BA917W	Bearing Shield
118	BA924	Feed Nut Assembly
119	BA924NB	Feed Bar
	BA929-1	Transmission (page 4)
121	B8030V	Saddle
122	BA930P	Indicator Plate
123	BA930R	Oil Reservoir
124	BA930SF	Feed Screw
125	BA930SS	Spacer
125	BA930T	Saddle Hold Down Plate
122	BA930W	Vellum Washer
121	BA930WL	Left Rear Saddle Way Shroud (out)
129	BA930WR	Right Rear Saddle Way Shroud (out)
130	BA930WC	Front Saddle Way Shroud (V and Flat)
130	BA930WC	Front Saddle Way Shroud (Double V)
130A	BA965DH	Door and Hinge Assembly
130B	BA966HS	Hinge Strip - obsolete
130C	BA967KB	Cutout Sox
1300	BA967KC	Clamp
130E	S890B	Wrench Rack
131	10-32 x 3/16	Socket Set Screw
133	10-32 x 1/2	Hex Socket Set Screw
134	1/4 x 1/4 SAE	Hex Socket Set Screw
135	5/16 x 5/16 USS	Hex Socket Set Screw, Cup Pt.
136	7/16 x 3/8 USS	Hex Socket Set Screw
136A	1/2 x 2 1/2 NC	Square Head Set Screw, Cup Pt.
136B	No. 6 x 3/8	S. T. Pan Head Screw, Type A
137	No. 2 x 1/8	S. T. Round Head Screw
	6-32 x 5/16	S. T. Flat Head Screw
139	10-32 x 5/16	S. T. Round Head Screw
140	10-32 x 3/8	S. T. Round Head Screw
140A	10-32 x 1/2	S. T. Round Head Screw
141	10-32 x 3/8	Flat Head Machine Screw (H.B.)
142	1/4 x 5/8 SAE	Flat Head Machine Screw (H.B.)
143	10-32 x 3/4	Round Head Machine Screw
143A	8-32 x 3/8	Round Head Machine Screw
143B	8-32 x 1/2	Round Head Machine Screw
143C	10-32 x 5/16	Round Head Machine Screw (HB)
143D	10-32 x 3/8	Round Head Machine Screw (Brass)
143E	10-32 x 1/4	Round Head Machine Screw
144	1/4 x 5/8 SAE	Fill Head Cap Screw
145	1/4 x 5/8 SAE	Flat Head Socket Cap Screw
146	1/4 X 5/8 SAE	Socket Head Cap Screw
147	1/4 x 1 1/2 SAE	Hex Socket Cap Screw
148	5/16x 3/4 SAE	Hex Socket Cap Screw
149	5/16 x 1 SAE	Hex Socket Cap Screw
	5/16 x 3 1/2 USS	Hex Socket Cap Screw
151	1/4 x 1/2 SAE	Hex Cap Screw
	5/16 x 7/8 SAE	Hex Cap Screw
152	1/4 x 1 NF	Hex Cap Screw
152A	1/2 x 2 NC	Hex Cap Screw
153	3/8 x 1 1/4 SAE	Hex Cap Screw
154	7/16 x 1 1/4 SAE	Hex Cap Screw
155	5/16 x 1/2 USS	Hex Cap Screw
156	5/16 x 1 USS	Hex Cap Screw
158	10-32	Hex Nut (H.B.)
158A	8-32	Hex Nut (HB)
158B	10-32	Hex Nut (Brass)
159	7/16 SAE	Hex Jam Nut (H.B.)
160	1/2 SAE	Hex Nut
160A	1/2 NC	Hex Jam Nut
161	1/4 USS	Hex Jam Nut (H.B.)
	3/8 USS	Hex Nut (H)
163	1/2 USS	Hex Nut
163A	1/4 Std.	Lock Washer
164	5/16 Std.	Lock Washer
165	1/2 Std.	Lock Washer
165A	1/2	Shakeproof Washer
	3/8 SAE	Washer (H)
166	3/16 Std.	Lock Washer
167	No. 2	Woodruff Key 3/32 x 1/2
168	1/4	Pipe Plug
169	201KTD	Ball Bearing
170	202KLL3	Ball Bearing
180	3006B	Knob - obsolete
181	CR151C10	End Block
182	CR151C2200	Box Terminal Block

**BA929 AND  
BA929-1  
TABLE  
TRANSMISSION  
ASSEMBLY**

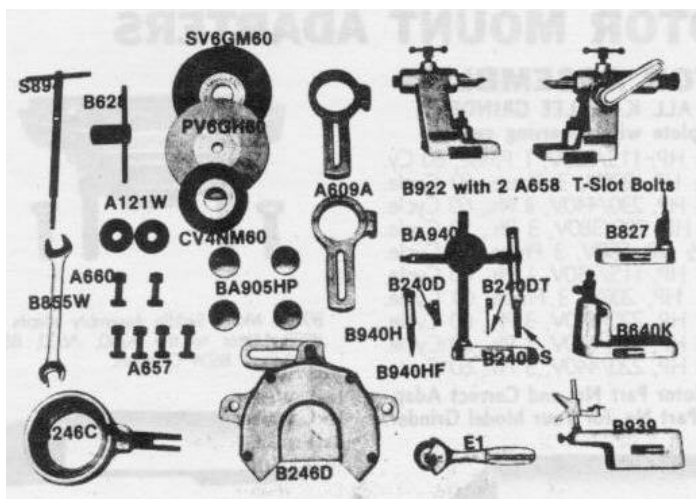


Index No.	Part No.	Description
1	A629J	Knurled Pin
2	B610KG	Pinion Gear
3	AA-710-16	Oilite Bearing
4	B712H	Handle
4	* B8298	Handle
5	B829CJ	Clutch Jaw
6	B829K	Control Knob
7	B829T	Drive Pin
8	B929C	Cover (obsolete)
8	BA929C	Cover
	* BA929CS	Bearing Shield
	BA929A	Adjustable Crank Arm
9	B929CA	Cluster Gear
10	B929CB	Cover Bushing
11	B929CG	Cover Gasket
12	B929C5	Cluster Gear Shaft
13	B929H	Housing
14	B929L	Drive Gear
15	B929LL	Drive Gear Spacer- Long

Index No.	Part No.	Description
16	B929LS	Drive Gear Spacer - Short
17	BA929S	Drive Shaft (BA929)
17	B6029S	Drive Shaft (BA929-1)
18	B929W	Thrust Collar
19	BA929Y	Stationary Shaft (BA929)
19	B6029Y	Stationary Shaft (BA929-1)
20	No. 2	Woodruff Key
21	10-32 x 3/16	Hex Socket Set Screw
22	10-32 x 5/8	Fill. Head Machine Screw
23	1/8 Briggs	Socket Pipe Plug
24	3/8 SAE	Hex Nut
25	856-40-2	Oil Seal - Trostel Packing 5/8 x 7/8 x 1/8
26	8210	O-Ring (1/8 x 3/4 x 1)
27	8215	O-Ring (1/8 x 1 1/16 x 1 5/16)
28	RS-100	Spirolox
	S7KD	Ball Bearing
	* 5629L	Lock Screw
	* 5/16 SAE	Hex Jam Nut (H.B.)
	* 5/16 Std.	Lock Washer

\*Used on BA929 Table Transmission Assembly with Adjustable Crank Arm

**B2000 SERIES STANDARD EQUIPMENT**



**STANDARD EQUIPMENT FOR MODEL B2060**  
**A657** T-Slot Bolt, **A660** T-Slot Bolt, **B640K** Diamond Dresser, **B827** Plain Tooth Rest, **B922** Tail Stock (Matched Set), **B939** Center Gauge, **BA940** Universal Tooth Rest, **B955** Universal Grinding Head, **E1** Wheel Dresser.

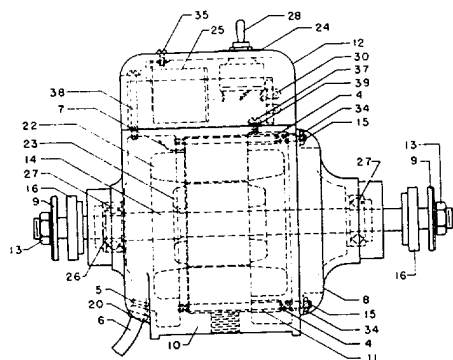
**STANDARD EQUIPMENT  
FOR MODEL 82000**

**A609A** T-Slot Arm, **A657** T-Slot Bolt (4), **A660** T-Slot Bolt (2), **B246C** Wheel Guard 4", **B246D** Wheel Guard 6", **B628** Wrench, **B640K** Diamond Dresser, **B827** Plain Tooth Rest, **B855W** Wrench, **B8569** Bracket, **B922** Tailstocks (Matched Set) with two A258 T-Slot Bolts, **B923G** Motor Assembly, **B939** Center Gauge, **BA940** Universal Tooth Rest (B940H Micrometer Tooth Rest. Blades: **B240D**, **B240DS**, **B240DT**, **B940HF**), **E1** Wheel Dresser, **CV4NM60** Cup Wheel, **PV6GH60** Straight Wheel, **SV6GM60** Saucer Wheel.

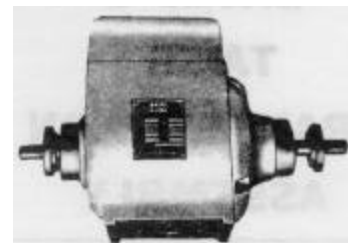
**STANDARD EQUIPMENT  
FOR MODEL B2000X**

**A609A** T-Slot Arm, **A660** T-Slot Bolt, **B246C** 4" Wheel Guard, **B246D** 6" Wheel Guard, **B628** Wrench (7/8" socket), **S894** Wrench, **8855W** Wrench (11/16" & 3/4"), **B923G** Motor Assembly.

**B923 MOTOR ASSEMBLY**



B923 Motor Assembly shown complete with Reversing Switch.



Index No.	Part No.	Description
4	A260HS	Spring
5	A612	Cord Retainer
6	A638D	Power Wire (16-3 Type SJ)
6	A638E	Power Wire (No. 16-4 Type SO)
7	B923EC	Wire Clamp
8	B923EE	End Bell
9	B923EF	Keyed Wheel Flange
10	8923EH	Motor Housing
11	B923EK	Spacer (B923A Motor)
11	B923EI	Spacer (B9230 Motor)
11	B923EM	Spacer (B923K Motor)
12	B923EL	Switch Bracket
13	B923EN	Special Nut
	B923EP	Knurled Plug
14	B923ES	Shaft
15	B923ET	Stud
	B923ETL	Stud
16	B923EW	Wheel Flange
	B923KN	Data Plate
	B923LS	Lamp Stud
	5/16 x 7/8 SAE	Hex Cap Screw
	0618-P	Light Fixture
	B990W	Jumper Wire
	B990X	Jumper Wire
	B990Y	Jumper Wire

Index No.	Part No.	Description
20	K5G	Grommet
21	K5L	Collar
22	K306G101	Field (B923K Motor)
22	KC30LG101	Field (B923A Motor)
22	K301G100	Field (B923G Motor)
23	K306G101	Rotor (B923K Motor)
23	KC30LG101	Rotor (B923A Motor)
23	K30JGC100	Rotor (B9230 Motor)
24	KO-20	Plate
25	3ARR3C2N3	Relay
26	8Z	Adjusting Spring
27	203KDD	Ball Bearing
28	7612K2	Switch
30	235637	Capacitor
34	8-32	Hex Nut
35	8-32 x 3/8	Round Head Machine Screw (NP)
37	10-32 x 5/16	Round Head Brass Screw
38	10-32 x 2	Round Head Machine Screw
39	3/16	Lock Washer
	8-32 x 1/4	Round Head Brass Machine Screw
	34070	Connector
	No. 2 x 1/8	S. T. Round Head Screw
	31891	Terminal
	31881	Terminal
	767	Bryant Wire Connector (3-18 Wire)

**AVAILABLE MOTOR MOUNT ADAPTERS**



B908 Motor Saddle Assembly will adapt B923 Motors to 8900, BA900, B900X, BA900X, 82000 and 82000X.

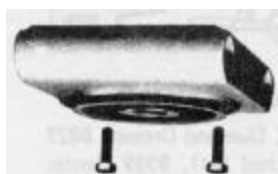


B9235 Adapter Slide adapts the B923 Motor Assembly to the B860 Grinder and B855 Speed Head.

**MOTOR ASSEMBLIES FOR ALL K. O. LEE GRINDERS**  
Complete with reversing switch.

- B923A** 1/2 HP, 115/230V, 1 Phase, 60 Cy.
- B923B** 1/2 HP, 208V, 3 Phase, 60 Cycle.
- B923G** 1/2 HP, 230/440V, 3 Ph., 60 Cycle.
- B923I** 1 HP, 220/380V, 3 Ph., 50 Cycle.
- B923W** 1/2 HP, 550V, 3 Phase, 60 Cycle.
- B2023A** 1 HP, 115/230V, 1 Ph., 60 Cycle.
- B20236** 1 HP, 208V, 3 Phase, 60 Cycle.
- B2023G** 1 HP, 220/440V, 3 Ph., 60 Cycle.
- B3023G** 2 HP, 220/440V, 3 Ph., 60 Cycle.
- B4023G** 3 HP, 220/440V, 3 Ph., 60 Cycle.

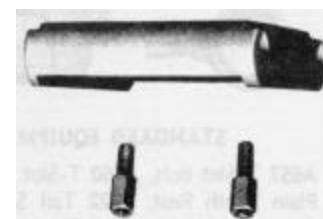
Specify Motor Part No. and Correct Adapter Plate Part No. for Your Model Grinder.



B945B Bracket adapts the B845, B945 Tilting Table to the B900, B900X, BA900, BA900X, B2000 and B2003X Grinders.



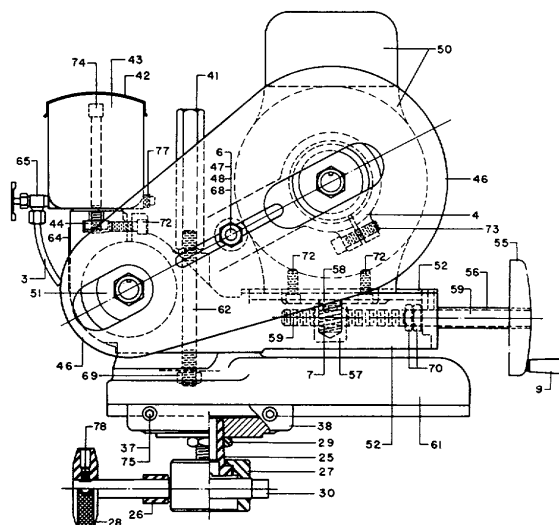
B925A Motor Saddle Assembly adapts the B923 Motor to the A290, A600, B600, B603 and B604 Grinders.



B945C Bracket adapts B845, B945 Tilting Table to the B955 Speed Head and B960, BA960 and B2060 Grinders.

**B955  
UNIVERSAL  
GRINDING HEAD**

**PARTS WITHOUT INDEX  
NUMBERS ARE SHOWN  
IN STANDARD EQUIPMENT  
PHOTO ON PAGE 7**



Index No.	Part No.	Description
	A32	Mounted Cup Wheel
	A36	Mounted Wheel
	A37	Mounted Wheel
3	A267LT	Tube (3/16" x 6") (out)
4	A609A	T-Slot Arm
	A657	T-Slot Bolt
6	A663B	T-Slot Bolt
	B246C	Wheel Guard 4"
	B246D	Wheel Guard 6"
7	B610PS	Compression Spring (2 Required)
	B628	Wrench
9	B685YH	Handle
	B780C	Collet Assembly
	B780HB	Spacer
	B780H2	Pulley 2 1/2" (For Flat Belts)
	B780H3	Pulley 2" (For Flat Belts)
	B780H4	Pulley 1 1/3" (For Flat Belts)
	B780H5	Pulley 1 1/4" (For Flat Belts)
	B780H6	Pulley 1 1/8" (For Flat Belts)
	B780H7	Pulley 1" (For Flat Belts)
	B2055H5	V-Pulley 2 3/8"
	B2055H6	V-Pulley 2"
	B2055H7	V-Pulley 1 1/2"
	B2055H8	V-Pulley 1 1/4"
	B2055H9	V-Pulley 1 1/8"
	B780J	Wheel Arbor 5-40
	B780K	Wheel Arbor 34-28
25	B813A	Lock Adjusting Screw
26	B813B	Bushing
27	B813C	Cage
28	B813D	Knurled Hand Nut
29	B813N	Lock Nut
30	B8135	Eccentric Shaft
	S894	Hex Wrench
	B855F	Pulley and Wheel Arbor Assembly
	B855H1	Pulley 3 3/8" (2 Req.) (For Flat Belts)
	B855H2	Pulley 4 1/2" (For Flat Belts)
	B855H3	Pulley 6" (For Flat Belts)
	B2055H1	V-Pulley 3 3/8"
	B2055H2	V-Pulley 4 1/2"
	B2055H3	V-Pulley 6"
	B855K	Saddle and Lock Assembly
37	B855L	Dovetail Plug (2 Required)
38	B855S	Saddle
	B855W	Wrench 11/16" and 3/4"
41	B855Y	Special Nut
42	B856C	Cover (out)
43	B856G	Tank (out)
44	B856P	T-Slot Plate (out)

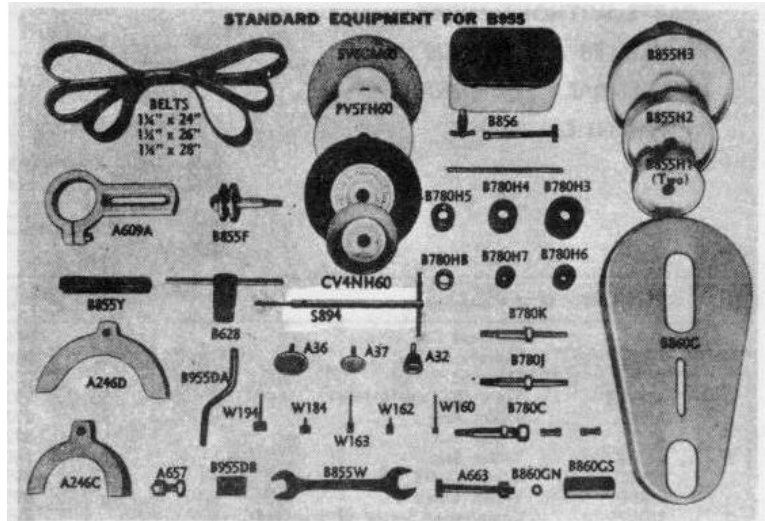
Index No.	Part No.	Description
46	B860G	Belt Guard (replaced by B960G)
47	B860CN	Special Nut (no longer standard)
48	B860GS	Spacer (no longer standard)
50	B923A	1/2 HP Motor Assembly, 115/230V, 1 Ph.
50	B923G	1/2 HP Motor Assembly, 220/440V, 3 Ph.
50	B923K	3/4 HP Motor Assembly, 220/440V, 3 Ph.
51	B6055B	Quill Assembly
52	B955B	Quill Bracket
	B955DA	Arm for Wheel Guard
	B955DB	Bracket for Wheel Guard
55	B955HB	Handwheel
56	B955HC	Collar
57	B955HN	Feed Nut
58	B955HP	Spring Plug (2 Required)
59	B955HS	Belt Tightener Screw
	B955N	Name Plate
61	B955P	Dovetail Slide
62	B955X	Swivel Stud
64	KO-16	Speed Chart
65	6845	Shut Off Cock (out)
68	3/8 USS	Hex Nut (H) (2 Required)
69	7/16 SAE	Hex Nut
70	1/2 NF	Hex Jam Nut
72	5/16 x 3/4 SAE	Hex Socket Cap Screw
73	5/16 x 1 1/4 SAE	Hex Socket Cap Screw
74	5/16 x 3 1/2 USS	Hex Socket Cap Screw
75	B955G	Lock Screw Assembly
77	1/8	Pipe Plug (out)
78	5/16 x 5/16 USS	Hex Socket Set Screw
	1 1/4 x 22	Flat Belt
	1 1/4 x 24	Flat Belt
	1 1/4 x 26	Flat Belt
	1 1/4 x 28	Flat Belt
	5M560	V-Belt 22"
	5M615	V-Belt 24"
	5M670	V-Belt 26"
	5M710	V-Belt 28"
	1/2 SAE	Hex Jam Nut
	3/8 x SAE	Washer (H)
	No. 2 x 1/8	S. T. Round Head Screw
	W160	Mounted Wheel
	W162	Mounted Wheel
	W163	Mounted Wheel
	W184	Mounted Wheel
	W194	Mounted Wheel
	CV4NM60	Cup Wheel
	PR6AH70	Cut Off Wheel
	PVSFH60	Straight Wheel
	SV6GM60	Saucer Wheel

**B955 UNIVERSAL GRINDING HEAD (with Flat Belts & Pulleys)**



**OBSOLETE -  
FOR PARTS  
SELECTION  
ONLY**

**STANDARD EQUIPMENT FOR B955 UNIVERSAL GRINDING HEAD**  
**A246C** Wh. Guard 4", **A246D** Wh. Guard 6", **A609A** T-Slot Arm, **A657** T-Slot Bolt, **A663** T-Slot Bolt, **B628** Wrench, **B780C** Collet Chuck Assembly, **B780H1** Spacer Bushing, **B780H3** Pulley 2", **B780H4** Pulley 1 1/2", **B780H5** Pulley 1 1/4", **B780H6** Pulley 1 1/8", **B780H7** Pulley 1", **B780J** Wheel Arbor (5-40), **B780K** Wheel Arbor, **S894** Hex Wrench, **B855F** Pulley and Wheel Arbor Assembly, **B855H1** Pulley 3 3/8", **B855H2** Pulley 4 1/2", **B855H3** Pulley 6", **B855W** Wrench, **B855Y** Special Nut, **B856** Tank Assembly, **B860G** Belt Guard, **B860GN** Special Nut, **B860GS** Spacer, **B923** ( ) Motor Assembly, **B955DA** Arm for Wheel Guard, **B955DB** Bracket for Wheel Guard, **1 1/4" x 24"** Flat Belt, **1 1/4" x 26"** Flat Belt, **1 1/4" x 28"** Flat Belt, **A32** Mounted Cup Wheel, **A36** Mounted Wheel, **A37** Mounted Wheel, **W160** Mounted Wheel, **W162** Mounted Wheel, **W163** Mounted Wheel, **W184** Mounted Wheel, **W194** Mounted Wheel, **CV4NM60** Cup Wheel, **PR6AH70** Cut Off Wheel, **PV5FH60** Straight Wheel, **SV6GM60** Saucer Wheel



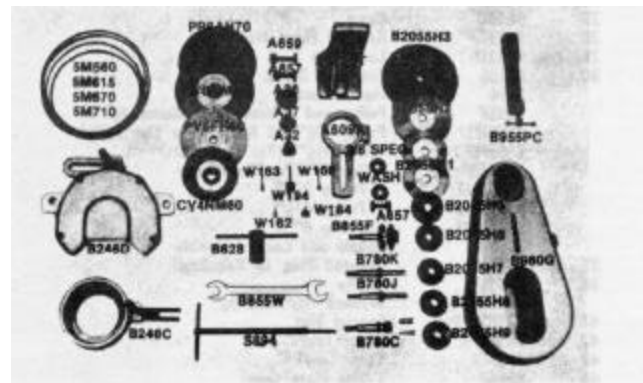
GRINDING HEAD SPEEDS		
Motor Pulley	Quill Pulley	Spindle Speed
Diameter	Diameter	R.P.M.
3 3/8	3 3/8	3450
4 1/2	3 1/8	4600
3 3/8	2	5820
4 1/2	2	7760
6	2	10350
6	1 1/2	13800
6	1 1/4	16560
6	1 1/8	18400
6	1	20700

GUARDS OBSOLETE-ORDER B955BT BRACKET AND GUARDS FROM PICTURE BELOW

**B955 UNIVERSAL GRINDING HEAD (with V-Belts & Pulleys)**



**STANDARD EQUIPMENT FOR B955 UNIVERSAL GRINDING HEAD**  
**A609A** T-Slot Arm, **A657** T-Slot Bolt, **A659** T-Slot Bolt, **B246C** Wheel Guard 4", **B246D** Wheel Guard 6", **B628** Wrench, **B780C** Collet Chuck Assembly, includes **B780CD** 1/8" & **B780CE** 1/4" Collets, **B780J** Wheel Arbor (5-40), **B780K** Wheel Arbor (14-28), **B855F** Pulley and Wheel Arbor Assembly, **B855W** Wrench, **B960G** Belt Guard, **B923G** Motor, **B955BT** Bracket for Wheel Guard or Tooth Rest, **B955PC** Dovetail Clamp Assembly, **B6055B** Quill Assembly, **B2055H1** V-Pulley 3 3/8" (2), **B2055H2** V-Pulley 4 1/2", **B2055H3** V-Pulley 6", **B2055H5** V-Pulley 2 3/8", **B2055H6** V-Pulley 2", **B2055H7** V-Pulley 1 1/2", **B2055H8** V-Pulley 1 1/4", **B2055H9** V-Pulley 1 1/8", **S894** Hex Wrench, **A32** Mounted Cup Wheel, **A36** Mounted Wheel, **A37** Mounted Wheel, **W160** Mounted Wheel, **W162** Mounted Wheel, **W163** Mounted Wheel, **W184** Mounted Wheel, **W194** Mounted Wheel, **CV4NM60** Cup Wheel, **PR6AH70** Cut Off Wheel, **PV5FH60** Straight Wheel, **SV6GM60** Saucer Wheel, **5M560** V-Belt 22", **5M615** V-Belt 24", **5M670** V-Belt 26", **5M710** V-Belt 28".



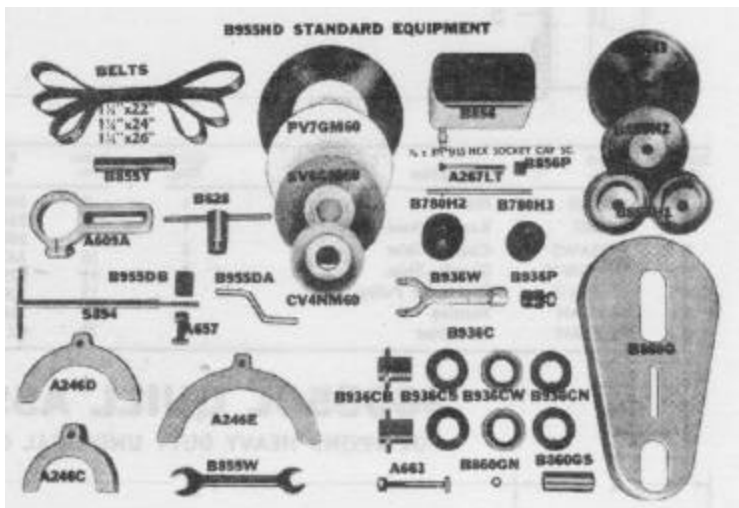
B6055B SPEED CHART KO-16				
Diameter of Wheel	Wheel Speed R.P.M.	Pulley on Meter 3450	Pulley on Spindle	Belt Used
6 TO 5	3,450	3 7/8	3 3/8	5M615
5 TO 4	4,600	4 1/2	3 3/8	5M670
6 TO 5	3,450	2 1/2	2 1/2	5M560
4 TO 3	5,820	3 3/8	2	5M615
3 TO 2	7,760	4 1/2	2	5M710
2 TO 1 1/2	10,350	6	2	5M670
1 1/3 TO 1	13,800	6	1 1/2	5M670
1 TO 3/4	16,560	6	1 1/4	5M670
3/4 TO 1/2	18,400	6	1 1/8	5M670

### B955HD HEAVY DUTY UNIVERSAL GRINDING HEAD (with Flat Belts and Pulleys)



**OBSOLETE -  
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ONLY**

GRINDING HEAD SPEEDS			
Diameter Of Wheel	Wheel R.P.M.	Pulley On Motor 3450	Pulley On Spindle
	1150	2	6
	2580	3 3/8	4 1/2
7 to 5 1/2	3450	3 3/8	3 3/8
7 to 5 1/2	3450	2 3/8	2 3/8
5 1/2 to 4	4600	4 1/2	3 3/8
4 to 3	6210	4 1/2	2 1/2
3 to 2 1/2	7760	4 1/2	2



GUARDS OBSOLETE-ORDER B955BT BRACKET AND GUARDS FROM PICTURE BELOW

### B955HD HEAVY DUTY UNIVERSAL GRINDING HEAD (with V-Belts and V-Pulleys)

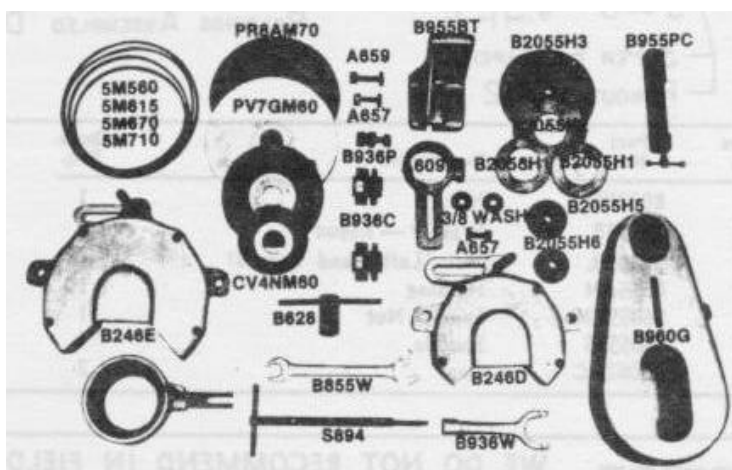
B955HD HEAVY DUTY UNIVERSAL GRINDING HEAD IS AVAILABLE AT EXTRA COST.

#### STANDARD EQUIPMENT FOR B955HD UNIVERSAL GRINDING HEAD

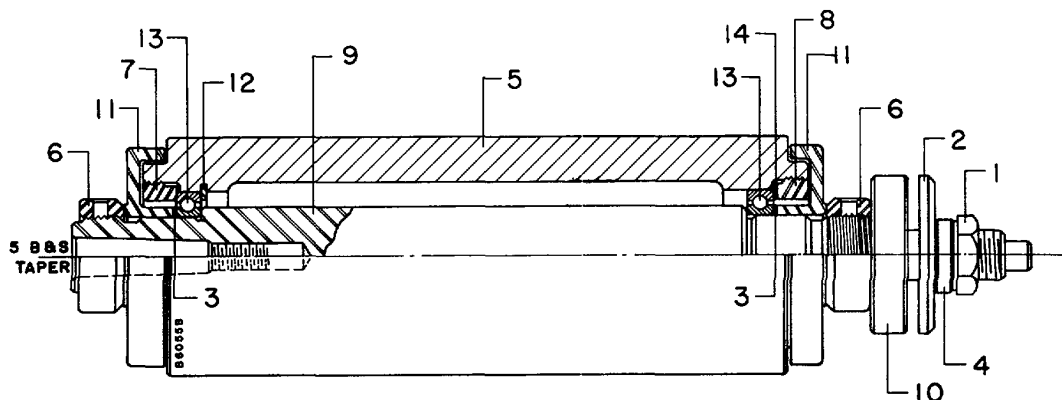
A609A T-Slot Arm, A657 T-Slot Bolt, A659 T-Slot Bolt, B246C Wheel Guard 4", B246D Wheel Guard 6", B246E Wheel Guard 8", B628 Wrench, B855W Wrench, B923G Motor, B936C Collet (2), B936CB Body, B936CS Wheel Spacer, B936CW Collet Keyed Washer, B936CN Nut, B936P Puller, B936W Wrench, B955BT Bracket for Wheel Guard or Tooth Rest, B955PC Dovetail Clamp Assembly, B960G Belt Guard, B2055H1 V-Pulley 3 3/8" (2), B2055H2 V-Pulley 4 1/2", B2055H3 V-Pulley 6", B2055H5 V-Pulley 2 3/8", B2055H6 V-Pulley 2", CV4NM60 Cup Wheel, PR8AM70 Cut Off Wheel, PV7GM60 Plain Wheel, SV6GM60 Saucer Wheel, S894 Hex Wrench, S6055CL Quill Assembly, 5M560 V-Belt 22", 5M615 V-Belt 24", 5M670 V-Belt 26", 5M710 V-Belt 28".

Heavy Duty Quill Assembly with two sets of Duplex Bearings for O.D. Grinding and Surface Grinding is standard equipment on the B955HD Universal Grinding Head.

56055CL SPEED CHART KO-25				
Diameter Of Wheel	Wheel R.P.M.	Pulley On Motor 3450	Pulley On Spindle	Belt Used
	1150	2	6	5M710
	2580	3 3/8	4 1/2	5M670
7 to 5 1/2	3450	3 3/8	3 3/8	5M615
7 to 5 1/2	3450	2 3/8	2 3/8	5M560
5 1/2 to 4	4600	4 1/2	3 3/8	5M670
4 to 3	6210	4 1/2	2 1/2	5M615
3 to 2 1/2	7760	4 1/2	2	5M615

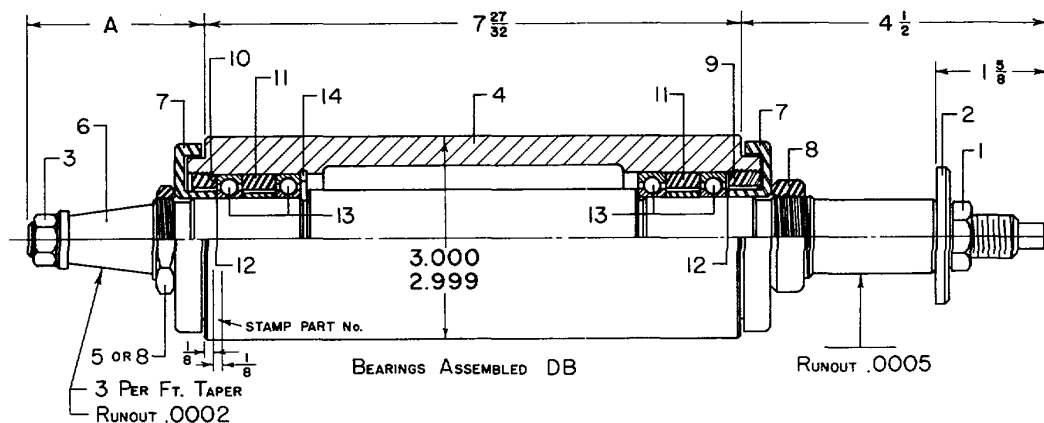


**B6055B QUILL ASSEMBLY**



Index No.	Part No.	Description	Quan. Req.	Index No.	Part No.	Description	Quan. Req.
1	B923EN	Nut	1	7	B6055AR1	Retainer Nut for Bearing	1
2	B923EF	Keyed Wheel Flange	1	8	B6055AR2	Retainer Nut for Bearing	1
3	B955AW5	Circular Shim	2	9	B6055BS	Spindle	1
3	B955AW15	Circular Shim	1	10	A6245	Spacer Washer	1
4	B2055H10	Spacer for Pulley	2	11	S755CC	Cap	2
5	B6055AH	Housing	1	12	3000-X165	Ring -- Internal No. 1300	1
6	B6055AN	Lock Nut	2	13	2MM9305WOCRUM	Ball Bearing Duplex	1 pr.
				14	9Z	Wavy Spring	2

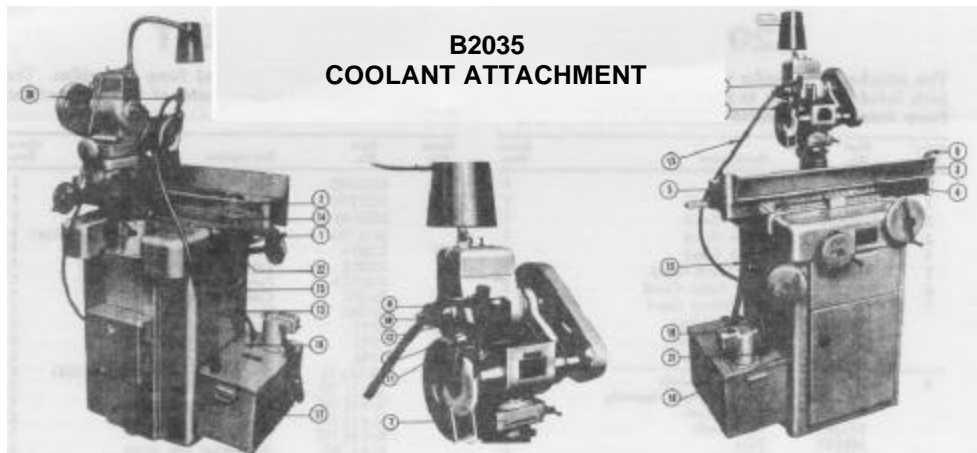
**S6055CL QUILL ASSEMBLY  
FOR B955HD HEAVY DUTY UNIVERSAL GRINDING HEAD**



Index No.	Part No.	Description	Quan. Req.	Index No.	Part No.	Description	Quan. Req.
1	B923EN	Nut	1	8	B6062AN	Lock Nut	1
2	B923EF	Washer - Keyed	1	9	B6062AR	Retainer Nut for Bearing 7/16"	1
3	B936NL	Nut (Left Hand Thread)	1	10	B6062AR2	Retainer Nut for Bearing 3/8"	1
4	B955AH	Housing	1	11	B6062AW	Spacer for Bearing	2
5	S6055CN	Special Nut	1	12	B6062AY5	Circular Shim .005"	2
6	S60555S	Spindle	1	12	B6062AY15	Circular Shim .015"	1
7	B6062AC	Cap	2	13	2MM9306-WO-CR-DUM	Bearings	2 pr.
				14	3000-X187	Retainer Ring - Int.	1

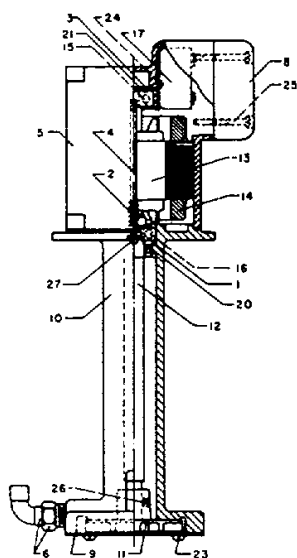
**NOTICE:** WE DO NOT RECOMMEND IN FIELD SERVICE ON THESE QUILLS. IF ATTEMPTED, WE NOTICE: ARE NOT RESPONSIBLE FOR SPINDLE OR BEARING DAMAGE.





**B2035  
COOLANT ATTACHMENT**

Index No.	Part No.	Description	Quan. Req.	Index No.	Part No.	Description	Quan. Req.
	A657B	T-Slot Bolt	1		B6035DS	Drain Spout	1
1	B6035DT	Drain Trough	1	16	S632H	Hanger	2
2	B2035GA	Splash Guard	1	17	S632TA	Tank Assembly	1
3	B2035GB	Splash Guard	1	18	S632TC	Cover	1
4	B2035GD	Splash Guard	1	19	S635AH	Pump Assembly (115V, 1 Ph.)	1
5	B935GL	Left Splash Guard	1		S635EH	Pump Assembly (230V, 3 Ph.)	1
6	B935GR	Right Splash Guard	1		S635GAH	Pump Assembly (440V, 3 Ph.)	1
7	B935GS	Wet Wheel Guard	1		S635KH	Pump Assembly (230V, 1 Ph.)	1
	B2035GR	Coolant Return	1		75-201	Connector Straight (1/2")	1
	B2035GW	Spacer Washer	1		7610K2	Switch	1
	S609W	Thumb Screw	1	20	HP11	Hose Clamp (on Guard)	1
8	B6035N	Nozzle Assembly	1	21	HP12	Hose Clamp (on Tank)	1
	B6035NA	Body and Tube Assembly	1	22	HP16	Hose Clamp	1
	K518K	Control Knob	1		10-32 x 1/2	Round Head Machine Screw (HB)	4
	K518S	Valve Shaft	1		1/4 X 1/2 NF	Hex Cap Screw (HB)	2
	5632NT	Tube	1		1/4 x 3/4 NF	Hex Cap Screw (HB)	4
	8011	O-Ring	1		1/4 x 1/2 NF	Hex Socket Cap Screw	2
	10-32 x 3/16	Hex Socket Set Screw	1		5/16 x 1/2 NC	Hex Socket Cap Screw	1
9	B935NB	Bracket	1		5/16 x 1 NC	Hex Socket Cap Screw	1
10	B935NP	Nozzle Stud	1		5/16 x 7/8 NF	Hex Socket Cap Screw	4
11	B935NS	Guard Stud	1		10-32	Hex Nut (HB)	4
12	B935NT	T-Slot Plate	1		3/8 NC	Hex Nut (H)	1
13	BA931H76	Plastic Hose (1/2)	1		1/2 NF	Hex Jam Nut (HB)	1
	BA967H28	Flexible Conduit (1/2)	1		3/16 STD.	Lock Washer	4
	BA967Y84	Power Wire	2-1 Ph., 3-3 Ph.		3/8 NF	Washer (H)	1
14	B2035DC	Drain Cap	1		1/2 NF	Washer (HB)	1
15	B2035DH	Drain Hose (1 1/8)	1		5/16 NF	Washer (HB)	1
					No. 1111	Rubber Pads	2



**S635AH Pump Assembly, 115V, 1 Ph., 60 Cycle**  
**S635EH Pump Assembly, 220V, 3 Ph., 60 Cycle**  
**S635GAH Pump Assembly, 440V, 3 Ph., 60 Cycle**  
**S635KH Pump Assembly, 230V, 1 Ph., 60 Cycle**

Index No.	Part No.	Description	Quan. Rqr.	Index No.	Part No.	Description	Quan. Rqr.
1	B637W	Thrust Ring	1	13	K10KG27	Field (440V. 3 Ph. 60 Cy.)	1
2	B6043EP	Field Position (all 1 Ph)	2	13	KH10NC32	Field (220V. 1 Ph. 60 Cy.)	1
2	B6043EP	Field Pos. (230V. 3 Ph.)	2	14	K10KG26	Rotor (220V. 3 Ph. 60 Cy.)	1
2	R55FP 19/32	Field Pos. (230V. 3 Ph.)	2	14	K10KG27	Rotor (440V. 3 Ph. 60 Cy.)	1
3	B943AT	Thrust Plate	1	14	KH10NC12	Rotor (115V. 1 Ph. 60 Cy/)	1
4	B943MDE	Stud Offset (115V, 1 Ph.)	2	14	KH10NG32	Rotor (220V. 1 Ph. 60 Cy.)	1
4	B943MDL	Stud Offset	2	15	39KVTD	Ball Bearing	1
5	B943MH	Motor Housing	1	16	202KLL3	Ball Bearing	1
5	B6043MH	Motor Hsg. (115V, 1 Ph.)	1	17	91252-45	Start. Switch (115V. 1 Ph.)	1
6	BA933G	90° Elbow	1	17	91252-250	Start Switch (220V. 1 Ph.)	1
7		Data Plate	1	19	31881	Terminal (1 Ph only)	2
8	B943BL	Switch Box (Lower 115V)	1	20	63 x 87	Seal (5/8 x 1 1/8 x 5/16)	1
8	B943BU	Switch Box (Upper 115V)	1	21	5Z	Adjusting Spring	1
8	S635B	Switch Box	1	23	10-32 x 3/8	S. T. Rd. Hd. Screw (NP)	4
9	S635C	Impeller Cover	1	24	8-32 x 3/8	Rd. Hd. Mach Sc. (NP)	2
10	S635H	Pump Housing	1	25	8-32 x 1 5/8	Rd. Hd. Mach. Sc. (HB)	2
11	S635R	Impeller	1	27	8-32	Acorn Nut - Light (NP)	2
12	S6355	Pump Shaft	1		BA967CP	Plug	1
12	S6355L	Pump Shaft (115V)	1		738	Bryant Wire Conn.	1
13	K10KG26	Field (220V, 3 Ph. 60 Cy.)	1		6502	Cord Grip Corn	1

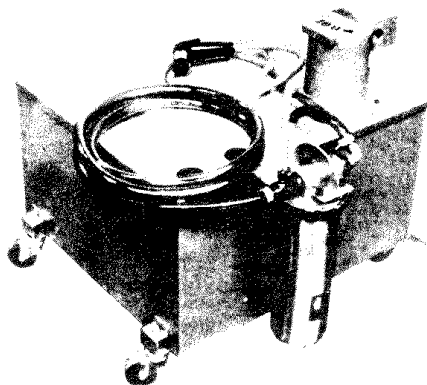
**B2035-15 COOLANT ATTACHMENT**

This attachment is similar to the B2035 except for 5612-233 (15 gallon) Tank Assembly and Pump Assemblies. The parts listed below refer to photographs on page 10. The S612-233 parts are listed in the center of this page and the Pump Assemblies are listed at the bottom of this page.

Index No.	Part No.	Description	Quan. Req.	Index No.	Part No.	Description	Quan. Req.
	A657B	T-Bolt	1	14	B2035DC	Drain Cap	1
1	B6035DT	Drain Trough	1	15	B2035DH	Drain Hose (1 1/8)	1
2	B2035GA	Splash Guard	1		B6035DS	Drain Spout	1
3	B2035G8	Splash Guard	1		S612-233	Tank Assembly (see parts list below)	1
4	B2035GD	Splash Guard	1	19	S1635A	Pump Assembly (115V, 1 Ph.)	1
5	B935GL	Left Splash Guard	1		S1635E	Pump Assembly (230V, 3 Ph.)	1
6	B935GR	Right Splash Guard	1		S1635GA	Pump Assembly (440V, 3 Ph.)	1
7	B935CS	Wet Wheel Guard	1		75-201	Connector Straight (1/2")	1
	B2035GR	Coolant Return	1		7610K2	Switch	1
	82035GW	Spacer Washer	1	20	HP11	Hose Clamp (on Guard)	1
	5609W	Thumb Screw	1	21	HP12	Hose Clamp (on Tank)	1
8	B6035N	Nozzle Assembly	1	22	HP16	Hose Clamp	1
	B6035NA	Body and Tube Assembly	1		10-32 x 1/2	Round Head Machine Screw (HB)	4
	K518K	Control Knob	1		1/4 x 1/2 NF	Hex Cap Screw (HB)	2
	K5185	Valve Shaft	1		1/4 x 3/4 NF	Hex Cap Screw (HB)	4
	S632NT	Tube	1		1/4 x 1/2 NF	Hex Socket Cap Screw	2
	8011	O-Ring	1		5/16 x 1/2 NC	Hex Socket Cap Screw	1
	10-32 x 3/16	Hex Socket Set Screw	1		5/16 x 1 NC	Hex Socket Cap Screw	1
9	B935NB	Bracket	1		5/16 x 7/8 NF	Hex Socket Cap Screw	4
10	B935NP	Nozzle Stud	1		10-32	Hex Nut (HB)	4
11	B935NS	Guard Stud	1		3/8 NC	Hex Nut (H)	1
12	B935NT	T-Slot Plate	1		1/2 NF	Hex Jam Nut (HB)	1
13	BA931H76	Plastic Hose (1/2)	1		3/16 STD.	Lock Washer	4
	BA967H28	Flexible Conduit (1/2)	1		3/8 NF	Washer (H)	1
	BA967Y84	Power Wire	2-1 Ph. 3-3 Ph.		1/2 NF	Washer (HB)	1
					5/16 NF	Washer (HB)	1
					No. 1111	Rubber Pads	2

**S612-23 TANK ASSEMBLY**

You may order this unit as a replacement for any Lee Coolant Attachment. It includes items listed below, but not the Pump, Splash Guards, Nozzle Assembly, etc., which are parts of original Coolant Attachment.



Part No.	Description	Quan. Req.	Part No.	Description	Quan. Req.
BA931H17	Hose, 17"	1	5612-232F	Flushing Attachment	1
BA931H84	Hose, 84"	1	3/4 - 3/8	Reducer Bushing	2
BA933G	Elbow	1	1/4 x 5/8 NC	Hex Cap Sc. H.	4
S612-44	Hose Coupling	1	1/4 STD.	Lock Washer	4
S832TA	Tank Assbly., 15 gal.	1	HP11	Hose Clamp	3
5612-232C	Cover Assembly	1	HP12	Hose Clamp	1
CT101	Cuno Filter	1	2278-L1	Replacement 50 Micron Filter Cartridge Available	
1-2251-51-2	Caster	4			

- S1635A Pump Assembly, 115V 1 Ph., 60 Cycle**
- S1635E Pump Assembly, 220VP 3 Ph., 60 Cycle**
- S1635GA Pump Assembly, 440V, 3 Ph., 60 Cycle**

Index No.	Part No.	Description	Quan. Req.	Index No.	Part No.	Description	Quan. Req.
1	B637W	Thrust Ring	1	13	K10FG22	Field (440V, 3 Ph., 60 Cy.)	1
2	B6043AP	Field Positioner	2	13	KH10FG11	Field (115V, 1 Ph., 60 Cy.)	1
3	B943AT	Thrust Plate	1	14	K10FG21	Rotor (220V, 3 Ph., 60 Cy.)	1
4	B943MDL	Stud Offset	2	14	K10FG22	Rotor (440V, 3 Ph., 60 Cy.)	1
5	B943MH	Motor Housing	1	14	KH10FG11	Rotor (15V, 1 Ph., 60 Cy.)	1
6	BA933G	90° Elbow	1	15	39KVTD	Ball Bearing	1
7	S1635AN	Data Plate	1	16	292KLL3	Ball Bearing	1
7	S1635EN	Data Plate	1	17	91252-45	Start. Switch (115V, 1 Ph.)	1
7	S1635GAN	Data Plate	1	17	91252-250	Start. Switch (220V, 1 Ph.)	1
3	S635B	Switch Box	1	20	63 x 87	Seal (3/8 x 1 1/8 x 5/16)	1
9	S635C	Impeller Cover	1	21	5Z	Adjusting Spring	1
10	S635H	Pump Housing	1	23	10-32 x 3/8	S. T. Rd. Hd. Screw (NP)	4
11	S635R	Impeller	1	24	8-32 x 3/8	Rd. Hd. Mach. Sc. (NP)	2
12	S6355	Pump Shaft	1	25	8-32 x 1 5/8	Rd. Hd. Mach. Sc. (HB)	2
13	K10FG21	Field (220V, 3 Ph., 60 Cy.)	1	26	1/4 x 1/4 NF	Hex Socket Set Screw	1
				27	8-32	Acorn Nut - Light (NP)	2

**NEW STYLE PUMP ASSEMBLY S1635E, 34 H.P., 3450, 2850 RPM, 208/230/460V, 60/50 CYCLE**


By Order of the Secretary of the Army:

Official:

E. C. MEYER  
*General, United States Army*  
*Chief of Staff*

B. G. JOYCE  
*Brigadier General, United States Army*  
*The Adjutant General*

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