

DEPARTMENT OF THE ARMY TECHNICAL MANUAL

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OPERATOR'S MANUAL

LATHE, BRAKE DRUM, FLOOR  
MOUNTED, 60 INCH RATED SWING,  
25 INCH MAXIMUM DRUM DIAME-  
TER, W/GRINDING PROVISIONS,  
1 HORSEPOWER DRIVE MOTOR,  
1/2 HORSEPOWER GRINDING MOTOR,  
115-VOLT, 60-CYCLE, SINGLE-PHASE  
(STAR MACHINE AND TOOL COM-  
PANY MODEL 1960) (4910-516-6192)

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This reprint includes all changes in effect at the time of  
publication -Change 1.

HEADQUARTERS, DEPARTMENT OF THE ARMY

MAY 1965

HEADQUARTERS  
DEPARTMENT OF THE ARMY  
WASHINGTON, D. C., 19 May 1965

TM 9-4910-446-10 is published for the information and use of all concerned.

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NG: State AG (2); United-Same as Active Army except allowance in one copy to each unit.

USAR: None.

For explanation of abbreviations used, see AR 32-50.

CHANGE  
No. 1



HEADQUARTERS  
DEPARTMENT OF THE ARMY  
WASHINGTON, D.C., 16 January 1973

**Operator's Manual**  
**LATHE, BRAKE DRUM, FLOOR MOUNTED,**  
**60 INCH RATED SWING, 25 INCH**  
**MAXIMUM DRUM DIAMETER, W/GRINDING**  
**PROVISIONS, 1 HORSEPOWER DRIVE MOTOR,**  
**1/2 HORSEPOWER GRINDING MOTOR,**  
**115-VOLT, 60-CYCLE, SINGLE-PHASE**  
**(STAR MACHINE AND TOOL COMPANY**  
**MODEL 1960) (4910-516-6192)**

*This change is current as of 6 December 1972*

TM 9-4910-446-10, 19 May 1965, is changed as follows:

1. This change identifies the type of catalog maintenance action taken in connection with the updating of previously published data.
2. This change is separated by additions, deletions, and changes and is a list of items added, deleted, and/or changed since the last previously published data.
3. All Federal stock numbers and reference numbers, additions, deletions, and changes should be made to the indexes.
4. Parts included with end items and considered a component or part of the item configuration, are listed on the following tables. The part numbers listed are for Star Machine and Tool Company Model 1960.
5. The reporting of errors, omissions, and recommendations for improving this publication by the individual user is encouraged. Reports should be submitted on DA Form 2028 (Recommended Changes to Publications) and forwarded direct to Commander, US Army Weapons Command, ATTN: AMSWE-MAS, Rock Island, IL 61201.

| Part   | Part No.    |
|--|-------------|
| ARBOR, DRUM: 1 in. dia, 1 in. thd            | 57127:R-740 |
| ARBOR, DRUM: 1 in. dia, 11/16 thd            | 57127:R-640 |
| ARBOR, DRUM: 2 in. dia, 2 in. thd            | 57127:R-390 |
| BAND, BRAKE DRUM SILENCING:<br>passenger car | 57127:SB-10 |
| BAND, BRAKE DRUM SILENCING:<br>truck         | 57127:SB-20 |
| BAR, DRAW: arbor holding<br>1 bore           | 57127:R-405 |
| CONE, CENTERING: 1-15/32 X 2-3/8 X<br>1 bore | 57127:R-680 |
| CONE, CENTERING: 2-15/16 X 3-1/4 X<br>1 bore | 57127:R-665 |
| CONE, CENTERING: 3-1/16 X 4 X 4 X<br>1 bore  | 57127:R-670 |
| CONE, RADII: 1-13/32 X 2-3/8 X 1 bore        | 57127:R-580 |
| CONE, RADII: 1-1/2 X 1-45/64 X 1 bore        | 57127:R-550 |
| CONE, RADII: 1-19/32 X 1-49/64 X 1<br>bore   | 57127:R-560 |
| CONE, RADII: 1-27/32 X 2-55/64 X 1<br>bore   | 57127:R-620 |
| CONE, RADII: 1-61/64 X 2-13/64 X 1<br>bore   | 57127:R-570 |
| CONE, RADII: 2-1/16 X 3-19/64 X 1<br>bore    | 57127:R-630 |
| CONE, RADII: 2-19/64 X 2-1/2 X 1 bore        | 57127:R-590 |
| CONE, RADII: 2-27/64 X 2-39/64 X 1<br>bore   | 57127:R-600 |
| CONE, RADII: 2-35/64 X 2-25/64 X 1<br>bore   | 57127:R-610 |
| CONE, TAPERED: 3/4 X 1-1/2 X 11/16<br>bore   | 57127:R-510 |
| CONE, TAPERED: 1-1/16 X 1-3/4 X 1<br>bore    | 57127:R-520 |
| CONE, TAPERED: 2-15/64 X 3-3/8 X 2<br>bore   | 57127:R-385 |
| CONE, TAPERED: 2-23/64 X 3-11/32 X<br>2 bore | 57127:R-380 |
| CONE, TAPERED: 3-17/64 X 3-52/64 X<br>2 bore | 57127:R-375 |
| CONE, TAPERED: 3-25/32 X 4-27/64 X<br>2 bore | 57127:R-370 |

| Part  | Part No.    |
|---|-------------|
| CONE, TAPERED: 4-5/16 X 4-31/32 X 2<br>bore   | 57127:R-365 |
| CONE, TAPERED: 4-56/64 X 5-1/2 X 2<br>bore  | 57127:R-360 |
| CONE, TAPERED: 5-25/64 X 6-1/32 X 2<br>bore   | 57127:R-355 |
| CONE, TAPERED: 5-59/64 X 6-9/16 X 2<br>bore   | 57127:R-350 |
| CONE, TAPERED: 6-31/64 X 7-1/8 X 2<br>bore  | 57127:R-345 |
| CONE, TAPERED: 6-63/64 X 7-5/8 X 2<br>bore  | 57127:R-340 |
| CONE, TAPERED: 7-17/64 X 8-11/61 X<br>2 bore  | 57127:R-335 |
| HONE, SHARPENING: tool bit  | 57127:CB-75 |
| NUT, ARBOR: 11/16 thd   | 57127:R-645 |
| NUT, ARBOR: 1 in. thd   | 57127:R-745 |
| NUT, ARBOR: 2 in. thd   | 57127:R-395 |
| PLATE, FACE: 1 in. bore   | 57127:R-655 |
| REDUCER: 1 in. od to 11/16 id, 1-3/8 lg   | 57127:R-501 |
| REDUCER: 2 in. od to 1 in. id, 1-1/8 lg   | 57127:R-331 |
| SPACER, ARBOR: 11/16 bore, 1 in. lg   | 57127:R-530 |
| SPACER, ARBOR: 1 in. bore, 1 in. lg   | 57127:R-540 |
| SPACER, ARBOR: 2 in. bore, 1 in. lg   | 57127:R-330 |
| SPACER, ARBOR: 2 in. bore, 2 in. lg   | 57127:R-325 |
| SPACER, ARBOR: 2 in. bore, 3 in. lg   | 57127:R-320 |
| SPRING, COIL: 4 coil, 2-1/8 od  | 57127:R-315 |
| SPRING, COIL: 4 coil, 2-3/8 id tapered<br>to 1-1/2 id   | 57127:R-675 |
| TOOL BIT: 5/8 sq, carbide tipped  | 57127:CB-35 |
| TOOL BIT: 5/8 sq HSS  | 57127:CB-36 |
| WRENCH, OPEN END, FIXED: sgle-hd<br>type, 15 deg angle of hd, 7/16<br>wrench opng             | 57127:R-152 |
| WRENCH, OPEN END, FIXED: sgle-hd<br>type, 15 deg angle of hd, 3 wrench<br>opng, 17 nom o/a lg | 57127:R-410 |

**Section II. BASIC ISSUE ITEMS LIST**

| (1)<br>Source,<br>maint. and<br>recov. code |               |               | (2)<br>Federal<br>stock<br>No. | (3)<br>Description  | (4)<br>Unit<br>of<br>issue | (5)<br>Qty.<br>inc.<br>in<br>unit<br>pack | (6)<br>Illustration |                    |
|---|---------------|---------------|--------------------------------|---|----------------------------|---|---------------------|--------------------|
| (a)<br>Source                               | (B)<br>Maint. | (C)<br>Recov. |                                |   |                            |   | (a)<br>Fig.<br>No.  | (b)<br>Item<br>No. |
|   |               |               |                                | BASIC ISSUE ITEMS LIST-SECTION II<br>BILL is a list in alphabetical sequence of items which are furnished with, and which must be turned in with, the end item. |                            |   |                     |                    |
| C   | O             |               | 5120-224-2504                  | KEY, SOCKET HEAD SCREW: hex type, L-hdl, 5/64 across fl, 1-7/8 nom lg arm lg  | EA                         | 1   | 1                   | 50                 |
| C   | O             |               | 5120-240-5292                  | KEY, SOCKET HEAD SCREW: hex type, L-hdl, 1/8 across fl, 2-1/4 nom lg arm lg   | EA                         | 1   | 1                   | 49                 |
| C   | O             |               | 5120-293-1266                  | WRENCH, BOX: stght sgle-hd type, hex shape wrench opng, 3/4 opng, 4-3/8 nom o/a lg  | EA                         | 1   | 1                   | 45                 |
| C   | O             |               | 5120-293-2124                  | WRENCH, OPEN END, FIXED, dble-hd type, 15 deg angle of hd, engineer style, 1-1/4 and 1-5/8 wrench opngs, 14 nom o/a lg, 9/16 thk of hd                          | EA                         | 1   | 1                   | 51                 |
| C   | O             |               | NA                             | WRENCH, OPEN END, FIXED: sgle-hd type, 15 deg angle of hd, 1/4 wrench opng, 3-1/2 nom o/a lg, 3/16 thk hd   | EA                         | 1   | 1                   | 48                 |
| C   | O             |               | 5120-277-1261                  | WRENCH, OPEN END, FIXED: sgle-hd type, 15 deg angle of hd, 3/8 wrench opng, 3-7/8 nom o/a lg, 17/64 thk hd  | EA                         | 1   | 1                   | 47                 |
|   |               |               |                                | Federal stock numbers are being assigned for items marked NA and then numbers will be published at a later date.  |                            |   |                     |                    |

By Order of the Secretary of the Army:

**CREIGHTON W. ABRAMS**  
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*Chief of Staff*

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TSG (1)  
COE (6)  
Dir of Trans (1)  
CONARC (3)  
AMC (10)  
MUCOM (2)  
ARADCOM (2)  
ARADCOM Rgn (2)  
TACOM (5)  
AVSCOM (10)

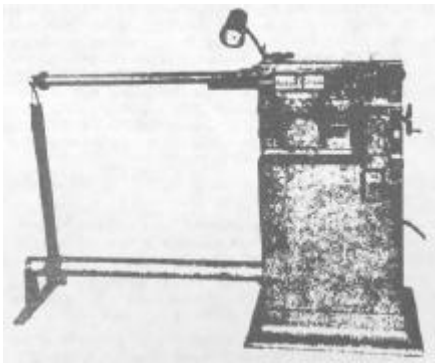
WECOM (10)  
OS Maj Comd (5)  
LOGCOMD (3)  
Armies (3) except  
    7th USA (5)  
    8th USA (5)  
Corps (2)  
USACOMZEUR (2)  
USARYIS (1)  
ANAD (2)  
TOE 55-465 (2)

NG: None.

USAR: None

For explanation of abbreviations used, see AR 310-50.

**SECTION I**  
**USE AND MAINTENANCE**



*Fig. 1-1. Brake Drum Lathe*

**1-1. INTRODUCTION**

1-2. The Star Brake Drum Lathe, Model 1960 is designed to put a smooth, accurate finish on used or unfinished brake drums (see figure 1-1).

1-3. The Model 1960 will handle passenger car drums as well as being capable of turning the largest and heaviest truck drums.

1-4. The Model 1960 is designed to keep maintenance expenses at a minimum and operating efficiency at a maximum.

1-5. The following instructions and parts breakdown will help ensure many years of high quality, troublefree drum turning. Numbers in parentheses refer to item numbers (see figure 2-1).

**1-6. TABLE OF SPECIFICATIONS**

|                                  |  |
|----------------------------------|--|
| Drum Capacity Range (dia.) ..... | 6" to 42"  |
| Drum Cutting Depth (face).....   | 10"  |
| Speeds, Number of Changes.....   | Infinite   |
| Speeds, Cutting Range.....       | 30 to 150 r.p.m.                                     |
| Swing .....                      | 60"  |
| Motor .....                      | 1 h.p., 115-230v., 60C.,<br>Single Phase 1725 r.p.m. |
| Feed, Range.....                 | O to Rapid Traverse                                  |
| Number of Feeds.....             | Infinite   |
| Weight .....                     | 590 lbs.   |

**1-7. INSTALLATION**

1-8. Remove machine and all accessories from shipping container.

1-9. Check all parts with packing slip to insure all items are included.

1-10. Clean the entire machine, adapters, and accessories with a good grease solvent to remove the protective coating on the machined surfaces,.

1-11. Place machine in desired position and securely bolt it to the floor. Make sure machine is level by using a level on the top plate of the cabinet.

1-12. Install the 2" Arbor, R-390, into the Spindle (28) and tighten until Arbor is drawn up tightly in Spindle (28).

1-14. Place the Vertical Tube (184) over the Horizontal Tube (197) and position the Horizontal Tube (197) over the plug which is welded to the base.

1-15. Fasten the Bottom Mounting Plate (198) to the base of the Horizontal Tube, (197).

1-16. By use of a plumb bob, level, and shims, permanently position the Bottom Mounting Plate (198) so that the Horizontal Tube (197) is directly beneath the Arbor and level to the floor. Tighten Cap Screw (200) at rear of Horizontal Tube (197).

1-17. Swing the Vertical Tube (184) into the upright position and slide it toward the Arbor. Raise the Adjusting Bushing (187) by hand until the Rod End Bearing (188) will slide over the end of Arbor and the Vertical Tube (184) is directly below Arbor. Fasten the Vertical Tube (184) to the Horizontal Tube (197) by tightening the Locking Screw Shaft (195). Place Cam Shaft (190) in the up position until Pin (194) hits Stop Pin (193). Rotate the Adjusting Bushing (187) until you feel it touch the Cam (191). This is done by slowly moving the Cam Shaft (190) while you are rotating the Adjusting Bushing (187) until you feel a slight drag on the Cam (191). Tighten the Jam Nut (189). The outboard support is now permanently adjusted.

1-18. Place Tool Bit, CB-35, into Boring Bar (77) and fasten securely with the two Square Head Set Screws (78). The tool bit slot in the end of the Boring Bar (77) is deep enough to enable several degrees of adjustment of the tool bit angle. The groove running along the Boring Bar (77) should be lined up with the slit in the Compound Rest (73).

1-19. Position Lamp (121) over Lamp Bracket (122) and plug into Receptacle (85). Use standard bulb, 75 watts or less, moistening bulb neck before slipping it through silicone grommet at the base of reflector.

After screwing bulb into socket, make sure air space between shade and reflector is equal on all sides.

1-20. Plug machine into 115 volt outlet and the machine is now properly installed.

**1-21. OPERATIONAL PROCEDURES**

1-22. Mount drum on arbor using one of the following methods which apply. Be sure that the Arbor is mounted in Spindle (28) before mounting hub and drum assembly.

a.-Loose Drum Set-up. Select proper Tapered Cone to fit in center of drum. Place one Face Plate on Arbor followed by the Spring and Tapered Cone. Place drum on Arbor over Tapered Cone and push drum up to pads of Face Plate. Place other Face Plate on Arbor and push up to drum. Place additional Spacers on Arbor so that the two Face Plates can be tightened together when the Arbor Nut is put on the end of Arbor and tightened. Make sure that the face plate pads are riding on a smooth dean surface of the drum (see figure 1-2).

b.-Tapered Hub. Select the proper Tapered Cones to fit in drum hub. On some drums the Tapered Cones go in about 1/4 of an inch. Place Tapered Cone for inside

of tapered hub onto Arbor followed by the drum and outside Tapered Cone. Place additional Spacers onto Arbor so that when the Arbor Nut is tightened at the end of the Arbor, the two Tapered Cones are drawn up tightly against the tapered hub (see figure 1-3).

c.-Ball Bearing Equipped Hub. Select the proper Radii Cone to fit into the inner and outer bearing cups. Radius of Radii Cone selected should seat in Center of bearing cup radius. Place Radii Cone for inner bearing cup onto Arbor followed by drum and Radii Cone for outer bearing cup. Place additional Spacers on Arbor so that when the Arbor Nut on the end of Arbor is tightened, the two Radii Cones are drawn up securely to the bearing cups. Make sure bearing cups and Radii Cones are clean before mounting (see figure 1-4).

d.-Tapered Bearing Equipped Hub. Select the proper Radii Cone to fit into the inner and outer bearing cups. Radius of Radii Cone selected should seat somewhere on cup bearing surface. In most cases, this will be approximately in the center of bearing cup. Place Radii Cone for inner bearing cup on Arbor, followed by hub and Radii Cone for outer bearing cup. Place additional Spacers on Arbor so that when the Arbor Nut is tightened on the end of the Arbor, the two Radii Cones will draw up securely to the bearing cups and Radii Cones are clean before mounting (see figure 1-5).

e.-Tapered Bearing Hub. (Truck). Select the proper Tapered Cones to fit into the inner and outer bearing cups. The Tapered Cone should fit so that it is almost completely inside the bearing cup. There are conditions when the Tapered Cone will barely enter the cup or just about go through the cup. Place the Tapered Cone for the inner bearing cup on the Arbor, followed by the drum and Tapered Cone for outer bearing cup. Place additional Spacers on the Arbor so that when the Arbor Nut on the end of the Arbor is tightened, the two Tapered Cones are drawn securely against the bearing cups. Make sure that the Tapered Cones and bearing cups are clean (see figure 1-6).

1-23. Place Brake Drum Silencing Band, SB-10 or SB-20, around drum and apply enough tension so that the drum is snugly wrapped. On passenger drums, the Brake Drum Silencing Band, SB-10, should be positioned even with the edge of open side of drum. The Brake Drum Silencing Band should not be too tight or too loose on drum.

1-24. If drum is to be turned with wheels mounted, then the outboard support should always be used.

1-25. Before drum and wheel assembly is resting with full weight on the Arbor, make sure that the Vertical Tube (184) of the outboard support is in place and the Cam Shaft (190) is in the up position.

1-26. For best results, the outboard support should be used on all drum and wheel assemblies.

1-27. The Boring Bar (77), Compound Rest (73), Cross Slide (59) and Apron (45) should be adjusted so that the

Tool Bit can be placed in the rear of the drum without interference. This adjustment depends on the diameter and depth of the drum. The Boring Bar (77) can be slid in and out of the Compound Rest (73) by loosening the Cap Screw (76). The Compound Rest (73) can be rotated by loosening Cap Screw (74) and Cap Screw (76) the Cross Slide (59) can be moved in or out by rotating Handle (71). 1-28. Turn machine on at Switch (112). Make sure Cut Off Switch (117) is also on.

1-29. If drum has a prominent ridge on outer or inner edge of braking surface, remove with rough cut before observing the following procedures.

1-30. Bring Tool Bit into rear of drum by moving Direction Lever (208) down and moving Speed Lever (207) down into the rapid traverse range.

1-31. As Tool Bit approaches rear of drum, raise up on Speed Lever (207) and move Direction Lever up to neutral position.

1-32. Bring Tool Bit to maximum depth of drum by rotating Large Handwheel (182).

1-33. Adjust Cut Off Rod (53) so that machine will shut off after Tool Bit has cleared drum. The Cut Off Rod (53) can be adjusted by merely pushing it. The drag on the Cut Off Rod (53) is set at the factory and should be such that the Cut Off Rod (53) will trip the Cut Off Switch (117) but not accidentally break it if the Apron (45) is hand cranked.

1-34. Advance Handle (71) until Tool Bit touches inside surface of drum. Each graduation on the Graduated Collar (68) represents .001" of travel of the Tool Bit. Advance Handle (71) an additional .10" into the drum. Lock Cross Slide (59) by tightening Thumb Screw (57).

1-35. Rotate Handwheel (99) counter clockwise in order that the drum will rotate in the lower r.p.m. range.

1-36. Move Direction Lever (208) up to move Tool Bit to the right.

1-37. Move Speed Lever (207) down into the rough cut range and lock into position by rotating Speed Lever (207) clockwise. If drum does not clean up, repeat above procedures.

1-38. When Tool Bit leaves drum, move Direction Lever (208) down to neutral position.

1-39. Remember Graduated Collar (68) reading, loosen Thumb Screw (57) and rotate Handle (71) back .015".

1-40. Move Direction Lever (208) down and unlock Speed Lever (207) and move it down to the rapid traverse range.

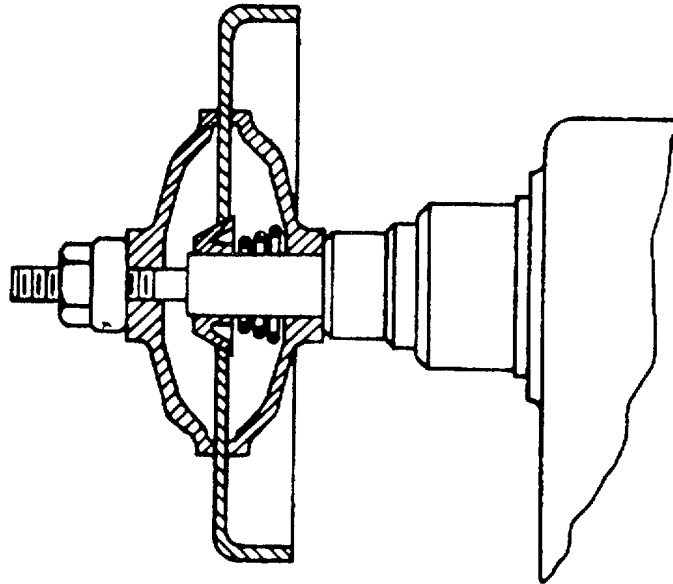
1-41. As Tool Bit approaches rear of drum, -raise Speed Lever (207) until Tool Bit stops moving.

1-42. Move Direction Lever (208) up to neutral position.

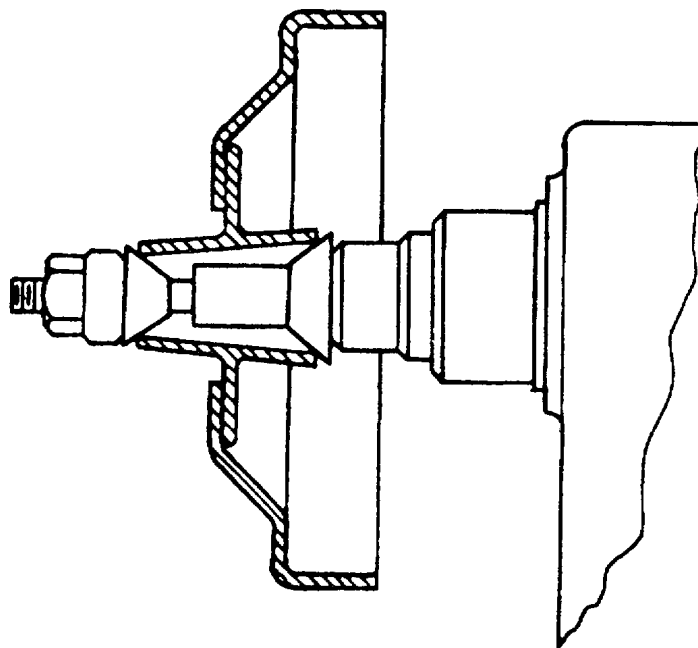
1-43. Bring Tool Bit to maximum depth of drum by rotating Large Handwheel (182).

1-44. Turn Handle (71) to rough cut reading plus an additional .002" and lock Cross Slide (59) by tightening Thumb Screw (57).

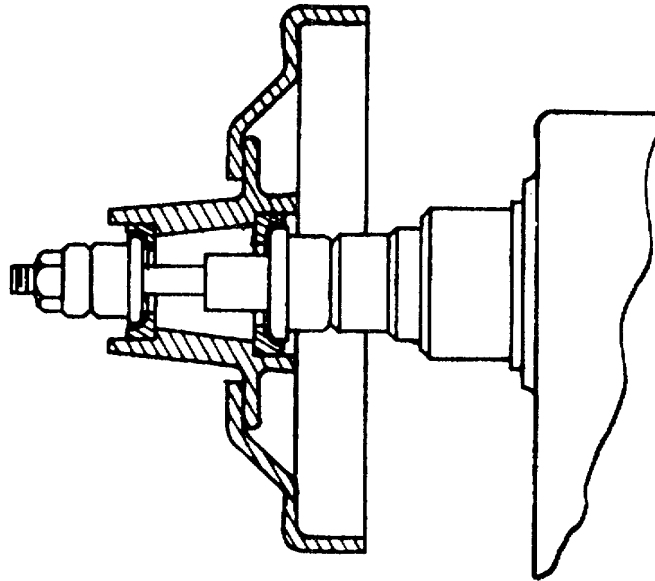




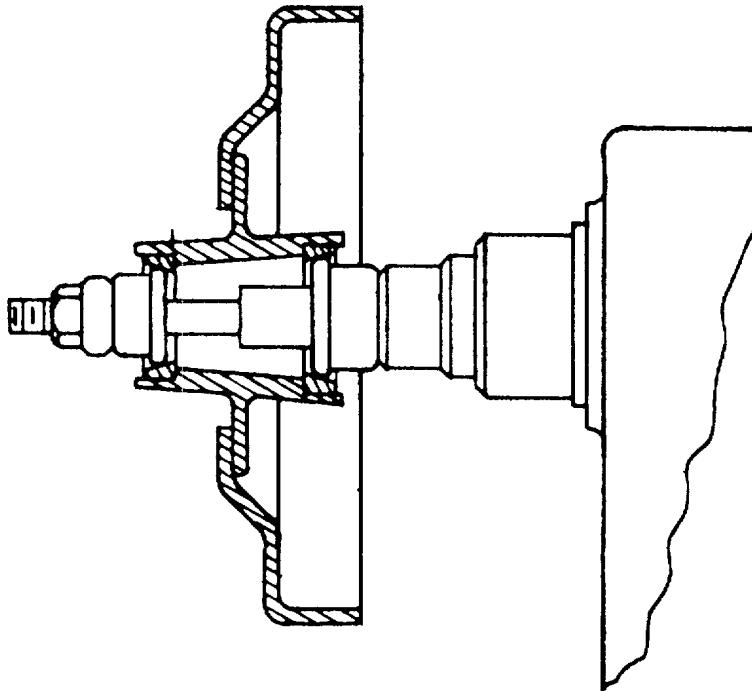
*Fig. 1-2 - LOOSE DRUM SET-UP*



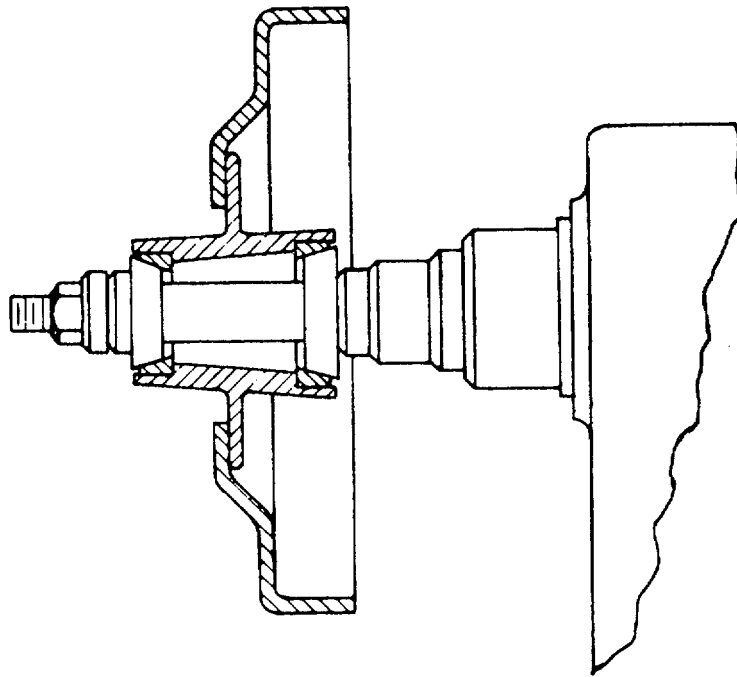
*Fig. 1-3 - TAPERED HUB*



*Fig. 1-4 - BALL BEARING EQUIPPED HUB*



*Fig. 1-5 - TAPERED BEARING EQUIPPED HUB*



*Fig. 1-6 - TAPERED BEARING HUB (TRUCK)*

1-45. Rotate Handwheel (99) clockwise until drum is rotating in the high r.p.m. range.

1-46. Move Direction Lever (208) up and move Speed Lever (207) down into finish cut range and lock by rotating Speed Lever (207) clockwise.

1-47. When Tool Bit leaves the drum, the drum should have an accurate and smooth finish.

1-48. Move Direction Lever (208) down to the neutral position and raise Speed Lever (207) up to the up position.

1-49. Turn machine off at Switch (112) and remove drum from machine.

1-50. The above procedures are for instruction purposes and are not necessarily correct for all cases.

Drum condition determines the proper depth of cuts, carriage feed, and spindle r.p.m. As the operator gains experience with this machine, he will be able to make the proper settings for maximum performance, efficiency and accuracy.

### **1-51. MAINTENANCE PROCEDURES**

#### **1-52. Lubrication**

a.-Main Bearings (3 & 4). Apply a few drops of light machine oil (SAE #10) in both Head Oilers (5).

b.-Lead Screw (42) and Lead Screw Nut (43). Apply a few drops of light machine oil (SAE #10) along length of Lead Screw (42) once a week.

c.-Cross Slide (59). Apply a few drops of light machine oil (SAE #10) at Oiler (60) and between Graduated Collar (68) and End Plate (66).

d.-Bearing (161) and Pillow Block Bearing (166). Apply a few drops of light machine oil (SAE #10) at both oil cups inside Guard (173) every 90 days.

e.-Gear box. Maintain the oil level in the center of Oil Window (8) with gear oil (SAE #90 or MIL L 15019C, Grade 6135). Add oil by removing Vented Plug (6). Caution: Do not fill higher than the top of Oil Window (8).

f.-Control Box (143). This box should be drained once each year or each 1500 hours of operation by removing Drain Plug (210). Twelve ounces of new oil (all purpose #80) or MIL L-2105) should be added at Vent Plug (209).

g.-Variable Speed Pulley (201). Lubricate grease fitting in rear of machine with one shot of light needle bearing grease every 90 days.

h.-Apron ways. Move Apron (45) to extreme front position, wipe away all dirt or cutting particles and apply several drops of light oil (SAE #10) to all exposed surfaces of the dovetail ways. Move Apron (45) in the, opposite direction and repeat above procedures. Perform weekly.

i.-Cross slide ways. Back out Cross Slide (59) to extreme out position, wipe the dovetail surfaces clean and apply light oil (SAE #10) weekly.

j.-Wipe machine free of dust and cutting particles with oil rag doily.

#### **1-53. Trouble Shooting.**

a.-Problem: Chatter.

Reason:

Wrong Cones and Adapters.

Face Plate, R-655, making poor contact due to excessive dirt between face plate pads and drum.

Dull Tool Bit.

Misaligned Boring Bar (77).

Failure to use Brake Drum Silencing Band, SB-10 or SB-20.

Improper mounting of Brake Drum Silencing Band, SB-10 or SB-20.

Spindle r.p.m. too slow or too fast for depth of cut.

Outboard support not bolted to floor.

The following areas should be checked for tightness:

(1) Tool bit, CB-35 or CB-36.

(2) Boring Bar (77).

(3) Gib (61).

(4) Gib (49).

(5) Draw bar, R-405.

(6) Arbor Nut, R-645, R-745 or R-395.

(7) Drum on hub.

(8) Bearing cup in hub.

Failure to tighten Cross Slide (59), Thumb Screw (57).

b.-Problem: Loss of power.

Reason.

Low voltage to motor.

Worn or loose drive belts.

Dull tool bit.

Failure to follow lubrication Instructions.

c.-Problem: Machine shuts off during operation.

Reason: Cut Off Rod (53) not adjusted properly.

Thermal overload switch (112) cuts off because machine is overworked.

d.-Problem: Machine will not start.

Reason: Cut Off Switch (117) Is in off position.

Thermal overload Switch (112) has not had time to cool.

#### **1-54. Calibration.**

a.-Gib (49) adjustment. Loosen Jam Nuts (51). Tighten Set Screws (50) until Apron (45) looseness is taken up. Tighten Jam Nuts (51).

b.-Cross slide Gib (51) adjustment, Loosen Jam Nuts (63). Tighten Gib Screws (62) until Cross Slide (59) looseness is taken up. Tighten Jam Nuts (63).

c.-Spindle (28). End play adjustment. Remove Guard (173) and Housing Cover (39). Loosen Lock Washer (35) from Nut (36). Tighten Nut (36) so that when you press hard at rear of Spindle (28) you can get a .003 feeler gauge between the Spindle (28) nose and the Front Main Bearing (3). Tighten Lock Washer (35) onto Nut (36) and replace Housing Cover (39) and Guard (173).

d.-Worm (14) end play. Remove Guard (173), Large Pulley (25) and Bearing Retainer (19). Remove either .010" Shim, (23) or .005" Shim (24) depending on amount of take up. Replace Bearing Retainer (19), Large Pulley (25), and Guard (173).

#### **1-55. DISASSEMBLY.**

1-56. Remove Arbor, R-390, R-640, or R-740 by loosening the Draw Bar, R-405, one turn and hitting end of Draw Bar with lead hammer until Arbor breaks free of Spindle (28).

1-57. Outboard support is removed by loosening two Cap Screws (199) and Cap Screw (200) and sliding Horizontal Tube (197) off of welded plug.

TABLE 1 - BRAKE DRUM CHARACTERISTICS - MILITARY VEHICLES

| SNL  | MODEL                                      | HUB NO.                               | DIA. X DEP. | ORD ENG STD   | CONE NO  | LOC                          | ORD ENG STD   | CUP NO   | LOC                           |
|------|--|---------------------------------------|-------------|---|--|------------------------------|---|--|-------------------------------|
| G842 | XM455<br>XM456                             | 8719915                               | 14.9 x 3.3  | CAS X 5.1   | 712869   |                              | CAS X 6.1   | 712868   |                               |
| G751 | M119<br>M118<br>M118A1<br>M164E1           | 8343586                               | 16.4 x 6    | CAS X 7.1 -<br>CAS X 6                                    | 706691<br>712120                               | IN<br>OUT                    | CAS X 7.1<br>CAS X 6                                      | 712286<br>712119                               | IN<br>OUT                     |
| G815 | M349                                       | 8720968                               | 16.5 x 6.7  | CAS X 5<br>CAS X 4  | 706683<br>706671                               | IN<br>OUT                    | CAS X 6<br>CAS X 4  | 705143<br>705116                               | IN<br>OUT                     |
| G800 | M197<br><br>M197A1<br><br>M198             | 8327340<br><br>8747994<br><br>7409395 | 16.4 x 6    | CAS X 7.1<br>CAS X 4<br>CAS X 7.1<br>CAS X 4<br>CAS X 7.1 | 706691<br>706671<br>706691<br>706671<br>706691 | IN<br>OUT<br>IN<br>OUT<br>IN | CAS X 7.1<br>CAS X 4<br>CAS X 7.1<br>CAS X 4<br>CAS X 7.1 | 712286<br>705116<br>712286<br>705116<br>705155 | IN<br>OUT<br>IN<br>OUT<br>OUT |
| G816 | M345                                       | 8710723                               | 16.4 x 6    | CAS X 7.1   | 706691   | IN<br>OUT                    | CAS X 7.1<br>CAS X 7.1                                    | 712286<br>705155                               | IN<br>OUT                     |
| G750 | M126<br>M127<br>M126A1<br>M127A1<br>M128A1 | 7409395<br><br>8333869                | 16.4 x 6    | CAS X 7.1<br>CAS X 7.1<br>CAS X 7.1                       | 706691<br>706691<br>712286                     | IN<br>IN<br>OUT              | CAS X 7.1<br>CAS X 7.1<br>CAS X 7.1<br>CAS X 7.1          | 712286<br>705155<br>712286<br>705155           | IN<br>OUT<br>IN<br>OUT        |
| G755 | M131<br><br>M131A1<br>M131A2               | 7509395<br><br>8333869                | 16.4 x 6    | CAS X 7.1<br><br>CAS X 7.1                                | 706691<br><br>706691                           |                              | CAS X 7.1<br>CAS X 7.1<br>CAS X 7.1<br>CAS X 7.1          | 712286<br>705155<br>712286<br>705155           | IN<br>OUT<br>IN<br>OUT        |
| G802 | M269<br>M270                               | 7979324                               | 16.4 x 6    | CAS X 7.1   | 706691   |                              | CAS X 7.1<br>CAS X 7.1                                    | 712286<br>705155                               | IN<br>OUT                     |
| G797 | M172<br><br>M172A1                         | 8379664<br><br>8787067RT<br>8687068LH | 12.2 x 6.6  | CAS X 6<br>CAS X 5.1<br>CAS X 7<br>CAS X 5.1              | 706704<br>707081<br>706704<br>707081           | IN<br>OUT<br>IN<br>OUT       | CAS X 7<br>CAS X 6<br>CAS X 7<br>CAS X 6                  | 705187<br>705167<br>705187<br>705167           | IN<br>OUT<br>IN<br>OUT        |
| G811 | M199                                       | 8720685                               | 16.4 x 7.5  | CAS X 6.1<br>CAS X 7                                      | 706707<br>706704                               | IN<br>OUT                    | CAS X 7<br>CAS X 7  | 705194<br>705187                               | IN<br>OUT                     |
| G160 | M15A1<br>M15A2                             | 7348199                               | 16 x 6      | CAS X 7<br>CAS X 5.1                                      | 706704<br>706784                               | IN<br>OUT                    | CAS X 7<br>CAS X 5.1                                      | 705187<br>705341                               | IN<br>OUT                     |

| SNL<br>G740 &<br>G758                                | HUB<br>ORD NO<br>7375142<br>7375144 | CUP<br>MFG'S<br>NO*<br>18520 | LOC<br>INF<br>OUTF<br>OUTR | CONE<br>MFG'S<br>NO*<br>18590 | LOC<br>INF<br>OUTF         | BRAKE<br>DRUM<br>DIA. IN<br>8.948 | BRAKE<br>DRUM<br>DEPTH IN.<br>2 17/64 |
|--|-------------------------------------|------------------------------|----------------------------|-------------------------------|----------------------------|-----------------------------------|---------------------------------------|
| Rear wheel hubs are taper bored to fit tapered shaft |                                     |                              |                            |                               |                            |                                   |                                       |
| G741   | 8376840                             | 28622<br>2924                | INF<br>INR<br>OUTF<br>OUTR | 28682<br>2984                 | INF<br>INR<br>OUTF<br>OUTR | 14.155                            | 2 11/32                               |
| G742   | 8357986                             | 3920E<br>3920E               | INF<br>INR<br>OUTF<br>OUTR | 3994<br>392                   | INF<br>INR<br>OUTF<br>OUTR | 14.995                            | 3 11/16                               |
| G749   | GM2280042                           | 39520<br>39520               | INF<br>INR<br>OUTF<br>OUTR | 39590<br>39590                | INF<br>INR<br>OUTF<br>OUTR | 14.995                            | 3 11/32                               |
| G744   | 7979324                             | 592A<br>592A                 | INFR<br>OUTRF              | 593A<br>596                   | INF<br>OUTRF               | 16.495                            | 6 1/16                                |
| G792   | M34KM46<br>M12QJ451                 | 5735<br>522<br>64700<br>854  | INF<br>OUTF<br>INR<br>OUTR | 5760<br>528A<br>64450<br>861  | INF<br>OUTF<br>INR<br>OUTR | 17.25                             | 6 15/32                               |

\*Timken      IN—Inner      OUT—Outer      F—front      R—rear

**SECTION II PARTS BREAKDOWN**  
**PARTS LIST FOR MODEL 1960-G, LATHE, BRAKE DRUM**

**Section II**

| Item No. | Ass'y. No. | Part No. | Description                                    | Quan. per Ass'y. | Quan. per Mach. |
|----------|------------|----------|--|------------------|-----------------|
| 1        | 100387     |          | Main Housing Assembly                          |                  | 1               |
| 2        |            | 300083   | Housing Main                                   | 1                | 1               |
| 3        |            | 150005   | Bearing, Main, Front                           | 1                | 1               |
| 4        |            | 150006   | Bearing, Main, Rear                            | 1                | 1               |
|          |            |          | END Main Housing Assembly                      |                  |                 |
| 5        |            | 230015   | Oiler, Head                                    | 2                | 2               |
| 6        |            | 230016   | Plug, Vented                                   | 1                | 1               |
| 7        |            | 990021   | Plug   | 1                | 1               |
| 8        |            | 990019   | Window, Oil                                    | 1                | 1               |
| 9        |            | 990274   | Plate, Name                                    | 1                | 1               |
| 10       |            | 990018   | Plate, Name, Star                              | 1                | 1               |
| 11       |            |          | Screw, Drive, #2, 1/4" Long, Plated, Hardened  | 4                | 4               |
| 12       | 100036     |          | Shaft Assembly                                 |                  | 1               |
| 13       |            | 600002   | Shaft, Drive                                   | 1                | 1               |
| 14       |            | 500006   | Worm   | 1                | 1               |
| 15       |            | 150007   | Cone, Bearing                                  | 2                | 2               |
| 16       |            | 150012   | Cup, Bearing                                   | 1                | 2               |
| 17       |            | 350003   | Key, Shaft, Drive                              | 1                | 1               |
|          |            |          | END Shaft Assembly                             |                  |                 |
| 18       | 100029     |          | Bearing Retainer Assembly                      |                  | 1               |
| 19       |            | 300008   | Retainer, Bearing                              | 1                | 1               |
| 20       |            | 250002   | Seal, Oil                                      | 1                | 1               |
| 21       |            | 150012   | Cup, Bearing                                   | 1                | 2               |
|          |            |          | END Bearing Retainer Assembly                  |                  |                 |
| 22       |            |          | Screw, Cap, Socket Head, 1/4-20 x 3/4"         | 4                | 10              |
| 23       |            | 250029   | Shim, .010                                     | 2                | 2               |
| 24       |            | 250030   | Shim, .005                                     | 1                | 1               |
| 25       |            | 500133   | Pulley, Large                                  | 1                | 1               |
| 26       |            |          | Screw, Set, Socket, Nyloc, 5/16-18 NC x 5/16"  | 1                | 2               |
| 27       |            | 350002   | Key, Pulley, Large                             | 1                | 1               |
| 28       |            | 600086   | Spindle  | 1                | 1               |
| 29       |            | 250056   | Seal, Spindle                                  | 1                | 1               |
| 30       |            |          | Screw, Machine, Round Hd. 6-32 x 3/4"          | 2                | 2               |
| 31       |            | 990024   | Ring "O"                                       | 1                | 1               |
| 32       |            | 650006   | Spacer, Spindle                                | 1                | 1               |
| 33       |            | 500134   | Gear, Worm                                     | 1                | 1               |
| 34       |            | 350001   | Key, Gear                                      |                  | 1               |
| 35       |            | 990013   | Washer, Lock                                   | 1                | 1               |
| 36       |            | 700005   | Nut  | 1                |                 |
| 37       |            | 250001   | Gasket, Cover                                  | 1                | 1               |
| 38       | 100389     |          | Cover Assembly                                 |                  | 1               |
| 39       |            | 170107   | Cover, Housing                                 | 1                | 1               |
| 40       |            | 250003   | Seal   | 1                | 1               |
|          |            |          | END Cover Assembly                             |                  |                 |
| 41       |            |          | Screw, Cap, Socket Hd. 1/4-20 x 3/4"           | 6                | 10              |
| 42       |            | 700234   | Screw, Lead                                    | 1                | 1               |
| 43       |            | 700241   | Nut, Screw, Lead                               | 1                | 1               |
| 44       |            |          | Nut, Hex, Jam, Finished, Plated, 1/2-13        | 1                | 1               |
| 45       |            | 300084   | Apron  | 1                | 1               |
| 46       |            | 130216   | Plate, Wiper                                   | 2                | 2               |
| 47       |            | 990286   | Wiper  | 2                | 2               |
| 48       |            |          | Screw, Machine, Round Hd, 10-24 x 1/2", Plated | 6                | 6               |
| 49       |            | 130381   | Gib  | 1                | 2               |
| 50       |            | 700242   | Screw, Set                                     | 3                | 3               |
| 51       |            |          | Nut, Jam, Hex, Finished, 1/4-20                | 3                | 6               |
| 52       | 100391     |          | Cut Off Rod Assembly                           |                  | 1               |
| 53       |            | 370114   | Rod, Cut Off                                   | 1                | 1               |
| 54       |            | 650010   | Retaining Ring                                 | 1                | 1               |
|          |            |          | END Cut Off Rod Assembly                       |                  |                 |
| 55       |            |          | Screw, Set, Socket, 1/4-20 x 3/8"              | 1                | 1               |
| 56       |            | 990140   | Plug, Nylon                                    | 1                | 2               |
| 57       |            |          | Screw, Thumb, Plated, 1/4-20 x 1-1/2"          | 1                | 1               |
| 58       |            | 990140   | Plug, Nylon                                    | 1                | 2               |
| 59       |            | 300085   | Cross Slide                                    | 1                | 1               |
| 60       |            | 230017   | Oiler  | 1                | 1               |
| 61       |            | 130381   | Gib  | 1                | 2               |
| 62       |            | 700199   | Screw, Gib                                     | 3                | 3               |
| 63       |            |          | Nut, Jam, Hex, Finished, 1/4-20                | 3                | 6               |
| 64       |            | 700235   | Screw, Cross Slide                             | 1                | 1               |

## Section II

## PARTS LIST FOR MODEL 1960-G, LATHE, BRAKE DRUM

| Item No. | Ass'y. No. | Part No. | Description                                      | Quan. per Ass'y. | Quan. per Mach. |
|----------|------------|----------|--|------------------|-----------------|
| 65       |            | 990023   | Washer, Bronze                                   | 1                | 1               |
| 66       |            | 130382   | Plate, End                                       | 1                | 1               |
| 67       |            |          | Screw, Cap, Socket Head, 5/16-18 x 1/2"          | 2                | 2               |
| 68       |            | 650250   | Collar, Graduated                                | 1                | 1               |
| 69       |            | 990144   | Plug, Nylon, Collar,                             | 1                | 1               |
| 70       |            |          | Screw, Set, Socket, 8-52 x 1/4"                  | 1                | 1               |
| 71       |            | 370115   | Handle   | 1                | 1               |
| 72       |            | 450039   | Pin, Spring, Handle                              | 1                | 1               |
| 73       |            | 300086   | Compound Rest                                    | 1                | 1               |
| 74       |            |          | Screw, Cap, Hex Head, 1/2-13 x 1-1/2             | 1                | 1               |
| 75       |            |          | Washer, Flat, 17/32 I.D. x 1-1/16 O.D.           | 1                | 1               |
| 76       |            |          | Screw, Cap, Hex Head, 1/2-13 x 3-1/2             | 1                | 1               |
| 77       |            | 900268   | Boring Bar                                       | 1                | 1               |
| 78       |            |          | Screw, Set, Sq. Hd. 3/8-16 x 5/8                 | 2                | 2               |
| 79       |            |          | Screw, Cap, Socket Hd, 3/8-16 x 1-1/4            | 4                | 4               |
| 80       |            |          | Washer, Lock, 3/8" Med.                          | 4                | 8               |
| 81       |            | 200062   | Clip, Cord                                       | 1                | 1               |
| 82       | 100392     |          | Cabinet Assembly                                 |                  | 1               |
| 83       |            | 170108   | Cover, Louvered                                  | 1                | 1               |
| 84       |            |          | Screw, Machine, Round Hd., 10-24 x 5/16"         | 8                | 8               |
| 85       |            | 200006   | Receptacle                                       | 1                | 1               |
| 86       |            |          | Screw, Machine, Round Hd., Plated, 10-24 x 7/16" | 2                | 2               |
| 87       | 850164     |          | Pulley Base Subassembly                          |                  | 1               |
| 88       |            | 990296   | Base, Pulley                                     | 1                | 1               |
| 89       |            | 650260   | Collar, Base                                     | 2                | 2               |
| 90       |            |          | Screw, Set, Socket, Nyloc, 1/4-20 x 1/4          | 2                | 4               |
| 91       |            | 150087   | Bearing, Thrust                                  | 2                | 4               |
| 92       |            | 150088   | Race, Thrust                                     | 4                | 8               |
| 93       |            | 400005   | Sleeve, Connecting                               | 1                | 1               |
| 94       |            | 450043   | Pin, Spring                                      | 1                | 3               |
|          |            |          | END Pulley Base Subassembly                      |                  |                 |
| 95       |            |          | Washer, Lock, 3/8" Med.                          | 4                | 8               |
| 96       |            |          | Nut, Hex, Finished, Full, 3/8-16                 | 4                | 4               |
| 97       |            | 400006   | Rod, Control                                     | 1                | 1               |
| 98       |            | 150078   | Bushing, Flanged                                 | 1                | 1               |
| 99       | 100404     |          | Handwheel Assembly                               |                  | 1               |
| 100      |            | 450358   | Pin, Spring, Handwheel                           | 1                | 2               |
| 101      |            | 200057   | Motor  | 1                | 1               |
| 102      |            | 200058   | Cord   | 1                | 1               |
| 103      |            | 200052   | Plug, Cord                                       | 1                | 1               |
| 104      |            | 200050   | Adapter  | 1                | 1               |
| 105      |            | 200042   | Connector, Screw                                 | 1                | 1               |
| 106      |            | 500137   | Pulley, Motor                                    | 1                | 1               |
| 107      |            | 350013   | Key, Pulley                                      | 1                | 1               |
| 108      |            |          | Screw, Set, Socket, Nyloc, 5/16-18 x 7/16"       | 2                | 2               |
| 109      |            |          | Screw, Cap, Hex Head, 5/16-18 x 3/4              | 4                | 4               |
| 110      |            |          | Washer, Flat, 3/8 I.D. x 7/8 O.D.                | 4                | 6               |
| 111      |            |          | Washer, Lock, 5/16" Med.                         | 4                | 11              |
| 112      |            | 200053   | Switch   | 1                | 1               |
| 113      |            | 200060   | Heater Coil                                      | 1                | 1               |
| 114      |            |          | Screw, Mach., Round Hd., 1/4-20 x 5/16"          | 2                | 2               |
| 115      |            |          | Screw, Mach., Round Hd., Plated, 8-32 x 1/4      | 1                | 1               |
| 116      |            | 200061   | Bushing, Snap                                    | 1                | 1               |
| 117      |            | 200003   | Switch, Cut Off                                  | 1                | 1               |
| 118      |            | 990150   | Ring, Off & On                                   | 1                | 1               |
| 119      |            | 200011   | Nut, Switch                                      | 1                | 1               |
| 120      |            | 990151   | Seal, Nut  | 1                | 1               |
| 121      |            | 200004   | Lamp   | 1                | 1               |
| 122      |            | 200036   | Bracket, Lamp                                    | 1                | 1               |
| 123      |            | 130385   | Plate, Mounting                                  | 1                | 1               |
| 124      | 850163     |          | Plate Bearing Retainer Subassembly               |                  | 1               |
| 125      |            | 650251   | Retainer, Bearing, Plate                         | 1                | 1               |
| 126      |            | 250058   | Seal, Retainer                                   | 1                | 1               |
| 127      |            | 150087   | Bearing, Thrust                                  | 1                | 4               |
| 128      |            | 150088   | Race, Thrust                                     | 2                | 8               |
| 129      |            | 150090   | Bearing, Needle, Collar                          | 2                | 2               |
|          |            |          | END Plate Bearing Retainer Subassembly           |                  |                 |
| 130      |            | 150087   | Bearing, Thrust                                  | 1                | 4               |
| 131      |            | 150088   | Race, Thrust                                     | 2                | 8               |
| 132      |            | 250022   | Seal, Dust                                       | 1                | 1               |

## Section II

## PARTS LIST FOR MODEL 1960-G, LATHE, BRAKE DRUM

| Item No. | Ass'y. No. | Part No. | Description  | Quan. per Ass'y. | Quan. per Mach. |
|----------|------------|----------|--|------------------|-----------------|
| 133      |            | 450356   | Pin, Dowel   | 2                | 6               |
| 134      |            |          | Screw, Cap, Soc. Hd., 1/4-20 x 1-1/2"  | 3                | 3               |
| 135      |            | 450356   | Pin, Dowel   | 2                | 6               |
| 136      |            |          | Screw, Cap, Hex Head, 5/16-18 x 5/8"   | 3                | 3               |
| 137      |            |          | Washer, Lock, 5/16" Med.   | 3                | 11              |
| 138      |            | 650252   | Spacer   | 1                | 1               |
| 139      |            | 450042   | Pin, Spring, Spacer  | 1                | 1               |
| 140      |            | 500135   | Gear, Nylon  | 1                | 1               |
| 141      |            | 450359   | Pin, Spring, Gear  | 1                | 1               |
| 142      |            |          | Screw, Set, Socket, 1/4-20 x 1/4"  | 1                | 1               |
| 143      |            | 990297   | Control Box  | 1                | 1               |
| 144      | 100394     |          | Overload Coupling Assembly   |                  | 1               |
| 145      |            | 990298   | Coupling, Overload   | 1                | 1               |
| 146      |            | 990299   | Adapter, Coupling  | 1                | 1               |
| 147      | 850155     |          | Pinion Gear Subassembly  |                  | 1               |
| 148      |            | 500138   | Gear, Pinion   | 1                | 1               |
| 149      |            | 150002   | Bushing, Bronze  | 1                | 1               |
| 150      |            |          | Screw, Set, Socket, Nyloc, 10-24 x 1/4"<br>END Pinion Gear Subassembly<br>END Overload Coupling Assembly | 4                | 4               |
| 151      |            | 450356   | Pin, Dowel   | 2                | 6               |
| 152      |            |          | Bolt, Oven Head, 1/4-20 x 1/2"   | 4                | 4               |
| 153      |            |          | Washer, Lock, Shakeproof, 1214 Pheoll  | 4                | 4               |
| 154      |            | 990300   | Coupling   | 1                | 1               |
| 155      |            |          | Screw, Set, Socket, Nyloc, 1/4-20 x 5/16"  | 2                | 2               |
| 156      |            | 600087   | Shaft, Long  | 1                | 1               |
| 157      |            | 500139   | Pulley   | 2                | 2               |
| 158      |            |          | Screw, Set, Socket, Nyloc, 5/16-18 x 3/8"  | 2                | 2               |
| 159      |            | 650253   | Collar, Set  | 2                | 2               |
| 160      |            |          | Screw, Set, Socket, Nyloc, 1/4-20 x 1/4"   | 2                | 4               |
| 161      |            | 150091   | Bearing  | 1                | 1               |
| 162      |            | 650254   | Spacer, Long   | 2                | 2               |
| 163      |            |          | Screw, Cap, Hex Head, 5/16-18 x 2-3/4  | 2                | 2               |
| 164      |            |          | Washer, Flat, 3/8 I.D. x 7/8 O.D.  | 2                | 6               |
| 165      |            |          | Washer, Lock, 5/16" Med.   | 2                | 11              |
| 166      |            | 150092   | Bearing, Pillow Block  | 1                | 1               |
| 167      |            | 600088   | Shaft, Short   | 1                | 1               |
| 168      |            |          | Screw, Cap, Hex Head, 5/16-18 x 7/8  | 2                | 2               |
| 169      |            |          | Washer, Lock, 5/16" Med.   | 2                | 11              |
| 170      |            | 500140   | Belt, "V", 57"   | 1                | 1               |
| 171      |            | 500141   | Belt, "V", 42"   | 1                | 1               |
| 172      |            | 500142   | Belt, "V", 58"   | 1                | 1               |
| 173      |            | 170109   | Guard  | 1                | 1               |
| 174      |            | 250060   | Gasket, Felt   | 1                | 1               |
| 175      |            |          | Screw, Machine, Round Head, 10-24 x 1/4  | 5                | 5               |
| 176      |            |          | Screw, Machine, Round Head, 8-32 x 1/4   | 2                | 2               |
| 177      |            | 700076   | Screw, Cover   | 2                | 2               |
| 178      |            | 990318   | Decal  | 1                | 1               |
| 179      |            | 990319   | Decal, Spindle Speed Selector  | 1                | 1               |
| 180      |            | 990320   | Decal, Oil   | 1                | 1               |
| 181      |            | 990321   | Decal, Carriage Speed Control  | 1                | 1               |
| 182      | 100385     |          | Large Handwheel Assembly   |                  | 1               |
| 183      |            | 450358   | Pin, Spring, Handwheel   | 1                | 2               |
| 184      | 100396     |          | Vertical Tube Assembly   |                  | 1               |
| 185      |            | 650256   | Retaining Ring   | 2                | 2               |
| 186      |            | 150093   | Bushing  | 1                | 1               |
| 187      | 100399     |          | Adjusting Bushing Assembly   |                  | 1               |
| 188      |            | 150094   | Bearing, Rod End   | 1                | 1               |
| 189      |            |          | Nut, Jam, Hex, Finished, Plated, 5/8-18  | 1                | 1               |
| 190      | 100398     |          | Cam Shaft Assembly   |                  | 1               |
| 191      |            | 370119   | Cam  | 1                | 1               |
| 192      |            | 700243   | Screw, Set, Socket   | 1                | 1               |
| 193      |            | 450355   | Pin, Spring, Stop  | 1                | 1               |
| 194      |            | 450043   | Pin, Spring  | 1                | 3               |
| 195      | 100397     |          | Locking Screw Shaft Assembly   |                  | 1               |
| 196      |            | 330081   | Ball   | 1                | 2               |
| 197      | 100395     |          | Horizontal Tube Assembly   |                  | 1               |
| 198      |            | 130386   | Plate, Mounting, Bottom  | 1                | 1               |
| 199      |            |          | Screw, Cap, Hex Head, 1/2-13 x 1" Long   | 2                | 2               |
| 200      |            |          | Screw, Cap, Hex Head, 1/2-13 x 5/8" Long   | 1                | 1               |



## Section II

## PARTS LIST FOR MODEL 1960-G, LATHE, BRAKE DRUM

| Item No. | Ass'y. No. | Part No. | Description                                  | Quan. per Ass'y. | Quan. per Mach. |
|----------|------------|----------|--|------------------|-----------------|
| 201      |            | 500136   | Pulley, Variable Speed                       | 1                | 1               |
| 202      |            | 150089   | Bearing, Needle                              | 2                | 2               |
| 203      |            | 250057   | Seal, Pulley                                 | 2                | 2               |
| 204      |            | 650261   | Collar, Pulley                               | 1                | 1               |
| 205      |            |          | Screw, Set, Socket, Nyloc, 5/16-18 x 5/16"   | 1                | 2               |
| 206      |            | 450043   | Pin, Spring                                  | 1                | 3               |
| 207      |            |          | Lever, Speed                                 |                  |                 |
| 208      |            |          | Lever, Direction                             |                  |                 |
| 209      |            |          | Plug, Vent                                   |                  |                 |
| 210      |            |          | Plug, Drain                                  |                  |                 |
|          |            |          | ACCESSORIES                                  |                  |                 |
|          |            | R-315    | Spring                                       |                  | 1               |
|          |            | R-320    | Spacer, 3" Long x 2" Bore                    |                  | 4               |
|          |            | R-325    | Spacer, 2" Long x 2" Bore                    |                  | 1               |
|          |            | R-330    | Spacer, 1" long x 2" Bore                    |                  | 1               |
|          |            | R-331    | Reducer, 2" Dia. x 1" Bore x 1-1/8" Long     |                  | 2               |
|          |            | R-335    | Tapered Cone, 7-17/32" x 8-11/64" x 2" Bore  |                  | 1               |
|          |            | R-340    | Tapered Cone, 6-63/64" x 7-5/8" x 2" Bore    |                  | 1               |
|          |            | R-345    | Tapered Cone, 6-31/64" x 7-1/8" x 2" Bore    |                  | 1               |
|          |            | R-350    | Tapered Cone, 5-59/64" x 6-9/16" x 2" Bore   |                  | 1               |
|          |            | R-355    | Tapered Cone, 5-25/64" x 6-1/32" x 2" Bore   |                  | 2               |
|          |            | R-360    | Tapered Cone, 4-55/64" x 5-1/2" x 2" Bore    |                  | 2               |
|          |            | R-365    | Tapered Cone, 4-5/16" x 4-31/32" x 2" Bore   |                  | 2               |
|          |            | R-370    | Tapered Cone, 3-25/32" x 4-27/64" x 2" Bore  |                  | 2               |
|          |            | R-375    | Tapered Cone, 3-17/64" x 3-57/64" x 2" Bore  |                  | 1               |
|          |            | R-380    | Tapered Cone, 2-23/32" x 3-11/32" x 2" Bore  |                  | 1               |
|          |            | R-385    | Tapered Cone, 2-15/64" x 3-3/8" x 2" Bore    |                  | 1               |
|          |            | R-390    | Arbor, 2" Diameter                           |                  | 1               |
|          |            | R-395    | Arbor Nut, 2"                                |                  | 1               |
|          |            | R-405    | Draw Bar                                     |                  | 1               |
|          |            | R-501    | Reducer, 1" to 11/16" Diameter x 1-3/8" Long |                  | 1               |
|          |            | R-510    | Tapered Cone, 3/4" x 1-1/2" x 11/16" Bore    |                  | 1               |
|          |            | R-520    | Tapered Cone, 1-1/16" x 1-3/4" x 1" Bore     |                  | 1               |
|          |            | R-530    | Spacer, 1" Long x 11/16" Bore                |                  | 2               |
|          |            | R-540    | Spacer, 1" Long x 1" Bore                    |                  | 2               |
|          |            | R-550    | Radii Cone, 1-1/2" x 1-45/64" x 1" Bore      |                  | 1               |
|          |            | R-560    | Radii Cone, 1-19/32" x 1-49/64" x 1" Bore    |                  | 1               |
|          |            | R-570    | Radii Cone, 1-61/64" x 2-13/64" x 1" Bore    |                  | 1               |
|          |            | R-580    | Radii Cone, 1-13/32" x 2-3/8" x 1" Bore      |                  | 1               |
|          |            | R-590    | Radii Cone, 2-19/64" x 2-1/2" x 1" Bore      |                  | 1               |
|          |            | R-600    | Radii Cone, 2-27/64" x 2-39/64" x 1" Bore    |                  | 1               |
|          |            | R-610    | Radii Cone, 2-35/64" x 2-25/32" x 1" Bore    |                  | 1               |
|          |            | R-620    | Radii Cone, 1-27/32" x 2-55/64" x 1" Bore    |                  | 1               |
|          |            | R-630    | Radii Cone, 2-1/16" x 3-19/64" x 1" Bore     |                  | 1               |
|          |            | R-640    | Arbor, 1" x 11/16"                           |                  | 1               |
|          |            | R-645    | Arbor Nut, 11/16"                            |                  | 1               |
|          |            | R-655    | Face Plate, 1" Bore                          |                  | 2               |
|          |            | R-665    | Centering Cone, 2-5/16" x 3-1/4" x 1" Bore   |                  | 1               |
|          |            | R-670    | Centering Cone, 3-1/16" x 4" x 1" Bore       |                  | 1               |
|          |            | R-675    | Spring                                       |                  | 1               |
|          |            | R-680    | Centering Cone, 1-15/32" x 2-3/8" x 1" Bore  |                  | 1               |
|          |            | R-740    | Arbor, 1"                                    |                  | 1               |
|          |            | R-745    | Arbor Nut, 1"                                |                  | 1               |
|          |            | SB-10    | Broke Drum Silencing Band, Passenger         |                  | 1               |
|          |            | SB-20    | Brake Drum Silencing Band, Truck             |                  | 1               |
|          |            |          | SPARE PARTS' & TOOLS                         |                  |                 |
|          |            | 83       | Allen Wrench, No. 8 Screw                    |                  | 1               |
|          |            | 119      | Allen Wrench, 1/4" Screw                     |                  | 1               |
|          |            | 500140   | "V" Belt, 3/8" x 57"                         |                  | 1               |
|          |            | 500141   | "V" Belt, 1/2" x 42"                         |                  | 1               |
|          |            | 500142   | "V" Belt, 1/2" x 58"                         |                  | 1               |
|          |            | CB-35    | 5/8" Solid Carbide-Tipped Tool Bit           |                  | 2               |
|          |            | CB-36    | 5/8" High Speed Steel Tool Bit               |                  | 2               |
|          |            | CB-75    | Hone   |                  | 1               |
|          |            | R-148    | 3/8" Open End Wrench                         |                  | 1               |
|          |            | R-149    | 3/4" Box Wrench                              |                  | 1               |
|          |            | R-152    | 7/16" Open End Wrench                        |                  | 1               |
|          |            | R-153    | 1/4" Open End Wrench                         |                  | 1               |
|          |            | R-154    | Open End Wrench, 1-1/4" x 1-5/8"             |                  | 1               |
|          |            | R-410    | Open End Wrench, 3"                          |                  | 1               |

APPENDIX

BASIC ISSUE ITEMS LIST

Section I. INTRODUCTION

1. General

This appendix is a list of basic issue items. It is composed of those items which make up the major end item of equipment and the operator's tools and equipment that are issued with the equipment and are required for stockage.

2. Requisition Notes

a. Repair Part Identified by Federal Stock Number.

- (1) If the exact item requisitioned is not furnished, or if other action is necessary, the exact nature of the action taken by the commodity command will be indicated by standard symbols on prescribed forms.
- (2) When requisitioning an item, the requesting agency will order the listed item. However, the commodity command will take necessary action to issue the exhausted stock item until stock is exhausted, whether it be an individual item, kit, set, or assembly.

b. Part to Which FSN Has Not Been Assigned.

When requisitioning a C source (local procurement) item identified only by a manufacturer's part number, it is mandatory that the following information be furnished the supply officer:

- (1) Manufacturer's code number (5-digit number preceding the colon in the descriptive column).
- (2) Manufacturer's part number (the number, and sometimes letters, following the colon, ((1) above). Dashes, commas, or other marks must be included exactly as listed.
- (3) Nomenclature exactly as listed herein, including dimensions if necessary
- (4) Name of manufacturer of end item (from cover of TM or manufacturer's name plate).
- (5) Federal stock number of end item (from TM).
- (6) Manufacturer's model number (from TM or name/data plate, preferably name/data plate).
- (7) Manufacturer's serial number (from name/data plate).

- (8) Any other information such as type, frame number, and electrical characteristics, if applicable.
- (9) 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, and 6, list manufacturer's code and manufacturer's part number (as listed in description column).
  - (b) In remarks field, list noun name (repair part), end item application (FSN of end item), manufacturer, model number (end item), serial number (end item), and any other pertinent information such as frame number, type, etc.

3. Explanation of Columns

a. Source, Maintenance, and Recoverability Code (col 1).

- (1) Materiel numerical codes (col 1a). Not required.
- (2) Source (col 1b). This column indicates the selection status and source for the listed item. Source code used in this list is-

| Code   | Explanation   |
|--------|---|
| C..... | Obtain through local procurement. If not obtainable from local procurement, requisition through normal supply channels with a supporting statement of nonavailability from local procurement. |

- (3) Maintenance level (col 1c). This column indicates the category of maintenance authorized to install the listed item. Maintenance level code used in this list is-

| Code    | Explanation                 |
|---------|-----------------------------|
| O ..... | Organizational maintenance. |

- (4) Recoverability (col 1d). This column indicates whether unserviceable items should be returned for recovery or salvage. When no code is indicated, the item will be considered expendable. Recoverability code used in this list is-

| <i>Code</i> | <i>Explanation</i>  |
|-------------|---|
| R .....     | Items which are economically repairable at direct and general support maintenance activities and are normally furnished by supply on an exchange basis. |

*b. Federal Stock Number (col 2).* This column indicates the Federal stock number has been assigned by the Cataloging Division, Defense Logistics Services Center.

*c. Description (col 3).* This column indicates the Federal item name (shown in capital letters) and any additional description required for supply operations. The manufacturer's code and part number are also included for reference.

| <i>Code</i> | <i>Explanation</i>           |
|-------------|------------------------------|
| 57127.....  | Star Machine & Tool Company. |

*d. Unit of Issue (col 4).* This column indicates the quantity to be requisitioned.

*e. Quantity Authorized (col 5).* This column indicates the quantity of the listed item authorized for stockage to constitute the prescribed load.

#### 4. Abbreviations and Symbols

##### *a. Abbreviations.*

| <i>Abbreviations</i> | <i>Explanation</i> |
|----------------------|--------------------|
| c .....              | cycle(s)           |
| cire .....           | circumference      |
| deg .....            | degree(s)          |
| fl .....             | flat               |

| <i>Abbreviations</i> | <i>Explanation</i> |
|----------------------|--------------------|
| hdl .....            | handle(d) (s)      |
| hd .....             | head               |
| HSS .....            | high speed steel   |
| min .....            | minimum            |
| mtd .....            | mounted            |
| nom .....            | nominal            |
| o/a .....            | overall            |
| sgle-ph.....         | single phase       |
| v .....              | volt(s)            |
| w.....               | wide, width        |
| w/.....              | with               |

##### *b. Symbols.*

| <i>Symbols</i> | <i>Explanation</i> |
|----------------|--------------------|
| x .....        | by(2 x 4)          |

#### 5. Suggestions and Recommendations

The direct reporting by the individual user, of errors, omissions, and recommendations for improving this manual, is authorized and encouraged. DA Form 2028 (Recommended Changes to DA Publications) will be used for reporting these improvements. This form will be completed in triplicate using pencil, pen, or typewriter. The original and one copy will be forwarded direct to Commanding General, Headquarters, U.S. Army Weapons Command, ATTN: AMSWE-SMM-P, Rock Island Arsenal, Rock Island, Ill. 61202. One information copy will be provided to the individual's immediate supervisor (e.g., officer, noncommissioned officer, supervisor, etc.).

**Section II. BASIC ISSUE ITEMS LIST**

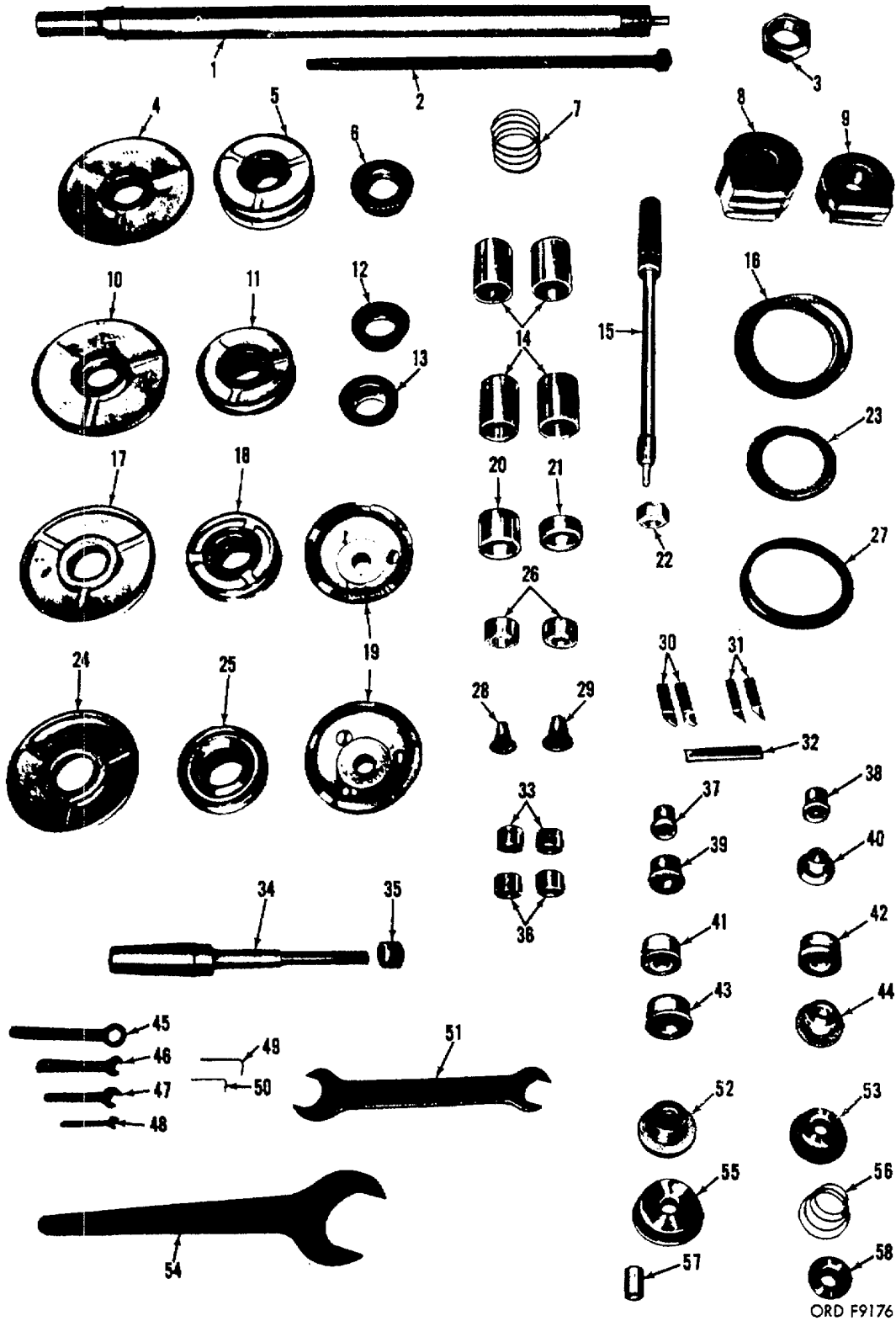
| (1)<br>Source,<br>maint. and<br>recov. code |              |              |               | (2)<br>Federal<br>stock No. | (3)<br>Description  | (4)<br>Unit<br>of<br>issue | (5)<br>Qty<br>auth | (6)<br>Illustration |                    |
|---|--------------|--------------|---------------|-----------------------------|---|----------------------------|--------------------|---------------------|--------------------|
| (a)<br>Mat.<br>code                         | (b)<br>Sour. | (c)<br>Maint | (d)<br>Recov. |                             |   |                            |                    | (a)<br>Fig.<br>No.  | (b)<br>Item<br>No. |
|   |              |              | R             | 4910-516-6192               | <p align="center"><b>MAJOR COMBINATION</b></p> <p>The following item is to be requisitioned for initial use only.</p> <p>LATHE,BRAKE DRUM: floor mtd, 60 in. rated swing, 25 in. max drum dia, 9 in. min drum dia, w/grinding provisions, 1 hp drive motor, 1/2 hp grinding motor, 115-v, 60 c, sgle-ph (57127:1960).</p> <p align="center"><b>COMPONENTS OF MAJOR COMBINATION</b></p> <p align="center">None authorized.</p> <p align="center"><b>SPARE PARTS</b></p> <p align="center">None authorized.</p> <p align="center"><b>REPAIR PARTS</b></p> | ea                         |                    |                     |                    |
| C   | O            |              |               |                             | BELT, V: rubberized fabric, 57 outside circ, 3/8 top w (57127:500140).  | ea                         | 1                  | 1                   | 16                 |
| C   | O            |              |               |                             | BELT, V: rubberized fabric, 42 outside circ, 1/2 top w (57127:500141).  | ea                         | 1                  | 1                   | 23                 |
| C   | O            |              |               |                             | BELT, V: rubberized fabric, 58 outside circ, 1/2 top w (57127:500142).  | ea                         | 1                  | 1                   | 27                 |
|   |              |              |               |                             | TOOLS AND EQUIPMENT FOR:  |                            |                    |                     |                    |
|   |              |              |               |                             | LATHE, BRAKE DRUM: (57127:1960)   |                            |                    |                     |                    |
| C   | O            |              |               |                             | ARBOR, DRUM: 1 in. dia, 1 in. thd (57127:R-760).  | ea                         | 1                  | 1                   | 15                 |
| C   | O            |              |               |                             | ARBOR, DRUM: 1 in. dia, 11/16 thd (57127:R-640).  | ea                         | 1                  | 1                   | 34                 |
| C   | O            |              |               |                             | ARBOR, DRUM: 2 in. dia, 2 in. thd (57127:R-390).  | ea                         | 1                  | 1                   | 1                  |
| C   | O            |              |               |                             | BAND, BRAKE DRUM SILENCING: passen-ger car (57127:SB-10).   | ea                         | 1                  | 1                   | 9                  |
| C   | O            |              |               |                             | BAND, BRAKE DRUM SILENCING: truck (57127:SB-20).  | ea                         | 1                  | 1                   | 8                  |
| C   | O            |              |               |                             | BAR, DRAW: arbor holding (57127:R-405) .....  | ea                         | 1                  | 1                   | 2                  |
| C   | O            |              |               |                             | CONE, CENTERING: 1 15/32 x 2 3/8 x 1 bore (57127:R-680).  | ea                         | 1                  | 1                   | 58                 |
| C   | O            |              |               |                             | CONE, CENTERING: 2 15/16 x 3 1/4 x 1 bore (57127:R-665).  | ea                         | 1                  | 1                   | 53                 |
| C   | O            |              |               |                             | CONE, CENTERING: 3 1/16 x 4 x 1 bore (57127:R-470).   | ea                         | 1                  | 1                   | 55                 |

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| (1)<br>Source,<br>maint. and<br>recov. code |              |              |               | (2)<br>Federal<br>stock No. | (3)<br>Description   | (4)<br>Unit<br>of<br>issu<br>e | (5)<br>Qty<br>auth. | (6)<br>Illustration |                    |
|---|--------------|--------------|---------------|-----------------------------|--|--------------------------------|---------------------|---------------------|--------------------|
| (a)<br>Mat.<br>code                         | (b)<br>Sour. | (c)<br>Maint | (d)<br>Recov. |                             |  |                                |                     | (a)<br>Fig.<br>No.  | (b)<br>Item<br>No. |
|   |              |              |               |                             | TOOLS AND EQUIPMENT FOR-Cont.<br>LATHE, BRAKE DRUM: (57127:1960)-Cont.           |                                |                     |                     |                    |
| C   | O            |              |               |                             | CONE, RADII: 1 13/32 x 2 3/8 x 1 bore (57127:R-580).                             | ea                             | 1                   | 1                   | 37                 |
| C   | O            |              |               |                             | CONE, RADII: 1 1/2 x 1 45/64 x 1 bore (57127:R-550).                             | ea                             | 1                   | 1                   | 38                 |
| C   | O            |              |               |                             | CONE, RADII: 1 19/32 x 1 49/64 x 1 bore (57127:R-560).                           | ea                             | 1                   | 1                   | 39                 |
| C   | O            |              |               |                             | CONE, RADII: 1 27/32 x 2 55/64 x 1 bore (52727:R-620).                           | ea                             | 1                   | 1                   | 41                 |
| C   | O            |              |               |                             | CONE, RADII: 1 61/64 x 2 13/64 x 1 bore (57127:R-570).                           | ea                             | 1                   | 1                   | 42                 |
| C   | O            |              |               |                             | CONE, RADII: 2 1/16 x 3 19/64 x 1 bore (57127:R-630).                            | ea                             | 1                   | 1                   | 43                 |
| C   | O            |              |               |                             | CONE, RADII: 2 19/64 x 2 1/2 x 1 bore (57127:R-590).                             | ea                             | 1                   | 1                   | 40                 |
| C   | O            |              |               |                             | CONE, RADII: 2 27/64 x 2 39/64 x 1 bore (57127:R-600).                           | ea                             | 1                   | 1                   | 44                 |
| C   | O            |              |               |                             | CONE, RADII: 2 35/64 x 2 25/64 x 1 bore (57127:R-610).                           | ea                             | 1                   | 1                   | 52                 |
| C   | O            |              |               |                             | CONE, TAPERED: 3/4 x 1 1/2 x 1 bore (57127:R-510).                               | ea                             | 1                   | 1                   | 28                 |
| C   | O            |              |               |                             | CONE, TAPERED: 1 1/16 x 1 3/4 x 1 bore (57127:R-520).                            | ea                             | 1                   | 1                   | 29                 |
| C   | O            |              |               |                             | CONE, TAPERED: 2 15/64; x 3 3/8 x 2 bore(57127:R-385).                           | ea                             | 1                   | 1                   | 13                 |
| C<br>12                                     | O            |              |               |                             | CONE, TAPERED: 2 23/64 x 3 11/32 x 2 bore(57127:R-380).                          | ea                             | 1                   | 1                   | 1                  |
| C   | O            |              |               |                             | CONE, TAPERED: 3 17/64x 3 52/64x 2 bore (57127:R-375).                           | ea                             | 1                   | 1                   | 6                  |
| C<br>25                                     | O            |              |               |                             | CONE, TAPERED: 3 25/32 x 4 27/64x 2 bore (57127:R-370).                          | ea                             | 2                   | 1                   | 18                 |
| C   | O            |              |               |                             | CONE, TAPERED: 4 5/16 x 4 31/32x 2 bore (57127:R-365).                           | ea                             | 2                   | 1                   | 11                 |
| C   | O            |              |               |                             | CONE, TAPERED: 4 55/64 x 5 1/2 x 2 bore (57127:R-360).                           | ea                             | 2                   | 1                   | 5                  |
| C   | O            |              |               |                             | CONE, TAPERED: 5 25/64 x 6 9/16 x 2 bore (57127:R-355).                          | ea                             | 2                   | 1                   | 24                 |
| C   | O            |              |               |                             | CONE, TAPERED: 5 59/64 x 6 9/16 x 2 bore(57127:R-350).                           | ea                             | 1                   | 1                   | 17                 |
| C   | O            |              |               |                             | CONE, TAPERED: 6 31/64 x 7 1/8x 2 bore (57127:R-345).                            | ea                             | 1                   | 1                   | 10                 |
| C   | O            |              |               |                             | CONE, TAPERED: 6 63/64 x 7 5/8x 2 bore (57127:R-340).                            | ea                             | 1                   | 1                   | 4                  |
| C   | O            |              |               |                             | CONE, TAPERED: 7 17/64 x 8 11/61 x 2 bore (57-127: R-335).                       | ea                             | 1                   | 1                   | 32                 |
| C   | O            |              |               |                             | HONE, SHARPENING: tool bit (57127:CB-75)_  | ea                             | 1                   | 1                   | 50                 |
| C   | O            |              |               | .....5120-224-2504          | KEY, SOCKET HEAD SCREW: hex type,<br>L-hdl, 5/64 across fl, 1 7/8 nom lg arm lg. | ea                             | 1                   | 1                   | 49                 |
| C   | O            |              |               | .....5120-240-5292          | KEY, SOCKET HEAD SCREW: hex type,<br>L-hdl, 1/8 across fl, 2 1/4 nom lg arm lg.  | ea                             | 1                   | 1                   |                    |

| (1)<br>Source,<br>maint. and<br>recov. code |              |              |               | (2)<br>Federal<br>stock No. | (3)<br>Description  | (4)<br>Unit<br>of<br>issue | (5)<br>Qty<br>auth | (6)<br>Illustration |                    |
|---|--------------|--------------|---------------|-----------------------------|---|----------------------------|--------------------|---------------------|--------------------|
| (a)<br>Mat.<br>code                         | (b)<br>Sour. | (c)<br>Maint | (d)<br>Recov. |                             |   |                            |                    | (a)<br>Fig.<br>No.  | (b)<br>Item<br>No. |
|   |              |              |               |                             | TOOLS AND EQUIPMENT FOR-Cont.<br>LATHE, BRAKE DRUM: (57127:1960)-Cont.  |                            |                    |                     |                    |
| C   | O            |              |               |                             | NUT, ARBOR: 11/16 thd (57127:R-645).....  | ea                         | 1                  | 1                   | 35                 |
| C   | O            |              |               |                             | NUT, ARBOR: 1 in. thd (57127:R-745).....  | ea                         | 1                  | 1                   | 22                 |
| C   | O            |              |               |                             | NUT, ARBOR: 2 in. thd (57127:R-395).....  | ea                         | 1                  | 1                   | 3                  |
| C   | O            |              |               |                             | PLATE, FACE: 1 in. bore (57127:R-655)   | ea                         | 2                  | 1                   | 19                 |
| C   | O            |              |               |                             | REDUCER: 1 in. od to 11/16 id, 1 3/8 lg (57127:R-501).  | ea                         | 1                  | 1                   | 57                 |
| C   | O            |              |               |                             | REDUCER: 2 in. od to 1 in. id, 1 1/8 lg (57127:R-331).  | ea                         | 2                  | 1                   | 26                 |
| C   | O            |              |               |                             | SPACER, ARBOR: 11/16 bore, 1 in. lg (57127:R-530).  | ea                         | 2                  | 1                   | 33                 |
| C   | O            |              |               |                             | SPACER, ARBOR: 1 in. bore, 1 in. lg (57127:R-540).  | ea                         | 2                  | 1                   | 36                 |
| C   | O            |              |               |                             | SPACER, ARBOR: 2 in. bore, 1 in. lg (57127:R-330).  | ea                         | 1                  | 1                   | 21                 |
| C   | O            |              |               |                             | SPACER, ARBOR: 2 in. bore, 2 in. lg (57127:R-325).  | ea                         | 1                  | 1                   | 20                 |
| C   | O            |              |               |                             | SPACER, ARBOR: 2 in. bore, 3 in. lg (57127:R-320).  | ea                         | 4                  | 1                   | 14                 |
| C   | O            |              |               |                             | SPRING, COIL: 4 coil, 2 3/8 od (57127:R-315)  | ea                         | 1                  | 1                   | 7                  |
| C   | O            |              |               |                             | SPRING, COIL: 4 coil, 2 3/8 id tapered to 1 1/2 id (57127:R-675).   | ea                         | 1                  | 1                   | 56                 |
| C   | O            |              |               |                             | TOOL BIT: 5/8 sq, carbide tipped (57127:CB-35).   | ea                         | 2                  | 1                   | 30                 |
| C   | O            |              |               |                             | TOOL BIT: 5/8 sq HSS (57127:CB-36).....   | ea                         | 2                  | 1                   | 31                 |
| C   | O            |              |               | 5120-293-1266               | WRENCH, BOX: stght, sgle-hd type, hex shape wrench opng, 3/4 opng, 4 3/8 nom o/a lg (57127:R-149).  | ea                         | 1                  | 1                   | 45                 |
| C   | O            |              |               | 5120-293-2124               | WRENCH, OPEN END, FIXED: dble-hd type, 15 deg angle of hd, engineer style, 1 1/4 and 1 5/8 wrench opngs, 14 nom o/a lg, 9/16 thk of hd (57127:R-154). | ea                         | 1                  | 1                   | 51                 |
| C   | O            |              |               | 5120-293-1840               | WRENCH, OPEN END, FIXED: sgle-hd type, 15 deg angle of hd, 1/4 wrench opng, 3 1/2 nom o/a lg, 3/16 thk hd (57127:R-153).                              | ea                         | 1                  | 1                   | 48                 |
| C   | O            |              |               | 5120-277-1261               | WRENCH, OPEN END, FIXED: sgle-hd type, 15 deg angle of hd, 3/8 wrench opng, 3 7/8 nom o/a lg, 17/64 thk hd (57127:R-148).                             | ea                         | 1                  | 1                   | 47                 |
| C   | O            |              |               |                             | WRENCH, OPEN END, FIXED: sgle-hd type, 15 aeg angle of hd, 7/16 wrench opng (57127:R-152).  | ea                         | 1                  | 1                   | 46                 |
| C   | O            |              |               |                             | WRENCH, OPEN END, FIXED: sgle-hd type, 15 deg angle of hd, 3 wrench opng, 17 nom o/a lg (57127:R-410).  | ea                         | 1                  | 1                   | 54                 |

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Figure 1. Tools and equipment.

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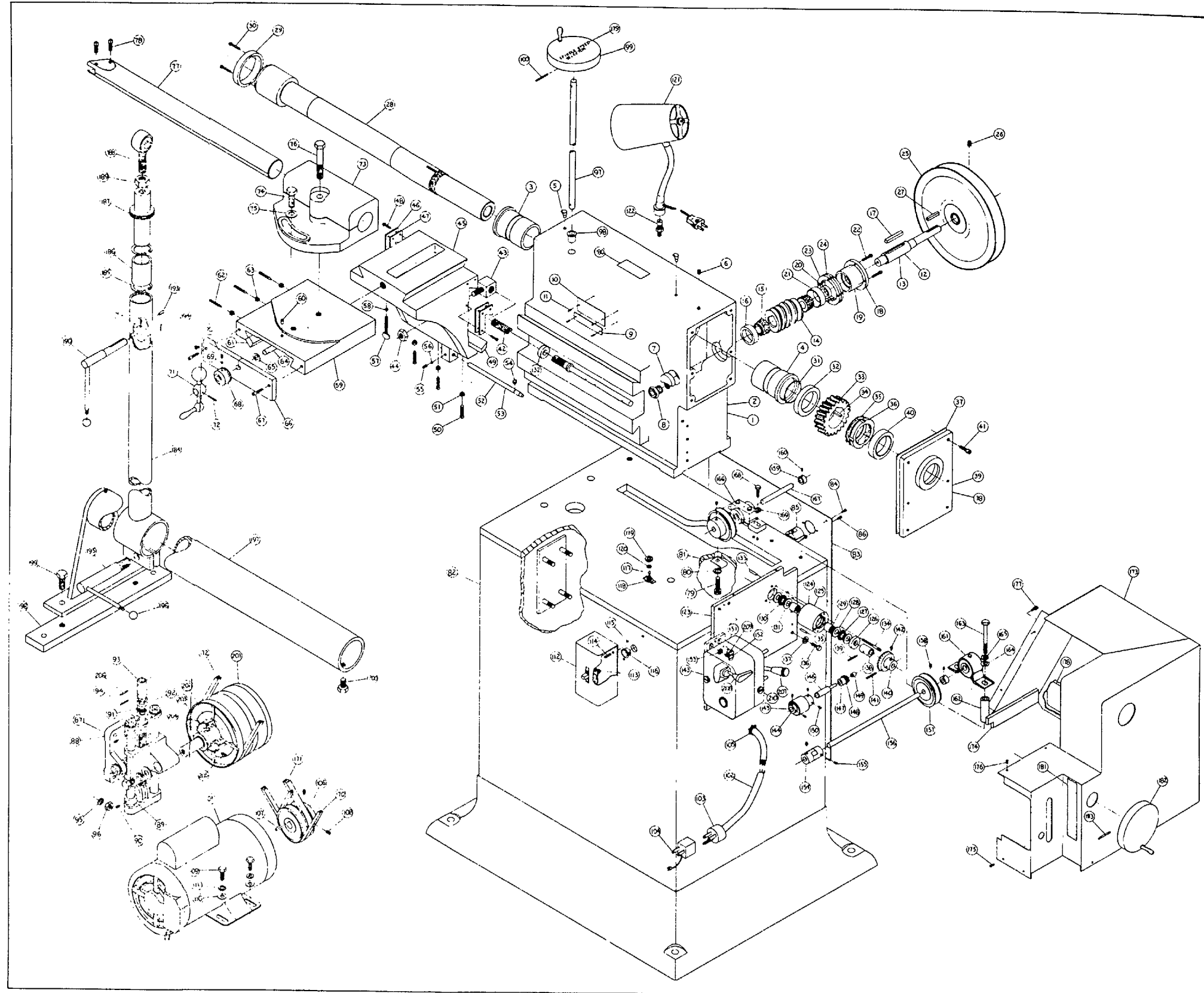


FIG. 2-1. PARTS BREAKDOWN MODEL 1960



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