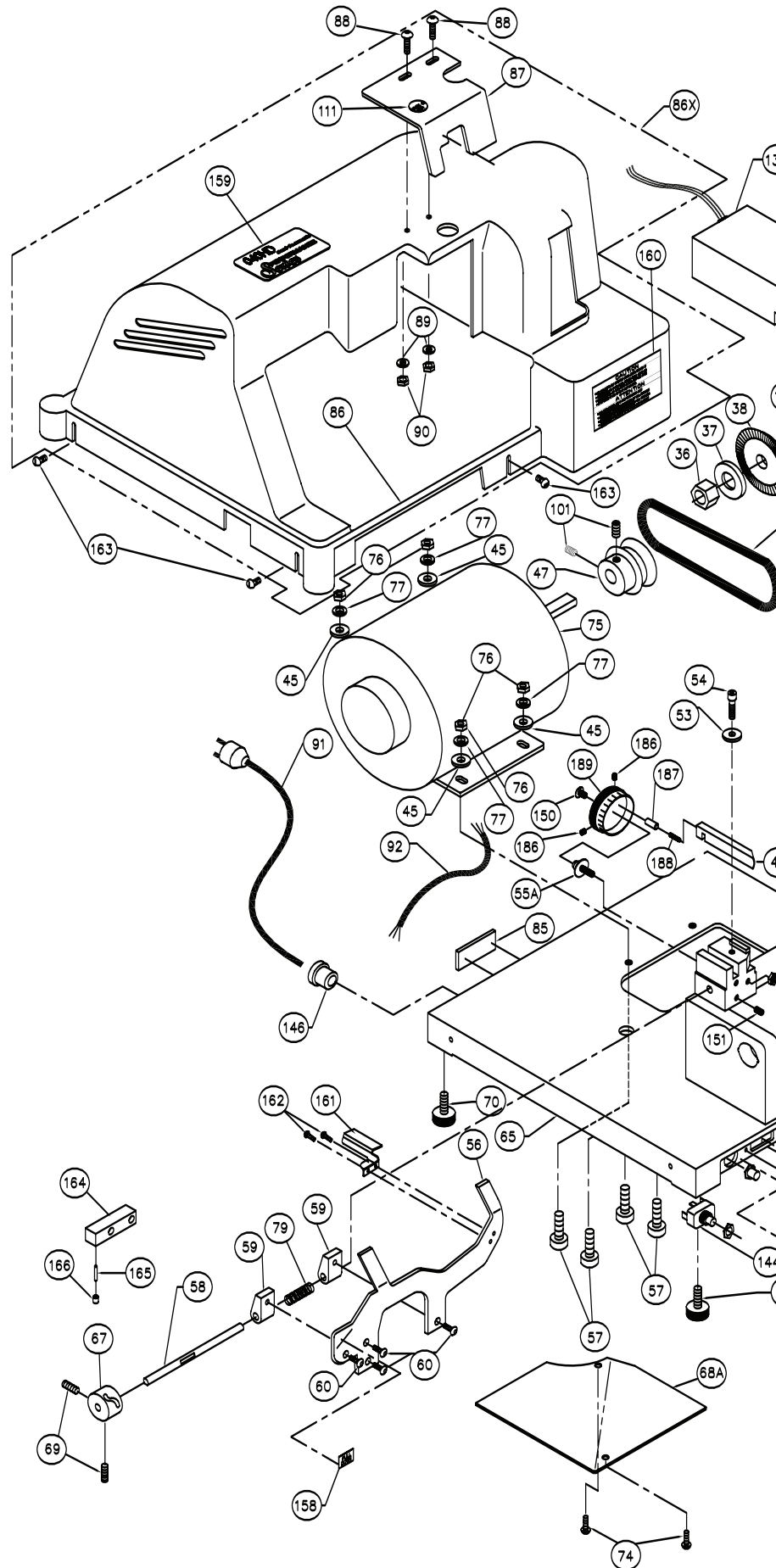
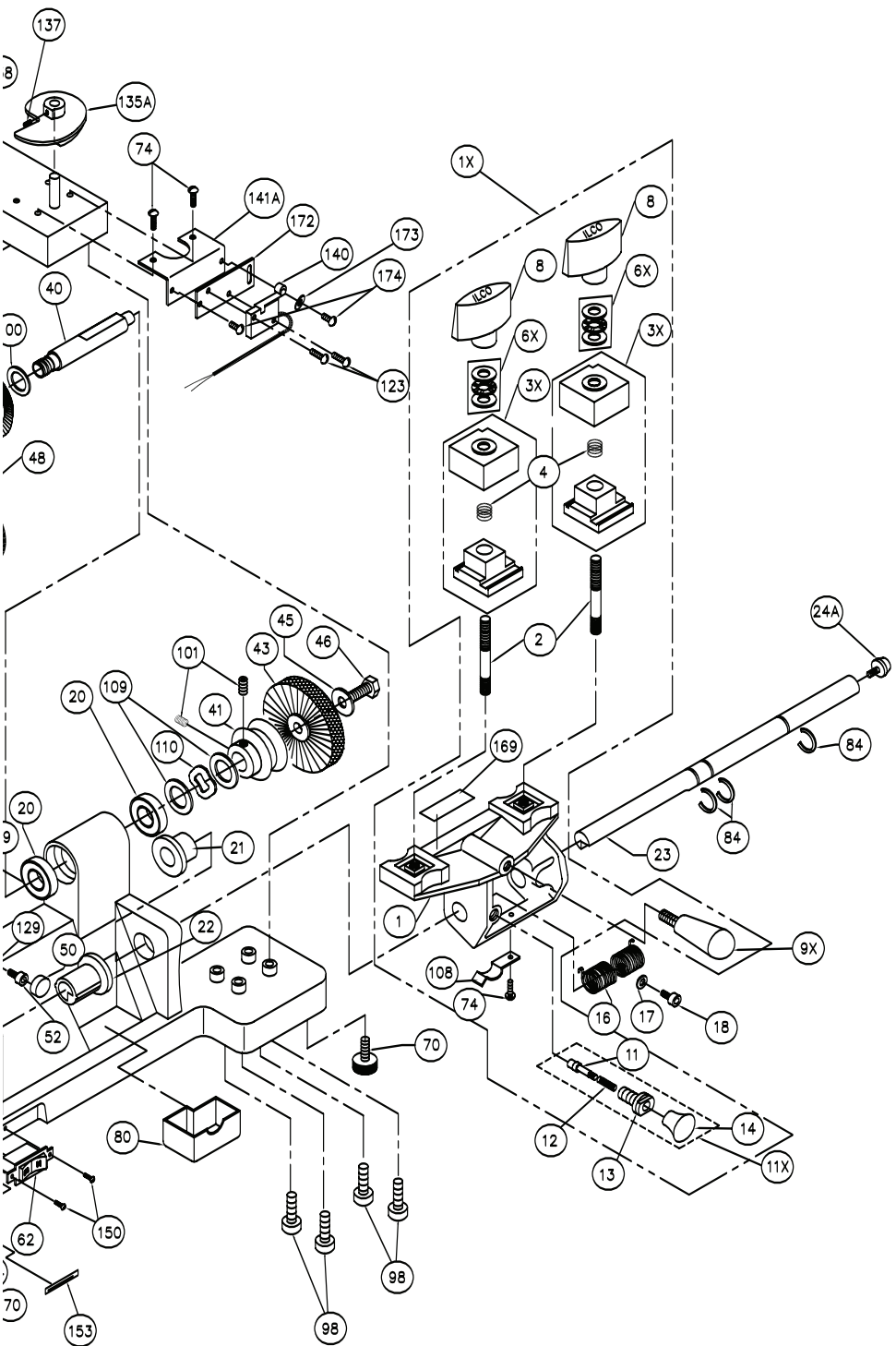


EXPLODED VIEW



EXPLODED VIEW



EXPLODED VIEW PARTS LIST

Refer to pages 6-7 for illustration

| Ref. | Part no. | Description | Ref. | Part no. | Description |
|------|-----------|---------------------------------|------|-----------|-----------------------------------|
| 1 | 040HD-1 | Carriage | 87 | 040HD-87 | Safety shield |
| 1X | 040HD-1X | Carriage assembly | 90 | 025-90 | Nut, #10-32 |
| 2 | 025-2 | Carriage stud | 91 | 040-91 | Power cord |
| 3X | 045HD-3X | Vise jaw assembly (Super Jaw 3) | 92 | 040-92 | motor cable |
| 4 | 025-4 | Vise jaw spring | 98 | 040-98 | Cam motor screws |
| 6X | 025-6X | Thrust bearing set | 100 | 040HD-100 | Cutter spacer; right |
| 8 | 025-8 | Wing nut | 101 | 025-101 | Set screw, 1/4-20x1/4" |
| 9X | 040-9X | Carriage handle | 106 | 040-106 | Chip tray |
| 11 | 040-11 | Trigger Pin | 108 | 040-108 | Carriage Bumper |
| 11X | 040-11X | Trigger Assembly | 109 | 025-109 | Bearing washer |
| 16 | 040-16 | Carriage torsion spring | 110 | 025-110 | Wave washer |
| 17 | 025-17 | Washer | 123 | 040-123 | Screw, #4-40x1/2" |
| 18 | 025-18 | Screw. 10-32 x 1/2" | 129 | 040-129 | Locking nut (8-32) |
| 20 | 040HD-20 | Cutter shaft bearings | 135 | 040-135 | Cam |
| 21 | 025-21 | Carriage shaft bushing, right | 137 | 040-137 | Set screw, #10-32 x 3/16" |
| 22 | 040-22 | Carriage shaft bushing, left | 138 | 040-138 | Gear motor (115V) |
| 23 | 040HD-23 | Carriage shaft | 140 | 040-140 | Gear motor cam |
| 24 | 040-24 | Friction Reducer | 141A | 040-141A | Micro switch plate |
| 36 | 025-36 | Cutter nut, N-4 | 144 | 040HD-144 | Automatic cycle switch |
| 37 | 025-37 | Cutter spacer; left | 146 | 040-146 | Strain relief for power cord |
| 38 | P-CU20 | P-CU20 cutter | 150 | 040-150 | Switch screw (6-32 x 1/4") |
| 40 | 040HD-40 | Cutter shaft | 151 | 040-151 | Set screw (8-32 x 3/8") |
| 41 | 040HD-41 | Cutter shaft pulley (2") | 153 | 040HD-153 | Switch panel label |
| 43 | 025-43 | Nylon brush | 158 | 040-158 | Key gauge label |
| 45 | 025-45 | Brush bolt washer, 5/16 | 160 | 025-160 | Caution label |
| 46A | 025-46A | Hex head screw, 5/16-18 x 3/4 | 161 | 040-161 | Key Gauge guard |
| 47 | 025-47 | Motor pulley 2" - 3L | 162 | 040-162 | Key Gauge guard Screws |
| 48 | 040HD-48 | V-Belt, 3L160 | 163 | 045-163 | Hood Screw |
| 49 | 040-49 | Cutter guide (stylus) | 164 | 040-164 | Cam follower block |
| 50 | 040-50 | Carriage stop | 165 | 040-165 | 3932 x 1/2 dowel pin |
| 52 | 040-52 | Socket hd. screw 8-32 x 1-1/2" | 166 | 044-166 | Cam follower pin |
| 53 | 040-53A | Cutter guide binding plate | 169 | 040-169 | Carriage Label |
| 54 | 045-54 | Cutter guide binding screw | 171 | 025-171 | Cutter pulley set screw, 3/8" -18 |
| 55 | 045-55A | Adjusting screw | 181 | 024B-181 | Key Gauge Spacer - Left |
| 56 | 040-56 | Key gauge | 183 | 040-183 | 1/4-20 Lockwasher |
| 58 | 040-58 | Key gauge dowel pin | 184 | 040-184 | 1/4-20 Hex Nut |
| 59 | 025-59 | Key gauge housing | 186 | 045-186 | 6-32 x 3/8" set screw |
| 60 | 025-60 | Cap screw, 8-32 x 1/2" | 187 | 045-187 | dowel |
| 62 | 025-62A | On/Off switch | 188 | 045-188 | dowel spring |
| 65 | 040HD-65 | Base machined | 189 | 045-189 | Adjustment dial |
| 68 | 040-68 | Electrical cover | 190 | 045-190 | Cutter guide label |
| 69 | 040-69 | Set Screw 10-24 x 3/8" | 191 | 040-191 | Switch plate (adjustable) |
| 70 | 040-70 | Rubber mount | 192 | 040-192 | Switch plate screws |
| 74 | 040-74 | Truss head screw, 8-32 | 193 | 040-193 | Switch plate washer |
| 75 | 040-75 | Motor, 1/4hp, 115V C/S | 194 | 045-194 | #10 flat washer |
| 79 | 040-79 | Key gauge spring | 195 | 045-195 | 10-32 x 1/2" Button hd. screw |
| 84 | 024B-84 | Crescent ring | NS | 040HD-IM | 040 HD Instruction Manual |
| 86X | 040HD-86X | Safety hood assembly | | | |