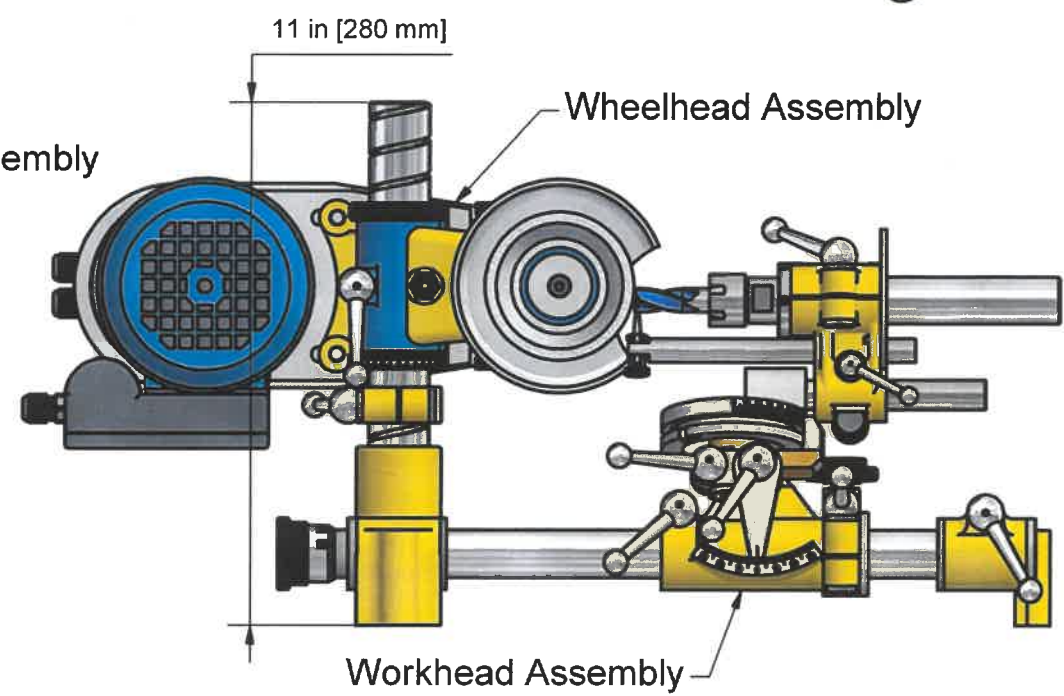
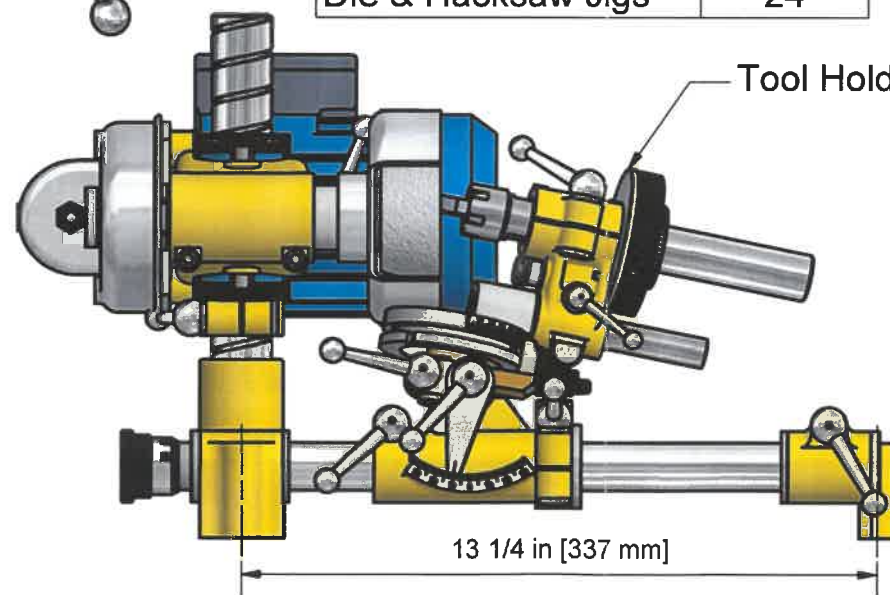
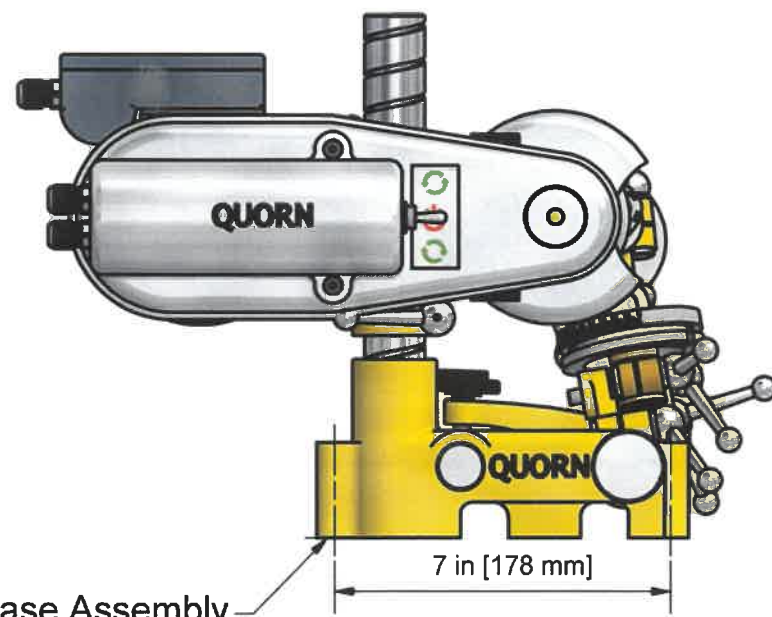


DRAWING INDEX - HK 2600©

DESCRIPTION	SHEETS
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Tool Holder Assembly	14 - 16
Spiralling Head	17 - 18
Ball Handles	19
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Motor & Electrical	22
Double Cotter Joints	23
Die & Hacksaw Jigs	24



Base Assembly

Tool Holder Assembly

Wheelhead Assembly

Workhead Assembly



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TITLE:
Quorn Mk3 - T & C Grinder

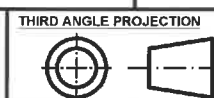
KIT CODE:
HK 2600

DESIGNER:
D H Chaddock CBE MSc CEng FIMechE

126 DUNVAL ROAD, BRIDGNORTH,
SHROPSHIRE, WV16 4LZ, UK
www.hemingwaykits.com

ORIGINAL DESIGN:
04/01/1974

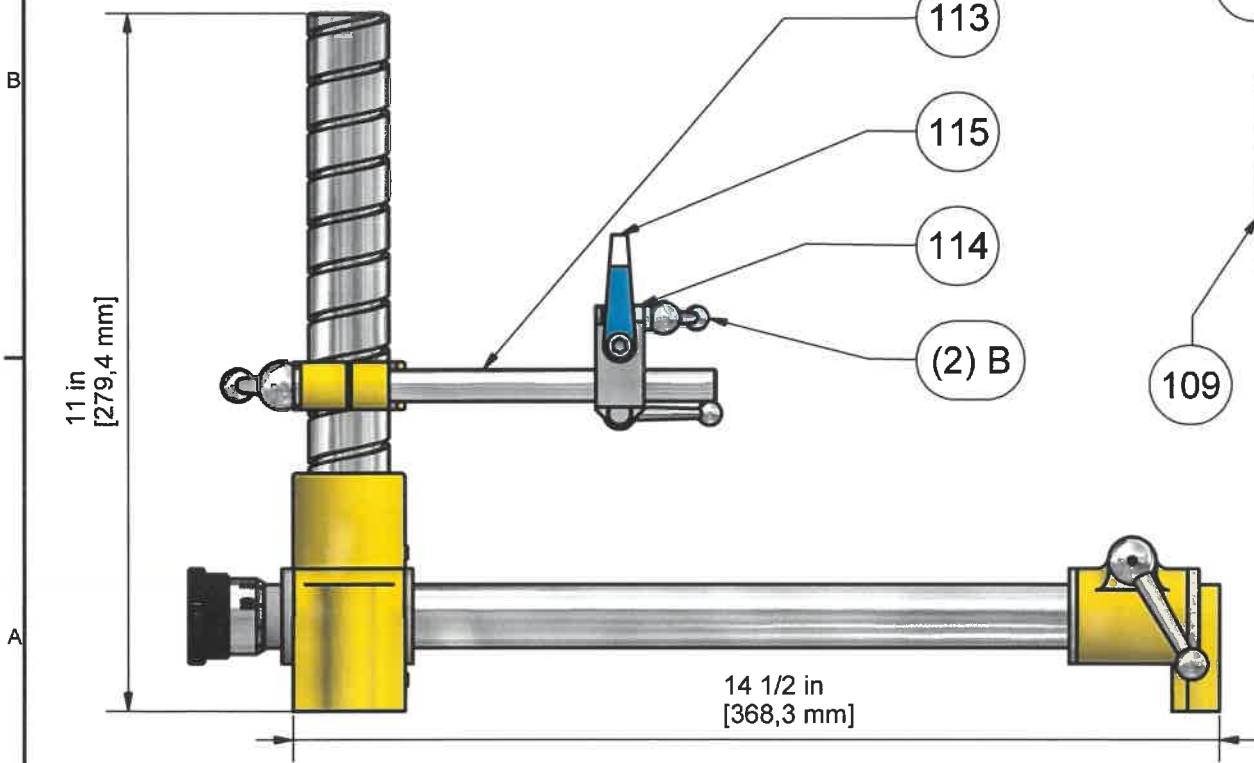
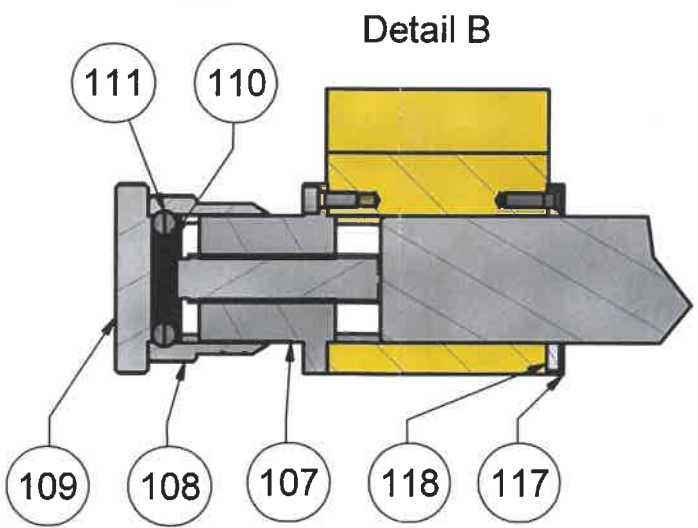
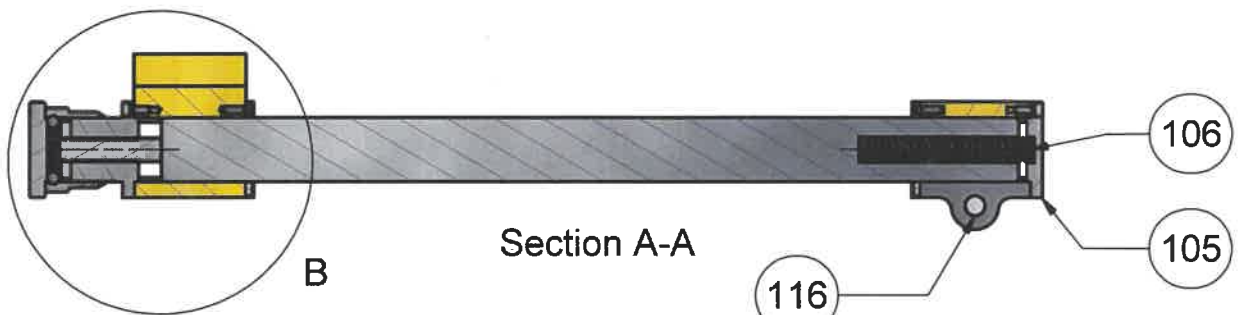
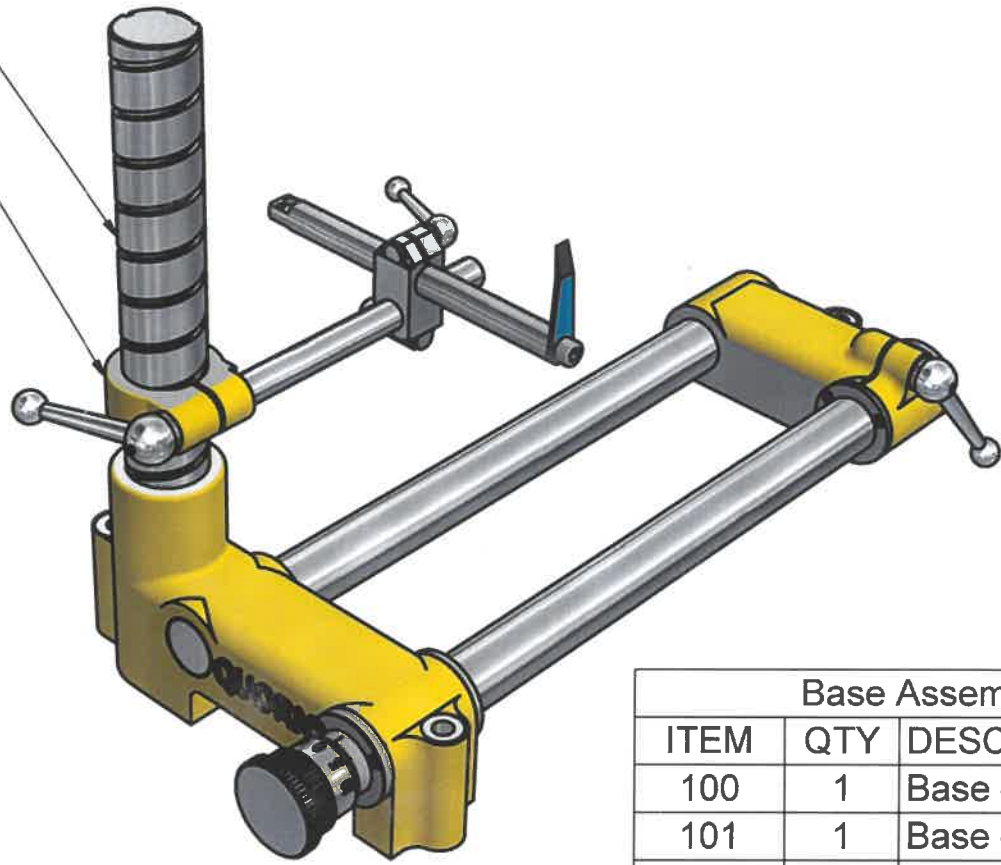
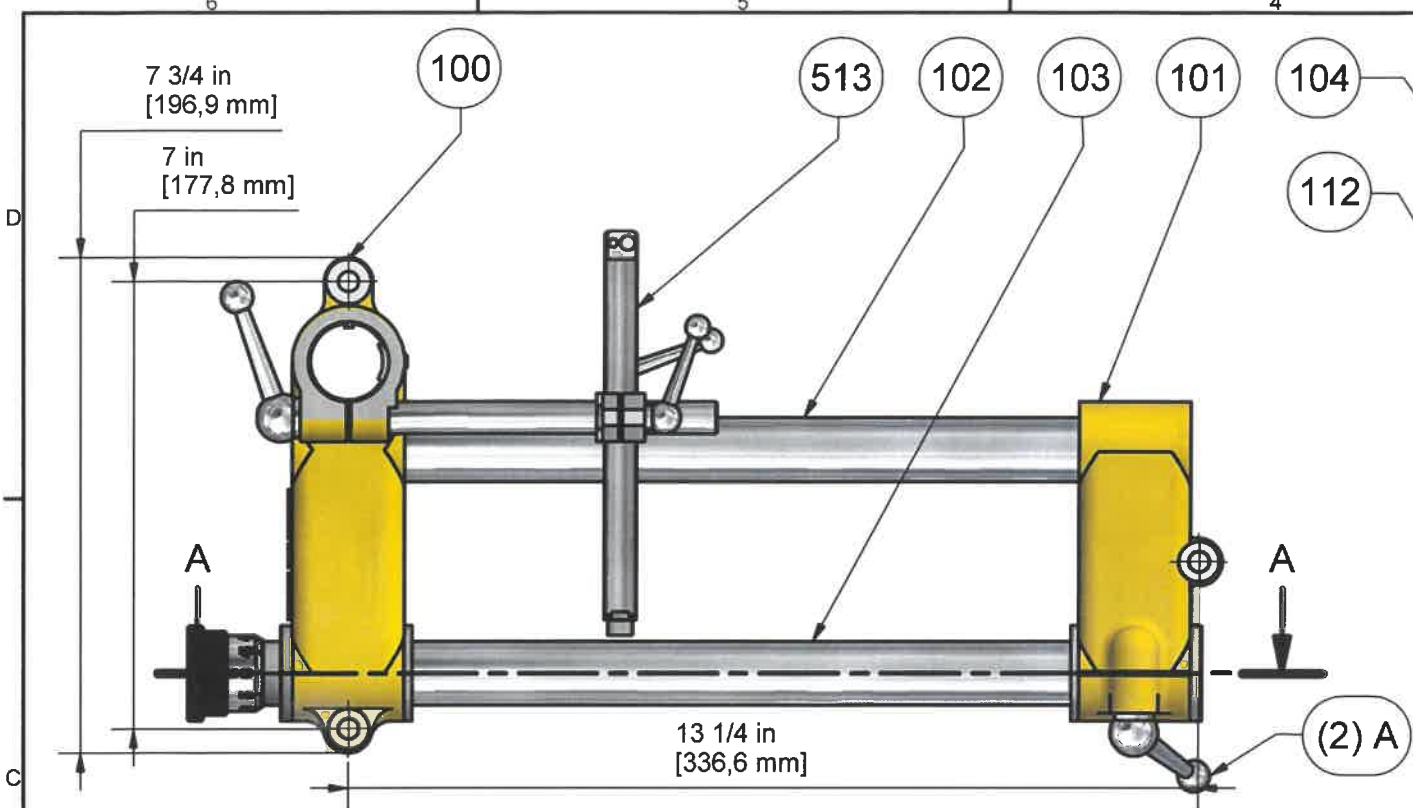
REVISION DATE:
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SHEET:
1 OF 24

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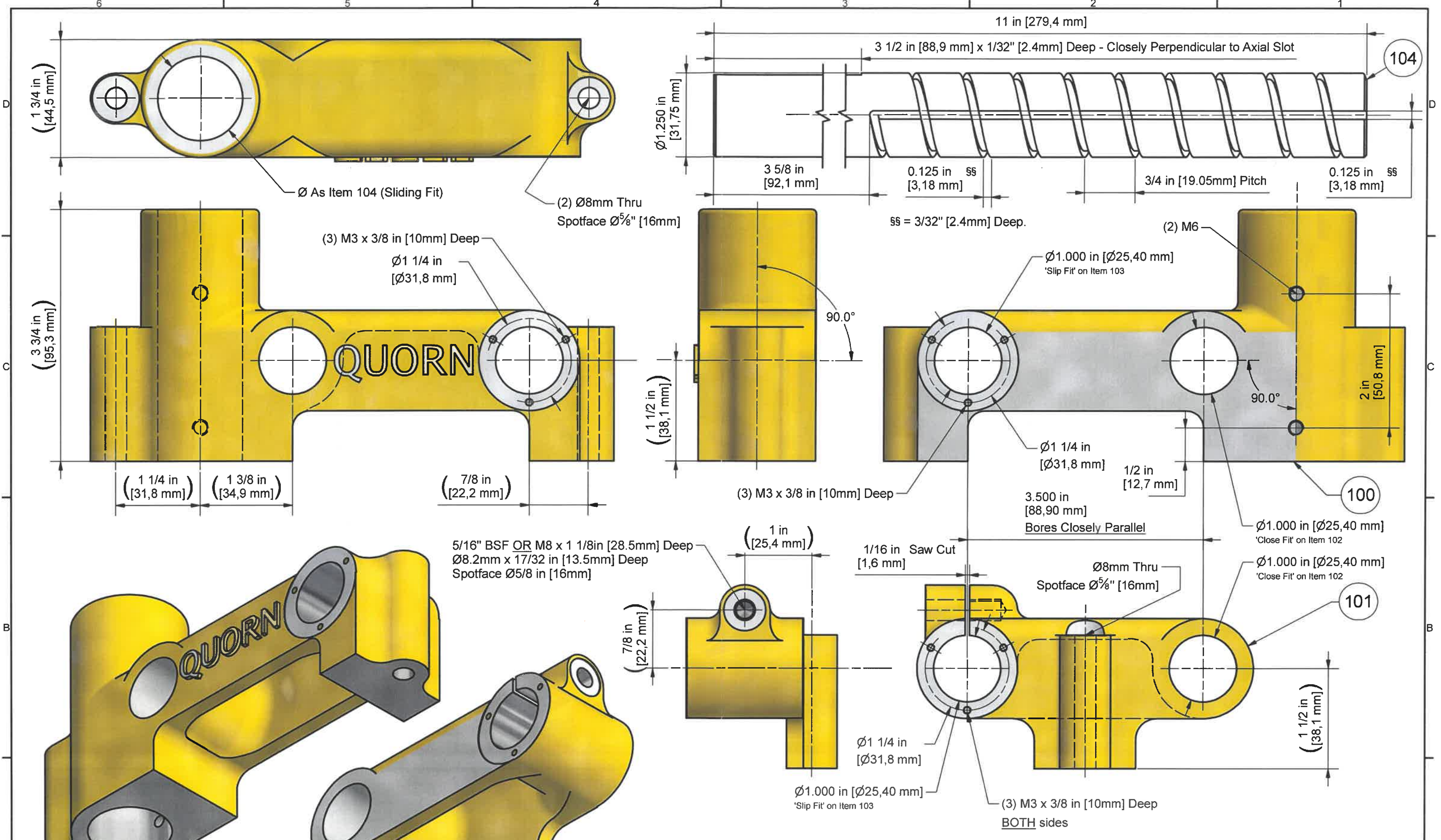
Base Assembly Parts List - HK 2600©			
ITEM	QTY	DESCRIPTION	SUPPLIED AS
100	1	Base - LH	Iron Casting
101	1	Base - RH	Iron Casting
102	1	Bar - Rear	Ø1" - PG/HTS
103	1	Bar - Front	Ø1" - PG/HTS
104	1	Column	Complete - HTS
105	1	End Cap - RH	Ø1 1/2" FCMS
106	1	Spring	Complete
107	1	Body	Ø40mm - Cast Iron
108	1	Thimble	Ø1 3/8" - FCMS
109	1	Micrometer Screw	Ø1 1/2" - FCMS
110	1	Spring	Complete
111	2	Steel Ball	Ø3/16"
112	1	Collar	Iron Casting
113	1	Support Bar	Ø1/2" - FCMS
114	1	Clamp	3/4" Sq. - BMS
115	1	Blade	As Required
116	1	Stud	Ø5/16" - FCMS
117	3	Dust Cover	Ø1 1/2" - Aluminium
118	3	Dust Seal	Felt - 3mm
513	1	Rest - Setting Bar	See Sheet 16





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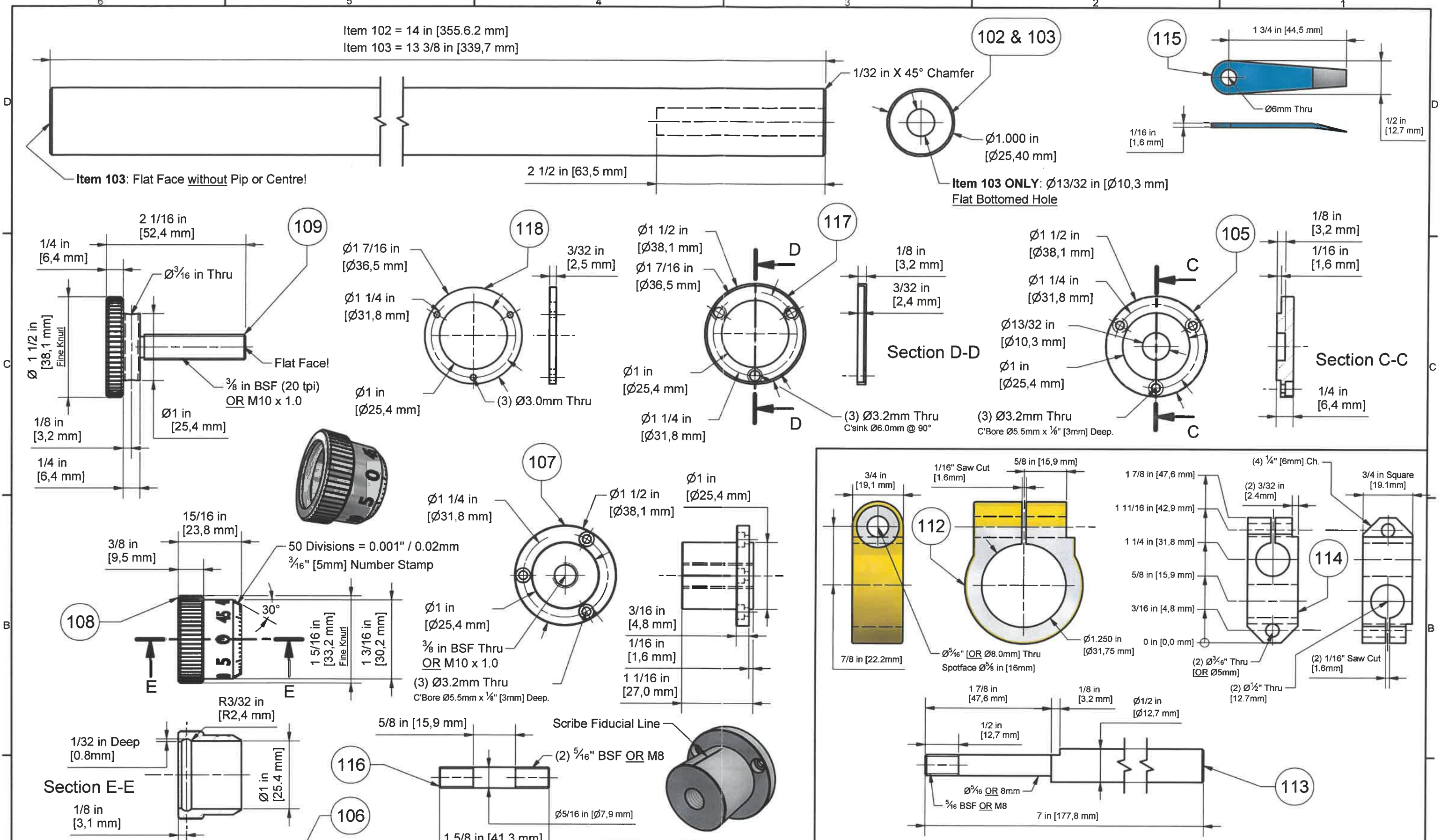
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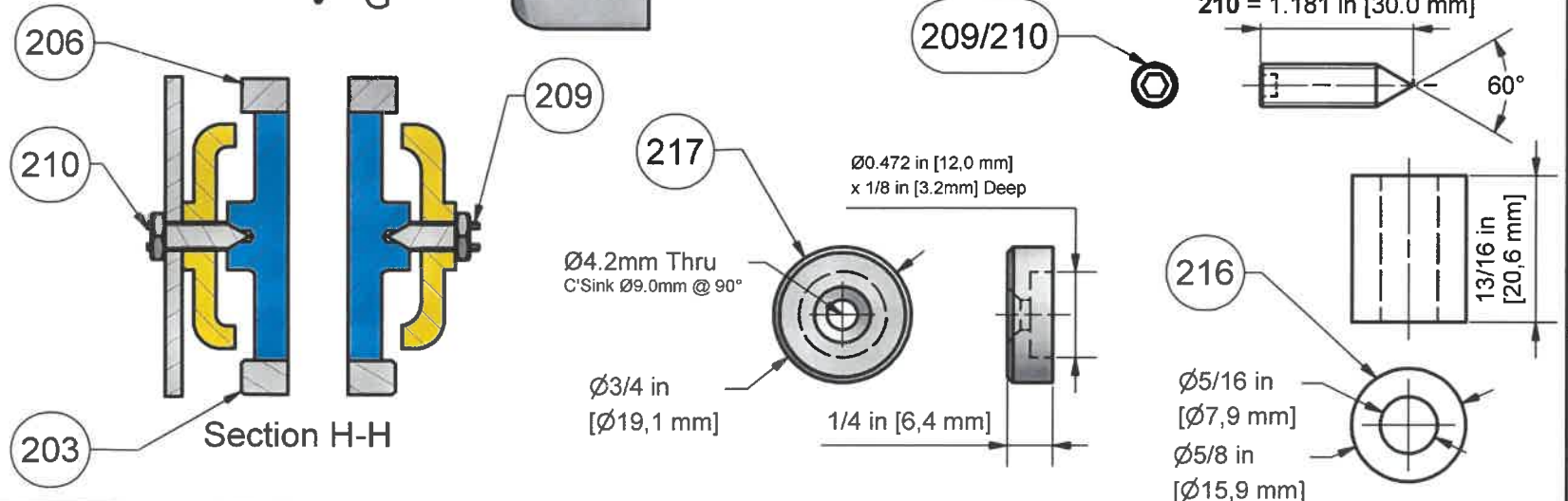
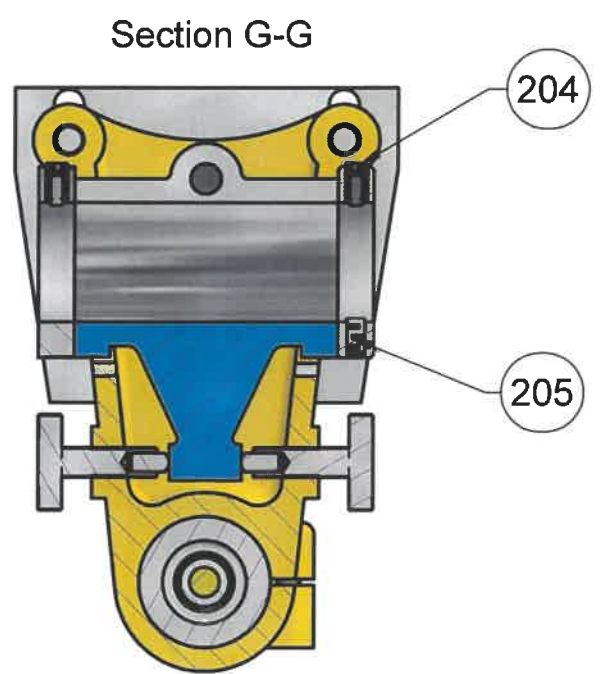
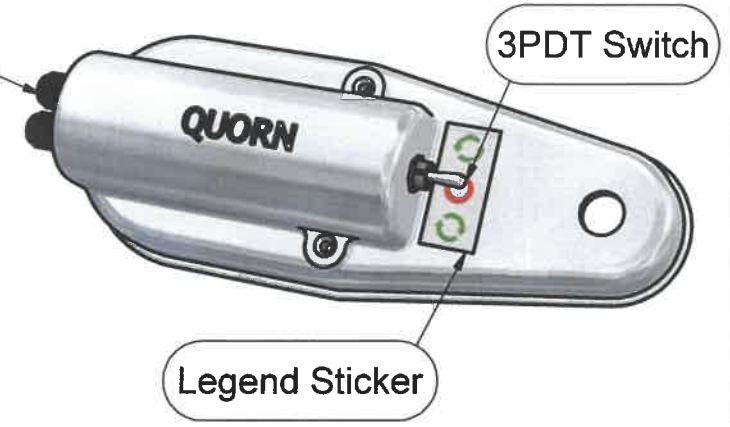
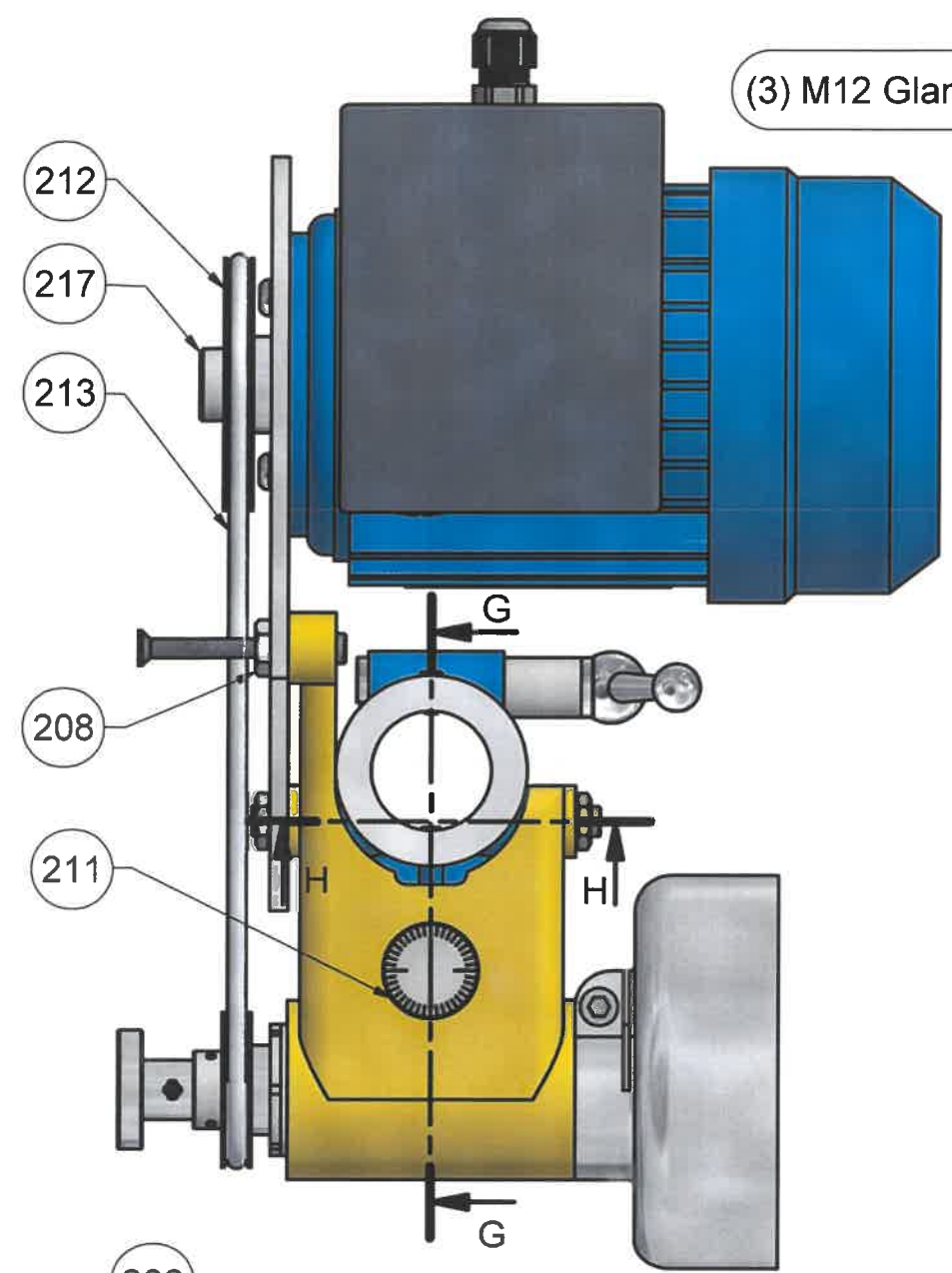
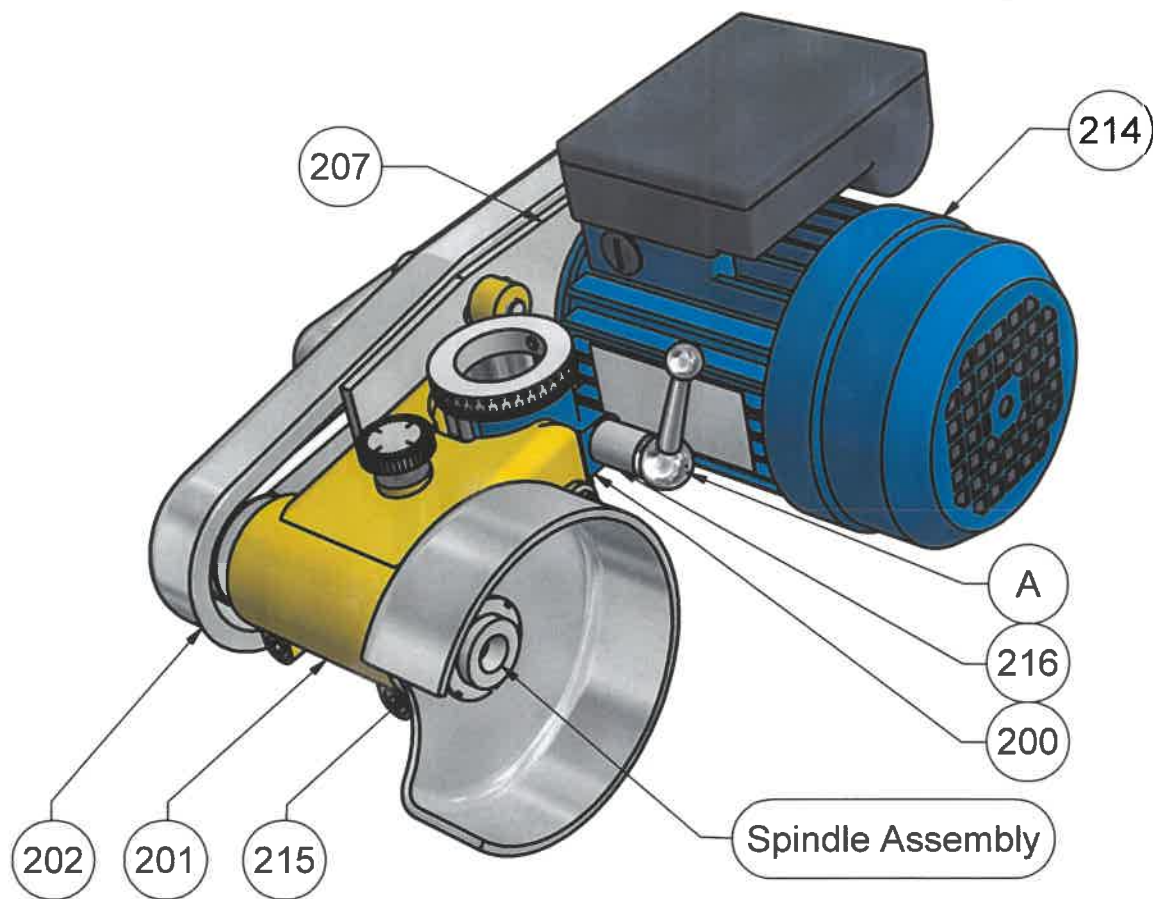


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Parts List - Wheelhead Assembly - HK 2600©

ITEM	QTY	DESCRIPTION	SUPPLIED AS
	1	Spindle Assembly	See Sheet 7
200	1	Wheelhead Collar	Iron Casting
201	1	Wheelhead Bracket	Iron Casting
202	1	Belt Guard	Aluminium Casting
203	1	Nut	Ø2" - FCMS
204	2	Peg Assembly	M6x8 Grub + Ø1/8" Dowel
205	1	Friction Pad	Ø3/16" Nylon 66
206	1	Indexing Ring	Ø2" - FCMS
207	1	Motor Plate	4" x 3/16" - BMS
208	2	Belt Adjusting Screw	M8 x 20 Hex Bolt
209	1	Pivot	M8 x 30 Grub Screw
210	1	Pivot	M8 x 30 Grub Screw
211	2	Adjusting Screw	Ø1" - FCMS
212	1	Motor Pulley	Ø3" - HE30 Aluminium
213	1	Drive Belt	Ø5mm Bond-a-Band
214	1	Induction Motor	240V, 120W, 2 Pole (50/60Hz)
215	1	Wheel Guard	Aluminium Casting
216	1	Distance Piece	Ø5/8" - FCMS
217	1	Pulley Clamp Washer	Ø3/4" - FCMS
218	1	Closing Plate (Sheet 22)	Steel Sheet - 0.7mm

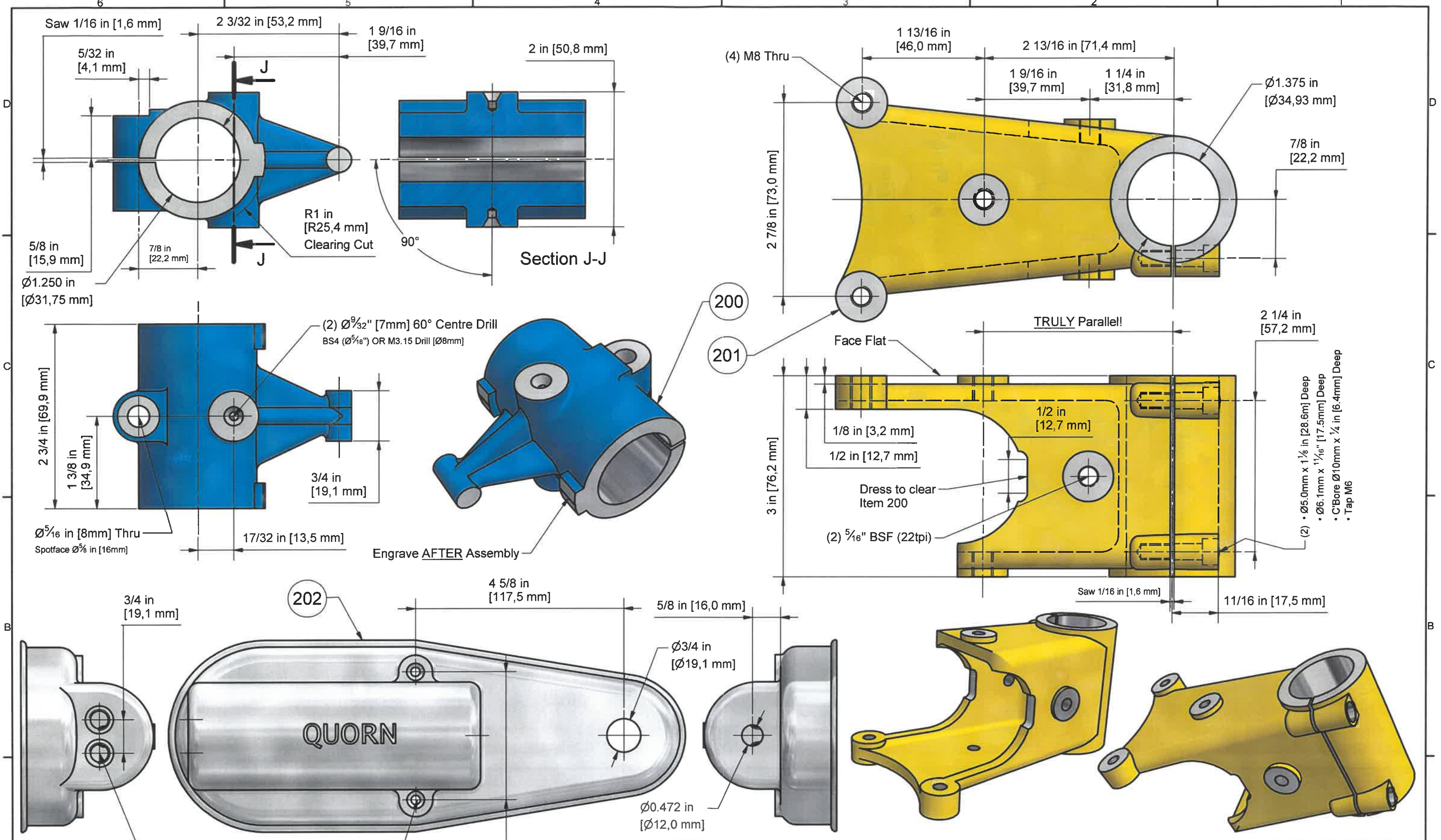


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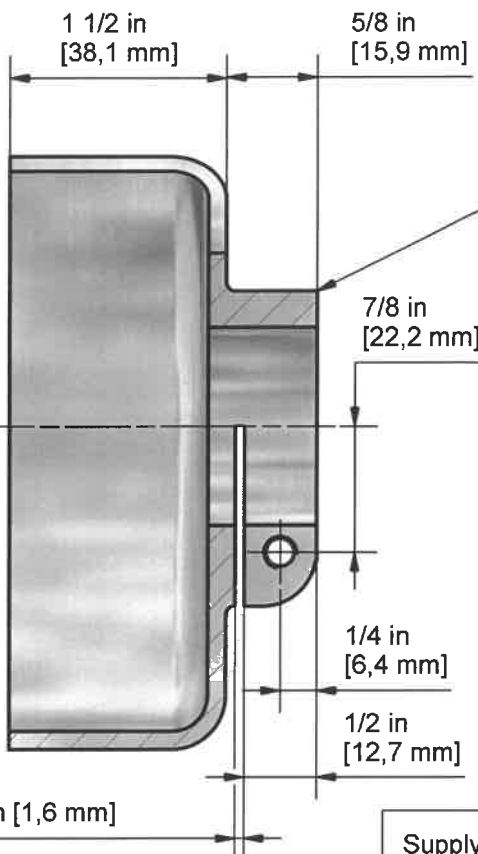
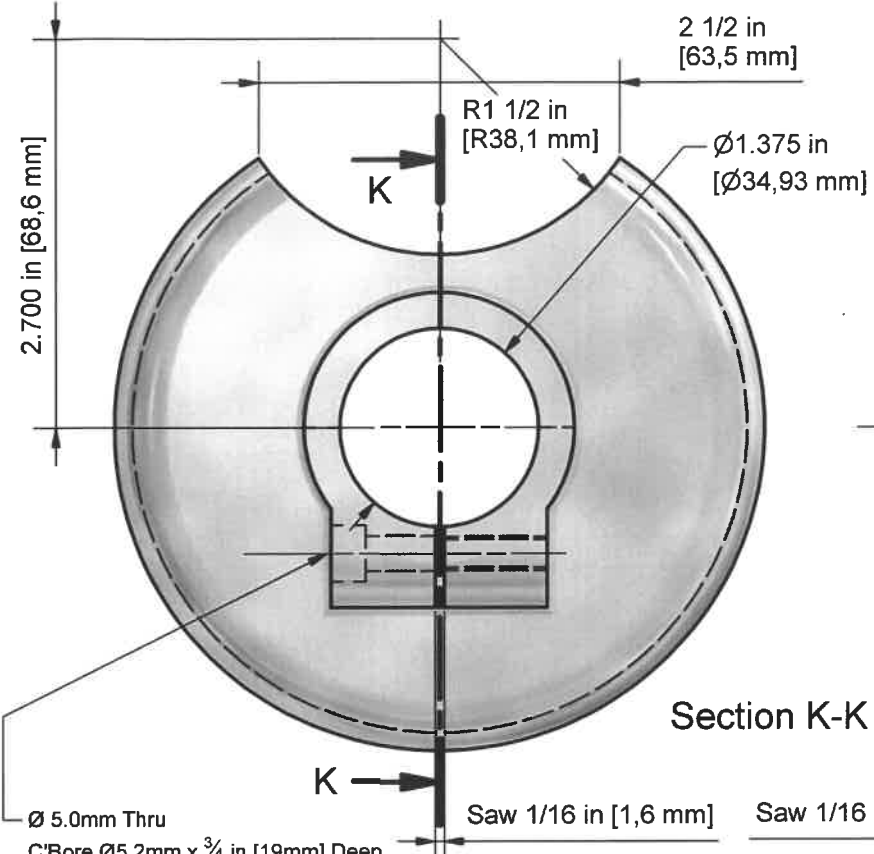
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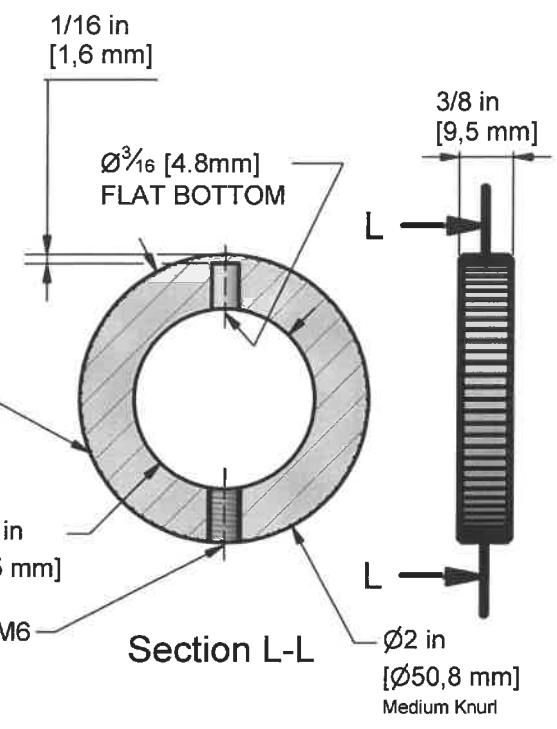
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ORIGINAL DESIGN: 04/01/1974	REVISION DATE: 23/03/2019	THIRD ANGLE PROJECTION 	SHEET: <div style="text-align: right; font-weight: bold;">6 OF 24</div>

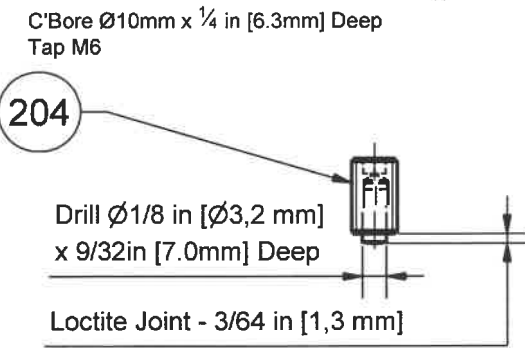
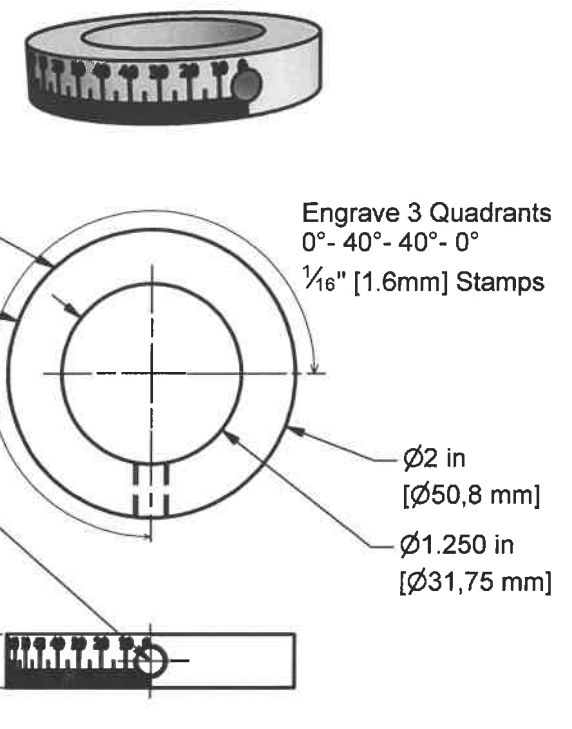


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203

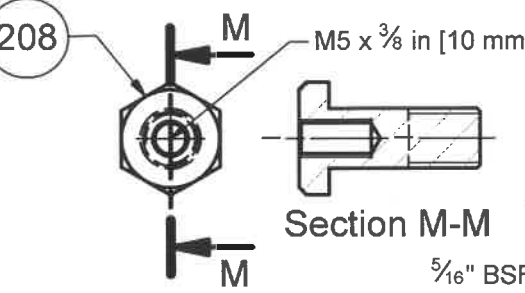
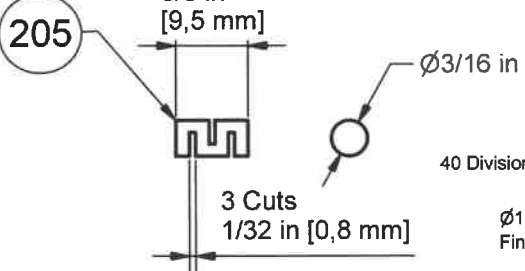


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Section M-M

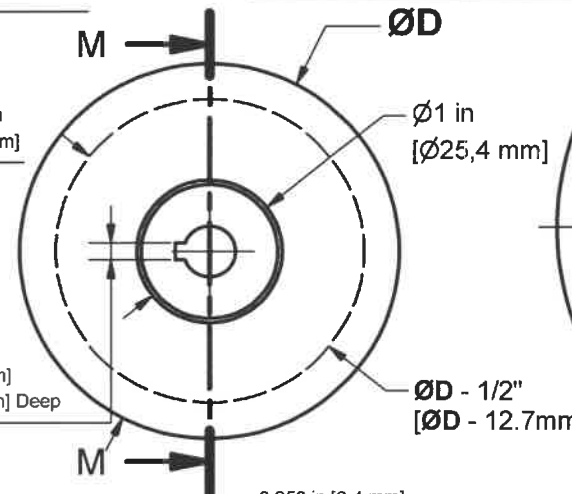


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Section M-M

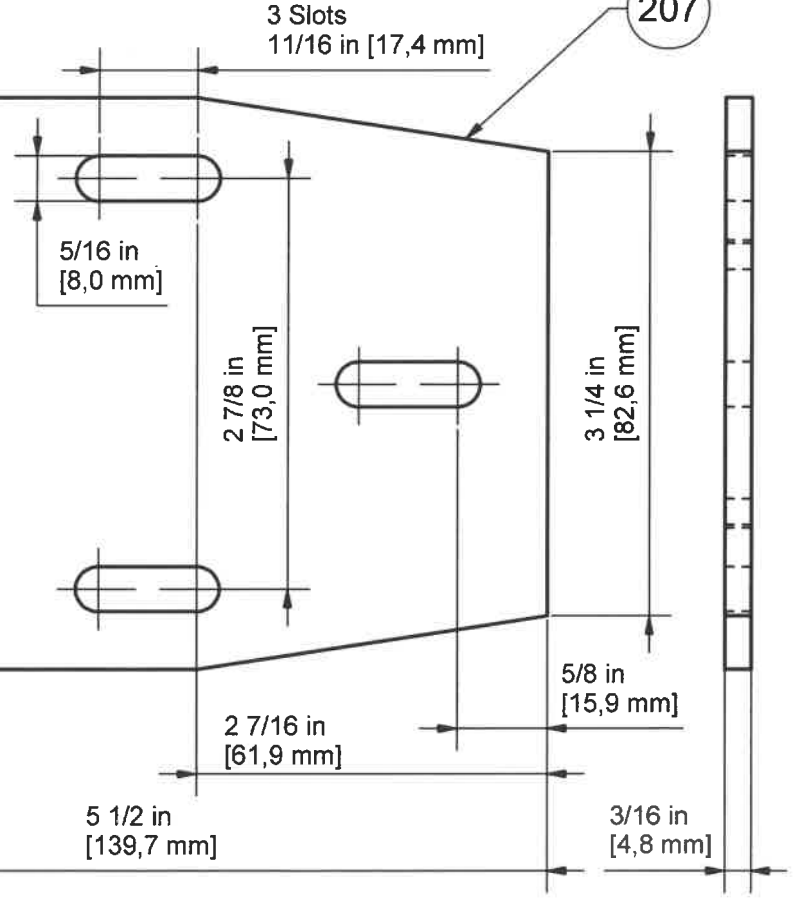
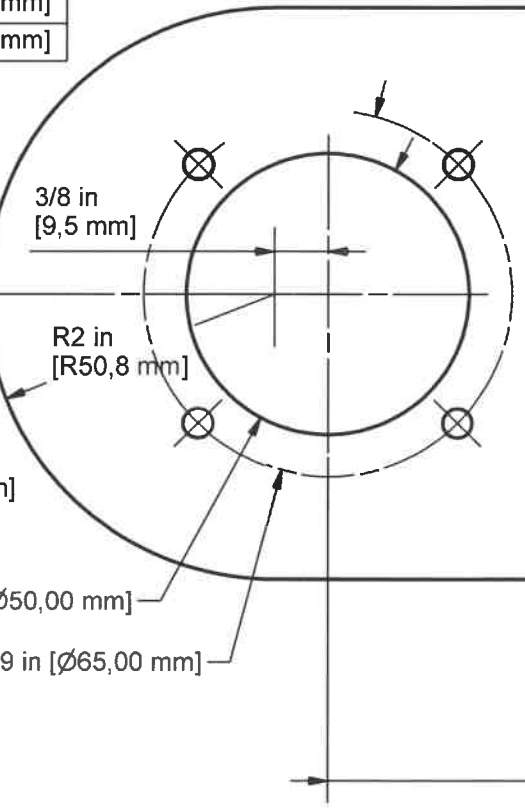
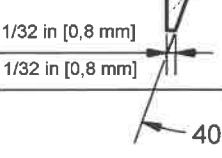


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60 Hz	Ø2.375 in [60.3mm]

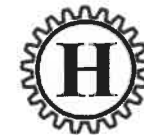


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Detail N



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TITLE:
Quorn Mk3 - T & C Grinder

KIT CODE:
HK 2600

DESIGNER:
D H Chaddock CBE MSc CEng FIMechE

126 DUNVAL ROAD, BRIDGNORTH,
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ORIGINAL DESIGN:
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23/03/2019

THIRD ANGLE PROJECTION

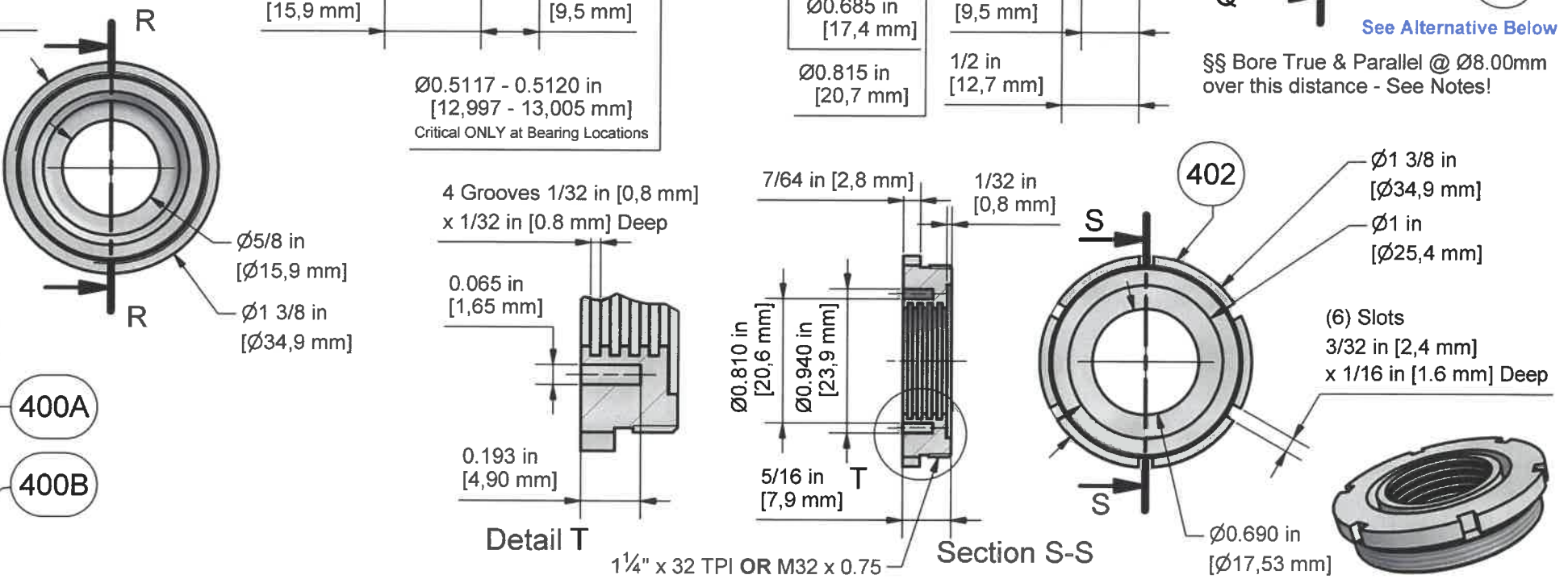
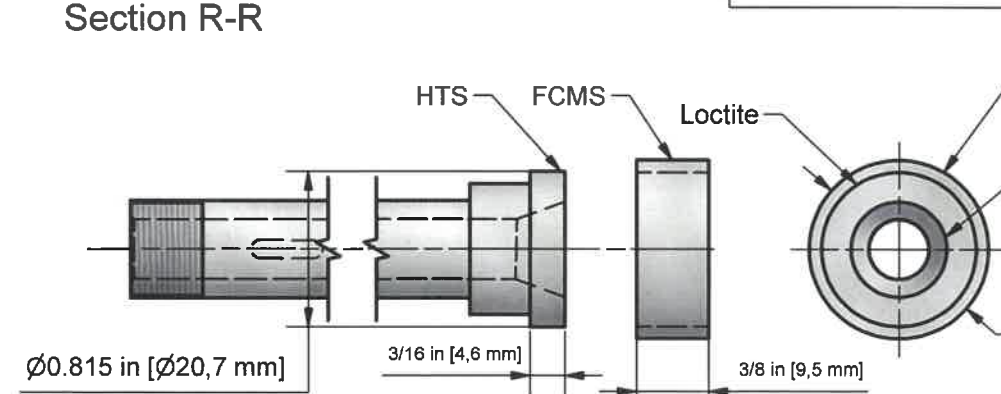
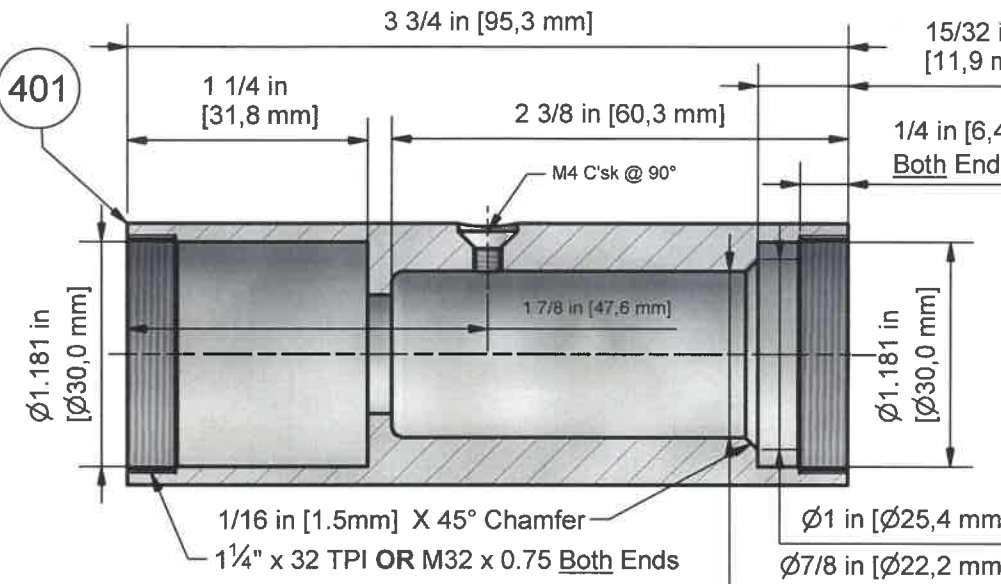
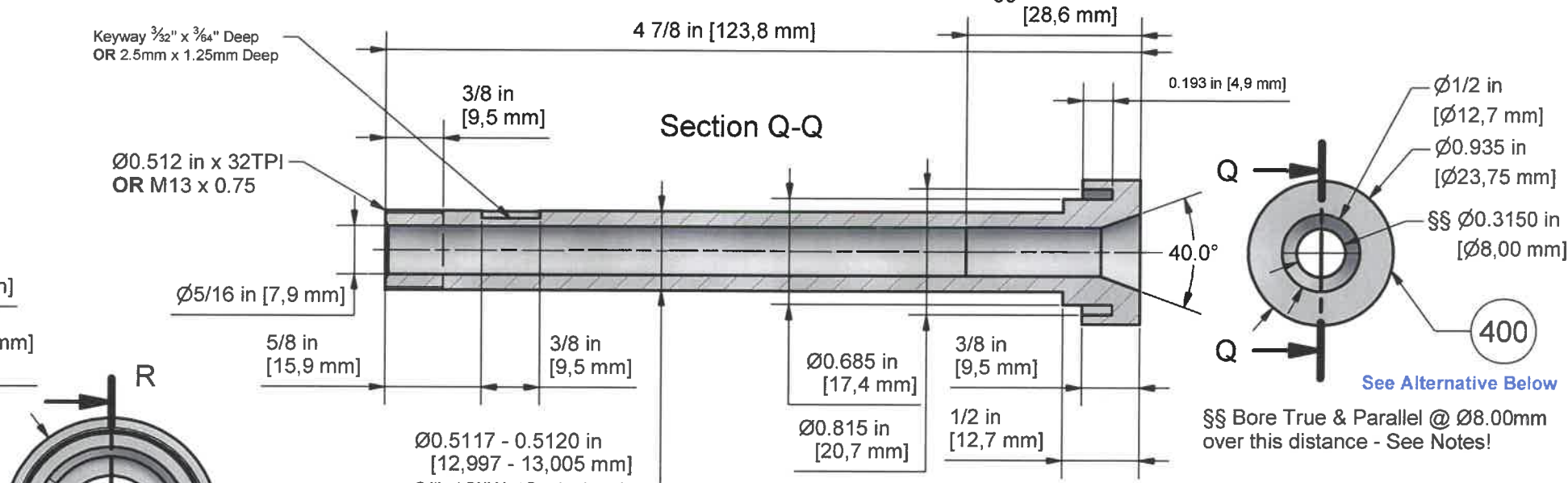
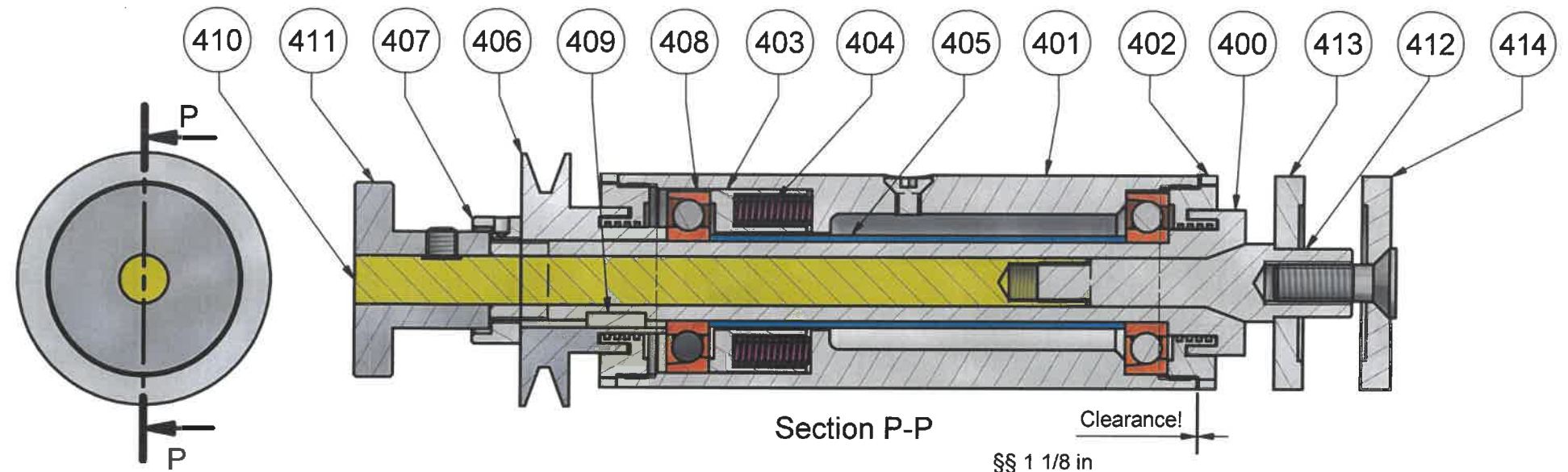
SHEET:
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Parts List Spindle Assembly - HK 2600©

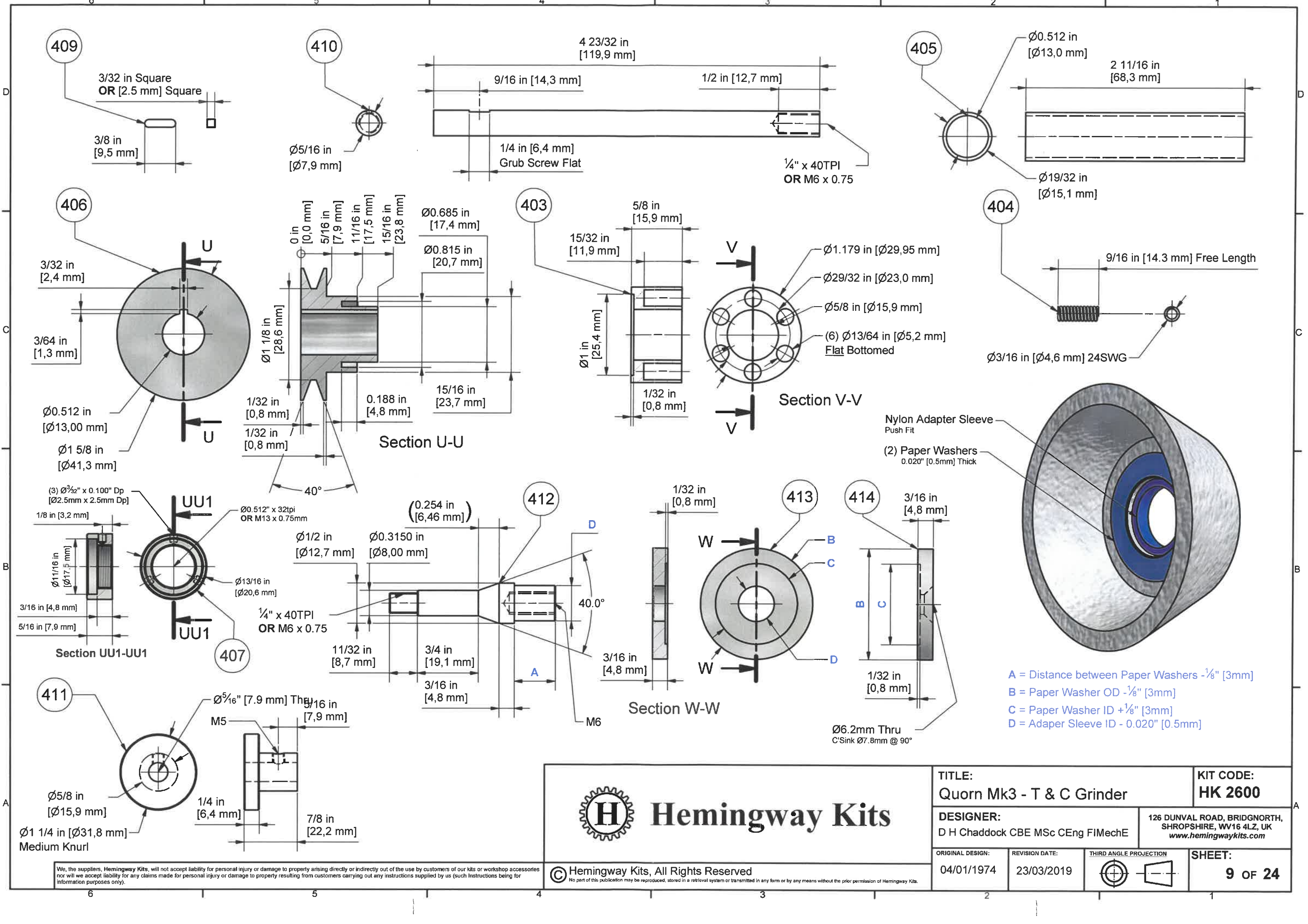
ITEM	QTY	DESCRIPTION	SUPPLIED AS
400	1	Spindle	Ø1" - HTS
401	1	Spindle Body	Ø1 1/2" - FCMS
402	2	End Cap	Ø1 1/2" - FCMS
403	1	Spring Box	Ø1 1/4" - FCMS
404	6	Spring	Complete
405	1	Distance Piece	Ø5/8" - FCMS
406	1	Spindle Pulley	Ø2" - Aluminium
407	1	Spindle Nut	Ø7/8" - FCMS
408	2	E13 - Mag. Bearing	Ø30 x Ø13 x 7mm
409	1	Key	1/8" Sq. Key Steel
410	1	Draw Bar	Ø5/16 - Sliver Steel
411	1	Knob	Ø1 1/4" - FCMS
412	8	Arbor	Ø1/2" - FCMS
413	8	Clamp Washer	Various - FCMS
414	8	Clamp Washer	Various - FCMS





TITLE: Quorn Mk3 - T & C Grinder		KIT CODE: HK 2600
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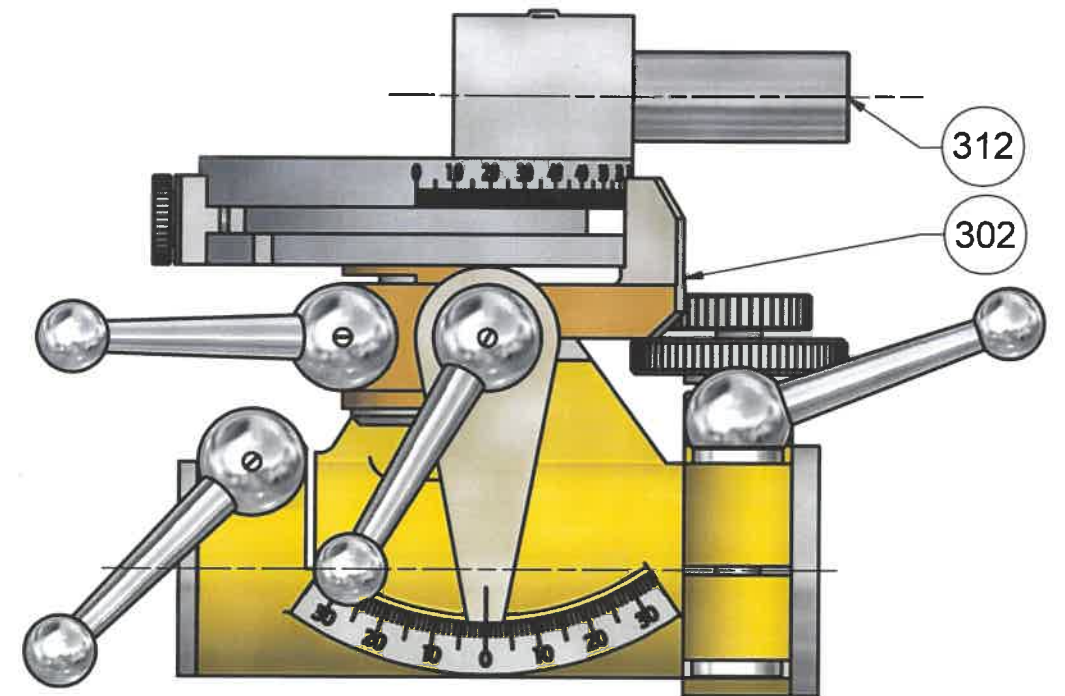
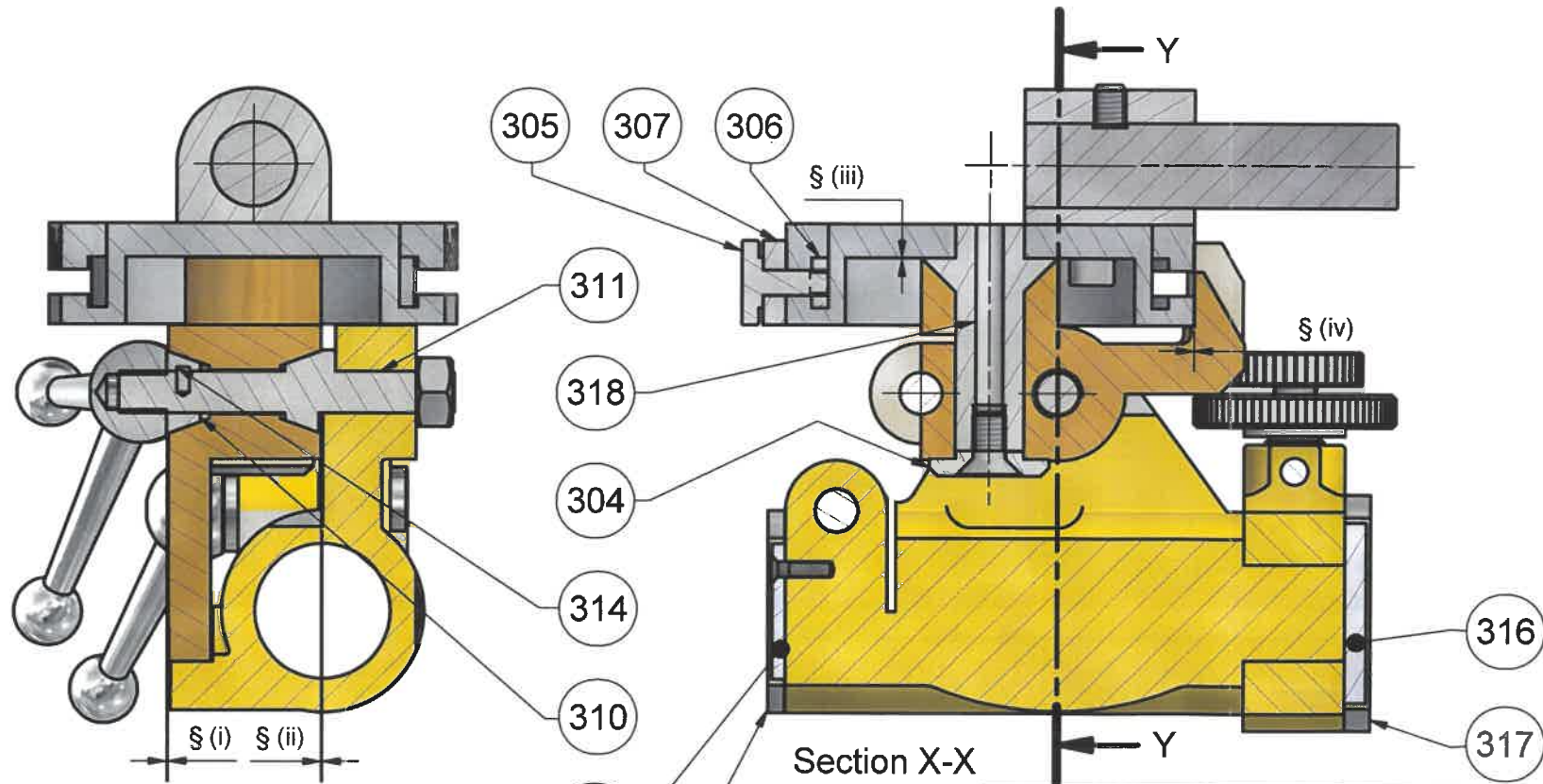
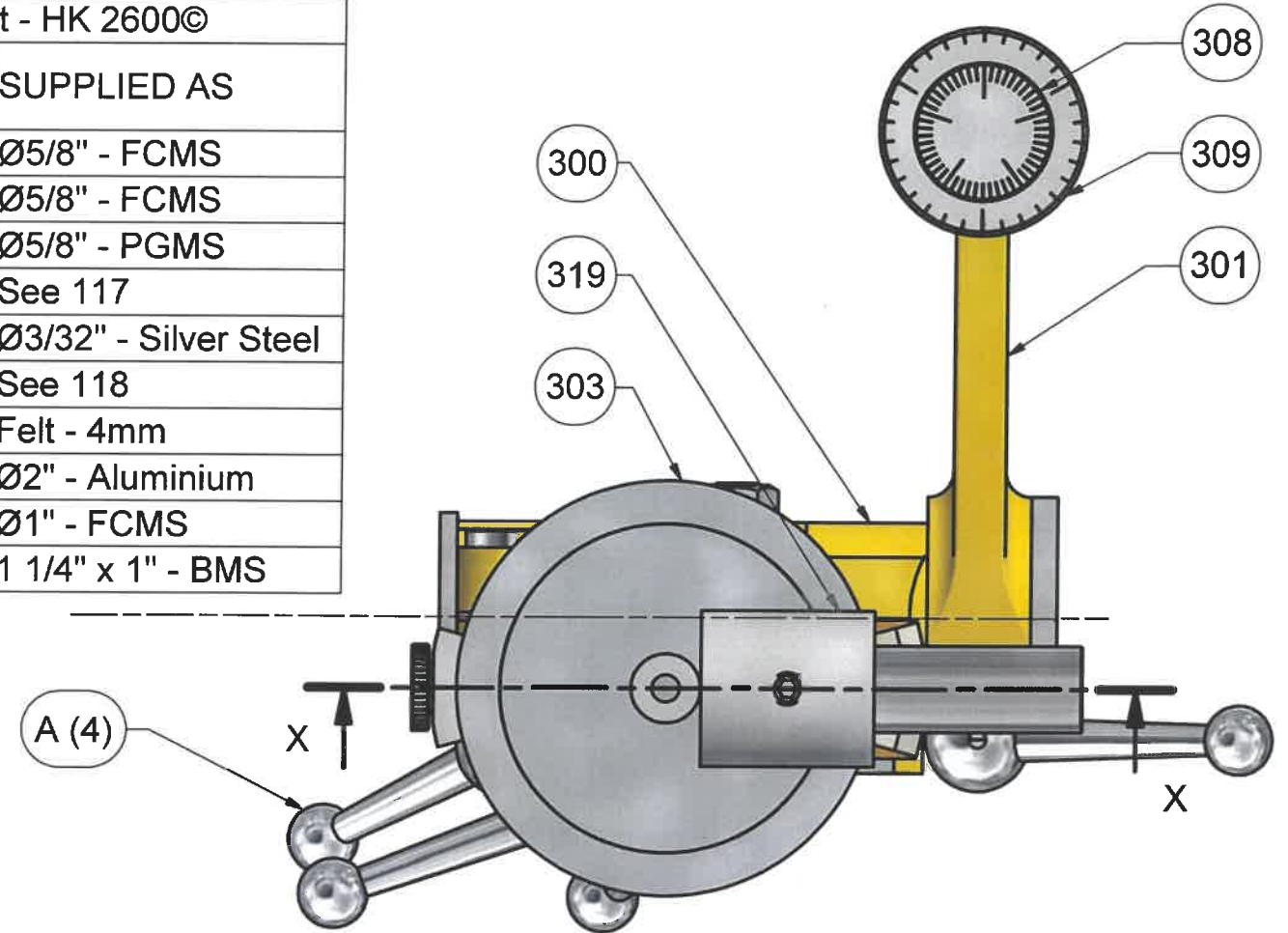
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Workhead Assembly Parts List - HK 2600©			
ITEM	QTY	DESCRIPTION	SUPPLIED AS
300	1	Workhead Base	Iron Casting
301	1	Rocking Lever	Iron Casting
302	1	Tilting Bracket	GM Casting
303	1	Rotating Table Assy.	Ø80mm - FCMS
304	1	Thrust Washer	Ø7/8" - FCMS
305	2	Stop Screw	Ø5/8" - FCMS
306	2	Stop Nut	3/8" Sq. - BMS
307	2	Stop	1" x 3/8" - BMS
308	1	Differential Screw	Ø1" - FCMS
309	1	Differential Nut	Ø1 1/2" - FCMS
310	1	Collet	Ø5/8" - FCMS


Workhead Assembly Parts List - HK 2600©			
ITEM	QTY	DESCRIPTION	SUPPLIED AS
311	1	Pivot Bolt	Ø5/8" - FCMS
311T	1	Pivot Arbor	Ø5/8" - FCMS
312	2	Bed Bar	Ø5/8" - PGMS
313	1	Dust Cover	See 117
314	1	Anti-Rotation Pin	Ø3/32" - Silver Steel
315	1	Dust Seal	See 118
316	1	Dust Seal	Felt - 4mm
317	1	Dust Cover	Ø2" - Aluminium
318	1	Spigot	Ø1" - FCMS
319	1	Boss	1 1/4" x 1" - BMS

§ Small Clearances Required:

- (i) 310 Protrudes Above 302
- (ii) Between 302 and 300
- (iii) Axially, Between 302 and 303
- (iv) Radially, Between 302 and 303

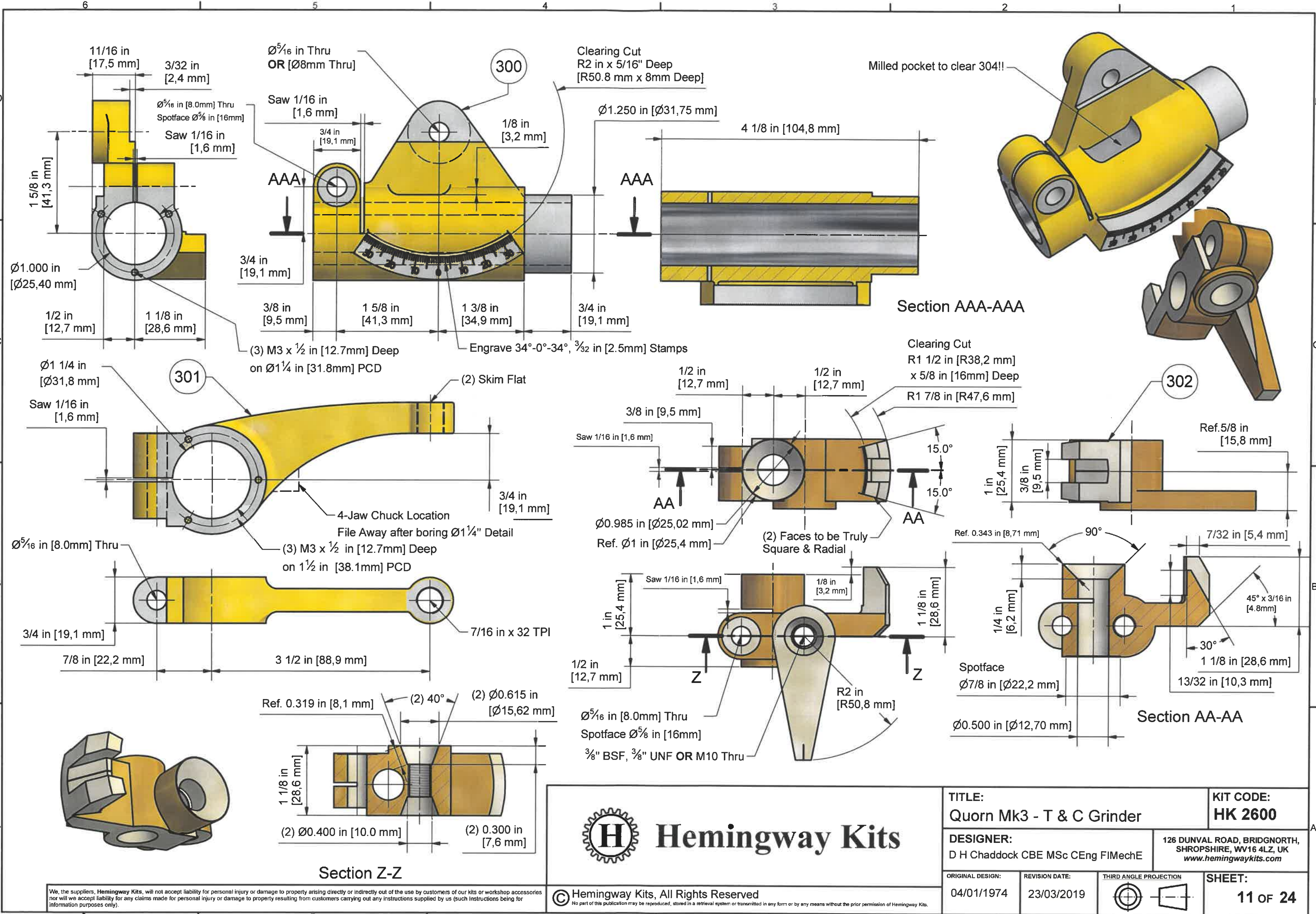


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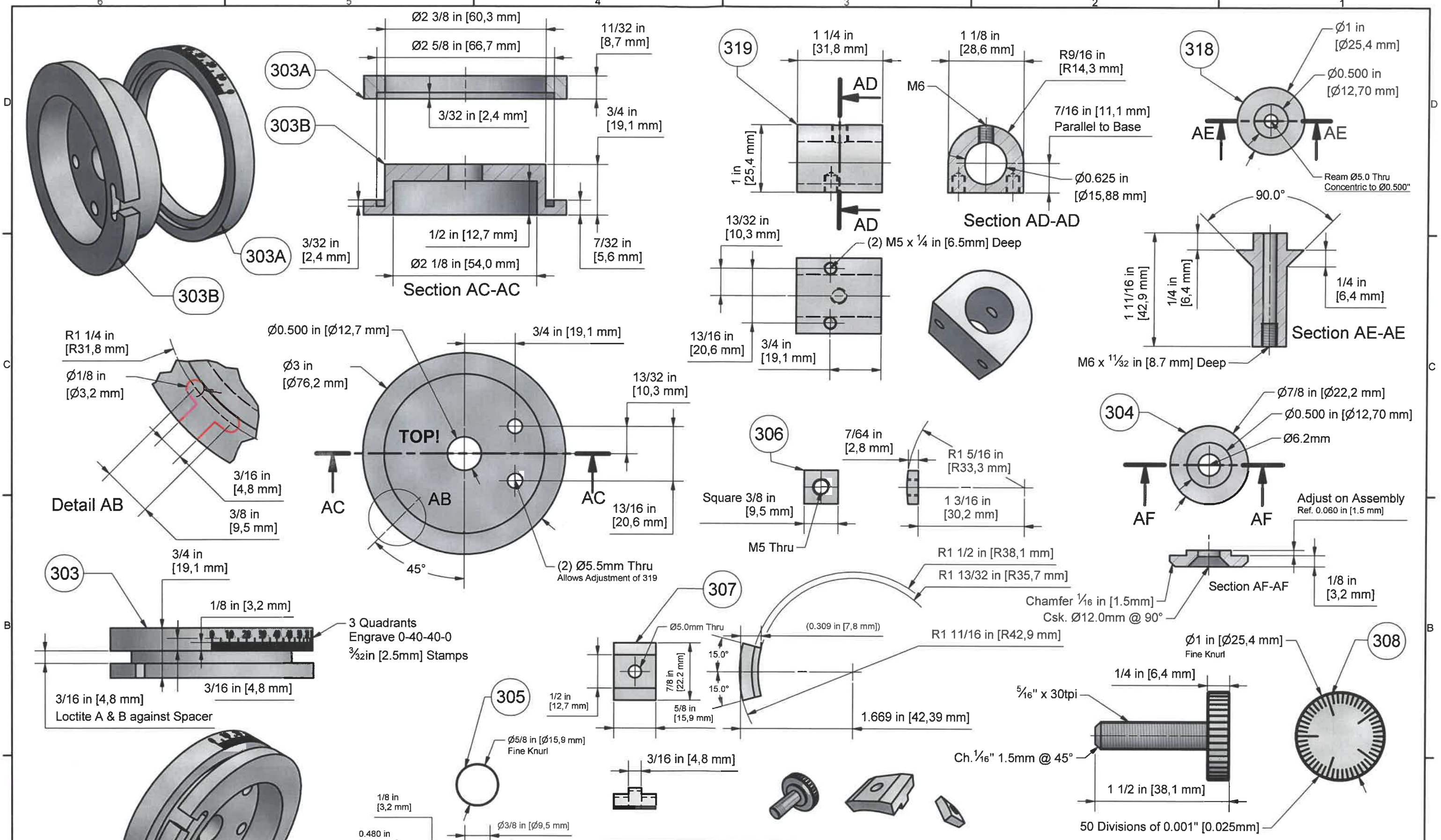
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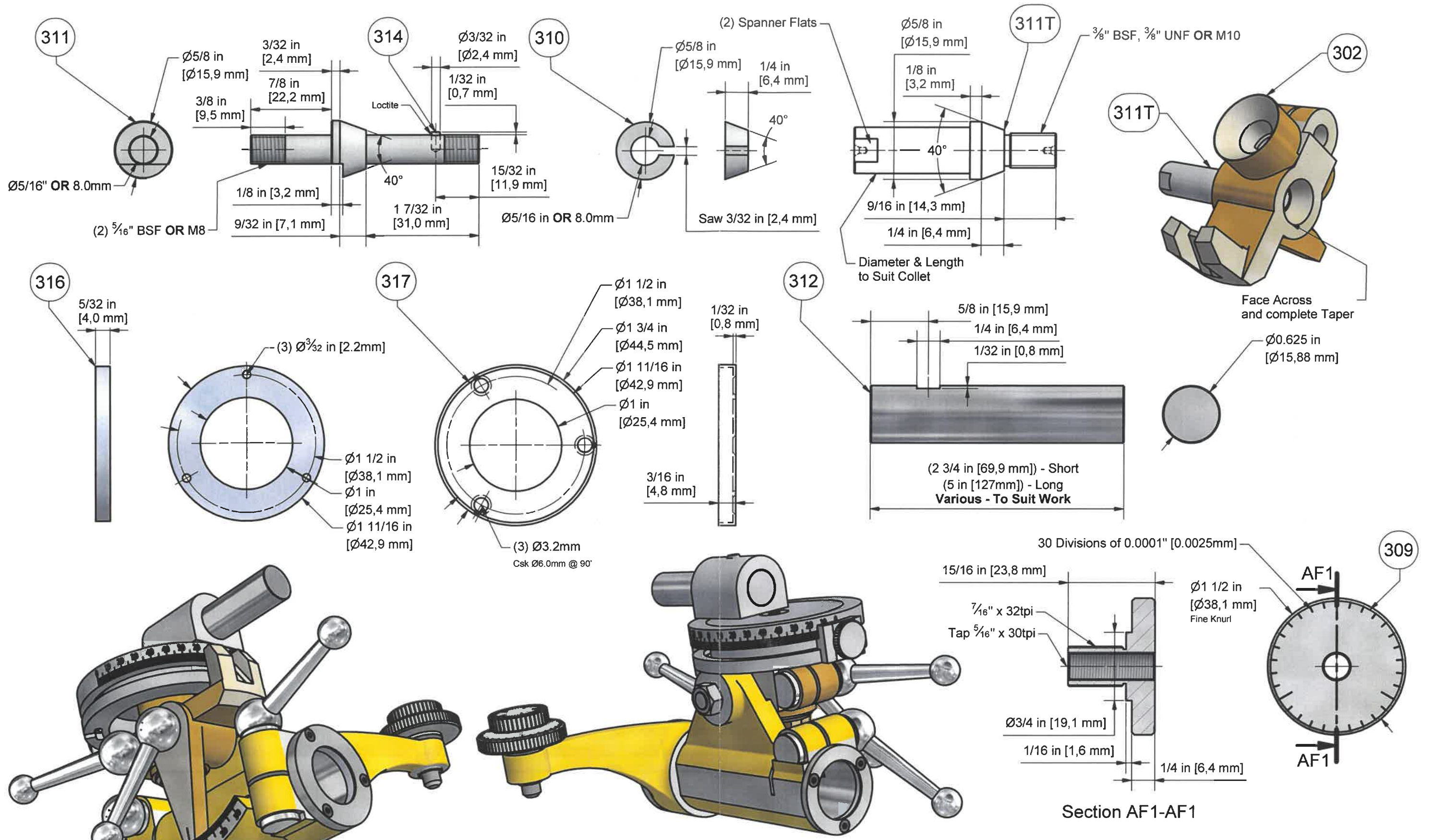
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THIRD ANGLE PROJECTION		



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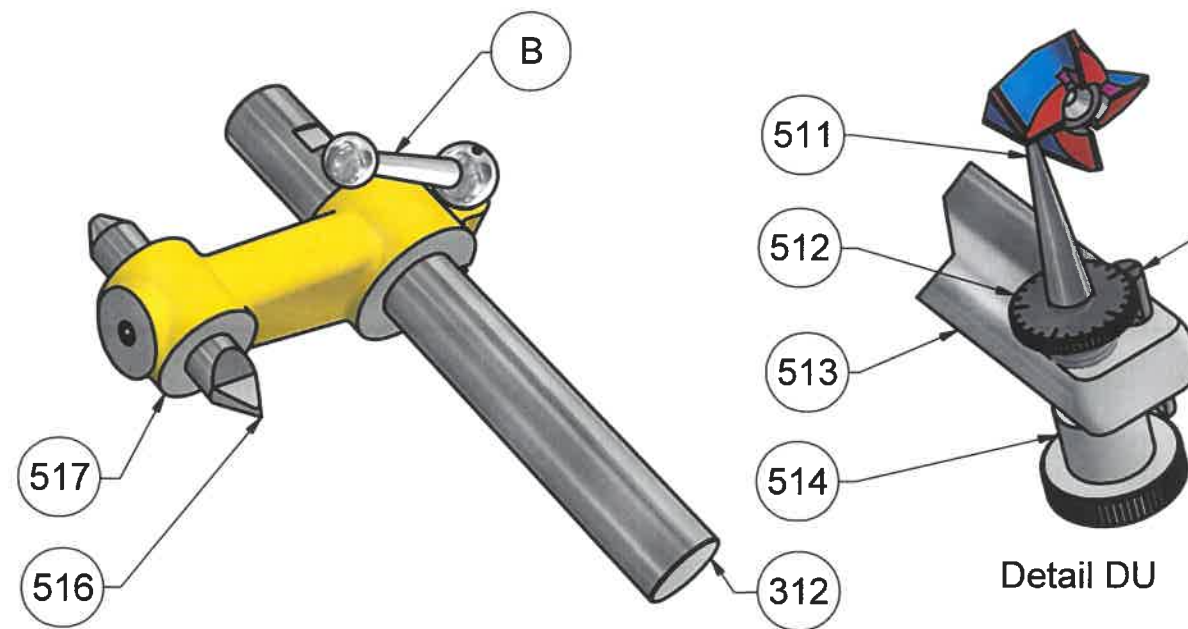
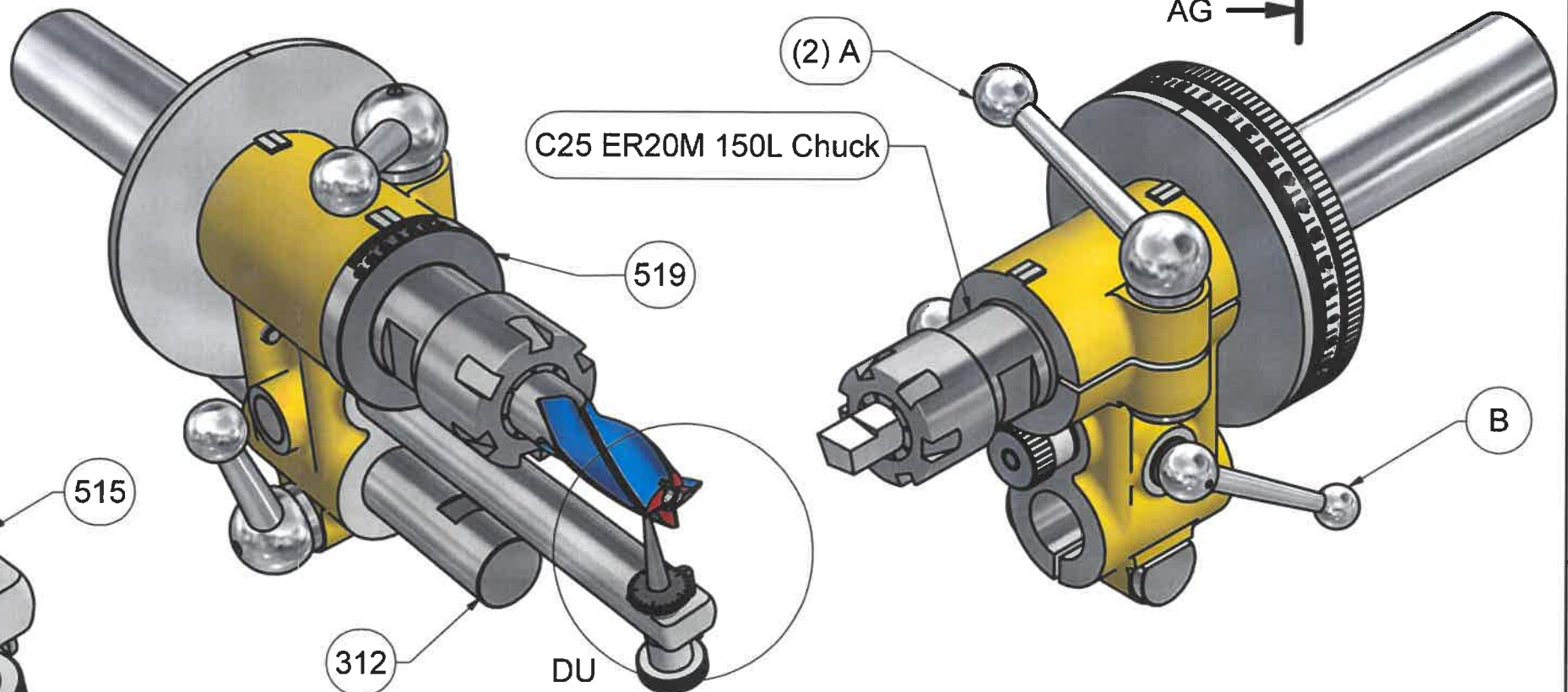
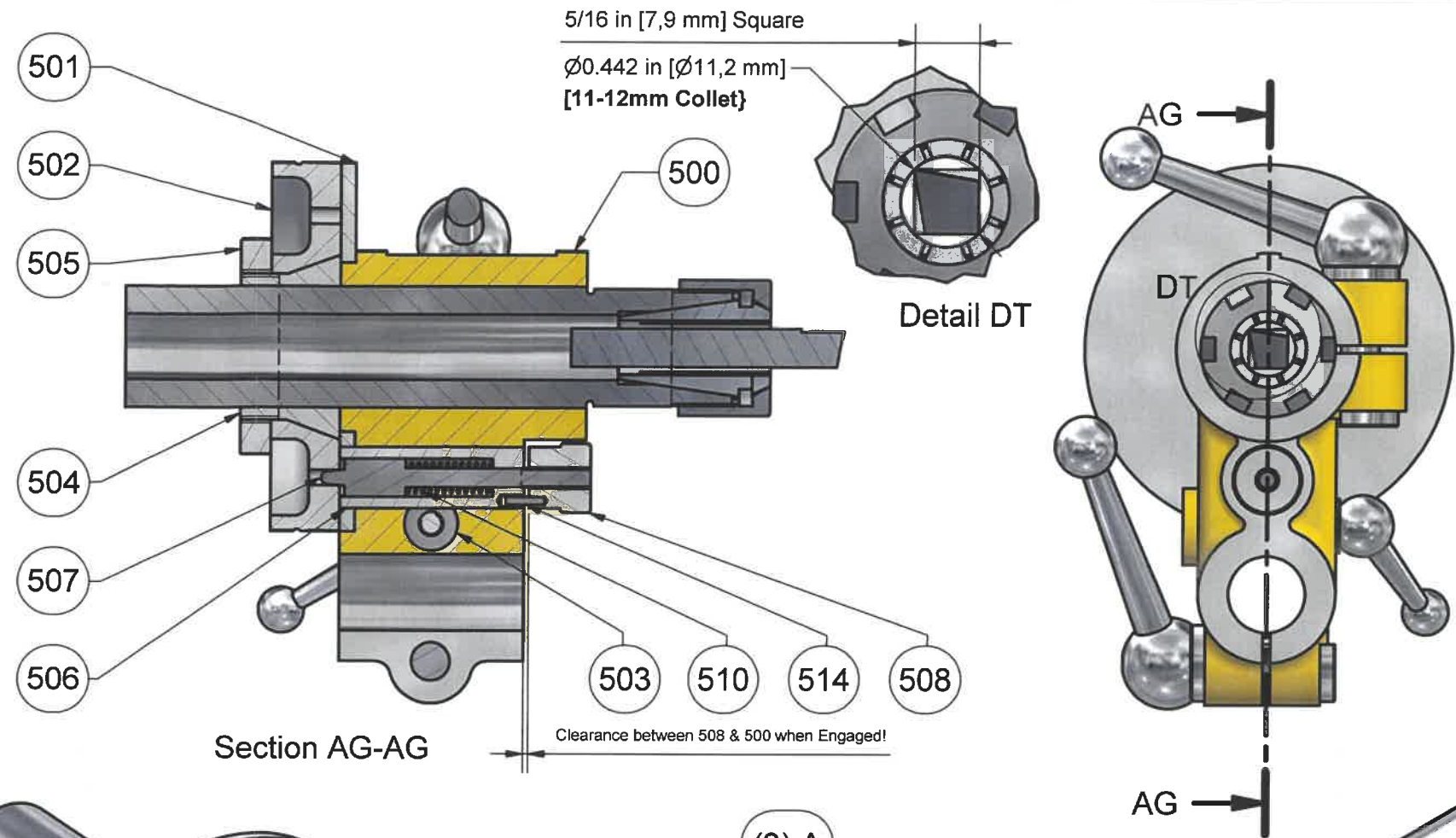
TITLE: Quorn Mk3 - T & C Grinder		KIT CODE: HK 2600	
DESIGNER: D H Chaddock CBE MSc CEng FIMechE		126 DUNVAL ROAD, BRIDGNORTH, SHROPSHIRE, WV16 4LZ, UK www.hemingwaykits.com	
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Tool Holder Parts List - HK 2600©

ITEM	QTY	DESCRIPTION	SUPPLIED AS
500	1	Tool Holder Body	Iron Casting
501	1	Backplate	Ø80mm - FCMS
502	1	Index Plate	Ø80mm - FCMS
503	1	Double Cotter	Ø1/2" - FCMS
504	1	Collet	Ø1 1/2" - FCMS
505	1	Nut	Ø2" - FCMS
506	1	Detent - Barrel	Ø5/8" - FCMS
507	1	Detent - Plunger	Ø5/16" Silver Steel
508	1	Detent - Knob	Ø5/8" - FCMS
509	1	Detent - Parking Pin	Ø1/16" Silver Steel
510	1	Detent - Spring	Complete
511	1	Rest - Tapered Pin	Ø5/32" - Silver Steel
512	1	Rest - Thimble	Ø1/2" - FCMS
513	1	Rest - Setting Bar	Ø1/2" - PGMS
514	1	Rest - Clamp Nut	Ø1/2" - FCMS
515	1	Rest - Zero Pin	Ø1/8" - Silver Steel
516	1	Tailstock Centre	Ø3/8" - Silver Steel
517	1	Tailstock	Iron Casting
518	1	MT2/1 Arbor	Ø1" - FCMS
519	1	Setting Collar	Ø2" FCMS
See Text	1	C25 ER20M 150L Chuck	Order Separately





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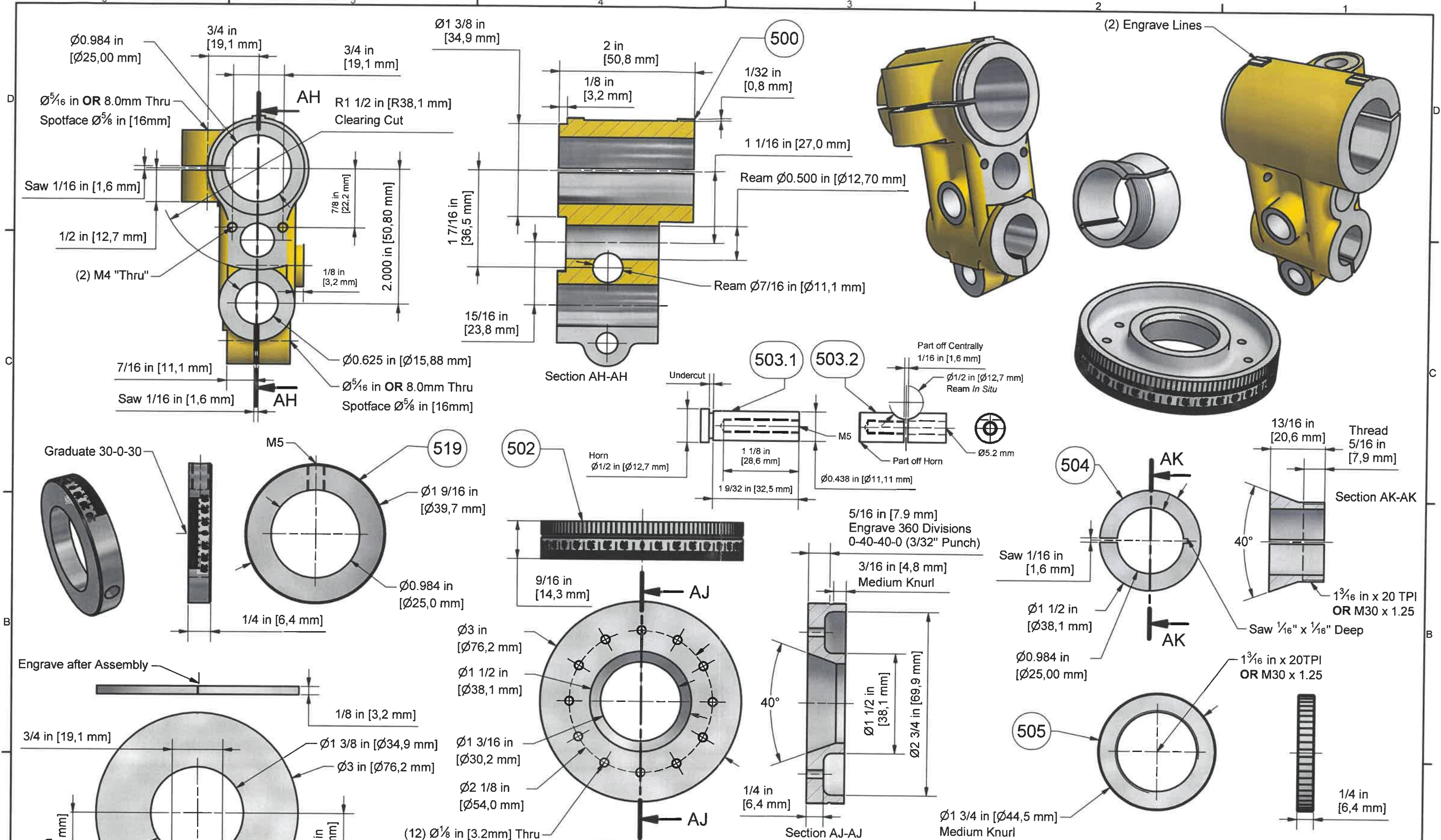
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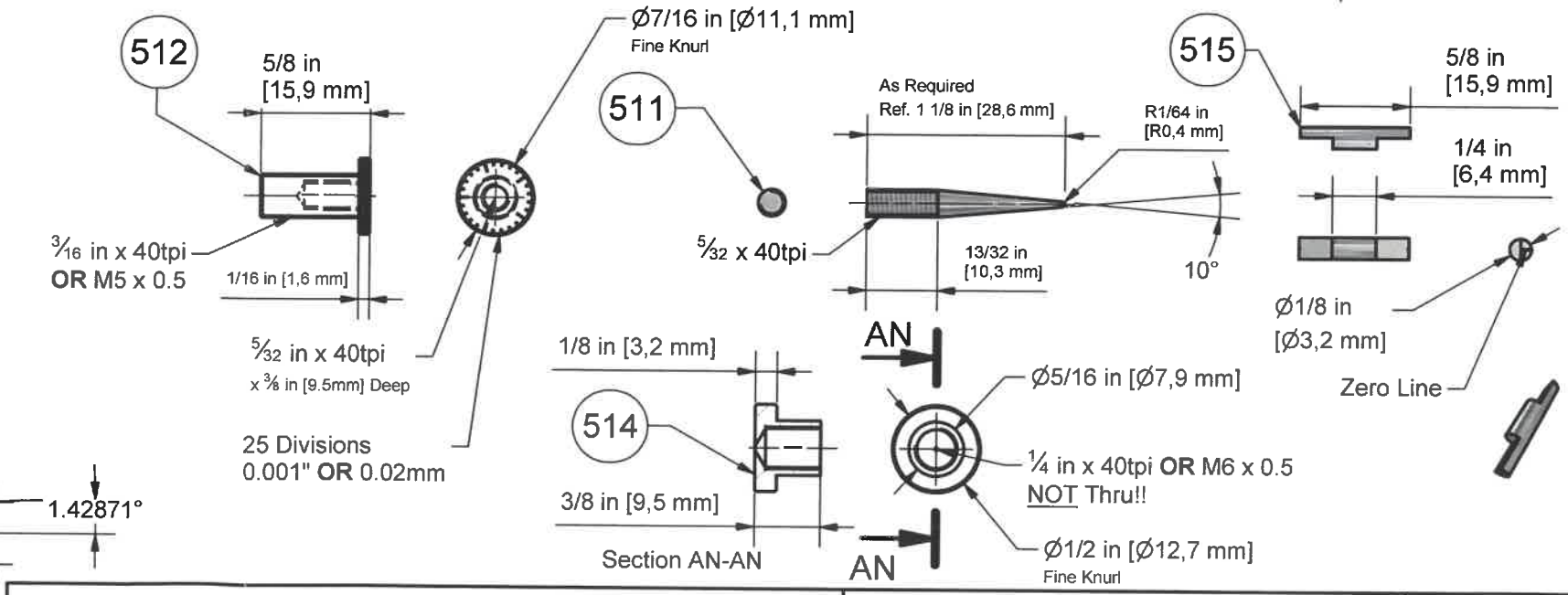
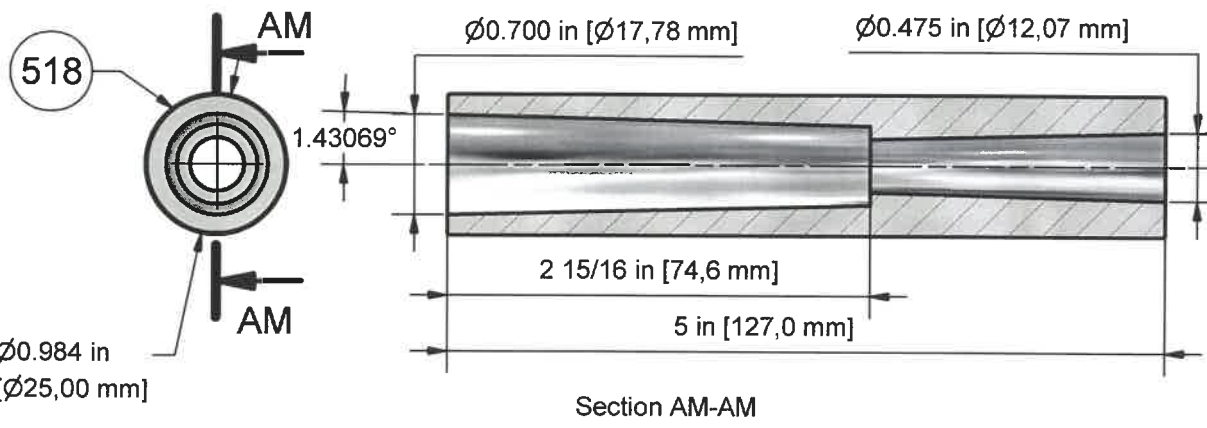
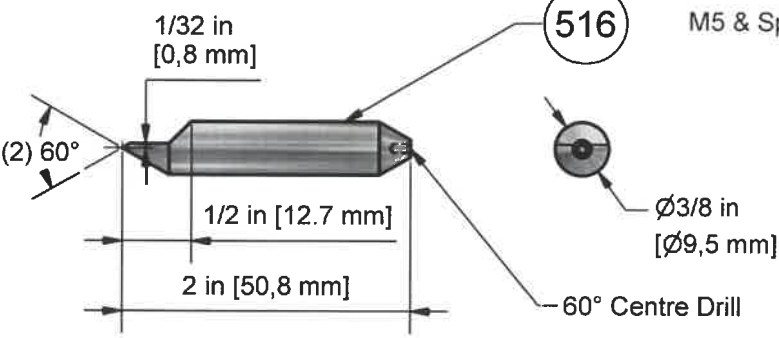
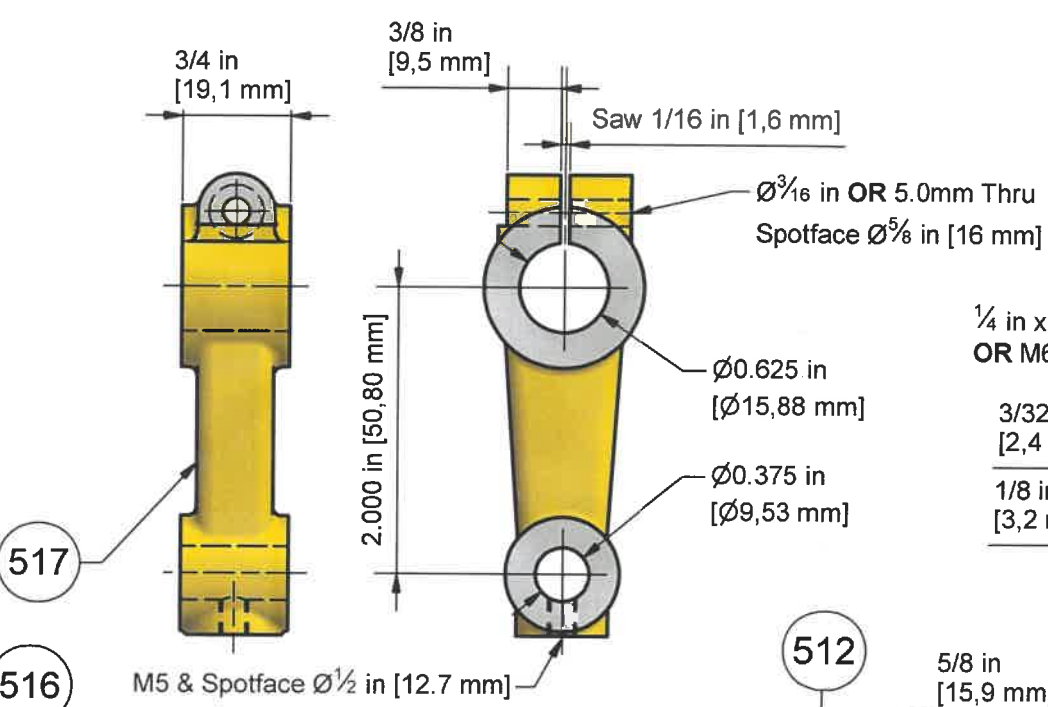
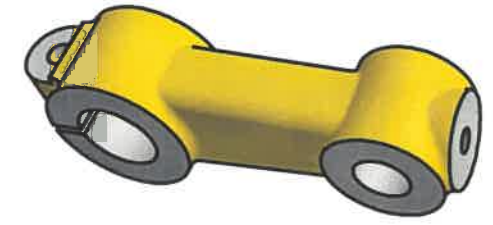
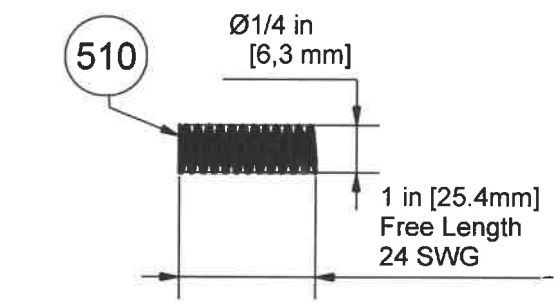
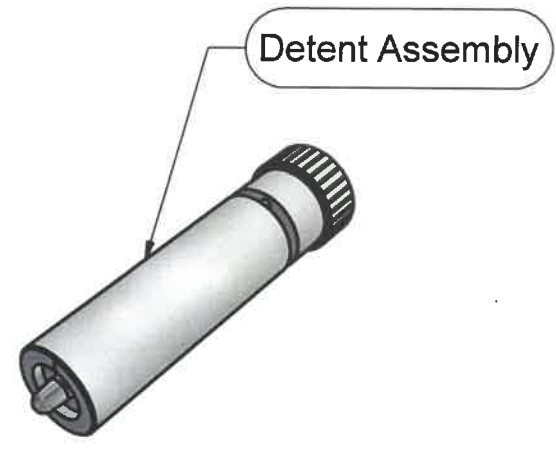
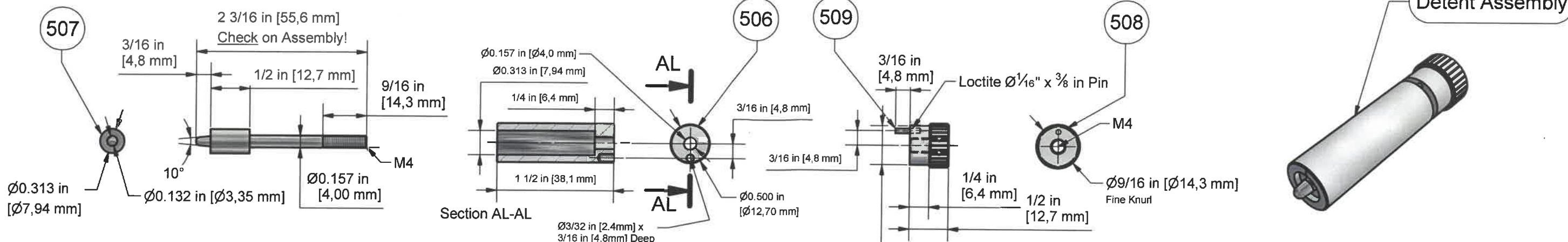
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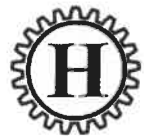
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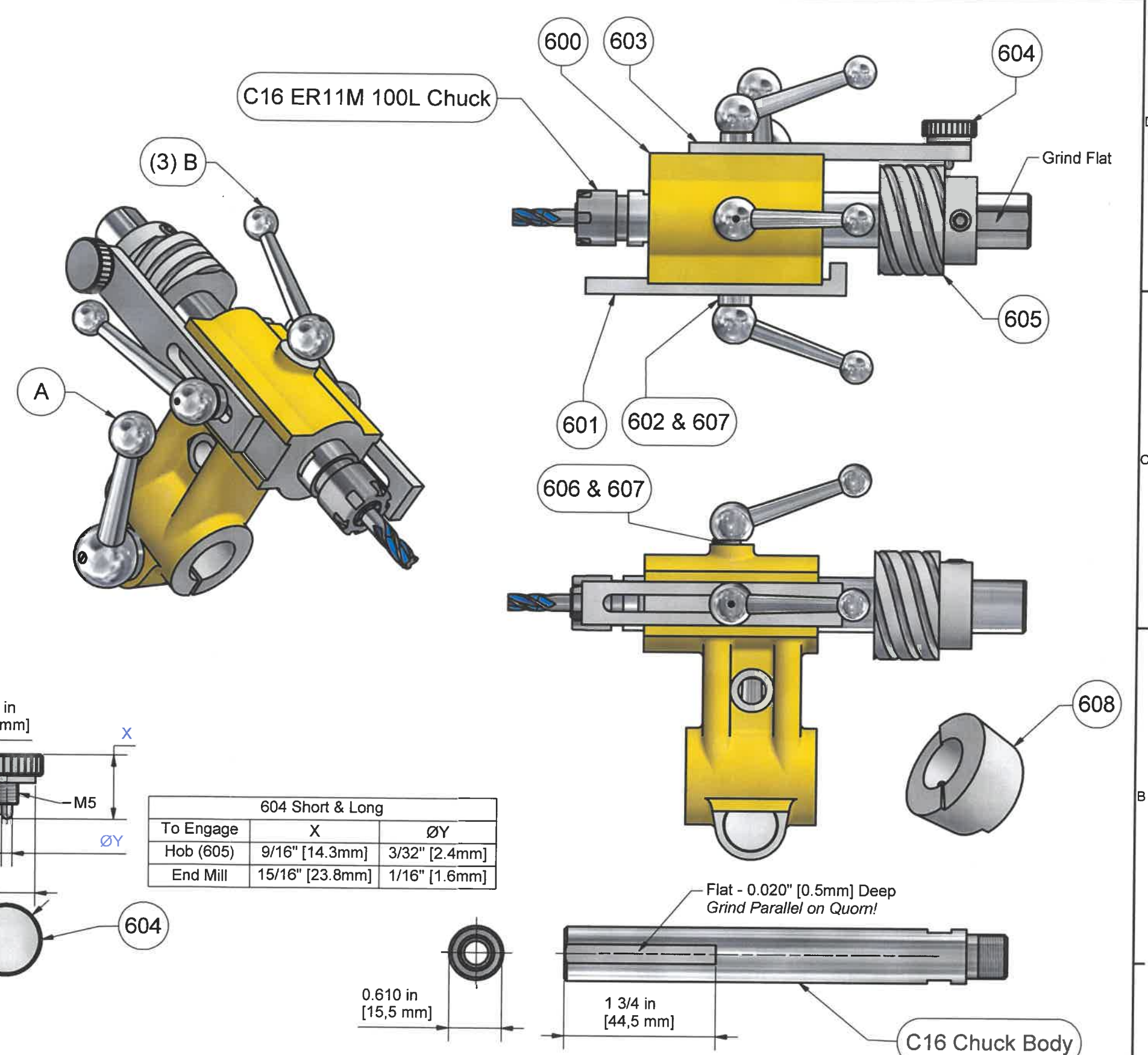
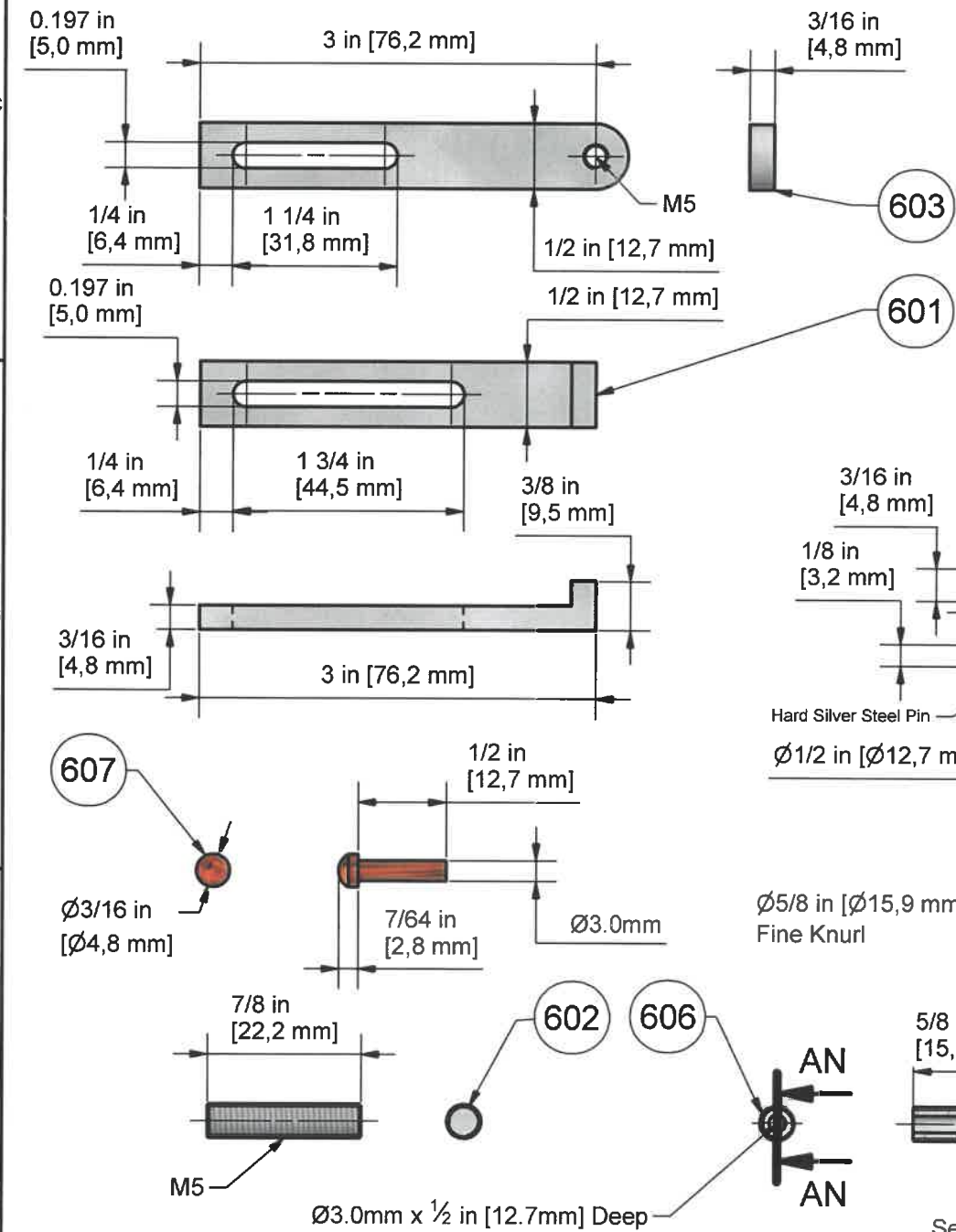
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Spiralling Workhead Parts List - HK 2600©

ITEM	QTY	DESCRIPTION	SUPPLIED AS
600	1	Spiralling Head Body	Iron Casting
601	1	Bar - Stop	1/2" x 3/8" - BMS
602	2	Stud - Side	M5 Studding
603	1	Bar - Guide	1/2" x 3/16" - BMS
604	2	Pin - Guide	Ø5/8" - FCMS
605	1	Hob	Ø1 1/4" - FCMS
606	1	Stud - Top	M5 Studding
607	1	Stud Tip	Ø1/8" Copper Rivet
608	1	Face Cam	Ø1 1/4" - FCMS
See Text	1	C16 ER11M 100L Chuck	Order Separately



604 Short & Long		
To Engage	X	ØY
Hob (605)	9/16" [14.3mm]	3/32" [2.4mm]
End Mill	15/16" [23.8mm]	1/16" [1.6mm]



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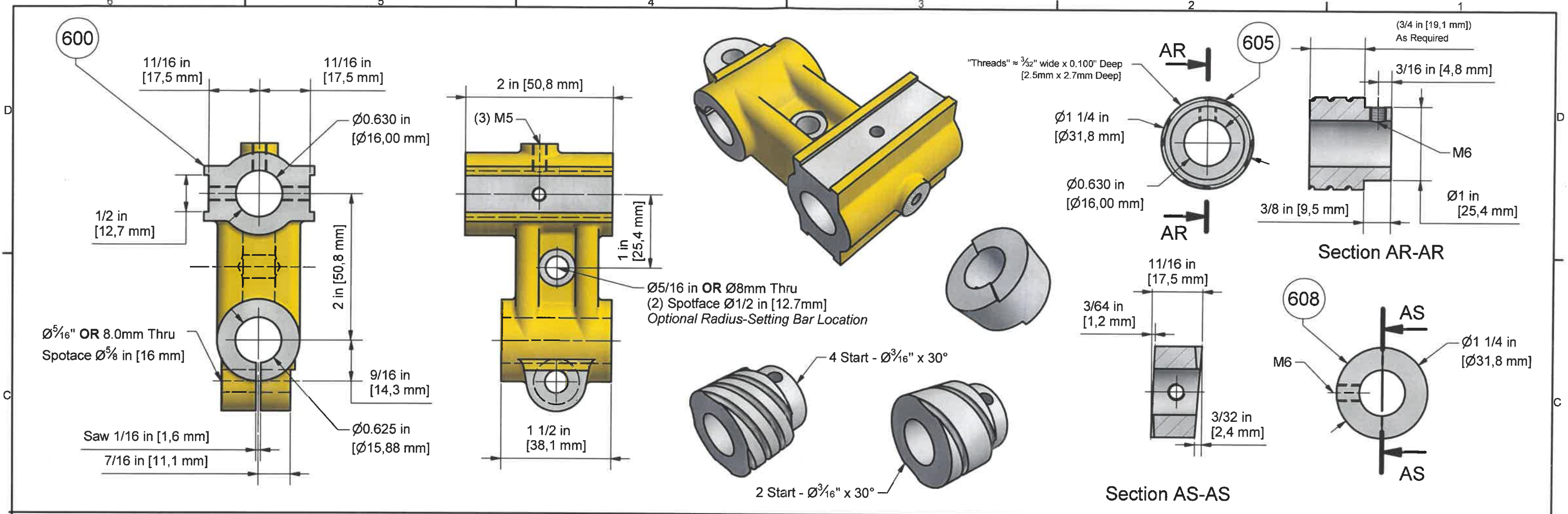
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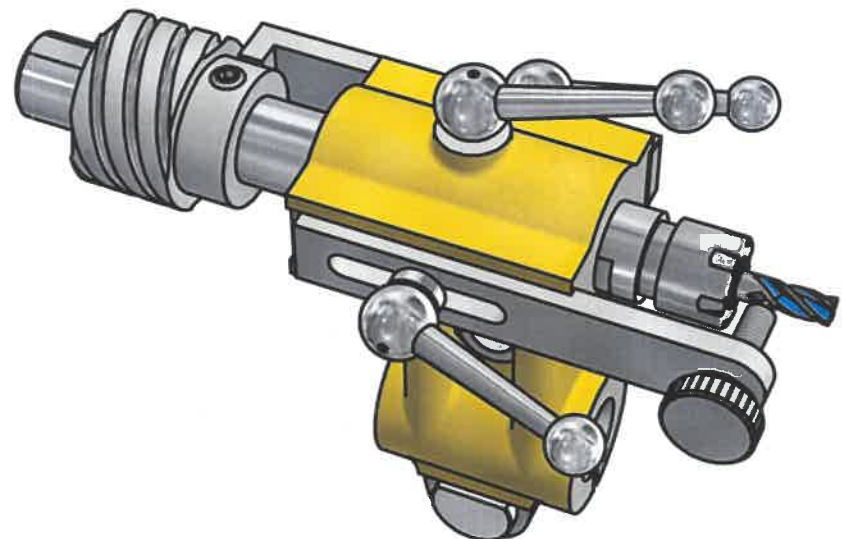
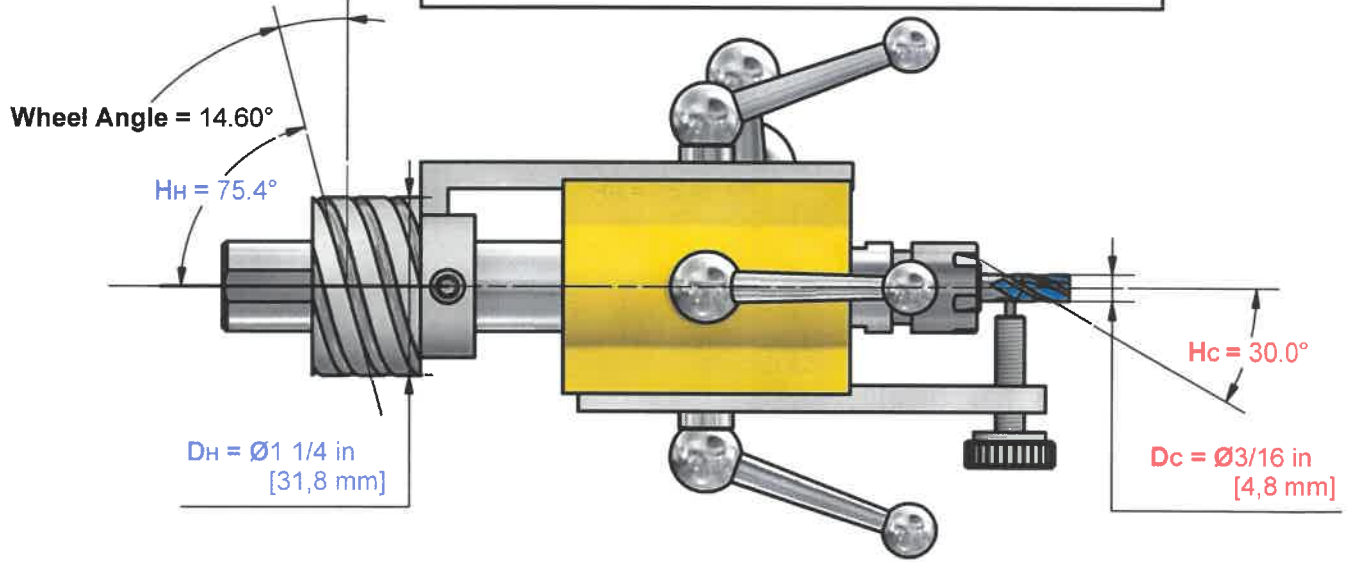
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Copy-Grinding: $\tan(H_H) = \tan(H_c) \times (D_H / D_c)$





- Reverse Spindle in Body
- Reverse Stop & Guide Bars
- Fit Longer Guide Pin
- Fit "Thin" Wheel
- Set Wheel Angle
- Apply Cut with Adjusting Screws (211)

Example:

$\tan(H_H) = \tan(30^\circ) \times (1.25 / 0.1875) = 3.849$

$H_H = 75.4^\circ$

Wheel Angle = $(90^\circ - 75.4^\circ) = 14.6^\circ$

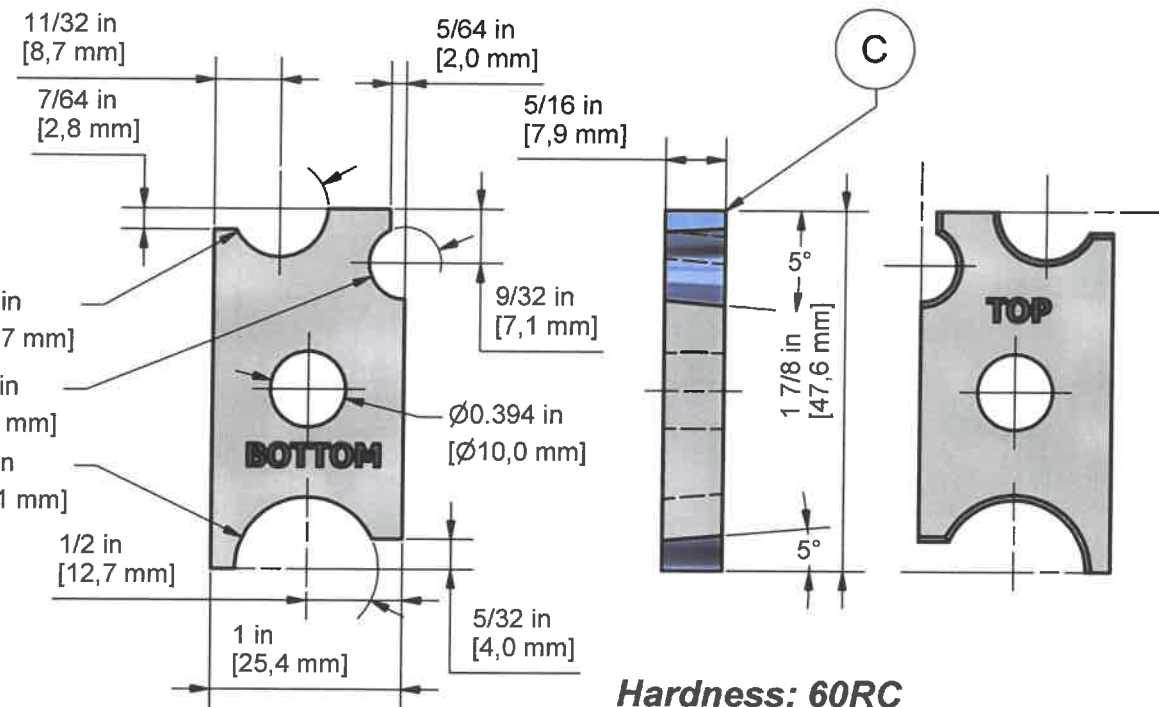
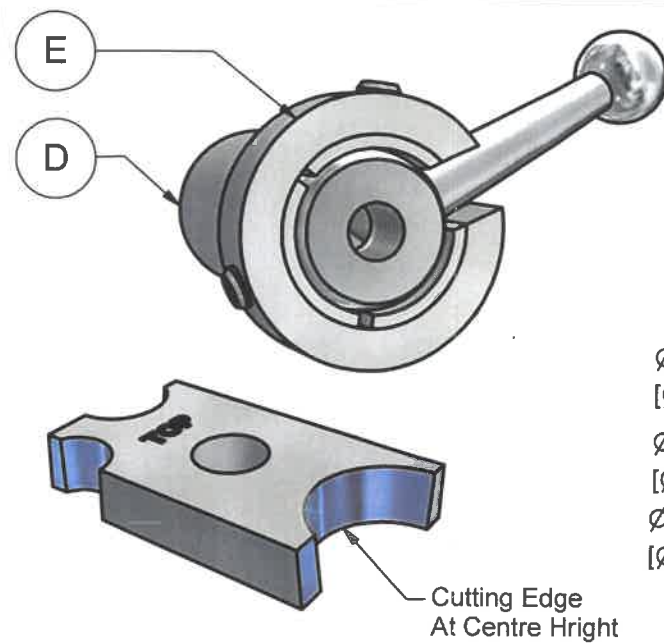
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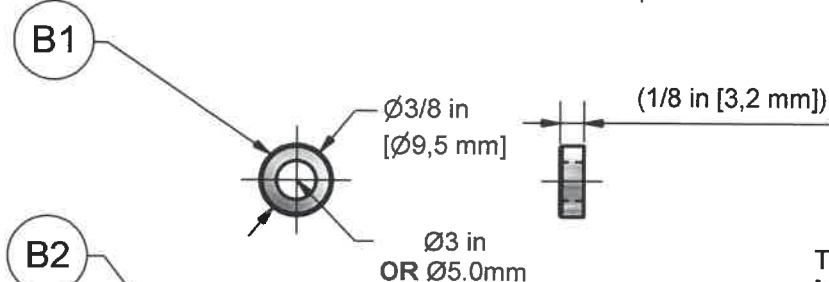
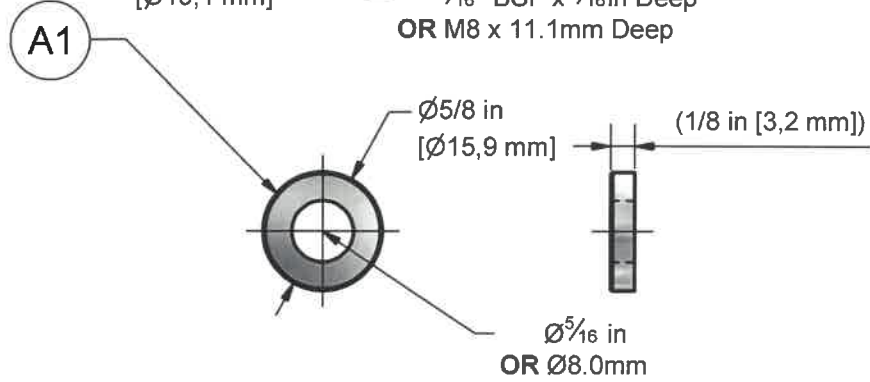
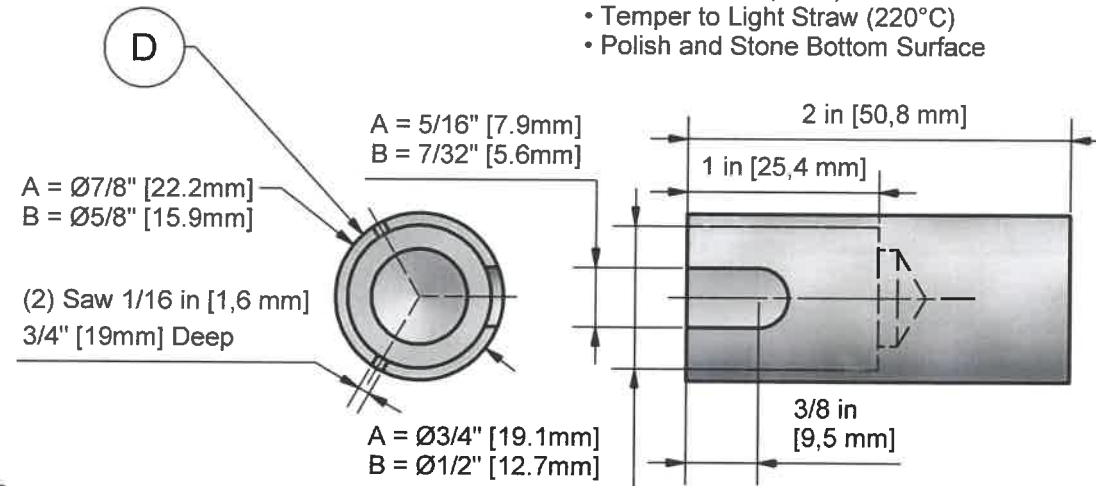
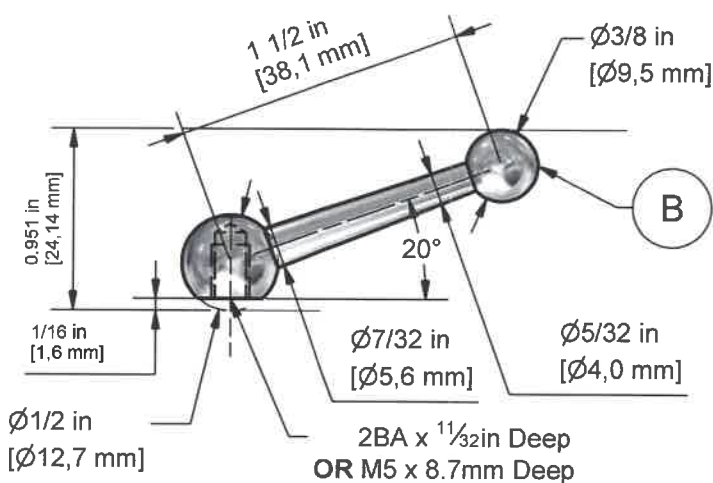
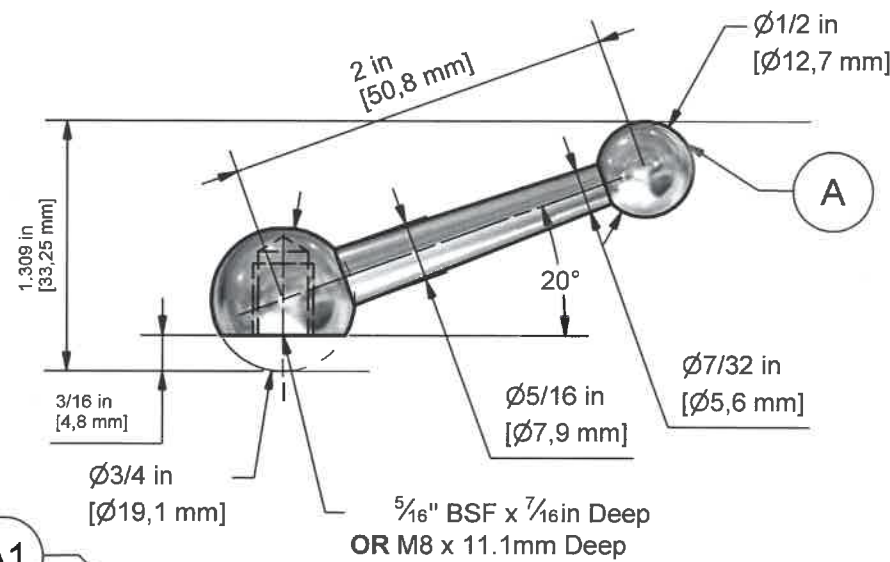
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Ball Handles Parts List - HK 2600©

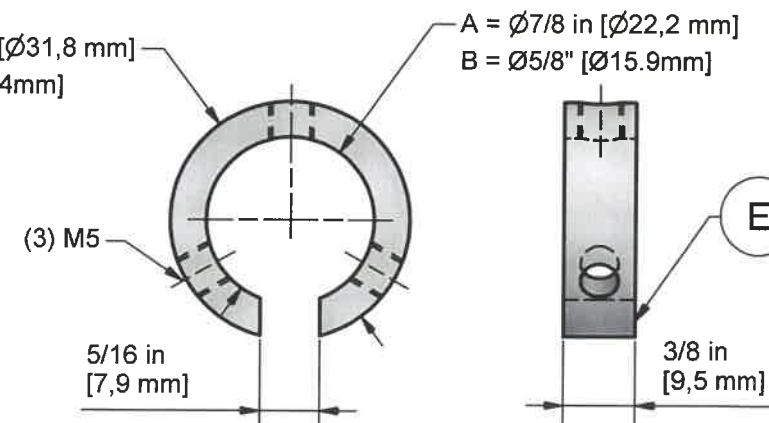
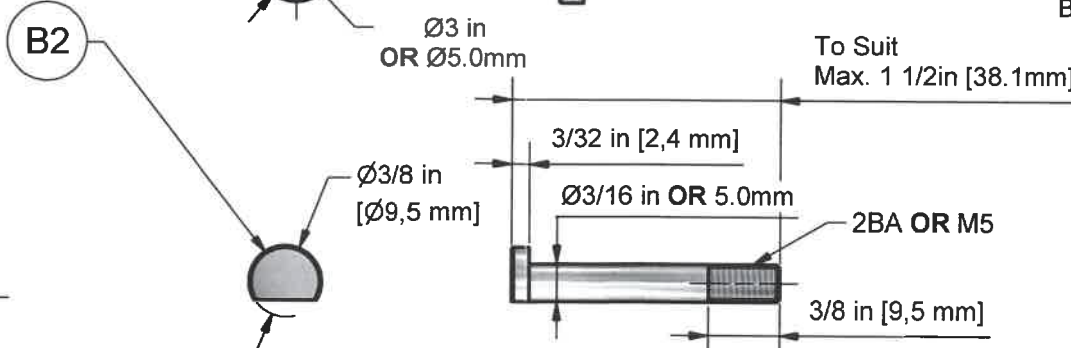
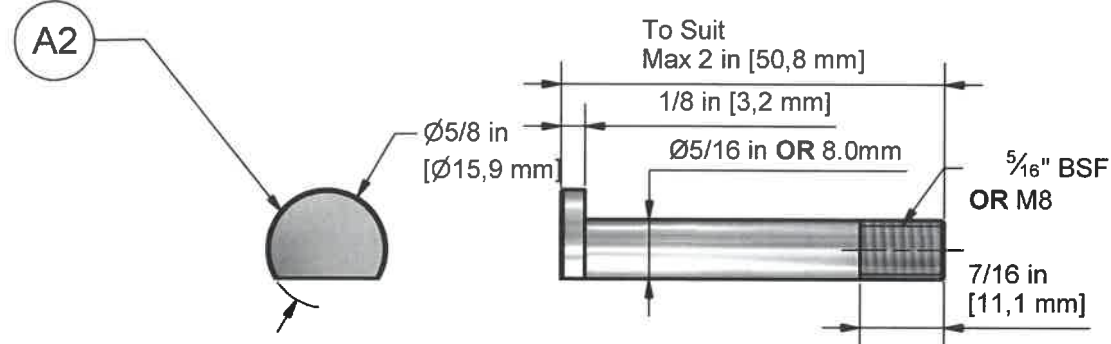
ITEM	QTY	DESCRIPTION	SUPPLIED AS
A	10	Large Ball Handle	Ø3/4" - FCMS
A1	10	Washer	Ø5/8" - FCMS
A2	10	Lock Bolt	Ø5/8" - FCMS
B	7	Small Ball Handle	Ø1/2" - FCMS
B1	7	Washer	Ø3/8" FCMS
B2	7	Lock Bolt	Ø3/8" FCMS
C	1	Form Tool	1 1/4" x 5/16" Gauge Plate
D1	1	Extension - A	Ø7/8" - FCMS
D2	1	Extension - B	Ø5/8" - FCMS
E1	1	Clamp Ring - A	Ø1 1/4" - FCMS
E2	1	Clamp Ring - B	Ø1" - FCMS



Hardness: 60RC
 • Heat to Cherry Red (800°C)
 • Quench in Oil (20°C)
 • Temper to Light Straw (220°C)
 • Polish and Stone Bottom Surface



A = Ø1 1/4 in [Ø31,8 mm]
 B = Ø1" [Ø25,4mm]
 A = Ø7/8 in [Ø22,2 mm]
 B = Ø5/8" [Ø15,9mm]



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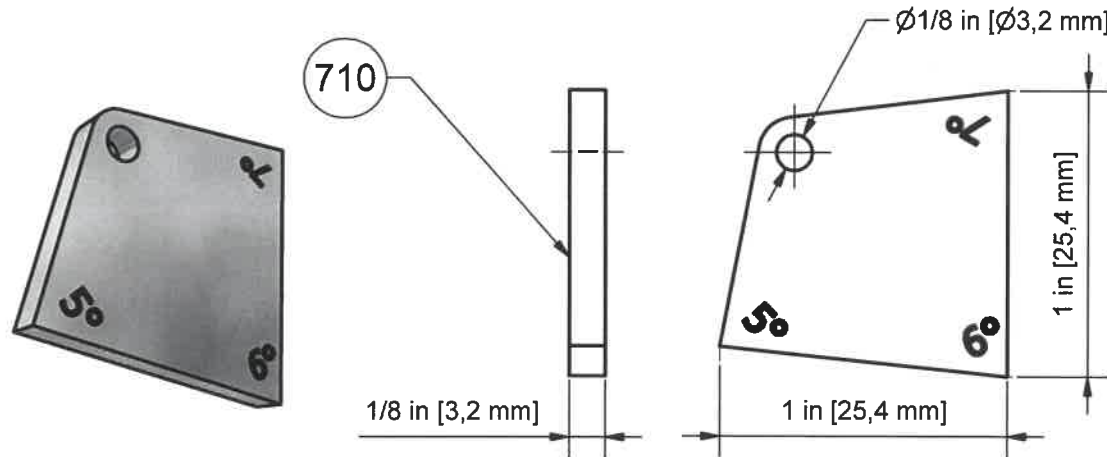
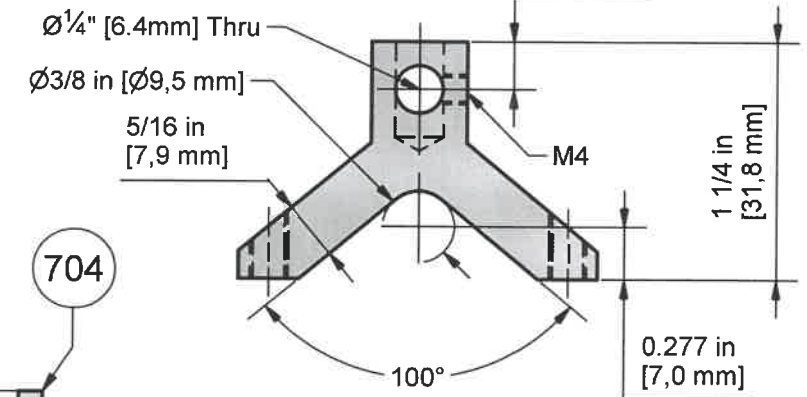
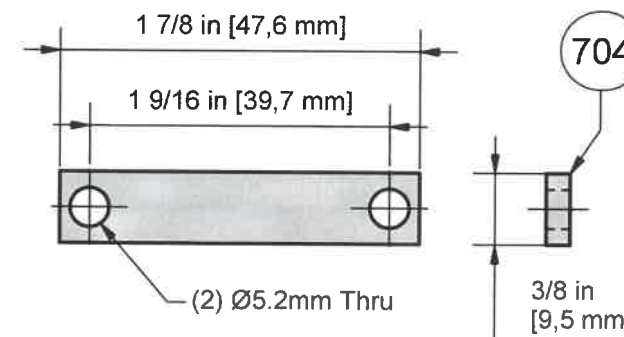
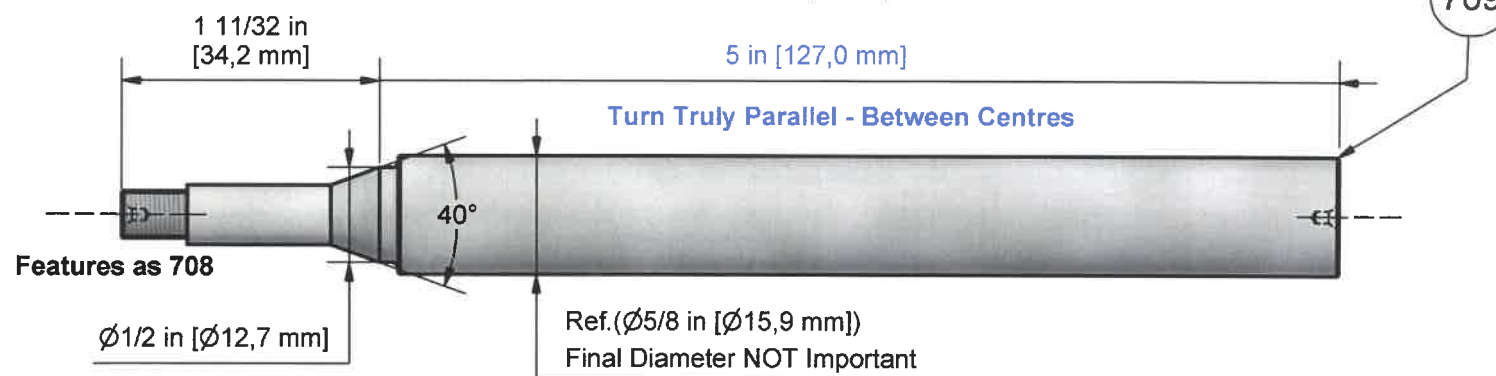
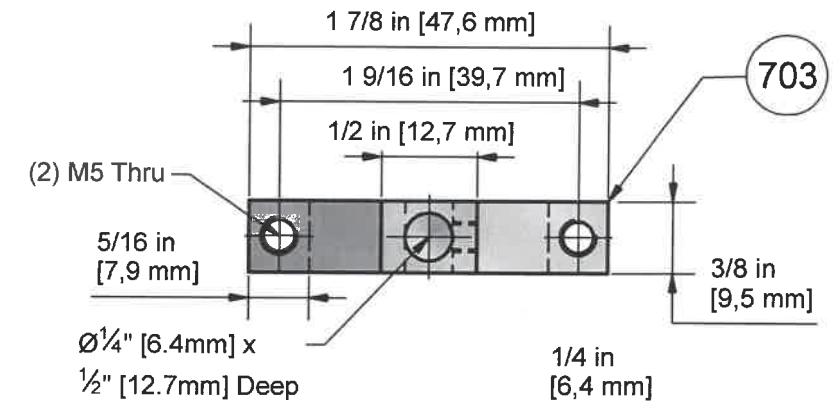
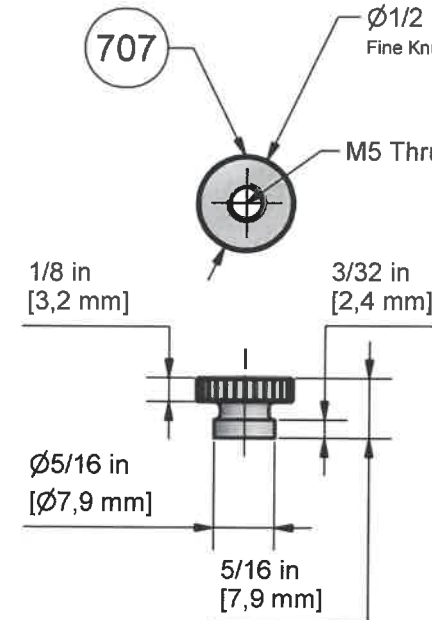
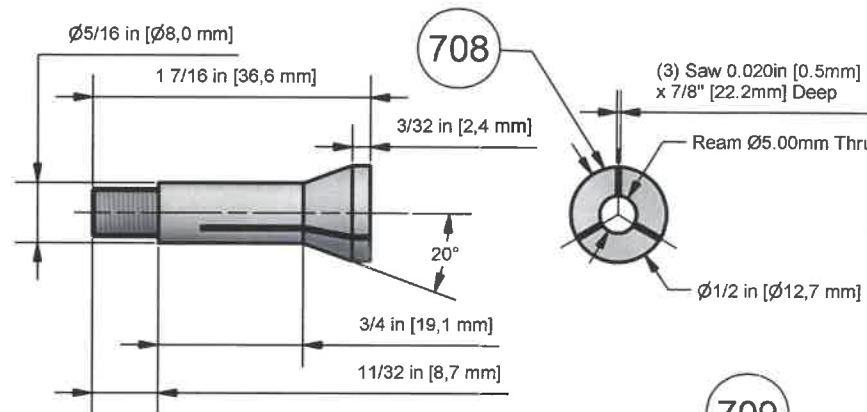
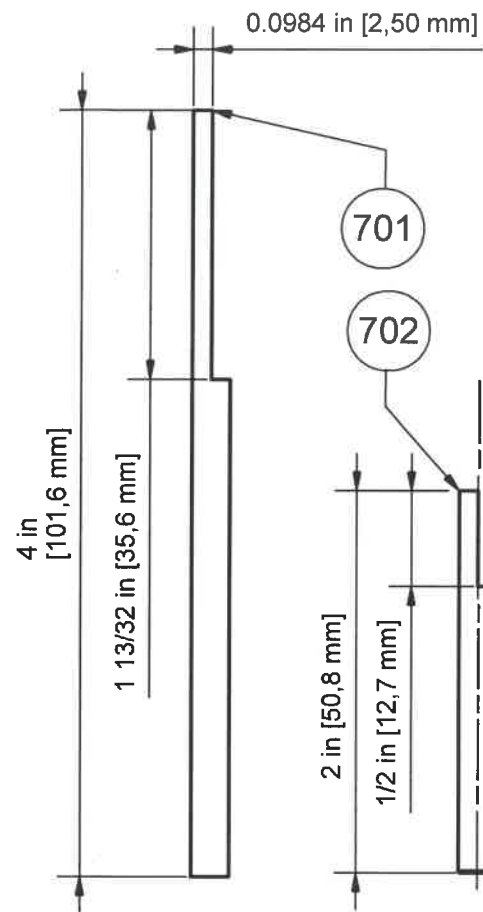
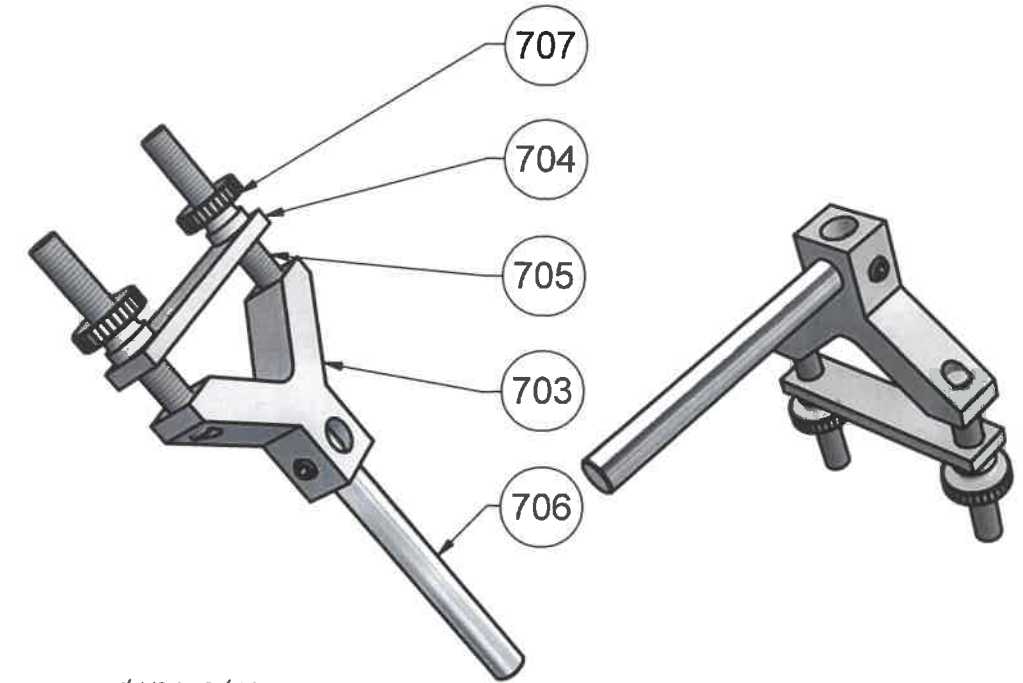
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Setting Aids Parts List - HK 2600©

ITEM	QTY	DESCRIPTION	SUPPLIED AS
701	1	Setting Pin - Long	Ø5mm - Silver Steel
702	3	Setting Pin - Short	Ø5mm - Silver Steel
703	1	"Y"Block	1 1/2" x 3/8" - BMS
704	1	Bridle	3/8" x 1/8" - BMS
705	2	Stud - 1 9/16" [40mm]	M5 Studding
706	1	Column - 2 1/2" [65mm]	Ø1/4" - Silver Steel
707	2	Nut	Ø1/2" - FCMS
708	1	Spindle Collet - Ø5mm	Ø1/2" - FCMS
709	1	Spindle Parallel Arbor	Ø5/8" - FCMS
710	1	Radial Clearance Gauge	1" x 1/8" - Gauge Plate
720	1	Radius Setting Jig	See Sheet 21





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Quorn Mk3 - T & C Grinder

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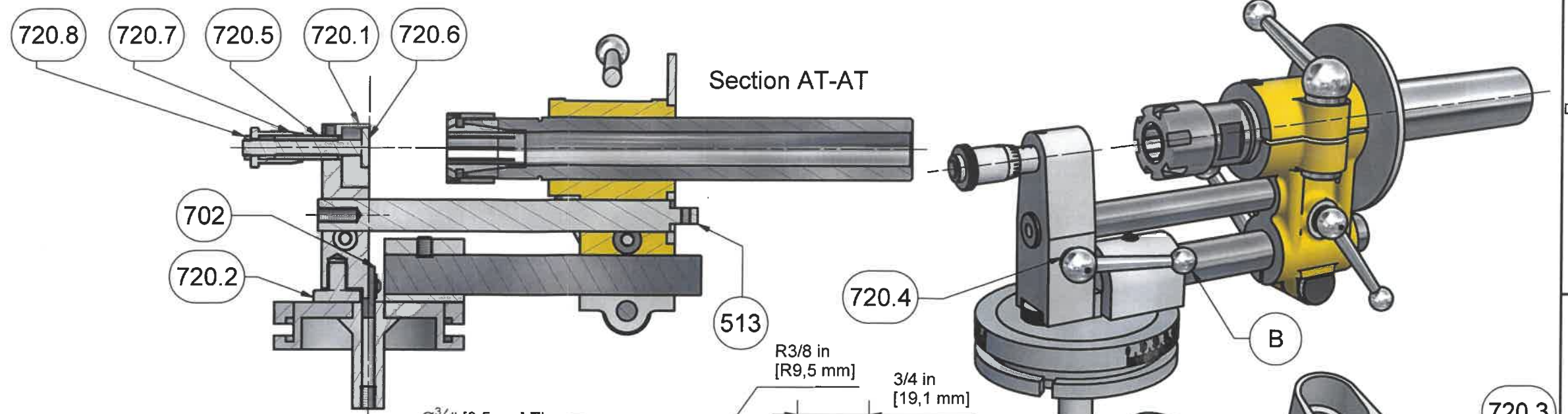
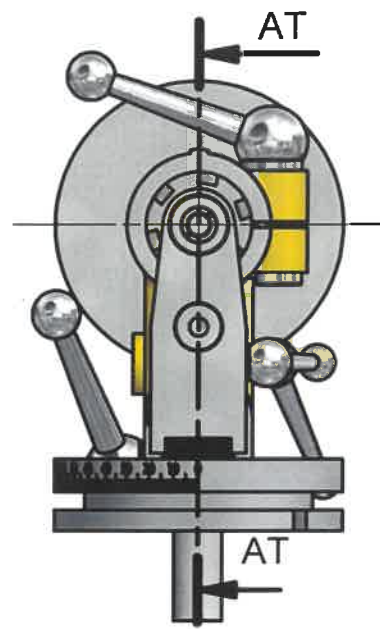
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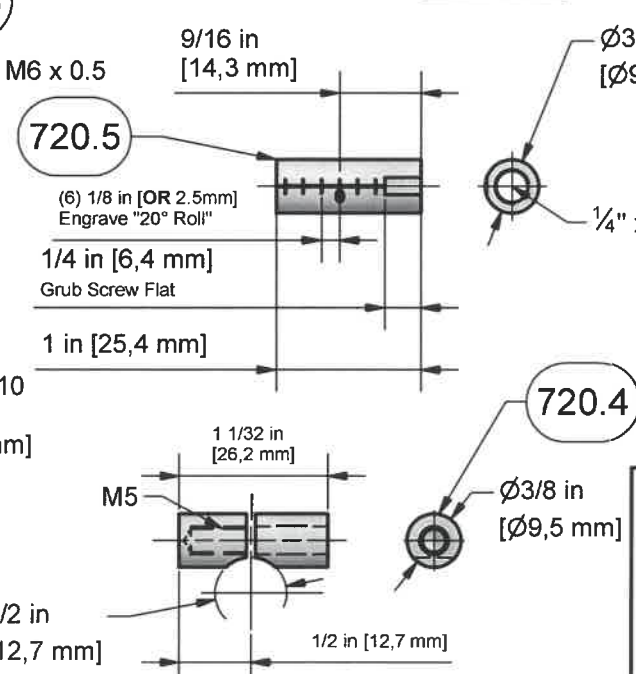
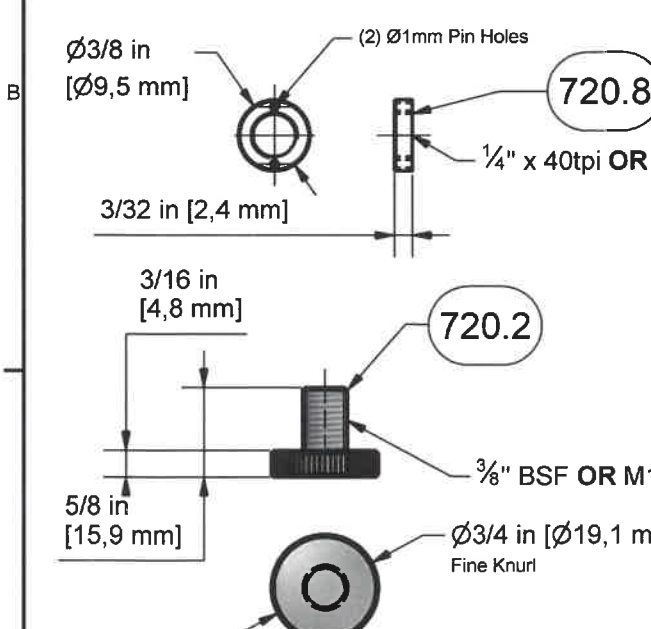
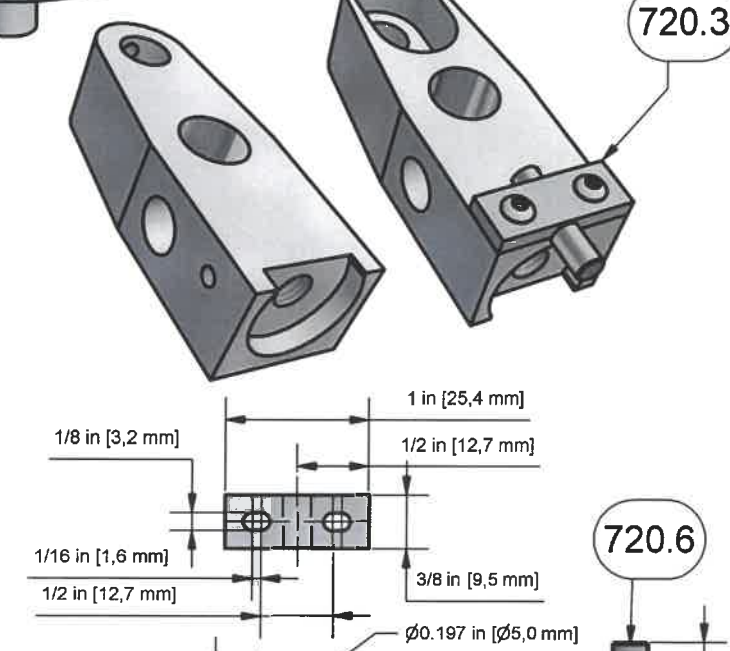
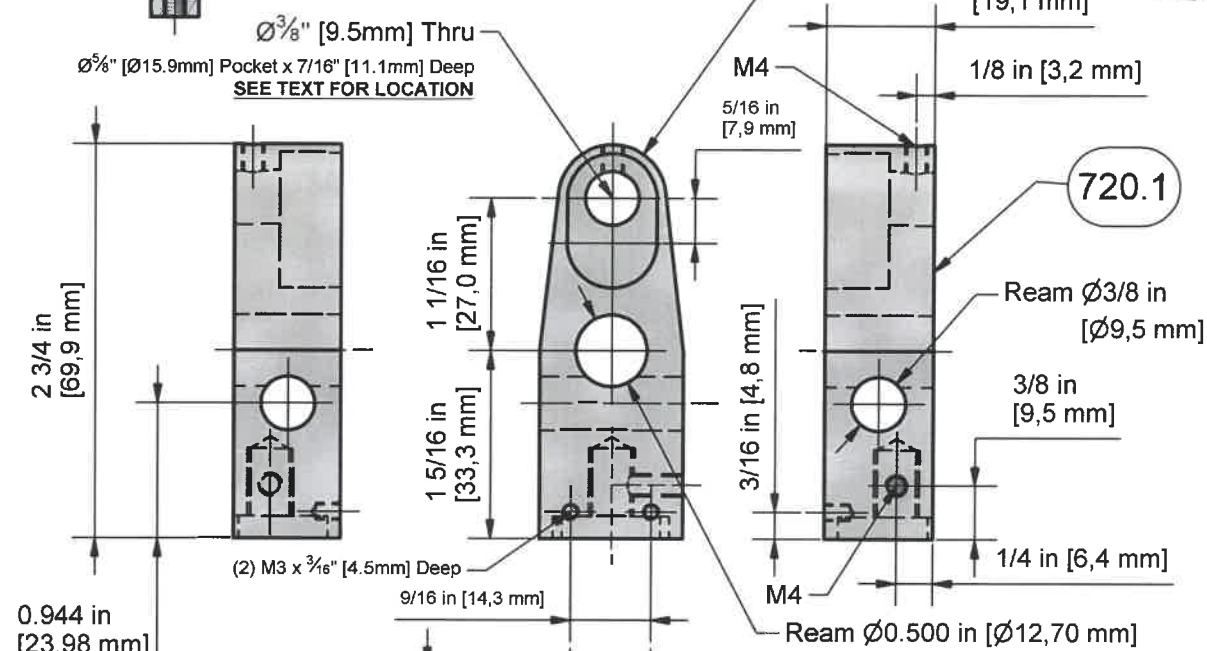
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Parts List - Radius Setting Jig - 720			
ITEM	QTY	DESCRIPTION	SUPPLIED AS
720.1	1	Body	1" x 3/4" - BMS
720.2	1	Jack Screw	Ø3/4" - FCMS
720.3	1	Pin Anchor	3/8" x 1/8" - BMS
720.4	1	Double Cotter	Ø1/2" - FCMS
720.5	1	Mic - Barrel	Ø3/8" - FCMS
720.6	1	Mic - Screw	Ø5/8" - FCMS
720.7	1	Mic - Thimble	Ø5/8" - FCMS
720.8	1	Mic - Locknut	Ø3/8" - FCMS



TITLE: Quorn Mk3 - T & C Grinder		KIT CODE: HK 2600	
DESIGNER: D H Chaddock CBE MSc CEng FIMechE		126 DUNVAL ROAD, BRIDGNORTH, SHROPSHIRE, WV16 4LZ, UK www.hemingwaykits.com	
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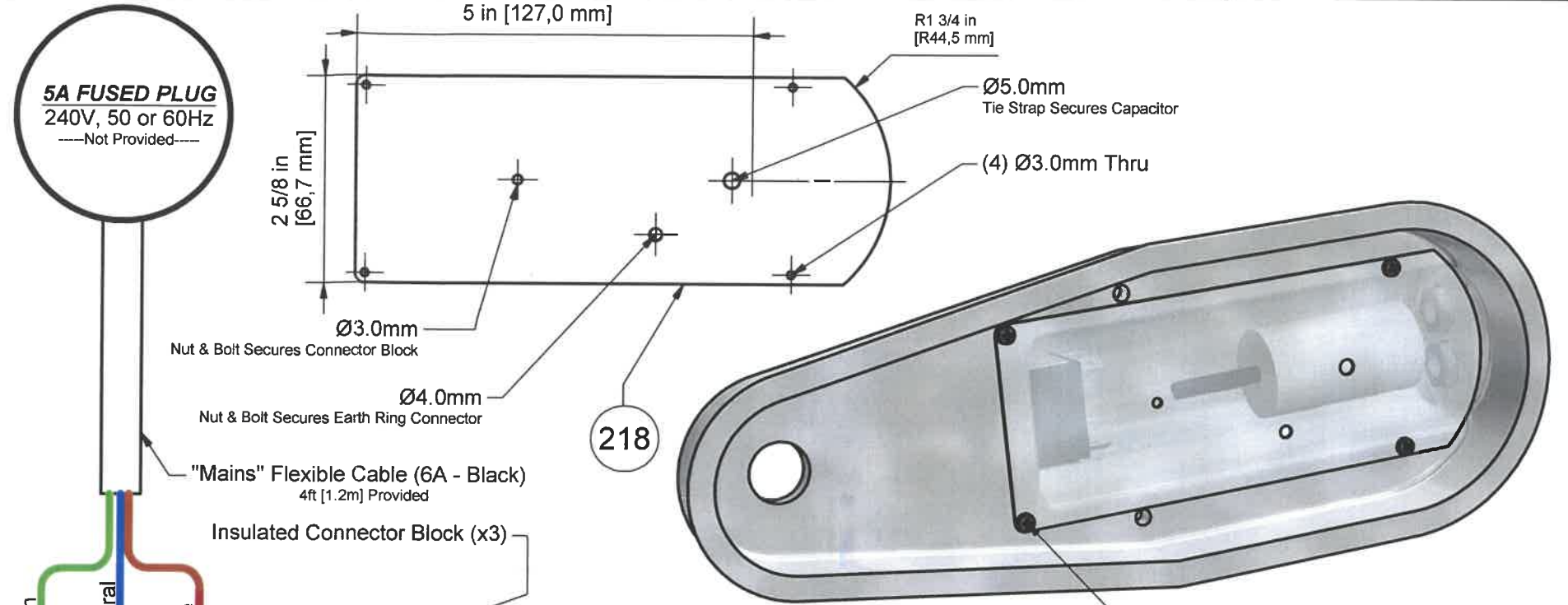
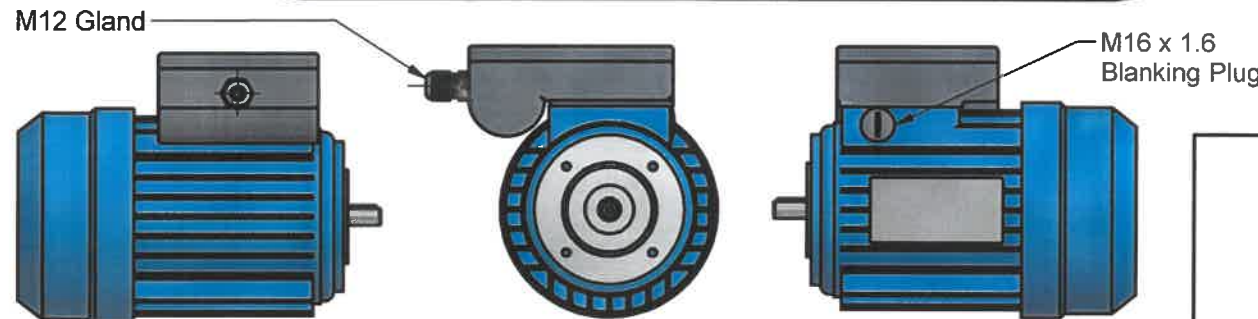
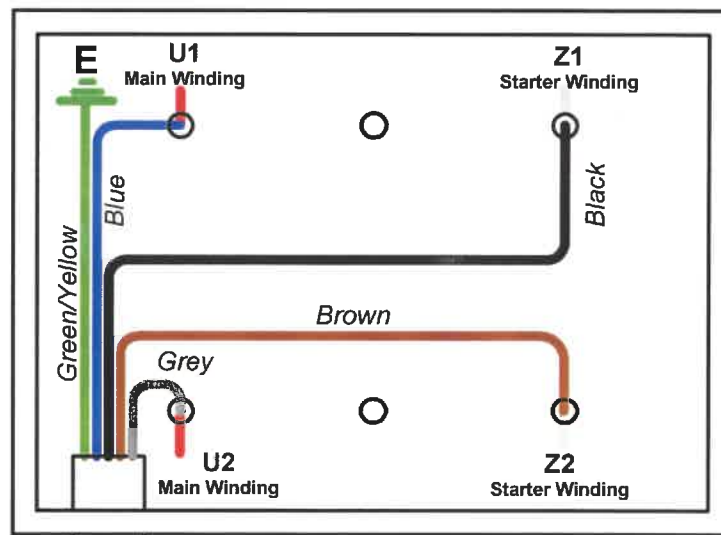
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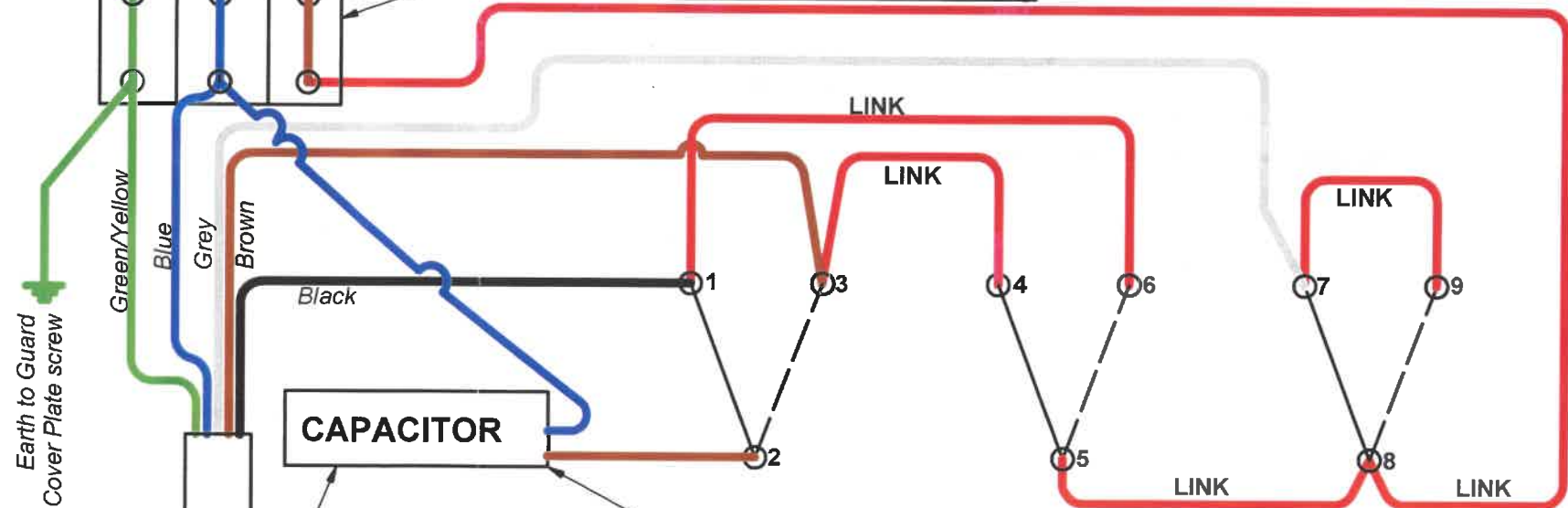
Wiring Notes

- The Quorn uses a 125W, 220V, Permanent Capacitor, Single Phase, 2 Pole Motor.
- 2 screws secure the terminal box cover. Remove and discard the 2 "Link Bars" between terminals.
- Entirely remove the Capacitor (with leads) from the terminal box.
- Remove the cable gland from the motor frame and replace it with the M16 x 1.6 blanking plug supplied.
- Drill a $\varnothing 12\text{mm}$ hole into the back of the terminal box and fit one of the M12 cable glands supplied.
- Within the terminal box, find the following 4 connections/wires:
 - > The 2 ends of the Starter Winding (Typically Z1 & Z2 in White Wire).
 - o {check continuity with multi-meter, slightly higher resistance}
 - > The 2 ends of the Main Winding (Typically U1 & U2 in Red Wire).
 - o {check continuity with multi-meter, slightly lower resistance}
- Motor has a conventional 6 stud terminal board (W1,W2, U1, U2, V1, V2) but only 4 terminal posts are required. Each of the 4 will end up with 2 wires attached - one from the 4 ends of the 2 windings and one from the 5 core cable supplied.
- Once the 5-core wire has been fed through the newly fitted gland, crimp or solder on the 5 ring-connectors supplied and attach as shown. The Yellow/Green earth wire is attached to the earth screw within the terminal box.
- Fit the 2 remaining M12 glands to the belt guard. Thread the 5-core cable through "Top" gland and the 3-core cable through the "Bottom" before stripping the PVC sheathing and all 8 wire ends.
- The 9 switch terminals are labeled on the back of the 3PDT switch. The 9 Female 1/4" Faston connectors supplied are crimped directly onto the stripped wires. Use the 4 Blue connectors where 2 wires are joined (1, 3, 7 & 8) and the Red ones for a single wire. Use the loose Red wire supplied to create the 4 x 2 1/2" link wires and a 3" one for terminal 8. Use the Green/Yellow wire and the final ring-connector for an additional earth wire between the connector block and the closing plate (218).
- With the wiring completed, power-up the motor and toggle the switch between the 3 positions (remaining in the central OFF position until the motor shaft has stopped spinning). Mount the switch within the Guard so that pushing "Down" gives a "Clockwise" rotation of the motor (looking at the shaft). Affix the legend sticker provided.

Typical Motor Terminal Wiring




Switch Terminal Wiring



DANGER:
The capacitor charges quickly and will hold lethal amounts of energy even when not in a live circuit (eg. you can receive a 240V shock with the plug disconnected from the mains). This energy will not quickly dissipate and you should use extreme caution in handling the capacitor leads.

With the motor unplugged, the capacitor can be discharged by shorting the 2 leads. Protect yourself; use insulated tools and wear eye protection as the discharge will be violent.



Hemingway Kits

TITLE:
Quorn Mk3 - T & C Grinder

KIT CODE:
HK 2600

DESIGNER:
D H Chaddock CBE MSc CEng FIMechE

126 DUNVAL ROAD, BRIDGNORTH,
SHROPSHIRE, WV16 4LZ, UK
www.hemingwaykits.com

ORIGINAL DESIGN: 04/01/1974

REVISION DATE: 23/03/2019

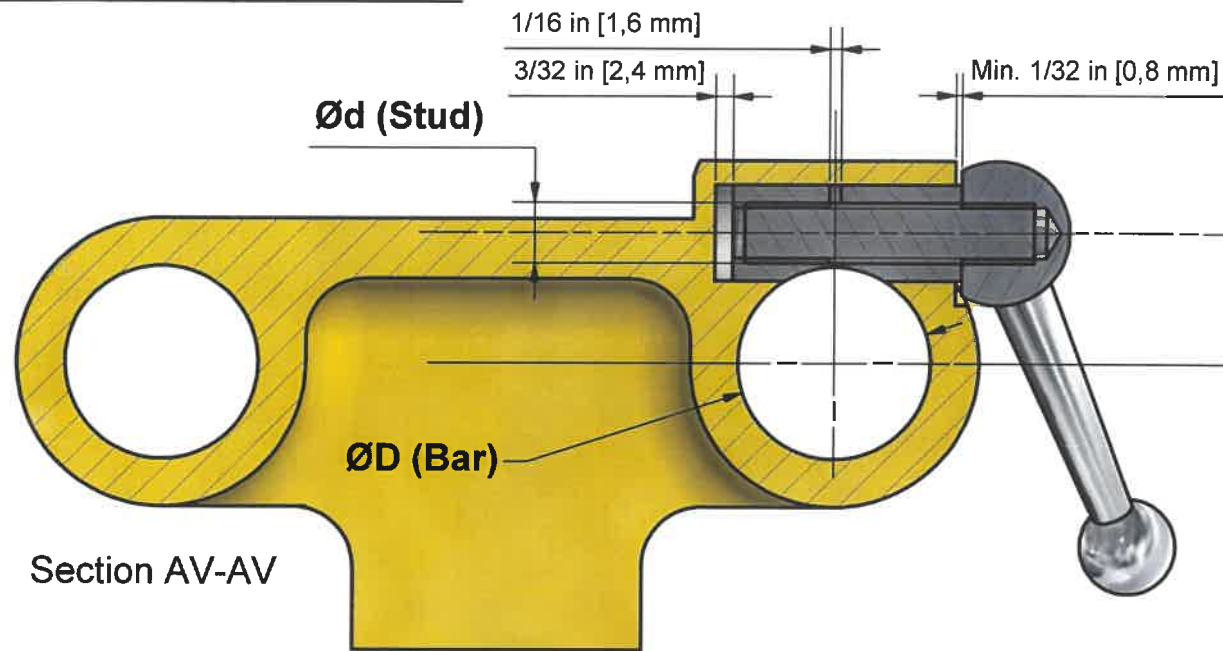
THIRD ANGLE PROJECTION

SHEET:
22 OF 24

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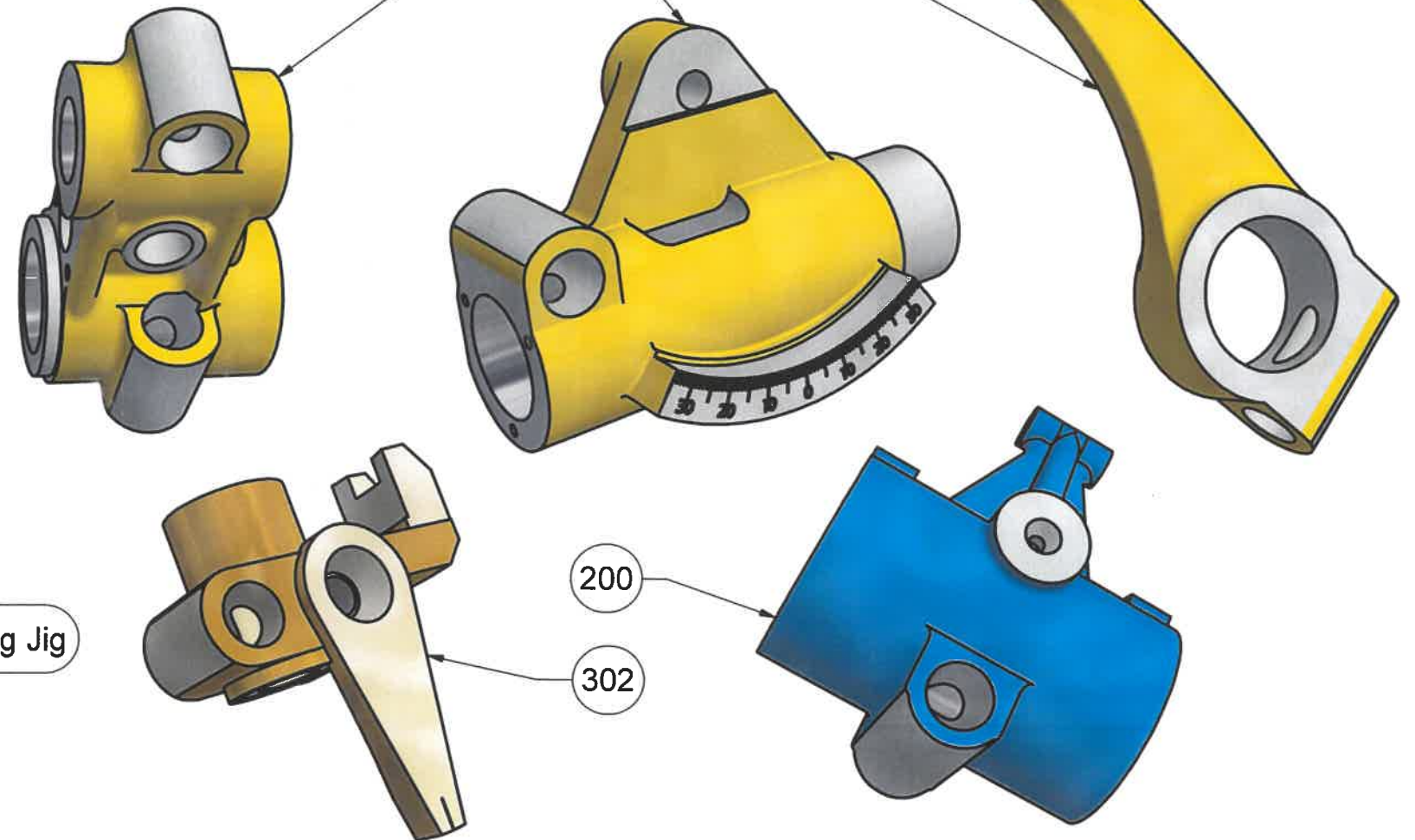
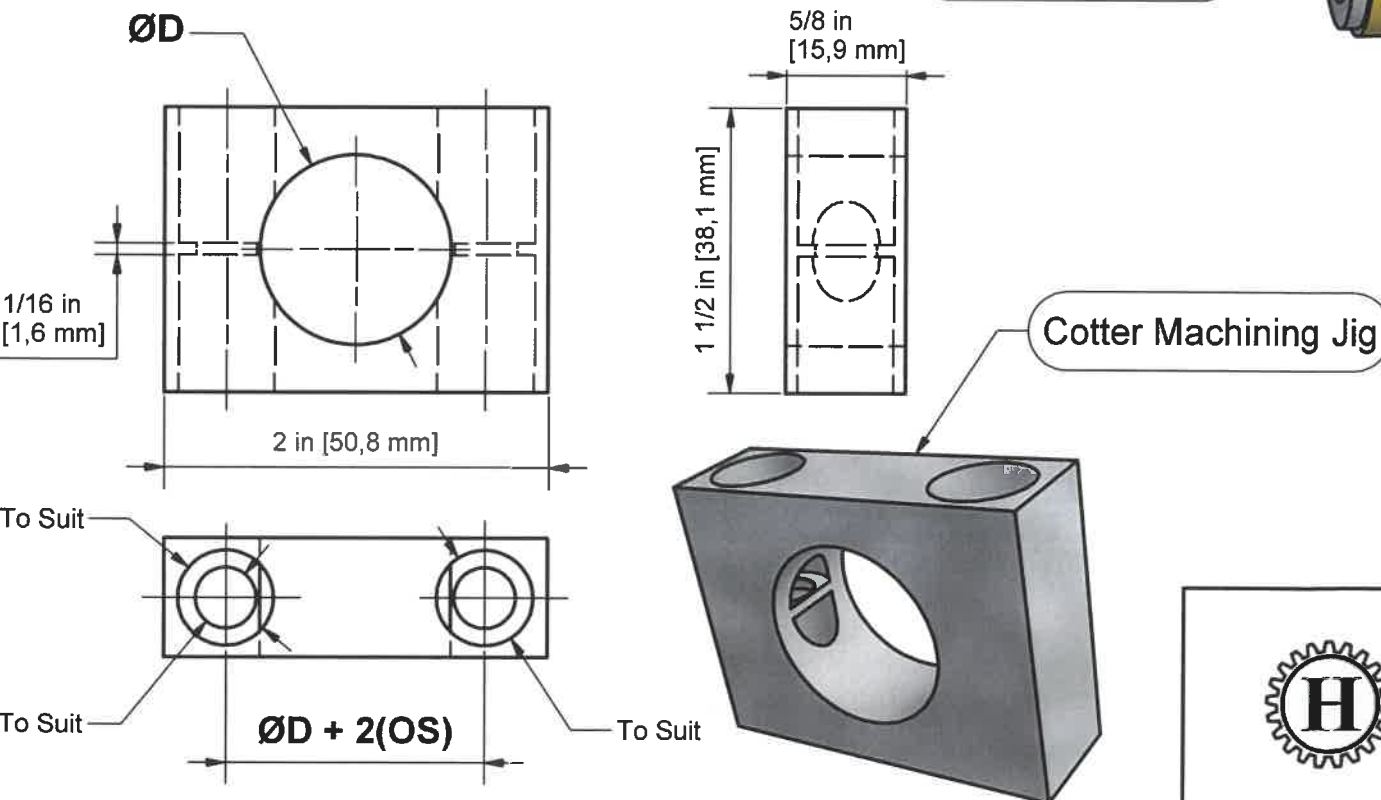
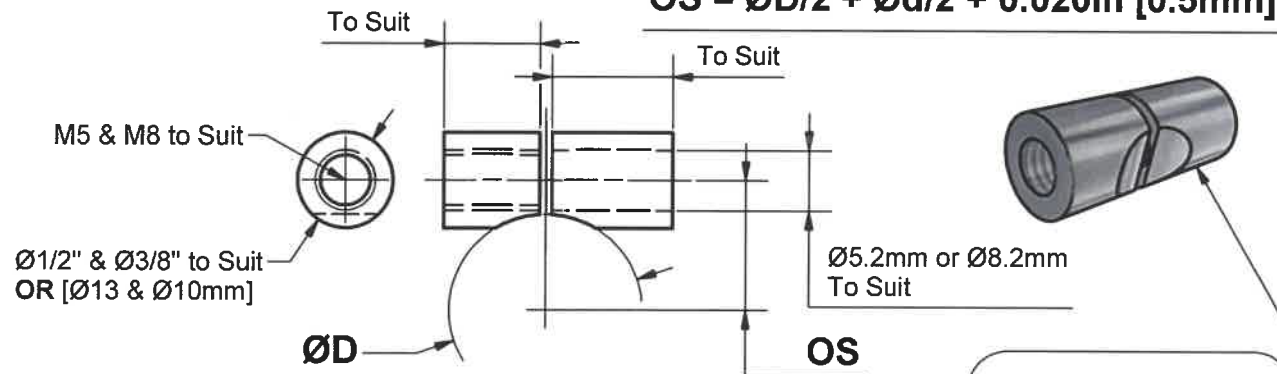
Double Cotter Joint



$OS = 0.677$ in [17,2 mm]

PLEASE NOTE: This variation will require material NOT included in the full material kit.

$OS = \varnothing D/2 + \varnothing d/2 + 0.020$ in [0.5mm]



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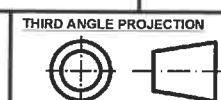
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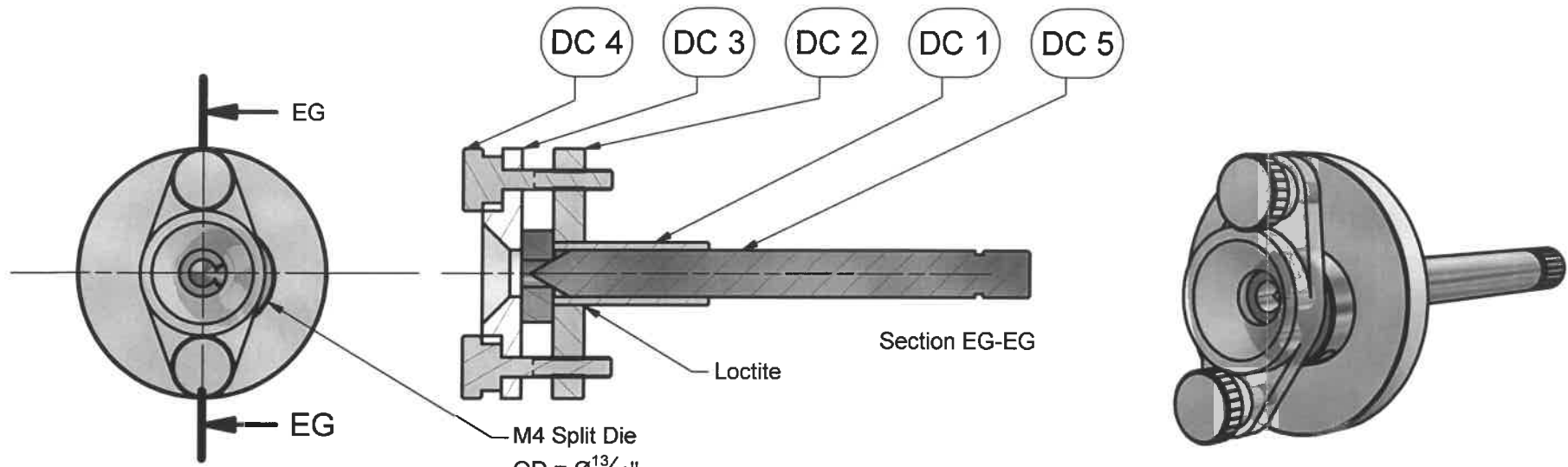
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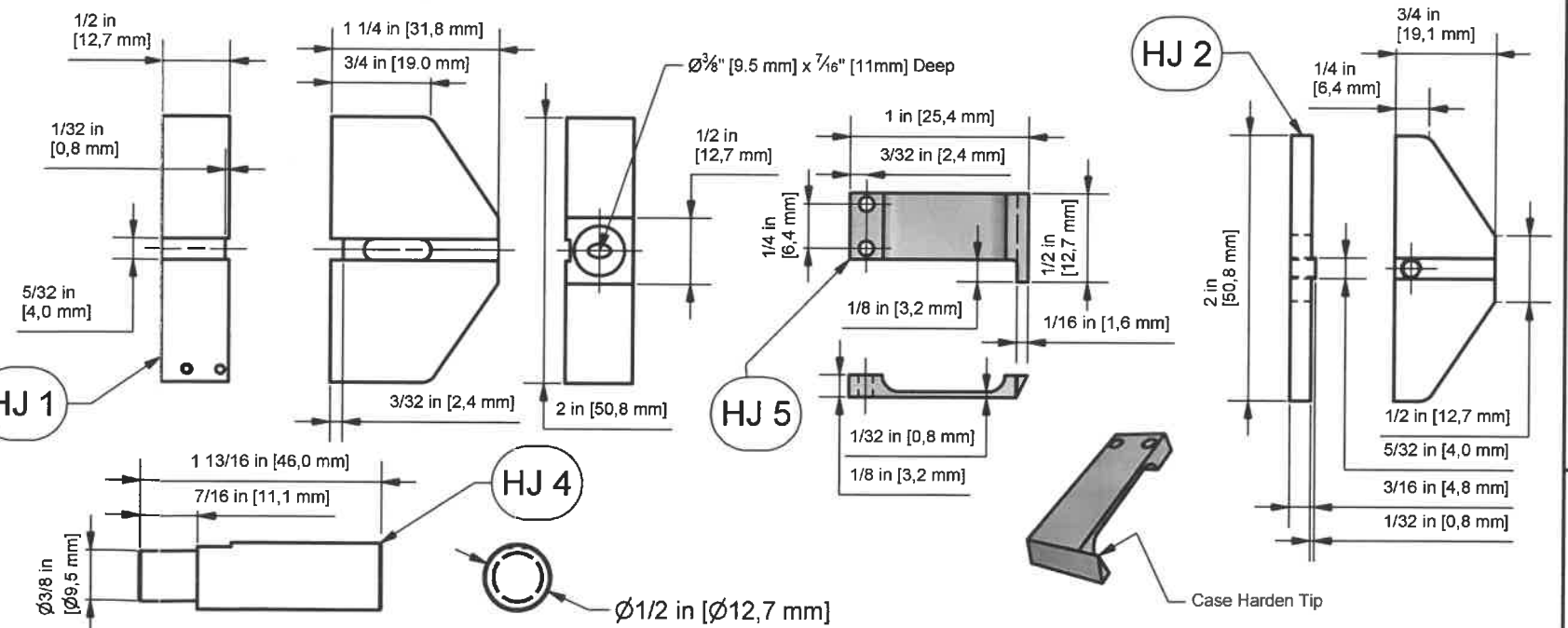
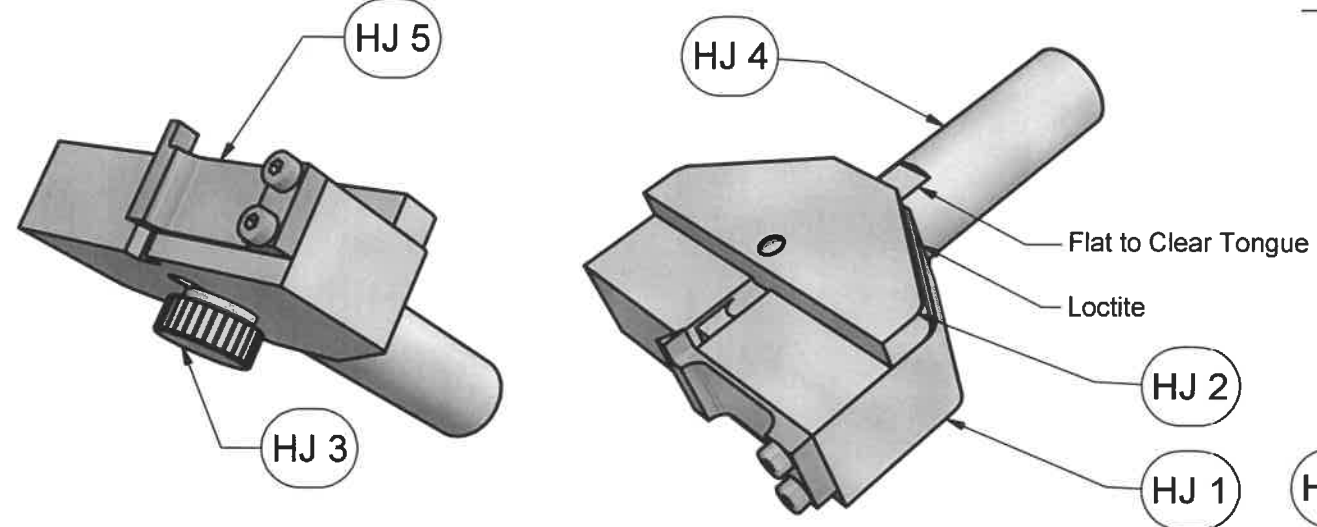
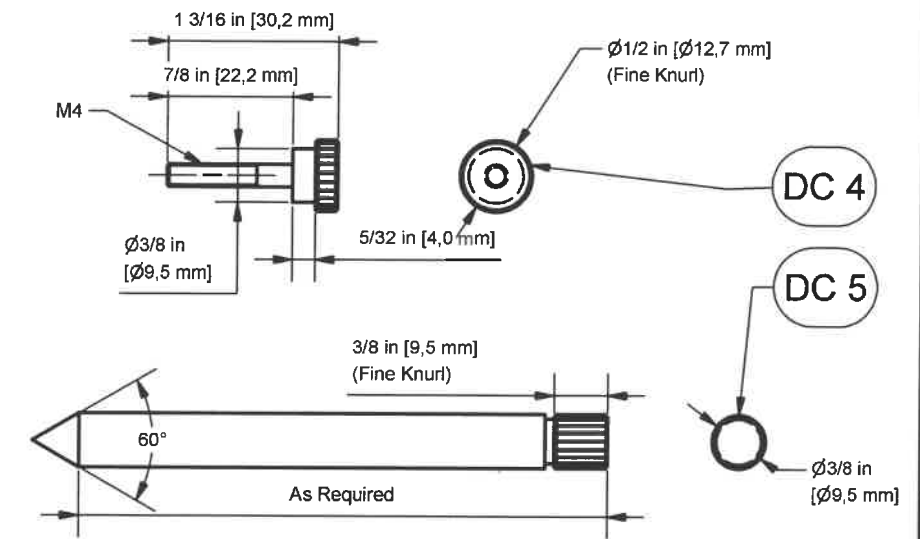
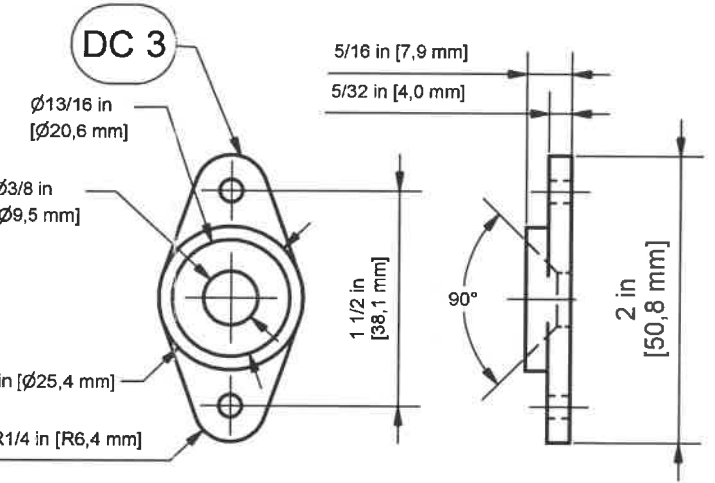
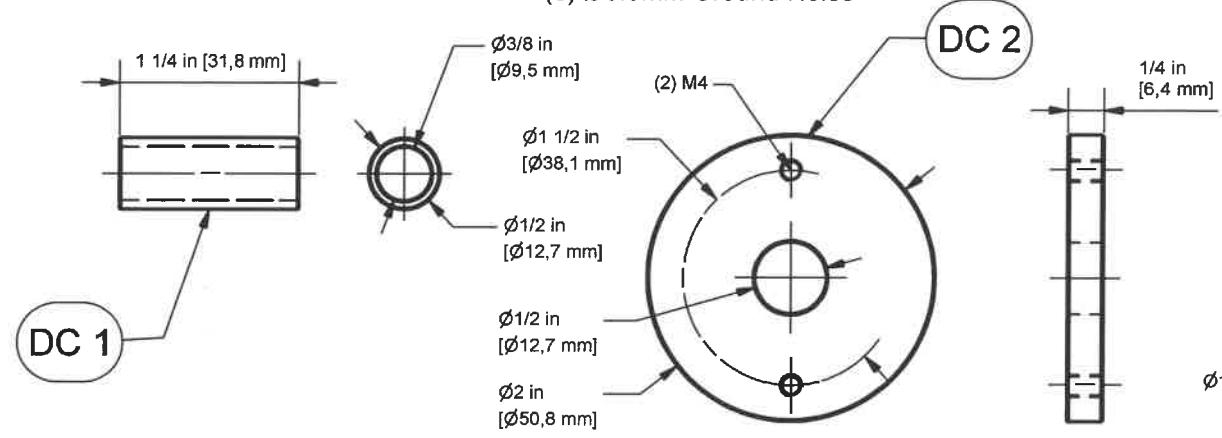
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Die Carrier - Parts List			
ITEM	QTY	DESCRIPTION	REQUIRED
DC 1	1	Arbor	Ø1/2" - FCMS
DC 2	1	Faceplate	Ø2" - FCMS
DC 3	1	Bridle	1" x 3/8" - BMS
DC 4	2	Clamp Screw	Ø1/2" - FCMS
DC 5	1	Pump Centre	Ø3/8" - Silver Steel

M4 Split Die
OD = Ø1 3/16"
(3) Ø5.5mm Ground Holes



Hacksaw Jig - Parts List			
ITEM	QTY	DESCRIPTION	REQUIRED
HJ 1	1	Body	1 1/4" x 1/2" - BMS
HJ 2	1	Fence	2" x 1/4" - BMS
HJ 3	1	Clamp Screw	AS DC4
HJ 4	1	Arbor	Ø1/2" - FCMS
HJ 5	1	Detent	1/2" x 1/8" - BMS



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	Item	SHEET	Description	Material	QTY	Bar Section	Remarks	Done
BASE ASSEMBLY	100	3	Base - LH	Casting - Iron	1			
	101	3	Base - RH	Casting - Iron	1			
	102	4	Bar - Rear	PG/HTS	1	Ø1"		
	103	4	Bar - Front	PG/HTS	1	Ø1"		
	104	3	Column	Complete - HTS	1	Ø1 1/4"		XX
	105	4	End Cap - RH	FCMS	1	Ø1 1/2"		
	106	4	Spring	Complete	1			XX
	107	4	Body	Iron	1	Ø40mm		
	108	4	Thimble	FCMS	1	Ø1 3/8"		
	109	4	Micrometer Screw	FCMS	1	Ø1 1/2"		
	110	NS	Spring	Complete	1			XX
	111	NS	Steel Ball Ø3/16"	Complete	2			XX
	112	4	Collar	Casting - Iron	1			
	113	4	Support Bar	FCMS	1	Ø1/2"		
	114	4	Clamp	BMS	1	3/4" x 3/4"		
	115*	4	Blade	Old Hacksaw*	1			
	116	4	Stud	FCMS	1	Ø5/16"		
	117	4	Dust Cover	Aluminium	3	Ø1 1/2"		
118	4	Dust Seal	Felt	3	45mm x 3mm			
WHEELHEAD ASSEMBLY	200	6	Wheelhead Collar	Casting - Iron	1			
	201	6	Wheelhead Bracket	Casting - Iron	1			
	202	6	Belt Guard	Casting - Al	1			
	203	7	Nut	FCMS	1	Ø2"		
	204	7	Peg Assembly	M6 x 8 Grub	2			
	205	7	Friction Pad	Nylon 66	1	Ø3/16"		
	206	7	Indexing Ring	FCMS	1	Ø2"		
	207	7	Motor Plate	BMS	1	4" x 3/16"		
	208	7	Belt Adjusting Screw	M8 x 20 Hex	2			
	209	5	Pivot Screw	M8 x 25 Grub	1			
	210	5	Pivot Screw	M8 x 30 Grub	1			
	211	7	Adjusting Screw	FCMS	2	Ø1"		
	212	7	Motor Pulley	Aluminium	1	Ø3"		
	213	NS	Drive Belt	PVC Belting	1	Ø5mm		
	214	NS	Induction Motor 240V	Complete	1			XX
	215	7	Wheel Guard	Casting - Al	1			
	216	5	Distance Piece	FCMS	1	Ø5/8"		
	217	5	Pulley Clamp Washer	FCMS	1	Ø3/4"		
218	22	Closing Plate	Sheet - 0.7mm	1	175mm x 70mm			
SPINDLE ASSEMBLY	400	8	Spindle	HTS	1	Ø1"		
	401	8	Spindle Body	FCMS	1	Ø1 1/2"		
	402	8	End Cap	FCMS	2	Ø1 1/2"		
	403	9	Spring Box	FCMS	1	Ø1 1/4"		
	404	9	Spring	Complete	6			XX
	405	9	Distance Piece	FCMS	1	Ø5/8"		
	406	9	Spindle Pulley	Aluminium	1	Ø2"		
	407	9	Spindle Nut	FCMS	1	Ø7/8"		
	408	NS	Spindle Bearings	E13 Magneto	2			XX
	409	9	Key	Key Steel	1	1/8" x 1/8"		
	410	9	Draw Bar	Silver Steel	1	Ø5/16"		
	411	9	Knob	FCMS	1	Ø1 1/4"		
	412	9	Arbor	FCMS	8	Ø1/2"		
	413	9	Clamp Washer	FCMS	8	Various		
	414	9	Clamp Washer	FCMS	8	Various		
	WORKHEAD ASSEMBLY	300	11	Workhead Base	Casting - Iron	1		
301		11	Rocking Lever	Casting - Iron	1			
302		11	Tilting Bracket	Casting - GM	1			
303 A		12	Rotating Table - Upper	FCMS	1	Ø80mm		
303 B		12	Rotating Table - Lower	FCMS	1	Ø80mm		
304		12	Thrust Washer	FCMS	1	Ø7/8"		
305		12	Stop Screw	FCMS	2	Ø5/8"		
306		12	Stop Nut	BMS	2	3/8" x 3/8"		
307		12	Stop	BMS	2	1" x 3/8"		
308		12	Differential Screw	FCMS	1	Ø1"		
309		13	Differential Nut	FCMS	1	Ø1 1/2"		
310		13	Collet	FCMS	1	Ø5/8"		
311		13	Pivot	FCMS	1	Ø5/8"		
311T		13	Pivot Arbor	FCMS	1	Ø5/8"		
312 A		13	Bed Bar - Short	PGMS	1	Ø5/8"		
312 B		13	Bed Bar - Long	PGMS	1	Ø5/8"		
314		13	Anti-Rotation Pin	Silver Steel	1	Ø3/32"		
316		13	Dust Seal	Felt	1	45mm x 3mm		
317		13	Dust Cover	Aluminium	1	Ø2"		
318		12	Spigot	FCMS	1	Ø1"		
319		12	Boss	BMS	1	1 1/4" x 1"		

	Item	SHEET	Description	Material	QTY	Bar Section	Remarks	Done
TOOL HOLDER ASSEMBLY	500	15	Tool Holder Body	Casting - iron	1			
	501	15	Backplate	FCMS	1	Ø80mm		
	502	15	Index Plate	FCMS	1	Ø80mm		
	503	15	Double Cotter	FCMS	1	Ø1/2"		
	504	15	Collet	FCMS	1	Ø1 1/2"		
	505	15	Nut	FCMS	1	Ø2"		
	506	16	Detent - Barrel	FCMS	1	Ø5/8"		
	507	16	Detent - Plunger	Silver Steel	1	Ø5/16"		
	508	16	Detent - Knob	FCMS	1	Ø5/8"		
	509	16	Detent - Parking	Silver Steel	1	Ø1/16"		
	510	NS	Detent - Spring	Complete	1			XX
	511	16	Rest - Tapered Pin	Silver Steel	1	Ø5/32"		
	512	16	Rest - Thimble	FCMS	1	Ø1/2"		
	513	16	Rest - Setting Bar	PGMS	1	Ø1/2"		
	514	16	Rest - Clamp Nut	FCMS	1	Ø1/2"		
	515	16	Rest - Zero Pin	Silver Steel	1	Ø1/8"		
	516	16	Tailstock Centre	Silver Steel	1	Ø3/8"		
	517	16	Tailstock	Casting - Iron	1			
518	16	MT2/1 Arbor	FCMS	1	Ø1"			
519	16	Setting Collar	FCMS	1	Ø2"			
SPIRALLING HEAD	600	18	Spiralling Head Body	Casting - Iron	1			
	601	17	Bar - Stop	BMS	1	1/2" x 3/8"		
	602	17	Stud	M5 Studding	2			
	603	17	Bar - Guide	BMS	1	1/2" x 3/16"		
	604	17	Pin - Guide	FCMS	2	Ø5/8"		
	605	18	Hob	FCMS	1	Ø1 1/4"		
	606	-17	Stud	M5 Studding	1			
	607	17	Stud Tip	Ø1/8" Rivet	1			
608	18	Face Cam	FCMS	1	Ø1 1/4"			
BALL HANDLES	A	19	Large Ball Handle	FCMS	10	Ø3/4"		
	A1	19	Washer	FCMS	10	Ø5/8"		
	A2	19	Lock Bolt	FCMS	10	Ø5/8"		
	B	19	Small Ball Handle	FCMS	7	Ø1/2"		
	B1	19	Washer	FCMS	7	Ø3/8"		
	B2	19	Lock Bolt	FCMS	7	Ø3/8"		
	C	19	Form Tool	Gauge Plate	1	1 1/4" x 5/16"		
	D1	19	Extension - A	FCMS	1	Ø7/8"		
	D2	19	Extension - B	FCMS	1	Ø5/8"		
	E1	19	Clamp Ring - A	FCMS	1	Ø1 1/4"		
E2	19	Clamp Ring - B	FCMS	1	Ø1"			
SETTING AIDS	701	20	Setting Pin - Long	Silver Steel	1	Ø5mm		
	702	20	Setting Pin - Short	Silver Steel	3	Ø5mm		
	703	20	"Y"Block	BMS	1	1 1/2" x 3/8"		
	704	20	Bridle	BMS	1	3/8" x 1/8"		
	705	20	Stud	M5 Studding	2	Ø5/8"		
	706	20	Column	Silver Steel	1	Ø1/4"		
	707	20	Nut	FCMS	2	Ø1/2"		
	708	20	Spindle Collet	FCMS	1	Ø1/2"		
	709	20	Spindle Parallel Arbor	FCMS	1	Ø5/8"		
	710	20	Radial Clearance Gauge	Gauge Plate	1	1" x 1/8"		
	720.1	21	Body	BMS	1	1" x 3/4"		
	720.2	21	Jack Screw	FCMS	1	Ø3/4"		
	720.3	21	Pin Anchor	BMS	1	3/8" x 1/8"		
	720.4	21	Double Cotter	FCMS	1	Ø1/2"		
720.5	21	Mic - Barrel	FCMS	1	Ø3/8"			
720.6	21	Mic - Screw	FCMS	1	Ø5/8"			
720.7	21	Mic - Thimble	FCMS	1	Ø5/8"			
720.8	21	Mic - Locknut	FCMS	1	Ø3/8"			
DIE GRINDING	DC 1*	24	Arbor	FCMS	1	Ø1/2"		
	DC 2*	24	Faceplate	FCMS	1	Ø2"		
	DC 3*	24	Bridle	BMS	1	1" x 3/8"		
	DC 4*	24	Clamp Screw	FCMS	2	Ø1/2"		
	DC 5*	24	Pump Centre	Silver Steel	1	Ø3/8"		
HACKSAW GRINDING	HJ 1*	24	Body	BMS	1	1 1/4" x 1/2"		
	HJ 2*	24	Fence	BMS	1	2" x 1/4"		
	HJ 3*	24	Clamp Screw	FCMS	1	Ø1/2"		
	HJ 4*	24	Arbor	FCMS	1	Ø1/2"		
	HJ 5*	24	Detent	BMS	1	1/2" x 1/8"		
*		= Material NOT included in kit.						
NS		= Not Shown on Drawings						
FCMS		= Free Cutting Mild Steel						
PGMS		= Pre-Ground Mild Steel						
PG/HTS		= Pre-Ground High Tensile Steel						
BMS		= Bright Mild Steel						