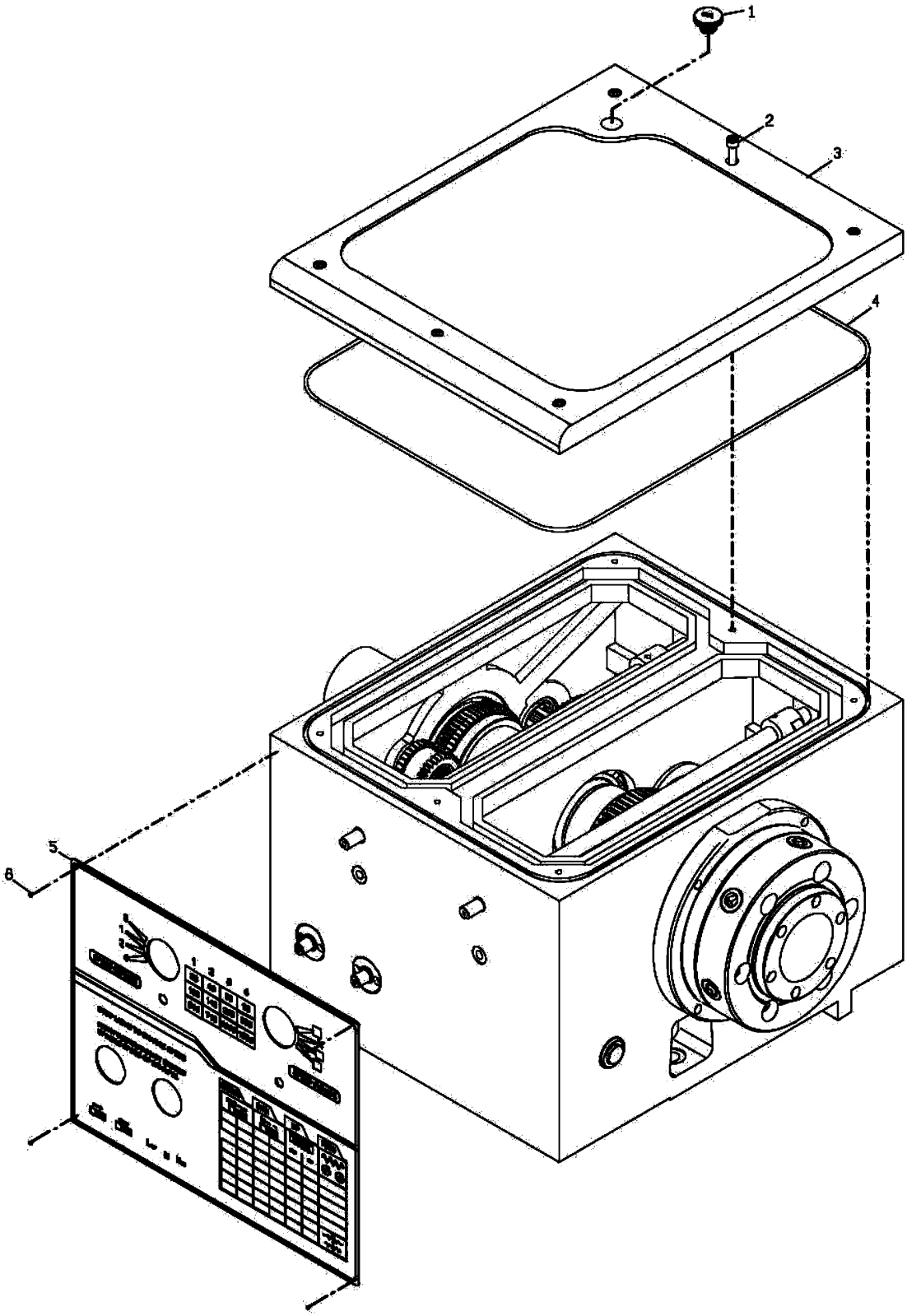
# JET GH-1640ZX | Stock JT1-3288

## Diagram A - Headstock Assembly I (1 of 4)

Original JET parts reference | Match model, voltage and serial-number notes

### Headstock Assembly I – Exploded View

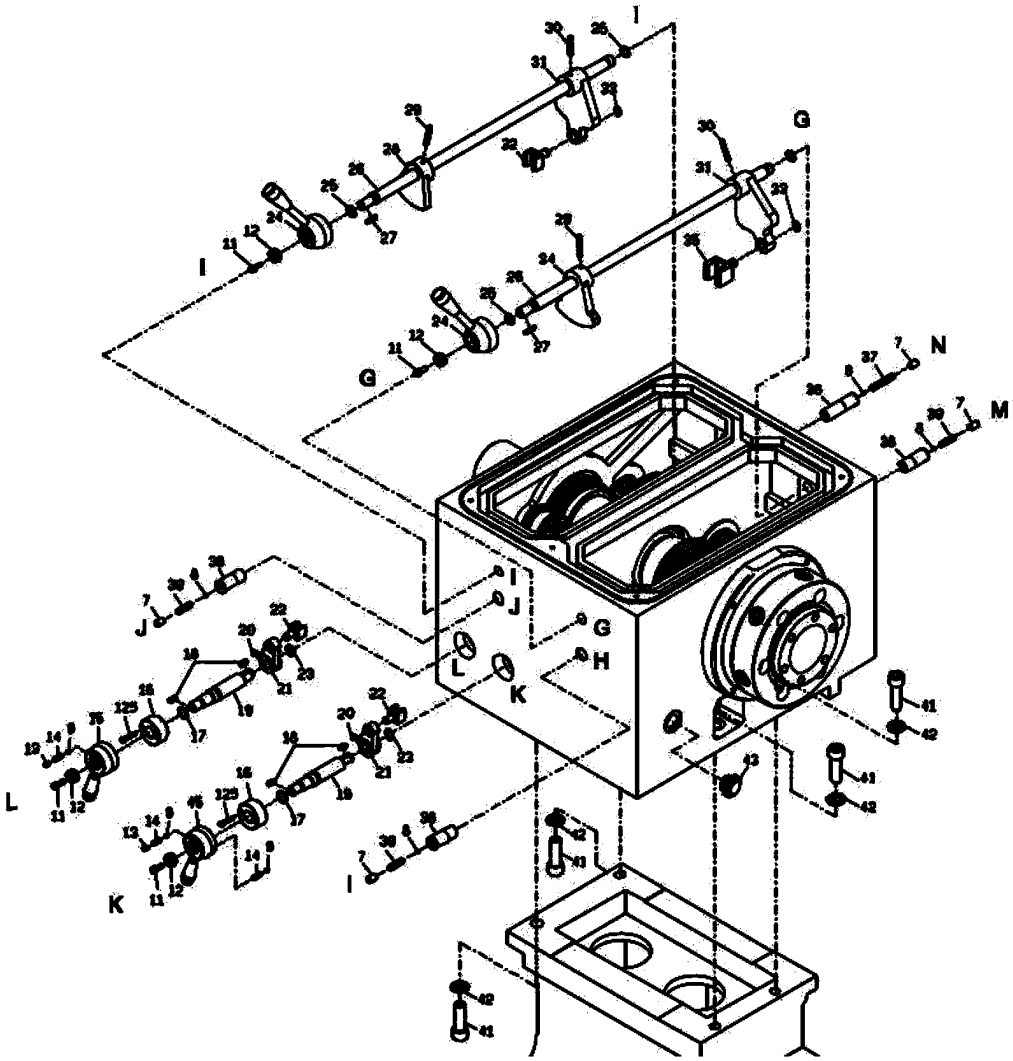


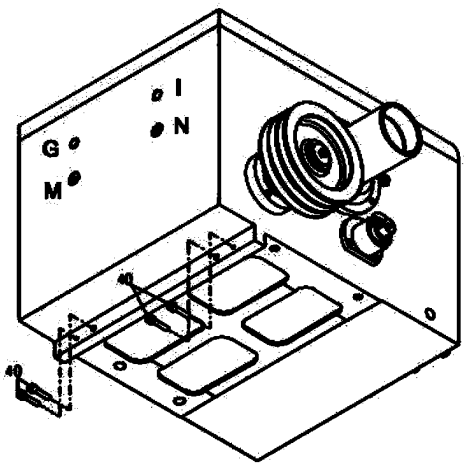

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## Diagram A - Headstock Assembly I (2 of 4)

Original JET parts reference | Match model, voltage and serial-number notes





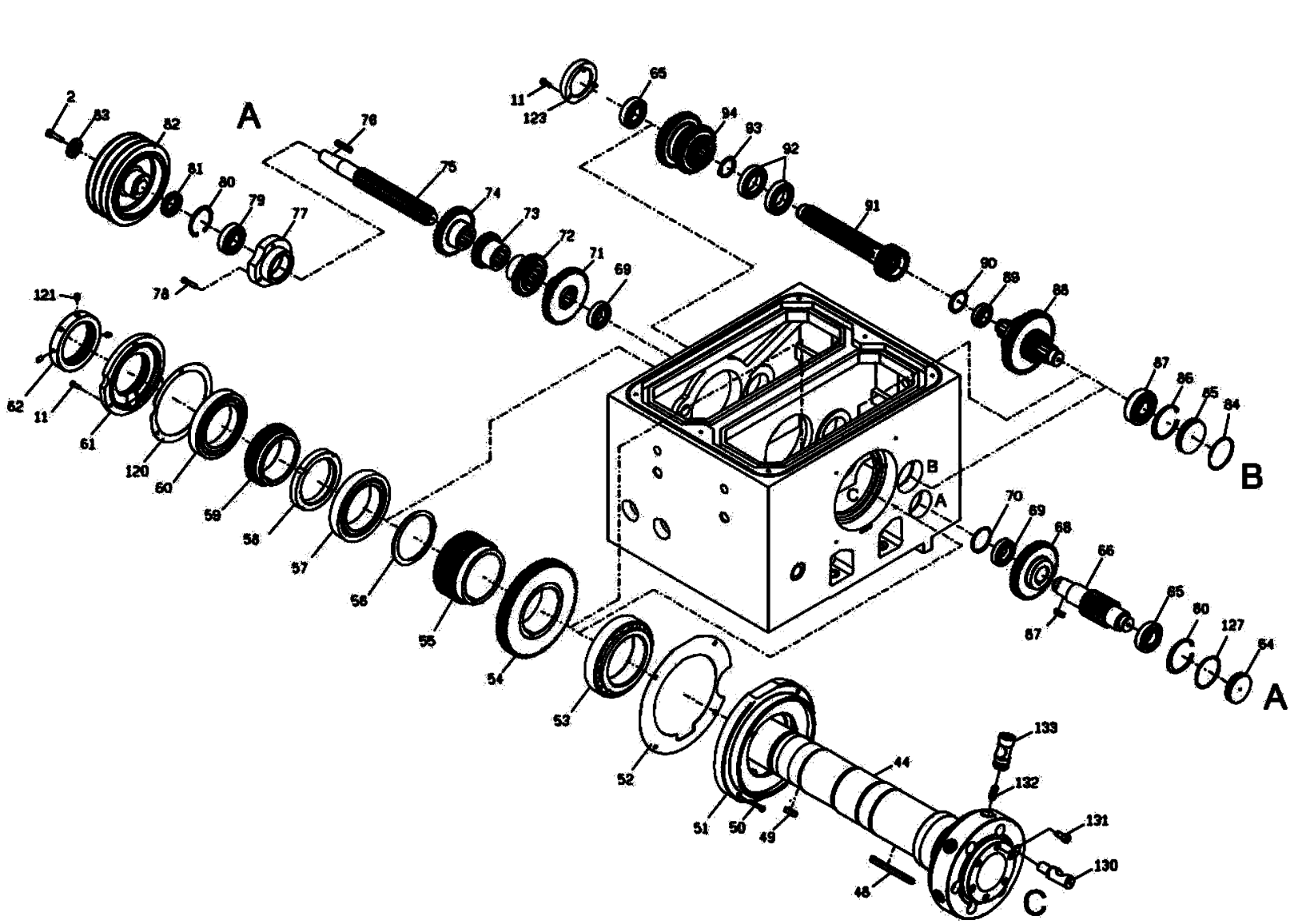
Headstock Assembly II – Exploded View

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## Diagram A - Headstock Assembly I (3 of 4)

Original JET parts reference | Match model, voltage and serial-number notes

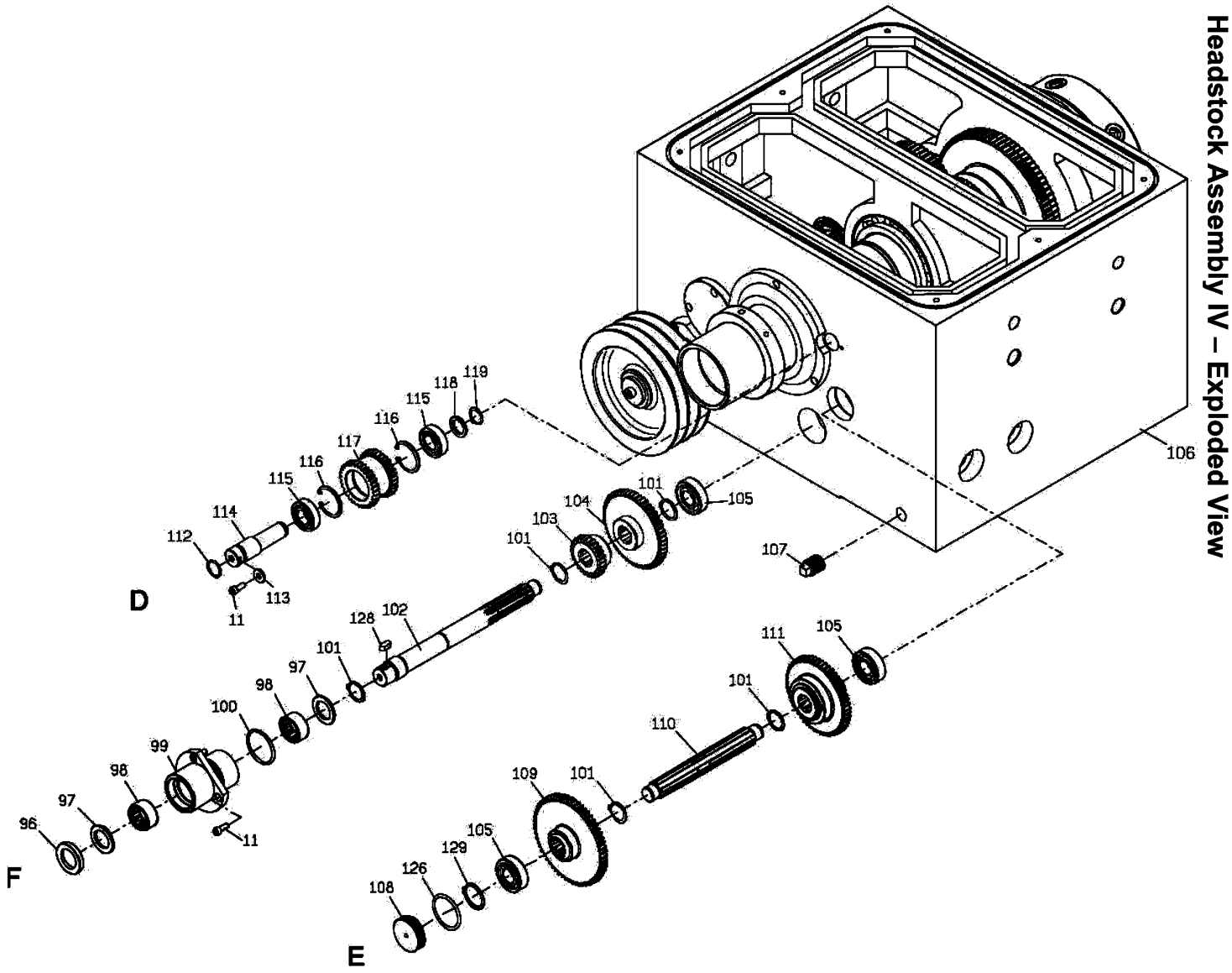



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# JET GH-1640ZX | Stock JT1-3288

## Diagram A - Headstock Assembly I (4 of 4)

Original JET parts reference | Match model, voltage and serial-number notes




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# JET GH-1640ZX | Stock JT1-3288

## Parts List A - Headstock Assembly I

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Oil Cover | 3/4" | 1 |
| 2 | ** | Hex. Socket Head Bolt | CAP 8x30 | 7 |
| 3 | ** | Headstock Cover | | 1 |
| 4 | ** | O Ring | Ø4x1840 | 1 |
| 5 | ** | Name Plate | For 16", 18", and 21"f | 1 |
| 6 | ** | Rivet | Ø2 | 4 |
| 7 | ** | Set Screw | SET 10x16 | 4 |
| 8 | ** | Steel Ball | Ø8.5 | 4 |
| 9 | ** | Steel Ball | Ø1/4" | 3 |
| 11 | ** | Hex. Socket Head Bolt | CAP 6x16 | 20 |
| 12 | ** | Washer | | 4 |
| 13 | ** | Set Screw | SET 8x8 | 2 |
| 14 | ** | Spring | | 3 |
| 15 | ** | Hub, Handle, Spring Pin (Ø3x24) | Assembly for replacement | 1 |
| 16 | ** | Collar | | 2 |
| 17 | ** | O Ring | P18 | 2 |
| 18 | ** | Key | 5x5x16 | 4 |
| 19 | ** | Shaft | | 2 |
| 20 | ** | Clip | E8 | 2 |
| 21 | ** | Lever | | 2 |
| 22 | ** | Fork | | 2 |
| 23 | ** | Clip | S15 | 2 |
| 24 | ** | Hub, Handle, Spring Pin (Ø3x25) | Assembly for replacement | 1 |
| 25 | ** | O Ring | P14 | 4 |
| 26 | ** | Rod | | 2 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List A - Headstock Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 27 | ** | Key | 5x5x22 | 2 |
| 28 | ** | Lever | | 1 |
| 29 | ** | Spring Pin | Ø6x40 | 2 |
| 30 | ** | Spring Pin | Ø6x36 | 2 |
| 31 | ** | Lever | | 2 |
| 32 | ** | Fork | | 1 |
| 33 | ** | Clip | S12 | 2 |
| 34 | ** | Lever | | 1 |
| 35 | ** | Lever | | 1 |
| 36 | ** | Bush | | 1 |
| 37 | ** | Spring | | 1 |
| 38 | ** | Bush | | 3 |
| 39 | ** | Spring | | 3 |
| 40 | ** | Hex. Socket Head Bolt | CAP 8x35 | 4 |
| 41 | ** | Hex. Socket Head Bolt | CAP 16x50 | 4 |
| 42 | ** | Washer | M16 | 4 |
| 43 | JT1-3064 | Oil Sight | 3/4" | 1 |
| 44 | ** | Spindle | | 1 |
| 45 | ** | Hub, Handle, Spring Pin (Ø3x25) | Assembly for replacement | 1 |
| 48 | ** | Key | 12x8x120 | 1 |
| 49 | ** | Key | 12x8x30 | 1 |
| 50 | ** | Hex. Socket Head Bolt | CAP 6x35 | 3 |
| 51 | ** | Front Bearing Cover | | 1 |
| 52 | ** | Packing F | | 1 |
| 53 | ** | Taper Roller Bearing | 32024XU | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List A - Headstock Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 54 | ** | Gear | 82T | 1 |
| 55 | ** | Gear | 53T | 1 |
| 56 | ** | Clip | S105 | 1 |
| 57 | ** | Taper Roller Bearing | 32020X | 1 |
| 58 | ** | Nut | YSR100 | 1 |
| 59 | ** | Gear | 62T | 1 |
| 60 | ** | Ball Bearing | 6019 | 1 |
| 61 | ** | Outside Cover | | 1 |
| 62 | ** | Balance Ring | | 1 |
| 63 | ** | Set Screw | SET 6x8 | 2 |
| 64 | ** | Cover | | 1 |
| 65 | ** | Ball Bearing | 6206 | 2 |
| 66 | ** | Gear Shaft | 20T | 1 |
| 67 | ** | Key | 8x7x25L | 1 |
| 68 | ** | Gear | 47T | 1 |
| 69 | ** | Ball Bearing | 6006 | 3 |
| 70 | ** | Collar | | 1 |
| 71 | ** | Gear | 46T | 1 |
| 72 | ** | Gear | 33T | 1 |
| 73 | ** | Gear | 27T | 1 |
| 74 | ** | Gear | 39T | 1 |
| 75 | ** | Shaft | | 1 |
| 76 | ** | Key | 7x7x45 | 1 |
| 77 | ** | Flanged Bearing | | 1 |
| 78 | ** | Hex. Socket Head Bolt | CAP 6x30 | 3 |
| 79 | ** | Ball Bearing | 5206S | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List A - Headstock Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 80 | ** | Clip | R62 | 2 |
| 81 | ** | Oil Seal | TC306212 | 1 |
| 82 | ** | Pulley | | 1 |
| 83 | ** | Washer | | 1 |
| 84 | ** | O Ring | G65 | 1 |
| 85 | ** | Plug | | 1 |
| 86 | ** | Clip | R72 | 1 |
| 87 | ** | Ball Bearing | 6306 | 1 |
| 88 | ** | Gear(23T),(25T/52T), Key (8x7x22), Clip(S50), Shaft | Assembly for replacement | 1 |
| 89 | ** | Double Law Deep Groove Ball Bearing | 25BD4715DUL16 | 1 |
| 90 | ** | Washer | | 1 |
| 91 | ** | Gear Shaft | 25T | 1 |
| 92 | ** | Ball Bearing | 6008 | 2 |
| 93 | ** | Clip | S38 | 1 |
| 94 | ** | Gear(26T),(39T),(45T),(33T), Key (8x7x70), Clip(S55) | Assembly for replacement | 1 |
| 96 | ** | Oil Seal | TC28x44x7 | 1 |
| 97 | ** | Washer | | 2 |
| 98 | ** | Needle Bearing | RNA6904 | 2 |
| 99 | ** | Flanged Bearing | | 1 |
| 100 | ** | O Ring | P44 | 1 |
| 101 | ** | Clip | S25 | 5 |
| 102 | ** | Shaft | | 1 |
| 103 | ** | Gear | 27T | 1 |
| 104 | ** | Gear | 54T | 1 |
| 105 | ** | Ball Bearing | 6204 | 3 |

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## Parts List A - Headstock Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 106 | ** | Head Stock | For 16", 18", and 21" | 1 |
| 107 | ** | Square Head Plug | PT 1/2" | 1 |
| 108 | ** | Cover | | 1 |
| 109 | ** | Gear | 62T | 1 |
| 110 | ** | Shaft | | 1 |
| 111 | ** | Gear(27T),(54T), Key (7x7x20), Clip(S45) | Assembly for replacement | 1 |
| 112 | ** | O Ring | P21 | 1 |
| 113 | ** | Washer | | 1 |
| 114 | ** | Shaft | | 1 |
| 115 | ** | Ball Bearing | 6004 | 2 |
| 116 | ** | Clip | R42 | 2 |
| 117 | ** | Gear | 31T | 1 |
| 118 | ** | Washer | | 1 |
| 119 | ** | Clip | S20 | 1 |
| 120 | ** | Packing | | 1 |
| 121 | ** | Set Screw | SET 8x12 | 3 |
| 123 | ** | Cover | | 1 |
| 125 | ** | Hex. Scoket Head Bolt | CAP 5x25 | 4 |
| 126 | ** | O Ring | P41 | 1 |
| 127 | ** | O Ring | G55 | 1 |
| 128 | ** | Key | 7x7x16 | 1 |
| 129 | ** | Clip | R47 | 1 |
| 130 | ** | Cams | | 6 |
| 131 | ** | Set Screw | | 6 |
| 132 | ** | Spring | | 6 |
| 133 | ** | Cams | | 6 |

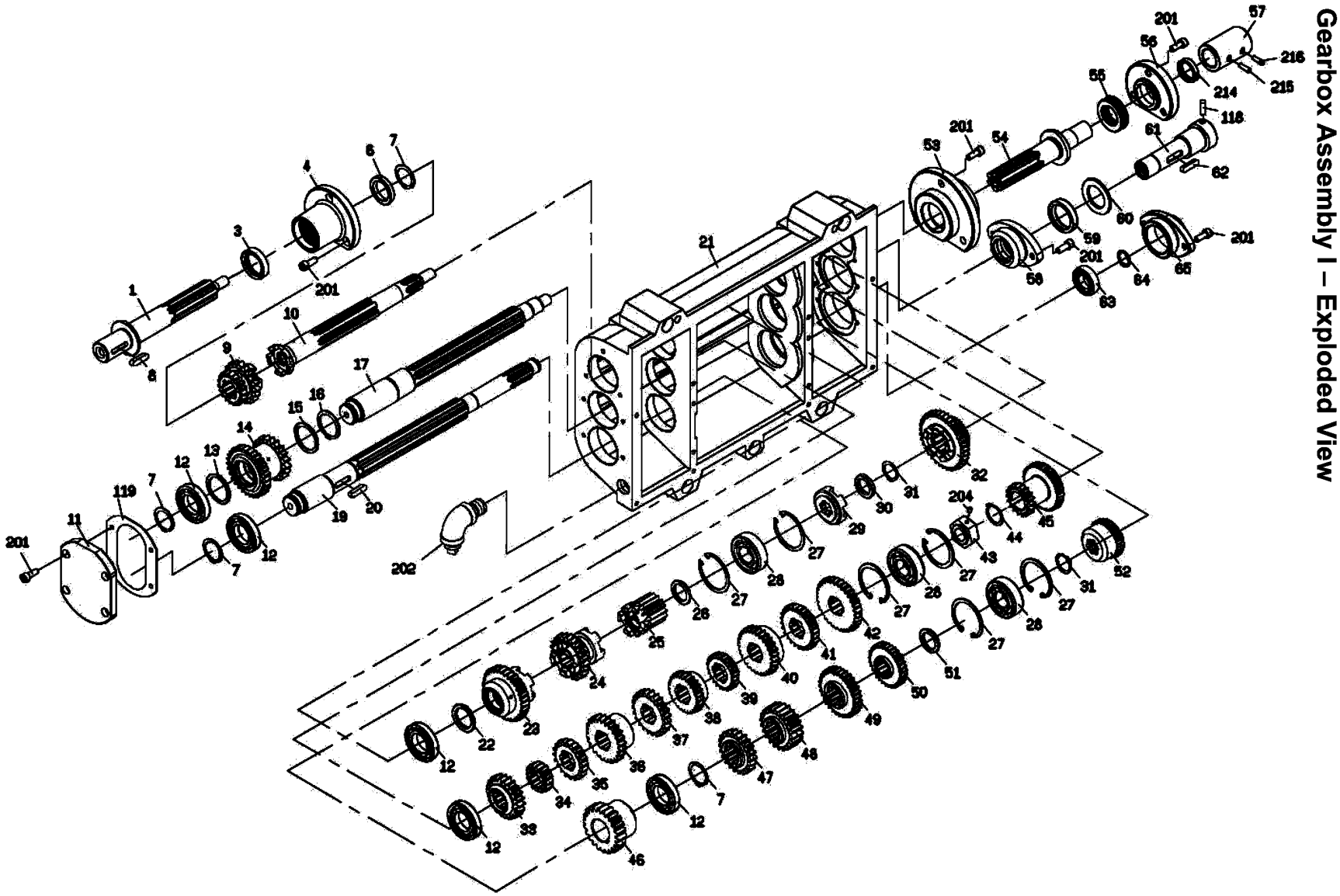
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## Diagram B - Gearbox Assembly I (1 of 2)

Original JET parts reference | Match model, voltage and serial-number notes

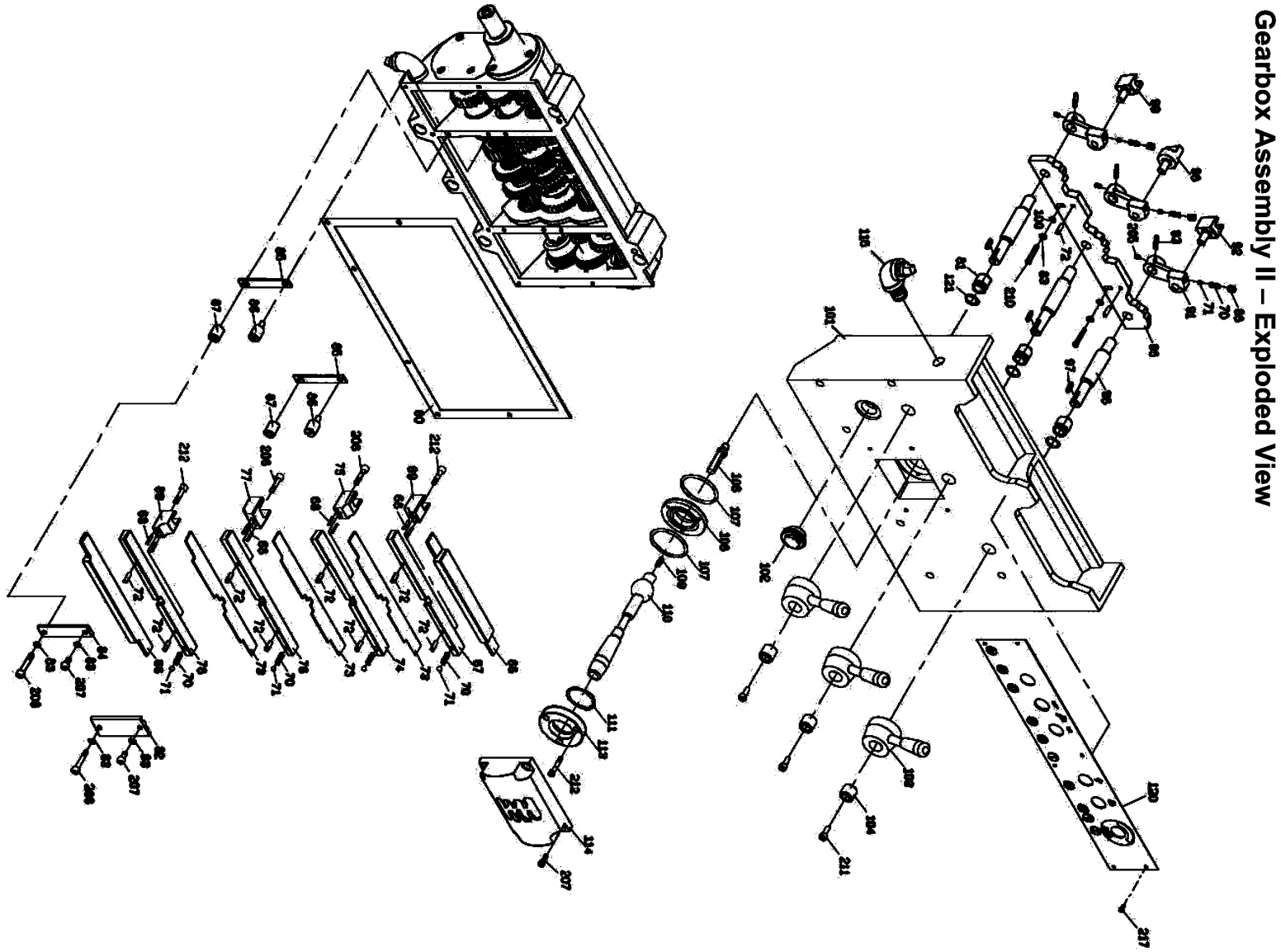



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## Diagram B - Gearbox Assembly I (2 of 2)

Original JET parts reference | Match model, voltage and serial-number notes




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# JET GH-1640ZX | Stock JT1-3288

## Parts List B - Gearbox Assembly I

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Shaft | | 1 |
| 3 | ** | Oil Seal | 25x37x08 | 1 |
| 4 | ** | Bearing(TAF25/20), Flanged Bearing | Assembly for | 1 |
| 6 | ** | Washer | | 1 |
| 7 | ** | Clip | S25 | 4 |
| 8 | ** | Key | 7x7x30 | 1 |
| 9 | ** | Gear | 19T/19T | 1 |
| 10 | ** | Shaft | | 1 |
| 11 | ** | Cover | | 1 |
| 12 | ** | Bearing | 16005 | 5 |
| 13 | ** | Washer | | 1 |
| 14 | ** | Gear | 30T/20T | 1 |
| 15 | ** | Washer | | 1 |
| 16 | ** | Clip | S30 | 1 |
| 17 | ** | Shaft | | 1 |
| 19 | ** | Shaft | | 1 |
| 20 | ** | Key | 6x6x25 | 1 |
| 21 | ** | Gearbox Body | | 1 |
| 22 | ** | Washer | | 1 |
| 23 | ** | Gear | 32T | 1 |
| 24 | ** | Gear | 23T | 1 |
| 25 | ** | Gear | 16T | 1 |
| 26 | ** | Washer | | 1 |
| 27 | ** | Clip | R47 | 6 |
| 28 | ** | Bearing | 6204 | 3 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List B - Gearbox Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 29 | ** | Clutch | | 1 |
| 30 | ** | Washer | | 1 |
| 31 | ** | Clip | S20 | 2 |
| 32 | ** | Gear | 35T | 1 |
| 33 | ** | Gear | 22T | 1 |
| 34 | ** | Gear | 16T | 1 |
| 35 | ** | Gear | 20T | 1 |
| 36 | ** | Gear | 24T | 1 |
| 37 | ** | Gear | 23T | 1 |
| 38 | ** | Gear | 27T | 1 |
| 39 | ** | Gear | 24T | 1 |
| 40 | ** | Gear | 28T | 1 |
| 41 | ** | Gear | 26T | 1 |
| 42 | ** | Gear | 32T | 1 |
| 43 | ** | Nut | | 1 |
| 44 | ** | Clip | S22 | 1 |
| 45 | ** | Gear | 18T/45T | 1 |
| 46 | ** | Gear | 22T | 1 |
| 47 | ** | Gear | 22T | 1 |
| 48 | ** | Gear | 22T | 1 |
| 49 | ** | Gear | 33T | 1 |
| 50 | ** | Gear | 22T | 1 |
| 51 | ** | Washer | | 1 |
| 52 | ** | Gear | 36T | 1 |
| 53 | ** | Flanged Bearing | | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List B - Gearbox Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 54 | ** | Shaft | | 1 |
| 55 | ** | Bearing | 51105 | 1 |
| 56 | ** | Flanged Bearing | | 1 |
| 57 | ** | Sleeve | | 1 |
| 58 | ** | Flanged Bearing | | 1 |
| 59 | ** | Oil Seal | 28x40x05 | 1 |
| 60 | ** | Washer | | 1 |
| 61 | ** | Shaft | | 1 |
| 62 | ** | Key | 5x5x35 | 1 |
| 63 | ** | Bearing | 16003 | 1 |
| 64 | ** | Clip | S17 | 1 |
| 65 | ** | Flanged Bearing | | 1 |
| 66 | ** | Upper Plate | | 2 |
| 67 | ** | Fort Support | | 1 |
| 68 | ** | Spring Pin | Ø3×16 | 8 |
| 69 | ** | Fork | | 2 |
| 70 | ** | Spring | Ø4×19 | 7 |
| 71 | ** | Steel Ball | 1/4" | 7 |
| 72 | ** | Spring Pin | Ø5x16 | 10 |
| 73 | ** | Partition | | 3 |
| 74 | ** | Fort Support | | 1 |
| 75 | ** | Fork | | 1 |
| 76 | ** | Fort Support | | 1 |
| 77 | ** | Fork | | 1 |
| 78 | ** | Fort Support | | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List B - Gearbox Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 80 | ** | Seal | | 1 |
| 81 | ** | Spacer | | 3 |
| 82 | ** | Reverse-Stop | | 1 |
| 83 | ** | Spring Washer | M6 | 6 |
| 84 | ** | Shoulder Plate | | 1 |
| 85 | ** | Fixed Plate | | 2 |
| 86 | ** | Partition Nut | | 2 |
| 87 | ** | Spacer | | 2 |
| 88 | ** | Set Screw | SET 8x8 | 3 |
| 91 | ** | Lever | | 3 |
| 92 | ** | Fork | | 1 |
| 93 | ** | Spring Pin | 4x24 | 3 |
| 95 | ** | Selector Bar | | 1 |
| 96 | ** | Shaft | | 3 |
| 97 | ** | Key | 4x4x15 | 3 |
| 98 | ** | Fork | | 1 |
| 99 | ** | Fork | | 1 |
| 100 | ** | Washer | M6 | 2 |
| 101 | ** | Gearbox Cover | | 1 |
| 102 | JT1-3064 | Oil Sight | 3/4" | 1 |
| 103 | ** | Handle & Hub | Assembly for | 1 |
| 104 | ** | Washer | | 3 |
| 106 | ** | Selector Lever | | 1 |
| 107 | ** | O Ring | G40 | 2 |
| 108 | ** | Selector Lever Support | | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List B - Gearbox Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 109 | ** | Spring | 9x38 | 1 |
| 110 | ** | Selector Lever | | 1 |
| 111 | ** | O Ring | G30 | 1 |
| 113 | ** | Selector Lever Cover | | 1 |
| 114 | ** | Specifying Base | | 1 |
| 115 | ** | Square Head Plug(3/4"), Elbow(3/4"), Nipple(3/4"x1") | Assembly for replacement | 1 |
| 118 | ** | Pin | Ø6×36 | 1 |
| 119 | ** | Seal | | 1 |
| 120 | ** | Plate | | 1 |
| 121 | ** | O Ring | P16 | 3 |
| 201 | ** | Hex. Socket Head Bolt | CAP 6x16 | 17 |
| 202 | ** | Square Head Plug(1/2"), Elbow(1/2"), Nipple(1/2"x1") | Assembly for replacement | 1 |
| 204 | ** | Set Screw | SET 5x6 | 1 |
| 205 | ** | Set Screw | SET 6x6 | 3 |
| 206 | ** | Hex. Socket Head Bolt | CAP 5x20 | 2 |
| 207 | ** | Hex. Socket Head Bolt | CAP 6x16 | 9 |
| 208 | ** | Hex. Socket Head Bolt | CAP 6x40 | 2 |
| 209 | ** | Hex. Socket Head Bolt | CAP 6x25 | 3 |
| 210 | ** | Hex. Socket Head Bolt | CAP 6x20 | 2 |
| 211 | ** | Hex. Socket Head Bolt | CAP 6x10 | 3 |
| 212 | ** | Hex. Socket Head Bolt | CAP 5x25 | 3 |
| 214 | ** | Oil Seal | 24x35x08 | 1 |
| 215 | ** | Pin | #4×32 | 1 |
| 216 | JT1-3075 | Pin | #4×32(Copper) | 1 |
| 217 | ** | Dome Hexagon Screw | M4x8 | 6 |

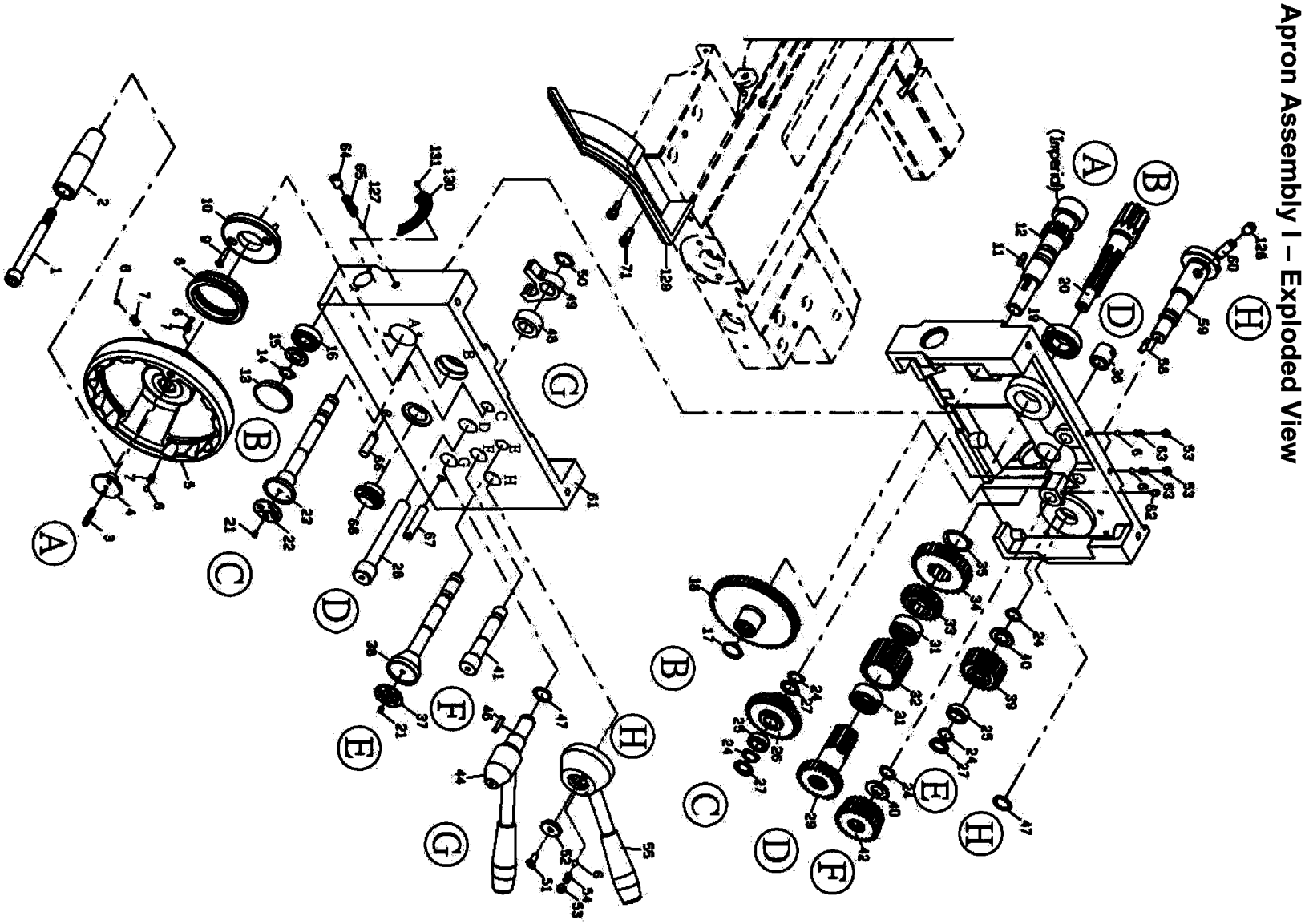
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## Diagram C - Apron Assembly I (1 of 2)

Original JET parts reference | Match model, voltage and serial-number notes

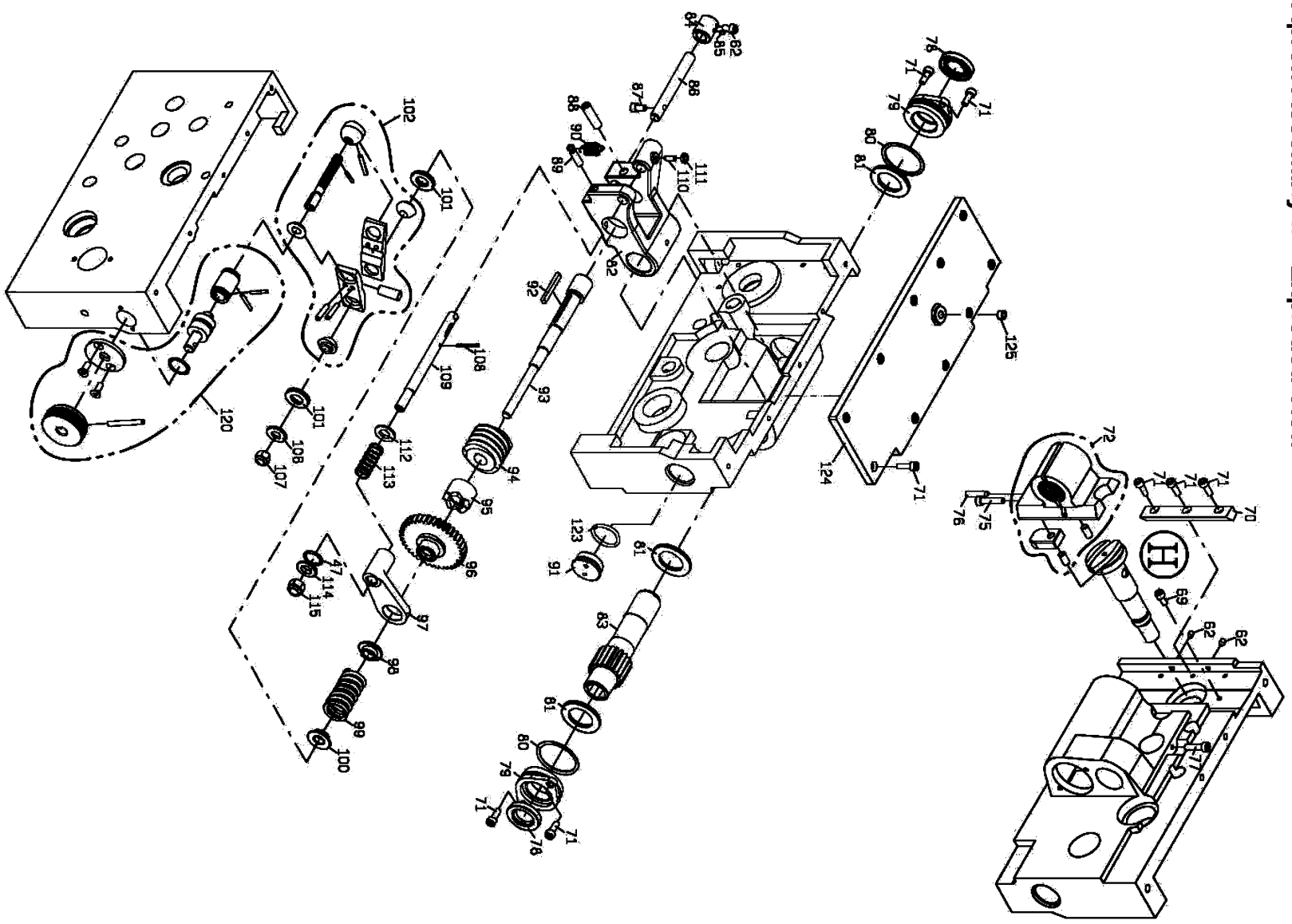



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# JET GH-1640ZX | Stock JT1-3288

## Diagram C - Apron Assembly I (2 of 2)

Original JET parts reference | Match model, voltage and serial-number notes




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# JET GH-1640ZX | Stock JT1-3288

## Parts List C - Apron Assembly I

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Screw | | 1 |
| 2 | ** | Handle | | 1 |
| 3 | ** | Set Screw | SET 6×25 | 1 |
| 4 | ** | Bolt | | 1 |
| 5 | ** | Hand Wheell | Left | 1 |
| 6 | ** | Steel Ball | 1/4" | 6 |
| 7 | ** | Spring | | 3 |
| 8 | ** | Index Ring | | 1 |
| 9 | ** | Flat Hexagon Screw | 5×12 | 2 |
| 10 | ** | Shaft Liner | | 1 |
| 11 | ** | Woodruff Key | Ø5×19 | 1 |
| 12 | ** | Gear Shaft | | 1 |
| 13 | ** | Plug | | 1 |
| 14 | ** | Snap Ring | S15 | 1 |
| 15 | ** | Collar | | 1 |
| 16 | ** | Ball Bearing | 6202LR | 1 |
| 17 | ** | Snap Ring | S22 | 1 |
| 18 | ** | Gear | 56T | 1 |
| 19 | ** | Ball Bearing | 6005LU | 1 |
| 20 | ** | Gear Shaft | | 1 |
| 21 | ** | Rivet | Ø2.8×10 | 2 |
| 22 | ** | Name Plate | | 1 |
| 23 | ** | Shaft | | 1 |
| 24 | ** | Snap Ring | S16 | 5 |
| 25 | ** | Collar | IMPERIAL | 1 |
| 26 | ** | Gear | 15T/33T | 1 |
| 27 | ** | Collar | | 3 |
| 28 | ** | Shaft Needle Bearing & Gear Shaft | | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List C - Apron Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 29 | ** | Assembly | | 1 |
| 31 | ** | Needle Bearing | TLA3016 | 2 |
| 32 | ** | Gear | 24T | 1 |
| 33 | ** | Gear | 24T | 1 |
| 34 | ** | Worm Wheel | | 1 |
| 35 | ** | Snap Ring | S30 | 1 |
| 36 | ** | Collar | | 1 |
| 37 | ** | Name Plate | | 1 |
| 38 | ** | Shaft | | 1 |
| 39 | ** | Gear | 24T | 1 |
| 40 | ** | Collar | | 2 |
| 41 | ** | Shaft | | 1 |
| 42 | ** | Gear | 24T/26T | 1 |
| 44 | ** | Spring Pin, Handle, Sleeve Assembly | | 1 |
| 46 | ** | Key | 4×4×25 | 1 |
| 47 | ** | O Ring | P18 | 3 |
| 48 | ** | Pad | | 1 |
| 49 | ** | Elasticity Pole | | 1 |
| 50 | ** | Snap Ring | S18 | 1 |
| 51 | ** | Flat Hexagon Screw | M6×16 | 1 |
| 52 | ** | Washer | | 1 |
| 53 | ** | Set Screw | SET8×8 | 3 |
| 54 | ** | Spring | | 2 |
| 55 | ** | Lead Nut Lever, Handle , Spring Pin | Assembly for replacement | 1 |
| 58 | ** | Key | 5x5×20 | 1 |
| 59 | ** | Cam Shaft | | 1 |
| 60 | ** | Set Screw | SET 10×40 | 1 |
| 61 | ** | Appron | | 1 |
| 62 | ** | Set Screw | SET 6×8 | 4 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List C - Apron Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 63 | ** | Spring | | 2 |
| 64 | ** | Set Screw | SET 10×16 | 1 |
| 65 | ** | Spring | | 2 |
| 66 | ** | Pin | | 1 |
| 67 | ** | Pin | | 1 |
| 68 | JT1-3064 | Oil Sight | 3/4" | 1 |
| 69 | ** | Hex. Socket Head Bolt | CAP 6×12 | 1 |
| 70 | ** | Adjust Plate | | 1 |
| 71 | ** | Hex. Socket Head Bolt | CAP 6×16 | 19 |
| 72 | ** | Pin, Slide Plate, Half Nut | Assembly for replacement | 1 |
| 75 | ** | Hex. Socket Head Bolt | CAP 6×30 | 1 |
| 76 | ** | Set Screw | SET 6×30 | 1 |
| 77 | ** | Hex. Socket Head Bolt | CAP 6×25 | 1 |
| 78 | ** | Oil Seal | 30×40×5 | 2 |
| 79 | ** | Sleeve | | 2 |
| 80 | ** | O Ring | G45 | 2 |
| 81 | ** | Thrust Bearing | NTB3047/AS2 | 3 |
| 82 | ** | Bracket | | 1 |
| 83 | ** | Pinion | | 1 |
| 84 | ** | Spacer | | 1 |
| 85 | ** | Spring Pin | Ø4×20 | 1 |
| 86 | ** | Pin | | 1 |
| 87 | ** | Hex. Socket Head Bolt | CAP 5×25 | 1 |
| 88 | ** | Pin | | 1 |
| 89 | ** | Pin | | 1 |
| 90 | ** | Spring | | 1 |
| 91 | ** | Nut | | 1 |
| 92 | ** | Key | 5×5×46 | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List C - Apron Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 93 | ** | Shaft | | 1 |
| 94 | ** | Worm | | 1 |
| 95 | ** | Clutch | | 1 |
| 96 | ** | Clutch Gear | | 1 |
| 97 | ** | Lever Arm | | 1 |
| 98 | ** | Washer | | 1 |
| 99 | ** | Spring | | 1 |
| 100 | ** | Washer | | 1 |
| 101 | ** | Thrust Bearing | NTB1528/AS2 | 2 |
| 102 | ** | Flanged Bearing Assembly | Assembly for replacement | 1 |
| 106 | ** | Washer | | 1 |
| 107 | ** | Nylon Jam Nut | M10 | 1 |
| 108 | ** | Spring Pin | Ø4x24 | 1 |
| 109 | ** | Trip Rod | | 1 |
| 110 | ** | Set Screw | SET 6x16 | 1 |
| 111 | ** | Nylon Jam Nut | M6 | 1 |
| 112 | ** | Washer | | 1 |
| 113 | ** | Spring | | 1 |
| 114 | ** | Washer | | 1 |
| 115 | ** | Nylon Jam Nut | M12 | 1 |
| 120 | ** | Flat Hexagon Screw Assembly | Assembly for replacement | 1 |
| 123 | ** | O Ring | P21 | 1 |
| 124 | ** | Plate | | 1 |
| 125 | ** | Hex. Socket Head Plug | PT1/4" | 1 |
| 127 | ** | Steel Ball | 3/8" | 1 |
| 128 | ** | Set Screw | SET 10×10 | 2 |
| 129 | ** | Handle Wheel Guard | | 1 |
| 130 | ** | Plate | | 1 |
| 131 | ** | Rivet | Ø2 | 3 |

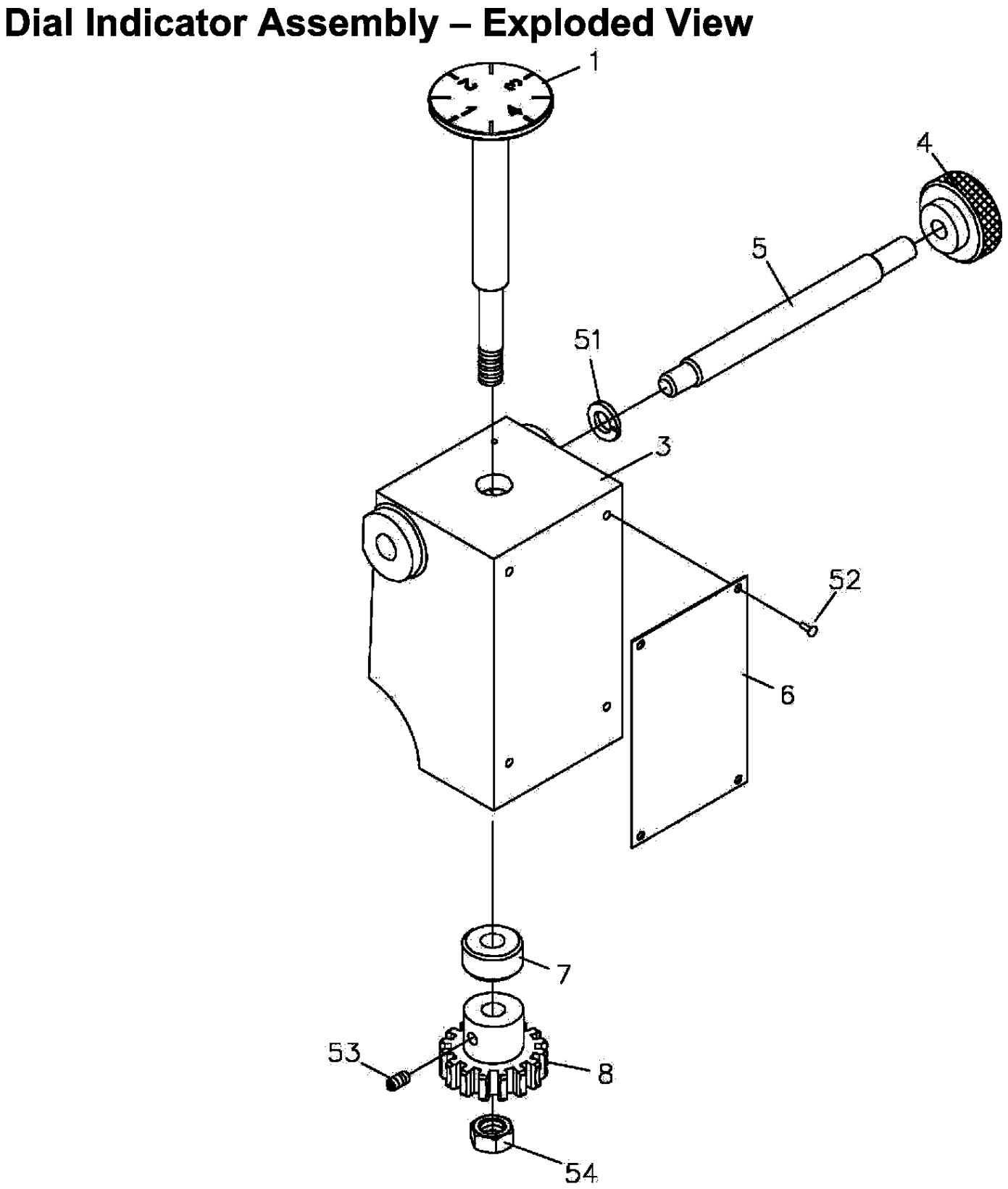
** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

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## Diagram D - Dial Indicator Assembly

Original JET parts reference | Match model, voltage and serial-number notes




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# JET GH-1640ZX | Stock JT1-3288

## Parts List D - Dial Indicator Assembly

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Gear Pivot | | 1 |
| 3 | ** | Body | | 1 |
| 4 | ** | Nut | | 1 |
| 5 | ** | Stud | | 1 |
| 6 | ** | Threading Plate | | 1 |
| 7 | ** | Spacer | | 1 |
| 8 | ** | Gear | 16T | 1 |
| 51 | ** | Spring Washer | M10 | 1 |
| 52 | ** | Rivet | Ø2 | 4 |
| 53 | ** | Set Screw | M6x6L | 1 |
| 54 | ** | Nylon Jam Nut | M8 | 1 |

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

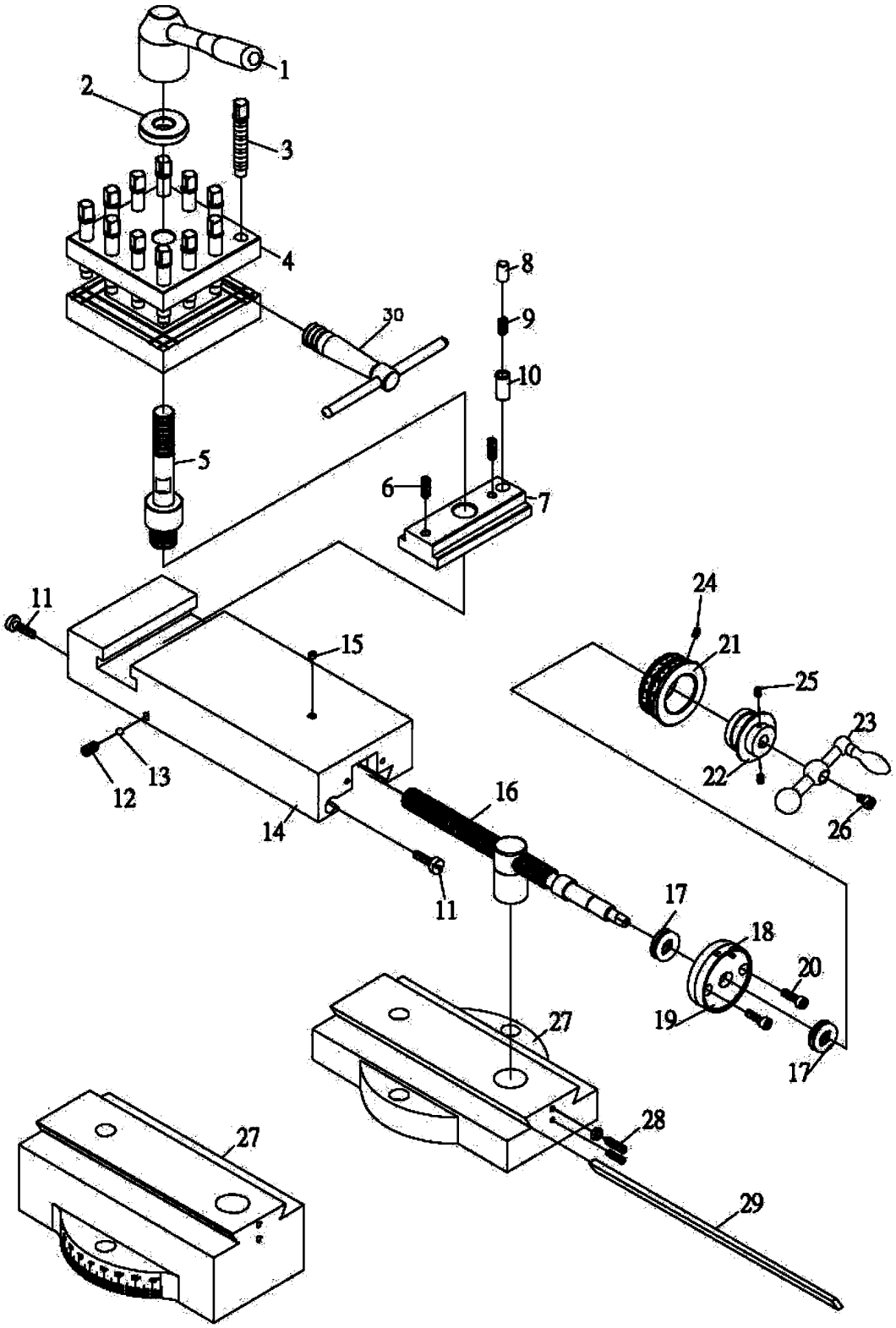
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## Diagram E - -Way Tool Post Assembly

Original JET parts reference | Match model, voltage and serial-number notes

### 4-Way Tool Post Assembly – Exploded View




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# JET GH-1640ZX | Stock JT1-3288

## Parts List E - -Way Tool Post Assembly

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Handle & Turret Nut | Assembly for replacement | 1 |
| 2 | ** | Collar | | 1 |
| 3 | ** | Bolt | | 12 |
| 4 | ** | Turret Body | | 1 |
| 5 | ** | Turret Shaft | | 1 |
| 6 | ** | Set Screw | SET 8x20 | 2 |
| 7 | ** | Nut | | 1 |
| 8 | ** | Pin | | 1 |
| 9 | ** | Spring | | 1 |
| 10 | ** | Bush | | 1 |
| 11 | ** | Screw | | 2 |
| 12 | ** | Set Screw | SET 8x12 | 1 |
| 13 | ** | Steel Ball | 1/4" | 1 |
| 14 | ** | Solid Topslide | | 1 |
| 15 | ** | Oil Ball | 1/4" | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List E - -Way Tool Post Assembly (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 16 | ** | Nut & Screw | Assembly for replacement | 1 |
| 17 | ** | Trust Baaring | 51102 | 2 |
| 18 | ** | Curve Pilot | | 1 |
| 19 | ** | Keep Assy | | 1 |
| 20 | ** | Hex. Socket Head Bolt | CAP 6x20 | 2 |
| 21 | ** | Dial Ring | | 1 |
| 22 | ** | Bushs | | 1 |
| 23 | ** | Handwheel And Handle | | 1 |
| 24 | ** | Set Screw | SET 5x8 | 1 |
| 25 | ** | Set Screw | SET 5x6 | 1 |
| 26 | ** | Hex. Socket Head Bolt | CAP 6x16 | 1 |
| 27 | ** | Swivel | | 1 |
| 28 | ** | Set Screw | CAP 6x20 | 2 |
| 29 | ** | Gib | | 1 |
| 30 | ** | T Wrench | | 1 |

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

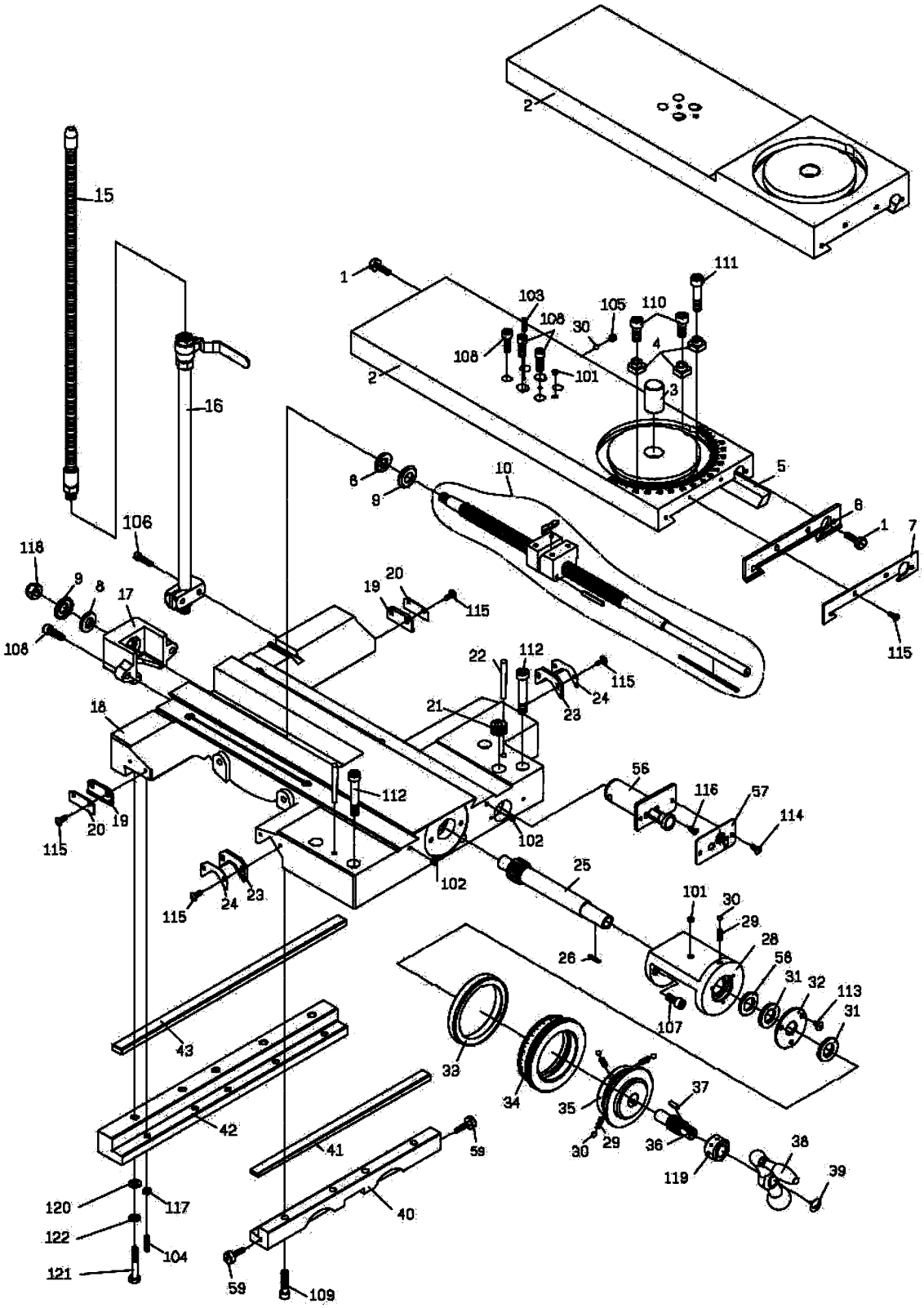
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# JET GH-1640ZX | Stock JT1-3288

## Diagram F - Saddles Assembly I (1 of 2)

Original JET parts reference | Match model, voltage and serial-number notes

### Saddles Assembly I – Exploded View



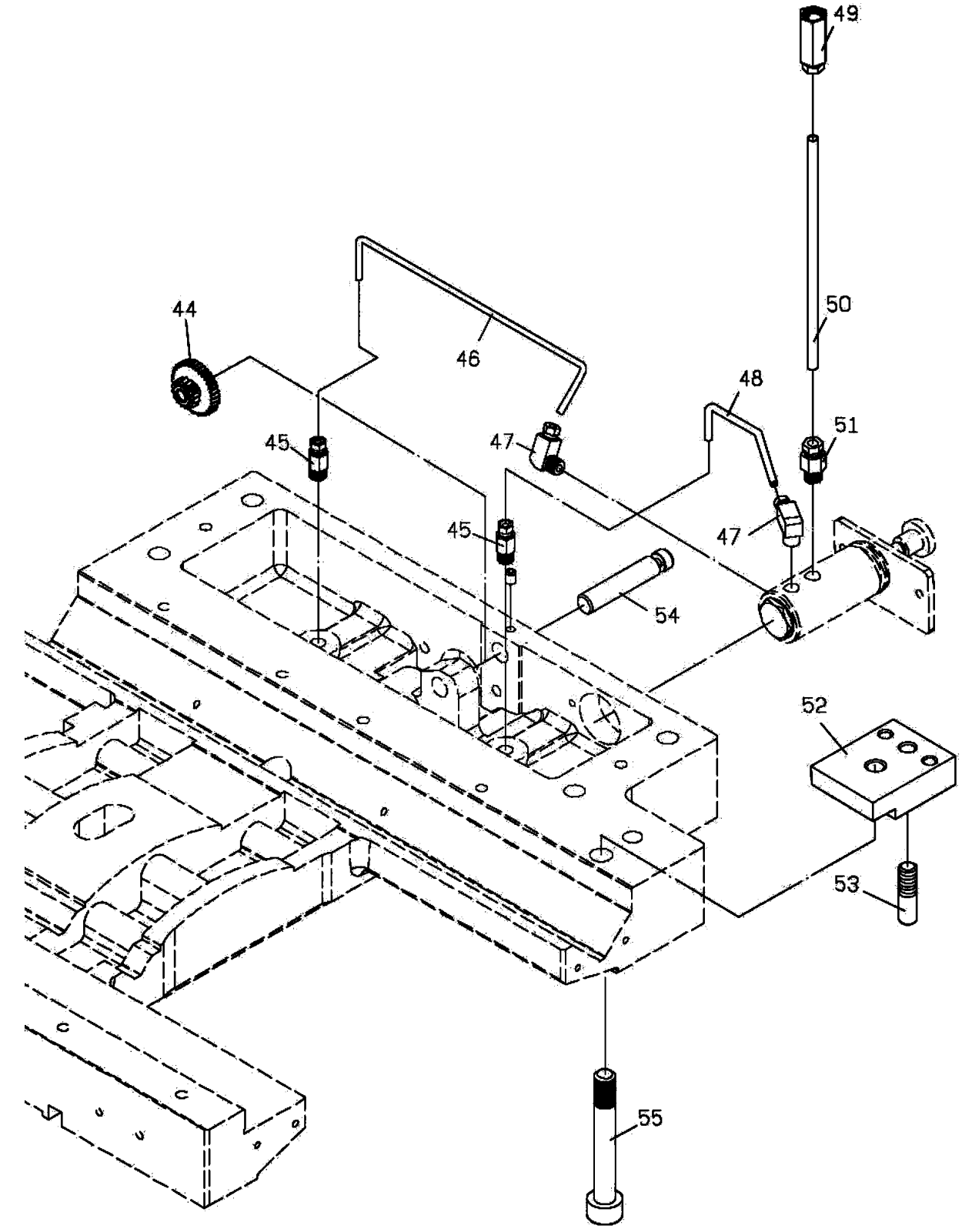

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# JET GH-1640ZX | Stock JT1-3288

## Diagram F - Saddles Assembly I (2 of 2)

Original JET parts reference | Match model, voltage and serial-number notes

### Saddles Assembly II – Exploded View




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# JET GH-1640ZX | Stock JT1-3288

## Parts List F - Saddles Assembly I

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Adjust Screw | Ø19 | 2 |
| 2 | ** | Cross Slide | For 16", 18” and 21” | 1 |
| 3 | ** | Pivot | Ø25x35 | 1 |
| 4 | ** | T Bolt | | 3 |
| 5 | ** | Gib-X | | 1 |
| 6 | ** | Wiper-X | | 1 |
| 7 | ** | Plate -X | | 1 |
| 8 | ** | Thrust Bearing | NTB/AS2 1528 | 2 |
| 9 | ** | Cap Collar Pin, Screw(16"), Nut, Key(3X3X115), | | 2 |
| 10 | ** | Spring Pin(5X40) | Assembly for replacement | 1 |
| 15 | ** | Spraying Pipe | PT3/8 x 24" | 1 |
| 16 | ** | Valve & Junction Assy. | PT3/8 | 1 |
| 17 | ** | Rear Bracket | For 16", 18” and 21” | 1 |
| 18 | ** | Saddle | | 1 |
| 19 | ** | Wiper F | | 2 |
| 20 | ** | Plate F | | 2 |
| 21 | ** | Hex. Socket Head Plug | PT 1/2" | 1 |
| 22 | ** | Taper Pin | #6x70L | 2 |
| 23 | ** | Wiper V | | 2 |
| 24 | ** | Plate V | | 2 |
| 25 | ** | Gear | 16T For 16" | 1 |
| 26 | ** | Key | 3x3x20 | 1 |
| 28 | ** | Front Bracket | For 16", 18” and 21” | 1 |
| 29 | ** | Spring | Ø6x15 L | 4 |
| 30 | ** | Steel Ball | 1/4" | 5 |
| 31 | ** | Thrust Bearing | NTB/AS2 2035 | 2 |

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## Parts List F - Saddles Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 32 | ** | Washer | | 1 |
| 33 | ** | Dial Ring | | 1 |
| 34 | ** | Dual | | 1 |
| 35 | ** | Bush | | 1 |
| 36 | ** | Shaft | | 1 |
| 37 | ** | Key | 5x5x15 | 1 |
| 38 | ** | Hand Wheel & Handle | Assembly for replacement | 1 |
| 39 | ** | Screw | | 1 |
| 40 | ** | Front Anti-Floater | | 1 |
| 41 | ** | Gib-Z | | 1 |
| 42 | ** | Rear Anti-Floater | | 1 |
| 43 | ** | Gib-Y | | 1 |
| 44 | ** | Gear | 16T/36T | 1 |
| 45 | ** | Straight Adapter | Ø4x1/8 | 2 |
| 46 | ** | Al. Tube | Ø4x258 | 1 |
| 47 | ** | Elbow Adapter | Ø4x1/8 | 2 |
| 48 | ** | Al. Tube | Ø4x121 | 1 |
| 49 | ** | Oil Filter | Ø6 | 1 |
| 50 | ** | Al. Tube | Ø6x170 | 1 |
| 51 | ** | Straight Adapter | Ø6x1/8 | 2 |
| 52 | ** | Clamp Plate | | 1 |
| 53 | ** | Bolt | | 1 |
| 54 | ** | Short Shaft | | 1 |
| 55 | ** | Hex. Socket Head Bolt | CAP12x85 | 1 |
| 56 | ** | Lubricator Assy. | | 1 |
| 57 | ** | Plate | | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List F - Saddles Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 58 | ** | Washer | | 1 |
| 59 | ** | Adjust Screw | Ø16 | 2 |
| 60 | ** | Joint Block | | 1 |
| 101 | ** | Oil Ball | 1/4" | 2 |
| 102 | ** | Set Screw | SET 6x8 | 2 |
| 103 | ** | Set Screw | SET 6x20 | 1 |
| 104 | ** | Set Screw | SET 8x25 | 5 |
| 105 | ** | Set Screw | SET 8x8 | 1 |
| 106 | ** | Hex. Socket Head Bolt | CAP 6x25 | 2 |
| 107 | ** | Hex. Socket Head Bolt | CAP 8x20 | 2 |
| 108 | ** | Hex. Socket Head Bolt | CAP 8x25 | 8 |
| 109 | ** | Hex. Socket Head Bolt | CAP 8x35 | 4 |
| 110 | ** | Hex. Socket Head Bolt | CAP 10x30 | 2 |
| 111 | ** | Hex. Socket Head Bolt | CAP 10x50 (16” & 18”) | 1 |
| 111 | ** | Hex. Socket Head Bolt | CAP 10x90 (21”) | 1 |
| 112 | ** | Hex. Socket Head Bolt | CAP 10x60 | 4 |
| 113 | ** | Dome Cross Screw | M5x10 | 3 |
| 114 | ** | Dome Cross Screw | M5x12 | 2 |
| 115 | ** | Dome Cross Screw | M5x16 | 10 |
| 116 | ** | Flat Hexagon Screw | M5x12 | 2 |
| 117 | ** | Nut | M8 | 5 |
| 118 | ** | Nylon Nut | M12 | 1 |
| 119 | ** | Nut | | 1 |
| 120 | ** | Washer | M8 | 5 |
| 121 | ** | Hexagon Head Bolt | M8x50 | 5 |
| 122 | ** | Spring Washer | M8 | 5 |

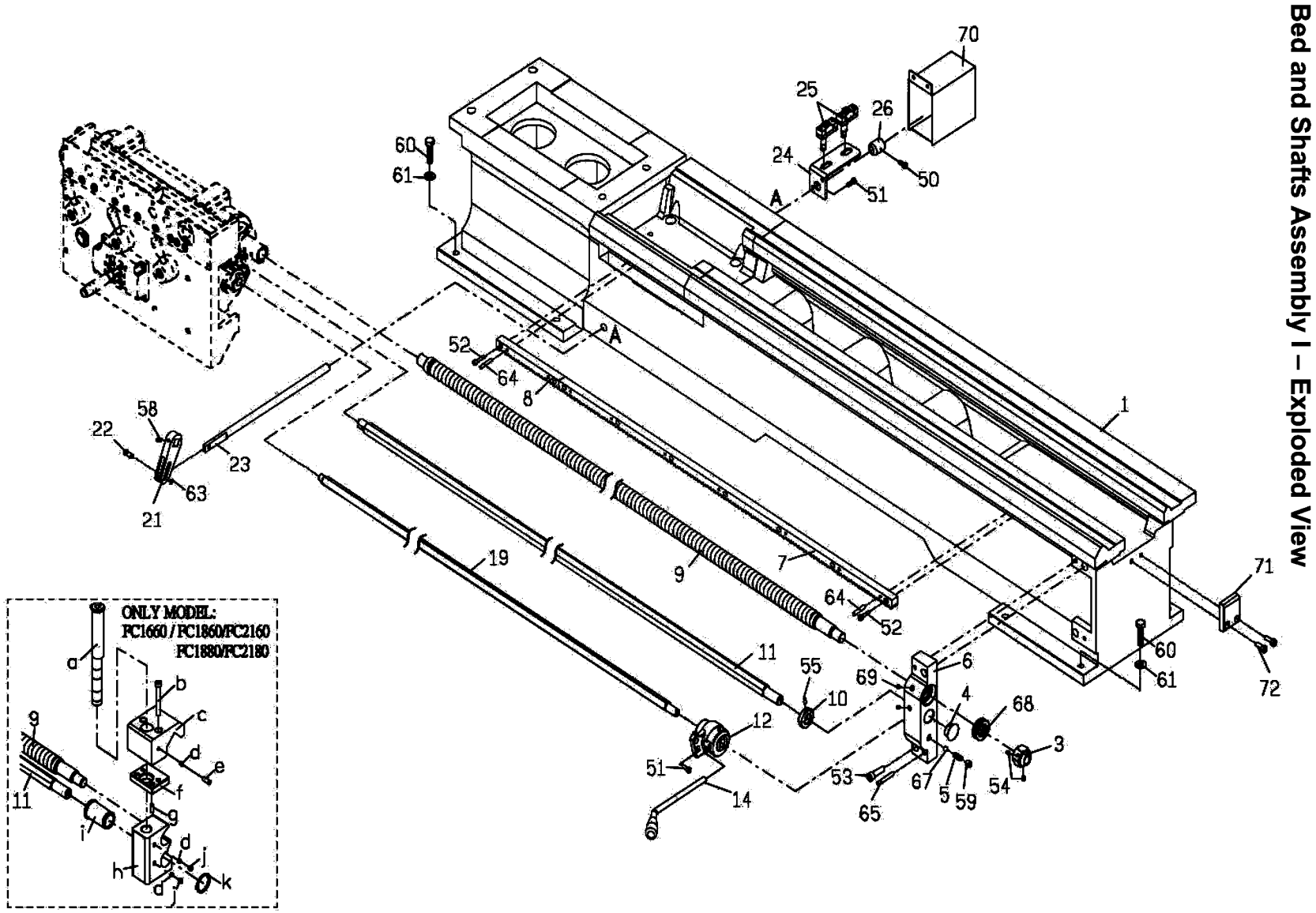
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# JET GH-1640ZX | Stock JT1-3288

## Diagram G - Bed and Shafts Assembly I (1 of 2)

Original JET parts reference | Match model, voltage and serial-number notes

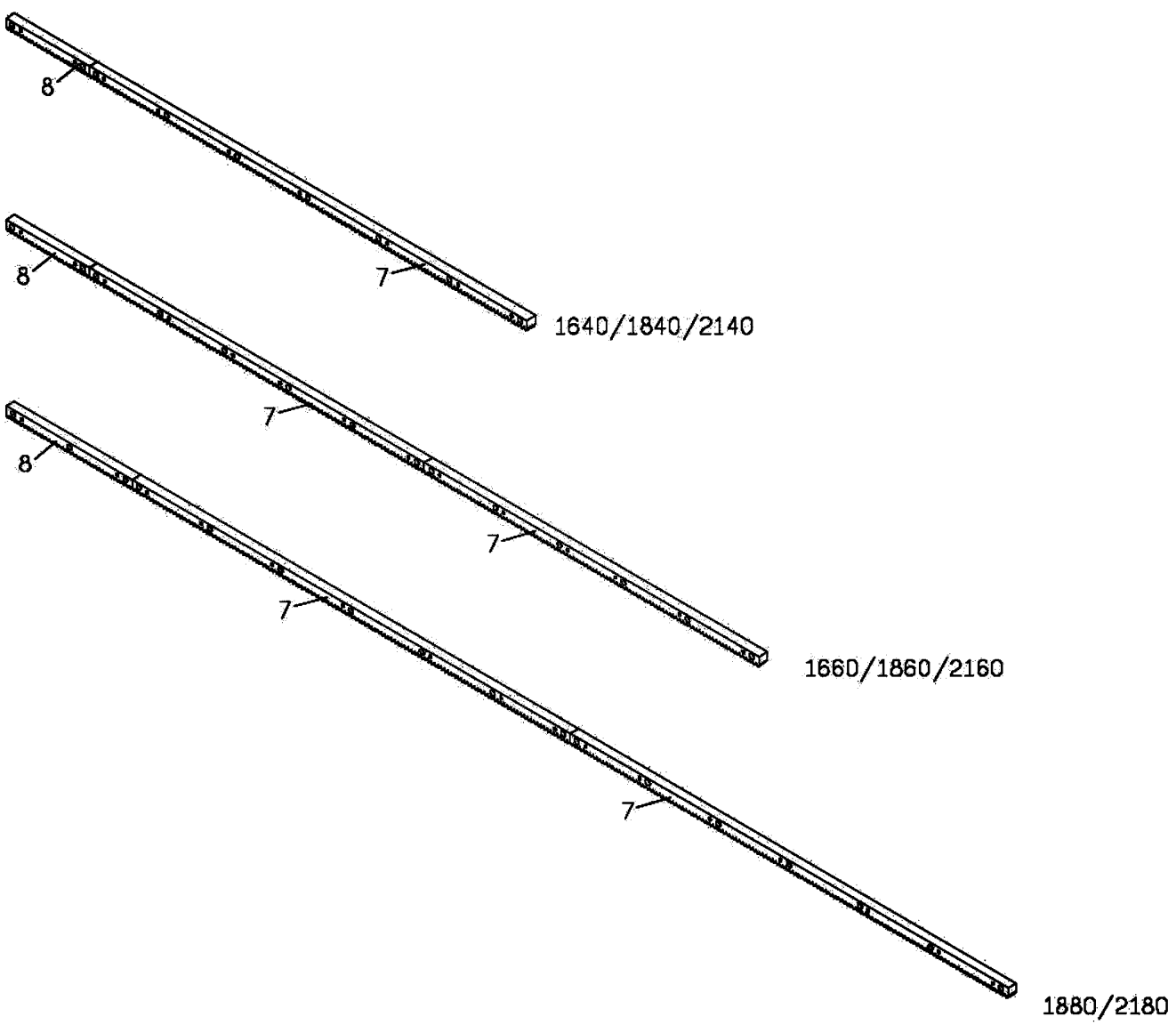



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# JET GH-1640ZX | Stock JT1-3288

## Diagram G - Bed and Shafts Assembly I (2 of 2)

Original JET parts reference | Match model, voltage and serial-number notes




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# JET GH-1640ZX | Stock JT1-3288

## Parts List G - Bed and Shafts Assembly I

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Bed | For 40" | 1 |
| 1 | ** | Bed | For 60" | 1 |
| 1 | ** | Bed | For 80" | 1 |
| 3 | ** | Nut | | 1 |
| 4 | ** | Plug | | 1 |
| 5 | ** | Spring | | 1 |
| 6 | ** | Bracket | | 1 |
| 7 | ** | Rack(Imperial) | For 40" | 1 |
| 7 | ** | Rack(Imperial) | For 60" | 1 |
| 7 | ** | Rack(Imperial) | For 80" | 1 |
| 8 | ** | Rack(Imperial) | For 40"/60" | 1 |
| 8 | ** | Rack(Imperial) | For 80" | 1 |
| 9 | ** | Leadscrew | For 40" | 1 |
| 9 | ** | Leadscrew | For 60" | 1 |
| 9 | ** | Leadscrew | For 80" | 1 |
| 10 | ** | Collar | | 1 |
| 11 | ** | Feed Rod | For 40" | 1 |
| 12 | ** | Lever Assy | | 1 |
| 14 | ** | Knob & Handle | Assembly for replacement | 1 |
| 19 | ** | Third Rod Shaft | For 40" | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List G - Bed and Shafts Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 19 | ** | Third Rod Shaft | For 60" | 1 |
| 19 | ** | Third Rod Shaft | For 80" | 1 |
| 21 | ** | Connecting Rod | | 1 |
| 22 | ** | Pin | | 1 |
| 23 | ** | Connecting Rod | | 1 |
| 24 | ** | Switch Base | | 1 |
| 25 | ** | Limit Switch | TM1308 | 2 |
| 26 | ** | Collar | | 1 |
| 50 | ** | Hex. Socket Head Bolt | CAP 6x12 | 1 |
| 51 | ** | Hex. Socket Head Bolt | CAP 6x16 | 4 |
| 52 | ** | Hex. Socket Head Bolt Cap 6X20 | For 40" | 9 |
| 52 | ** | Hex. Socket Head Bolt Cap 6X20 | For 60" | 9 |
| 52 | ** | Hex. Socket Head Bolt Cap 6X20 | For 80" | 9 |
| 53 | ** | Hex. Socket Head Bolt | CAP 10x35 | 2 |
| 54 | ** | Set Screw | SET 6x8 | 2 |
| 55 | ** | Set Screw | SET 6x10 | 1 |
| 58 | ** | Set Screw | SET 8x10 | 1 |
| 59 | ** | Set Screw | SET 12x12 | 1 |
| 60 | ** | Hexagon Head Bolt | M12x50 | 8 |
| 61 | ** | Washer | M12 | 8 |
| 63 | ** | Snap Ring | E6 | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List G - Bed and Shafts Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

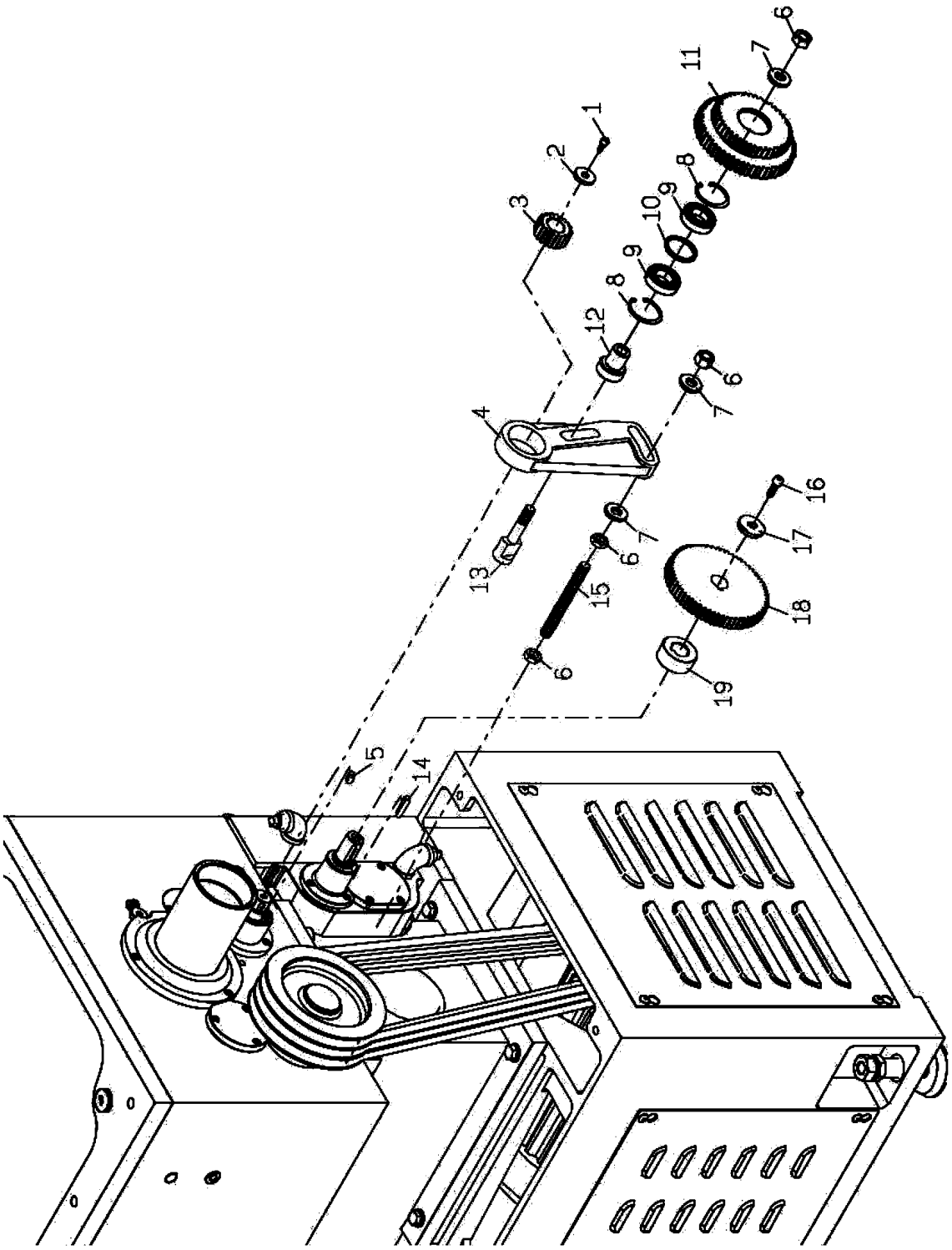
| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 64 | ** | Pin Ø6×25 | For 40" | 9 |
| 64 | ** | Pin Ø6×25 | For 60" | 9 |
| 64 | ** | Pin Ø6×25 | For 80" | 9 |
| 65 | ** | Pin | Ø7x45 | 2 |
| 67 | ** | Steel Ball | 3/8" | 1 |
| 68 | ** | Thrust Bearing | 51105 | 2 |
| 69 | ** | Oil Ball | 1/4" | 2 |
| 70 | ** | Block Oil Plate | | 1 |
| 71 | ** | Block | | 1 |
| 72 | ** | Hex. Socket Head Bolt | CAP 8x25 | 2 |
| a | ** | Shaft | | 1 |
| b | ** | Hex. Socket Head Bolt | CAP 8x70 | 2 |
| c | ** | Block | | 1 |
| d | ** | Pin | | 3 |
| e | ** | Set Screw | SET 8x20 | 1 |
| f | ** | Block | | 1 |
| g | ** | Set Screw | SET 8x16 | 1 |
| h | ** | Beracket | | 2 |
| i | ** | Barrel | | 1 |
| j | ** | Set Screw | SET 8x8 | 1 |
| k | ** | Clip | S35 | 1 |

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### End Gear Assembly I – Exploded View

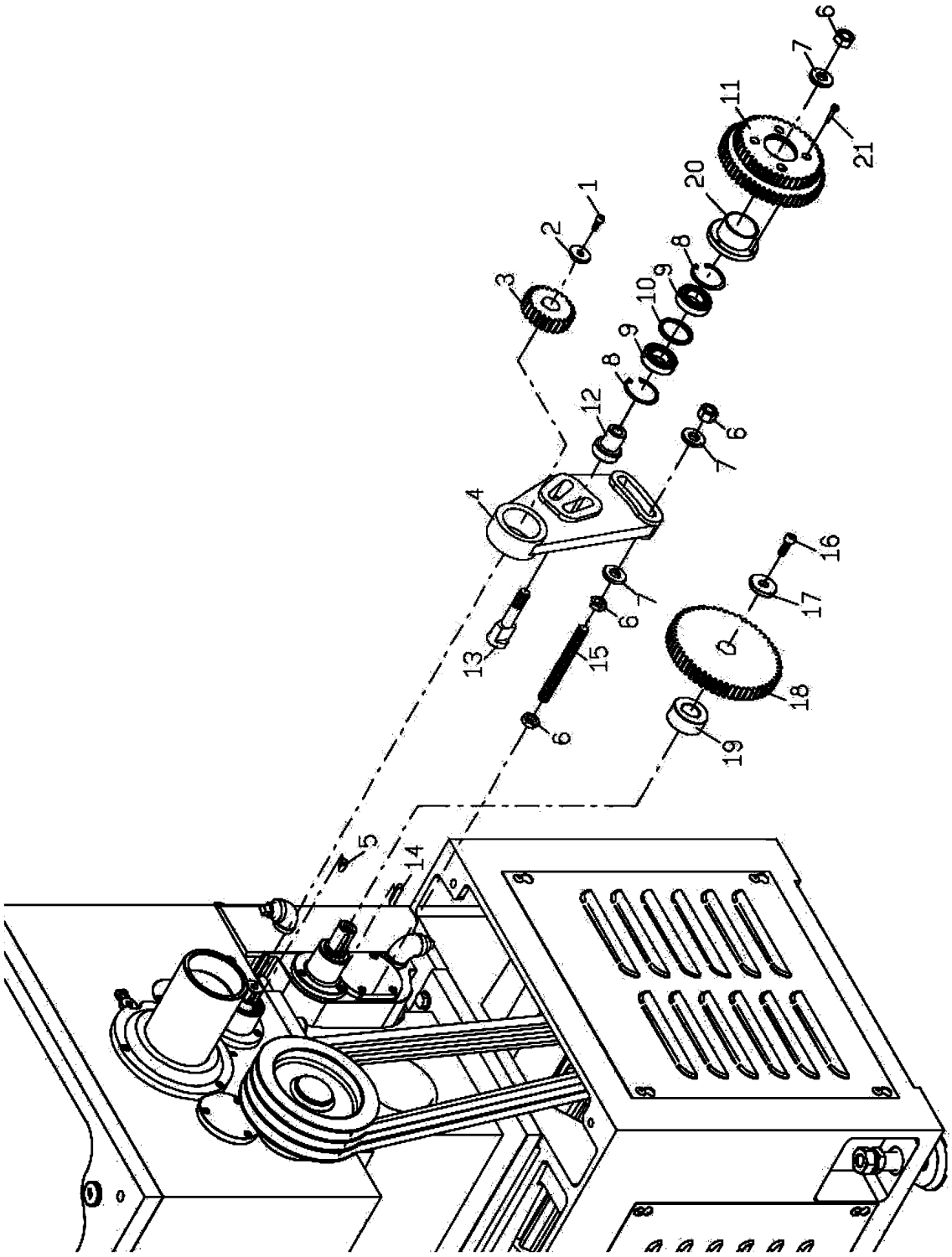
**Models GX-1640ZX, GX-1660XZ & GX-1860ZX**




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## End Gear Assembly II – Exploded View

### Models GX-1880ZX & GX-2180ZX




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# JET GH-1640ZX | Stock JT1-3288

## Parts List H - End Gear Assembly I

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Hex. Socket Head Bolt | CAP 6x16 | 1 |
| 2 | ** | Washer | | 1 |
| 3 | ** | Gear | 24T | 1 |
| 4 | ** | Swing Frame | | 1 |
| 5 | ** | Key | 7x7x15 | 1 |
| 6 | ** | Nut | M14 | 4 |
| 7 | ** | Washer | | 3 |
| 8 | ** | Clip | R47 | 2 |
| 9 | ** | Ball Bearing | 6005Z | 2 |
| 10 | ** | Collar | | 1 |
| 11 | ** | Gear | 44T / 56T | 1 |
| 12 | ** | Shaft Collar | | 1 |
| 13 | ** | Gear Shaft | | 1 |
| 14 | ** | Key | 7x7x30 | 1 |
| 15 | ** | Stud | | 1 |
| 16 | ** | Hex. Socket Head Bolt | CAP 8x25 | 1 |
| 17 | ** | Washer | | 1 |
| 18 | ** | Gear | 57T | 1 |
| 19 | ** | Collar | | 1 |
| 21 | ** | Hex. Socket Head Bolt (GX-2180ZX) | CAP 6x30 | 4 |

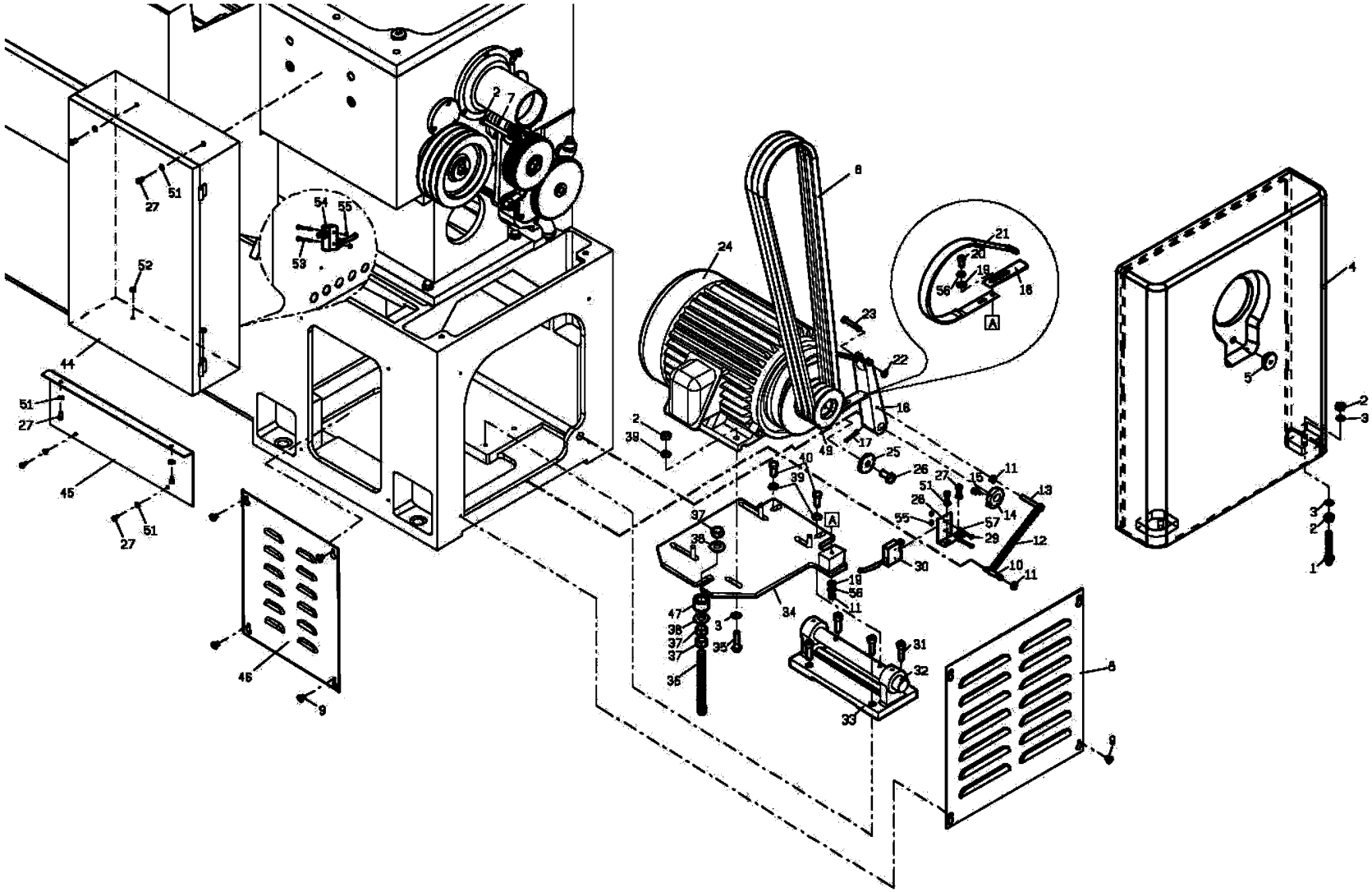
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# JET GH-1640ZX | Stock JT1-3288

## Diagram I - Main Motor Assembly I (1 of 2)

Original JET parts reference | Match model, voltage and serial-number notes

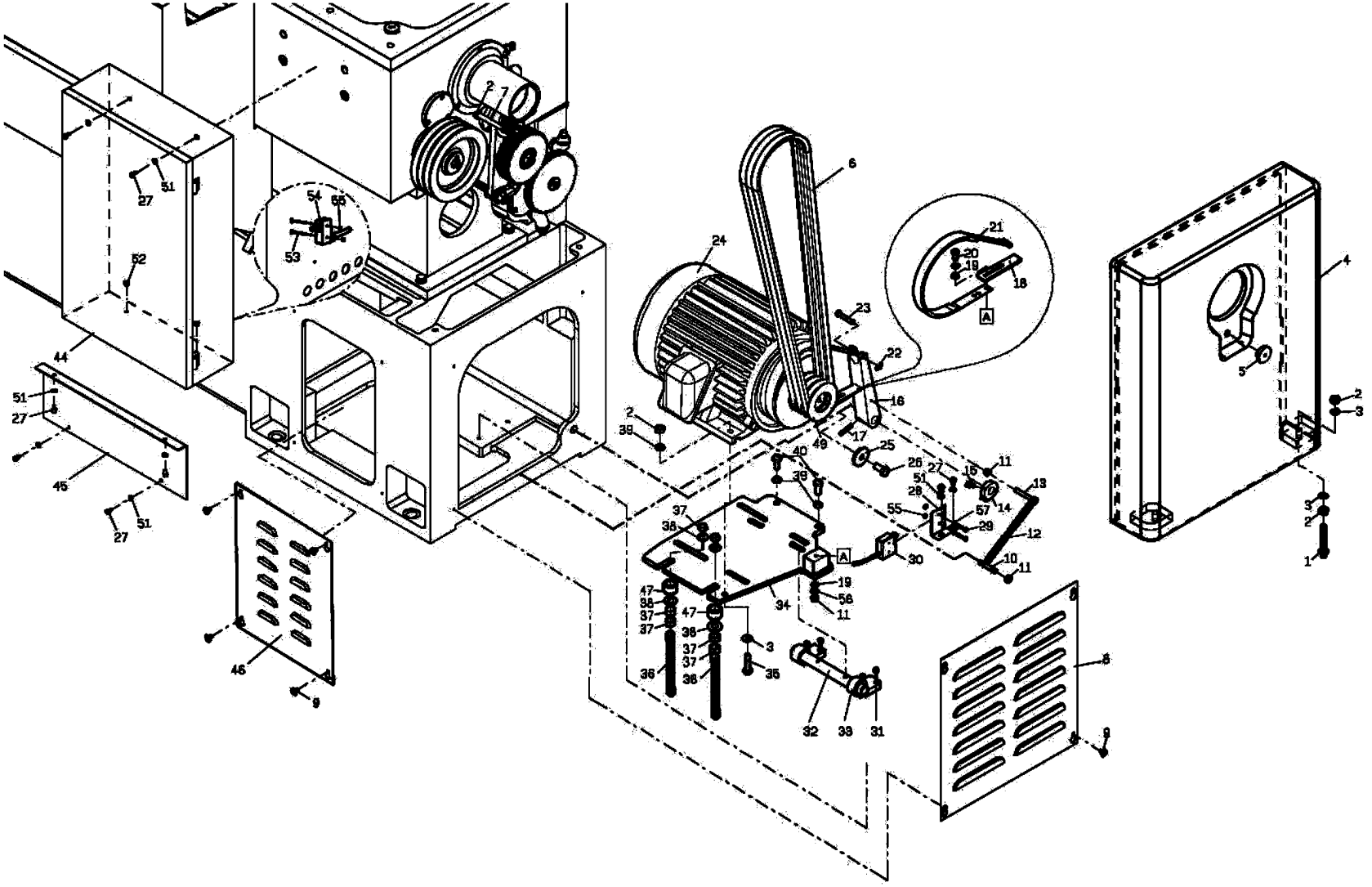



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## Diagram I - Main Motor Assembly I (2 of 2)

Original JET parts reference | Match model, voltage and serial-number notes




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# JET GH-1640ZX | Stock JT1-3288

## Parts List I - Main Motor Assembly I

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Bolt | | 2 |
| 2 | ** | Nut | M10 | 9 |
| 3 | ** | Washer | M10 | 9 |
| 4 | ** | Cover | For 16" | 1 |
| 5 | ** | Nut | | 1 |
| 6 | JT1-3077 | V Belt | For GX-1640ZX & 1660ZX | 3 |
| 6 | JT1-3082 | V Belt | For GX-1860ZX | 3 |
| 6 | JT1-3083 | V Belt | For GX-1880ZX | 3 |
| 6 | JT1-3085 | V Belt | For GX-2180ZX | 3 |
| 7 | ** | Bolt | | 1 |
| 8 | ** | Cover | | 1 |
| 9 | ** | Dome Cross Screw | M6x10 | 8 |
| 10 | ** | Bolt | | 1 |
| 11 | ** | Nut | M8 | 3 |
| 12 | ** | Spring | | 1 |
| 13 | ** | Hex. Socket Head Bolt | CAP 8x55 | 1 |
| 14 | ** | Cam | | 1 |
| 15 | ** | Hex. Socket Head Bolt | CAP 6x16 | 1 |
| 16 | ** | Lever | | 1 |
| 17 | ** | Spring Pin | Ø6x35 | 1 |
| 18 | ** | Fixed Plate | | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List I - Main Motor Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 19 | ** | Washer | M8 | 2 |
| 20 | ** | Hex.Socket Head Bolt | CAP 8x20 | 1 |
| 21 | JT1-3078 | Brake Belt (GX-1640ZX, 1660ZX, 1860ZX) | 660 | 1 |
| 21 | JT1-3084 | Brake Belt (GX-1880ZX, 2180ZX) | 660 | 1 |
| 22 | ** | Clip | E8 | 1 |
| 23 | ** | Pin | | 1 |
| 24 | ** | Motor | 10HP 230/460V 3Ph | 1 |
| 25 | ** | Washer | | 1 |
| 26 | ** | Hexagon Head Bolt | M12x25 | 1 |
| 27 | ** | Hex. Socket Head Bolt | CAP 6x12 | 8 |
| 28 | ** | Bracket | | 1 |
| 29 | ** | Dome Cross Screw | M4x30 | 2 |
| 30 | ** | Limit Switch | TM-1704 | 1 |
| 31 | ** | Hex. Socket Head Bolt | CAP 10x35 | 4 |
| 32 | ** | Shaft (GX-1640ZX, 1660ZX, 1860ZX) | | 1 |
| 32 | ** | Shaft (GX-1880ZX, 2180ZX) | | 1 |
| 33 | ** | Support (GX-1640ZX, 1660ZX, 1860ZX) | | 1 |
| 33 | ** | Support (GX-1880ZX, 2180ZX) | | 1 |
| 34 | ** | Plate (GX-1640ZX, 1660ZX, 1860ZX) | | 1 |
| 34 | ** | Plate (GX-1880ZX, 2180ZX) | | 1 |
| 35 | ** | Hexagon Head Bolt | M10x40 | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List I - Main Motor Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 36 | ** | Screw (GX-1640ZX, 1660ZX, 1860ZX) | | 1 |
| 36 | ** | Screw (GX-1880ZX, 2180ZX) | | 2 |
| 37 | ** | Nut (GX-1640ZX, 1660ZX, 1860ZX) | M16 | 3 |
| 37 | ** | Nut (GX-1880ZX, 2180ZX) | M16 | 6 |
| 38 | ** | Washer (GX-1640ZX, 1660ZX, 1860ZX) | M16 | 2 |
| 38 | ** | Washer (GX-1880ZX, 2180ZX) | M16 | 4 |
| 39 | ** | Spring Washer | M10 | 6 |
| 40 | ** | Hexagon Head Bolt | M10x25 | 2 |
| 44 | ** | Electrical Box | | 1 |
| 45 | ** | Cover | | 1 |
| 46 | ** | Cover | | 1 |
| 47 | ** | Rubber Ring (GX-1640ZX, 1660ZX, 1860ZX) | | 1 |
| 47 | ** | Rubber Ring (GX-1880ZX, 2180ZX) | | 2 |
| 49 | ** | Motor Pully | | 1 |
| 51 | ** | Washer | M6 | 8 |
| 52 | ** | Nut | M6 | 2 |
| 53 | ** | Dome Cross Screw | M4x40 | 2 |
| 54 | ** | Limit Switch | TM1307 | 1 |
| 55 | ** | Nut | M4 | 4 |
| 56 | ** | Spring Washer | M8 | 2 |
| 57 | ** | Washer | M4 | 2 |

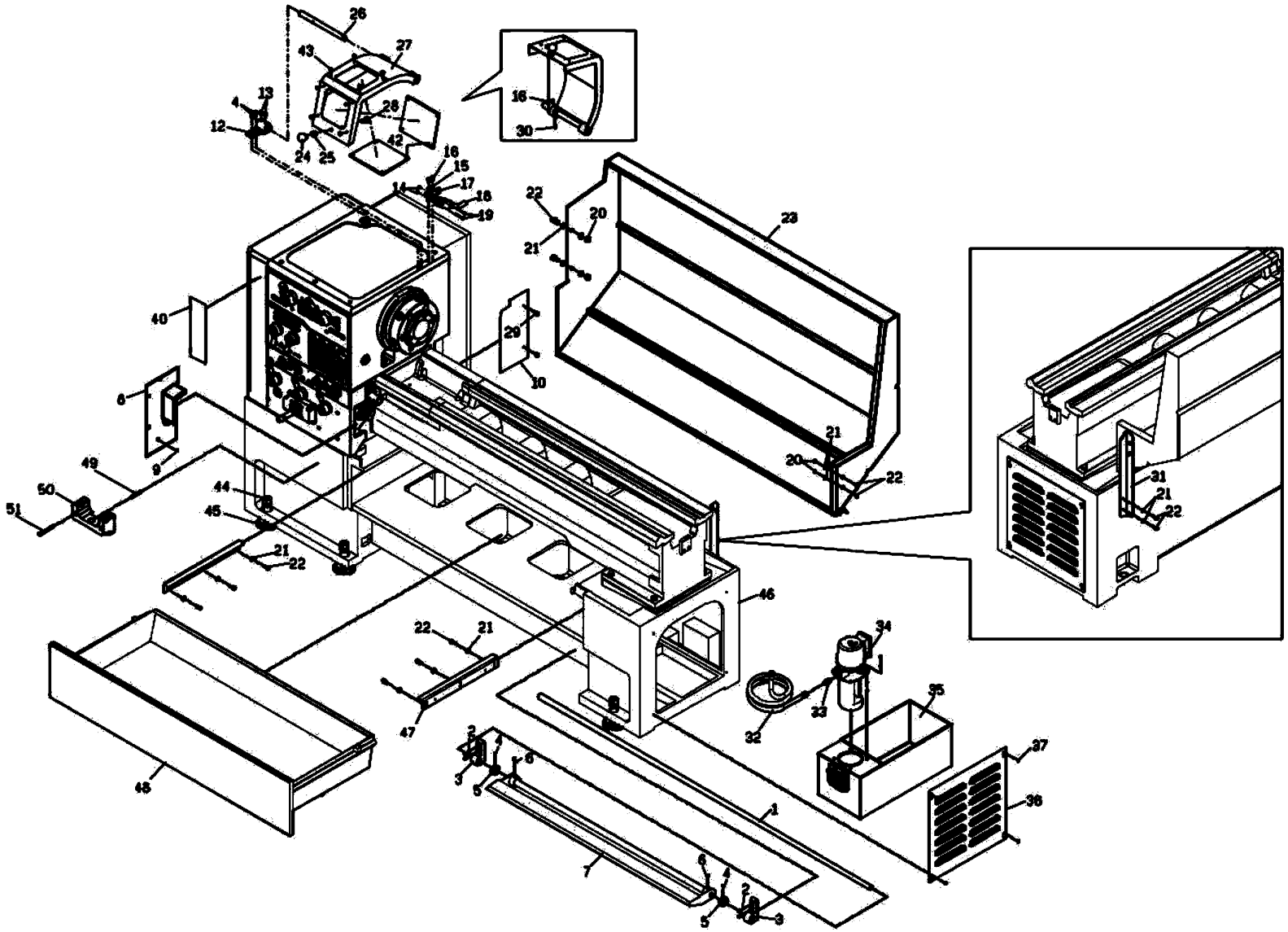
** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

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# JET GH-1640ZX | Stock JT1-3288

## Diagram J - Cabinet and Panel Assembly I (1 of 2)

Original JET parts reference | Match model, voltage and serial-number notes

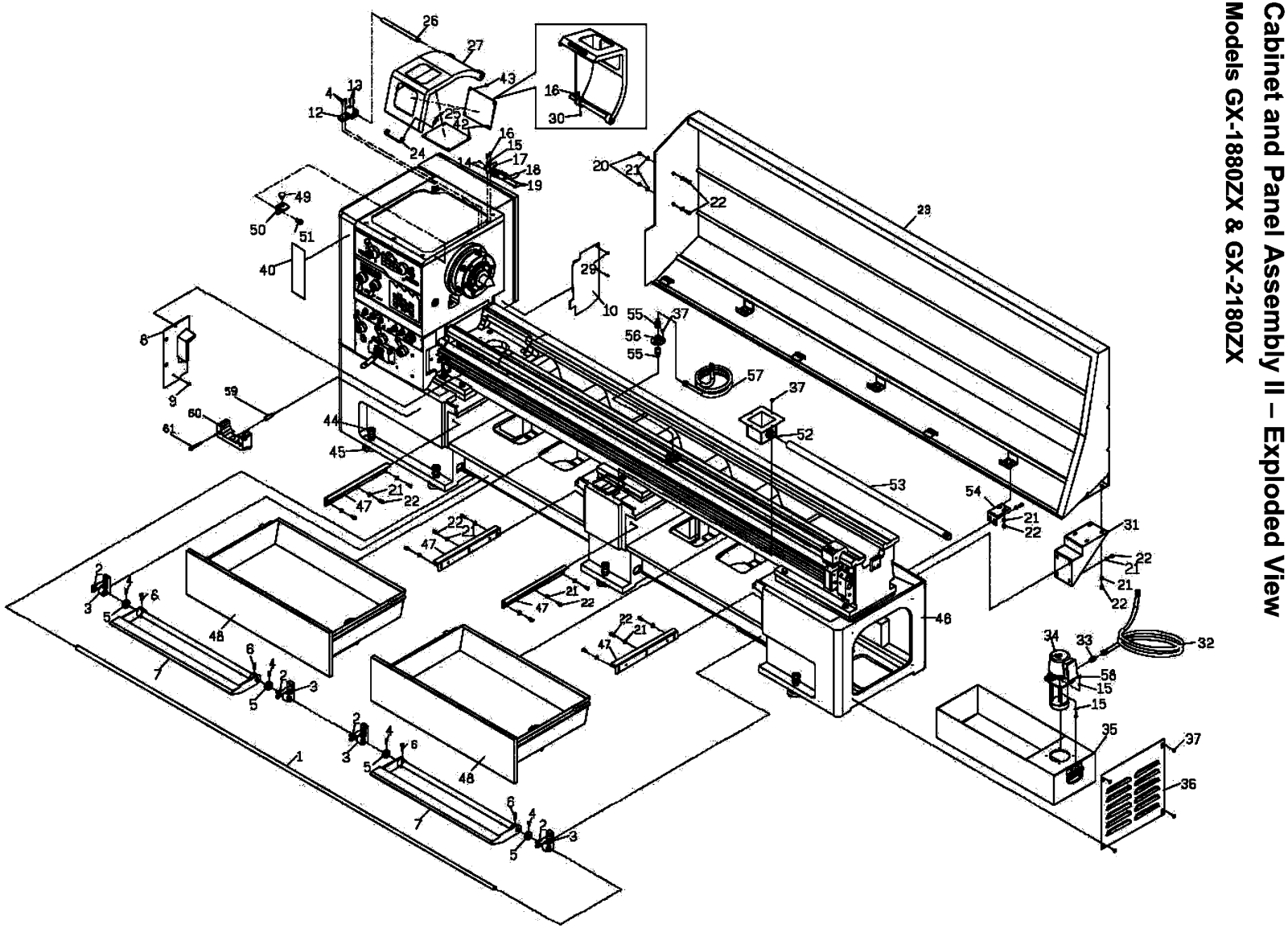



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# JET GH-1640ZX | Stock JT1-3288

## Diagram J - Cabinet and Panel Assembly I (2 of 2)

Original JET parts reference | Match model, voltage and serial-number notes




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# JET GH-1640ZX | Stock JT1-3288

## Parts List J - Cabinet and Panel Assembly I

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Shaft | | 1 |
| 2 | ** | Hex. Socket Head Bolt | CAP 8x25 | 4 |
| 3 | ** | Pedal Bracket | | 2 |
| 4 | ** | Hex. Socket Head Bolt | CAP 6x16 | 6 |
| 5 | ** | Ring | | 2 |
| 6 | ** | Hex. Socket Head Bolt | CAP 10x20 | 2 |
| 7 | ** | Saddle | | 1 |
| 7 | ** | Saddle | | 1 |
| 8 | ** | Plate | | 1 |
| 9 | ** | Dome Hexagon Screw | M5x8 | 4 |
| 10 | ** | Plate | | 1 |
| 12 | ** | Small Bracket | | 1 |
| 13 | ** | Set Screw | SET 8x12 | 2 |
| 14 | ** | Nut | M4xP0.7 | 2 |
| 15 | ** | Spring Washer | M6 | 2 |
| 16 | ** | Hex. Socket Head Bolt | CAP 6x12 | 3 |
| 17 | ** | Bracket | | 1 |
| 18 | ** | Limit | TZ9212 | 1 |
| 19 | ** | Dome Cross Screw | M4x40 | 2 |
| 20 | ** | Nut | M8 | 4 |
| 21 | ** | Washer | M8 | 14 |
| 22 | ** | Hex. Socket Head Bolt | CAP 8x20 | 12 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List J - Cabinet and Panel Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 23 | ** | Splash Guard | | 1 |
| 24 | ** | Knob (GX-1640ZX, 1660ZX, 1860ZX) | | 1 |
| 24 | ** | Knob (GX-1880ZX, 2180ZX) | A-3-1 | 1 |
| 25 | ** | Nut (GX-1640ZX, 1660ZX, 1860ZX) Hex. Head Bolt (GX-1880ZX, | M12xP1.75 | 1 |
| 25 | ** | 2180ZX) | Screw 3/16"x3/8" | 1 |
| 26 | ** | Pivot | | 1 |
| 27 | ** | Chuck Safety Guard | | 1 |
| 28 | ** | Hex. Socket Head Bolt | CAP 12x20 | 1 |
| 29 | ** | Flat Hexagon Screw | M5x8 | 2 |
| 30 | ** | Set Screw Angle Steel (GX-1640ZX, 1660ZX, | SET 5x16 | 1 |
| 31 | ** | 1860ZX) | | 1 |
| 31 | ** | Bracket (GX-1880ZX, 2180ZX) Coolant Conduit 40 (GX-1640ZX, | | 1 |
| 32 | ** | 1660ZX, 1860ZX) Coolant Conduit 60 (GX-1640ZX, | CT801x3/8"x72" | 1 |
| 32 | ** | 1660ZX, 1860ZX) Coolant Conduit (GX-1880ZX, | CT801x3/8"x78" | 1 |
| 32 | ** | 2180ZX) | CT801x3/8"x74" | 1 |
| 33 | ** | Nipple | 3/8"PTx3/8"PH | 1 |
| 34 | JT1-3070 | Coolant Pump | 1/8Hp 230/460V 3Ph | 1 |
| 35 | ** | Coolant Tank | | 1 |
| 36 | ** | Cover | | 1 |
| 37 | ** | Dome Cross Screw | M6x10 | 4 |
| 40 | ** | Nameplate | | 1 |
| 42 | ** | Plate | PC | 2 |
| 43 | ** | Dome Hexagon Screw (GX-1640ZX, 1660ZX, 1860ZX) | M6x12 | 8 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List J - Cabinet and Panel Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 43 | ** | Nylon Jam Nut (GX-1880ZX, 2180ZX) | M6 | 8 |
| 44 | ** | Screw & Nut | Assembly for replacement | 8 |
| 45 | ** | Block | | 1 |
| 46 | ** | Base | | 1 |
| 46 | ** | Base | | 1 |
| 47 | ** | Angle Steel | | 2 |
| 48 | ** | Chip Tray Sensor (GX-1640ZX, 1660ZX, | | 1 |
| 49 | ** | 1860ZX) | M12x1.0 | 1 |
| 49 | ** | Rubber (GX-1880ZX, 2180ZX) Bracket (GX-1640ZX, 1660ZX, | M12x1.0 | 1 |
| 50 | ** | 1860ZX) | | 1 |
| 50 | ** | Fixed Support (GX-1880ZX, 2180ZX) Screw (GX-1640ZX, 1660ZX, | | 1 |
| 51 | ** | 1860ZX) | M6x70 | 2 |
| 51 | ** | Hex. Socket Head Bolt (GX-1880ZX, 2180ZX) | CAP 6x10 | 1 |
| 52 | ** | Box (GX-1880ZX, 2180ZX) | | 1 |
| 53 | ** | Tube (GX-1880ZX, 2180ZX) | | 1 |
| 54 | ** | Bracket (GX-1880ZX, 2180ZX) | | 1 |
| 55 | ** | Nipple (GX-1880ZX, 2180ZX) | 1/2"PTx3/8"PH | 1 |
| 56 | ** | Cover (GX-1880ZX, 2180ZX) Coolant Conduit (GX-1880ZX, | | 1 |
| 57 | ** | 2180ZX) | CT801x3/8"x98" | 1 |
| 58 | ** | Nut (GX-1880ZX, 2180ZX) | M6 | 4 |
| 59 | ** | Sensor (GX-1880ZX, 2180ZX) | M12x1.0 | 1 |
| 60 | ** | Bracket (GX-1880ZX, 2180ZX) | | 1 |
| 61 | ** | Screw (GX-1880ZX, 2180ZX) | M8x70 | 2 |

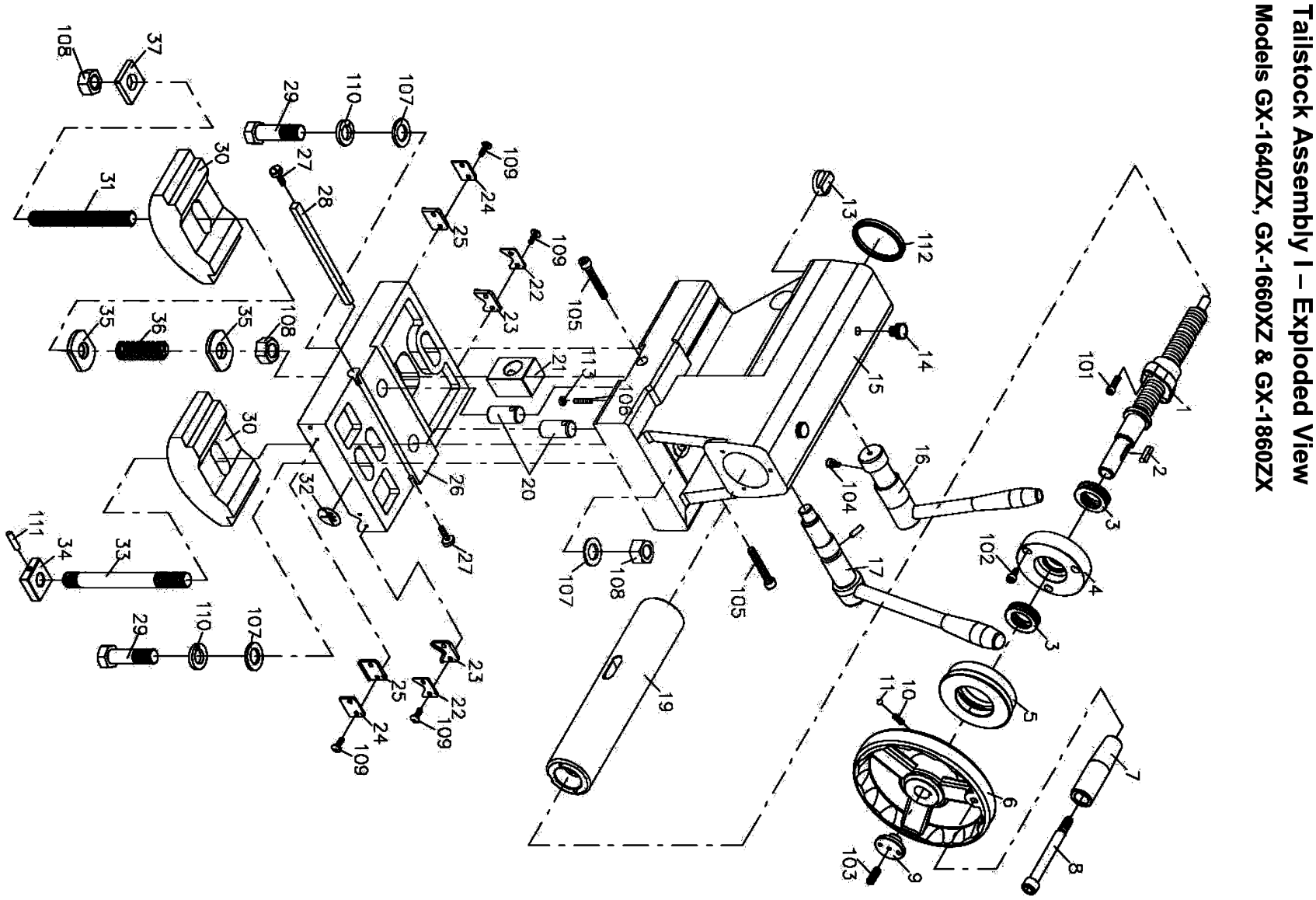
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# JET GH-1640ZX | Stock JT1-3288

## Diagram K - Tailstock Assembly I (1 of 2)

Original JET parts reference | Match model, voltage and serial-number notes

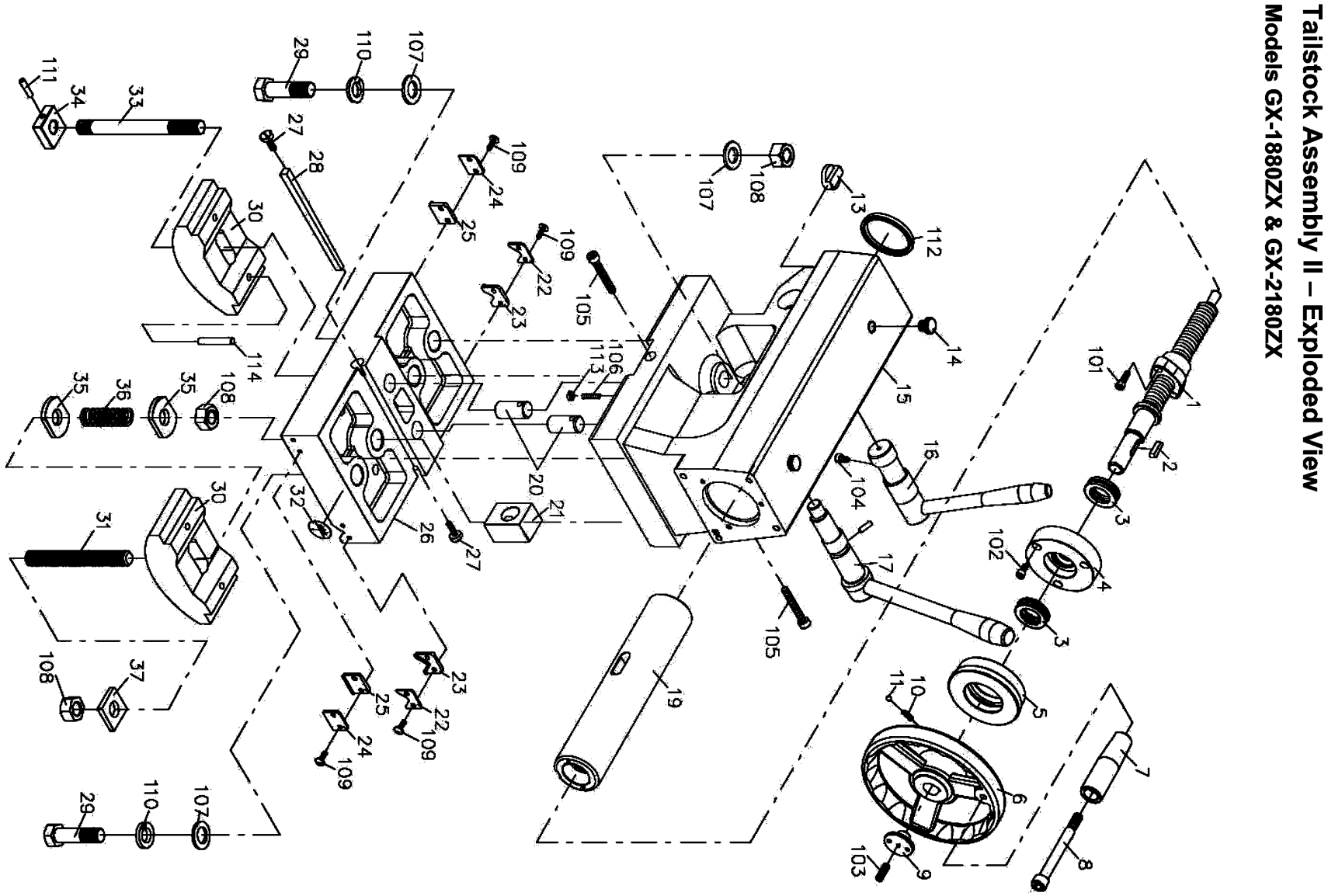



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# JET GH-1640ZX | Stock JT1-3288

## Diagram K - Tailstock Assembly I (2 of 2)

Original JET parts reference | Match model, voltage and serial-number notes




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# JET GH-1640ZX | Stock JT1-3288

## Parts List K - Tailstock Assembly I

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Screw & Nut | Assembly for replacement | 1 |
| 2 | ** | Key | 6×6x25 | 1 |
| 3 | ** | Thrust Bearing | 51105 | 2 |
| 4 | ** | Flange | | 1 |
| 5 | ** | Index Ring | | 1 |
| 6 | ** | Handle | | 1 |
| 7 | ** | Handle | | 1 |
| 8 | ** | Bolt | | 1 |
| 9 | ** | Fixed Screw | | 1 |
| 10 | ** | Spring | | 3 |
| 11 | ** | Steel Ball | 1/4" | 3 |
| 13 | ** | Guide Key | | 1 |
| 14 | ** | Screw | | 2 |
| 15 | ** | Tail Stock | | 1 |
| 16 | ** | Clamp Lever L & Cam Shaft L | Assembly for replacement | 1 |
| 17 | ** | Clamp Lever R & Cam Shaft R & Pins | Assembly for replacement | 1 |
| 19 | ** | Quill | | 1 |
| 20 | ** | Pin Nut | | 2 |
| 21 | ** | Pivot Block | | 1 |
| 22 | ** | Plate V | | 2 |
| 23 | ** | Wiper V | | 2 |
| 24 | ** | Plate F | | 2 |
| 25 | ** | Wiper F | | 2 |
| 26 | ** | Base | For 16" | 1 |
| 27 | ** | Gib Screw | | 2 |
| 28 | ** | Gib Hexagon Head Screw (GX-1640ZX, | | 1 |
| 29 | ** | 1660ZX, 1860ZX) Hexagon Head Screw (GX-1880ZX, | M18x65 | 2 |
| 29 | ** | 2180ZX) | M18x130 | 2 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List K - Tailstock Assembly I (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 30 | ** | Clamp Block Stud Bolt (GX-1640ZX, 1660ZX, | | 2 |
| 31 | ** | 1860ZX) | M18×150L | 1 |
| 31 | ** | Stud Bolt (GX-1880ZX) | M18×165L | 1 |
| 31 | ** | Stud Bolt (GX-2180ZX) | M18×205L | 1 |
| 32 | ** | Warked Plate Stud Bolt (GX-1640ZX, 1660ZX, | | 1 |
| 33 | ** | 1860ZX) | M18×180L | 1 |
| 33 | ** | Stud Bolt (GX-1880ZX) | M18×197L | 1 |
| 33 | ** | Stud Bolt (GX-2180ZX) | M18×237L | 1 |
| 34 | ** | Nut | | 1 |
| 35 | ** | Washer | | 2 |
| 36 | ** | Spring | | 1 |
| 37 | ** | Washer | | 1 |
| 101 | ** | Hex. Socket Head Bolt | CAP 6x20 | 2 |
| 102 | ** | Hex. Socket Head Bolt Set Screw (GX-1640ZX, 1660ZX, | CAP 6x25 | 3 |
| 103 | ** | 1860ZX) | SET 8x28 | 1 |
| 103 | ** | Set Screw (GX-1880ZX, 2180ZX) | SET 8x30 | 1 |
| 104 | ** | Hex. Socket Head Bolt | CAP 6x10 | 1 |
| 105 | ** | Hex. Socket Head Bolt | CAP 8×55 | 2 |
| 106 | ** | Set Screw | SET 8×25 | 1 |
| 107 | ** | Washer | M18 | 4 |
| 108 | ** | Nut | M18 | 3 |
| 109 | ** | Dome Cross Screw | M5×12 | 8 |
| 110 | ** | Spring Washer | M18 | 2 |
| 111 | ** | Pin | Ø4×38 | 1 |
| 112 | ** | Oil Seal (GX-1640ZX, 1660ZX, 1860ZX) | DH-60 | 1 |
| 112 | ** | Oil Seal (GX-1880ZX, 2180ZX) | TC689012 | 1 |
| 113 | ** | Nut | M6 | 1 |
| 114 | ** | Pin (GX-1880ZX, 2180ZX) | Ø8×50 | 1 |

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

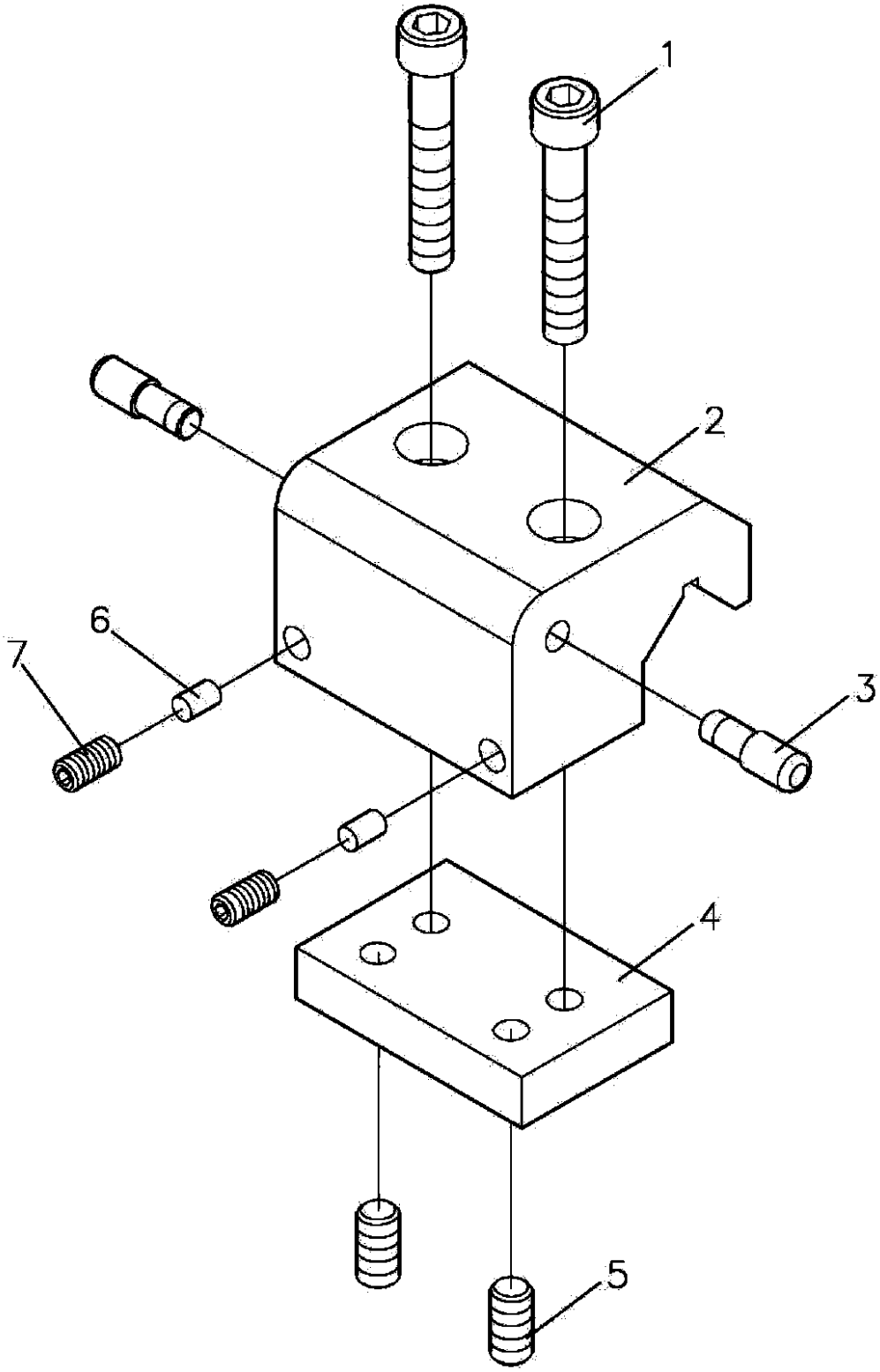
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# JET GH-1640ZX | Stock JT1-3288

## Diagram L - Bed Stop Assembly

Original JET parts reference | Match model, voltage and serial-number notes

## Bed Stop Assembly – Exploded View




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# JET GH-1640ZX | Stock JT1-3288

## Parts List L - Bed Stop Assembly

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Hex. Socket Head Bolt | CAP 10x60 | 2 |
| 2 | ** | Body | | 1 |
| 3 | ** | Pad | | 2 |
| 4 | ** | Clamp Plate | | 1 |
| 5 | ** | Set Screw | M10x20 | 2 |
| 6 | ** | Copper Pin | | 2 |
| 7 | ** | Set Screw | M8x16 | 2 |

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

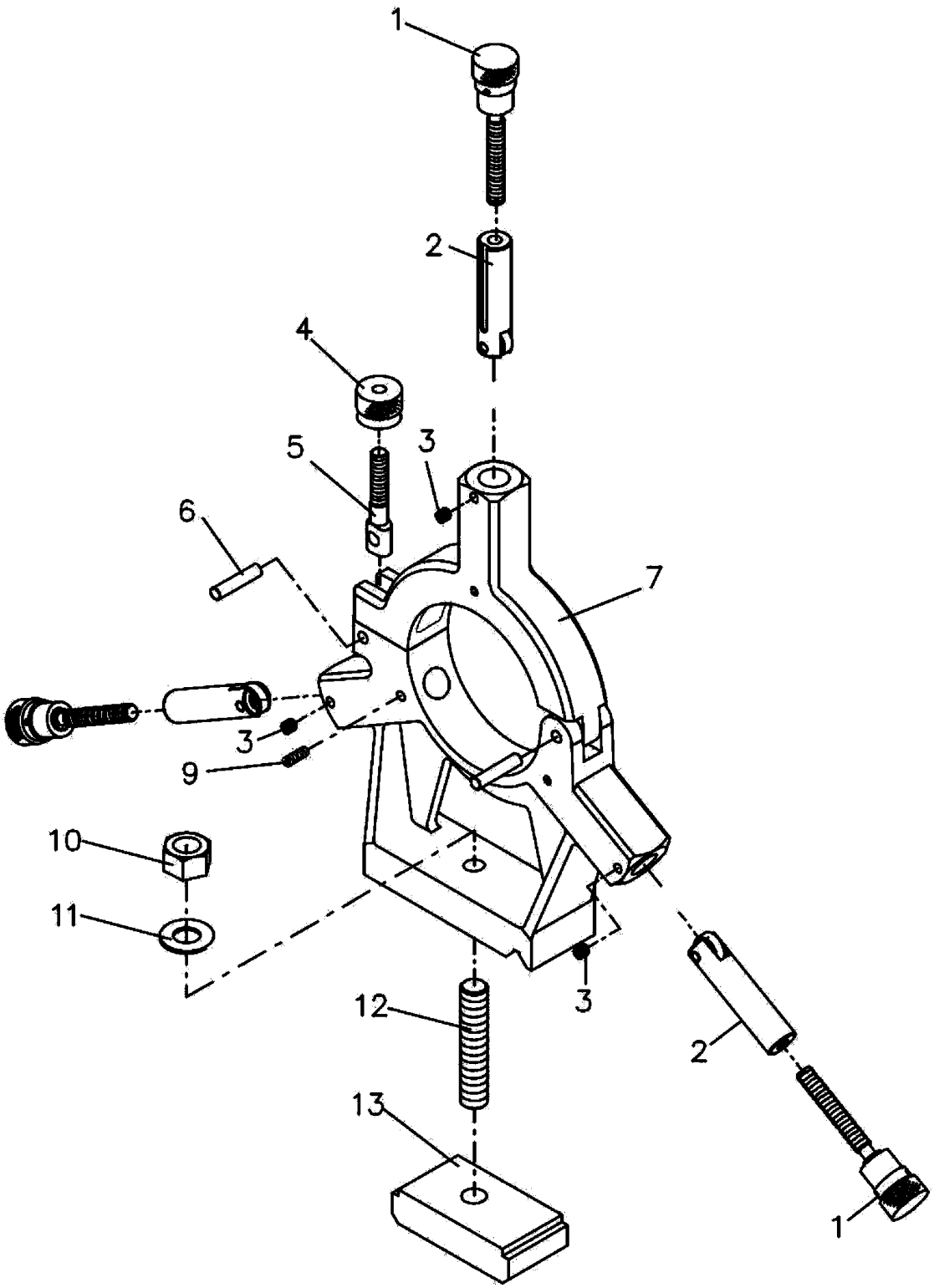
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# JET GH-1640ZX | Stock JT1-3288

## Diagram M - Steady Rest Assembly I (1 of 2)

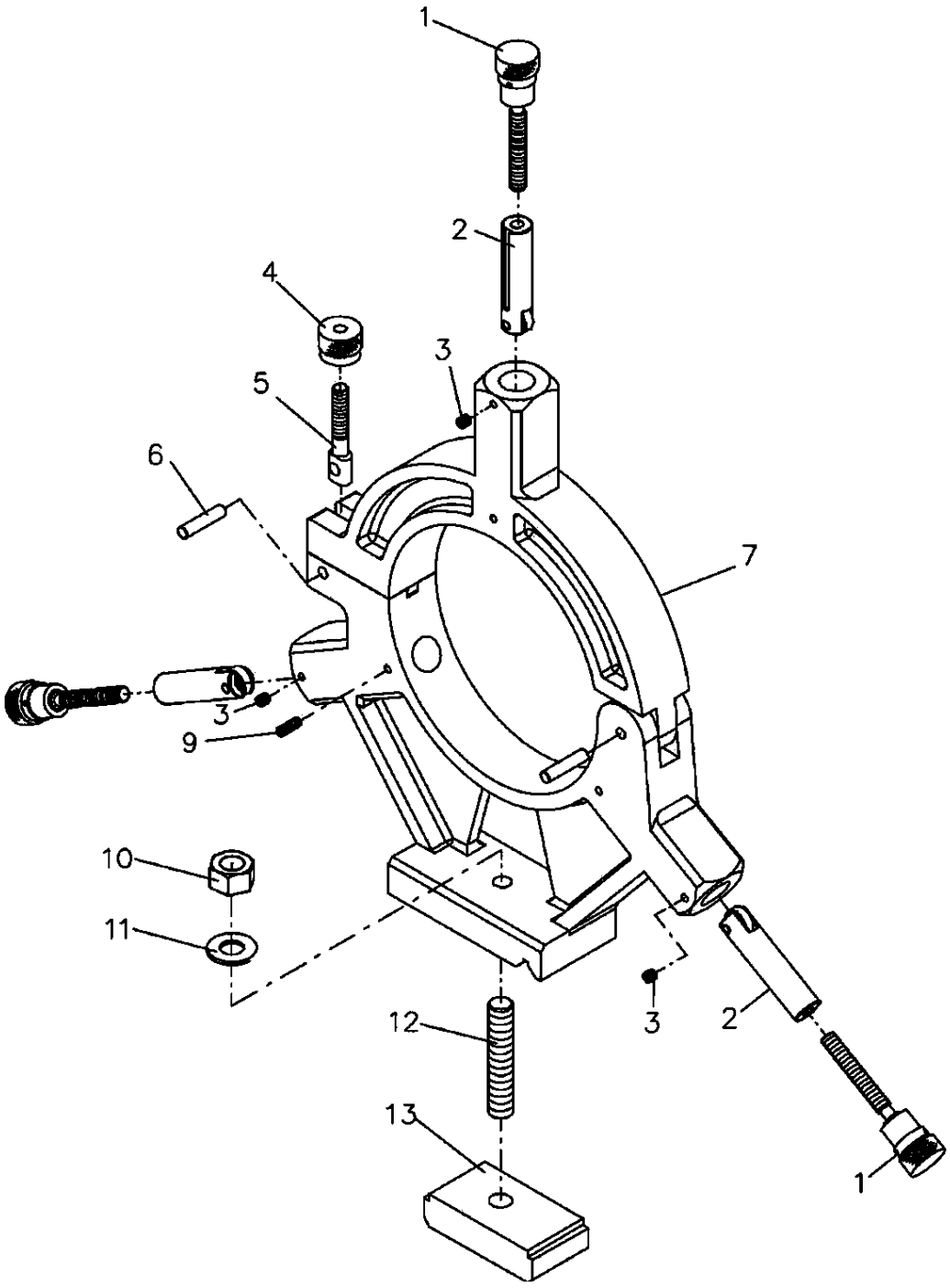
Original JET parts reference | Match model, voltage and serial-number notes

### Steady Rest Assembly I – Exploded View




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## Steady Rest Assembly II – Exploded View




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# JET GH-1640ZX | Stock JT1-3288

## Parts List M - Steady Rest Assembly I

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Collar, Screw Adjusting Knob , Spring Pin(Ø4X30L), | Assembly for Replacement | 3 |
| 1 | ** | Collar, Screw (GX-2180ZX) | Assembly for Replacement | 3 |
| 2 | ** | Finger , Pin , Ball Bearing(627) Finger , Pin , Ball Bearing(638) (GX- | Assembly for Replacement | 3 |
| 2 | ** | 2180ZX) | Assembly for Replacement | 3 |
| 3 | ** | Set Screw | M8x8L | 3 |
| 3 | ** | Set Screw (GX-2180ZX) | M8x12L | 3 |
| 4 | ** | Knob Nut | | 1 |
| 5 | ** | Clamp Screw | | 1 |
| 6 | ** | Hinge Pin Top Casting & Base Casting (GX- | | 2 |
| 7 | ** | 1640ZX & 1660ZX) | | 1 |
| 7 | ** | Top Casting & Base Casting (GX- 1860ZX & 1880ZX) Top Casting & Base Casting (GX- | | 1 |
| 7 | ** | 2180ZX) | | 1 |
| 9 | ** | Set Screw | M8x16L | 3 |
| 10 | ** | Nut | M14 | 1 |
| 11 | ** | Spring Washer | | 1 |
| 12 | ** | Hexagon Head Bolt | M14x95 | 1 |
| 13 | ** | Clamp Plate | | 1 |

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

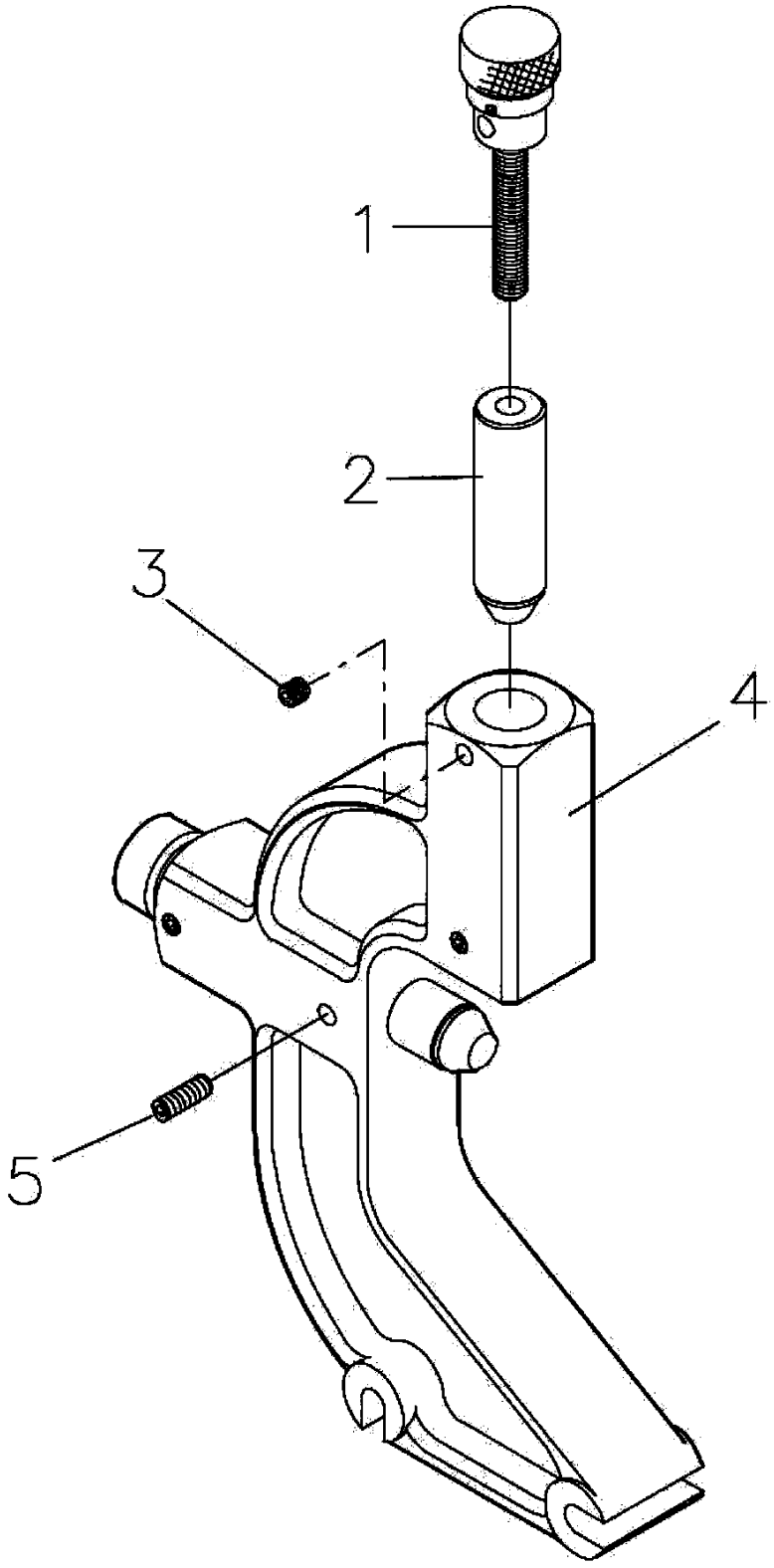
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# JET GH-1640ZX | Stock JT1-3288

## Diagram N - Follow Rest Assembly

Original JET parts reference | Match model, voltage and serial-number notes

### Follow Rest Assembly – Exploded View




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# JET GH-1640ZX | Stock JT1-3288

## Parts List N - Follow Rest Assembly

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Collar, Screw | Assembly for replacement | 2 |
| 2 | ** | Finger, Bracket | Assembly for replacement | 2 |
| 3 | ** | Set Screw | M8x10 | 2 |
| 4 | ** | Casting (GX-1640ZX & 1660ZX) | for 16" | 1 |
| 4 | ** | Casting (GX-1860ZX & 1880ZX) | for 16" | 1 |
| 4 | ** | Casting (GX-2180ZX) | for 16" | 1 |
| 5 | ** | Set Screw | M8x16 | 2 |

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

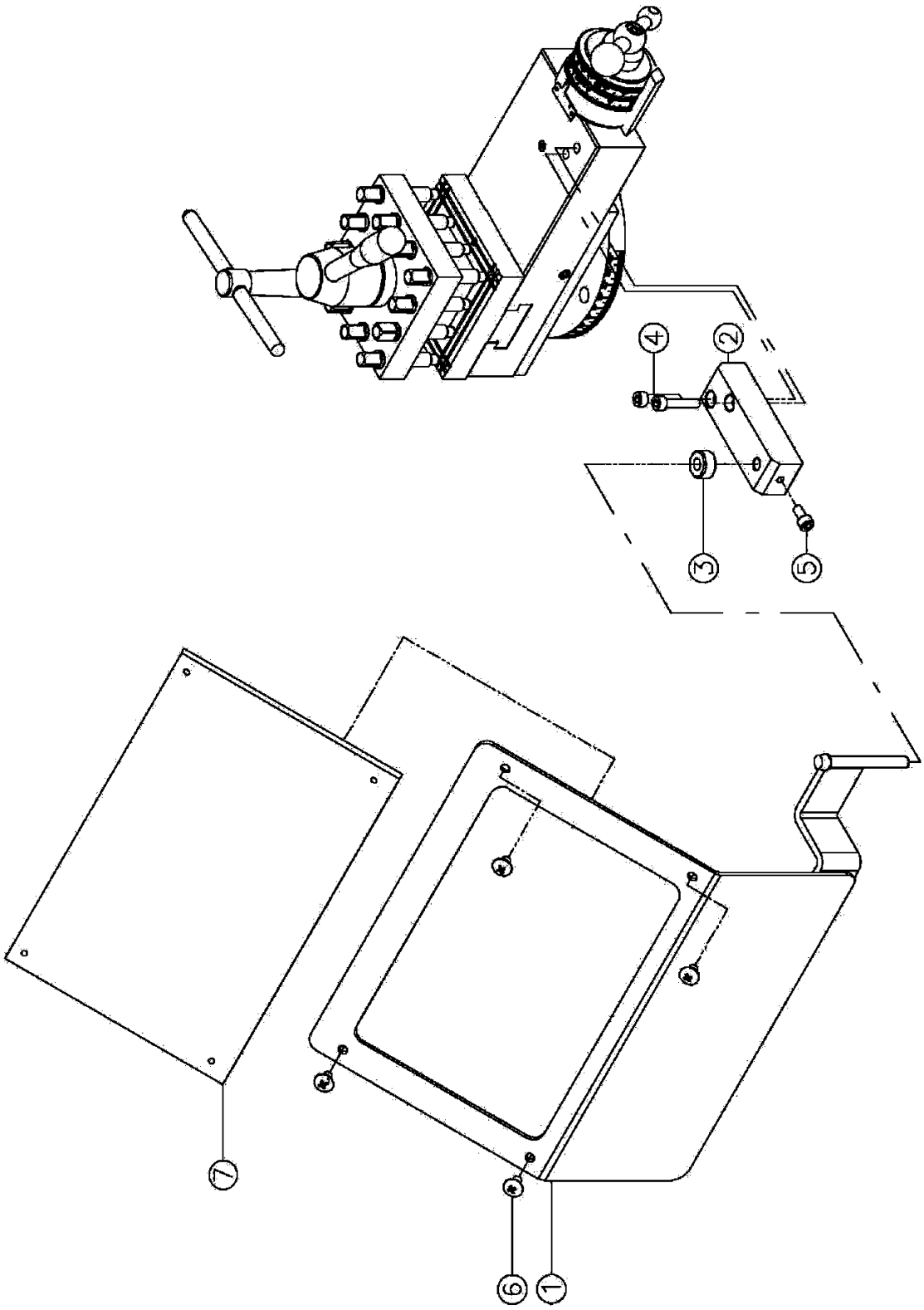
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# JET GH-1640ZX | Stock JT1-3288

## Diagram O - Tool Post Safety Guard Assembly

Original JET parts reference | Match model, voltage and serial-number notes

## Tool Post Safety Guard Assembly – Exploded View




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# JET GH-1640ZX | Stock JT1-3288

## Parts List O - Tool Post Safety Guard Assembly

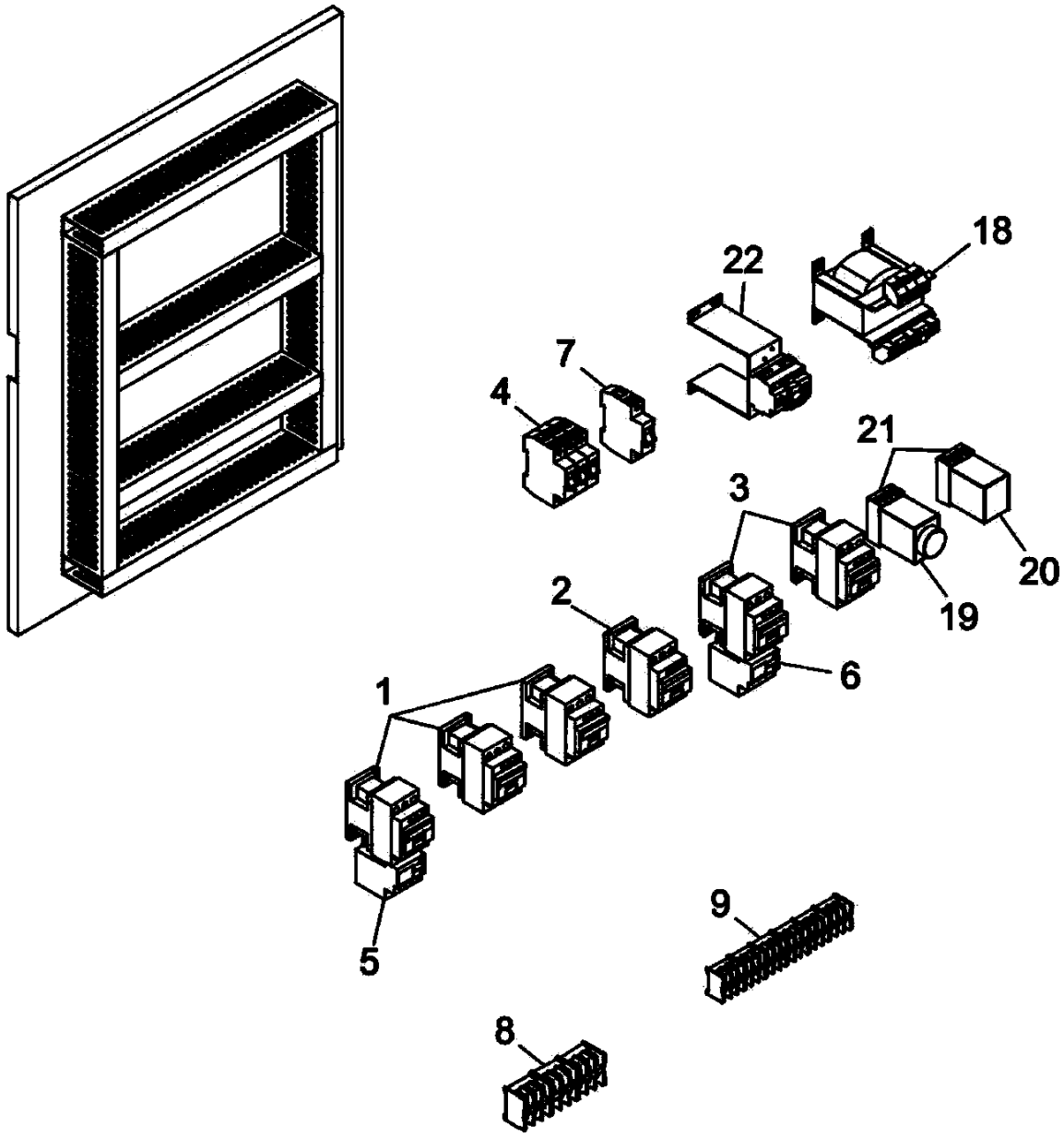
Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Chip Frame | | 1 |
| 2 | ** | Cover Seat | | 1 |
| 3 | ** | Wash | | 1 |
| 4 | ** | Hex. Socket Head Bolt | CAP M6x30L | 2 |
| 5 | ** | Hex. Socket Head Bolt | CAP M6x12L | 1 |
| 6 | ** | Dome Hexagon Screw | M5x8 | 4 |
| 7 | ** | Cover | | 1 |

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

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## Electrical Box Assembly – Exploded View



# JET GH-1640ZX | Stock JT1-3288

## Parts List P - Electrical Box Assembly

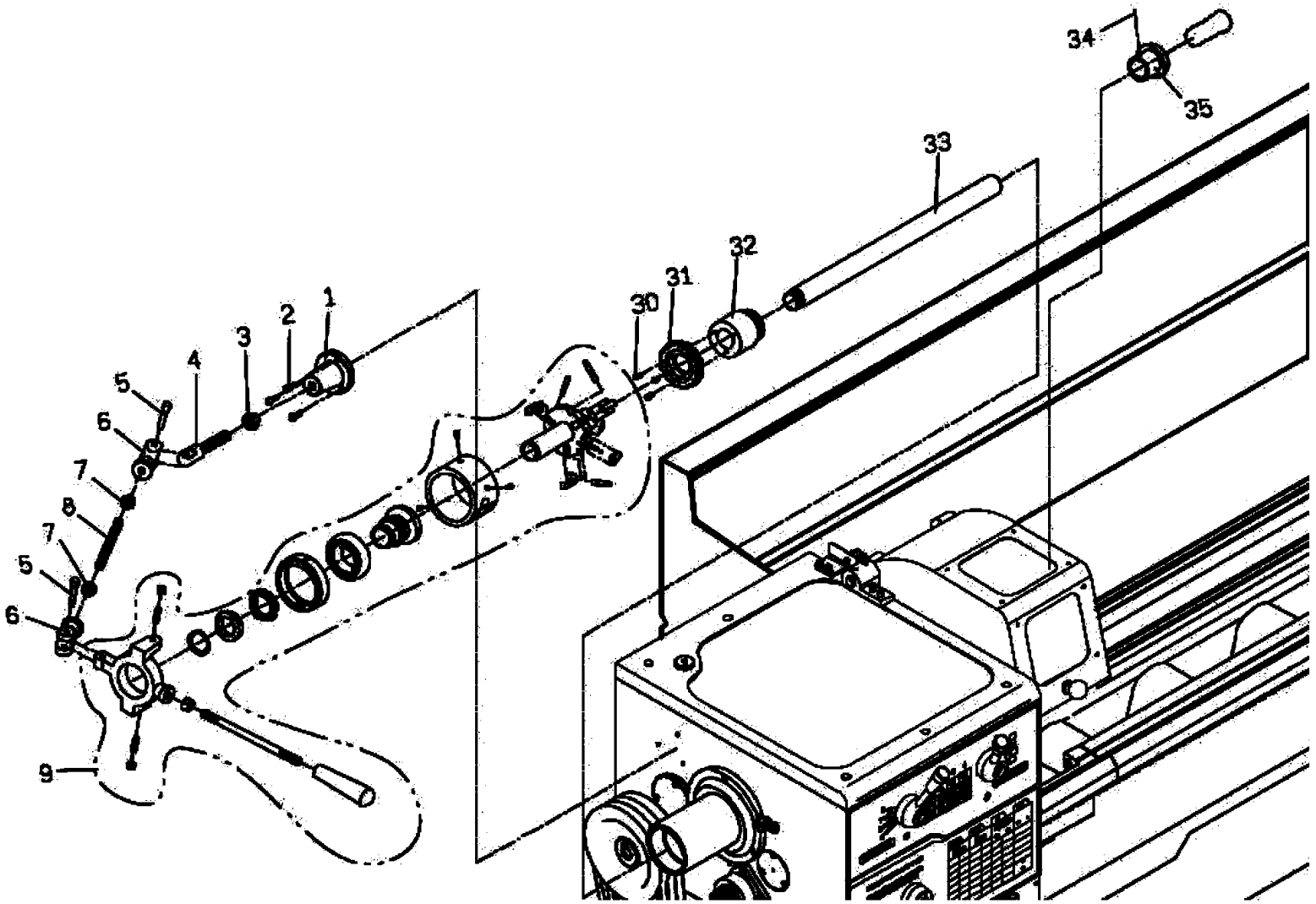
Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | AC Magnetic Switch | K1,K2,K6 LC1D32B7 | 3 |
| 2 | ** | AC Magnetic Switch | K5 LC1D18B7 | 1 |
| 3 | ** | AC Magnetic Switch | K3,K4 LC1D09B7 | 2 |
| 4 | JT1-3080 | Circuit Breaker | F1 FAZ-D32/3 | 1 |
| 5 | ** | Over Relay | F2 LR3D32 23A~32A | 1 |
| 6 | ** | Over Relay | F3 LR3D03 0.25A~0.4A | 1 |
| 7 | JT1-3072 | Circuit Breaker | F4 FAZ-D1/1 | 1 |
| 8 | ** | Terminal Board | TB1 IN30BK | 3 |
| 9 | ** | Terminal Board | TB2 MACK IN 13SBK(3P 20A) | 6 |
| 18 | ** | Transformer | T1 0V,220V,440V 140VA | 1 |
| 19 | ** | Multi-Range Analoge Timer | KT1 AH3-RC | 1 |
| 20 | ** | Amplifier | PU1 PU-NC | 1 |
| 21 | ** | Relay Seat | PF085A | 2 |
| 22 | ** | Door-Type Main Cam Switch | Q1 32A ,SE163003B+011/0001 | 1 |

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### 5C Collet Closer Assembly (Optional) – Exploded View




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# JET GH-1640ZX | Stock JT1-3288

## Parts List Q - C Collet Closer Assembly (Optional)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Bracket | CAP 6x25 | 1 |
| 2 | ** | Hex. Socket Head Bolt | | 3 |
| 3 | ** | Nut | M16 | 1 |
| 4 | ** | Bolt | | 1 |
| 5 | ** | Bolt | | 1 |
| 6 | ** | Connector Casting | | 1 |
| 7 | ** | Nut | W1⁄2" | 2 |
| 8 | ** | Screw | W1⁄2 x 155mm | 1 |
| | ** | Handle Casting | | 1 |
| | ** | Set Screw | SET M8x10 | 2 |
| | ** | Nut | M8 | 2 |
| | ** | Nut | 1⁄2" - 12UNC | 1 |
| | ** | Handle Rod | | 1 |
| | ** | Handle | | 1 |
| | ** | Clip | S34 | 1 |
| | ** | Washer | Ø52.4xØ34.4x9 | 1 |
| | ** | Nut | | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List Q - C Collet Closer Assembly (Optional) (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| | ** | Bearing And Retainer | | 1 |
| 9 | ** | Ball Bearing | 6208 | 1 |
| | ** | Cam | | 1 |
| | ** | Hex. Socket Head Bolt | CAP 4x8 | 3 |
| | ** | Collar | | 1 |
| | ** | Tube | | 1 |
| | ** | Finger | | 3 |
| | ** | Pivot Pin | Ø6x40 | 3 |
| | ** | Knob | | 1 |
| | ** | Steel Ball | Ø5 | 1 |
| | ** | Spring | | 1 |
| | ** | Pin | Ø5x18 | 1 |
| 30 | ** | Hex. Socket Head Bolt | CAP 5x12 | 3 |
| 31 | ** | Index Ring | | 1 |
| 32 | ** | Hub | | 1 |
| 33 | ** | Tube | | 1 |
| 34 | ** | Pin | | 1 |
| 35 | ** | Bush | | 1 |

** These parts are shown for reference only and are not available for order individually. Non-proprietary parts, such as fasteners, can usually be found at local hardware stores.

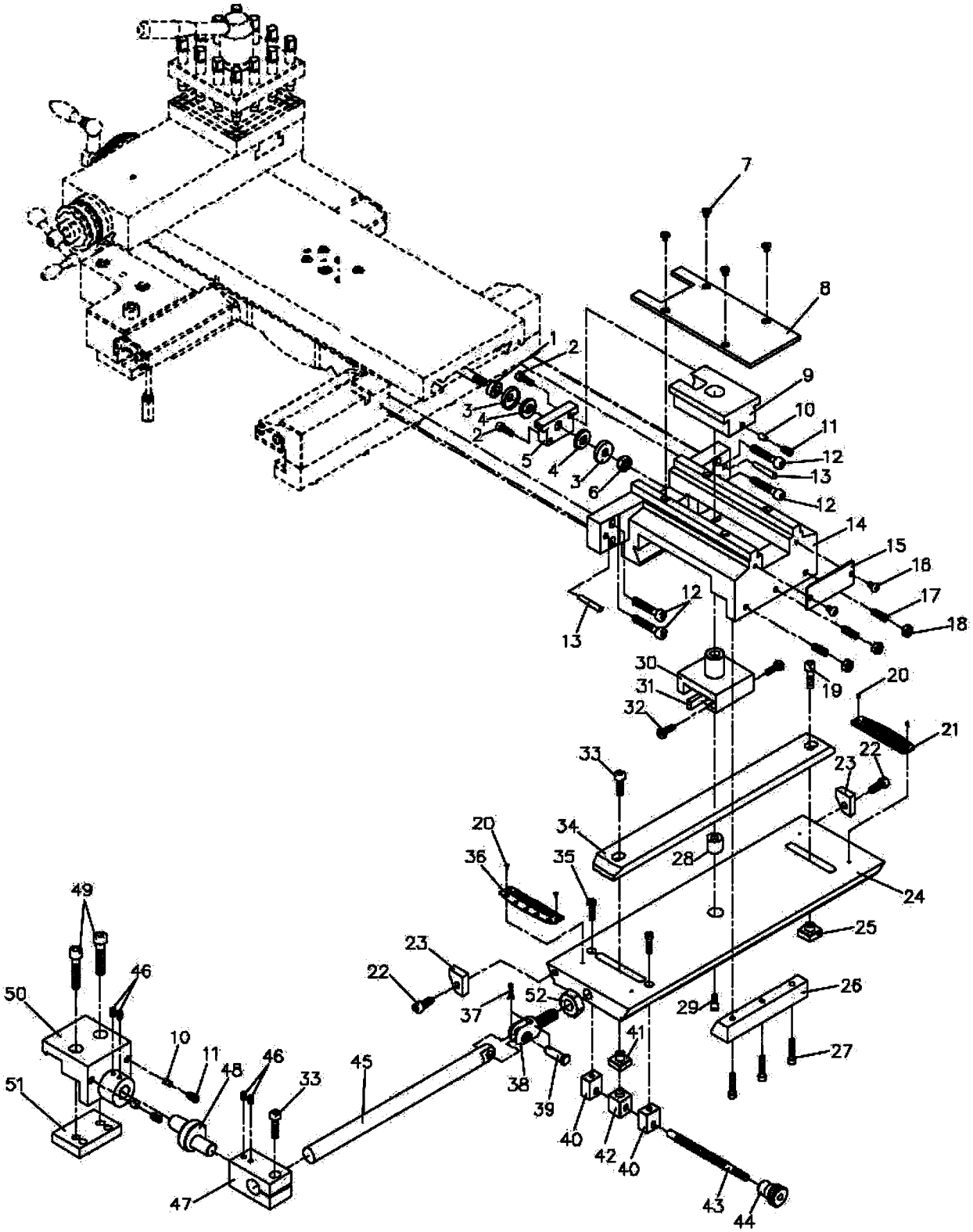
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# JET GH-1640ZX | Stock JT1-3288

## Diagram R - Taper Attachment Assembly (Optional)

Original JET parts reference | Match model, voltage and serial-number notes

### Taper Attachment Assembly (Optional) – Exploded View




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# JET GH-1640ZX | Stock JT1-3288

## Parts List R - Taper Attachment Assembly (Optional)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 1 | ** | Collar | | 1 |
| 2 | ** | Hex. Socket Head Bolt | CAP 6x20 | 2 |
| 3 | ** | Cap Collar | | 2 |
| 4 | ** | Thrust Bearing | NTB / AS2-1226 | 2 |
| 5 | ** | Yoke Plate | | 1 |
| 6 | ** | Nut | M12 | 1 |
| 7 | ** | Flat Hexagon Screw | M5x12 | 4 |
| 8 | ** | Cover Plate | | 1 |
| 9 | ** | Yoke | | 1 |
| 10 | ** | Copper Pin | | 3 |
| 11 | ** | Set Screw | M8x20 | 3 |
| 12 | ** | Hex. Socket Head Bolt | CAP 8x45 | 4 |
| 13 | ** | Taper Pin | #6x11⁄2" | 2 |
| 14 | ** | Main Bracket | | 1 |
| 15 | ** | Plate | | 1 |
| 16 | ** | Done Cross Screw | M6x10 | 2 |
| 17 | ** | Set Screw | M8x25 | 3 |
| 18 | ** | Hexagon Nut | M8 | 3 |
| 19 | ** | Hex. Socket Head Bolt | CAP 8x30 | 2 |
| 20 | ** | Rivet | Ø2 | 4 |
| 21 | ** | Name Plate | | 1 |
| 22 | ** | Hex. Socket Head Bolt | CAP 8x20 | 2 |
| 23 | ** | Stop | | 2 |
| 24 | ** | Plate | | 1 |
| 25 | ** | Nut | | 1 |
| 26 | ** | Gib | | 1 |

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# JET GH-1640ZX | Stock JT1-3288

## Parts List R - Taper Attachment Assembly (Optional) (continued)

Original JET parts reference | Match model, voltage and serial-number notes

| Ref. | Part number | Description | Size | Qty. |
|---|---|---|---|---|
| 27 | ** | Hex. Socket Head Bolt | CAP 6x30 | 3 |
| 28 | ** | Slide Pivot Pin | | 1 |
| 29 | ** | Hex. Socket Head Bolt | CAP 8x16 | 1 |
| 30 | ** | Side Block | | 1 |
| 31 | ** | Gib | | 1 |
| 32 | ** | Screw | | 1 |
| 33 | ** | Hex. Socket Head Bolt | CAP 8x25 | 2 |
| 34 | ** | Swive Slide | | 1 |
| 35 | ** | Hex. Socket Head Bolt | CAP 6x25 | 2 |
| 36 | ** | Name Plate | | 1 |
| 37 | ** | Split Pin | Ø2.5x16 | 1 |
| 38 | ** | Bolt | | 1 |
| 39 | ** | Pin | | 1 |
| 40 | ** | Block | | 2 |
| 41 | ** | Nut | | 1 |
| 42 | ** | Block | | 1 |
| 43 | ** | Screw | | 1 |
| 44 | ** | Knob | | 1 |
| 45 | ** | Bolt | | 1 |
| 46 | ** | Set Screw | M6x12 | 4 |
| 47 | ** | Bracket | | 1 |
| 48 | ** | Eccentric Pin | | 1 |
| 49 | ** | Hex. Socket Head Bolt | CAP 10x70 | 2 |
| 50 | ** | Bracket | | 1 |
| 51 | ** | Hub | | 1 |
| 52 | ** | Nut | M14 | 1 |

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