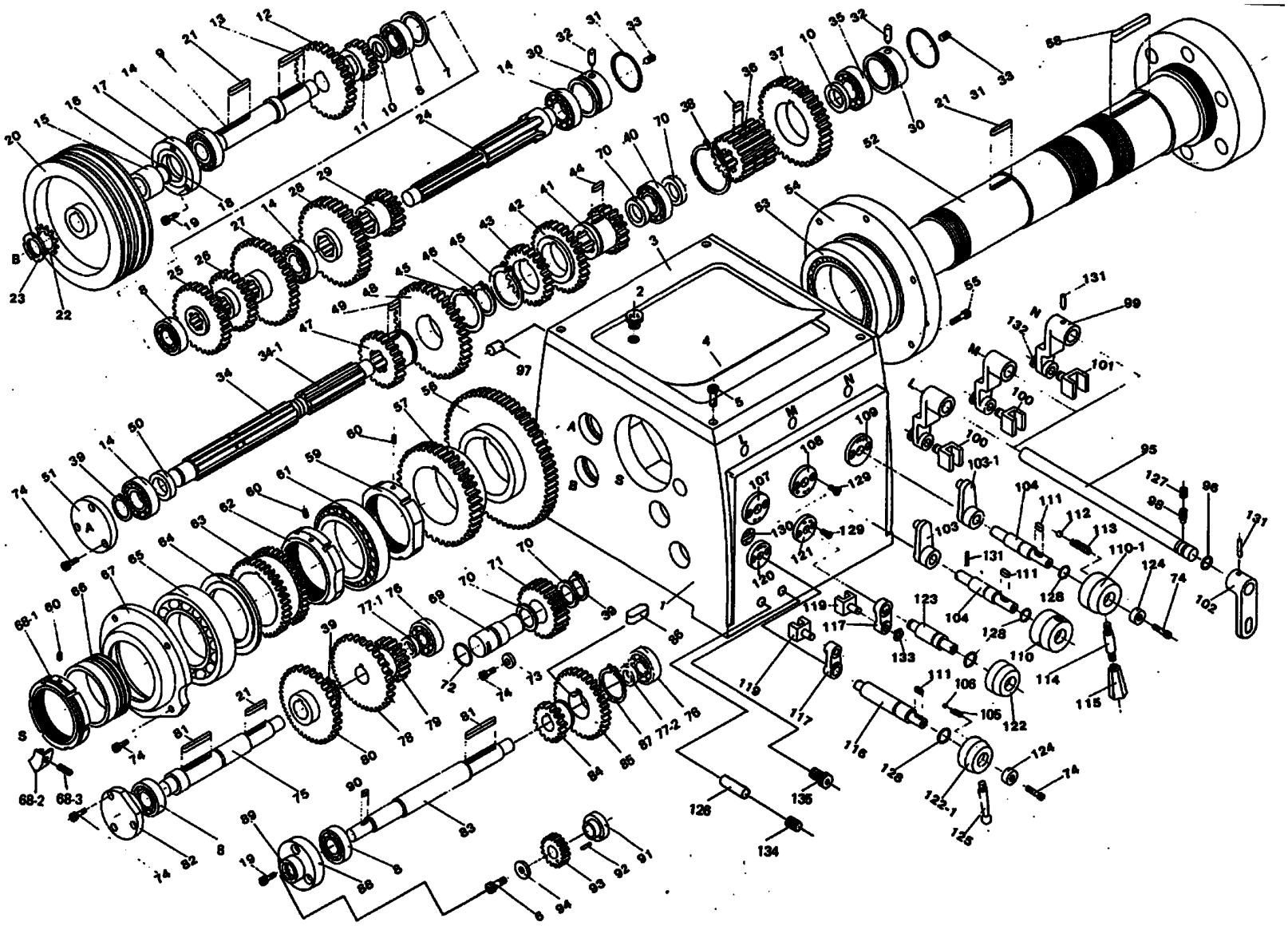
JET GH-2680ZH | Stock JT1-3315

Diagram A - Headstock Assembly

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



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Parts List A - Headstock Assembly

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

Ref.	Part number	Description	Size	Qty.
1	**	Headstock		1
2	**	Oil Plug		1
3	**	Headstock Cover		1
4	**	Blanket		1
5	**	Hex Socket Screw	M8 x P1.25 x 35L	4
7	**	Spacer		1
8	**	Ball Bearing	6205	1
9	**	Input Shaft		1
10	**	Spacer		2
11	**	Gear - i	20T	1
12	**	Gear - g	41T	1
13	**	Square Key	8x7x55L	1
14	**	Ball Bearing	6206	5
17	**	Housing		1
18	**	Oil Seal	TC30x50x8L	1
19	**	Hex Socket Screw	M6xP1.0x20L	6
20	**	Pulley wheel		1
21	**	Square key	8x7x45L	3
22	**	Spring-washer	M12	1
23	**	Screw	M12x30	1
24	**	Shaft-B		1
25	JT1-3086	Headstock gear #25	39T	1
26	JT1-3087	Headstock gear #26	32T	1
27	JT1-3088	Headstock gear #27	48T	1
28	**	Gear- k	46T	1
29	**	Gear- o	22T	1
30	**	Plug-cover		2
31	**	O-ring	P55x3.5	2

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Parts List A - Headstock Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
32	**	Fixed pin		2
33	**	Set screw		2
34	**	Shaft-A		1
34-1	**	Shaft-L		1
35	**	Ball-bearing	6305	1
36	**	Gear- l	25T	1
36-1	**	Square key	7x10x18L	2
37	**	Gear- m		1
38	**	Snap ring	S75	2
39	**	Snap ring	S30	3
40	**	Ball-bearing	6006	2
41	JT1-3089	Headstock gear #41		1
42	JT1-3090	Headstock gear #42		1
43	JT1-3091	Headstock gear #43		1
44	**	Square key	8x7x30L	1
45	**	Snap ring	S55	2
46	**	Snap ring	S38	2
47	**	Gear- h	30T	1
48	**	Gear- j	51T	1
49	**	Square key	8x7x25L	1
50	**	Spacer		1
51	**	Cover		1
52	**	Spindle	A1-11	1
	**	Spindle	D1-11	1
53	**	Taper roller bearing	32032	1
54	**	Cover		1
55	**	Hex Socket Screw	M6xP1.0x20L	6
56	**	Gear- p	95T	1

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JET GH-2680ZH | Stock JT1-3315

Parts List A - Headstock Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
57	**	Gear- n	72T	1
58	**	Square key	10x8x85L	1
59	**	Lock-nut		1
60	**	M8xP1.25x8L		5
61	**	Taper roller bearing	32030	1
62	**	Lock-nut		1
63	**	Gear	65T	1
64	**	Collar		1
65	**	Ball-bearing	6028	1
66	**	Oil return collar		1
67	**	Cover		1
68-1	**	Lock-nut		1
68-2	**	Balance piece		3
68-3	**	Set screw		6
69	**	Idle gear shaft		1
70	**	Spacer		4
71	**	Idle gear	34T	1
72	**	O-ring	P29	1
73	**	Washer		1
74	**	Hexagon socket screw	M6xP1.0x16L	16
75	**	Shaft-c		1
76	**	Ball-bearing	6304	2
77-1	**	Spacer		1
77-2	**	Spacer		1
78	**	Gear	42T	1
79	**	Gear	28T	1
80	**	Gear	65T	1
81	**	Square key	8x7x65L	2

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JET GH-2680ZH | Stock JT1-3315

Parts List A - Headstock Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
82	**	Cover		1
83	**	Shaft-D		1
84	**	Gear	42T	1
85	**	Gear	56T	1
86	**	Square key	8x7x20L	1
87	**	Snap ring	S45	1
88	**	Housing		1
89	**	Seal-oil	TC25x47x8L	1
90	**	Square key	6x6x12L	1
91	**	Collar		1
92	**	Taper pin	O#x25L	1
93	**	Gear		1
94	**	Washer		1
95	**	Shifting shaft		3
96	**	O-ring	P16	6
97	**	Plug		3
98	**	Set screw		3
99	**	Shifting lever		3
100	**	Shifting fork		1
101	**	Shifting fork		1
102	**	Shifting lever		3
103	**	Shifting lever		3
104	**	Shaft		3
105	**	Spring	D6xd0.8x25L	2
106	**	Ball steel	Ø1/4"	2
107	**	Detent plate		1
108	**	Detent plate		1
109	**	Detent plate		1

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JET GH-2680ZH | Stock JT1-3315

Parts List A - Headstock Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
110	**	Hub		2
110-1	**	Hub		1
111	**	Square key	5x5x15L	3
112	**	Ball steel	Ø5/16"	3
113	**	Spring	D8xd0.8x25L	1
	**	Spring	D8xd1.1x29L	2
114	**	Lever		3
115	**	Knob		3
116	**	Shaft		1
117	**	Shifting lever		2
119	**	Shifting fork		2
120	**	Detent plate		1
121	**	Detent plate		1
122	**	Knob		1
122-1	**	Knob		1
123	**	Shaft		1
124	**	Washer		5
125	**	Lever		2
126	**	Pin		2
127	**	Set screw	M8xP1.25x8L	3
128	**	O-ring	P18	5
129	**	Screw	M6xP1.0x14L	10
130	**	Lenz-oil	Ø 29	1
131	**	Spring pin	Ø5x30L	9
132	**	Snap ring	S12	3
133	**	Snap ring	S10	2
134	**	Set screw	M12xP1.75x20L	2
135	**	Hexagon socket screw	M8xP1.25x35L	2

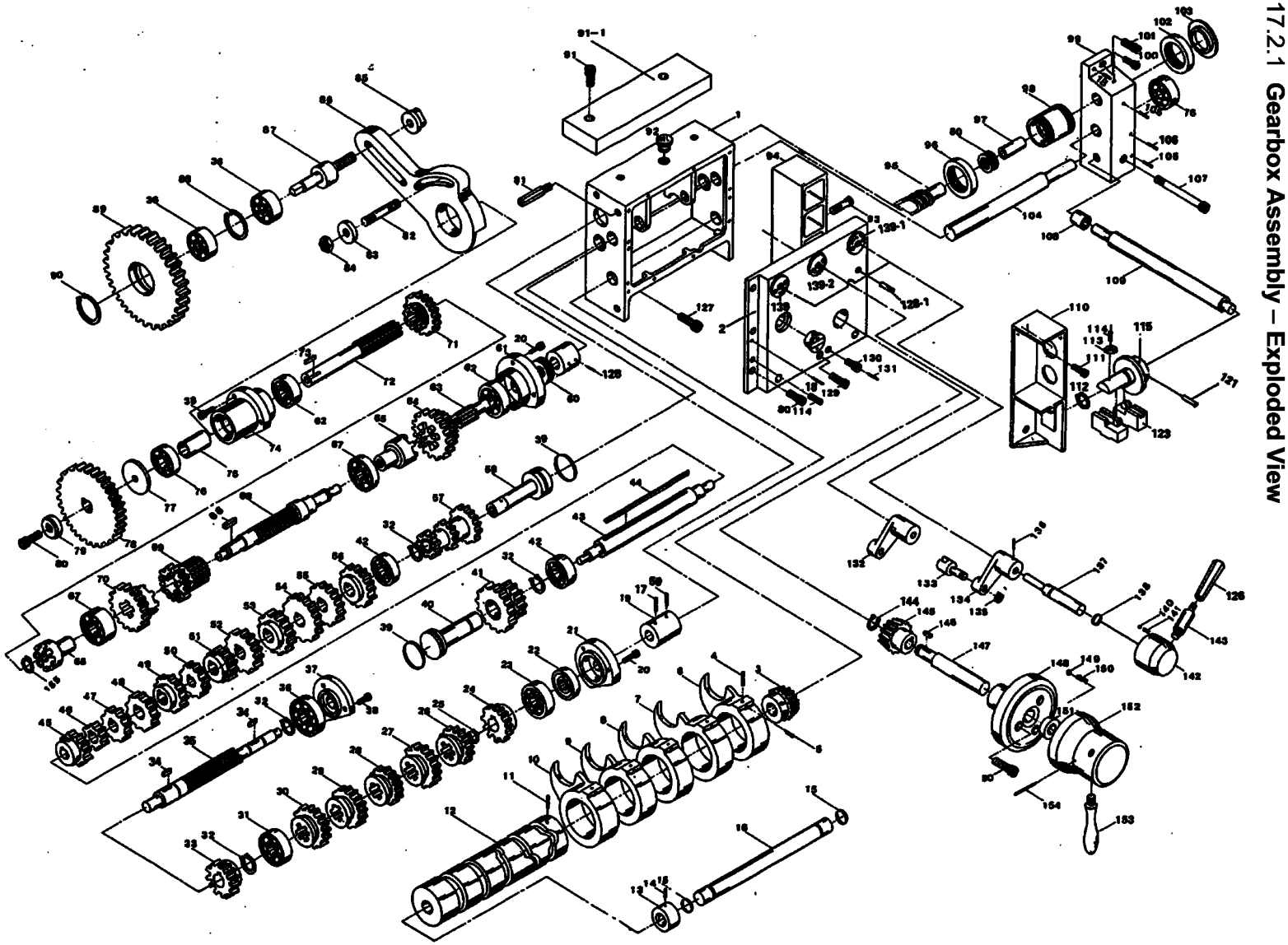
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Diagram B - Gearbox Assembly

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



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JET GH-2680ZH | Stock JT1-3315

Parts List B - Gearbox Assembly

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

Ref.	Part number	Description	Size	Qty.
1	**	Gear Box		1
2	**	Cover-gear box		1
3	**	Gear-driven bevel		1
4	**	Pin-fixed		5
5	**	Pin-split		5
6	**	Claw-shifter		1
7	**	Claw-shifter		1
8	**	Claw-shifter		1
9	**	Claw-shifter		1
10	**	Claw-shifter		1
11	**	Set screw	M8xP1.25x8L	1
12	**	Cam-shifter		1
13	**	Collar		1
14	**	Set-screw	M8x12	1
15	**	Ring-"O"	P18	2
16	**	Shaft-"A"		1
17	**	Pintaper	#4x38	2
18	**	Pintaper	#6x38	2
19	**	Collar-linkage		2
20	**	Hexagon socket screw	M6xP1.0x20L	6
21	**	Cap-right		1
22	**	Seal-oil	20x40x10L	1
23	**	Bearing-ball	6204	1
24	**	Gear-"B" shaft	36T	1
25	**	Snap ring	S25	2

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Parts List B - Gearbox Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
26	**	Gear-"B" shaft	22T	1
27	**	Gear-"B" shaft	22T	1
28	**	Gear-"B" shaft	33T	1
29	**	Gear-"B" shaft	22T	1
30	**	Gear-"B" shaft	22T	1
31	**	Bearing ball	6004	1
32	**	Snap ring	S20	2
	**	Snap ring	S18	2
33	**	Gear-"B" shaft	22T	1
34	**	Key-square	6x6x20L	2
35	**	Shaft-"B"		1
36	**	Bearing ball	6003	3
37	**	Cap-left		1
38	**	Hexagon socket screw	M6xP1.0x20L	6
39	**	Ring-"O"	P36	2
40	**	Shaft-"C"		1
41	**	Gear-“C” Shaft	20T.20T	1
42	**	Bearing	6203	2
43	**	Shaft-"D"		1
44	**	Key-square	6x6x146L	1
45	**	Gear-"D" shaft	19T	1
46	**	Gear-"D" shaft	18T	1
47	**	Gear-"D" shaft	20T	1
48	**	Gear-"D" shaft	22T	1
49	**	Gear-"D" shaft	23T	1

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Parts List B - Gearbox Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
50	**	Gear-"D" shaft	24T	1
51	**	Gear-"D" shaft	27T	1
52	**	Gear-"D" shaft	24T	1
53	**	Gear-"D" shaft	26T	1
54	**	Gear-"D" shaft	36T	1
55	**	Gear-"D" shaft	27T	1
56	**	Gear-"D" shaft	28T	1
57	**	Gear-"E" shaft	18T.36T	1
58	**	Shaft-"E"		1
59	**	Pin-taper	3x35	1
60	**	Bearing-thrust	51104	1
61	**	Cap		1
62	**	Bearing ball	6004V	2
63	**	Shaft-"F"		1
64	**	Gear-“F” shaft	35T.35T	1
65	**	Shaft-"F"		1
66	**	Square key	4x4x20L	2
67	**	Bearing ball	6005	2
68	**	Shaft-"G"		1
69	**	Gear-"G" shaft		1
70	**	Gear-"G" shaft	36T	1
71	**	Gear-"H" shaft	38T.19T	1
72	**	Shaft-"H"		1
73	**	Key-square	6x6x13L	1
74	**	Cap-bearing		1

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JET GH-2680ZH | Stock JT1-3315

Parts List B - Gearbox Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
75	**	Bushing-"H" shaft		1
76	**	Bearing ball	6004Z	2
77	**	Spacer		1
78	**	Gear-drive shaft	57T	1
79	**	Washer	M8	1
80	**	Hexagon socket screw	P1.25x16L	1
81	**	Bolt-lock end cover		1
82	**	Stud		1
83	**	Washer	5/8"	1
84	**	Nut	M16	1
85	**	Nut-lock stud		1
86	**	Quadrat		1
87	**	Stud-gear		1
88	**	Snap-ring	R40	1
89	**	Gear-quadrat		1
90	**	Snap ring	S18	1
91	**	Hexagon socket screw	M6xP1.0x25L	2
91-1	**	Cover		1
92	**	Plug-oil inlet		1
93	**	Hexagon socket screw	M6xP1.0x65L	2
94	**	Seat-pilot light		1
95	JT1-3092	Z axis leadscrew (in)		1
96	**	Nut-lock		1
97	**	Bushing-leadscrew		1
98	**	Plug-lead screw		1

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JET GH-2680ZH | Stock JT1-3315

Parts List B - Gearbox Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
99	**	Supporter for Lead Screw feed Rod		1
100	**	Plug-oil inlet		1
101	**	Hexagon socket screw	M8xP1.25x30L	1
102	**	Nut-lock		1
103	**	Plug-plastic		1
104	JT1-3093	Auto feeding rod		1
105	**	Hexagon socket screw	M6xP1.0x20L	2
106	**	Pin-taper	6x100L	1
107	**	Hexagon socket screw		1
108	**	Bushing spindle start rod		1
109	JT1-3094	Spindle starting rod		1
110	**	Seat-switch		1
111	**	Hexagon socket screw	M8xP1.25x25L	2
112	**	Snap ring	S30	1
113	**	Nut	M6xP1.0	1
114	**	Set screw	M6xP1.0x20L	1
115	**	Bracket		1
121	**	Pin	5x25L	1
122	**	Hexagon socket screw	M6xP1.0x8L	1
123	**	Switch		2
126	**	Knob		3
127	**	Screw Socket head cap	M10xP1.5x35L	4
128	**	Pin-taper	0x35	1
128-1	**	Pin-taper	6x45	1
129	**	Hexagon socket screw	M8xP1.25x40L	7

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Parts List B - Gearbox Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
130	**	Screw-taper, oil outlet	PT 3/8	1
132	**	Shifter	Shoe-shifter	1
133	**	Shoe-shifter		2
134	**	Shifter		1
135	**	Snap ring	S10	3
136	**	Pin-spring	5x25	3
137	**	Shaft-shifter		3
138	**	Ring-"O"	P12	3
139	**	Detent plate		1
139-1	**	Detent plate		1
139-2	**	Detent plate		1
140	**	Ball steel	1/4	3
141	**	Spring	1x6x30L	3
142	**	Hub		3
143	**	Lever		3
144	**	Snap ring	S15	1
145	**	Gear-drive bevel		1
146	**	Key-square	5x5x25L	1
147	**	Shaft-bevel gear		1
148	**	Seat-gear shifting		1
149	**	Ball steel	5/16	2
150	**	Spring	1x6x22L	2
151	**	Seal-oil	25x35x10L	1
152	**	Hub		1
153	**	Handle		3
154	**	Pin	5x50	1

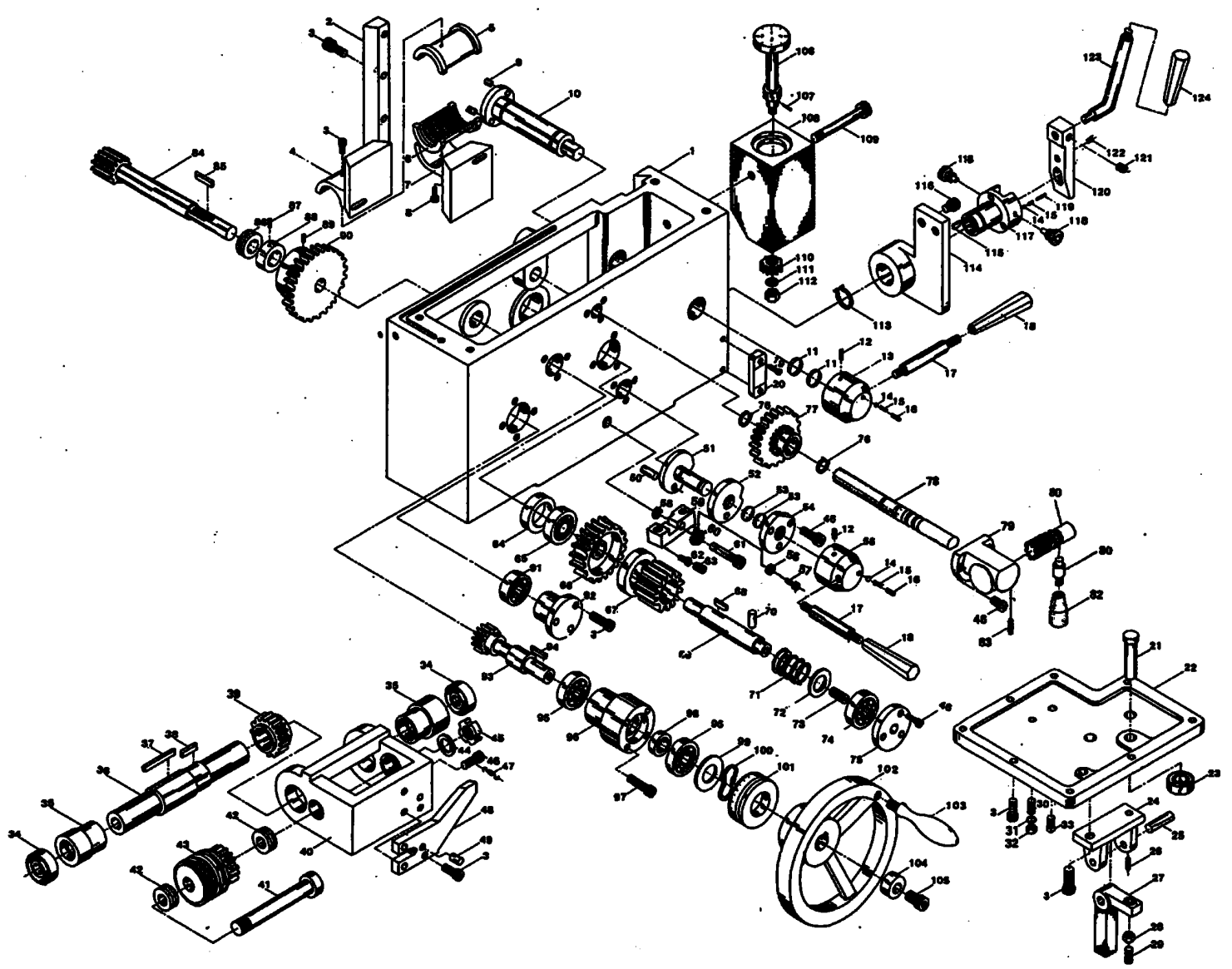
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Diagram C - Apron Assembly

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



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JET GH-2680ZH | Stock JT1-3315

Parts List C - Apron Assembly

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

Ref.	Part number	Description	Size	Qty.
1	**	Body-Apron (right hand)		1
	**	Body-Apron (left hand)		1
2	**	Gib		1
3	**	Hexagon socket screw	M6xP1.0x20L	17
4	**	Holder-half nut (right)		1
	**	Holder-half nut (left)		1
5	JT1-3096	Nut-half		1
6	JT1-3096	Nut-half		1
7	**	Holder-half nut		1
8	**	Hexagon socket screw	M6xP1.0x16L	1
9	**	Pin-sliding		2
10	**	Shaft-half nut (right)		1
	**	Shaft-half nut (left)		1
11	**	Ring-O	P26	2
12	**	Set screw	M12xP1.75x20L	2
13	**	Hub (right)		1
	**	Hub (left)		1
14	**	Ball-steel	1/4"	4
15	**	Spring	Ø 1x6x30L	3
16	**	Set screw	M8xP1.25x10L	2
17	**	Lever		2
18	**	Knob		2
19	**	Hexagon socket screw	M10xP1.5x25L	2
20	**	Lenx-oil	CTA-8	1
21	**	Shaft-auto stop		1
22	**	Cover-bottom apron		1

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JET GH-2680ZH | Stock JT1-3315

Parts List C - Apron Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
23	**	Seal-oil	15x25x7	1
24	**	Seat-tappet		1
25	**	Shaft-tappet		1
26	**	Set screw	M6xP1.0x16L	2
27	**	Tappet		1
28	**	Nut	M8xP1.25	1
29	**	Set screw	M8xP1.25x30L	1
30	**	Set screw	M6xP1.0x40L	1
31	**	Ring-O	P6	1
32	**	Nut	M6xP1.0	1
33	**	Screw-oil leakage	PT1/4	1
34	JT1-3097	Apron- oil seal	34x45x11L	1
35	JT1-3098	Apron- bushing		2
36	JT1-3099	Apron- sleeve feed rod+pin		1
37	JT1-3099	Apron- sleeve feed rod+pin	6x6x42L	1
38	**	Key-square	6x6x12L	1
39	**	Gear		1
40	**	Seat-worm		1
41	**	Shaft-worm		1
42	**	Bearing-thrust	2904	2
43	**	Worm gear		1
44	**	Washer-lock	20	1
45	**	Nut		1
46	**	Hexagon socket screw	M6xP1.0x12L	8
47	**	Spring,Ø 1x10x60L (right)		1
	**	Spring,Ø 1x10x60L (left)		1

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JET GH-2680ZH | Stock JT1-3315

Parts List C - Apron Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
48	**	Block-safe device (right)		1
	**	Block-safe device (left)		1
49	**	Pin	5x18L	2
50	**	Pin		1
51	**	Shaft-auto feed (right)		1
	**	Shaft-auto feed (left)		1
52	**	Collar		1
53	**	Ring-O	P16	2
54	**	Cover		1
55	**	Hub (right)		1
	**	Hub (left)		1
56	**	Spring washer	M12	1
57	**	Hexagon socket screw	M8xP1.25x12L	1
58	**	Snap ring	S10	1
59	**	Lever		1
60	**	Spring washer	M12	1
61	**	Screw		1
62	**	Hexagon socket screw	M5xP0.8x20L	1
63	**	Spring		1
64	**	Spacer		1
65	**	Bearing ball	6005V	1
66	JT1-3100	Apron- worm gear		1
67	**	Wheel-friction		1
68	**	Key-square	7x7x12L	1
69	**	Shaft-worm wheel		1
70	**	Pin		1

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JET GH-2680ZH | Stock JT1-3315

Parts List C - Apron Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
71	**	Spring, compressing		1
72	**	Washer		1
73	**	Screw-hexa. Socket Headless set		1
74	**	Bearing ball	6204	1
75	**	Cover		1
76	**	Snap ring	S20	2
77	**	Gear		1
78	**	Shaft-cross feed		1
79	**	Set (right)		1
80	**	Set (left)		1
81	**	Shaft-lever		1
82	**	Lever		1
83	**	Screw-hexa. Socket Headless set		1
84	JT1-3101	Apron- Pinion		1
85	**	Key-square	6x6x20L	1
86	**	Bering-middle	NK20/22	1
87	**	Set screw	M6xP1.0x10L	1
88	**	Collar		1
89	**	Pin-spring	6x36L	1
90	**	Gear		1
91	**	Bearing ball	6003	1
92	**	Cover		1
93	**	Pinion-handwheel		1
94	**	Key-square	6x6x25L	1
95	**	Bearing ball	6004V	2
96	**	Seat		1

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JET GH-2680ZH | Stock JT1-3315

Parts List C - Apron Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
97	**	Hexagon socket screw	M5xP0.8x20L	4
99	**	Washer		1
100	**	Washer-wave type		1
101	**	Dial-rack		1
102	**	Handwheel		1
103	**	Handle		1
104	**	Washer-lock		1
105	**	Hexagon socket screw	M8xP1.25x20L	1
106	**	Dial-thread chasing		1
107	**	Pin		1
108	**	Seat-dial shaft		1
109	**	Hexagon socket screw	M10xP1.25x65L	1
110	JT1-3102	Apron- gear	16T	1
111	**	Washer-spring	10	1
112	**	Nut	M10xP1.5	1
113	**	Snap ring	S30	1
114	**	Seat-switch		1
115	**	Key-square	6x8x25L	1
116	**	Hexagon socket screw	M8xP1.25x16L	2
117	**	Bracket		1
118	**	Screw-lock		2
119	**	Screw-hexa. Socket Headless cap		1
120	**	Seat-lever		1
121	**	Set screw	M8xP1.25x8L	2
122	**	Spring		1
123	**	Lever		1
124	**	Sleeve-lever		1

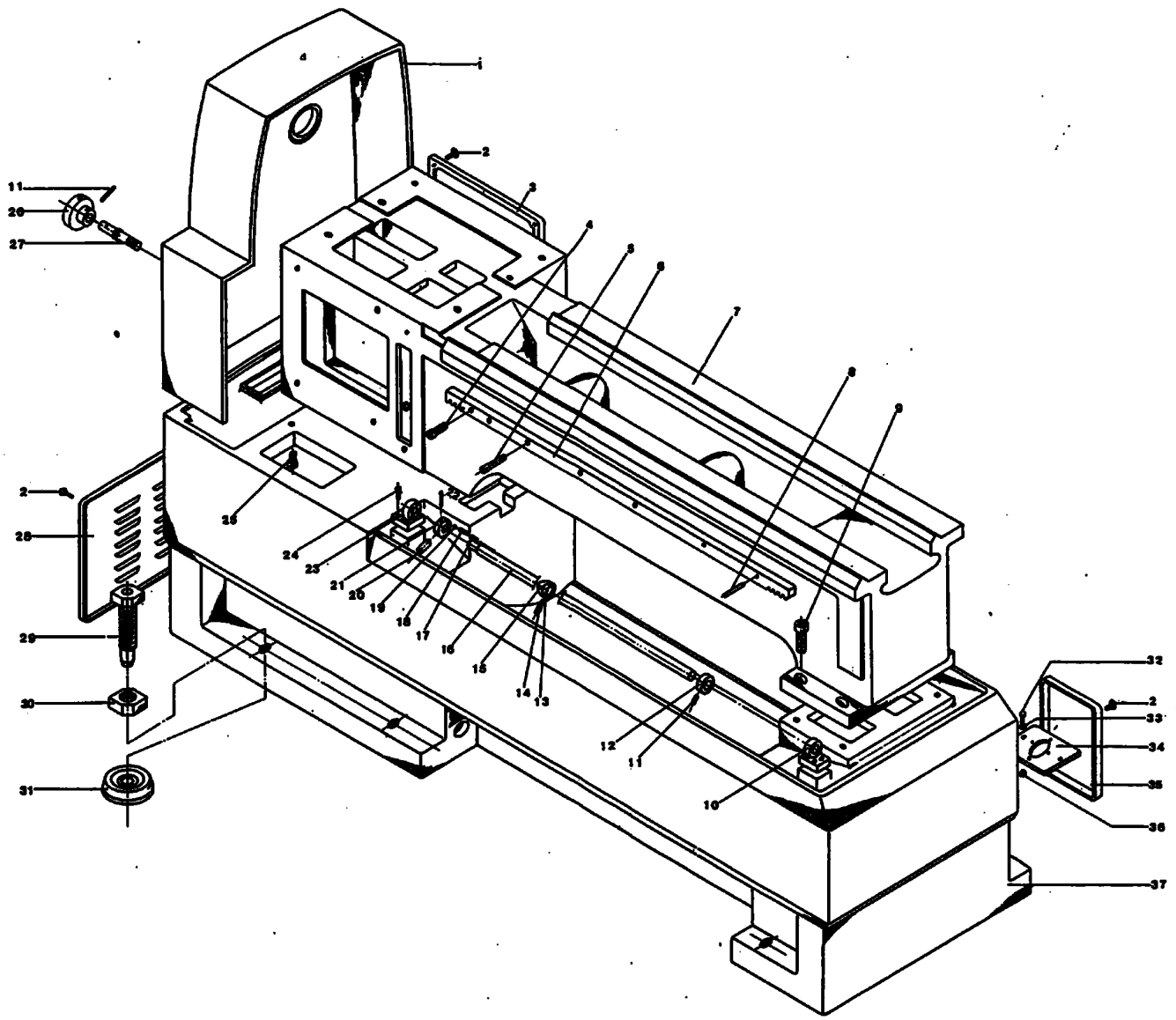
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JET GH-2680ZH | Stock JT1-3315

Diagram D - Bed & Base Assembly

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



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JET GH-2680ZH | Stock JT1-3315

Parts List D - Bed & Base Assembly

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

Ref.	Part number	Description	Size	Qty.
1	**	Cover-end		1
2	**	Head	M6xP1.0x20L	12
3	**	Cover-electric box		1
4	**	Hexagon socket screw	M6xP1.0x25L	10
5	**	Pin-taper	6x35	2
6	JT1-3103	Z axis rack set		1
7	**	Bed		1
9	**	Hexagon socket screw	M16xP2.0x45L	4
10	**	Supporter-shaft		1
11	**	Set screw	M6xP1.0x10L	2
12	**	Collar		1
13	**	Shoe-brass		4
14	**	Set screw	M6xP1.0x6L	1
15	**	Cam-auto feed stopping		4
16	**	Shart-auto stopping		1
17	**	Set screw	M8xP1.25x8L	1
18	**	Spring	1x6x10L	1
19	**	Ball steel	1/4"	1

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JET GH-2680ZH | Stock JT1-3315

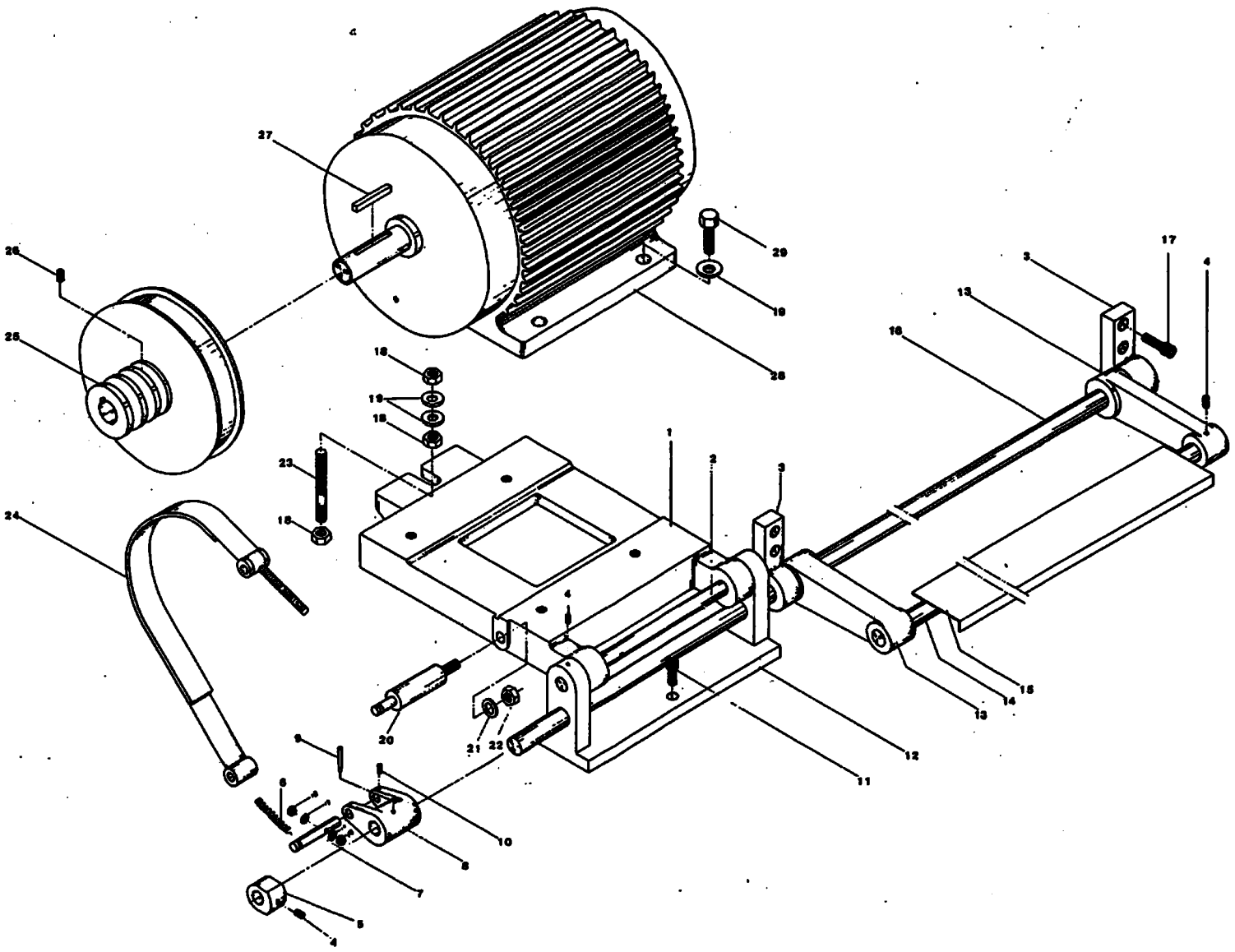
Parts List D - Bed & Base Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
20	**	Lever-turning shaft		4
21	**	Collar		1
22	**	Set screw	M8xP1.25x10L	1
23	**	Supporter-shaft		1
24	**	Hexagon socket screw	M8xP1.25x16L	4
25	**	Hexagon socket screw	M16xP2.0x55L	8
26	**	Plug		1
27	**	Bolt-lock		1
28	**	Cover-motor seat		2
29	**	Bolt-set machine		6
30	**	Nut-lock		6
31	**	Block-leveling		6
32	**	Bolt-hexa. head	M8x38	2
33	**	Washer	W5/8"	2
34	**	Seat-coolant pump		1
35	**	Cover-coolant motor seat		1
36	**	Nut-lock	M8	2
37	**	Base		1

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JET GH-2680ZH | Stock JT1-3315

Parts List E - Brake System Assembly

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

Ref.	Part number	Description	Size	Qty.
1	**	Seat-motor		1
2	**	Shaft-motor seat		1
3	**	Block		2
4	**	Set screw	M6xP1.0x12L	1
5	**	Cam		1
6	**	Spring		1
7	**	Shaft-brake belt		1
8	**	Arm-brake		1
9	**	Pin-taper	4x38L	1
10	**	Set screw	M6xP1.0x10L	1
11	**	Hexagon socket screw	M10xP1.5x30L	3
12	**	Bracket-motor seat		1
13	**	Bracket-pedal		2
15	**	Pedal-brake		1
16	**	Shaft-pedal bracket		1
17	**	Hexagon socket screw	M8xP1.25x25L	4
18	**	Nut	M16	6
19	**	Washer	M16	4
20	**	Bolt-adjusting		1
21	**	Washer	M12	1
22	**	Nut	M12	1
23	**	Bolt-adjusting		1
24	JT1-3105	Belt-brake	15HP	1
25	**	Belt pulley		1
27	**	Key	7x7x55L	1
28	**	Motor		1
29	**	Bolt-hexa. Head	M10x30L	4

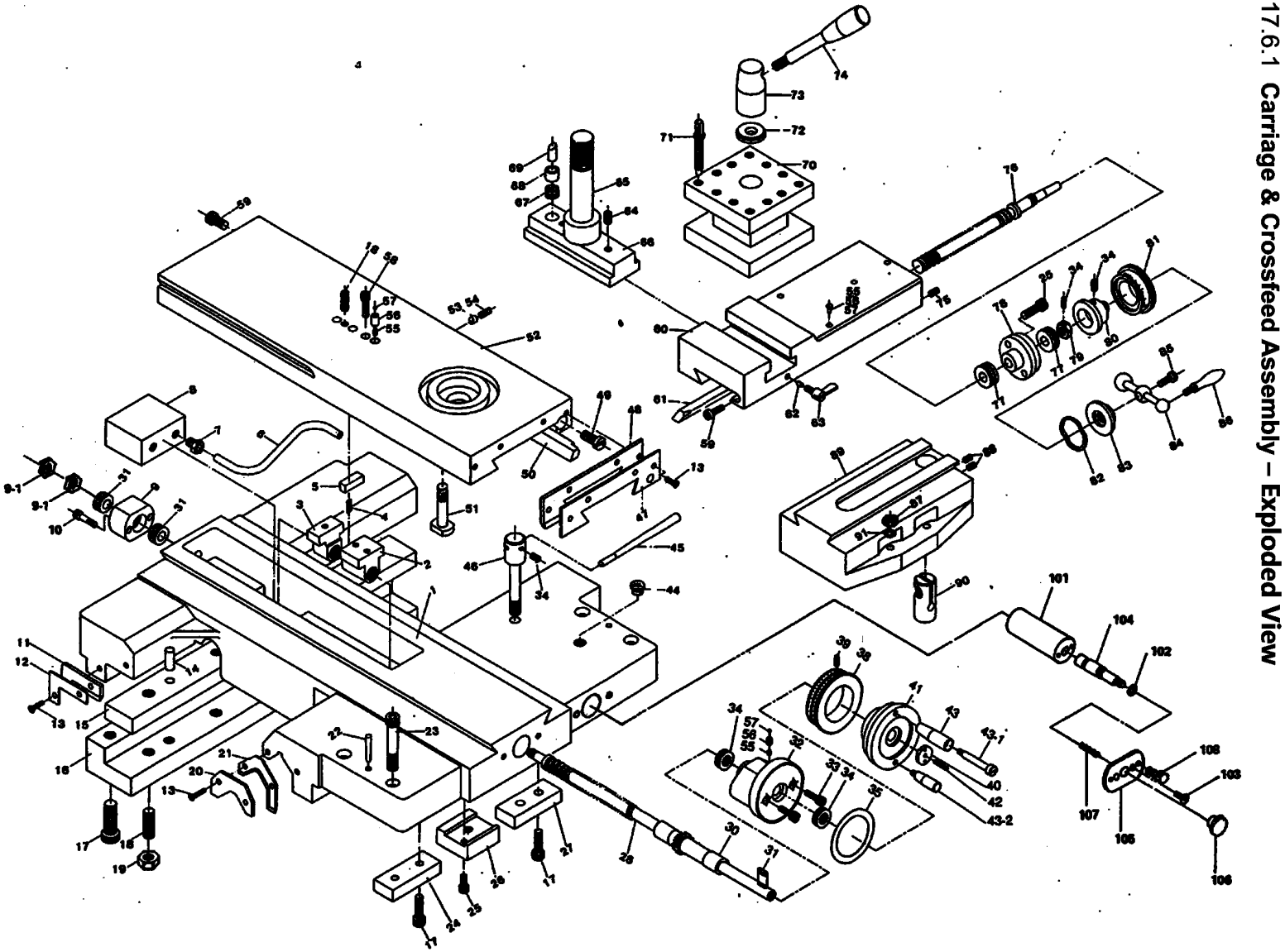
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JET GH-2680ZH | Stock JT1-3315

Diagram F - Carriage & Crossfeed Assembly

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



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JET GH-2680ZH | Stock JT1-3315

Parts List F - Carriage & Crossfeed Assembly

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

Ref.	Part number	Description	Size	Qty.
1	**	Carriage		1
2	JT1-3104	Cross slide screw and nut set (in)		1
3	JT1-3104	Cross slide screw and nut set (in)		1
4	**	Spring	1x5x25L	1
5	**	Shim-crossfeed nut		1
6	**	Pipe-lubrication oil		1
7	**	Nut-copper		1
8	**	Conveyor-oil		1
9	**	Cap-crossfeed screw		1
9-1	**	Nut-hexa. head	M12xP1.25	2
10	**	Hexagon socket screw	M6xP1.0x25L	2
11	JT1-3095	Wiper (Z axis)		1
12	JT1-3095	Wiper (Z axis)		1
13	**	Screw-cross-recessed	M4xP0.7x10L	8
14	**	Pin		2
15	**	Gib		1
16	**	Holder-gib		1
17	**	Hexagon socket screw	M8xP1.25x25L	4
18	**	Set screw	M8xP1.25x25L	4
19	**	Nut	M8xP1.25	4
20	JT1-3095	Wiper (Z axis)		1
21	JT1-3095	Wiper (Z axis)		1
22	**	Pin-taper	6#75L	2
23	**	Hexagon socket screw	M10xP1.5x70L	4
24	**	Gib-left-front		1

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JET GH-2680ZH | Stock JT1-3315

Parts List F - Carriage & Crossfeed Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
25	**	Set screw	M6xP1.0x16L	3
26	**	Clamp-carriage		1
27	**	Gib-right-front		1
28	JT1-3104	Cross slide screw and nut set (in)		1
30	JT1-3106	Cross slide -pinion		1
31	JT1-3107	Bearing	51101	11
32	**	Bracket		1
33	**	Bolt-hexa. Socket	M8xP1.25x40L	2
34	JT1-3108	Bearing	51104	1
35	**	Washer-wave type	6210	1
36	**	Set screw	M6xP1.0x10L	1
37	**	Clutch-dial		1
38	**	Dial-crossfeed		1
39	**	Hexagon socket screw	M6xP1.0x15L	2
40	**	Nut-lock clutch		1
41	**	Handle		1
42	**	Screw-adjusting	M6xP1.0x30L	1
43	**	Knob-handle		1
43-1	**	Screw-handle		1
43-2	**	Knob-handle		1
44	**	Plug-oil inlet		1
45	**	Lever		1
46	**	Screw-carriage clamp		1
47	**	Case-wiper		1
48	**	Wiper		1
49	**	Screw-adjusting		1

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JET GH-2680ZH | Stock JT1-3315

Parts List F - Carriage & Crossfeed Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
50	JT1-3110	X axis Gib		1
51	JT1-3109	Special bolt		4
52	**	Cover-cross sliding		1
53	**	Shoe-clamp		1
54	**	Set screw	M6xP1.0x20L	1
55	**	Spring		5
56	**	Sleeve		5
57	**	Ball-steel	1/4"	5
58	**	Hexagon socket screw	M6xP1.0x20L	3
59	**	Screw-gib		2
60	**	Compound rest		1
61	JT1-3111	Gib-compound rest		1
62	**	Shoe-clamp		1
63	**	Screw-clamp		1
64	**	Hexagon socket screw	M8xP1.25x10L	4
65	**	Shaft-tool post		1
65-1	**	Shaft-tool post		1
66	**	Block-tee		1
67	**	Spring	1x8x20L	1
68	**	Sleeve		1
69	**	Button		1
70	**	Tool post-square		1
71	**	Screw-square head		1
72	**	Bearing-thrust		1
73	**	Knob-lever		1

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JET GH-2680ZH | Stock JT1-3315

Parts List F - Carriage & Crossfeed Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
74	**	Lever		1
75	**	Screw-gib	M8xP1.25x30L	1
76	JT1-3112	Compound rest screw and nut set		1
77	**	Bearing thrust	51102	2
78	**	Seat-compound rest screw		1
79	**	Nut		1
80	**	Collar		1
81	**	Dial-compound rest		1
82	**	Washer-wave type		1
83	**	Nut		1
84	**	Handle		1
85	**	Hexagon socket screw	M6xP1.0x16L	1
86	**	Knob-handle		1
87	**	Nut	M10xP1.5	4
88	**	Set screw	M8xP1.25x8L	2
89	**	Swivel		1
90	JT1-3112	Compound rest screw and nut set		1
91	**	Spring washer	M10	4
101	**	Body-pump		1
102	**	Ring-O	PA10	1
103	**	Screw	M5xP0.8x12L	2
104	**	Rod-pump		1
105	**	Stopper		1
106	**	Plug		1
107	**	Spring-compressing	Ø1.2x10x63L	1
108	**	Hex Socket Head Screw	M6x10L	2

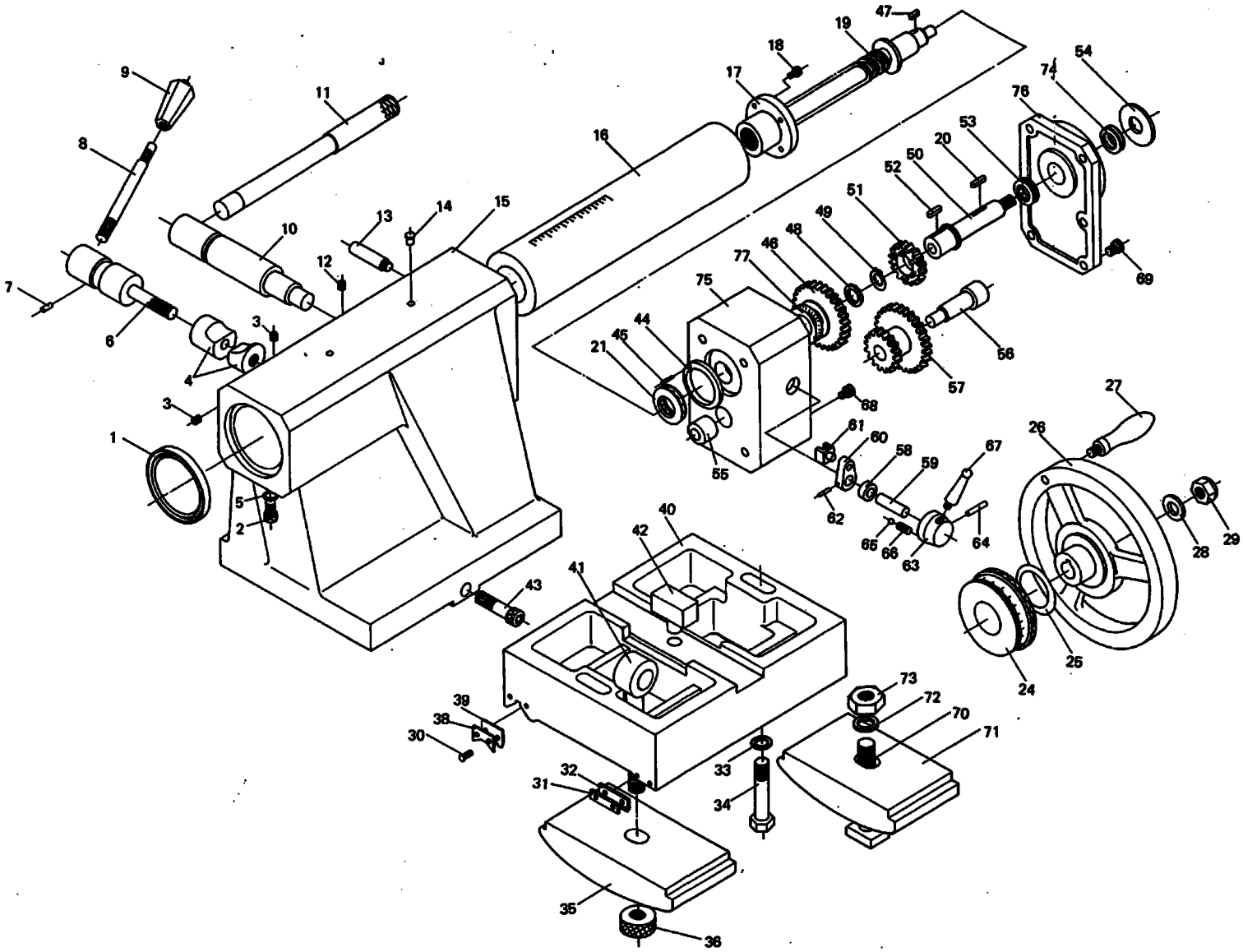
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Diagram G - Tailstock Assembly

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



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JET GH-2680ZH | Stock JT1-3315

Parts List G - Tailstock Assembly

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

Ref.	Part number	Description	Size	Qty.
1	**	Seal-oil	TC75x90x8	1
2	**	Hexagon socket screw	M8xP1.25x10L	1
3	**	Set screw	M6xP1.0x12L	1
4	**	Block-clamp		1
5	**	Spring washer	M12	1
6	**	Shaft-clamp spindle		1
7	**	Pin	5x12	2
8	**	Lever		1
9	**	Sleeve-lever		1
10	**	Shaft-clamp bottom		1
11	**	Lever		1
12	**	Set Screw	M6xP1.0x20L	1
13	**	Screw-brake		1
14	**	Plug-oil	1/4"	3
15	**	Body-tailstock		1
16	JT1-3113	Tailstock-tang slot		1
17	JT1-3114	Tailstock- screw and nut set		1
18	**	Hexagon socket screw	M6xP1.0x16L	4
19	JT1-3114	Tailstock- screw and nut set		1
20	**	Key-square	6x6x25	1
21	**	Bearing-thrust	51205	1
24	**	Dial-feed		1
25	**	Washer-wave type	WW-46	2
26	**	Handwheel		1

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JET GH-2680ZH | Stock JT1-3315

Parts List G - Tailstock Assembly (continued)

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

Ref.	Part number	Description	Size	Qty.
27	**	Knob		1
28	**	Washer	W1/2"	1
29	**	Nut	1/2"-20UNF	1
30	**	Screw-cross-recessed	M4xP0.7x10L	8
31	JT1-3095	Wiper (Z axis)		1
32	JT1-3095	Wiper (Z axis)		1
33	**	Washer-flat	M12	2
34	**	Bolt-clamp	M12xP1.75.75L	2
35	**	Clamp		1
36	**	Nut		1
38	JT1-3095	Wiper (Z axis)		1
39	JT1-3095	Wiper (Z axis)		1
40	**	Bottom-tailstock		1
41	JT1-3115	Tailstock- bolt		1
42	**	Block-adjusting		1
43	**	Hexagon socket screw	M10xP1.5x80L	2
44	**	Socket washer		1
45	**	Pin ,	Ø4x22.5L	1
46	**	Clutch shaft		1
47	**	Square key	5x5x10L	1
48	**	Washer		1
49	**	Snap ring	S18	1
50	**	Clutch shaft		1
51	**	Gear		1
52	**	Square key	5x5x25	1

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Parts List G - Tailstock Assembly (continued)

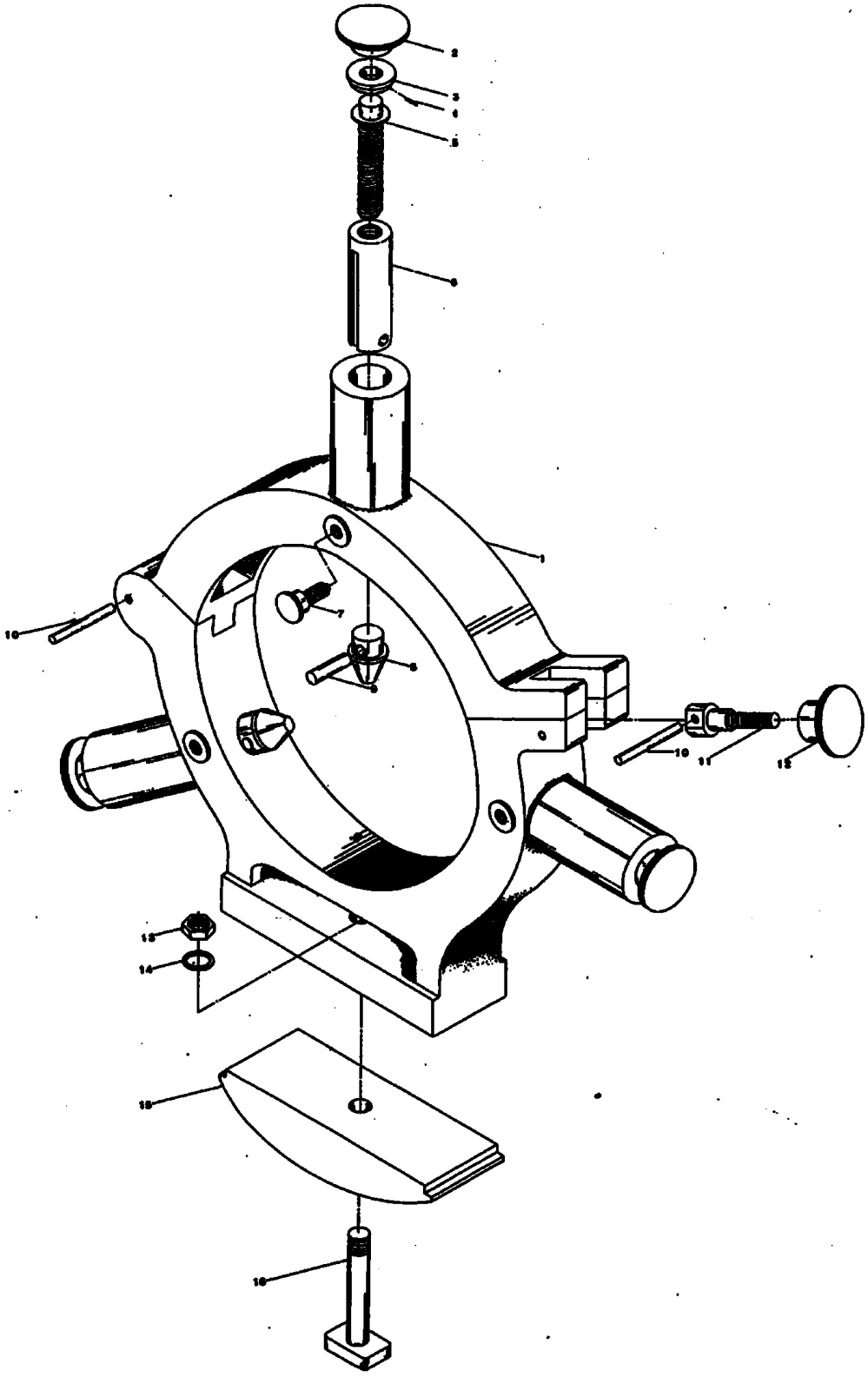
Original JET parts reference | Match model, voltage and serial-number notes

Ref.	Part number	Description	Size	Qty.
53	**	Thrust bearing	51104	1
54	**	Washer		1
55	**	Spacer		1
56	**	Idle shaft		1
57	**	Gear		1
58	**	Spacer		1
59	**	Shaft		1
60	**	Shifting lever		1
61	**	Shifting fork		1
62	**	Spring pin	Ø4x25L	1
63	**	Knob		1
64	**	Spring pin	Ø5x38L	1
65	**	Ball steel	Ø1/4"	1
66	**	Spring	D6xd1x20L	1
67	**	Lever		1
68	**	Hexagon socket screw	M8xP1.25x25L	4
69	**	Hexagon socket screw	M6xP1.0x16L	6
70	**	Bolt clamp		1
71	**	Clamp		1
72	**	Washer	W3/4	1
73	**	Nut	W3/4-10NC	1
74	**	Ball bearing	6004	1
75	**	Shifting box		1
76	**	Shifting cover		1
77	**	Bearing thrust		1

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17.8.1 Steady Rest Assembly – Exploded View



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Parts List H - Steady Rest Assembly

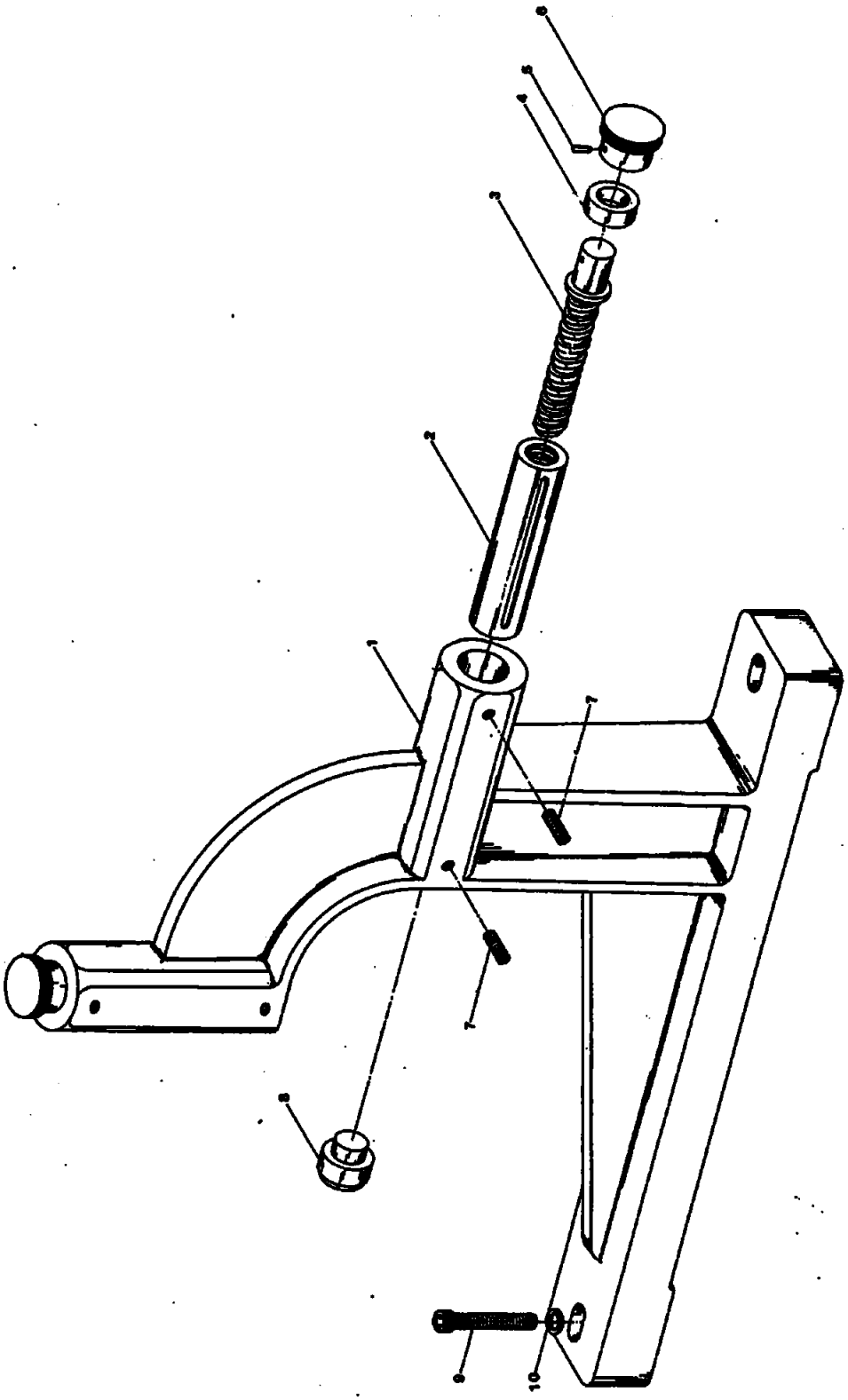
Original JET parts reference | Match model, voltage and serial-number notes

Ref.	Part number	Description	Size	Qty.
1	**	Steady-rest		1
2	**	Plug-lead screw		3
3	**	Cap	6x52L	3
4	**	Pin		3
5	**	Lead-screw		3
6	**	Nut-lead screw		3
7	**	Screw-fixed		3
8	**	Jaw		3
9	**	Pin-fixed		3
10	**	Pin	9x25L	2
11	**	Screw		1
12	**	Plug		1
13	**	Nut	W5/8"	1
14	**	Washer		1
15	**	Block-clamp		1
16	**	Bolt		1

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17.9.1 Follow Rest Assembly – Exploded View



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JET GH-2680ZH | Stock JT1-3315

Parts List I - Follow Rest Assembly

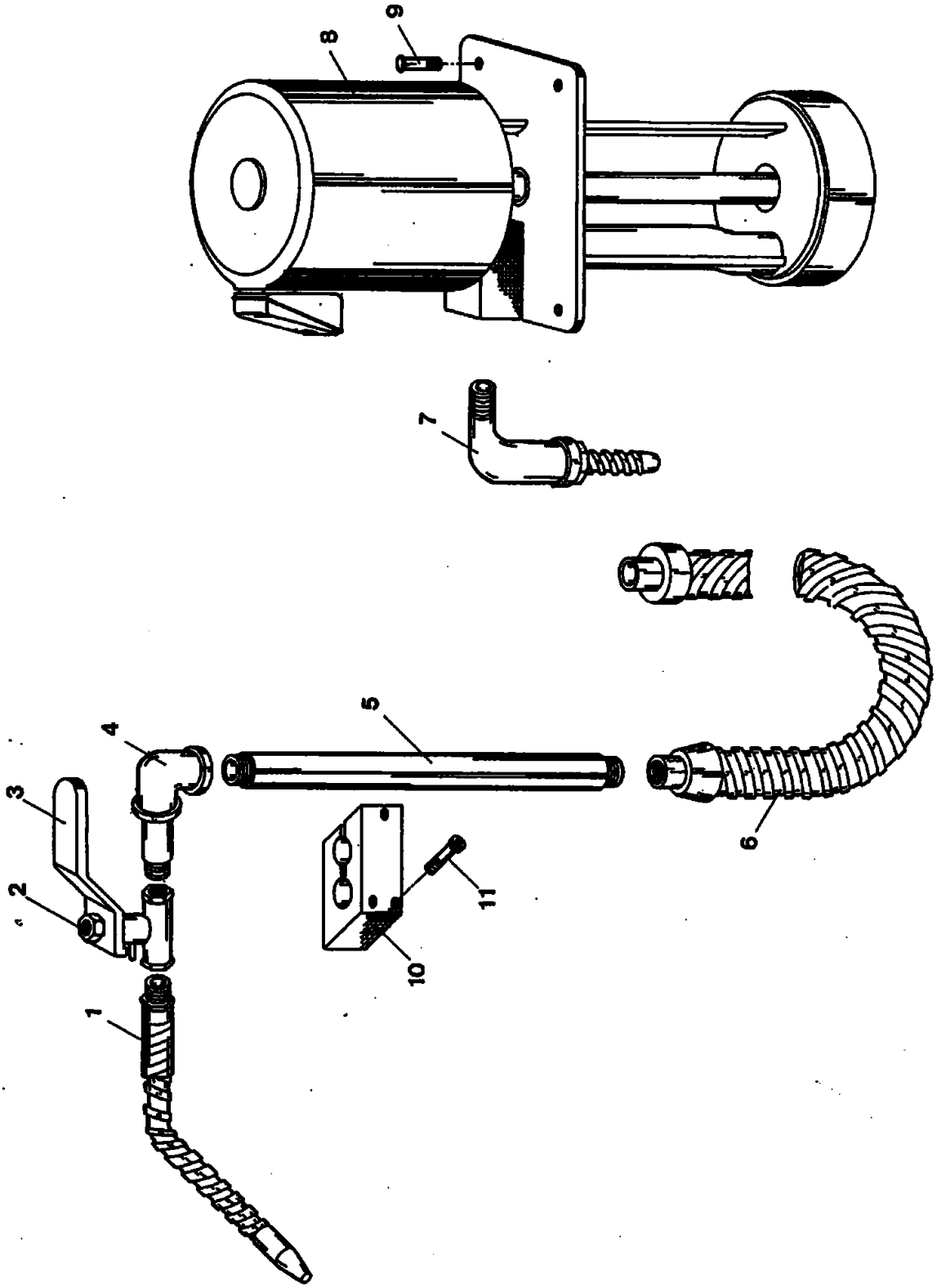
Original JET parts reference | Match model, voltage and serial-number notes

Ref.	Part number	Description	Size	Qty.
1	**	Body-follow rest		1
2	**	Nut-lead screw		2
3	**	Lead-screw		2
4	**	Collar		2
5	**	Pin	4x25L	2
6	**	Plug-lead screw		2
7	**	Screw-hexa. Socket headless screw	M8xP1.25x10L	4
8	**	Shoe		2
9	**	Hexagon socket screw	M10xP1.5x30L	2
10	**	Washer		2

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17.10.1 Coolant System Assembly – Exploded View



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JET GH-2680ZH | Stock JT1-3315

Parts List J - Coolant System Assembly

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

Ref.	Part number	Description	Size	Qty.
1	**	Nozzle		1
2	**	Nut-lock		1
3	**	Cock-lever		1
4	**	Elbow		1
5	**	Rod-support		1
6	JT1-3116	Pipe (model GH-2680ZH)	104”	1
	JT1-3149	Pipe (model GH-26130ZH)	163”	1
7	**	Elbow		1
8	**	Pump body		1
9	**	Bolt-hex. Head	M6xP1.0x12L	2
10	**	Supporter-lock pipe		1
11	**	Screw-hexa. socket head cap	M6xP1.10x20L	3

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