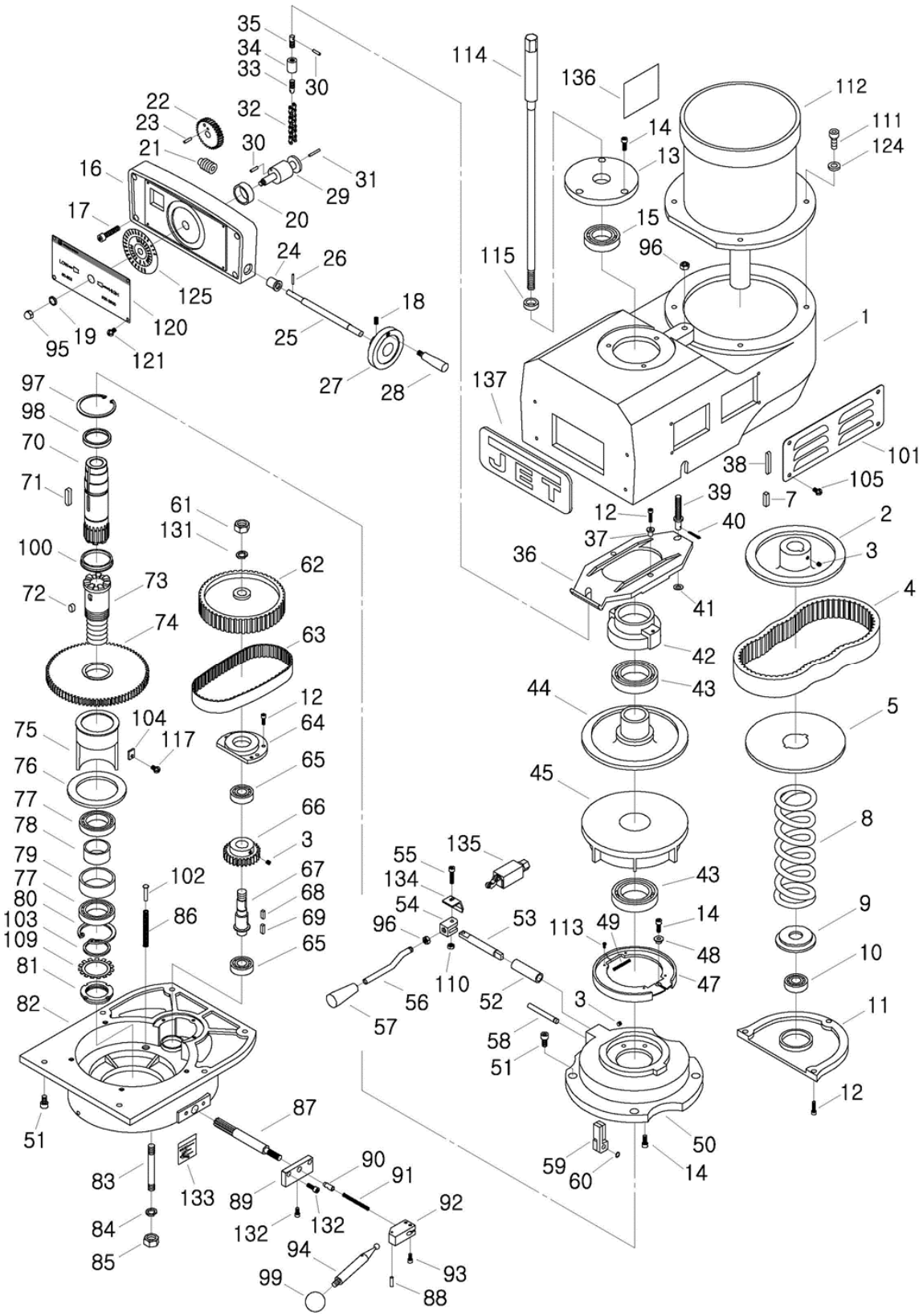
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Diagram A - Upper Head - JTM-1254VS

Base machine; retain model, voltage and serial-number applicability.



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Parts List A - Upper Head - JTM-1254VS

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
1	JTM1254VS-A01	Upper Pulley Housing		1
2	JTM1254VS-A02	Motor Disc - Upper		1
3	TS-1523011	Set Screw	M6x6L	4
4	JTM1254VS-A04	Belt		1
5	JTM1254VS-A05	Motor Disc - Lower		1
7	6295247	Key	7x7x25L	1
8	JTM1254VS-A08	Spring		1
9	JTM1254VS-A09	Washer		1
10	BB-6204ZZ	Ball Bearing	6204ZZ	1
11	JTM1254VS-A11	Pulley Cover		1
12	TS-1503041	Hex Socket Cap Screw	M6x16L	4
13	JTM1254VS-A13	Upper Cover		1
14	TS-1503041	Hex Socket Cap Screw	M6x16L	10
15	BB-6009ZZ	Ball Bearing	6009ZZ	1
16	JTM1254VS-A16	Dial Housing		1
17	TS-1503071	Hex Socket Cap Screw	M6x30L	4
18	TS-1523051	Set Screw	M6x16L	2
19	JTM1254VS-A19	Bushing		1
20	JTM1254VS-A20	Spacer		1
21	JTM1254VS-A21	Worm		1
22	JTM1254VS-A22	Worm Gear		1
23	5301041	Spring Pin	Ø5x10L	2
24	JTM1254VS-A24	Bushing		2
25	JTM1254VS-A25	Shaft		1
26	5302611	Spring Pin	Ø3x12L	1

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Parts List A - Upper Head - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
27	JTM1254VS-A27	Handwheel		1
	JTM1254VS-A27A	Handwheel Assembly (includes #18,27,28)		1
28	JTM1254VS-A28	Handle		1
29	JTM1254VS-A29	Chain Axle		1
30	5509313	Spring Pin	Ø4x16L	2
31	GA7X-865	Spring Pin	Ø3x25L	1
32	JTM1254VS-A32	Chain		1
33	JTM1254VS-A33	Screw		1
34	JTM1254VS-A34	Spacer		1
35	JTM1254VS-A35	Pin		1
36	JTM1254VS-A36	Adjustable Plate		1
37	JTM1254VS-A37	Shift Sleeve		2
38	6294761	Key	6x6x45L	1
39	JTM1254VS-A39	Bottom Pin		1
40	5307431	Spring Pin	3/32"x3/4"	1
41	JTM1254VS-A41	Flat Washer	Ø8.5	1
42	JTM1254VS-A42	Bearing Housing		1
43	BB-6010ZZ	Ball Bearing	6010ZZ	2
44	JTM1254VS-A44	Spindle Disc - Upper		1
45	JTM1254VS-A45	Spindle Disc - Lower		1
47	JTM1254VS-A47	Brake Lining		1
48	JTM1254VS-A48	Lock Collar		1
49	JTM1254VS-A49	Spring		1
50	JTM1254VS-A50	Brake Seat		1
51	TS-1504041	Hex Socket Cap Screw	M8x20L	10

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Parts List A - Upper Head - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
52	JTM949EVS-A53	Brake Sleeve		1
53	JTM949EVS-A54	Spindle Brake Shaft		1
54	JTM949EVS-A56	Spindle Brake Lever Pivot		1
55	TS-1503071	Hex Socket Cap Screw	M6x30L	1
56	JTM1254VS-A56	Spindle Brake Lever		1
57	JTM949EVS-A50	Brake Lever Knob	3/8"	1
58	JTM1254VS-A58	Hand Rod		1
59	JTM1254VS-A59	Brake Bracket		1
60	JTM949EVS-A46	Retaining Ring	STW8	1
61	TS-0561072	Hex Nut	5/8-18UNF	1
62	JTM1254VS-A62	Timing Wheel		1
63	JTM1254VS-A63	Timing Belt		1
64	JTM1254VS-A64	Bearing Seat		1
65	BB-6203ZZ	Ball Bearing	6203ZZ	2
66	JTM1254VS-A66	Pinion		1
67	JTM1254VS-A67	Gear Shaft		1
68	KF2R5515	Double Round Key	5x5x15L	1
69	KF2R5518	Double Round Key	5x5x18L	1
70	JTM1254VS-A70	Input Clutch		1
71	5307741	Key	8x7x24L	1
72	KF2R8712	Key	8x7x12L	1
73	JTM1254VS-A73	Output Clutch		1
74	JTM1254VS-A74	Gear		1
75	JTM1254VS-A75	Bearing Housing		1
76	JTM1254VS-A76	Washer		1
77	BB-6912ZZ	Ball Bearing	6912ZZ	2

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Parts List A - Upper Head - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
78	JTM1254VS-A78	Spacer (Small)		1
	JTM1254VS-A78A	Gear Bearing Spacer Assembly (includes #78,79)		1
79	JTM1254VS-A79	Spacer (Large)		1
80	RTW62	Retaining Ring	RTW62	1
81	AN08	Bearing Nut	AN08	1
82	JTM1254VS-A82	Upper Pulley Housing		1
83	JTM1254VS-A83	Stud	7/16x4"	3
84	TS-0720101	Spring Washer	7/16"	3
85	TS-0561041	Hex Nut	7/16"	3
86	JTM1254VS-A86	Spring		3
87	JTM949EVS-A03	Bull Gear Shifter Pinion Shaft		1
88	B-56	Spring Pin	Ø3x20L	1
89	JTM949EVS-A04	Hi-Lo Detent Plate		1
90	JTM949EVS-A05	Sleeve		1
91	JTM949EVS-A06	Spring		1
92	JTM949EVS-A08	Hi-Lo Pinion Block		1
93	TS-1502031	Hex Socket Cap Screw	M5x12	2
94	JTM949EVS-A09	Hi-Lo Shift Handle		1
95	F004478	Cap Nut	5/16”-18UNC	1
96	TS-0570031	Hex Nut	3/8”-16UNC	2
97	RTW80	Retaining Ring	RTW80	1
98	JTM1254VS-A98	Collar		1
99	BH1/4	Black Plastic Ball	1/4"	1
100	JTM1254VS-A100	Clutch Collar		1
101	JTM1254VS-A101	Pulley Cover		2

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Parts List A - Upper Head - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

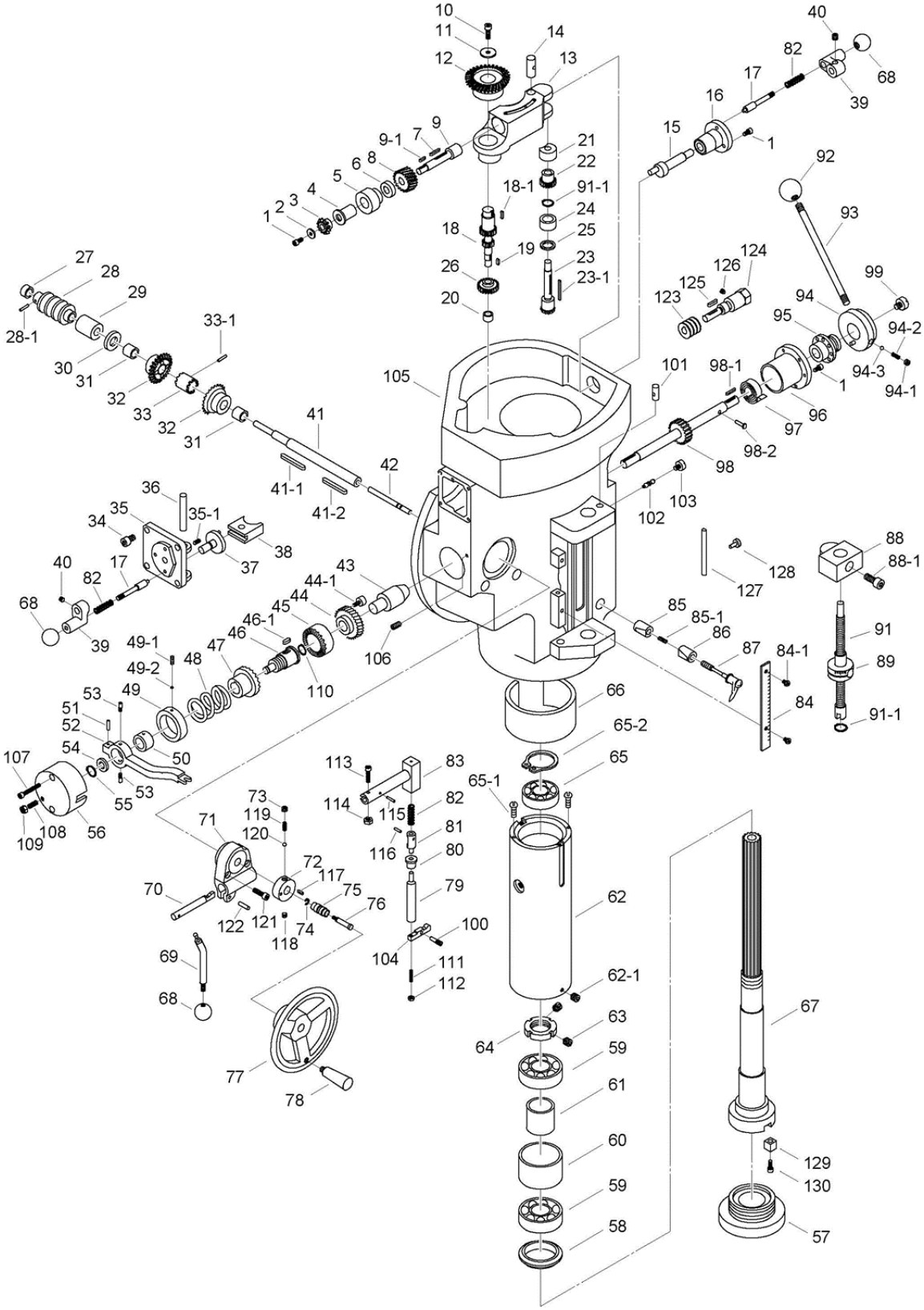
Ref.	Part number	Description	Size	Qty.
102	JTM1254VS-A102	Spring Shaft		3
103	JTM1254VS-A103	Spacer		1
104	JTM1254VS-A104	Square Nut		1
105	5712561	Pan Head Screw	M5x8L	8
109	AW08	Bearing Washer	AW08	1
110	TS-1540041	Nut	M6	1
111	TS-1209051	Hex Socket Cap Screw	3/8"x1"L	4
112	JTM1254VS-A112	Motor	3.75kW,5 HP,3Ph	1
	JTM1254VS-A112-1	Motor Fan (not shown)		1
	JTM1254VS-A112-2	Motor Fan Cover (not shown)		1
	JTM1254VS-A112-3	Junction Box Cover (not shown)		1
113	JTM949EVS-A51	Pan Head Screw	1/8"x1/4"L	4
114	JTM1254VS-A114	Draw Bar	5/8"	1
115	JTM1254VS-A115	Spacer		1
117	VS-117	Pan Head Screw	3/16"x1/2"L	1
120	JTM1254VS-A120	Speed Plate		1
121	TS-2284202	Pan Head Screw	M4x20L	4
124	TS-1550071	Flat Washer	Ø10mm	4
125	JTM1254VS-A125	Speed Dial		1
131	TS-0720131	Spring Washer	5/8"	1
132	TS-1502041	Hex Socket Cap Screw	M5x16L	3
133	LM000005	Speed Range Label		1
134	JTM949EVS-A91	Push Plate		1
135	JTM949EVS-A92	Limit Switch		1
136	LM000182	Motor Label		1
137	JET-165	JET Logo	165x68 mm	1

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Diagram B - Lower Head - JTM-1254VS

Base machine; retain model, voltage and serial-number applicability.



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Parts List B - Lower Head - JTM-1254VS

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
1	TS-1502031	Hex Socket Cap Screw	M5x12L	6
2	JTM949EVS-B02	Flat Washer	Ø5	1
3	JTM1254VS-B03	Feed Gear		1
4	JTM1254VS-B04	Shaft Sleeve		1
5	JTM1254VS-B05	Worm Cradle Bushing		1
6	JTM1254VS-B06	Worm Gear Spacer		1
7	KF2R3320	Key	3x3x20L	1
8	JTM1254VS-B08	Feed Drive Worm Gear		1
9	JTM1254VS-B09	Worm Gear Shaft		1
9-1	5308721	Worm Shaft Key	3x3x10L	1
10	JTM1254VS-B10	Hex Socket Cap Screw	5/16”x1/2”L	1
11	JTM1254VS-B11	Washer	5/16”	1
12	JTM1254VS-B12	Feed Reverse Bevel Gear		1
13	JTM1254VS-B13	Worm Gear Cradle		1
14	JTM1254VS-B14	Feed Engage Pin		1
15	JTM949EVS-B18	Cam Rod		1
16	JTM949EVS-B19	Shift Sleeve		1
17	JTM949EVS-B20	Lock Rod		2
18	JTM1254VS-B18	Feed Drive Gear		1
	JTM1254VS-B18A	Feed Drive Gear Assembly (includes #18,18-1 and 19)		1
18-1	KF2R5508	Key	5x5x8L	1
19	KF2R5512	Key	5x5x12L	1
20	JTM1254VS-B20	Needle Bearing	BA66	1
21	JTM1254VS-B21	Upper Bushing		1
22	JTM1254VS-B22	Cluster Gear		1
23	JTM1254VS-B23	Bevel Gear Shaft		1

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Parts List B - Lower Head - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
23-1	KF2R4445	Key	4x4x45L	1
24	JTM1254VS-B24	Bevel Gear Bushing		1
25	JTM1254VS-B25	Spacer		1
26	JTM1254VS-B26	Feed Drive Gear	TA2620Z	1
27	JTM1254VS-B27	Bushing		1
28	JTM1254VS-B28	Worm		1
28-1	JTM1254VS-B28-1	Spring Pin		1
29	JTM1254VS-B29	Feed Worm Shaft Bushing		1
30	JTM1254VS-B30	Bevel Gear Thrust Spacer		1
31	JTM1254VS-B31	Bushing		2
32	JTM1254VS-B32	Feed Reverse Bevel Gear		2
33	JTM1254VS-B33	Feed Reverse Clutch		1
33-1	JTM1254VS-B33-1	Spring Pin		1
34	TS-1502021	Hex Socket Cap Screw	M5x10L	4
35	JTM949EVS-B66	Cluster Gear Cover		1
35-1	TS-1522031	Socket Set Screw	M5x10L	1
36	JTM949EVS-B60	Feed Shift Rod		1
37	JTM1254VS-B37	Cluster Gear Shift Crank		1
38	JTM1254VS-B38	Feed Gear Shift Fork		1
39	JTM949EVS-B23	Crank		2
40	5302731	Socket Set Screw	M8x6	2
41	JTM1254VS-B41	Feed Worm Shaft		1
41-1	KF2R5515	Key	5x5x15L	1
41-2	JVM836B79-2	Key	5x5x10L	1
42	JTM1254VS-B42	Reverse Clutch Rod		1
43	JTM1254VS-B43	Pinion Shaft		1
44	JTM1254VS-B44	Overload Clutch Worm Gear		1

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Parts List B - Lower Head - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
44-1	JTM1254VS-B44-1	Screw		3
45	JTM1254VS-B45	Overload Clutch Ring		1
46	JTM1254VS-B46	Overload Clutch Sleeve		1
	JTM1254VS-B46A	Overload Clutch Assembly (includes #46,47,49, 49-1,49-2)		1
46-1	KF2R5516	Key	5x5x16L	1
47	JTM1254VS-B47	Overload Clutch		1
48	JTM1254VS-B48	Safety Clutch Spring		1
49	JTM1254VS-B49	Overload Clutch Lockout		1
49-1	TS-2276081	Set Screw	M6x8L	1
49-2	JTM1254VS-B49-2	Lock Block		1
50	JTM1254VS-B50	Clutch Ring		1
51	GA7X-122	Spring Pin	Ø5x20L	1
52	JTM1254VS-B52	Trip Lever		1
53	JTM1254VS-B53	Clutch Ring Pin		2
54	JTM1254VS-B54	Washer		1
55	STW10	Retaining Ring	STW10	1
56	JTM1254VS-B56	Clutch Arm Cover		1
57	JTM1254VS-B57	Nose Piece		1
58	JTM1254VS-B58	Spindle Shield		1
59	BB-7010ZZ	Ball Bearing	7010ZZ	2
60	JTM1254VS-B60	Bearing Spacer (Large)		1
61	JTM1254VS-B61	Bearing Spacer (Small)		1
62	JTM1254VS-B62	Quill		1
62-1	5308081	Set Screw	M5x5L	1
63	TS-1523011	Set Screw	M6x6L	2
64	AN10	Bearing Nut	AN10	1

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Parts List B - Lower Head - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
65	BB-6008ZZ	Ball Bearing	6008ZZ	1
65-1	TS-1533032	Pan Head Cross Screw	M5x10L	2
65-2	2210-255	Retaining Ring	STW40	1
66	JTM1254VS-B66	Quill Skirt		1
67	JTM1254VS-B67	Spindle	NT40	1
68	BH1/4	Black Plastic Ball	1/4"	3
69	JTM949EVS-B104	Trip Handle		1
70	JTM1254VS-B70	Cam Rod		1
71	JTM1254VS-B71	Feed Trip Bracket		1
72	JTM1254VS-B72	Handwheel Clutch		1
73	5302731	Set Screw	M8x6L	1
74	ETW6	Retaining Ring	ETW6	1
75	JTM1254VS-B75	Feed Reverse Stud		1
	JTM1254VS-B75A	Feed Reverse Stud Assembly (includes #74,75,76)		1
76	JTM1254VS-B76	Feed Reverse Bolt		1
77	JTM1254VS-B77	Cast Handwheel		1
77A	JTM1254VS-B77HA	Handwheel Assembly (includes #77,78)		1
78	JTM1254VS-B78	Handle		1
79	JTM1254VS-B79	Feed Trip Plunger		1
80	JTM1254VS-B80	Bushing		1
81	JTM1254VS-B81	Trip Plunger		1
82	JTM949EVS-B21	Spring		3
83	JTM1254VS-B83	Cam Rod Sleeve Assembly		1
84	JTM1254VS-B84	Micrometer Scale		1
84-1	TS-2171012	Pan Head Cross Screw	M4x6L	2
85	JTM1254VS-B85	Quill Lock Sleeve		1
85-1	JTM1254VS-B85-1	Spring		1

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Parts List B - Lower Head - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
86	JTM1254VS-B86	Quill Lock Sleeve		1
87	JTM1254VS-B87	Lock Handle		1
88	JTM1254VS-B88	Quill Stop Block		1
88-1	TS-0209032	Hex Socket Cap Screw	3/8"-24UNFx3/4"	1
89	JTM949EVS-B162	Micrometer Nut		1
91	JTM949EVS-B164	Quill Micro-Screw		1
91-1	STW16	Retaining Ring	STW16	2
92	JTM949EVS-B77	Ball Grip		1
93	JTM949EVS-B84	Handle		1
94	JTM949EVS-B138	Hub		1
94-1	TS-0270031	Set Screw	5/16”x3/8”	1
94-2	JTM1254VS-B94-2	Spring		1
94-3	SB-3/16	Steel Ball	3/16 in	1
95	JTM1254VS-B95	Hub Sleeve		1
96	JTM1254VS-B96	Spring Cover		1
97	JTM1254VS-B97	Adjustable Spring		1
98	JTM1254VS-B98	Quill Pinion Shaft		1
	JTM1254VS-B98A	Quill Pinion Shaft Assembly (includes #98,98-2)		1
98-1	KF2R5525	Key	5x5x25L	1
98-2	JTM1254VS-B98-2	T type Pin		1
99	JTM1254VS-B99	Pinion Shaft Hub		1
100	JTM1254VS-B100	Trip Lever Pin		1
101	JTM1254VS-B101	Rod		1
102	JTM1254VS-B102	Lever		1
103	JTM1254VS-B103	Screw		1
104	JTM1254VS-B104	Feed Trip Lever		1

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Parts List B - Lower Head - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

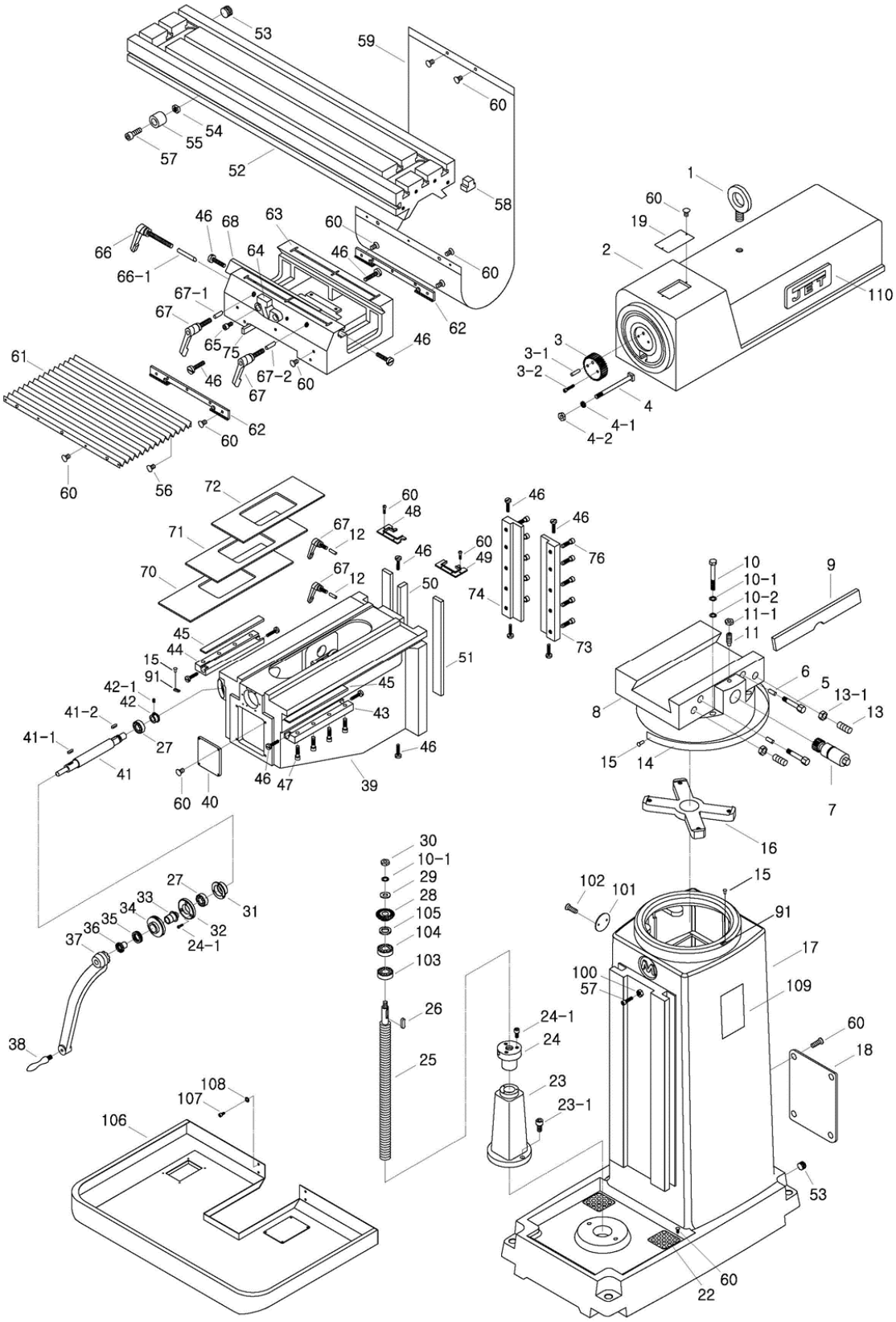
Ref.	Part number	Description	Size	Qty.
105	JTM1254VS-B105	Quill Housing		1
106	TS-1523021	Set Screw	M6x8L	1
107	TS-1502081	Hex Socket Cap Screw	M5x35L	2
108	TS-1523051	Set Screw	M6x16L	1
109	TS-2311061	Hex Nut	M6	1
110	STW22	Retaining Ring	STW22	1
111	TS-1521071	Set Screw	M4x20L	1
112	TS-1540021	Hex Nut	M4	1
113	TS-1502051	Hex Socket Cap Screw	M5x20L	1
114	TS-1540031	Hex Nut	M5	1
115	JTM1254VS-B115	Spring Pin		1
116	5302611	Spring Pin	Ø3x12L	1
117	KF2R3312	Key	3x3x12L	1
118	TS-1523011	Socket Set Screw	M6x6	1
119	JTM1254VS-B119	Spring		1
120	SB-3/16	Steel Ball	3/16 in	1
121	TS-1503051	Hex Socket Cap Screw	M6x20	2
122	5625391	Spring Pin	Ø5x16L	1
123	JTM1254VS-B123	Worm Gear		1
124	JTM1254VS-B124	Worm Shaft		1
	JTM1254VS-B124A	Worm Shaft Assembly (includes #124,125,126)		1
125	KF2R4418	Key	4x4x18L	1
126	JTM1254VS-B126	Set Screw		1
127	JTM949EVS-B25	Indicator Rod		1
128	JTM949EVS-B26	Indicator Rod Screw		1
129	JTM1254VS-B129	Stop Block		2
130	TS-1504041	Hex Socket Cap Screw	M8x20L	2

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Diagram C - Base - JTM-1254VS

Base machine; retain model, voltage and serial-number applicability.



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Parts List C - Base - JTM-1254VS

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
1	JTM1050EVS-C01	Lifting Ring	M24	1
2	JTM1254VS-C02	Ram		1
3	JTM949EVS-C02	Worm Gear		1
3-1	5501115	Spring Pin	Ø6x30L	1
3-2	TS-1504061	Hex Socket Cap Screw	M8x30L	2
4	JTM1254VS-C04	Bolt	5/8"	4
4-1	TS-2361161	Spring Washer	Ø16	4
4-2	TS-0561071	Hex Nut	5/8"	4
5	JTM1254VS-C05	Ram Lock Bolt		2
6	JTM1254VS-C06	Ram Lock Plunger		2
7	JTM1254VS-C07	Ram Pinion		1
8	JTM1254VS-C08	Turret		1
9	JTM1254VS-C09	Ram/Turret Gib		1
10	JTM1254VS-C10	Hex Head Screw	M12x185L	4
10-1	TS-2361121	Spring Washer	Ø12	5
10-2	JTM949EVS-B120	Flat Washer	Ø13	4
11	JWS35X-222	Socket Set Screw	M8x30L	1
11-1	TS-1540061	Hex Nut	M8	1
12	JTM1254VS-C12	Knee Lock Plunger		2
13	JTM1254VS-C13	Set Screw	M10x60L	2
13-1	TS-2331101	Hex Nut	M10	2
14	JTM1254VS-C14	Turret Scale		1
15	RN2L6	Rivet	Ø2x6L	6
16	JTM1254VS-C16	Spider		1
17	JTM1254VS-C17	Column		1

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Parts List C - Base - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
18	JTM1254VS-C18	Plate		1
19	JTM1254VS-C19	Ram Cover		1
22	JTM1254VS-C22	Strainer Net		2
23	JTM1254VS-C23	Elevating Screw Housing		1
23-1	TS-1505071	Hex Socket Cap Screw	M10x45L	2
24	JTM1254VS-C24	Elevating Nut (Inch)	Ø32 x 5 tpi	1
24-1	TS-1503051	Hex Socket Cap Screw	M6x20L	6
25	JTM1254VS-C25	Lead Screw (Inch)	Ø35 x 5tpi (590L)	1
26	KF2R5520	Key	5x5x20L	1
27	BB-6204ZZ	Bearing	6204ZZ	2
28	JTM949EVS-C58	Bevel Gear	36T	1
29	JTM1254VS-C29	Washer	Ø13xØ32x5t	1
30	JTM1254VS-C30	Hex Nut	1/2-20UNF	1
31	JTM1254VS-C31	Bearing Seat		1
32	JTM1254VS-C32	Cover		1
33	JTM1254VS-C33	Dial Holder		1
34	JTM1254VS-C34	Dial (Inch)	100/0.001"	1
35	JTM1254VS-C35	Dial Lock Nut		1
36	JTM1254VS-C36	Clutch Insert		1
37	JTM1050EVS2-75	Elevating Crank		1
38	JTM949EVS-C62	Handle		1
39	JTM1254VS-C39	Knee		1
40	JTM1254VS-C40	Knee Cover		1
41	JTM1254VS-C41	Elevating Shaft		1
41-1	5308721	Key	3x3x10L	1

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Parts List C - Base - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
41-2	5510498	Key	4x4x16L	1
42	JTM949EVS-C74	Bevel Gear	18T	1
42-1	TS-1523031	Socket Set Screw	M6x10L	1
43	JTM1254VS-C43	Support Plate-R		1
44	JTM1254VS-C44	Support Plate-L		1
45	JTM1254VS-C45	Gib		2
46	JTM1254VS-C46	Adjusting Screw		14
47	TS-1506041	Hex Socket Cap Screw	M12x35L	8
48	JTM1254VS-C48	Knee Wiper (left)		1
49	JTM1254VS-C49	Knee Wiper (right)		1
50	JTM1254VS-C50	Knee/ Column Gib		1
51	JTM1254VS-C51	Knee/ Column Gib		2
52	JTM1254VS-C52	Table	12"x54"	1
53	JTM1254VS-C53	Oil Plug	1/2”PT	3
54	JTM1254VS-C54	Nut		2
55	JTM1254VS-C55	Bushing		2
57	TS-1505041	Hex Socket Cap Screw	M10x30L	3
58	JTM1254VS-C58	T-Rubber		6
59	JTM1254VS-C59	Flat Way Cover (Rear)		1
60	TS-2245102	Socket Head Button Screw	M5x10L	39
61	JTM1254VS-C61	Pleated Way Cover (Front)		1
62	JTM1254VS-C62	Wiper		2
63	JTM1254VS-C63	Saddle		1
64	JTM1254VS-C64	Table Stop Bracket		1
65	TS-1505011	Hex Socket Cap Screw	M10X16L	2

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Parts List C - Base - JTM-1254VS (continued)

Base machine; retain model, voltage and serial-number applicability.

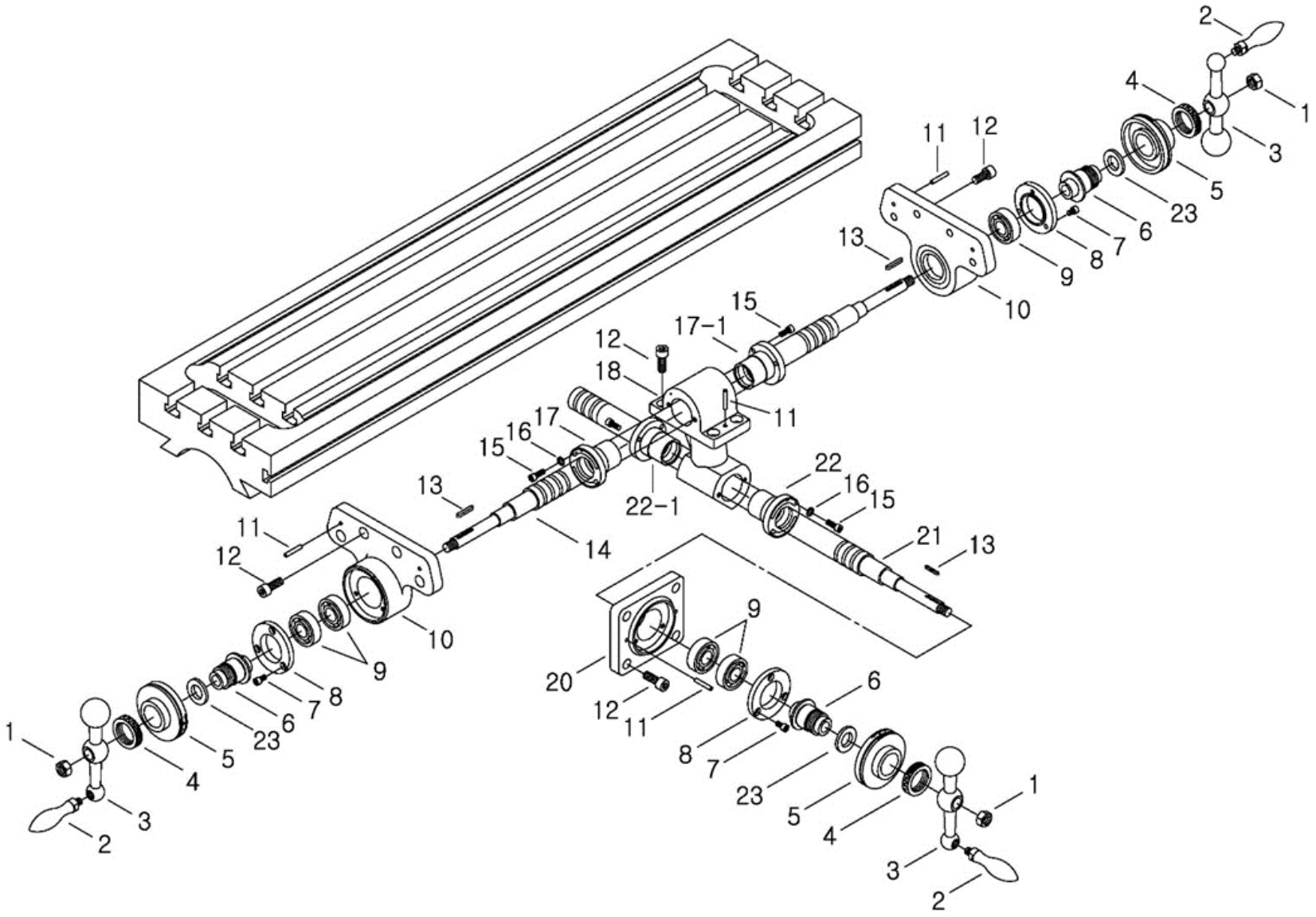
Ref.	Part number	Description	Size	Qty.
66	JTM1254VS-C66	Lock Handle		1
66-1	JTM1254VS-C66-1	Saddle Lock Plunger		1
67	JTM1254VS-C67	Lock Handle	M12x25L	4
67-1	JTM1254VS-C67-1	Table Lock Plunger 1		1
67-2	JTM1254VS-C67-2	Table Lock Plunger 2		1
68	JTM1254VS-C68	Gib		1
70	JTM1254VS-C70	Chip Guard (Bottom)	680 mm (129x2.0T)	1
71	JTM1254VS-C71	Chip Guard (Middle)	565 mm (129x2.0T)	1
72	JTM1254VS-C72	Chip Guard (Top)	430 mm (129x2.0T)	1
73	JTM1254VS-C73	Knee Support Plate (Right)		1
74	JTM1254VS-C74	Knee Support Plate (Left)		1
75	JTM1254VS-C75	Gib		1
76	F005475	Hex Socket Cap Screw	M14x35L	10
91	JTM1254VS-C91	Pointer		2
100	TS-1540071	Hex Nut	M10	1
101	JTM949EVS-C84	Side Cover		1
102	TS-1503031	Socket Head Button Screw	M6x12L	2
103	BB-51305	Bearing	51305	1
104	BB-6205ZZ	Ball Bearing	6205ZZ	1
105	JTM949EVS-C44	Washer		1
106	JTM1254VS-C106	Chip Pan		1
107	TS-1504031	Hex Socket Cap Screw	M6x12L	4
108	TS-1550041	Flat Washer	Ø6	4
109	LM000183	ID/Warning Label, JTM-1254VS		1
110	JET-254	JET Logo	254x105 mm	2
	JTM1254VS-TB	Tool Box Kit Complete (not shown)		1

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Diagram D - Table

Base machine; retain model, voltage and serial-number applicability.



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Parts List D - Table

Base machine; retain model, voltage and serial-number applicability.

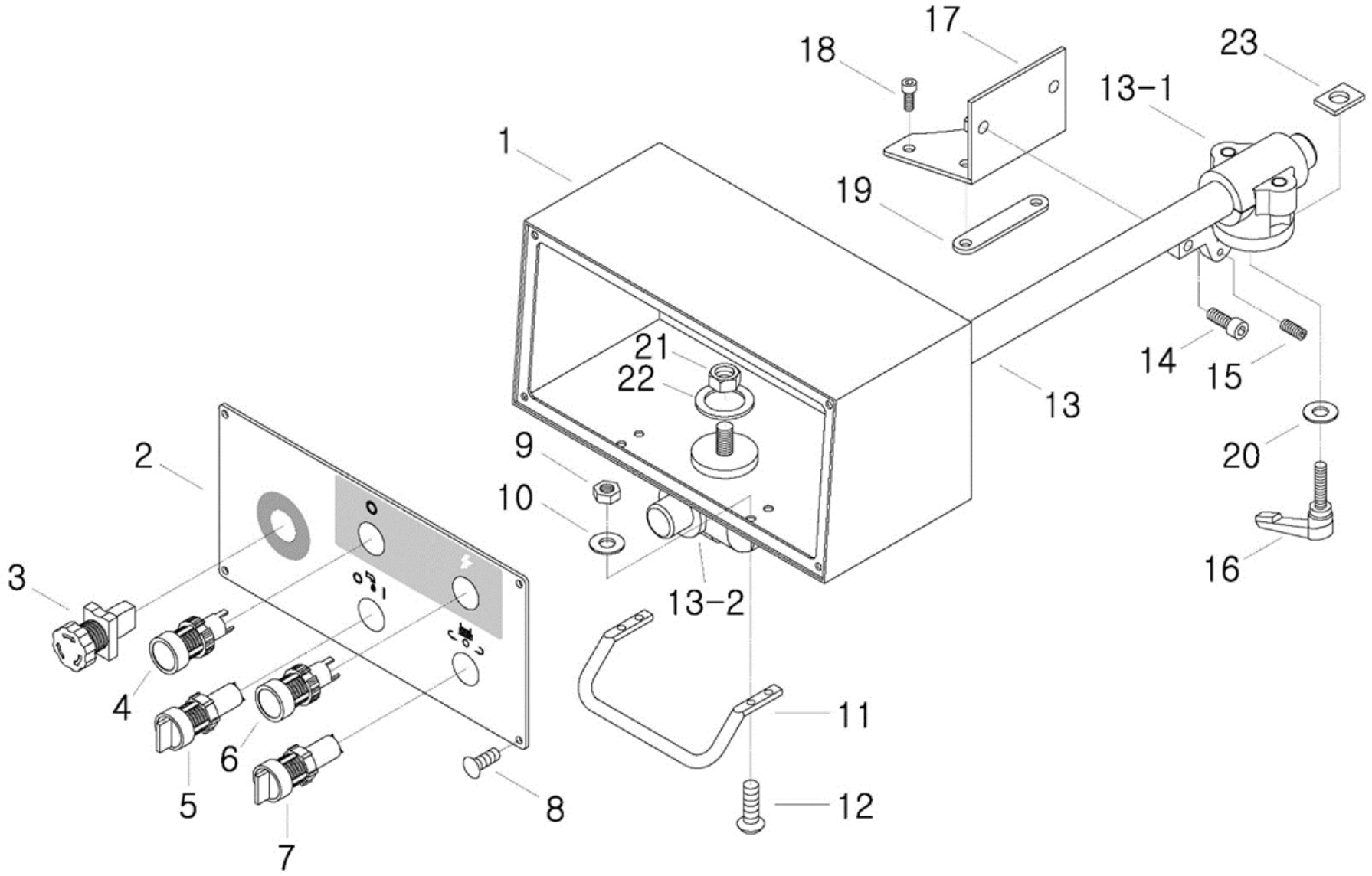
Ref.	Part number	Description	Size	Qty.
1	TS-0561052	Nut	1/2-20UNF	3
2	JTM949EVS-D02	Handle	3/8"	3
	JTM949EVS-D03A	Ball Crank Assembly (includes #2,3)		1
3	JTM949EVS-D03	Ball Crank		3
4	JTM949EVS-D04	Dial Lock Nut		3
5	JTM949EVS-D05	Dial (Inch)	200/0.001"	3
6	JTM949EVS-D06	Dial Holder	3mm / 56.6L	3
7	TS-1503031	Hex Socket Cap Screw	M6x12	9
8	JTM949EVS-D08	Cover		3
9	BB-6204ZZ	Ball Bearing	6204ZZ	5
10	JTM949EVS-D10	Bearing Bracket	Ø60	2
11	5311251	Spring Pin	Ø5x30	6
12	TS-1505011	Hex Socket Cap Screw	M10x16	16
13	KF2R3325	Key	3x3x25	3
14	JTM1254VS-D14	Lead Screw	Ø32 x 5 tpi (1632)	1
15	TS-1503041	Hex Socket Cap Screw	M6x16	10
16	TS-1550041	Flat Washer	M6	4
17	JTM949EVS-D17	Feed Screw Nut (Inch)	Ø32 x 5 tpi	1
17-1	JTM949EVS-D17-1	Feed Screw Nut (Adjust-I)	Ø32 x 5 tpi	1
18	JTM1254VS-D18	Lead Screw Housing		1
20	JTM949EVS-D20	Cross Bearing Bracket		1
21	JTM1254VS-D21	Cross Feed Screw	Ø32 x 5 tpi (720)	1
22	JTM949EVS-D22	Cross Feed Adjustment Nut (Inch)	Ø32 x 5 TPI	1
22-1	JTM949EVS-D22-1	Cross Feed Nut (Inch)	Ø32 x 5 TPI	1
23	JTM949EVS-D23	Adjusting Washer	Ø45xØ34x0.15t	3

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Diagram E - Control Box

Base machine; retain model, voltage and serial-number applicability.



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Parts List E - Control Box

Base machine; retain model, voltage and serial-number applicability.

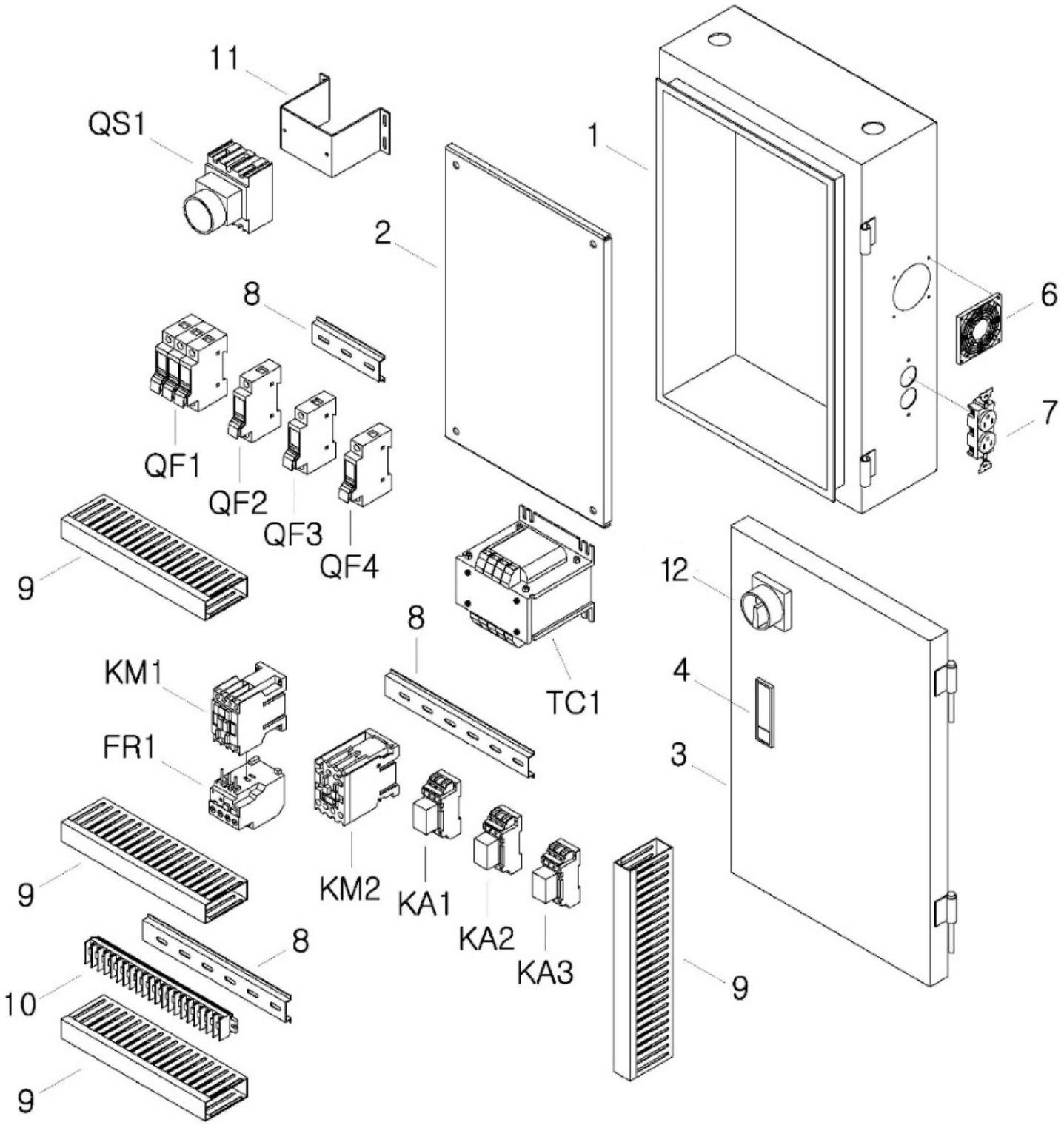
Ref.	Part number	Description	Size	Qty.
	JTM1254VS-CBA	Control Box Assembly (includes #1~8)		1
1	JTM949EVS-E01	Control Box		1
2	JTM1254VS-CB	Control Panel		1
3	JTM949EVS-E09	Emergency Switch		1
4	JTM949EVS-E07	Spindle Stop Button		1
5	JTM949EVS-E06	Coolant Pump Switch		1
6	JTM949EVS-E08	Power Start Button		1
7	JTM949EVS-E04	F/R Select Switch		1
8	TS-2245102	Socket Head Button Screw	M5x10L	4
9	TS-1540031	Hex Nut	M5	4
10	TS-1550031	Flat Washer	Ø5	4
11	JTM949EVS-E12	Handle		1
12	TS-2245162	Socket Head Button Screw	M5x16	4
	JTM949EVS-E14	Support Rod Unit Assembly (includes #13, 13-1, 13-2, 16, 20, 23)		1
13	JTM1254VS-E13	Rod		1
13-1	JTM1254VS-E13-1	Rotating Bracket		1
13-2	JTM1254VS-E13-2	Control Box Bracket		1
14	TS-1504041	Hex Socket Cap Screw	M8X20L	2
15	TS-1523031	Socket Set Screw	M6x10	3
16	JTM949EVS-E18	Lock Handle	M12X35L	1
17	JTM949EVS-E19	Bracket		1
18	TS-1523051	Hex Socket Cap Screw	M6x16L	3
19	JTM1254VS-E19	Spacer		1
20	JTM949EVS-B120	Flat Washer	Ø13xØ20x2T	1
21	TS-0640081	Hex Nylon Lock Nut	5/16"-18	1
22	JTM1254VS-E22	Rubber gasket		1
23	JTM1254VS-E23	Nut		1
	JTM1254VS-D19	Cable (Control Panel to Electrical Box) - not shown		1

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Diagram F - Electrical Box

Base machine; retain model, voltage and serial-number applicability.



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Parts List F - Electrical Box

Base machine; retain model, voltage and serial-number applicability.

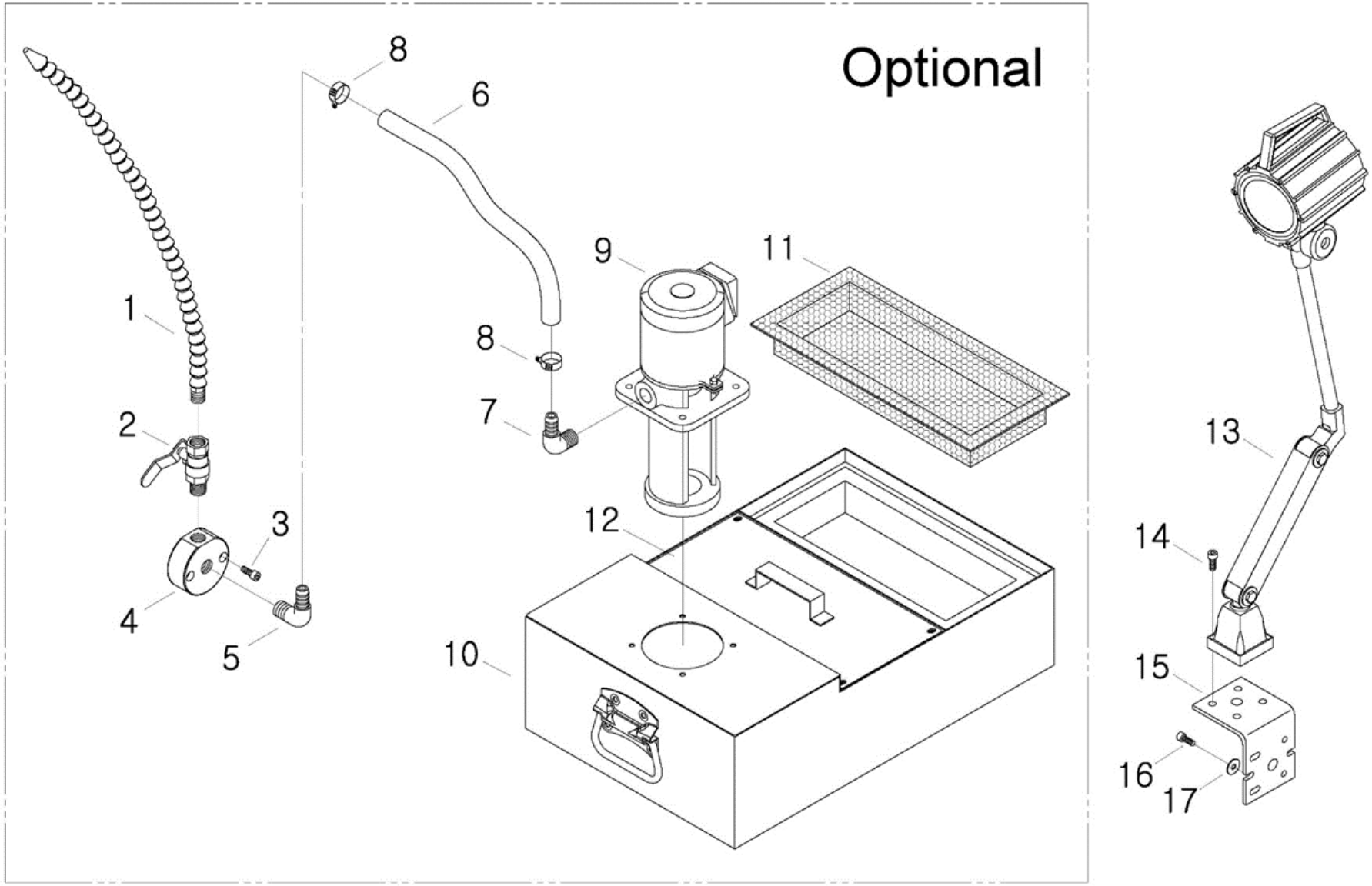
Ref.	Part number	Description	Size	Qty.
1	JTM949EVS-F01	Electrical Cabinet (RE: JTM949EVS-F21)		1
2	JTM949EVS-F02	Electrical Plate (RE: JTM949EVS-F21)		1
3	JTM949EVS-F03	Electrical Cabinet Door (RE: JTM949EVS-F21)		1
	JTM949EVS-F21	Electrical Cabinet Assembly (includes #1-3)		1
4	JTM949EVS-F04	Door Latch		1
6	JTM949EVS-F18	Fan Cover		1
7	JTM949EVS-F19	Electric Receptacle		1
8	JTM949EVS-F16	Aluminum Rail		2
9	JTM949EVS-F14	Wire Casing		5
10	JTM949EVS-F15	Terminal Block		1
11	JTM949EVS-F21	Switch Bracket		1
12	JTM949EVS-F05-1	Switch Interface		1
QS1	JTM949EVS-F05	Door Switch (includes #12)		1
TC1	JTM949EVS-F06	Transformer	400VA	1
KM1	JTM1254VS-FKM1	Magnetic Contactor	TECO / CU-11	1
FR1	JTM1254VS-FFR1	Flicker Relay		1
KM2	JTM1254VS-FKM2	Magnetic Contactor	TECO / CU-11	1
KA1	JTM1254VS-FKA1	Relay	RMIA4524VAC	1
KA2	JTM1254VS-FKA2	Relay	RMIA21024VAC	1
KA3	JTM1254VS-FKA3	Relay	RMIA4524VAC	1
QF1	JTM1254VS-FQF1	Power Circuit Breaker	3P 25A	1
QF2	JTM1254VS-FQF2	Power Circuit Breaker	1P 2A	1
QF3	JTM1254VS-FQF3	Power Circuit Breaker	1P 6A	1
QF4	JTM1254VS-FQF4	Power Circuit Breaker	1P 6A	1

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Diagram G - Optional Coolant Pump and Work Lamp

Base machine; retain model, voltage and serial-number applicability.



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Parts List G - Optional Coolant Pump and Work Lamp

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
	JTM949EVS-G00	Coolant Pump Kit (includes #1 thru 12)		
1	JTM949EVS-G01	Plastic Nozzle		1
2	JTM949EVS-G02	Valve	PT 3/8" x 1/2"	1
3	TS-1503091	Hex Socket Cap Screw	M6 x 40	2
4	JTM949EVS-G04	Block		1
5	JTM949EVS-G07	Hose Fitting	PT 3/8" x 1/2" (90°)	1
6	JTM949EVS-G06	Hose	1/2"	1
7	JTM949EVS-G07	Hose Fitting	PT 3/8" x 1/2" (90°)	1
8	JTM949EVS-G08	Hose Clamp	5/6" (11 ~ 20)	2
9	JTM949EVS-G09	Coolant Pump	1/8HP	1
10	JTM949EVS-G10	External Coolant Tank		1
11	JTM949EVS-G11	Strainer		1
12	JTM949EVS-G12	Cover with handle		1
13	JTM949EVS-G13	Work Lamp	24V / LED	1
14	TS-1502041	Hex Socket Cap Screw	M5X16	4
15	JTM949EVS-G15	Work Light Bracket		1
16	TS-1503041	Hex Socket Cap Screw	M6X16	6
17	TS-1550041	Flat Washer	Ø6mm	6
18	JTM949EVS-G18	LED Bulb (not shown)	24V	1

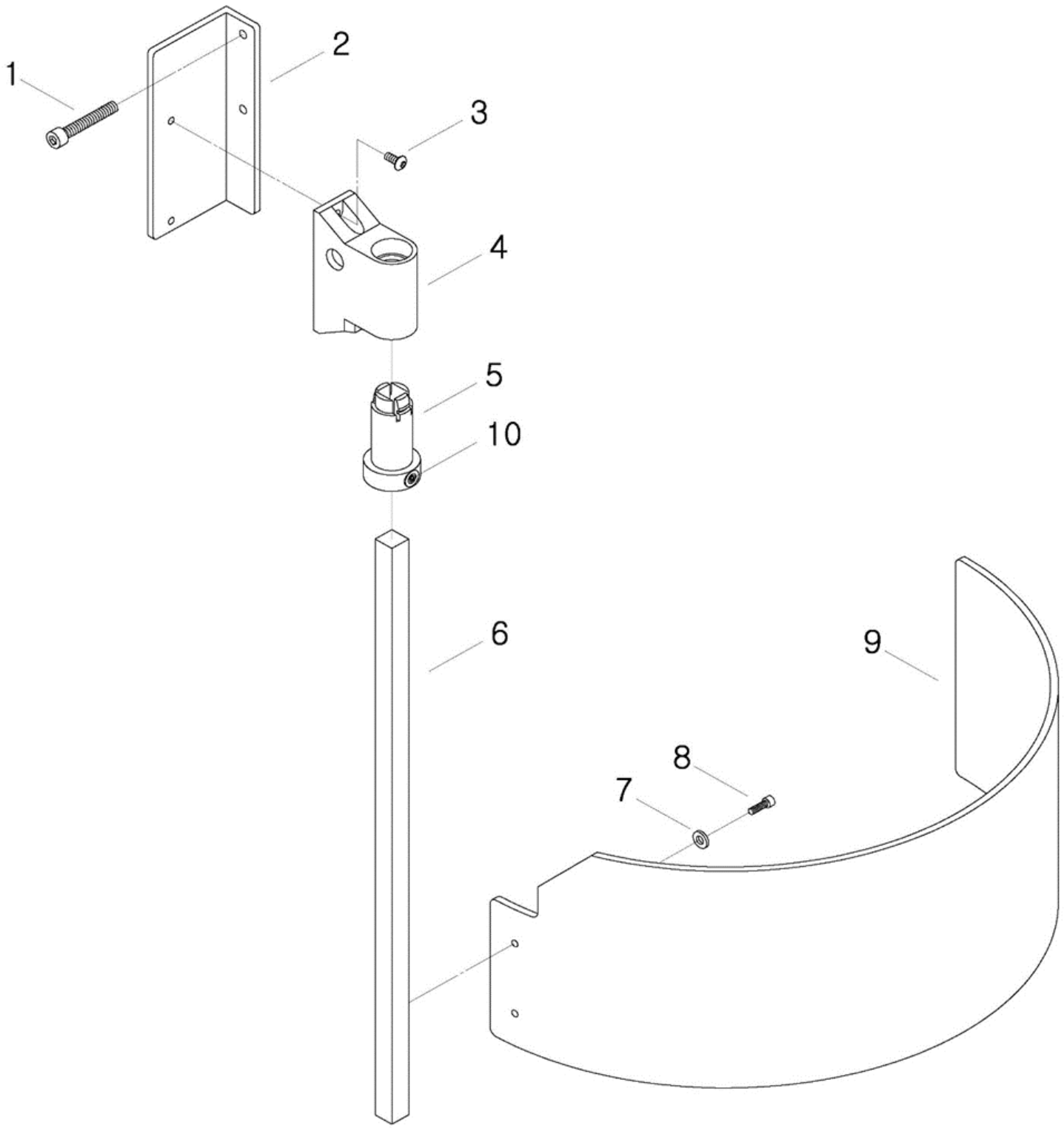
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Diagram H - Spindle Guard

Base machine; retain model, voltage and serial-number applicability.



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Parts List H - Spindle Guard

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
	JTM949EVS-SGA	Spindle Guard Assembly (#1 thru 10)		
1	TS-1502101	Hex Socket Cap Screw	M5x45	2
2	JTM949EVS-H02	Support Plate		1
3	TS-2245102	Socket Head Button Screw	M5x10	2
4	JTM949EVS-H04	Bushing Bracket (Re: JTM949EVS-H04A)		1
	JTM949EVS-H04A	Bushing Bracket Assembly (includes #4,5)		1
5	JTM949EVS-H05	Bushing		1
6	JTM949EVS-H06	Support Rod		1
7	TS-1550031	Washer	Ø5	2
8	TS-1502031	Hex Socket Cap Screw	M5x12	2
9	JTM949EVS-H09	Spindle Guard		1
10	TS-1522021	Socket Set Screw	M5x8	1

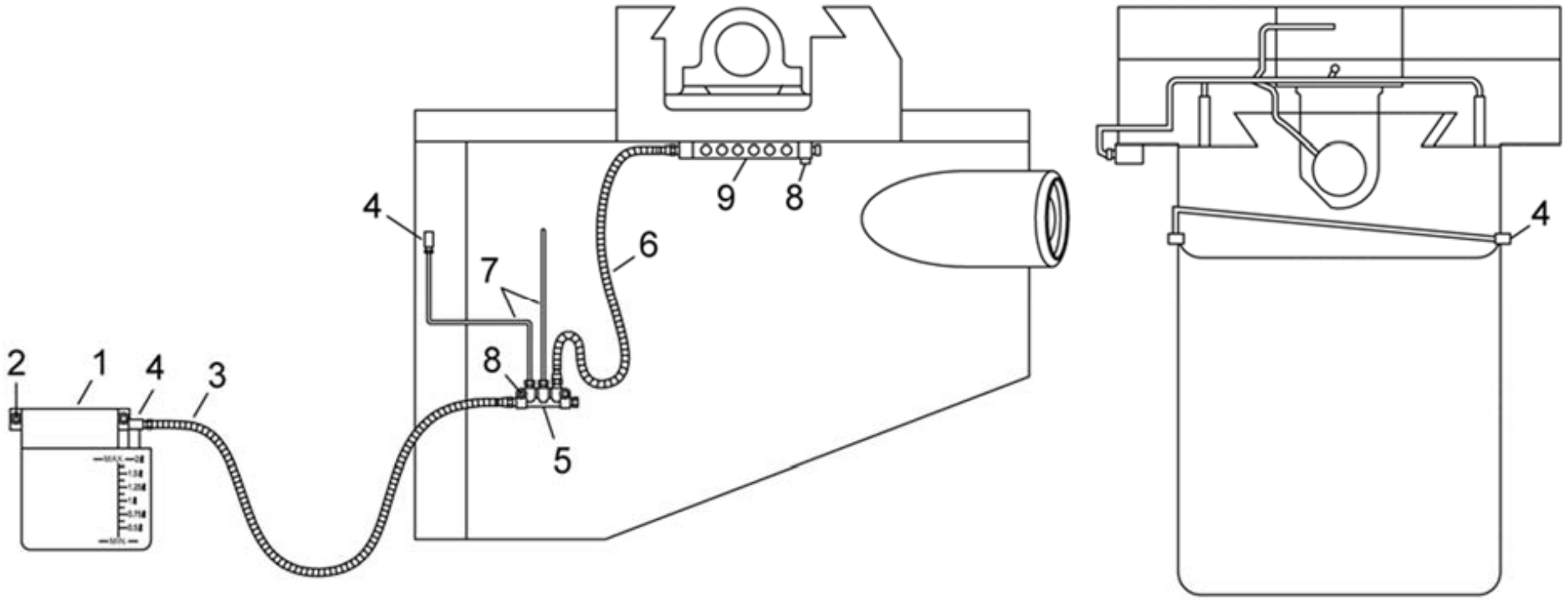
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Diagram I - Lubrication System

Base machine; retain model, voltage and serial-number applicability.



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Parts List I - Lubrication System

Base machine; retain model, voltage and serial-number applicability.

Ref.	Part number	Description	Size	Qty.
1	JTM949EVS-J01N	Automatic Oiler	2L, 0~180min	1
2	TS-1503061	Hex Socket Cap Screw	M6x25L	2
3	JTM949EVS-J03	Flexible Steel Tube	Ø4	1
4	JTM949EVS-J04	Elbow Adaptor	Ø4	3
5	JTM949EVS-J10	Oil Distributor	Ø4, 6 holes	2
6	JTM949EVS-J06	Flexible Steel Tube		1
7	JTM949EVS-J07	Aluminum Pipe	Ø4	2
8	TS-1502061	Hex Socket Cap Screw	M5x25L	4
9	JTM1254VS-J09	Oil Distributor	Ø4, 8 holes	1
	JTM1254VS-J05A	Oil Distributor Kit (incl. #3,5,6,9)		1

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