



**OPERATING MAINTENANCE
&
SPARE PARTS BOOK**

**LIGHT DOUBLE END TENSIONER
TYPE WU 60**

BOOKLET No 1144

SPARE PARTS

Should spare parts be required due to breakage or wear full particulars including the machine number must be given. This information is on the name plate at the front of the backshaft motor housing and should be forwarded to the SERVICE MANAGER.

Machines are occasionally modified. It is important therefore that only the book sent with the machine should be used as a working manual.

WADKIN LTD., GREEN LANE WORKS, LEICESTER, LE5 4PF, ENGLAND.

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This book is applicable to machines with belt driven head units.

LIGHT DOUBLE END TENONER TYPE WU 60

Principal Dimensions and Capacities

Maximum depth of timber admitted	5"	130 mm
Maximum depth of timber that can be cut off	3"	75 mm
Maximum width of timber admitted (infeed capacity)	24"	610 mm
Maximum distance across tracks (Model WU 60/1500)	5' 0"	1500 mm
(Alternative maximum distance across tracks Model WU 60/2500)	8' 6"	2500 mm
Minimum distance across tracks	6"	150 mm
Maximum length of tenon	3"	75 mm
Maximum overhang, track to column	7"	180 mm
Spindle diameters, all heads	1 1/4"	—
Optional spindle diameters	30 mm	30 mm
Spindle speeds, all heads	5,000 r.p.m.	
Diameter of cut-off saws, front heads	10"	254 mm
Maximum diameter of cut-off saws, front heads	12"	305 mm
Maximum diameter of cut-off saws, rear heads	9"	230 mm
Horsepower and speed of motors on 50 cycles:		
All head motors 3 h.p. (optional 5 h.p. intermittent)	3,000 r.p.m.	3,000 r.p.m.
Feed motor 1.4/0.75 h.p.	1500/750 r.p.m.	1500/750 r.p.m.
Traverse motor 1 h.p.	1,500 r.p.m.	1,500 r.p.m.
Rates of feed:		
Standard for 50 and 60 cycles	10, 15, 20 and 30 ft. per min.	3, 4.5, 6, and 9 m per min.
Infinitely variable with two-speed motor (optional extra) 1 1/2/3 h.p.	11 to 48 ft. per min.	3.4 to 14.6 m per min.
Infinitely variable with two-speed motor (optional extra) 2 h.p.	22 to 48 ft. per min.	
Floor space required for Model WU 60/1500	12' x 8' 8"	3658 x 2642 mm
Floor space required for Model WU 60/2500	15' 6" x 8' 8"	4724 x 2642 mm
Height of track	2' 11 3/8'	898 mm
Approximate net weight WU 60/1500 (8 head M/c)	4144 lb	1880 kg.
Approximate net weight WU 60/2500 (8 head M/c)	5488 lb	2489 kg.
Shipping Dimensions (Model WU 60/1500)	350 cu. ft.	10m ³
Shipping Dimensions (Model WU 60/2500)	450 cu. ft.	12.7m ³

For cutter equipment see catalogue No. 1104

INSTALLATION

Slinging

Fig. B1

1. Pass a 1.1/2" dia, steel bar through the two centre apertures on the base of the machine (8' 6" M/C) or through end apertures of machine (5' 0" M/C).
2. Attach lifting gear to each end of bars and move machine into position.

Cleaning

Clean protective coating from all bright parts by applying a cloth soaked in paraffin, turpentine or other solvent.

Marking Out

Mark out floor, using floor plan supplied with machine and drill to suit 5/8" Rawlbolts. These are not supplied with the machine but are available on request at additional cost.

Levelling

1. Fit steel packing pieces (supplied with machine) beneath levelling screws in base of machine and control gear housing.
2. Level bed using levelling screws, screwing them down on to packing pieces. Bed should be within 0.002" of length and width.
3. Take weight of control gear housing on packing pieces by using levelling screws.
4. Fully tighten Rawlbolts and re-check levelling. Adjust if required.

Wiring Details

Fig. B2

The motors and control gear have been wired in before despatch. All that is required is to connect the power supply to the isolating switch. Points to note when connecting to power supply:

1. Check that the electrical supply details on the machine nameplate correspond to the supply available.
2. Check that the main fuses are correct.
3. Connect the incoming supply leads to the appropriate terminals on main isolating switch.
4. Check that all connections are sound.
5. Check that adjustable headstock unit moves in correct direction. Number 1 indicates traverse towards fixed headstock, number 2 indicates traverse away from fixed headstock.
6. If directions of traverse are reversed change over any two of the wires on the Incoming Supply. All other movements will be found to be correct when the traverse is correct.

NOTE:

Dust Exhaust System

Information is available on request.

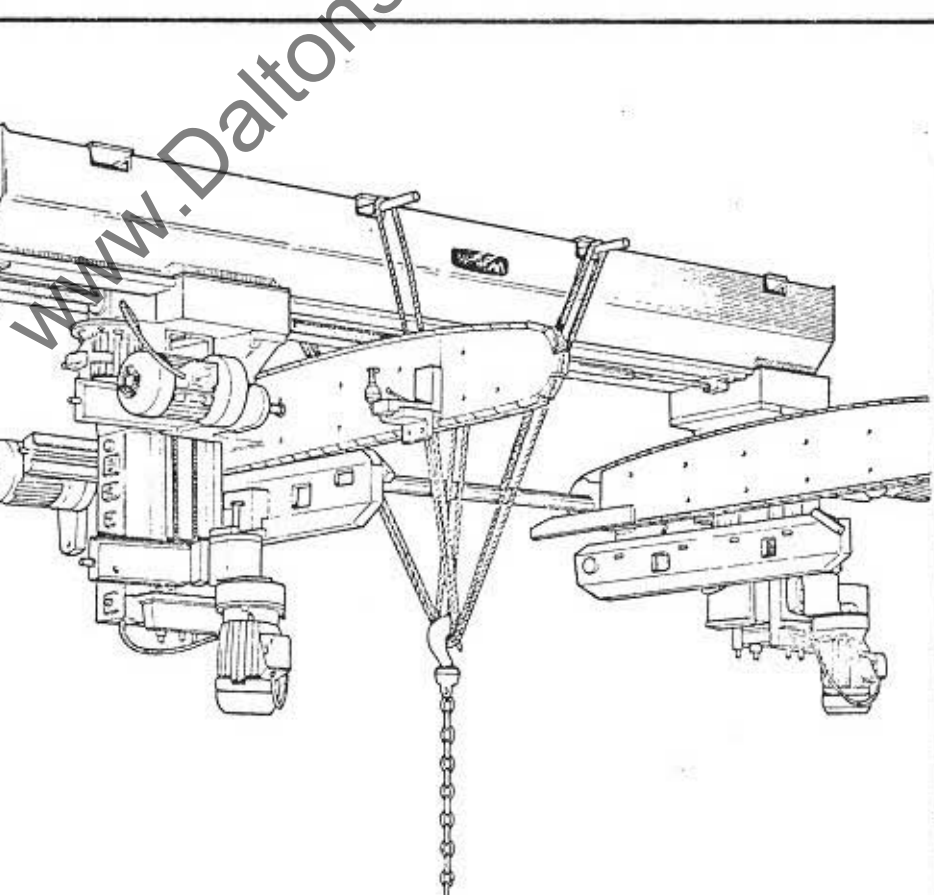


FIG C 3

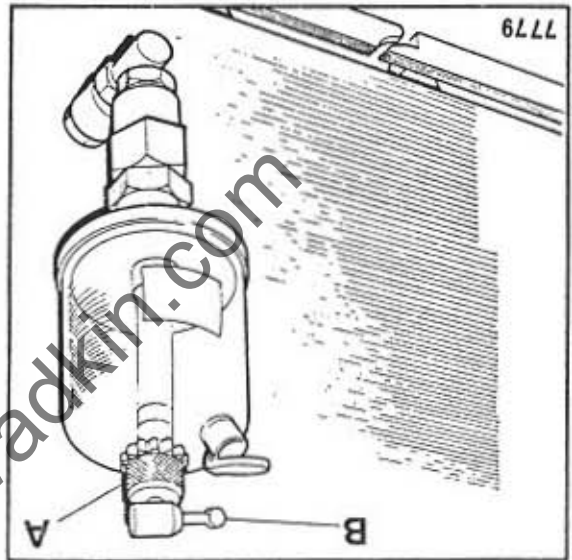


FIG C 1

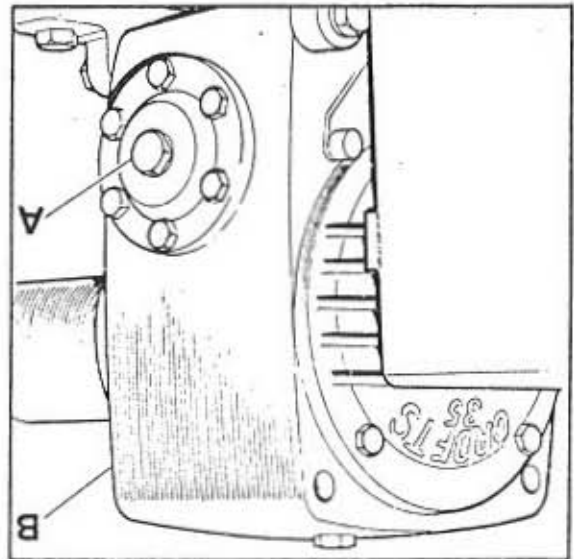


FIG C 4

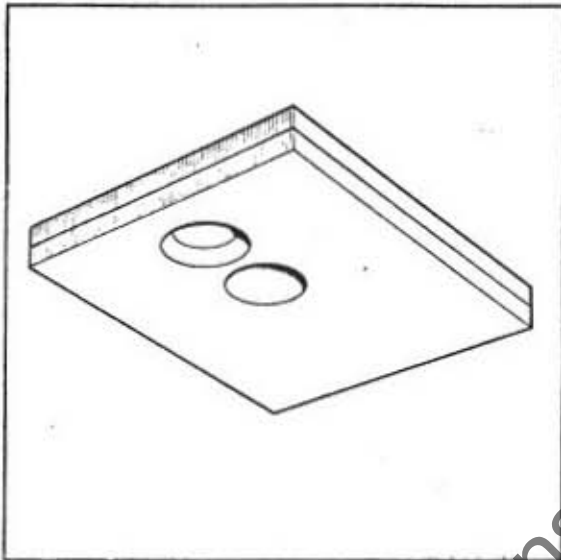
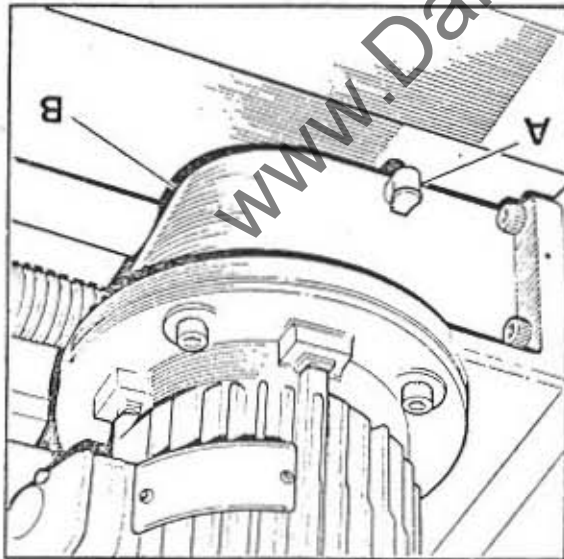


FIG C 2



DESCRIPTION AND OPERATION

Preparation for Operation

Fig. C1

1. Remove oil level plug (A) from side of back shaft gearbox (B) and check that oil level is up to bottom of hole. Top up, if necessary, using correct grade of oil. See APPROVED LUBRICANTS, page D1.

Fig. C2

2. Lift filler/level cap (A) on side of traverse worm gearbox (B) and check that oil level is up to top of hole. Top up, if necessary, using correct grade of oil. See APPROVED LUBRICANTS, page D1.

Fig. C3

3. Fill oil drip feed lubrication bottles on each track with correct grade lubricant. See APPROVED LUBRICANTS, page D1. Set drip feed adjuster 'A' in Fig. C3 to maximum then turn tap 'B' to 'on' position i.e. vertical, when tracks are moving. If tracks are stopped while lubrication bottle contains lubricant switch tap 'B' to 'off' position. Allow bottles to empty once per day while machine is working.
4. It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting.

Fig. C4

Note:

If polyurethane friction pads are fitted to driven tracks. Extra long dogs must be fitted to make up height difference.

CONTROLS AND OPERATION

CONTROLS

Control Panel

Fig. C5

There are two control panels, one fitted to the fixed column and one to the adjustable column. The following controls are incorporated on each panel:

- A. Multi-Switch (Head unit No. 1)
- B. Multi-Switch (Head unit No. 2)
- C. Multi-Switch (Head unit No. 3)
- D. Multi-Switch (Head unit No. 4)

Each multi-switch controls direction of rotation, starting and stopping of each head unit.

Note:

An additional feature of each multi-switch being that when machine is stopped by master stop switch, each multi-switch remains in selected position for head rotation so eliminating re-selection of head rotation direction. To re-start each head a slight radial movement of multi-switch is needed.

E. Feed Switch

Push button 1 to switch feed on. Push button 0 to switch feed off.

Note:

For convenience an additional feed button is fitted to the fixed chain beam of each machine.

F. Traverse Switch

Fitted only to the panel on adjustable column. Has three positions as follows:-

Move switch to position 1 to traverse beam towards fixed beam.

Move switch to CENTRE position to stop traverse.

Move switch to position 2 to retract beam away from fixed beam.

Note:

Cut out switch fitted on machine bed automatically stops beam at approx. 4" from farthest possible traverse position at either end of bed.

G. Master Stop Switch

Stops complete machine when pressed. Two fitted, one to each control panel.

ADJUSTMENTS

Cutting Head Vertical Adjustment

Fig. C6

Each cutting head unit is separately adjustable by means of an individual screw (B) and can be locked vertically in any position by the locknut (A). Vertical adjustment scales on each control panel show the position of the top and bottom heads in relation to each other as indicated by pointer on each head unit. A micro adjustment scale (D) is fitted to the top of each adjusting screw. These scales can be used to determine depth of vertical cut or thickness of tenon.

Cutting Head Horizontal Adjustment

Fig. C7

Each cutting head unit is adjustable horizontally parallel to the bed of machine by means of an individual screw (B). Horizontal lock to head is by means of a locknut (A). Fitted to the upper face of the horizontal slide is a head traverse scale (C) indicated by a pointer mounted on the head unit. A micro adjustment scale (D) is fitted to end of slide.

Head Canting Adjustment

Fig. C8

Each head unit can be canted from vertical to horizontal by loosening locknut (A) canting head unit (B) to required angle then relock locknut (A). Fitted to the head unit (B) is a canting scale (C) indicated by a pointer on head mounting bracket.

FIG C8

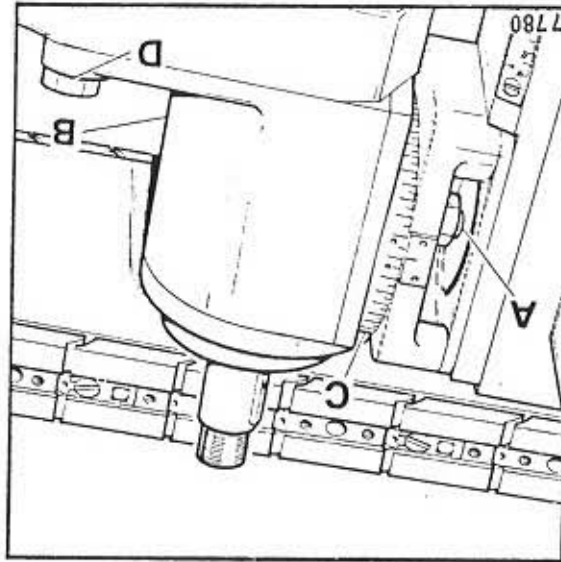


FIG C7

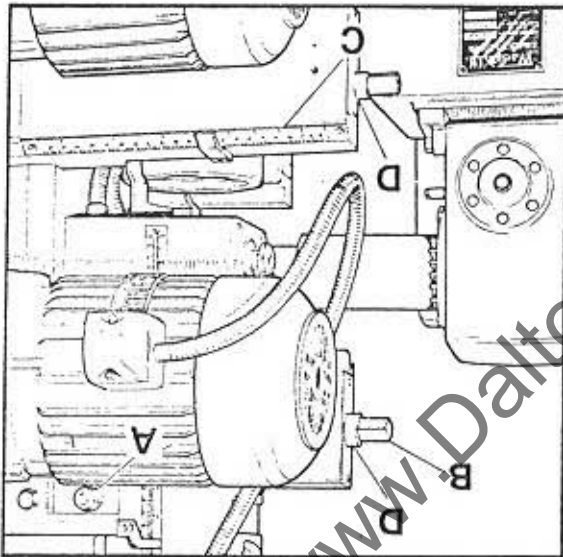


FIG C6

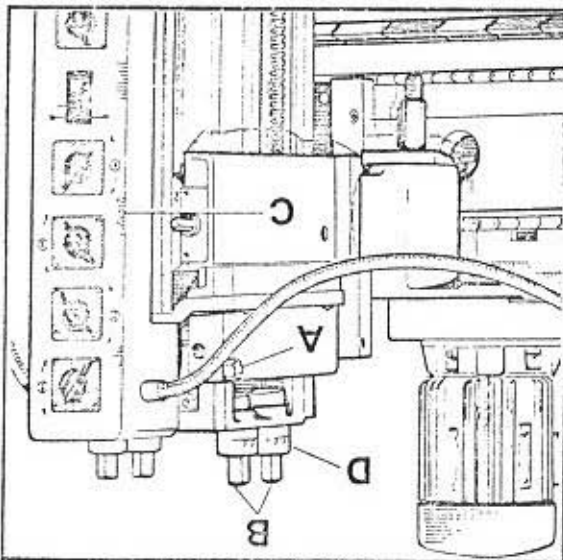


FIG C5

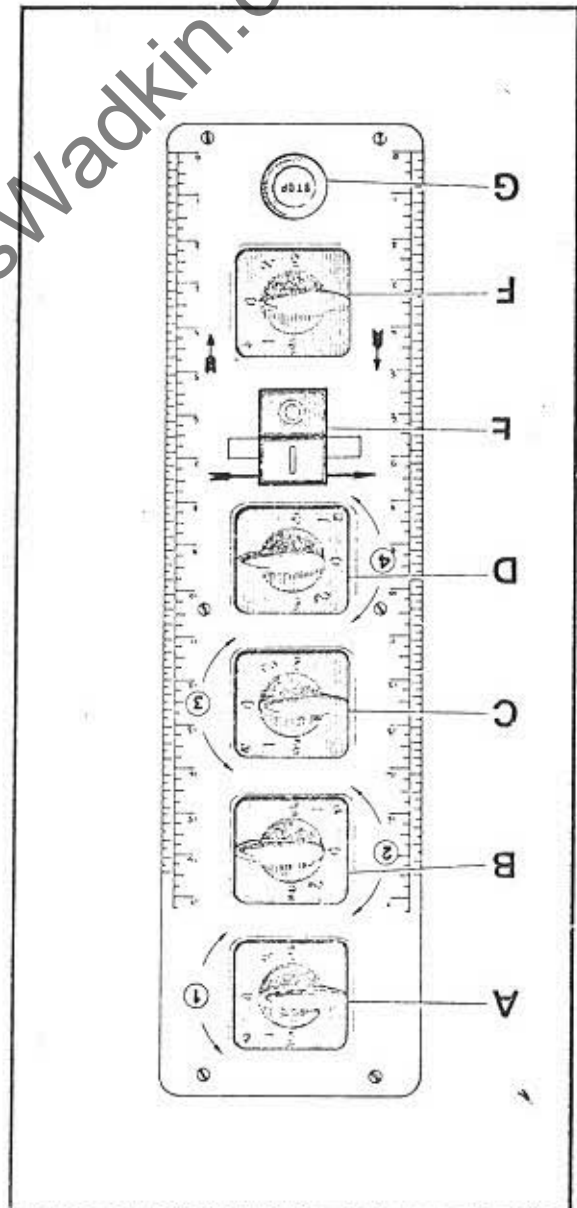


FIG C13

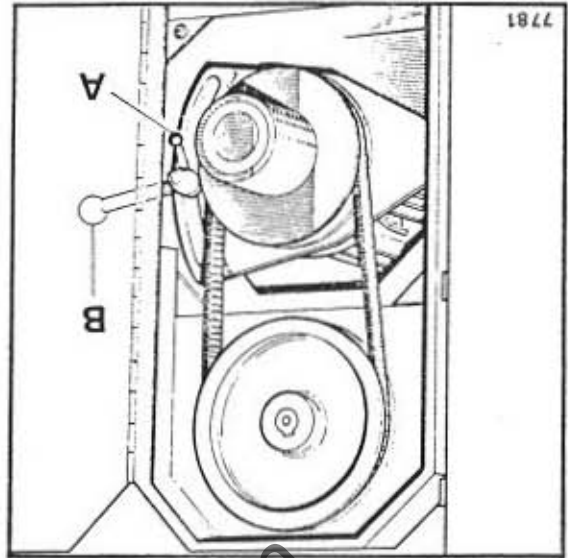


FIG C11

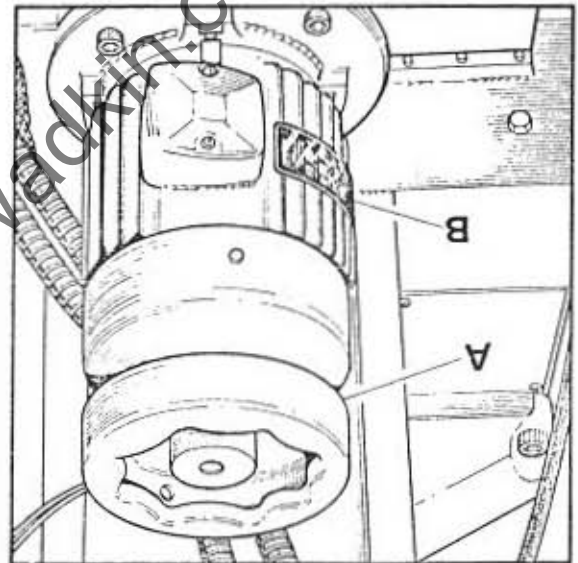


FIG C9

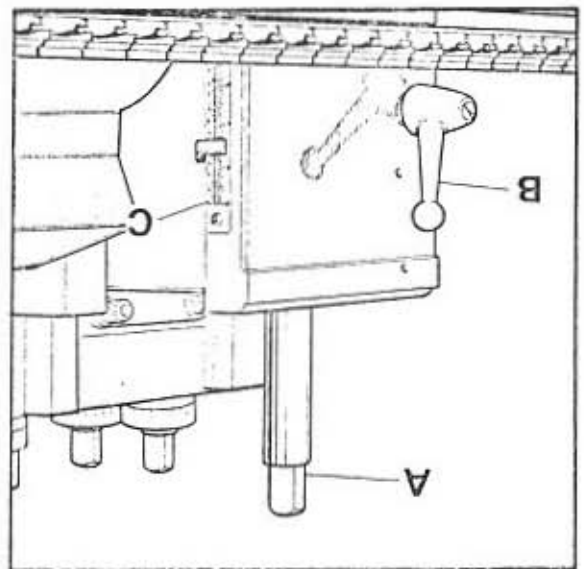


FIG C14

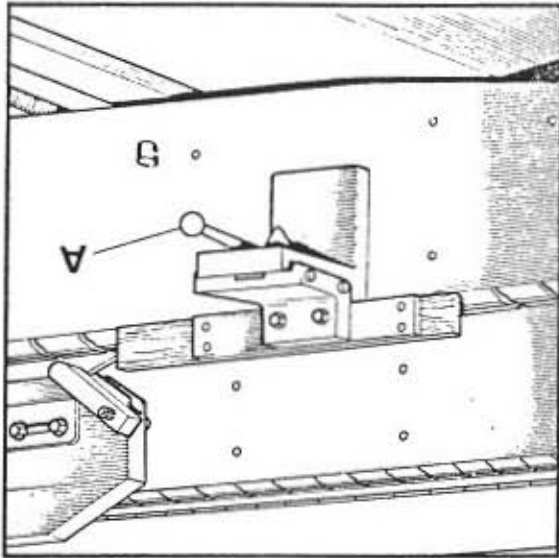


FIG C12

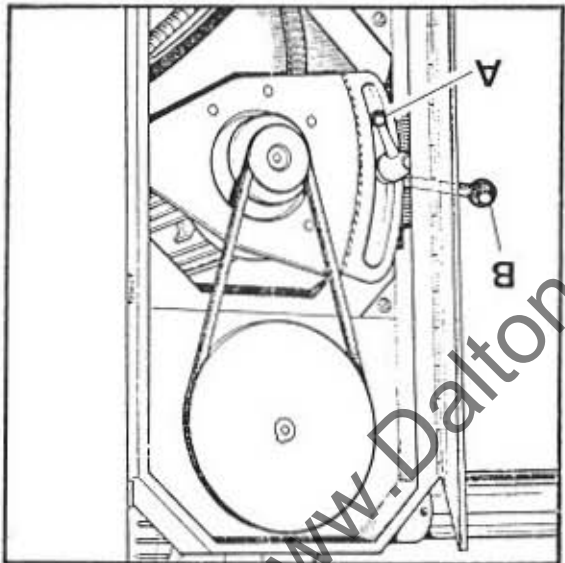
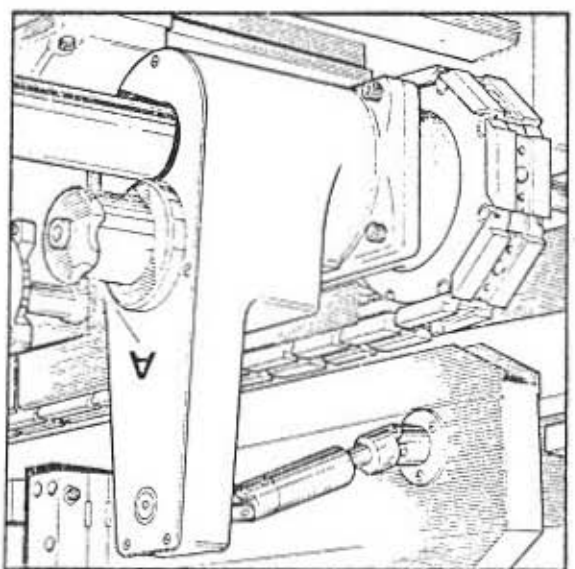


FIG C10



ADJUSTMENTS Cont'd.

Fig. C8 Cont'd.

Note:

Depending on the working position of the head unit, it may foul with part of machine. By loosening the locknut (D), the head unit can be pivoted to prevent fouling, then relock locknut (D).

Top Pressure Adjustment

Fig. C9

Each top pressure beam can be adjusted vertically by the screw (A). Vertical lock to beam is by locking handle (B). A timber thickness scale (C) is fitted to the pressure beam slide. Setting the pointer to correspond to the timber thickness ensures correct pressure.

Clutch Drive to Top Pressures

(Top Driven pressures only)

Fig. C10

Drive to each top pressure is through a friction clutch controlled by handwheel (A). This feature compensates for the feed speed differential between tracks and top pressures. Drive to each top pressure can be completely disengaged by removing pressure from the friction clutch by means of the handwheel.

Column Traverse Adjustment

Fig. C11

Traverse of adjustable column is by means of the traverse switch as previously described in SECTION C7F. For fine adjustment of traverse a handwheel (A) is fitted to traverse motor (B). For accurate adjustment a traverse scale is fitted to the bed slide and is indicated by a pointer mounted on the adjustable saddle.

Feed Speed Adjustment

Fig. C12

Drive to the backshaft is through an interchangeable vee belt from a two speed motor (Non Variable Drive) thus giving four alternative feed speeds. A switch situated on the electrical control cabinet determines speed of motor.

Belt change for required feed speed is as follows:-

- 1 Open door for access to belt drive and release locking handle (A).
- 2 Relieve tension from belt by raising handle (B).
- 3 Change belt.
- 4 Re-tension by lowering handle (B) until weight of motor is taken by belt tension.
- 5 Re-lock locking handle (A).

Feed Speed Adjustment (Variable Speed Drive)

Fig. C13

- 1 Release locking handle (A).
- 2 Raise speed control handle (B) to increase or lower to decrease speed.
- 3 When set, relock locking handle (A).

Note:

Ensure motor is running before attempting to adjust feed speed (Variable Drive) or damage may occur to belt.

Fence

Fig. C14

The fence ensures that timber is fed squarely into the machine and in correct position in relation to heads. Adjust by loosening locking handle (A), setting fence as required, then relocking handle (A).

Polyurethane Pads

Polyurethane friction pads can be supplied as an optional extra and are recommended for use when feeding large panels against rear face of dogs. This facility produces more accurate feeding due to the frictional adhesion action between timber and pads. See Fig. C4.

Note:

Extra long dogs must be fitted to make up height difference when polyurethane pads are employed.

SECTION C

Setting Up

Fig. C15

1. Loosen two nuts (A) securing each cutter guard and remove guards.
2. Fit required cutters to spindles and secure with spindle nut (B). To lock each spindle whilst tightening nut, insert a 3/8" diameter bar through spindle housing and locate in spindle. When nut is secure, remove bar and refit guards.

Note:

Certain slitting and grooving operations can be performed on the inside of the top pressure beam by passing the cutter spindle through the rectangular slots and mounting the cutter inside the pressure beam.

If a great reduction in section or a complex profile is required, both front and rear heads should be used, cutting part of the section or profile at the front heads and taking a finishing cut at the rear heads. When profile cutting use top heads only.

Fig. C16

3. Set each head vertically by loosening locknut (A) and positioning head vertically by means of screw (B) using height scales (C) on control panels and micro adjustment scales (D) fitted to each adjusting screw. Relock locknut (A).

Note:

Ensure locks are free before making either vertical or horizontal adjustment.

4. Set heads at required angle by loosening locknut (A) canting head unit (B) to required angle using the canting scale (C) then relocking locknut (A). (Fig. C10).
5. Set heads at required lateral position, by loosening locknut (A) adjusting head laterally to required position by means of screw (B) using scale fitted to top of lateral slide housing and micro adjustment scale (D) fitted to end of slide. Re-lock locknut (A) (Fig. C9).
6. Using column traverse switch F in Fig. C7 fitted to adjustable beam control panel position column so that width of material that can be worked is approximately that required using traverse scale fitted to bed slide. Exact working width can be set by means of the fine adjustment handwheel (B). (Fig. C13).
7. Set top pressure beams to thickness of timber:- loosen locking handle (B). Adjust pressure beam vertically by means of screw (A) using accurate timber thickness scale (C) fitted to pressure beam slide. Relock locking handle (B) (Fig. C11).

Fig. C17

8. Set number of disappearing drive dogs required. Those not required should be secured below level as follows:- Insert screwdriver into slot of dog and push dog below chain link setting plate. Turn to secure. Dogs are mounted eccentrically for securing and adjusting purposes.

Note:

Fig. C18

When feeding narrow boards etc., feed against front of dogs, when feeding large panels, feed against rear of dogs (back dog).

9. Set required feed speed as previously described in page C6.

Fig. C19

10. Hold back shoe units (A) are fitted to the front of the pressure beams and can be mounted on either inside or outside of beams depending on size of timber being worked. These units are fitted with flexible bushes which allow the units to swivel slightly when displaced.

To set, loosen nut (B) and set unit (A) approximately 1/4" down on thickness of timber being worked, then relock nut (B).

Note:

These units should be either removed or released when "back dogging".

Fig. C20

11. Set fence (A) in to ensure timber is fed square through machine, loosen locking handle (B), set fence as required, then relock handle (B).

Note:

Ensure machine is correctly lubricated before commencing to start. Set lubrication bottle drip feed adjuster (A) to maximum and turn on lever (B). (Fig. C3).

Ensure lubrication bottle lever (B) is turned on at all times when machine is operating. See LUBRICATION CHART SECTION D.

FIG C 19

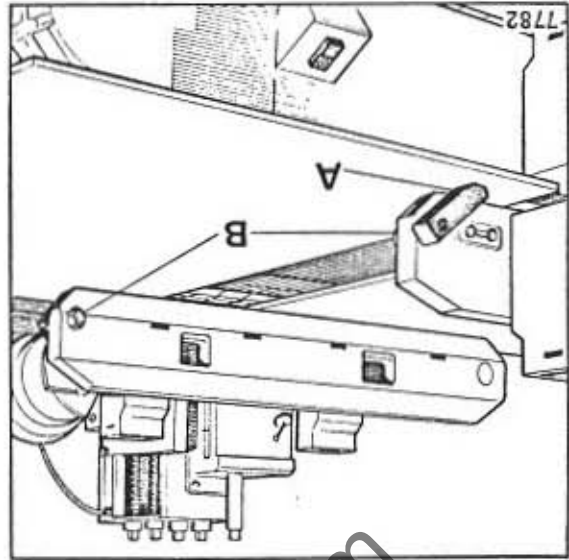


FIG C 17

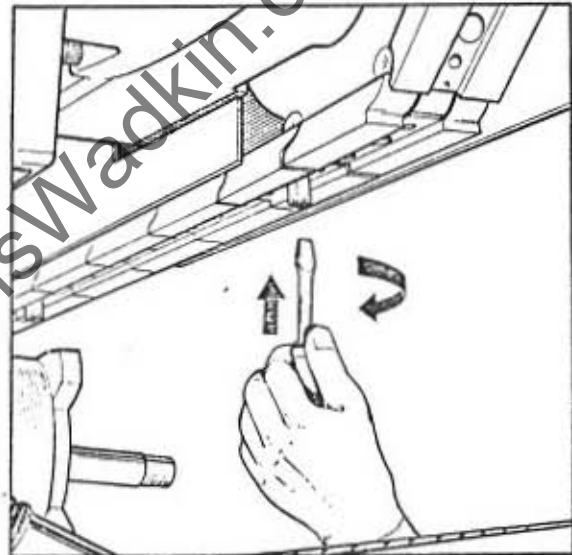


FIG C 15

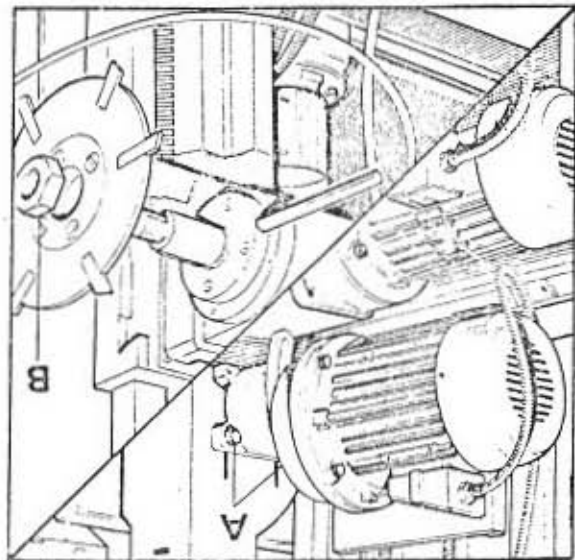


FIG C 20

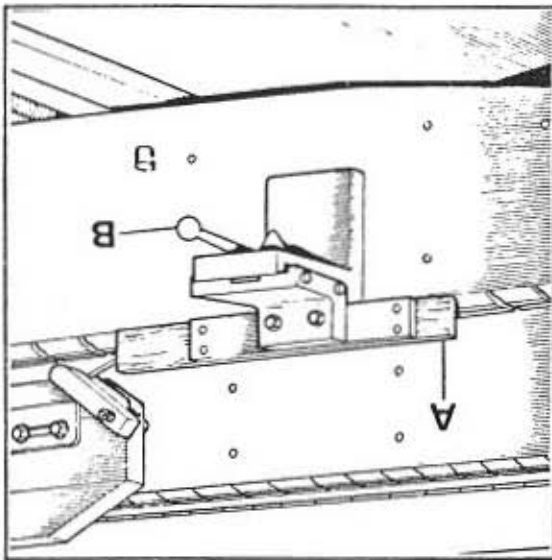


FIG C 18



FIG C 16

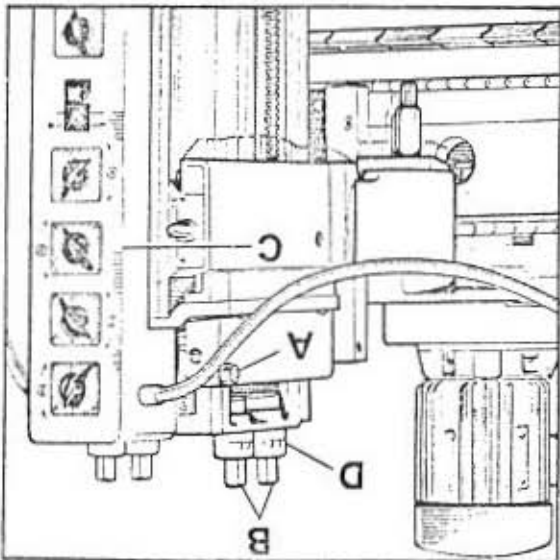


FIG C23

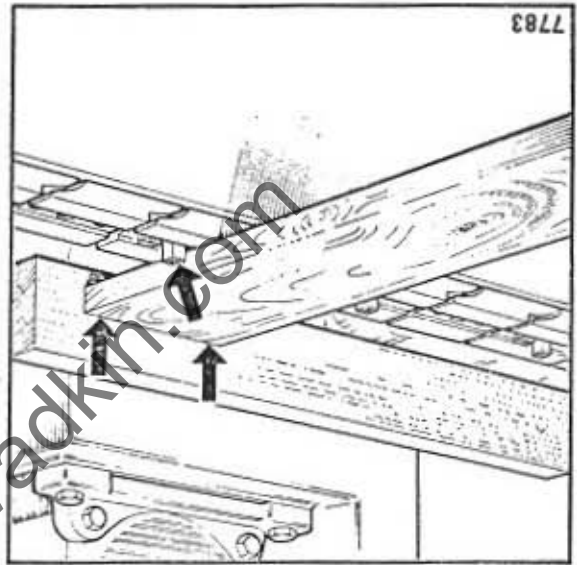


FIG C21

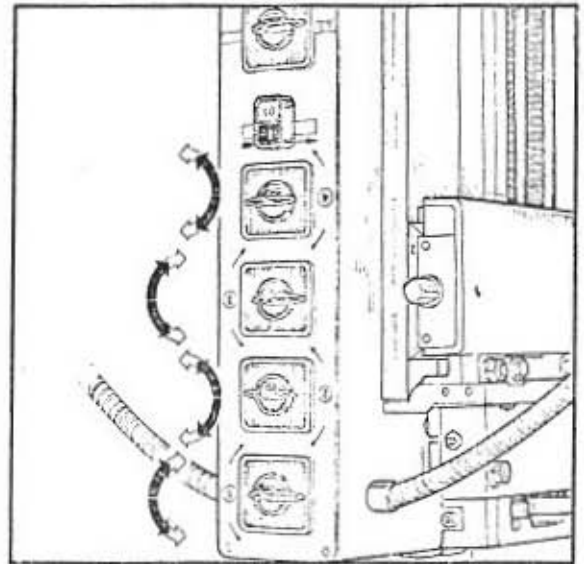


FIG C24

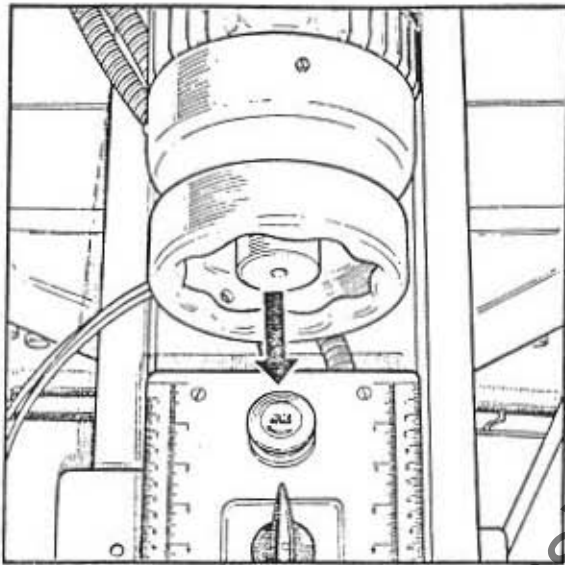
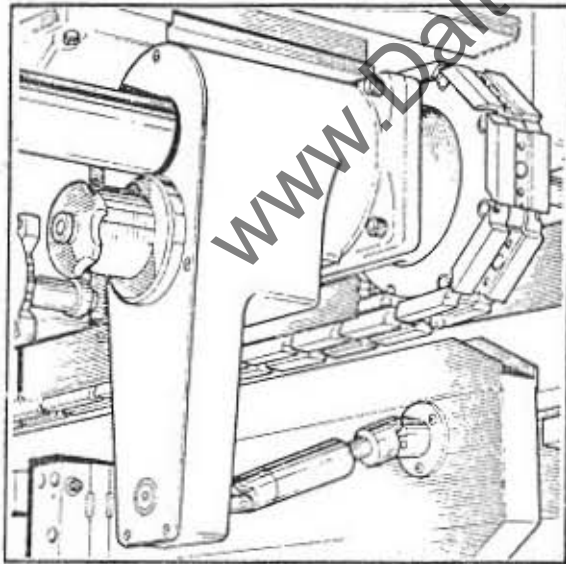


FIG C22



Starting

Before commencing to start machine check carefully to ensure that all the cutters are tight and secure on their respective cutterblocks. Check that the pressures and fence are set correctly.

Fig. C21

1. Select correct head rotational direction for each head in use.
2. Place isolator switch fitted to electrical control cabinet, in ON position.
3. Start each head by moving its switch to 'START'.
4. Start tracks. For operating convenience an extra control switch is mounted on each track, in addition to that on each headstock.

Fig. C22

5. Engage top pressure drive, if fitted, using handwheel. When using front of dogs (forward feed) DO NOT engage top pressure drive.

Fig. C23

6. Carry out work, pushing material squarely up to material stop and dogs to ensure accurate machining.

Stopping**Fig. C24**

1. Press either of the master stop switches on the headstock control panels.
2. Place isolator switch in OFF position.

Note:

There is no need to switch off individual control switches unless machine is to be out of use for any considerable period of time.

SECTION D

GENERAL MAINTENANCE
LUBRICATION

DAILY

- A Two depressions of oil gun containing Wadkin Oil grade L.4.
 B Two depressions of oil gun containing Wadkin Oil grade L.4, whilst pressures are running.
 G Fill with Wadkin Oil grade L.4.

WEEKLY

- F Oil cross traverse screws, raising screws and all slideways for head and pressure, using Wadkin Oil grade L.4.
 Oil backshaft, traverse screw and bed slides using Wadkin Oil grade L.4.

MONTHLY

- C Check oil level. Fill with Wadkin heavy gear oil grade L.2 until tip up filler overflows.
 D Check oil level in Croft gear box. Fill up to levelling hole with Wadkin heavy gear oil grade L.2.

THREE MONTHLY

- E Two grease nipples to each head. Give three depressions of grease gun containing Wadkin grease grade L.6, if grease nipples are fitted.

Note:

If machine is fitted with variable speed drive, give three depressions of grease gun every three months to grease nipple mounted on variable speed pulley, using Wadkin grease grade L.6.

APPROVED LUBRICANTS

WADKIN GRADE	CASTROL	B.P.	SHELL	MOBIL	ESSO	GULF	CALTEX
L.2.	Alpha LS4	Energol CS.425	Vitrea 75	DTE Oil AA	Pen-O-Led EP3	Security 118	Meropa Lubricant 4
L.4.	Magna ED	Energol H.P. 20	Vitrea 33	Vactra Oil Heavy Medium	Esstic 50	Service 51	Ursa P.20
L.6.	Spheerol AP3	Energrease LS3	Alvania Grease No. 3	Mobilplex Grease No. 48	Beacon 3	Gulfcrown Grease No. 3	Regal Starfak Premium 3

FIG D1

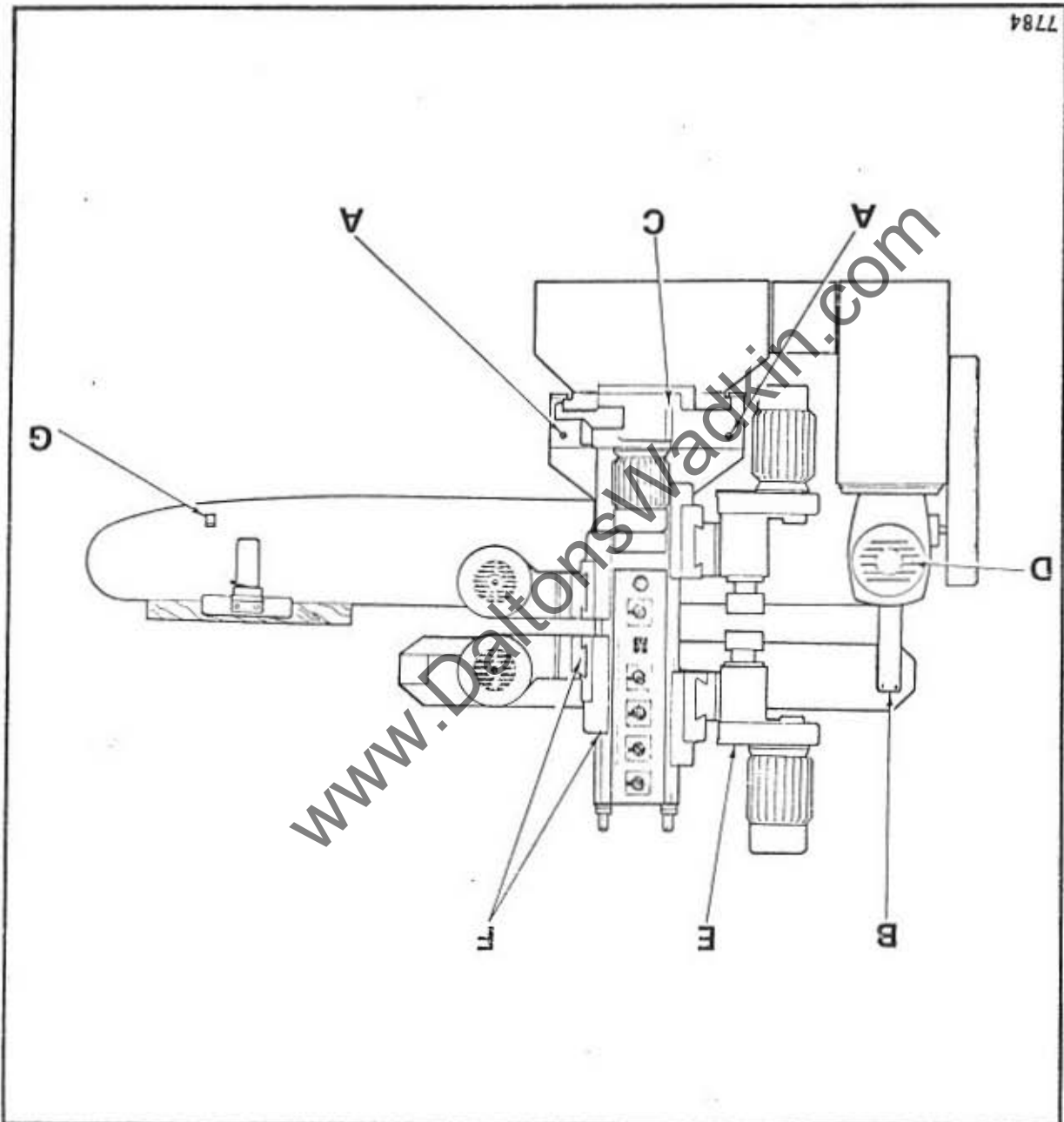


FIG D6

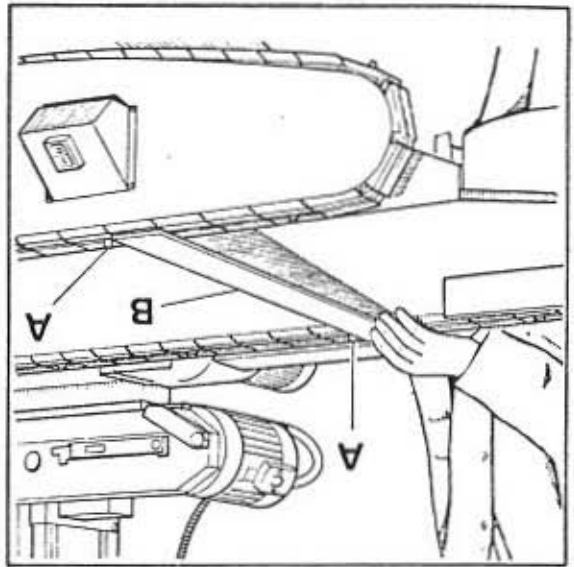


FIG D7

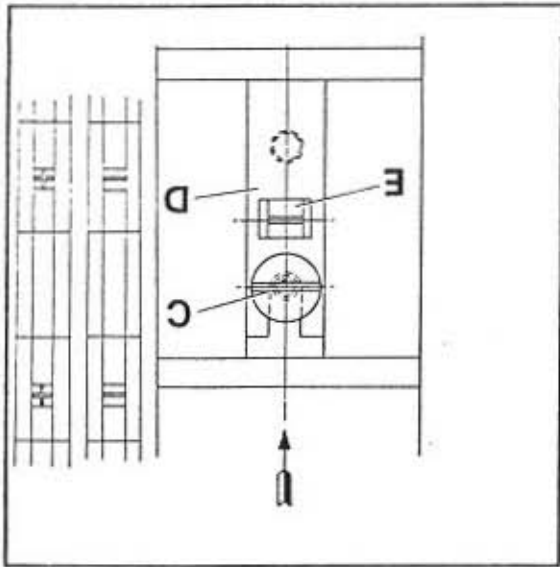


FIG D4

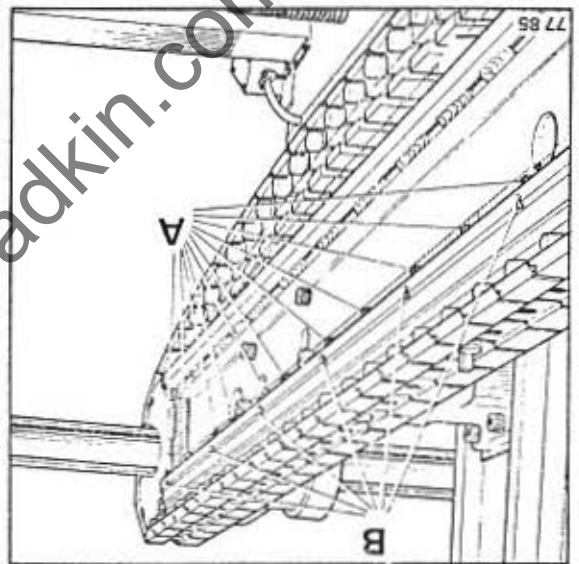


FIG D5

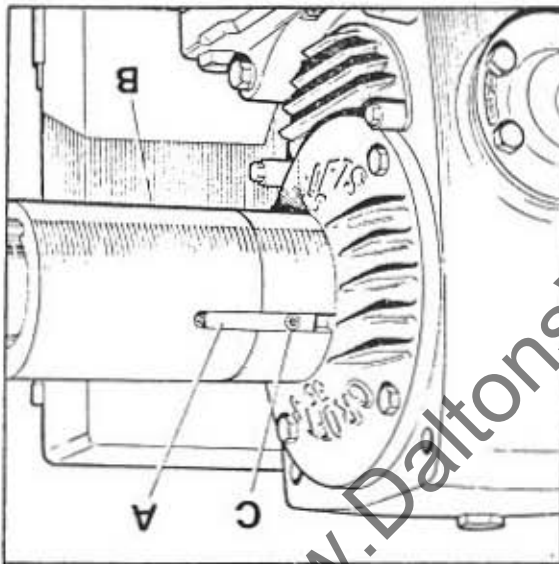


FIG D2

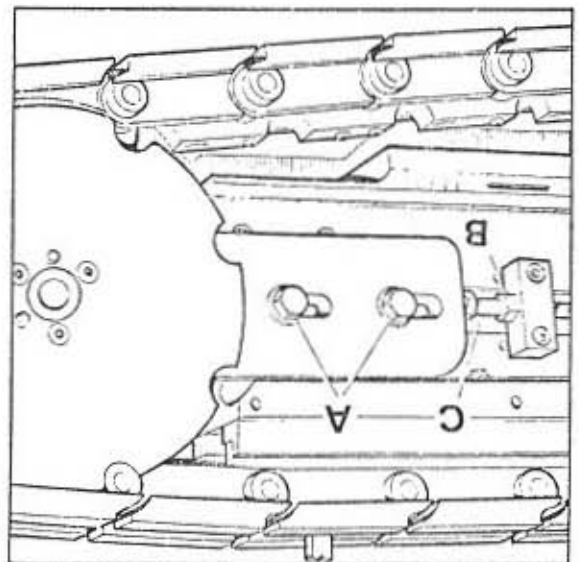
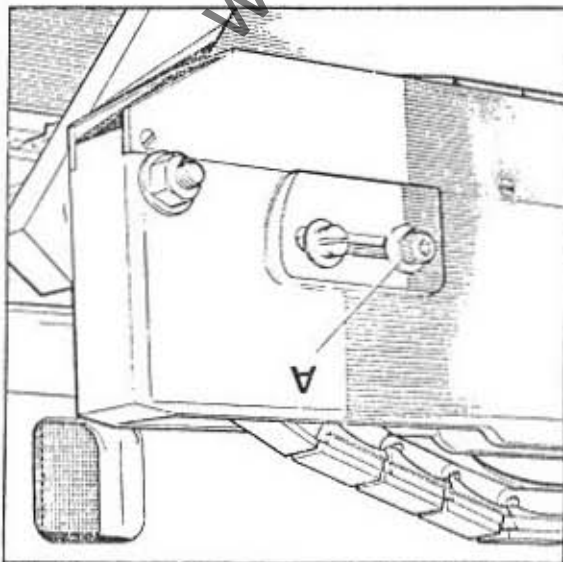


FIG D3



GENERAL MAINTENANCE

SECTION D

Track Tension Adjustment

Fig. D2

Periodically check to ensure that return side of each track follows the profile of the beam cover. Adjust if necessary as follows:-

1. Loosen four round head screws and remove chain idler sprocket cover.
2. Loosen two bolts (A) securing idler sprocket to beam.
3. Loosen locknut (B) and turn adjusting screw (C) until lower side of chain track follows profile of chain beam cover. Ensure that chain track does not foul underside of chain beam.
4. When set, tighten locknut (B) and two securing bolts (A). Refit chain cover.

Top Pressure Track Tension Adjustment

Fig. D3

Periodically check to ensure $\frac{3}{4}$ " deflection at return side of each top pressure track. Adjust if necessary as follows:-

1. Loosen socket head capscrew (A) and move sprocket along slot until deflection of track at return side is $\frac{3}{4}$ ".
2. Hold sprocket in position and retighten socket head capscrew (A).

Setting Disappearing Dogs for Squareness

The disappearing dogs are pre-set for squareness at the works but during life of machine, feeding out of square may occur. If necessary adjust as described in section C, page C2, paragraph 5.

Track Side Play Adjustment

Fig. D4

If side play in chain track occurs, adjust as follows:-

1. Loosen socket head capscrews (A).
2. Adjust screws (B) to eliminate play.
3. When set relock socket head capscrews (A).

Backshaft Shear Key

Fig. D5

The drive from the worm reduction box to the backshaft is through a brass shear key (A) located in the coupling (B). This key prevents overload in the drive assembly. In the event of an overload the sheared key can be removed by loosening the countersunk head screw (C). Replace with new key.

Cleaning

Cleanliness of machine cannot be over emphasized.

1. Blow traverse leadscrew clean with airline or similar — once daily.
2. Blow chain tracks clean — twice daily.
3. Blow heads vertical adjustment and lateral adjustment screws clean — once daily.
4. Remove side panels from chain beams and covers from top pressure housings. Blow clean — twice fortnightly.

Fig. D6 & D7

5. Check squareness of disappearing drive dogs (A). Check each pair across the tracks, individually. Place a large try square (B) with stock to fence of Tenoner and blade across tracks. Each pair of dogs should be up to blade during check. Fig. D6 The dogs are eccentrically fitted in the tracks to make adjustment especially easy and accurate. Slacken cheese head screw (C) securing each dog setting plate (D), insert a screwdriver in top of dog (E), push dog below plate and turn it to correct position to square up with corresponding dog on other track. Move setting plate forward or back to allow dog to pass up through it. Lock in position using cheese head screw. Fig. D7

Important

All disappearing dogs are marked + or —. Ensure that all dogs marked + are on the same chain track. All dogs marked — should be on other train track. Correct adjustment of + and — dogs enables fine adjustment to be made.

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- Belt Tension**
Should a head belt be removed for some reason or renewed, retensioning will be necessary.
- Fig. D8 and D9
To Retension**
1. Loosen two round head screws (A) and remove inspection cover (B).
 2. Slacken motor pivot capscREW (C) and aerotight nut (D) in Fig.
 3. With motor running, adjust motor until belt runs in a true vibrationless path around pulleys and re-tighten pivot capscREW (C) and aerotight nut (D).
- Note:**
Too little tension will cause belt to vibrate or 'flap'. Too much tension will result in excessive belt 'whine'.

TIMING BELT DRIVE

FIG D9

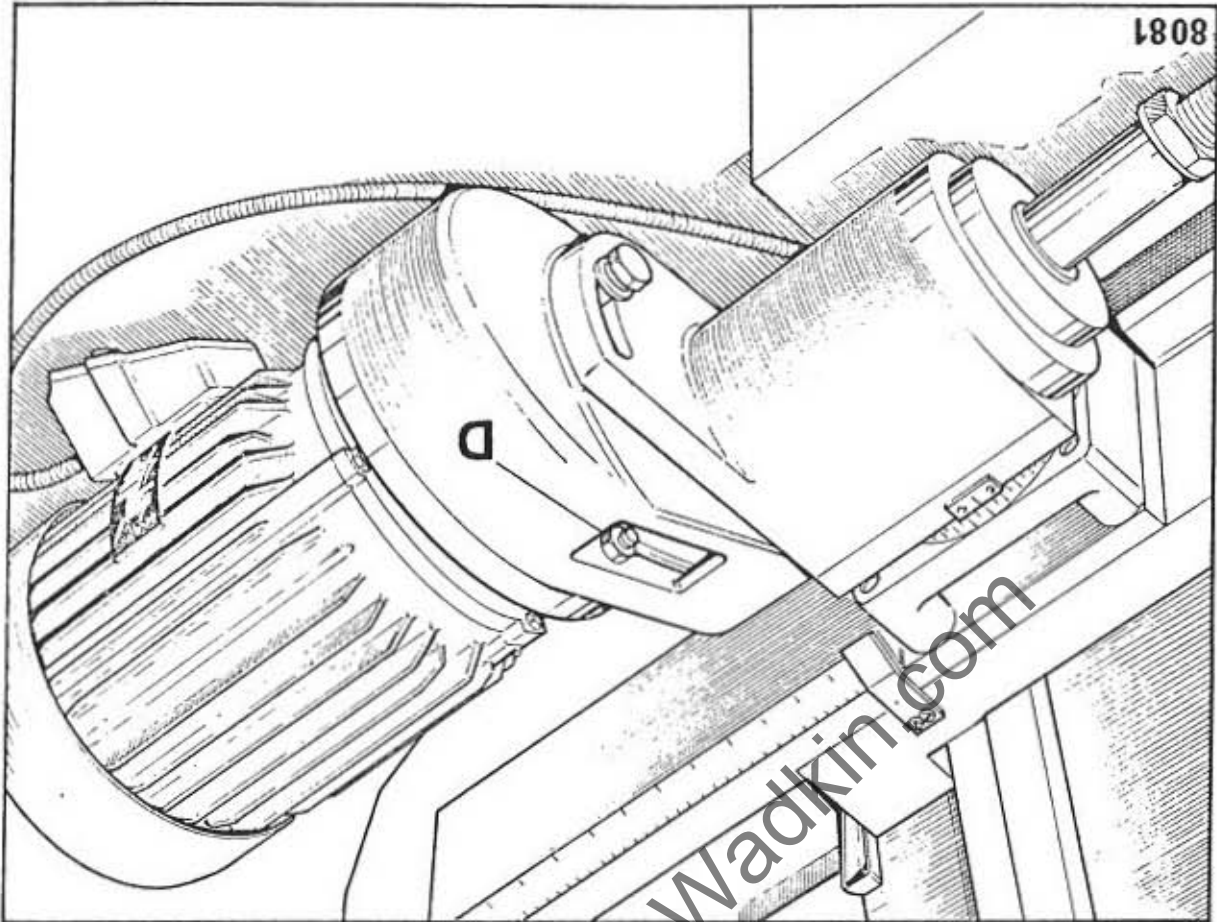
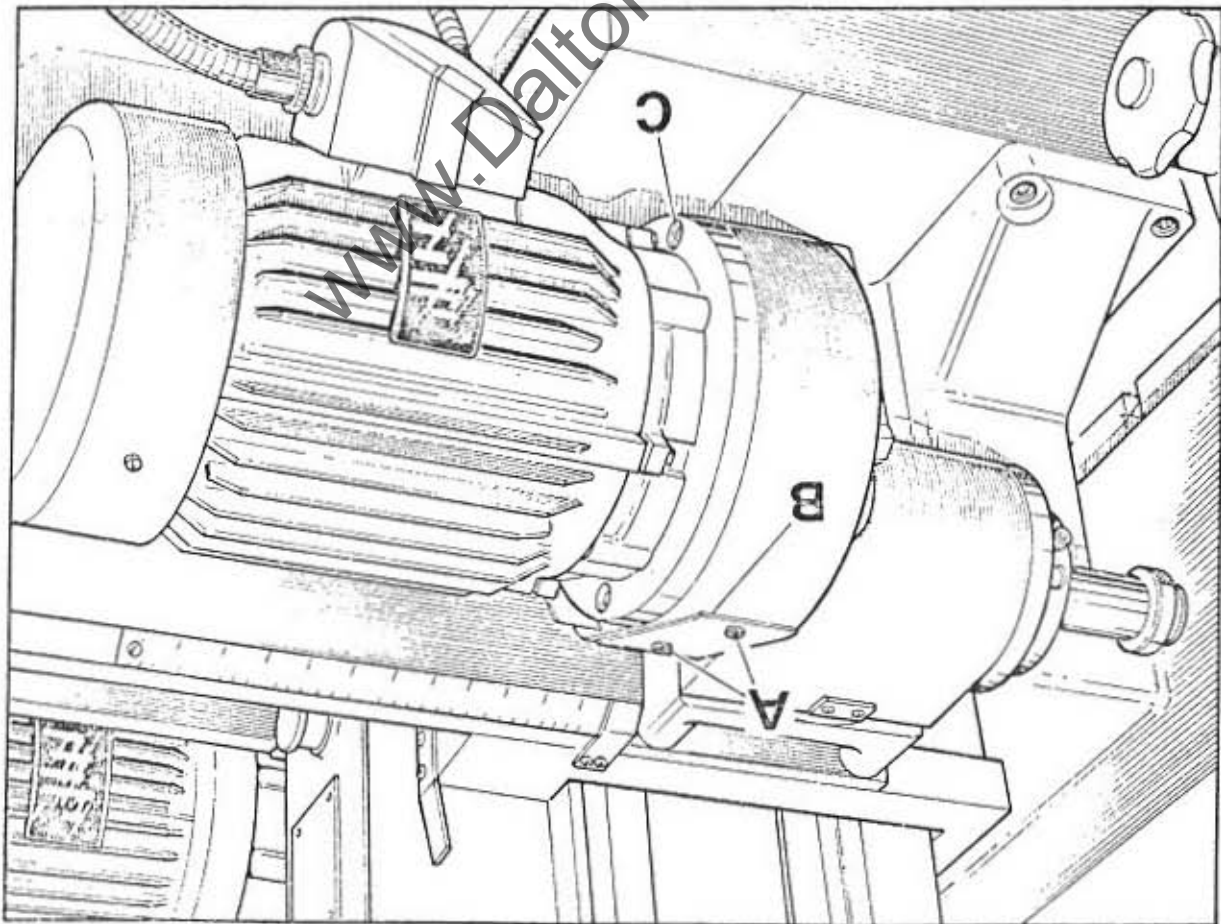


FIG D8



SPARE PARTS LIST

ILLUSTRATIONS

SECTION F

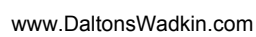
Page F1	Bed assembly
Page F4	Backshaft drive assembly
Page F5	Feed motor mounting
Page F8	Saddle assembly
Page F9	Saddle traverse box assembly
Page F12	Column assembly
Page F13	Chain beam assembly
Page F16	Chain drive sprocket assembly
Page F17	Feed chain idler sprocket assembly
Page F20	Head slide assembly
Page F21	Head barrel assembly
Page F24	Head assembly
Page F25	Pressure beams slide assembly
Page F28	Clutch drive to pressure assemblies
Page F29	Driven top pressure assembly
Page F32	Non-driven top pressure assembly
Page F33	Fence assembly

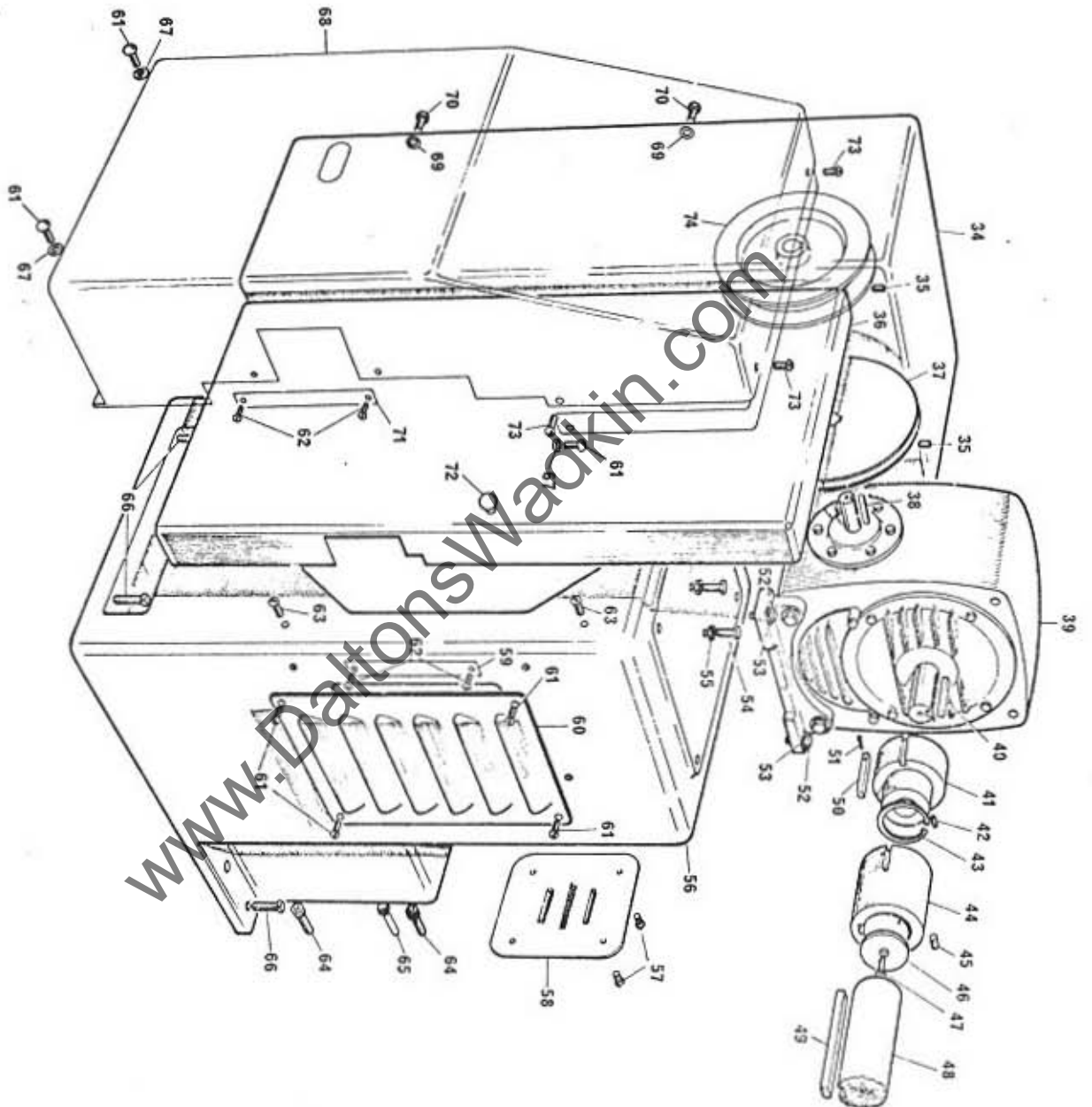
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SECTION F

BED ASSEMBLY

Ref. No.	Part No.	Description	No. Off
1	WU114	Tension nut for traverse screw	4 per m/c.
2	WU383	Traverse screw bracket (fixed head end)	1
	WU384	Traverse screw bracket (adjustable head end)	1
3	K05/20/710	3/8" dia. x 1.1/2" long square head dowel	4
4		1/2" whit. x 1.1/4" long socket head capscrew	4 per m/c.
5	WU335	Trip cam for bed	2
6		1/4" washer	4
7		1/4" whit. x 1" long socket head grubscrew	4
8		1/4" wide. x 2" long feather key	1
9	WU125	Traverse screw (5' 0" machine)	1
	WU126	Traverse screw (8' 6" machine)	1
10		3/16" whit. x 3/8" long countersunk screw	As req'd.
11	WU127	English rule, 5' 0" machine, L.H. opening	1
	WU374	English rule, 5' 0" machine, R.H. opening	1
	WU375	Metric rule, 5' 0" machine, L.H. opening	1
	WU376	Metric rule, 5' 0" machine, R.H. opening	1
	WU372	English rule, 8' 6" machine, L.H. opening	1
	WU373	English rule, 8' 6" machine R.H. opening	1
	WU377	Metric rule, 8' 6" machine, L.H. opening	1
	WU378	Metric rule, 8' 6" machine, R.H. opening	1
12		1/2" whit. x 3/4" long hexagon head bolt	4
13	WU468	Cover plate for aperture	1
14	WU122	Machine bed (5' 0" machine)	1
	WU329	Machine bed (8' 6" machine)	1
15		1/2" whit. x 2" long square head bolt	6 per 5' 0" m/c.
		1/2" whit. x 2" long square head bolt	8 per 8' 6" m/c.
16	WA149	Packing pieces	As req'd.
17		1.1/4" dia. conduit tubing for 5' 0" machine	3' 10"
		1.1/4" dia. conduit tubing for 8' 6" machine	5' 10"
18	WU326	Conduit bracket	1
19		1" dia. flexible tubing for 5' 0" machine	3' 10"
		1" dia. flexible tubing for 8' 6" machine	5' 10"
20	QAJ260	Wadkin nameplate	1
21		3/16" whit. x 3/8" long round head screw	2
22	A-1045/242	Cover plate	1
23	WU128	Common filling in piece	1





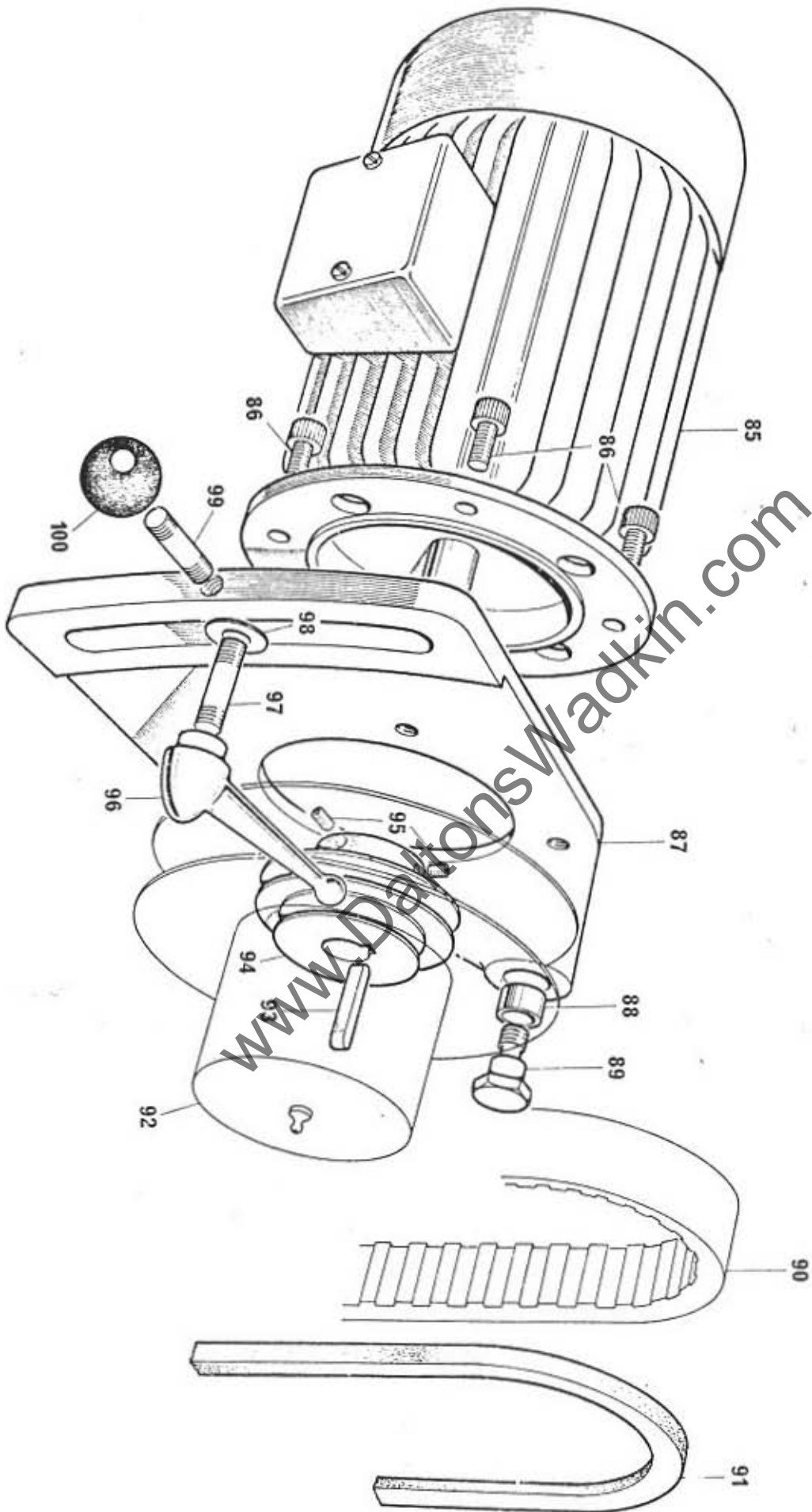
BACKSHAFT DRIVE ASSEMBLY

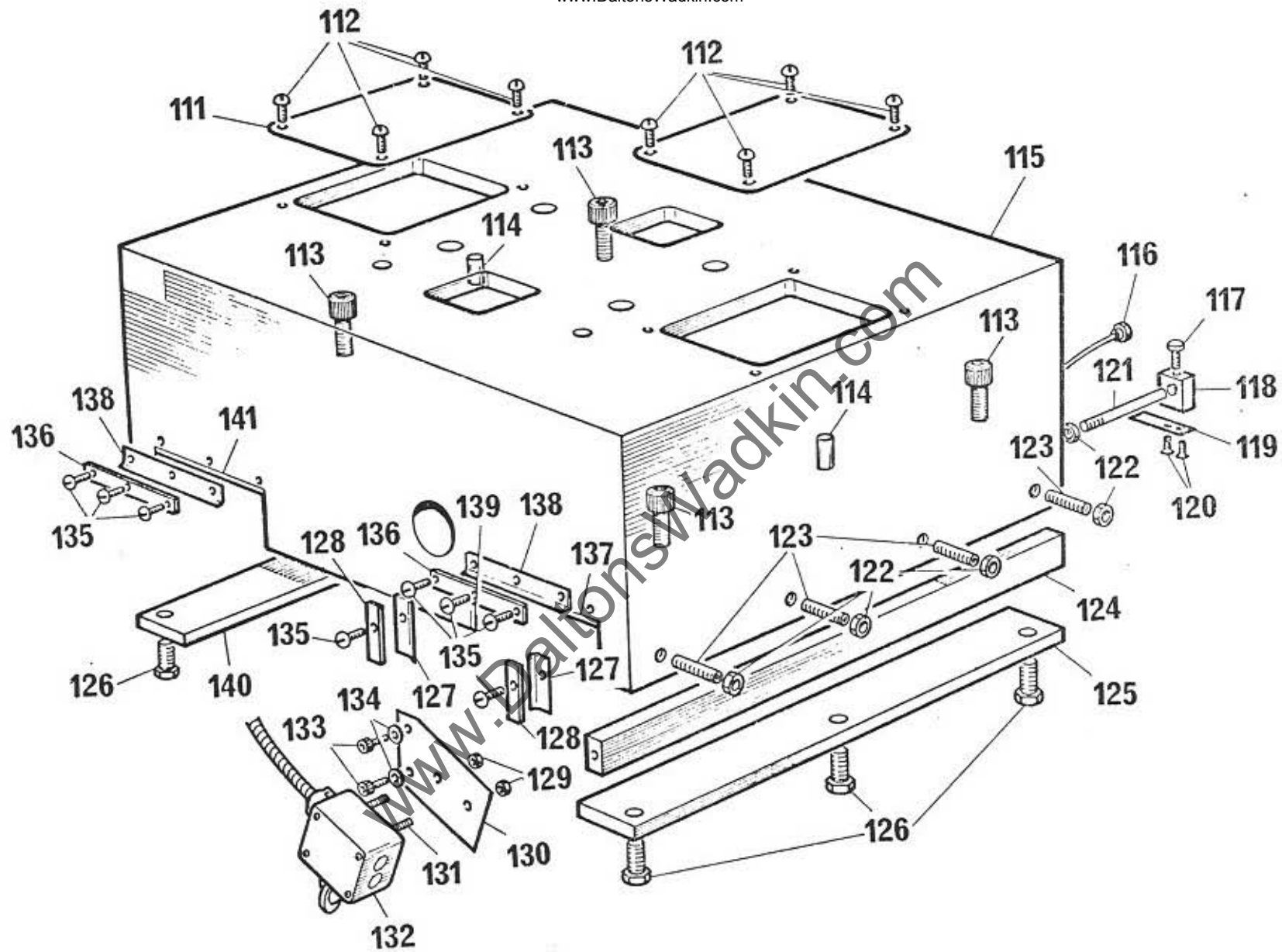
Ref. No.	Part No.	Description	No. Off
34		Electrical control cabinet	1
35		5/16" whit. x 3/8" long socket head grubscrew	2
36	WU342	Drive cover for 4 speed drive	1
37	WU156	Wormbox pulley (50 cycles)	1
	WU481	Wormbox pulley (60 cycles)	1
38		1/4" wide. x 2.1/2" long feather key	1
39	RR35	Croft worm reduction box assembly No. 2 (L.H. machine)	1
	RR35	Croft worm reduction box assembly No. 1 (R.H. machine)	1
40		3/8" wide x 2.3/4" long feather key	1
41	WU483	Wormshaft coupling	1
42		1/2" whit. x 1" long socket head grubscrew	1
43	5000/250	Truarc internal circlip	1
44	WU482	Backshaft coupling	1
45		1/2" whit. x 1/2" long socket head grubscrew	1
46	WU312	Coupling washer	1
47		5/16" whit. x 1" long countersunk socket head capscrew	1
48	WU501	Backshaft (5' 0" machine)	1
	WU502	Backshaft (8' 6" machine)	1
49	WU503	Fixed key for backshaft (5' 0" machine)	1
	WU504	Fixed key for backshaft (8' 6" machine)	1
50	WU313	Brass shear key for coupling	1
51		3/16" whit. x 3/4" long countersunk socket head screw	1
52		1/2" whit. x 1.1/2" long hexagon head bolt	4
53		1/2" washer	4
54		3/8" whit. x 1.3/4" long hexagon head bolt	2
55		3/8" whit. locknut	2
56	WU341	Wormbox support	1
57		1/4" whit. x 1/2" long raised head screws	4
58	1031/53	Cover plate	1
59	WU337	Feed speed plate (high range - variable drive)	1
60	WN278	Cover for feed drive	1
61		1/4" whit. x 1/2" long round head screw	8
62		1/2" long Z.10 self tapping screw	As req'd.
63		5/16" whit. x 1/2" long round head screw	4
64		1/2" whit. x 1.1/4" long socket head capscrew	4
65	K05-20-710	3/8" dia. x 1.1/2" long square head dowel	2
66		1/2" whit. x 2" long square head bolt	4
67		1/4" washer	4
68	WU336	Drive cover (variable drive 22-48 F.P.M.)	1
	WU555	Drive cover (variable drive 11-48 F.P.M.)	1
69		3/8" washer	4
70		3/8" whit. x 1/2" long hexagon head bolt	4
71	WU338	Feed speed plate (low range - variable drive)	1
72		1" dia. 'Rencol' knob, 5/16" whit. bore	1
73		3/16" whit. x 1/2" long round head screw	4
74	WU332	Wormbox pulley (50 cycle - variable drive, 22-48 F.P.M.)	1
	WU445	Wormbox pulley (60 cycle - variable drive, 22-48 F.P.M.)	1
	WU552	Wormbox pulley (50 cycle - variable drive, 11-48 F.P.M.)	1
	WU553	Wormbox pulley (60 cycle - variable drive, 11-48 F.P.M.)	1

SECTION F

FEED MOTOR MOUNTING

Ref. No.	Part No.	Description	No. Off
85		D90LD, flange mounted motor, 1.4/.75 H.P. 1,500/750 R.P.M. T.E.F.C. 3 phase, 50 cycles	1
		D90LD, flange mounted motor, 1.4/.75 H.P. 1,800/900 R.P.M. T.E.F.C. 3 phase, 60 cycles	1
		D90LD, flange mounted motor, 2 H.P. 1,500 R.P.M. T.E.F.C. 3 phase, 50 cycles	1
		D90LD, flange mounted motor, 2H.P. 1,800 R.P.M. T.E.F.C. 3 phase, 60 cycles	1
		D112MD, flange mounted motor 3/1½ H.P. 1,500/750 R.P.M. T.E.F.C. 3 phase, 50 cycles	1
		D112MD, flange mounted motor, 3/1½ H.P. 1,800/900 T.E.F.C. 3 phase, 60 cycles	1
86		3/8" whit. x 3/4" long socket head capscrew	4
87	WU330	Motor plate	1 per m/c
	WU554	Motor plate (special for 3/1½ H.P. motor)	1
88		3/4" i/d. x 7/8" o/d. x 3/4" long oilite bush	1
89	WU319	Locating pin for motor plate	1
	WU556	Locating pin for motor plate (special for 3/1½ H.P. motor)	1
90	Q/467	Variable speed vee belt (50 cycles)	1
	Q/537	Variable speed vee belt (60 cycles)	1
91	ALPHA 400	Fenner 'alpha' spacesaver vee belt (50 cycles)	1
	ALPHA 450	Fenner 'alpha' spacesaver vee belt (60 cycles)	1
92	775/Q	Hainsworth variable speed unit (extra)	1
93		8 mm wide x 1.1/2" long feather key	1
94	WU155	Motor pulley (4 speed drive)	1
95		5/16" whit. x 3/8" long socket head grubscrew	2
96		1/2" whit. 'Bursgreen' adjustable handle	1
97		1/2" whit. x 1.3/4" long stud	1
		1/2" whit. x 2" long stud (variable drive)	1
		1/2" whit. x 2.1/2" long stud (variable drive 3/1½ H.P. motor)	1
98		1/2" whit. washer (4 speed drive)	1
	WU513	Washer for variable speed lock	1
99	MA223	Handle for feed adjustment	1
100		1 3/4" dia. plastic ball, 1/2" whit. bore	1





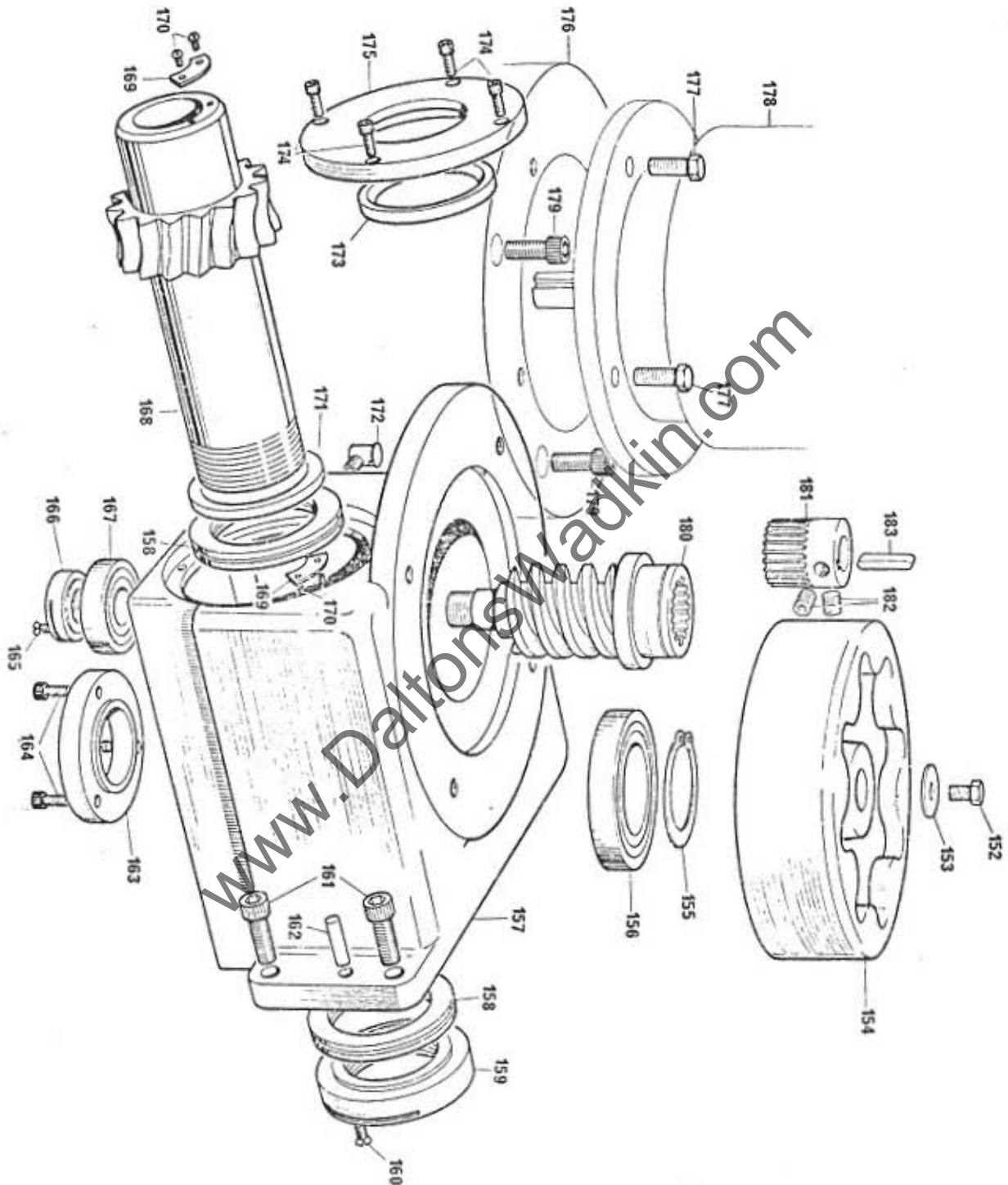
SADDLE ASSEMBLY

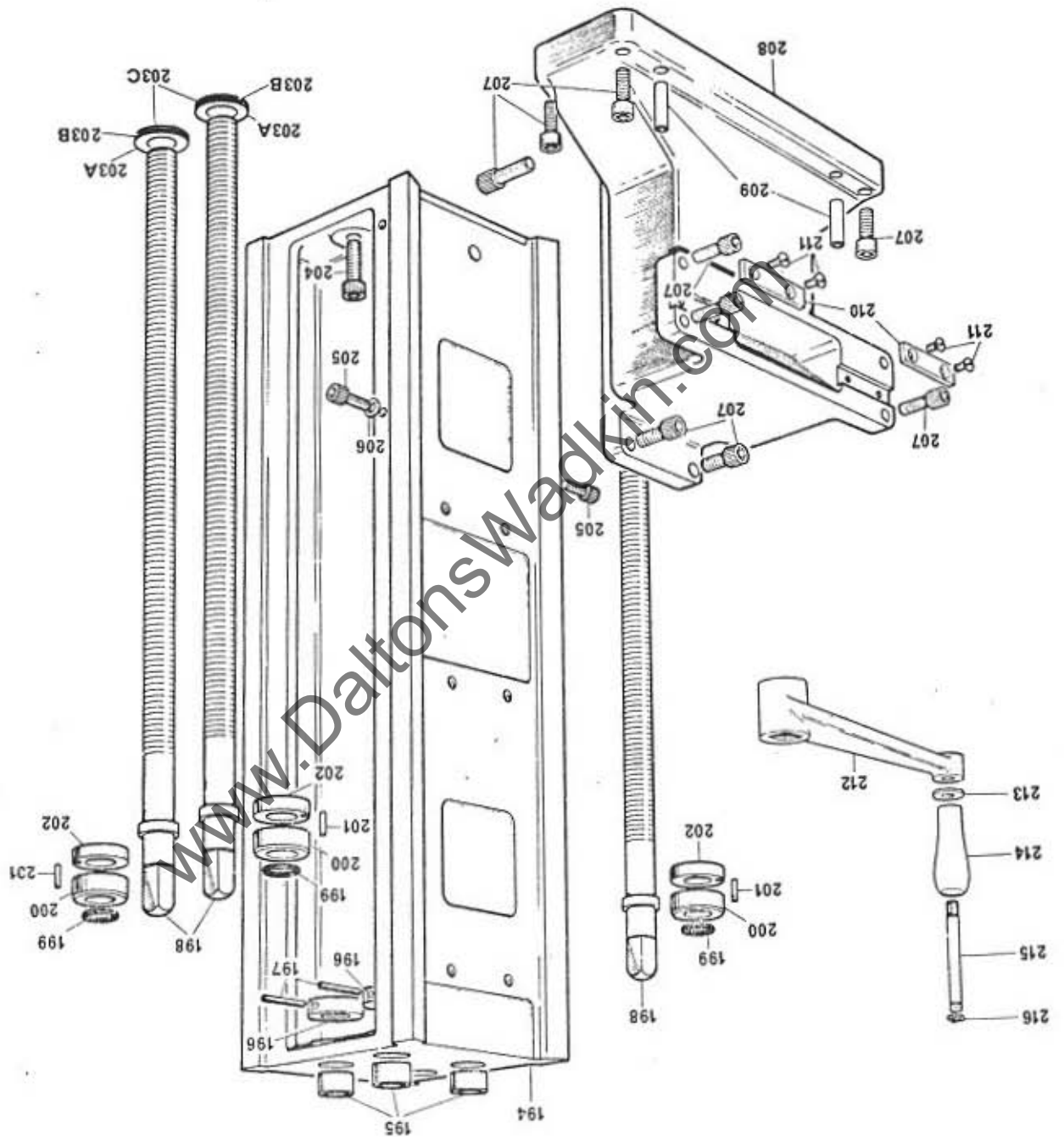
Ref. No.	Part No.	Description	No. Off
111	WU116	Cover for saddle	2 per saddle
112		3/16" whit. x 1/2" long round head screw	8 per saddle
113		1/2" whit. x 1.1/4" long socket head capscrew (fixed saddle)	4
114		3/8" dia. x 1.1/4" precision ground dowel (fixed saddle)	2
115	WU129	Adjustable saddle (L.H.)	1
	WU130	Adjustable saddle (R.H.)	1
	WU131	Fixed saddle	1
116	PC.2	Concave oiler	2
117	D/1797/62	Knurled knob	1
118	WU385	Pointer block	1 per m/c.
119	WU387	Pointer for bed rule	1 per m/c.
120		3/16" whit. x 3/8" long countersunk screw	2 per m/c.
121	WU386	Shaft for pointer block	1 per m/c.
122		3/8" whit. locknut	6 per m/c.
123		3/8" whit. x 1.1/2" long socket head grub screw	6 per m/c.
124	WU141	Wear strip for saddle	1
125	WU140	Lip plate for adjustable saddle	1
126		1/2" whit. x 1" long hexagon head bolt	6
127	Prescolian PV.1094	Wear strips for saddle (1.1/4" long)	2
128	WU474	Support plate for wipers	2
129		2BA nuts	2
130	WU334	Bracket for limit switch	1
131		2BA x 3/8" long round head screws	2
132	C32L810/811	Donavan limit switch	1
133		1/4" whit. x 1/2" long hexagon head bolt	2
134		1/4" washer	2
135		3/16" whit. x 1/2" long round head screw	11
136	WU476	Support plate for wipers	3
137	WU148	Slide strip for saddle	1
138	Prescolian PV.1094	Wear strips for saddle (3.1/2" long)	3
139	WU149	Slide strip for saddle	1
140	WU139	Lip plate for adjustable saddle	1
141	WU147	Slide strip for saddle	1

SECTION F

SADDLE TRAVERSE BOX ASSEMBLY

Ref. No.	Part No.	Description	No. Off
152		1/4" whit. x 3/4" long hexagon head bolt	1
153	WU564	Washer for traverse motor handwheel	1
154	WU561	Traverse handwheel	1
155	5100-187	Truarc external circlip	1
156	XLS 1.7/8"	Hoffman bearing	1
157	WU395	Wormbox for traverse (R.H. machine)	1
	WU394	Wormbox for traverse (L.H. machine)	1
158	AXK5578	Ina thrust needle cage	2
	GS5578	Ina housing washer	2
	WS5578	Ina shaft washer	2
159	K05/19/197	3.1/4" dia. locknut	1
160		1/4" whit. x 3/8" long countersunk screw	1
161		3/8" whit. x 1.1/4" long socket head capscrew	4
162		3/8" dia. x 1" long precision dowel	2
163	WU371	End cap for wormbox	1
164		1/4" whit. x 3/4" long socket head capscrew	3
165		3/16" whit. x 1/4" long countersunk screw	1
166	K05/19/153	1.1/2" dia. locknut	1
167	HOFF 120	Hoffman bearing	1
168	WU558	Wormwheel for traverse	1
169	WU509	Wiper pad for traverse screw	2
170		3/16" whit. x 3/8" long round head screw	4
171	WU145	Letting up spacer for wormbox	1
172	2630	Adams oil cup	1
173	W27621 631R4	'Weston' oil seal	1
174		3/16" whit. x 3/4" long socket head capscrew	4
175	WU142	End cap for wormbox	1
176	WU563	Adaptor plate for traverse motor	1
177		5/16" whit. x 1" long hexagon head bolt	4
178		Brook motor, frame T8, 2 H.P., 3000 R.P.M. T.E.N.V., 5 min. rated, flange mounted with shaft extension at N.D.E. (3 phase 50 cycles)	1
		Brook motor, frame T8, 2 H.P., 3600 R.P.M. T.E.N.V., 5 min rated, flange mounted with shaft extension at N.D.E. (3 phase 60 cycles)	1
179		3/8" whit. x 1" long socket head capscrew	4
180	WU557	Wormshaft for traverse	1
181	WU559	Traverse worm driving gear	1
182		1/8" gas x 3/8" long socket head grubscrew	2
183		3/16" wide x 1.1/4" long feather key	1





SECTION F

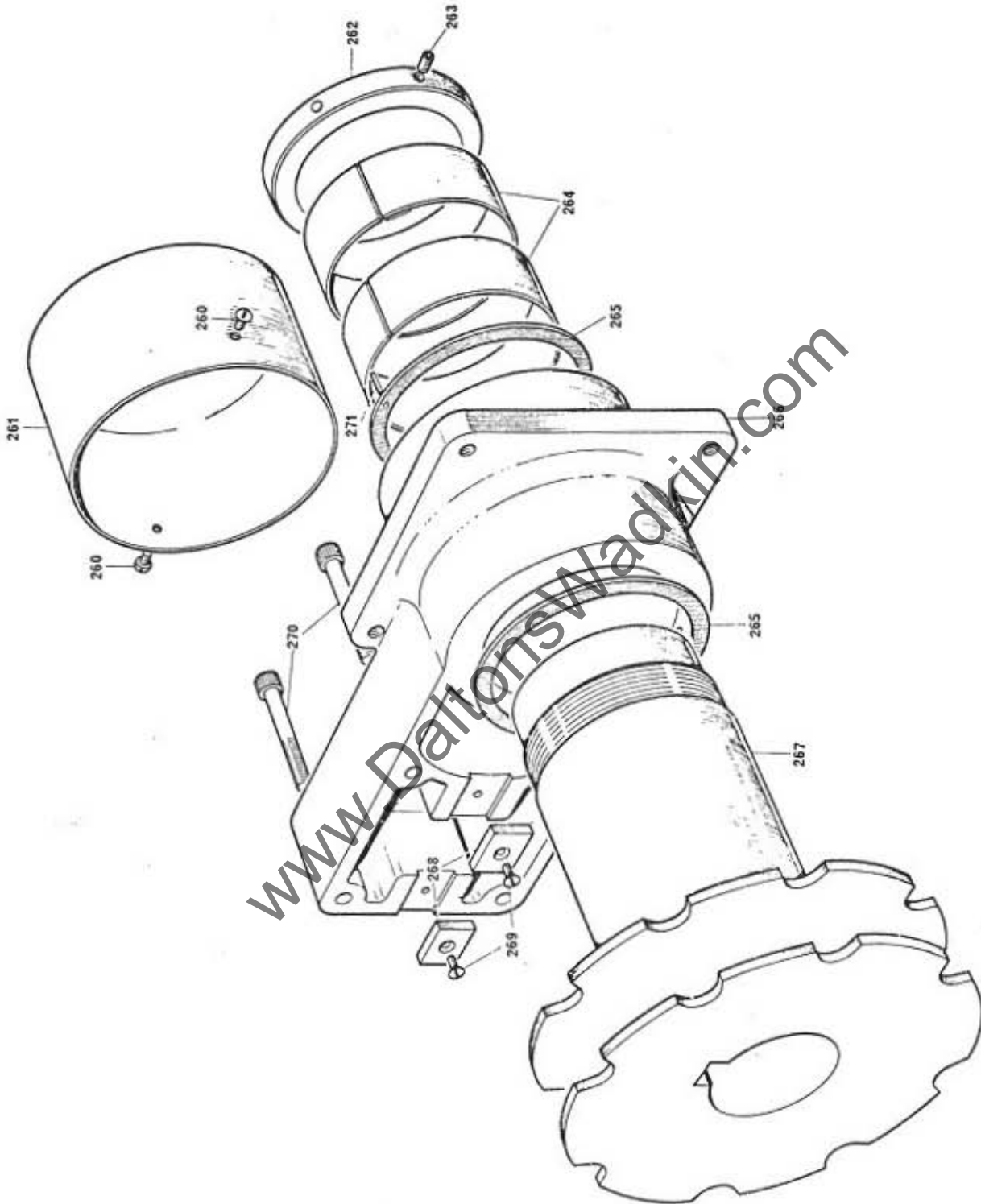
COLUMN ASSEMBLY

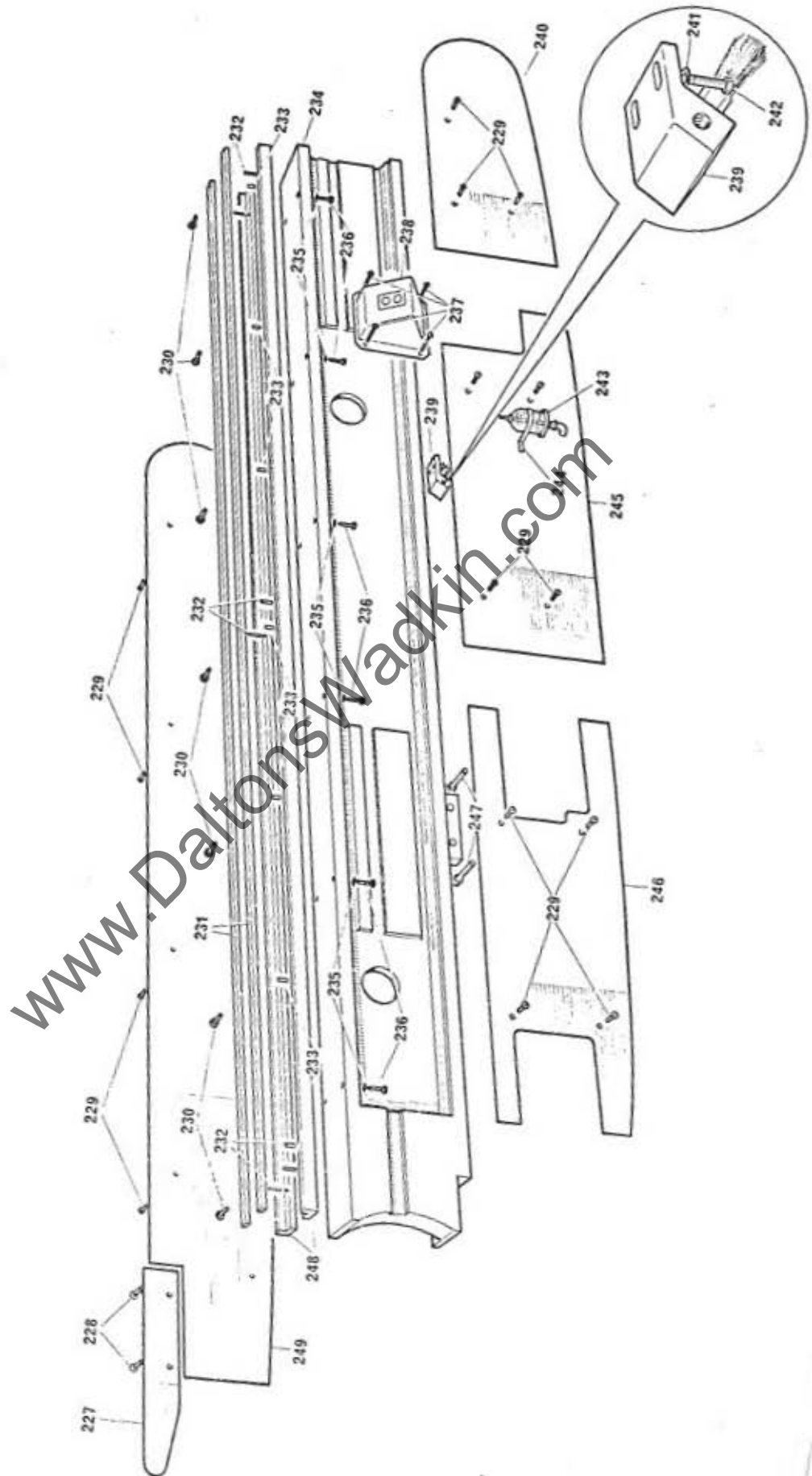
Ref. No.	Part No.	Description	No. Off
194	WU505	Column	2 per m/c.
195		1.1/8" o/d. x 1" bore x 3/4" long olive bush	1 per head
196	K05/20/105	1" collar	1 per head
197	No. 4	Taper pin	1 per head
198	WU248	Rise and fall screw for head	1 per head
199	W09803	Weston 'O' ring	1 per head
200	WN561	Dial for vertical adjustment	1 per head
201		1/8" dia. x 1/2" long groverlok spring dowel	1 per head
202	WN562	Zero ring	1 per head
203A	TRA1625	Torrington thrust washer	1 per head
203B	NTA1625	Torrington thrust bearing	1 per head
203C	TRB1625	Torrington thrust washer	1 per head
204		1/2" whit. x 1.1/4" long socket head capscrew	2 per column
205		3/8" whit. x 3/4" long socket head capscrew	2 per column
206		3/8" washer	2 per column
207		1/2" whit. x 1.1/4" long socket head capscrew	11 per stretcher
208	WU152	Stretcher for chain beam with tenon slot	1
209	WU152	Stretcher for chain beam without tenon slot	1
210	WU115	Dowel for chain beam stretcher	2 per stretcher
211		Tenon block for stretcher	2 per m/c.
212	WU550	Crank handle	4 per m/c.
213	A-S-211	Distance piece for plastic handle	1
214		3" long No. 4 plastic handle	1
215	A-S-101	Spindle for crank handle	1
216	5555-37	3/8" external clutch	1

SECTION F

CHAIN BEAM ASSEMBLY

Ref. No.	Part No.	Description	No. Off
227	WU333	Support rail	1 per beam
228		1/4" whit. x 3/4" long countersunk socket head screw	2
229		1/4" whit. x 3/8" long round head screw	18 per beam
230	WU466	Adjusting screw for track	7 per beam
231	WU339	Polyethelene guide rail for chain block	2 per beam
232		3/16" dia. x 1/2" long fluted dowel for polyethelene rail	6 per beam
233		1/4" dia. x 3/4" long fluted dowel for retaining bar	7 per beam
234	WU512	Chain beam (R.H.)	1
	WU511	Chain beam (L.H.)	1
235		3/16" washer	12 per beam
236		3/16" whit. x 1.1/8" long socket head capscrew	12 per beam
237		3/16" whit. x 1.1/2" long round head screw	4
238	WU275	Push button box for beam	1
239	WN868	Wiper for chain track	1 per beam
240	WU270	Infeed cover	1 per beam
241		1/4" washer	2 per beam
242		1/4" whit. x 1" long hexagon head bolt	2 per beam
243	USF 7417	Oiler for track	1 per beam
244	WU549	Oil bottle clip	1 per beam
245	WU562	Centre cover (starter side)	1
	WU271	Centre cover (fence side)	1
246	WU272	Outfeed cover	1 per beam
247		1/2" whit. x 1.1/4" long socket head capscrew	2 per beam
248	WU487	Retaining bar	2 per beam
249	WU273	Inside chain beam cover	1 each hand





CHAIN DRIVE SPROCKET ASSEMBLY

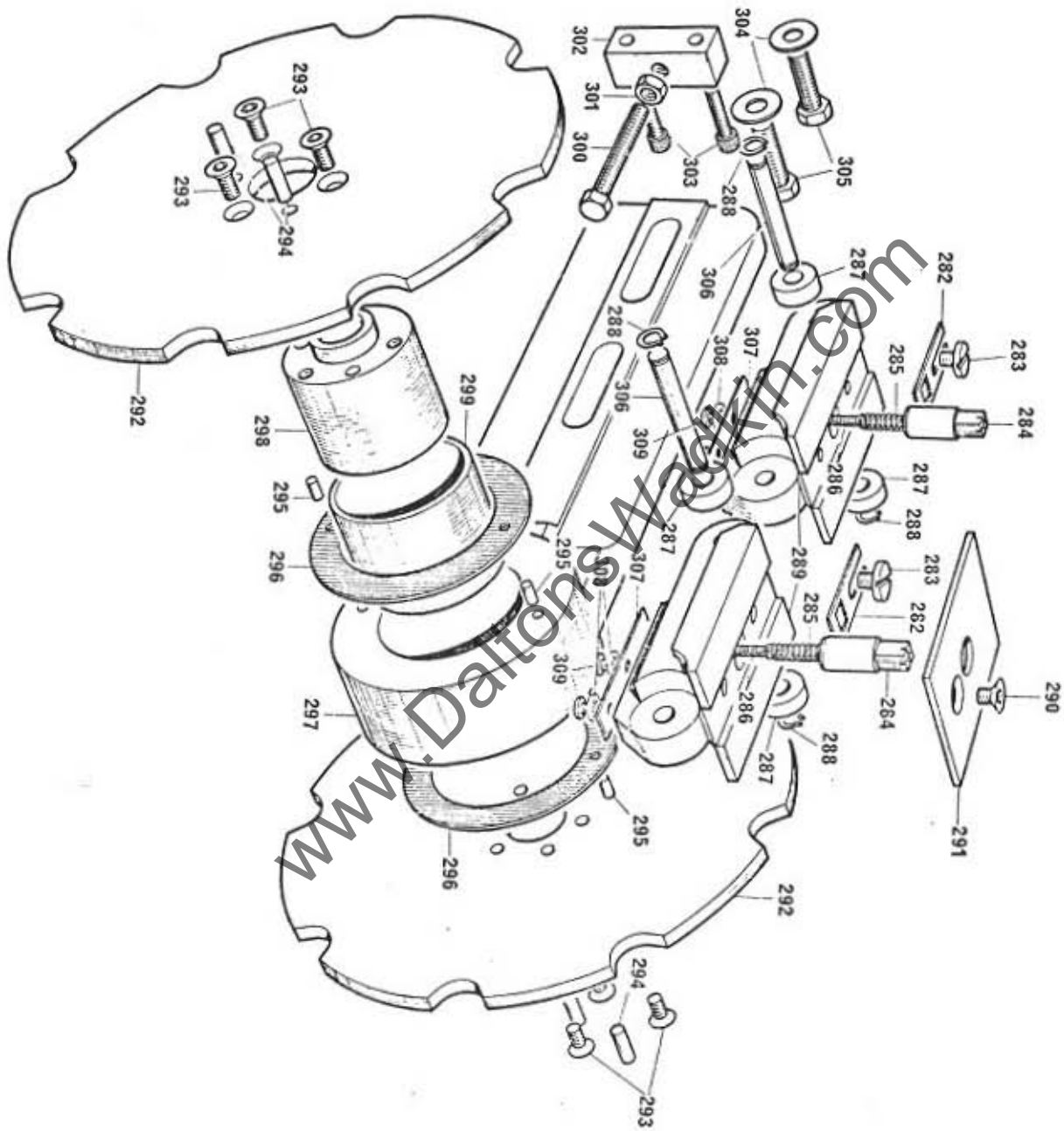
<i>Ref. No.</i>	<i>Part No.</i>	<i>Description</i>	<i>No. Off</i>
260		3/16" whit. x 3/8" long round head screw	2
261	WU349	Dust cover for backshaft (non-driven feed track)	1
262	WU219	Locknut for driving sprocket	1 per beam
263		3/8" BSF x 1/2" long socket head grubscrew	1 per beam
264	MB,100,50,DU	Glacier bush	2 per beam
265	WU174	Thrust washer	2 per beam
266	WU345	Bracket for main drive shaft	1 per beam
267	WU478	Driving sprocket	1 per beam
268	WU113	Tenon block	2 per beam
269		3/16" whit. x 1/2" long countersunk screw	2 per beam
270		3/8" whit. x 2.3/4" long socket head capscrew	8 per m/c.
271		1/8" dia. x 1/2" long groverlok spring dowel	2 per beam

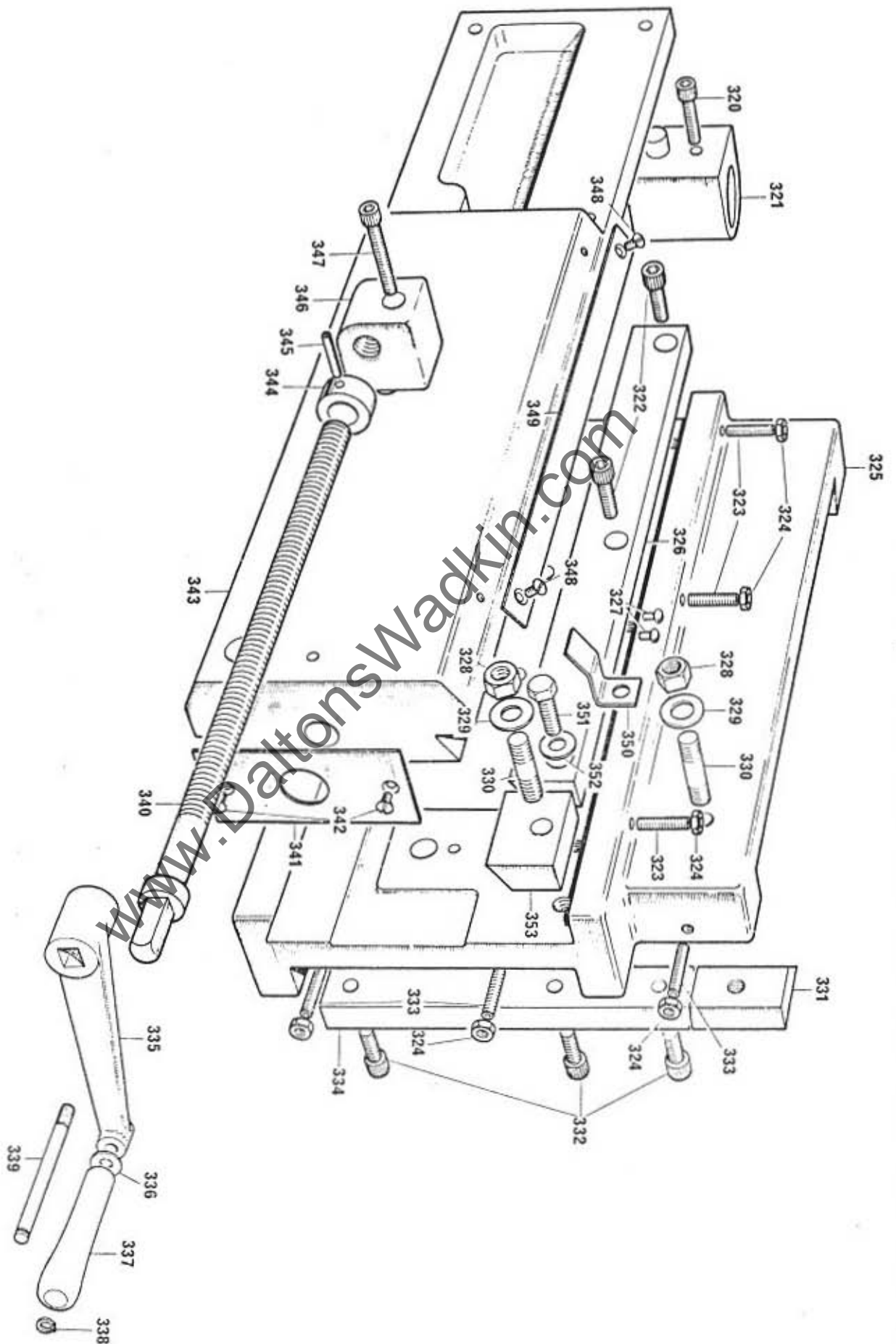
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SECTION F

FEED CHAIN IDLER SPROCKET ASSEMBLY

Ref. No.	Part No.	Description	No. Off
282	WU216	Top retaining plate for plunger	As req'd.
283	WU280	Fixing screw for plate	As req'd.
284	WU109	Disappearing dog plunger type	As req'd.
	WU110	Disappearing dog plunger type	As req'd.
	WU493	Disappearing dog plunger type (for use with polyurethane pads)	As req'd.
	WU498	Disappearing dog plunger type (for use with polyurethane pads)	As req'd.
285	ETS40	Compression spring (for dogs 109 & 110)	As req'd.
	ETS37	Compression spring (for dogs 493 & 498)	As req'd.
286	WU282	Compression spring (for dogs 109 & 110)	As req'd.
	WU514	Compression spring (for dogs 493 & 498)	As req'd.
287	WU204	Roller for chain block	2 per link
288	5555/37	3/8" external circlip	2 per link
289	WU542	Feed chain link	60 per beam
290		5/16" whit x 5/8" long countersunk socket head screw	1 per pad
291	WU430	Polyurethane pad	As req'd.
292	WU105	Feed chain idle sprocket	2 per beam
293		1/4" whit. x 3/4" long countersunk socket head screw	6 per beam
294		1/4" dia. x 3/4" long precision dowel	4 per beam
295		3/16" dia. x 1/4" long fluted dowel	4 per beam
296	DU32	Glacier thrust washer	2 per beam
297	WU343	Idle sprocket bracket	1 per beam
298	WU107	Shaft for idle sprocket	1 per beam
299	32.DU.24	Glacier bush	1 per beam
300		3/8" whit. x 3" long hexagon head bolt	1 per beam
301		3/8" whit. nut	1 per beam
302	WU108	Jacking block for idle sprocket bracket	1 per beam
303		1/4" whit. x 1" long socket head capscrew	2 per beam
304		3/8" washer	2 per beam
305		3/8" whit. x 1" long hexagon head bolt	2 per beam
306	WU448	Axle for chain block	60 per beam
307	WU217	Bottom retaining plate for plunger	As req'd.
308		3/16" star washer	As req'd.
309		3/16" whit. x 3/8" long 'nylok' button socket head screw	As req'd.





SECTION F

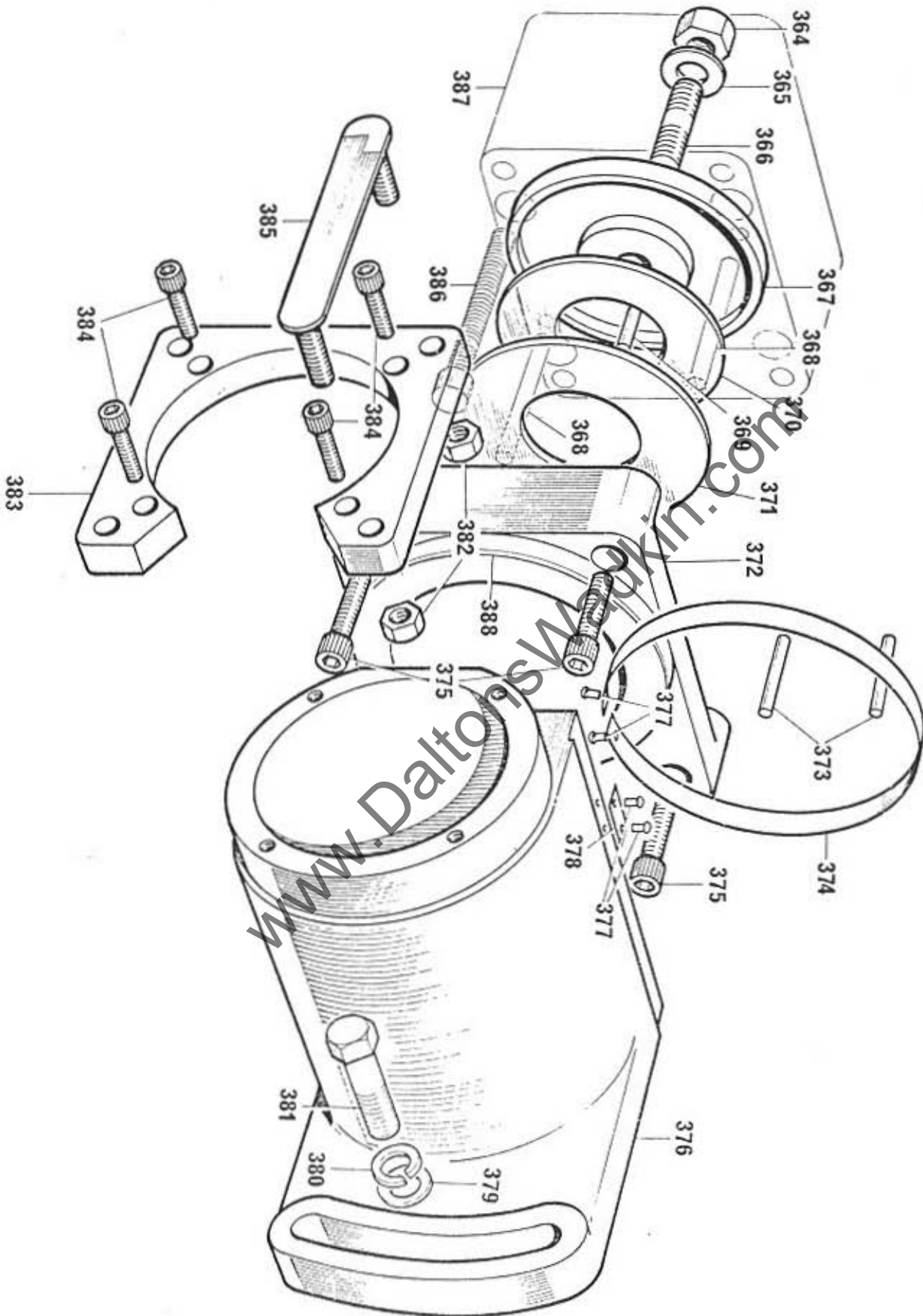
HEAD SLIDE ASSEMBLY

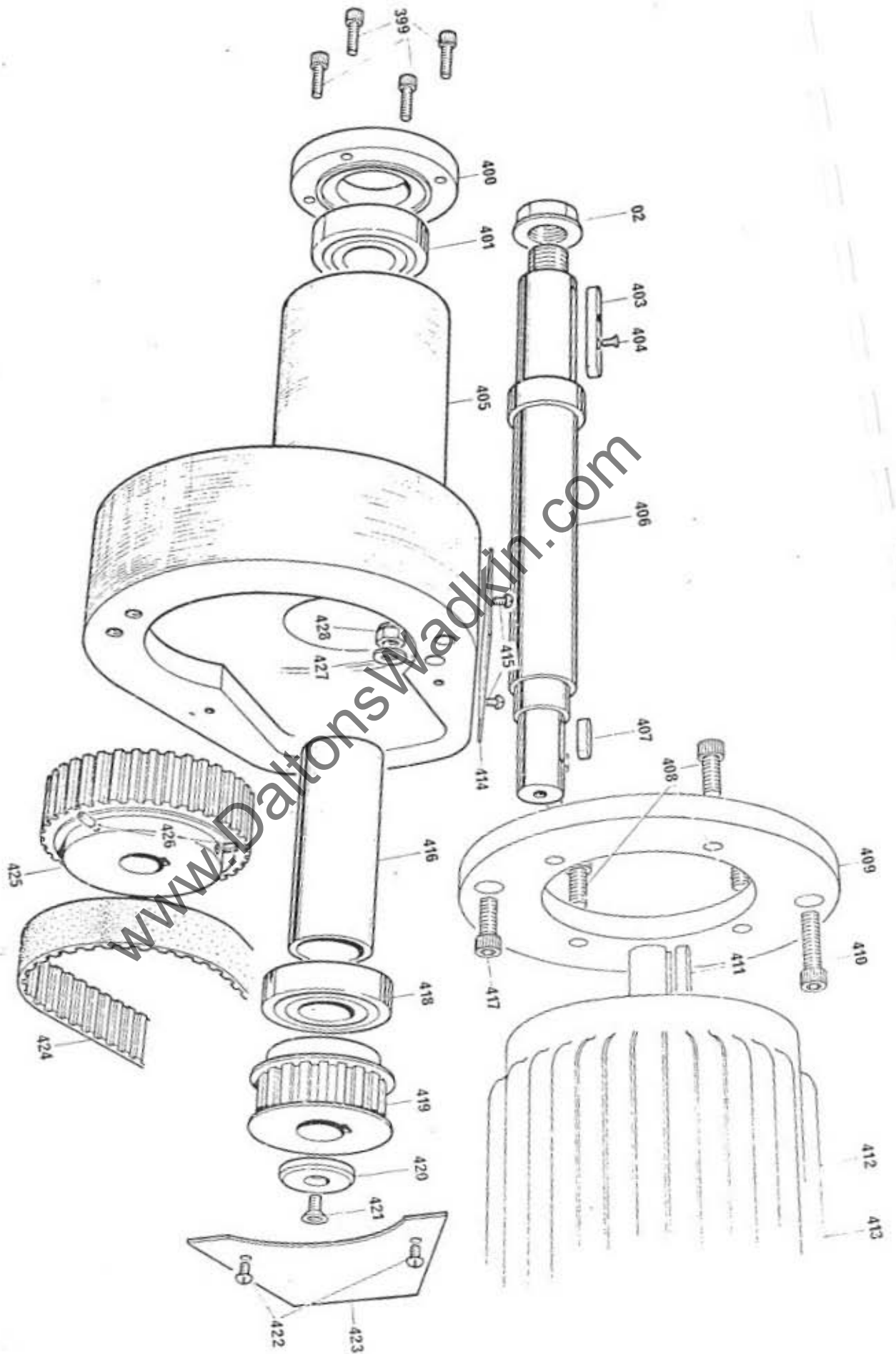
Ref. No.	Part No.	Description	No. Off
320	WU178	5/16" whit. x 5/8" long socket head capscrow	1 per head
321		Nut for raising screw	1 per head
322		3/16" whit. x 7/8" long hexagon head bolt	2 per top head
323		1/4" whit. x 1" long socket head grubscrow	3 per bottom head
324		1/4" whit. locknut	3 per head
325	WU506	Back slide for cutter spindle, (for front heads, top right and bottom left also rear heads top left and bottom right)	1 per head
326	WU238	Vee Strip for backslide	1 per head
327		3/16" whit. x 3/8" long round head screw	2 per bottom head
328		1/2" whit. nut	2 per head
329		1/2" BSF washer	2 per head
330		1/2" whit. x 1.3/4" long stud	2 per head
331	WU510	Locking strip for head slide	1 per head
332		3/8" whit. x 1.1/2" long socket head capscrow	3 per slide
333	WU508	1/4" whit. x 1.1/4" long socket head grubscrow	3 per head
334		Vee slide for cutter head slide	1 per head
335	WE-607	Crank handle	1
336	A-S-211	Distance piece for plastic handle	1
337		3" long No. 4 plastic handle	1
338	5555-37	3/8" external clutch	1
339	A-S-101	Spindle for crank handle	1
340	WU227	Horizontal traverse screw	1 per head
341	WU241	Horizontal traverse screw indicator plate	1 per head
342		1/4" long 2.6 self tapping screw	2 per head
343	WU258	Horizontal slide for cutter spindle (for front heads, top right and bottom left also rear heads top left and bottom right)	1 per head
344	K05/20/103	3/4" collar	1 per head
345		3/16" dia. x 1.1/4" groverlok spring dowel	1 per head
346	WU236	Nut for horizontal adjustment	1 per head
347		5/16" whit. x 1.1/2" long socket head capscrow	1 per head
348		3/16" whit. x 3/8" long countersunk screw	2 per head
349	WE743	9" rule cross traverse scale	state head req'd.
350	WU361	9" rule cross traverse scale	state head req'd.
351	WU362	Top head pointer, horizontal, front right and rear right.	1 per head
352	WU363	Bottom head pointer, horizontal front left and rear left.	1 per head
353	WU364	Bottom head pointer, horizontal, front right and rear right.	1 per head
354		3/8" whit. x 1.1/4" long hexagon head bolt	1 per head
355		3/8" BSF washer	1 per head
356		Vee locking strip for backslide	1 per head

SECTION F

HEAD BARREL ASSEMBLY

Ref. No.	Part No.	Description	No. Off
364		5/8" whit. nut	1 per head
365		5/8" washer	1 per head
366		5/8" whit. x 2" long stud	1 per head
367	WU205	Cap for disc. spring	1 per head
368		1/4" dia. x 2.1/4" long precision dowel (special for use with WU159)	As req'd.
369		1/4" dia. x 3/4" long fluted dowel	1 per head
370		100 mm dia. x 3.5 mm thick 'Schnorr' disc spring	1 per head
371	WU206	Disc spring spacer	1 per head
372	WU254	Pivot bracket for front cutter spindle	1 per head
	WU253	Pivot bracker for rear cutter spindle	1 per head
373		1/4" dia. x 2.1/4" long precision ground dowels	2 per head
374	WU359	Scale for canting movement	1 per head
375		3/8" whit. x 1.3/4" long socket head capscrew	4 per head
376	WU252	Cutter spindle barrel	1 per head
377		1/8" Z.4 self tapping screw	4 per head
378	WE731	Indicator plate for head	1 per head
379		1/2" washer	1 per head
380		1/2" heavy spring washer	1 per head
381		1/2" whit. x 1.3/4" long hexagon head bolt	1 per head
382		3/8" whit. nut	2 per head
383	WU223	End cap for hood	1 per head
384		1/4" whit. x 3/4" long socket head capscrew	4 per head
385	WU442	Clamp strip for cutter guard	1 per head
386		3/8" whit. x 2.3/4" long socket head capscrew (special for use with packing plate WU159)	As req'd.
387	WU159	Packing plate for scoring head (special to order only)	As req'd.
388	WU360	Friction washer for head cant	1 per head





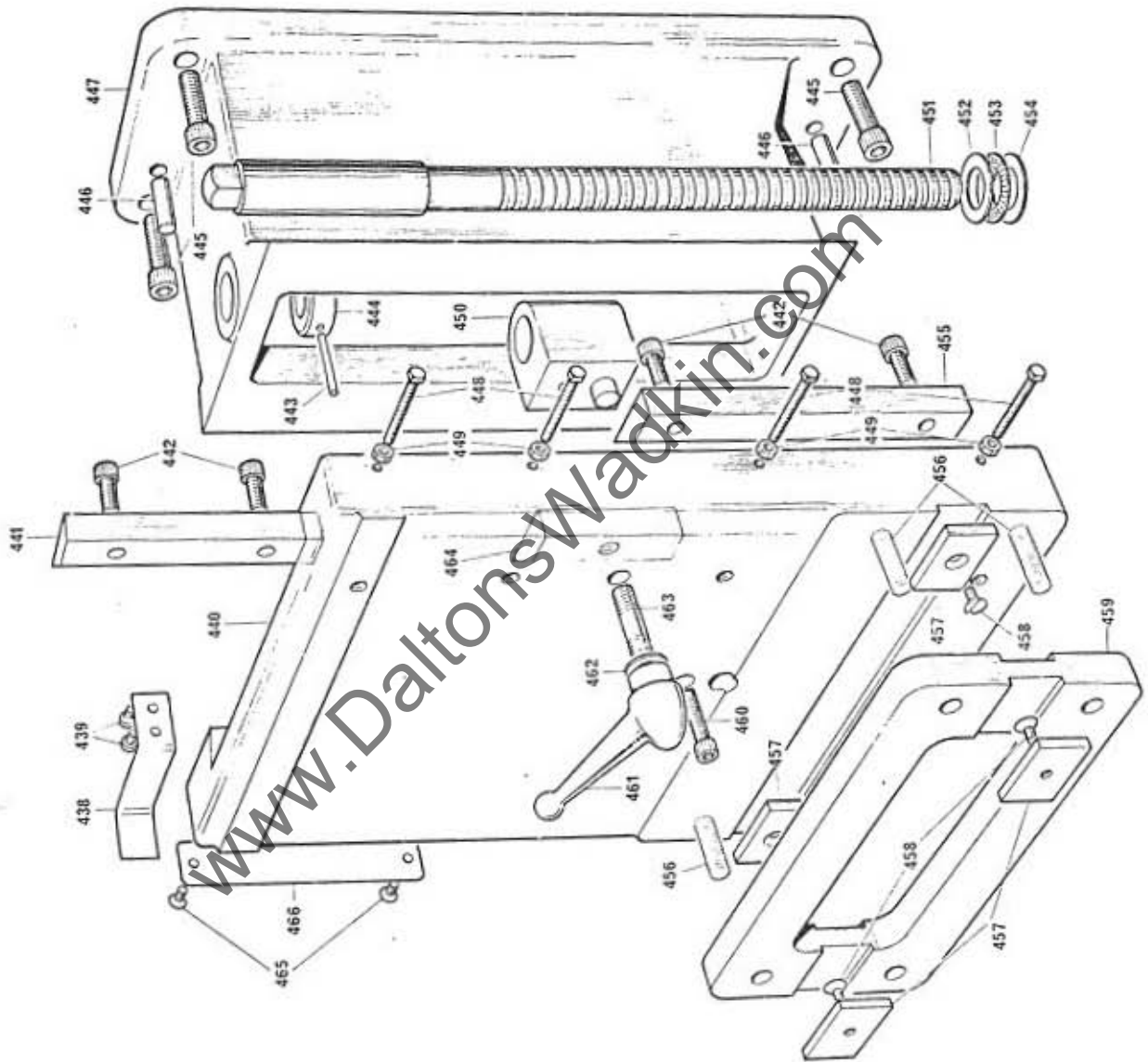
HEAD ASSEMBLY - (BELT DRIVE)

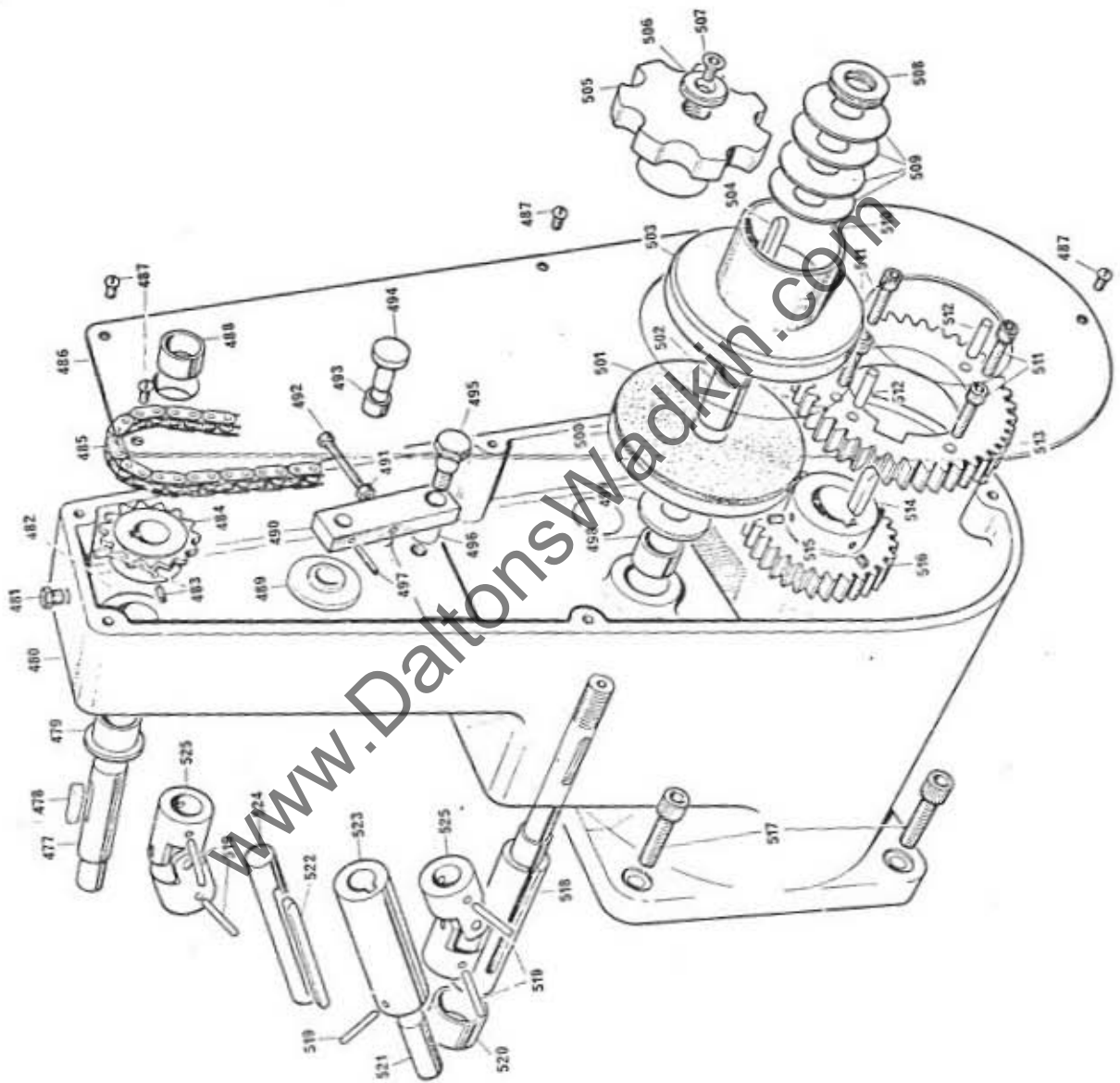
Ref. No.	Part No.	Description	No. Off
399	WU233	1/4" whit. x 3/4" long socket head capscREW	4 per head
400	WU233	End cap for spindle housing	1 per head
401	135 RSS	Hoffman bearing (sealed for life)	1 per head
402	WA497	Nut for spindle	1 per head
403	WU393	Key for cutter spindle	1 per head
404		1/8" whit. x 3/8" long countersunk screw	1 per head
405	WU492	Spindle housing	1 per head
406	WU494	Cutter spindle (1.1/4" dia.)	1 per head
407	WU495	Cutter spindle (30 mm dia.)	1 per head
408		5/16" wide x 1" long feather key	1 per head
409	WU516	8 mm x 20 mm long socket head capscREW	4 per 5 H.P. head
410		Adaptor plate for 4 H.P. motor	1 per 4 H.P. head
411		3/8" whit. x 1.1/2" long socket head capscREW	1 per head
412		8 mm wide x 1.1/4" long key	1 per head
413		D100L motor, 4/5 H.P., 3,000 R.P.M. T.E.F.C.	1 per 4 H.P. head
		'C' face flange mounted, 3 phase, 50 cycles	
		D100L motor, 4/5 H.P., 3,600 R.P.M. T.E.F.C.	1 per 4 H.P. head
		'C' face flange mounted, 3 phase, 60 cycles	
		D90LD motor 3 H.P., 3,000 R.P.M. T.E.F.C.	1 per 3 H.P. head
		CMR, flange mounted, 3 phase, 50 cycles	
414	WU517	Inspection cover for spindle housing	1 per head
415		1/4" whit. x 3/8" long round head screws	2 per head
416	WU235	Bearing spacer for cutter spindle	1 per head
417		3/8" whit. x 3/4" long socket head capscREW	1 per head
418	330 RSS	Hoffman bearing (sealed for life)	1 per head
419	WU522	Spindle pulley (22L100-50 cycles)	1 per head
420	WU539	Spindle pulley (19L100-60 cycles)	1 per head
421	WU496	Washer for cutter spindle	1 per head
422		3/8" whit. x 1.1/4" long countersunk 'nylok' socket head capscREW	1 per head
423	WU497	Cover for spindle housing	2 per head
424	187L100	Timing belt (50 cycles)	1 per head
425	165L100	Timing belt (60 cycles)	1 per head
	WU524	Motor pulley (4 H.P., 50 cycles - 36L100)	1 per head
	WU523	Motor pulley (3 H.P., 50 cycles - 36L100)	1 per head
	WU540	Motor pulley (3 H.P., 60 cycles - 27L100)	1 per head
	WU541	Motor pulley (4 H.P., 60 cycles - 27L100)	1 per head
426		1/4" whit. x 3/4" long socket head grubscrew	2 per head
427		3/8" washer	1 per head
428		3/8" whit. aerotight nut	1 per head

SECTION F

PRESSURE BEAMS SLIDE ASSEMBLY

Ref. No.	Part No.	Description	No. Off
438	WU446	Pointer for pressure rise and fall (R.H.)	1 per m/c.
	WU447	Pointer for pressure rise and fall (L.H.)	1 per m/c.
439		3/16" whit. x 1/2" long round head screw	2 per slide
440	WU432	Backslide for pressure (R.H.)	1 per m/c.
	WU431	Backslide for pressure (L.H.)	1 per m/c.
441	WU433	Vee strip for pressure slide	1 per slide
442		3/8" whit. x 1" long socket head capscrew	4 per slide
443	No. 4	Taper pin	1 per slide
444	K05/20/105	Collar for raising screw	1 per slide
445		1/2" whit x 1.1/4" long socket head capscrew	4 per slide
446		3/8" dia. x 1.1/4" precision dowel	2 per slide
447	WU182	Pressure support bracket	2 per m/c.
448		1/4" whit. x 1.3/4" long hexagon head bolt	4 per slide
449		1/4" whit. locknut	4 per slide
450	WU178	Raising nut for pressure beam	1 per slide
451	WU177	Raising screw for pressures	1 per slide
452	TRB 1625	Torrington thrust washer	1 per slide
453	NTA 1625	Torrington thrust bearing	1 per slide
454	TRA 1625	Torrington thrust washer	1 per slide
455	WU434	Vee strip for pressure slide	1 per slide
456		3/8" whit. x 2.1/4" long socket head capscrew	4 per slide
457	WU113	Tenon block	4 per slide
458		3/16" whit. x 1/2" long countersunk screw	4 per slide
459	WU421	Packing plate	1 per slide
460		5/16" whit. x 3/4" long socket head capscrew	1 per slide
461		3/8" whit. 'Bursgreen' adjustable handle	1 per slide
462		3/8" washer	1 per slide
463		3/8" whit. x 1.1/4" long stud	1 per slide
464	WU435	Pressure locking pad	1 per slide
465		3/16" whit. x 3/8" long countersunk screw	2 per slide
466	WU381	Scale for pressure rise and fall	1 per slide

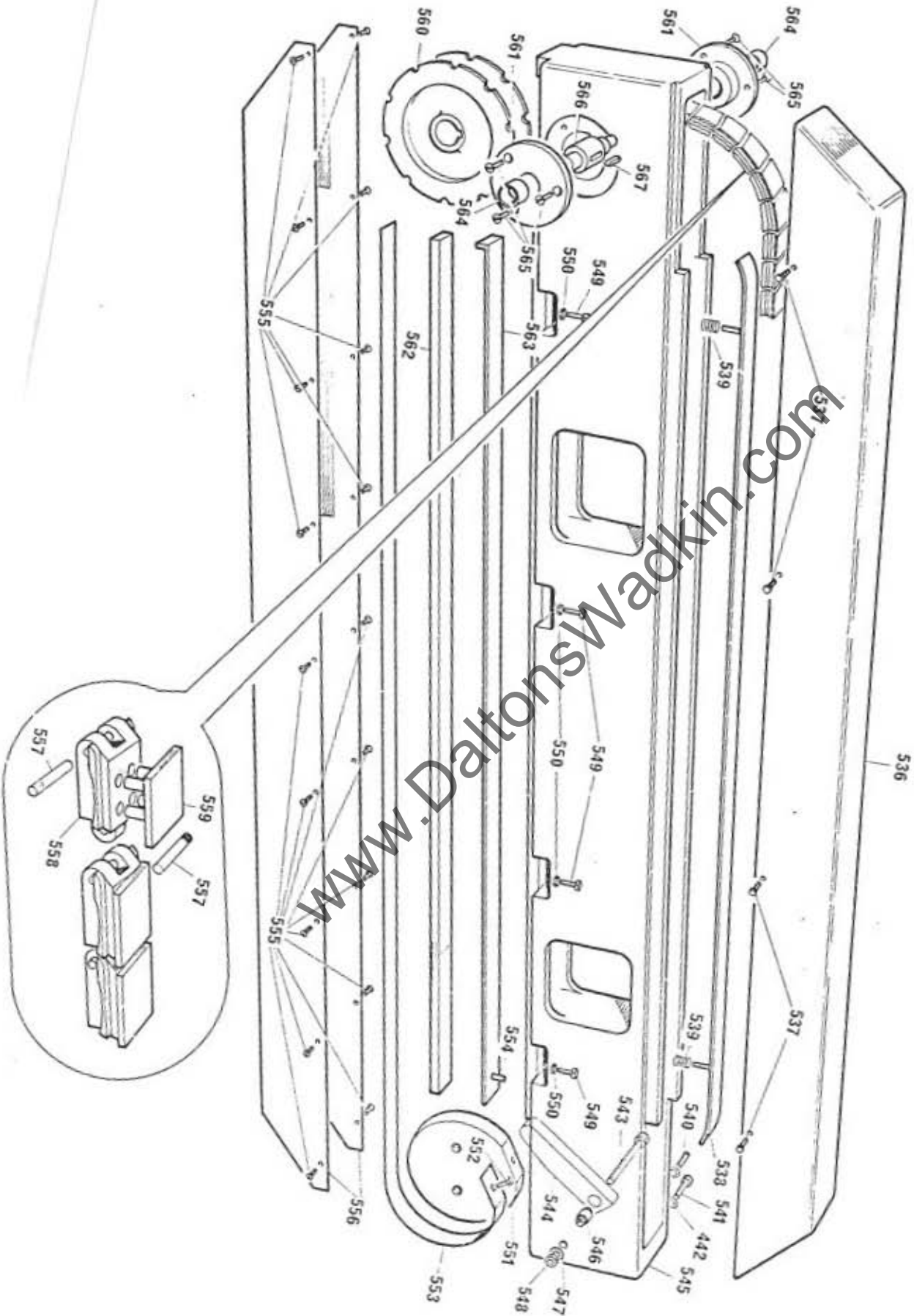




SECTION F

CLUTCH DRIVE TO PRESSURES ASSEMBLIES

Ref. No.	Part No.	Description	No. Off
477	WU 535	Shaft for idle sprocket	1 per drive
478	FBS399	3/16" wide x 3/4" long feather key	1 per clutch
479	WU396	3/4" long flanged oilite bush	1 per drive
480	PC 2	Top pressure feed housing	2 per m/c
481	WU530	Concave oiler	1 per clutch
482	WU538	Spacer for idle sprocket	1 per drive
483	WU538	Sprocket for pressure drive	2 per drive
484	110038	Renold chain, 57 links including conn' link	1 per drive
485	WU397	Cover for feed housing (Driven pressures movable beam)	1 length per drive
486	WU398	Cover for feed housing (Driven pressures fixed beam)	1
487		3/16" whit. x 3/8" long round head screw	5 per clutch
488		3/4" i/d. x 1" o/d. x 5/8" oilite bush	1 per clutch
489	WU404	Jockey roller	1 per clutch
490	WU401	Link for adjusting tension on chain	1 per drive
491		3/16" whit. nut	5 per clutch
492		3/16" whit. x 1 1/2" long hexagon head bolt	1 per clutch
493		3/8" i/d. x 1 1/2" o/d. x 1/2" long oilite bush	1 per clutch
494	WU403	Pin for jockey roller	1 per drive
495	WU536	Pivot pin	1 per drive
496	WU532	Spacer for chain tensioning link	1 per drive
497		1/8" dia. x 3/4" long grovelok spring dowel	1 per clutch
498		3/4" i/d. x 7/8" o/d. x 3/4" long oilite bush	1 per clutch
499	WU531	Thrust washer for clutch	1 per clutch
500	WU526	Clutch sprocket for pressure drive	1 per clutch
501	WU529	Clutch plate for pressure drive	1 per clutch
502		3/4" o/d. x 5/8" i/d. x 1" long oilite bush	1 per clutch
503	WU527	Clutch plate for pressure drive	1 per clutch
504		3/16" wide x 3/4" long feather key	1 per clutch
505		3" dia. plastic handwheel, 5/8" whit. bore	1 per clutch
506	WU534	Stop washer for clutch shaft	1 per clutch
507		1/4" whit. x 1/2" long countersunk socket	1 per clutch
508	HORNMAN EW5/8"	Thrust race	1 per drive
509	1385/15	Belville type washers, (.0625 x 5/8" x 1.3/4")	4 per clutch
510	WU533	Clutch shroud	1 per clutch
511		3/16" whit. x 3/4" long socket head capscrew	4 per clutch
512		3/16" dia. x 3/4" long precision dowel	2 per clutch
513	WU328	Driving gear for pressures	1 per drive
514		1/4" wide x 1.1/4" long feather key	1 per clutch
515		5/16" whit. x 5/16" long socket head grubscrow	2 per clutch
516	WU537	Driven gear for pressures	1 per drive
517		3/8" whit. x 1" long socket head capscrews	4 per clutch
518	WU528	Shaft for driven gear	1 per clutch
519	No. 4	Taper pin	5 per drive
520		1" i/d. x 1.1/8" o/d. x 1/2" long oilite bush	1 per clutch
521	WU164B	Pin for driving sleeve	1 per clutch
522		3/16" wide x 2.1/2" long feather key	1 per clutch
523	WU164	Driving sleeve	1 per drive
524	WU188	Driving shaft	1 per clutch
525	No. 2	Mollart 'Hooks' type universal joint, 5/8" bore each end.	2 per drive



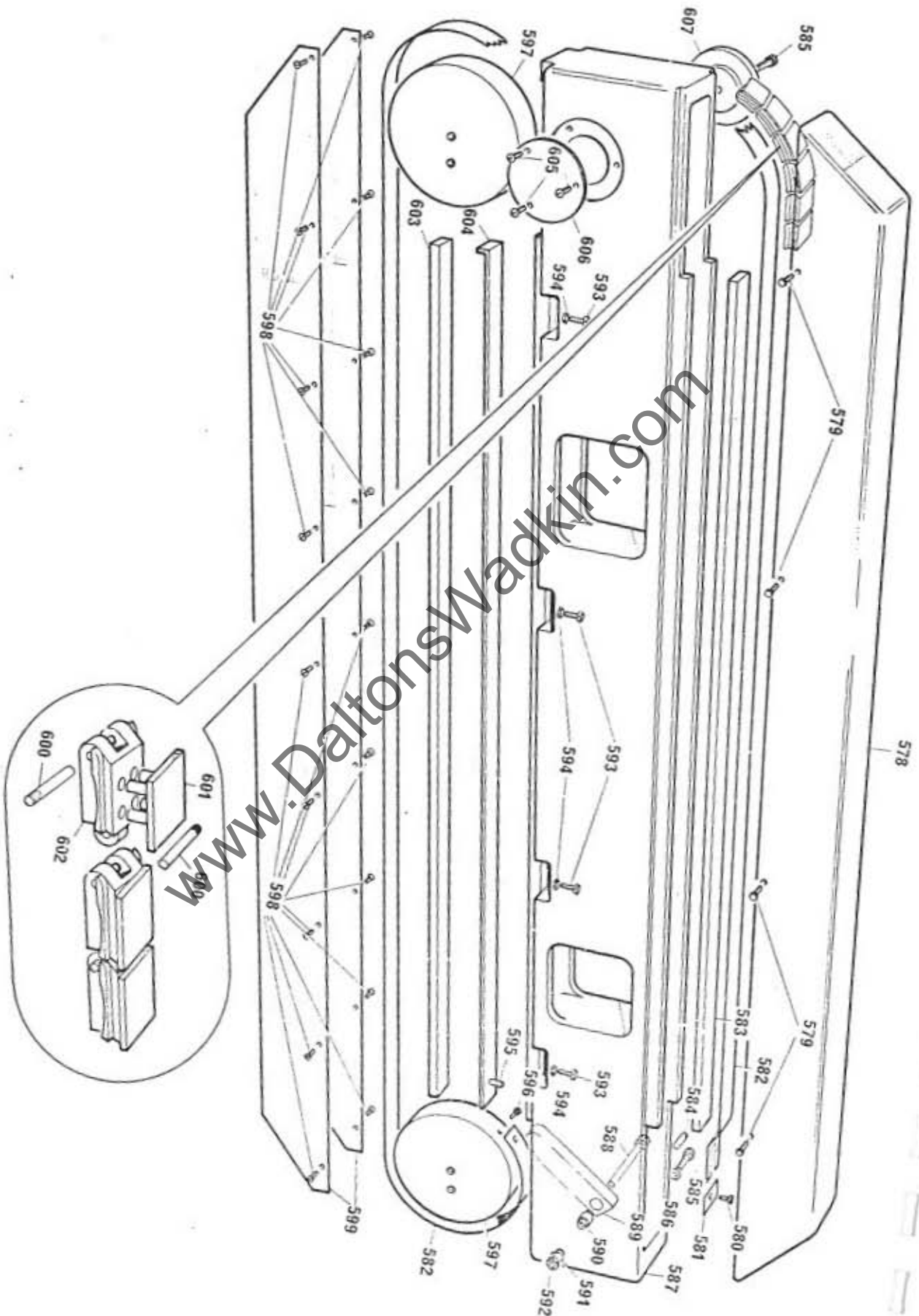
SECTION F

DRIVEN TOP PRESSURE ASSEMBLY

Ref. No.	Part No.	Description	No. Off
536	WU425	Sheet iron cover	1 per beam
537		3/16" whit. x 1/2" long hexagon head bolts	8 per beam
538	WU426	Track skid for pressure	1 per beam
539	WU409	Spring for skid	2 per beam
540		3/8" whit. x 1.1/4" long stud with screwdriver slot	1 per beam
541		3/8" whit. x 1.1/2" long socket head capscrew	1 per beam
542		3/8" washer	1 per beam
543		1/2" whit x 3.3/4" long socket head capscrew	1 per beam
544	WU260	Hold back shoe	1 per beam
545	WU415	Pressure beam (R.H.)	1
	WU416	Pressure beam (L.H.)	1
546	13/827	Metalastic bush ultra duty	1 per beam
547		1/2" washer	1 per beam
548		1/2" whit nut	1 per beam
549		1/4" whit. x 1" long square head bolts	4 per beam
550		1/4" whit. locknut	4 per beam
551	WU456	Infeed roller skid	1 per beam
552		3/16" whit. x 1/2" long socket head capscrew	1 per beam
553	WU465	Shim steel platen	1 per beam
554		1/4" whit x 3/4" long stud	1 per beam
555		3/16" whit. x 3/8" long countersunk screw	18 per beam
556	WU423	Support rail (L.H.)	1 per beam
	WU424	Support rail (R.H.)	1 per beam
557	WU315	Axle for pressure link	65 per beam
558	WU410	Pressure link	65 per beam
559	WU411	Pressure pad	65 per beam
560	WU417	Driving sprocket	1 per beam
561	WU419	End cap for pressure drive	2 per beam
562	WU462	Rubber pressure track	1 per beam
563	WU459	Retaining bar for rubber	1 per beam
564		2 7/8" o/d. x 3/4" i/d. x 5/8" long oilite bush	2 per beam
565		3/16" whit. x 1/2" long countersunk screw	6 per beam
566	WU420	Axle for driving sprocket	1 per beam
567		1/4" wide x 3/4" long feather key	1 per beam

NON-DRIVEN TOP PRESSURE ASSEMBLY

Ref. No.	Part No.	Description	Qty.
578	WU425	Sheet iron cover	1 per beam
579		3/16" whit. x 1/2" long hexagon head bolts	8 per beam
580		1/4" whit x 1/2" long hexagon head bolt	1 per beam
581	WU407	Clamp plate for shim runner	1 per beam
582	WU464	Shim steel platen	1 per beam
583	WU463	Rubber pressure track	1 per beam
584		3/8" whit. x 1.1/4" long stud with screwdriver slot	1 per beam
585		3/8" whit. x 1.1/2" long socket head capscrew	2 per beam
586		3/8" washer	1 per beam
587	WU415	Pressure beam (R.H.)	1
	WU416	Pressure beam (L.H.)	1
588		1/2" whit. x 3.3/4" long socket head capscrew	1 per beam
589	WU260	Hold back shoe	1 per beam
590	13/827	Metalastic bush ultra duty	1 per beam
591		1/2" washer	1 per beam
592		1/2" whit nut	1 per beam
593		1/4" whit. x 1" long square head bolt	4 per beam
594		1/4" whit locknut	4 per beam
595		1/4" whit. x 3/4" long stud	1 per beam
596		3/16" whit. x 1/2" long socket head capscrew	1 per beam
597	WU456	Infeed - Outfeed roller skid	2 per beam
598		3/16" whit. x 3/8" long countersunk screw	18 per beam
599	WU423	Support rail (L.H.)	1 per beam
	WU424	Support rail (R.H.)	1 per beam
600	WU315	Axle for pressure link	65 per beam
601	WU411	Pressure pad	65 per beam
602	WU410	Pressure link	65 per beam
603	WU427	Rubber pressure track	1 per beam
604	WU459	Retaining bar for rubber	1 per beam
605		3/16" whit. x 3/8" long round head screw	3 per beam
606	WU449	Cover for driving spindle	1 per beam
607	WU488	Washer for track skid	1 per beam



SECTION F

FENCE ASSEMBLY

<i>Ref. No.</i>	<i>Part No.</i>	<i>Description</i>	<i>No. Off</i>
618	WU161	Fence plate	1
619		3/8" washer (extra)	4
620		3/8" whit. x 1.1/4" long hexagon head bolts	2
621	WU247	Fence slide bracket	1
622		3/16" whit. nut	2
623		3/16" whit. x 3/4" long socket head capscrew	2
624	WU118	Wear strip for fence bracket	1
625	WU246	Fence support bracket	1
626		1/2" whit x 1.1/2" long stud	1
627	WU513	Locking washer	1
628		1/2" whit. 'Bursgreen' adjustable handle	1
629		3/8" whit. x 1" long socket head capscrew	4
630	WU113	Tenon block	2
631		3/16" whit. x 1/2" long countersunk head screw	2
632		3/8" nut (extra)	2
633	WU515	Core stock fence (extra)	1

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