

SECTION 5

ILLUSTRATED PARTS LIST

ALWAYS QUOTE MODEL AND MACHINE NUMBER WHEN ORDERING SPARES

SPARE PARTS

Should spare parts be required due to breakage or wear, full particulars including machine and test number must be given. This information is on the nameplate attached to the front of the machine and should be forwarded to the Service Manager.

Wadkin PLC
GREEN LANE WORKS, LEICESTER, ENGLAND

MACHINE NO. _____
TEST NO. _____
VOLTS _____ 3- _____ HZ
AMPS _____ MAX

SAMPLE TYPE ORDER

MACHINE
MACHINE NO:
TEST NO:
PARTS REQUIRED e.g.

- 1 - M10 x 50mm long screwed stud
- 1 - M10 size bright mild steel washer.
- 1 - Raising screw.

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

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ILLUSTRATED PARTS LIST

BACKING PIECE AND TURRET SHAFT

Ref.No.	Description	Quantity
1	Turret stop shaft	1
2	Bearing spacer	1
3	Bearing	2
4	Internal circlip $\phi 42$	1
5	External circlip $\phi 20$	1
6	Square headed dowel	1
7	Drill bush	1
8	Backing plate clamp	1
9	Backing ring	1
10	Backing piece	1
11	Pan head screw M5 x 10LG	1
12	Oval link chain	1
13	Hexagonn capscrew M8 x 30LG	1

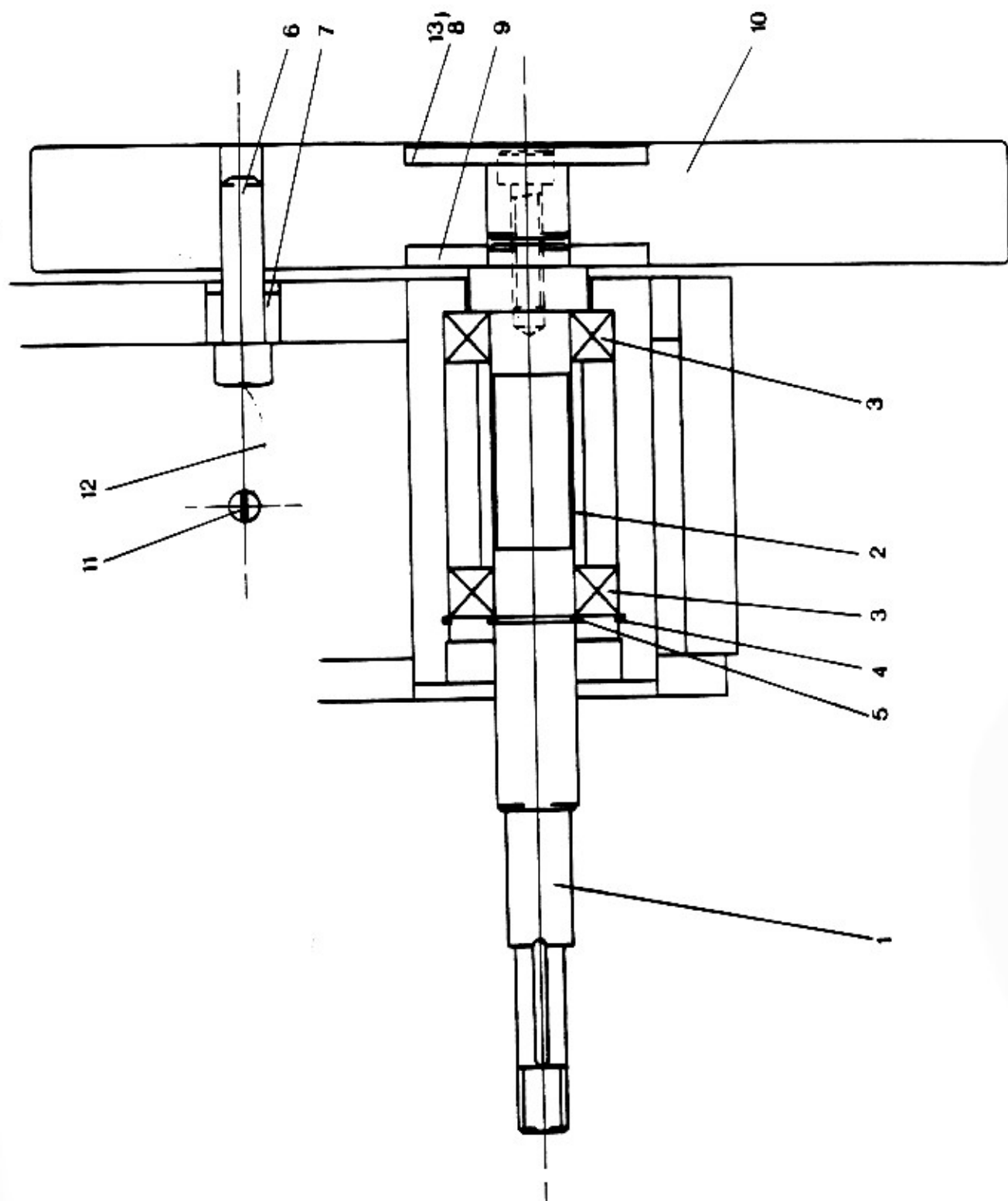


FIG.1 BACKING PIECE & TURRET SHAFT

ILLUSTRATED PARTS LIST

BACKING PIECE TURRET

Ref.No.	Description	Quantity
1	Turret mounting plate assy.	1
2	Clutch arm	1
3	Clutch arm key	1
4	Hexagon capscrew M4 x 8LG	1
5	Brass pad	1
6	Brake housing	1
7	Hexagon capscrew M6 x 30LG	2
8	Proximity switch target	1
9	Turret stop ring	1
10	Grub screw M8 x 25LG	2
11	Turret stop shaft	1
12	Proximity switch	6
13	Hexagon capscrew M6 x 20LG	4
14	Steel ball $\phi 8$	2
15	Compression spring	2
16	Bush 16 x 20 x 25	1
17	Detent plate	1
18	Stieder clutch	1
19	Hexagon full nut M12	1
20	Cover turret mounting plate	1
21	Cover spacer	2
22	Screw assy.	1
23	Hexagon full nut M8	2
24	Pneumatic cylinder	1
25	Cylinder clevis	1
26	Proximity switch	2
27	Flow control valve	2
28	Festo straight connection	2
29	Straight dowel $\phi 6$ x 20LG	2
30	Parallel Key 4 x 4 x 32LG	1
31	Hexagon full nut M8	1
32	Grub screw M8 x 20LG	1
33	Compression spring	1
34	Hexagon capscrew M6 x 65LG	2

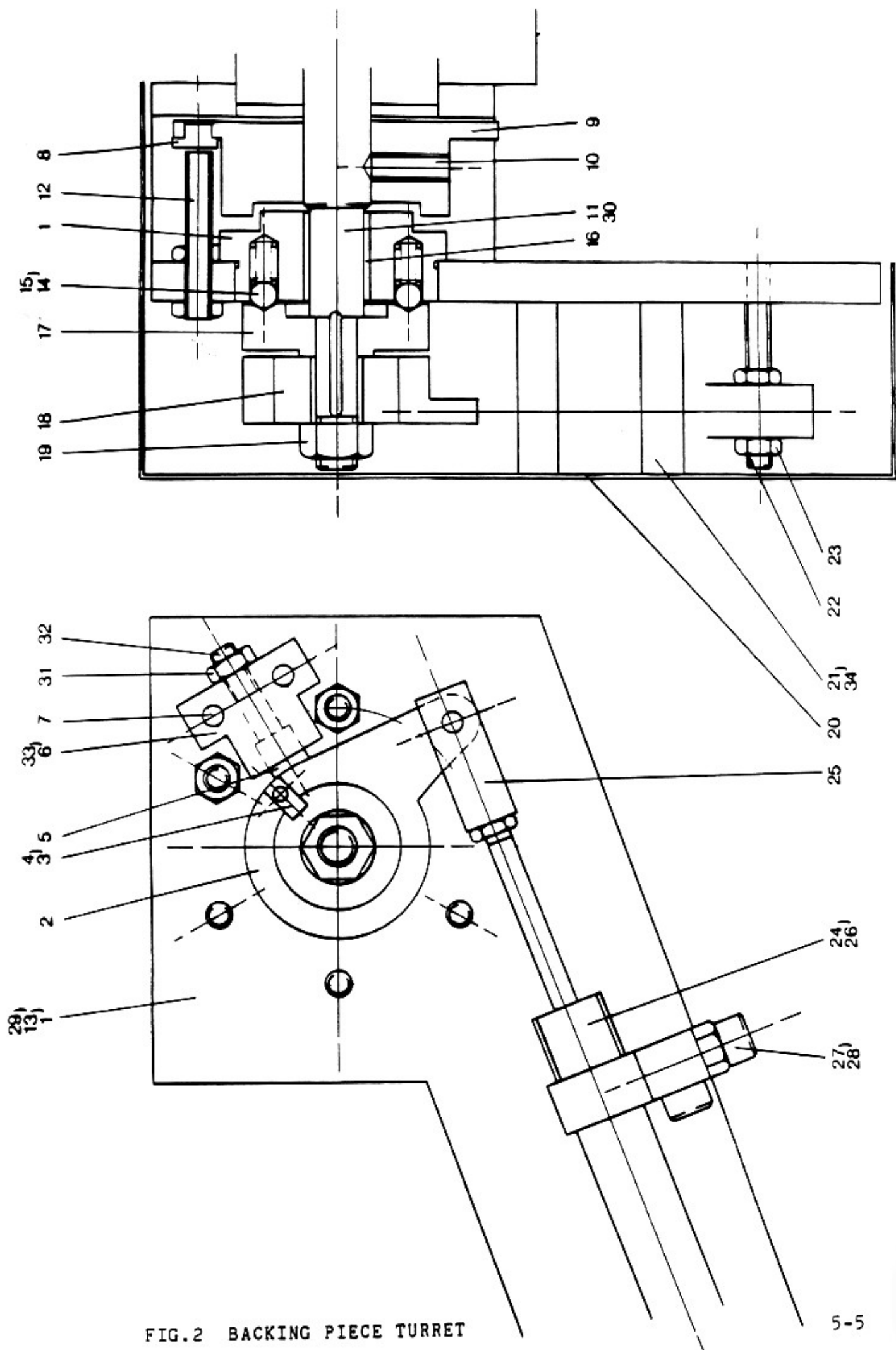


FIG. 2 BACKING PIECE TURRET

ILLUSTRATED PARTS LIST

HOGGING SAW - IN/OUT

Ref.No.	Description	Quantity
1	Lead screw	1
2	Lead screw nut housing	1
3	Spacer - lead screw nut housing	2
4	Bearing pot	1
5	Extension shaft (short)	1
6	Digital indicator (high speed)	1
7	Spring washer $\phi 10$	4
8	Horizontal adjustment nut	1
9	Tension pin $\phi 8$ x 50LG	1
10	Notch nut M20 x 1.5 pitch	1
11	Tab lock washer $\phi 20$	1
12	Bush 25 x 20 x 25	1
13	Thrust washer	4
14	Thrust bearing	2
15	Plain washer $\phi 10$	4
16	Full nut M10	4
17	Hexagon head screws M10 x 65LG	4
18	Tension pin $\phi 4$ x 20LG	1
19	Dowel pin $\phi 10$ x 60LG	2
20	Hexagon head screw M6 x 20LG	2
21	Adaptor plate	1
22	Hexagon head screw M12 x 25LG	2

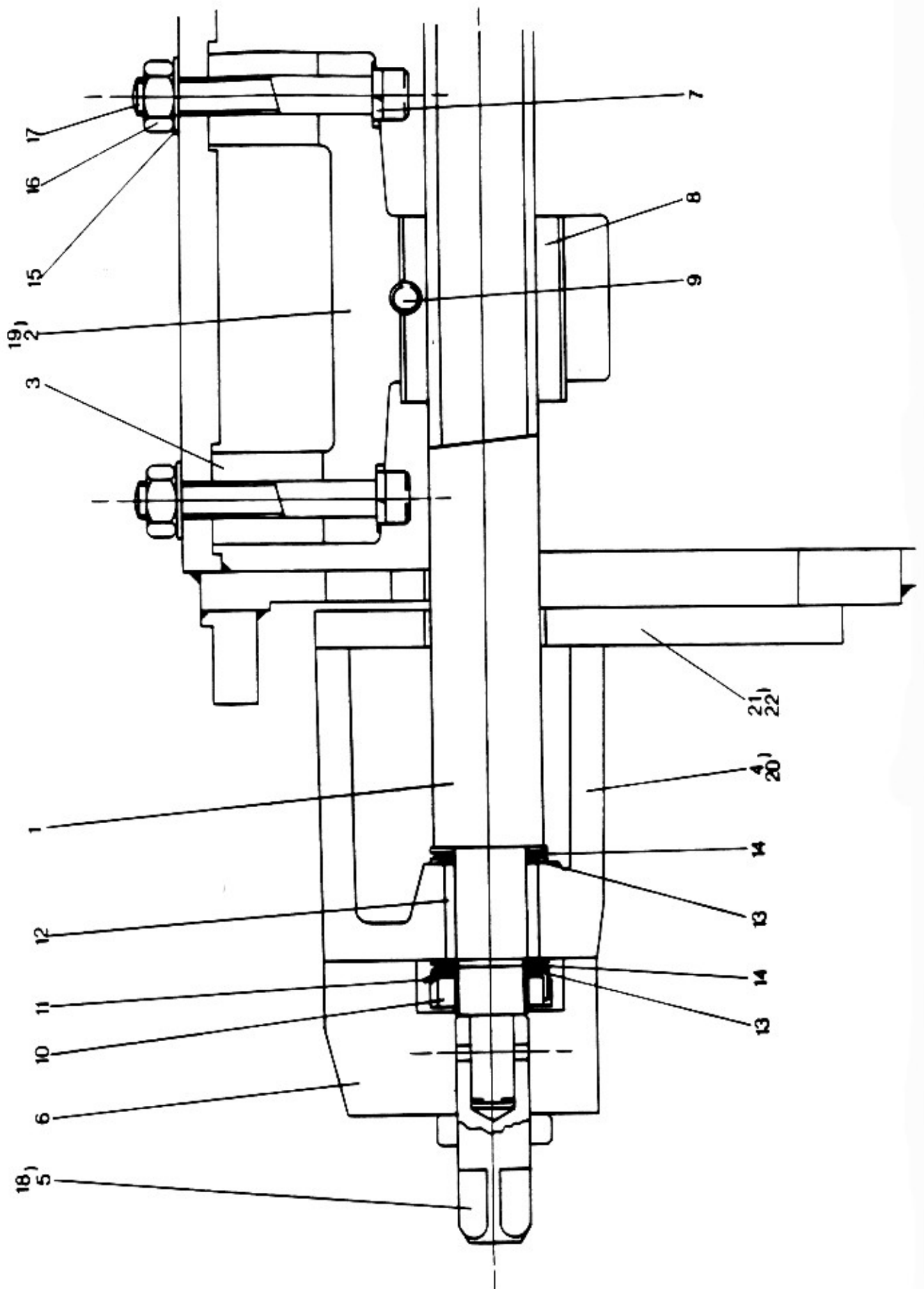


FIG.3 HOGGING SAW - IN/OUT

ILLUSTRATED PARTS LIST

TENON BEAM - BALLSCREW

Ref.No.	Description	Quantity
1	Ballscrew	1
2	Bearing housing	2
3	Ballnut housing	1
4	Spacer	2
5	Thrust plate	2
6	Combined bearing	2
7	Bearing and seal	2
8	Inner ring	4
9	Sealing ring 35 x 42 x 4	2
10	Poly-vee pulley	1
11	Taper bush 14mm Bore	1
12	Key 5 x 5 x 32	1
13	Poly-vee belt	1
14	Plain washer $\phi 6$	1
15	Hexagon capscrew M6 x 20LG	1
16	Square flanged ballscrew nut	1
17	Hexagon capscrew M8 x 35LG	4
18	Hexagon screw M12 x 35LG	2
19	Spring washer $\phi 12$	2
20	Hexagon half nut M12	1
21	Hexagon full nut M12	1
22	Plain washer $\phi 12$	1
23	Plain dowels $\phi 12$ x 40LG	2
24	Hexagon screw M12 x 45LG	4
25	Spring washer $\phi 12$	4

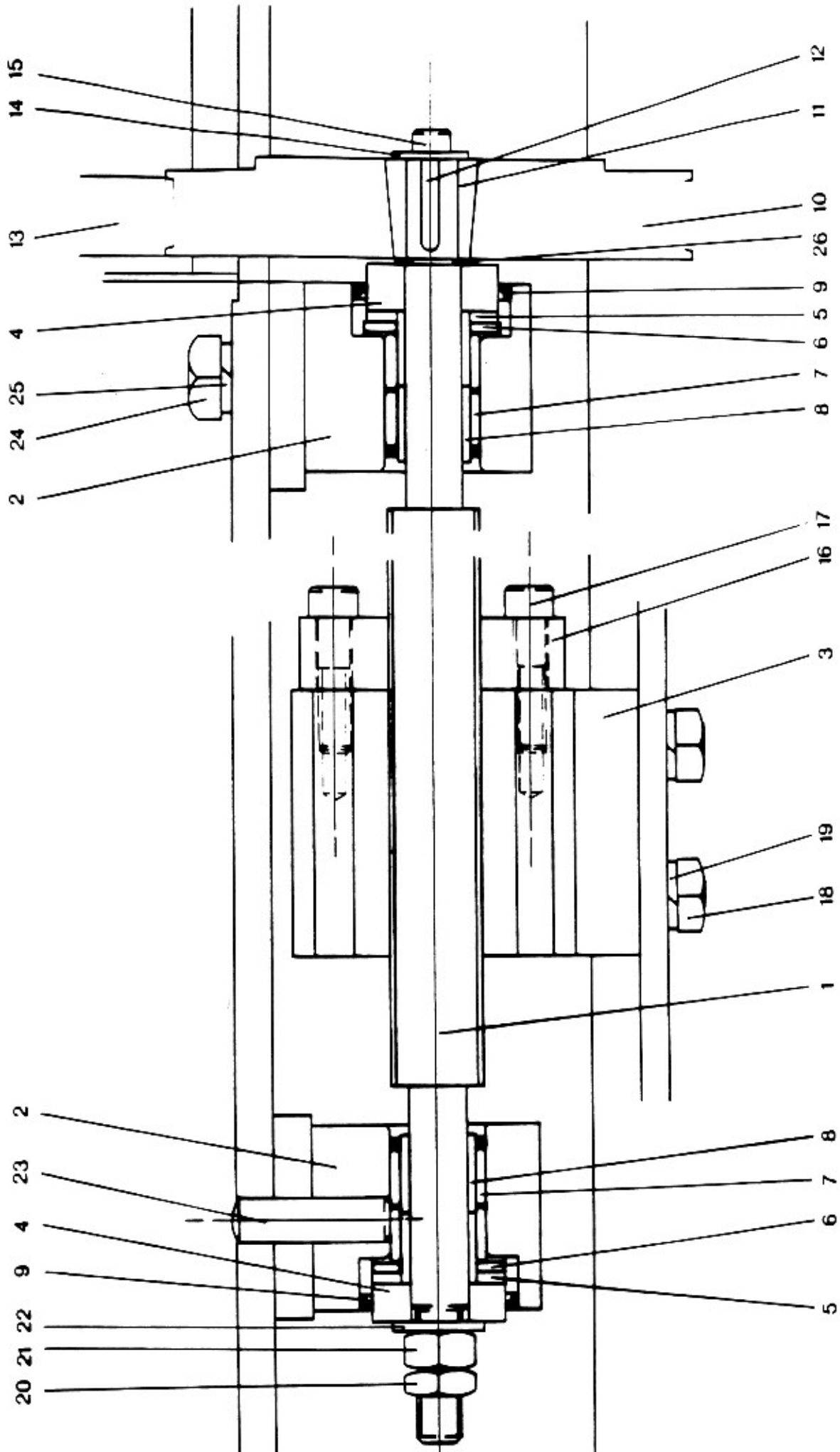


FIG.4 TENON BEAM - BALLSCREW

ILLUSTRATED PARTS LIST

600mm TENON SPINDLE - MOUNTING

Ref.No.	Description	Quantity
1	Cutter Spindle	1
2	End cap	1
3	Bearing Klubergreased	2
4	Bearing housing	1
5	Bearing spacer	1
6	Hexagon capscrew M6 x 20LG	6
7	Disc spring	1
8	Poly-vee belt	1
9	Hexagon screw M12 x 40LG	6
10	Plain washer ϕ 12	6
11	Plain washer ϕ 12	1
12	Spring washer ϕ 12	1
13	Hexagon screw M12 x 45LG	1
14	Pulley locking collar	1
15	Spindle pulley	1

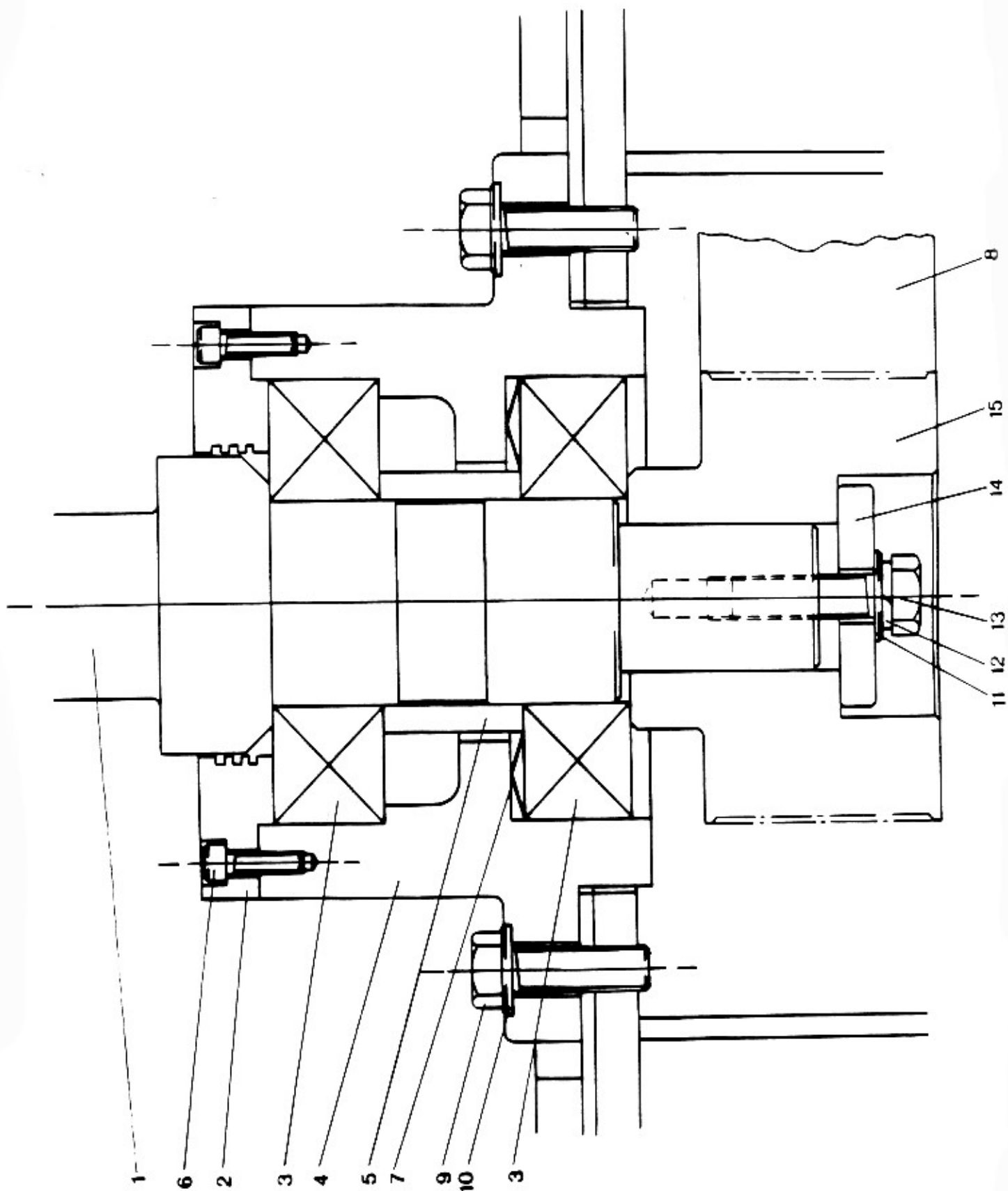


FIG. 5 600mm TENON SPINDLE - MOUNTING

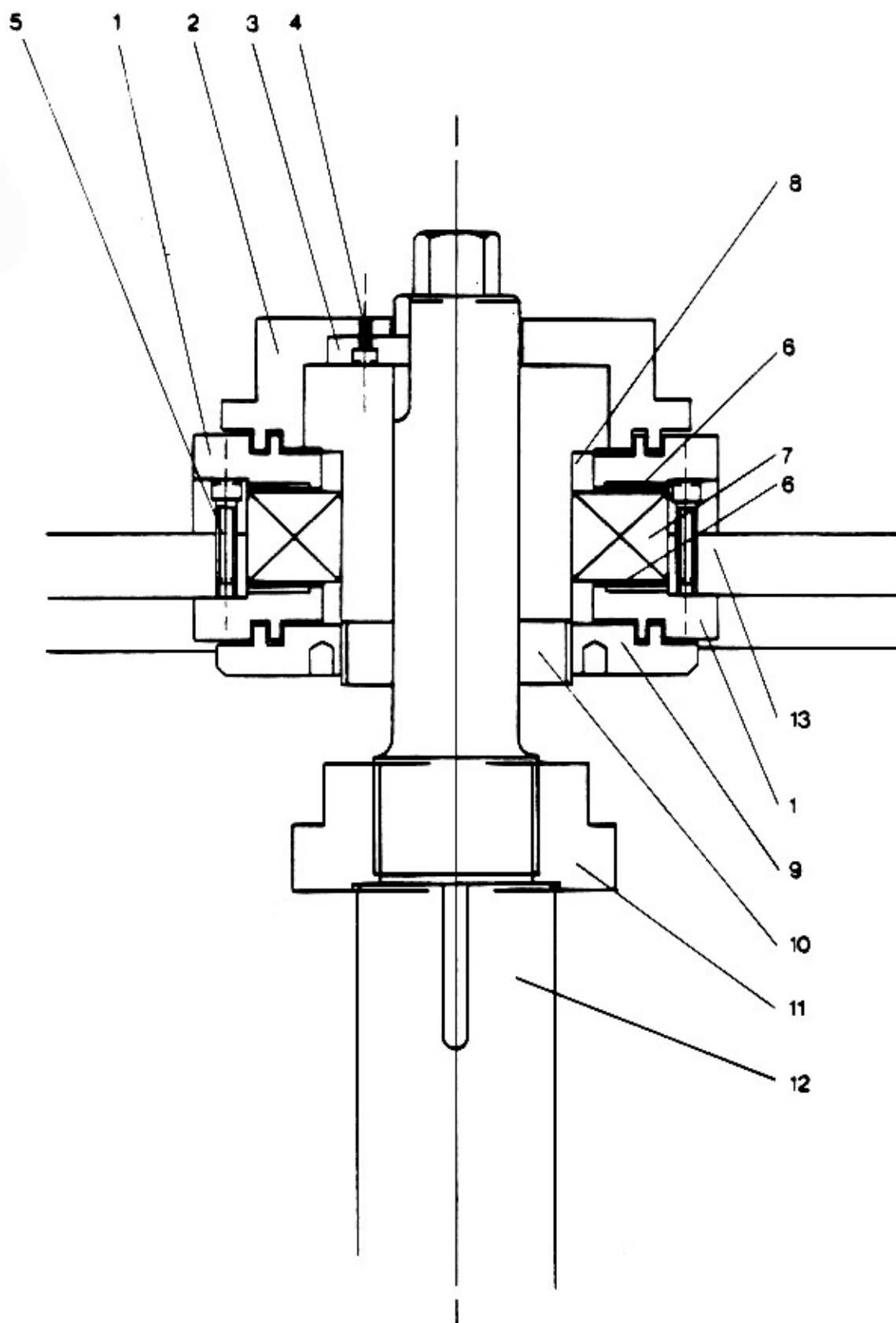


FIG.6 600mm TENON SPINDLE (HYDRO-GRIP)

ILLUSTRATED PARTS LIST

ELEC/MECH DRIVE ASSEMBLY

Ref.No.	Description	Quantity
1	Encoder plate cover	1
2	Hexagon capscrew M6 x 35LG	2
3	Hexagon capscrew M6 x 60LG	1
4	Encoder mounting plate	1
5	Hexagon capscrew M5 x 12LG	2
6	Encoder adaptor	1
7	C'SK. screw M4 x 12LG	3
8	Encoder	1
9	Encoder pulley	1
10	Grubscrew M4 x 4LG	1
11	Timing belt	1
12	Gearbox pulley	1
13	Grub screw M4 x 6LG	1
14	Drive adaptor	1
15	Siko-position indicator	1
16	Gear box/motor	1
17	Key 4 x 4 x 20LG	1
18	Coupling	1
19	Motor adaptor	1
20	Hexagon capscrew M5 x 25LG	4
21	Grub screw M6 x 6LG	1
22	Grub screw M6 x 8LG	1

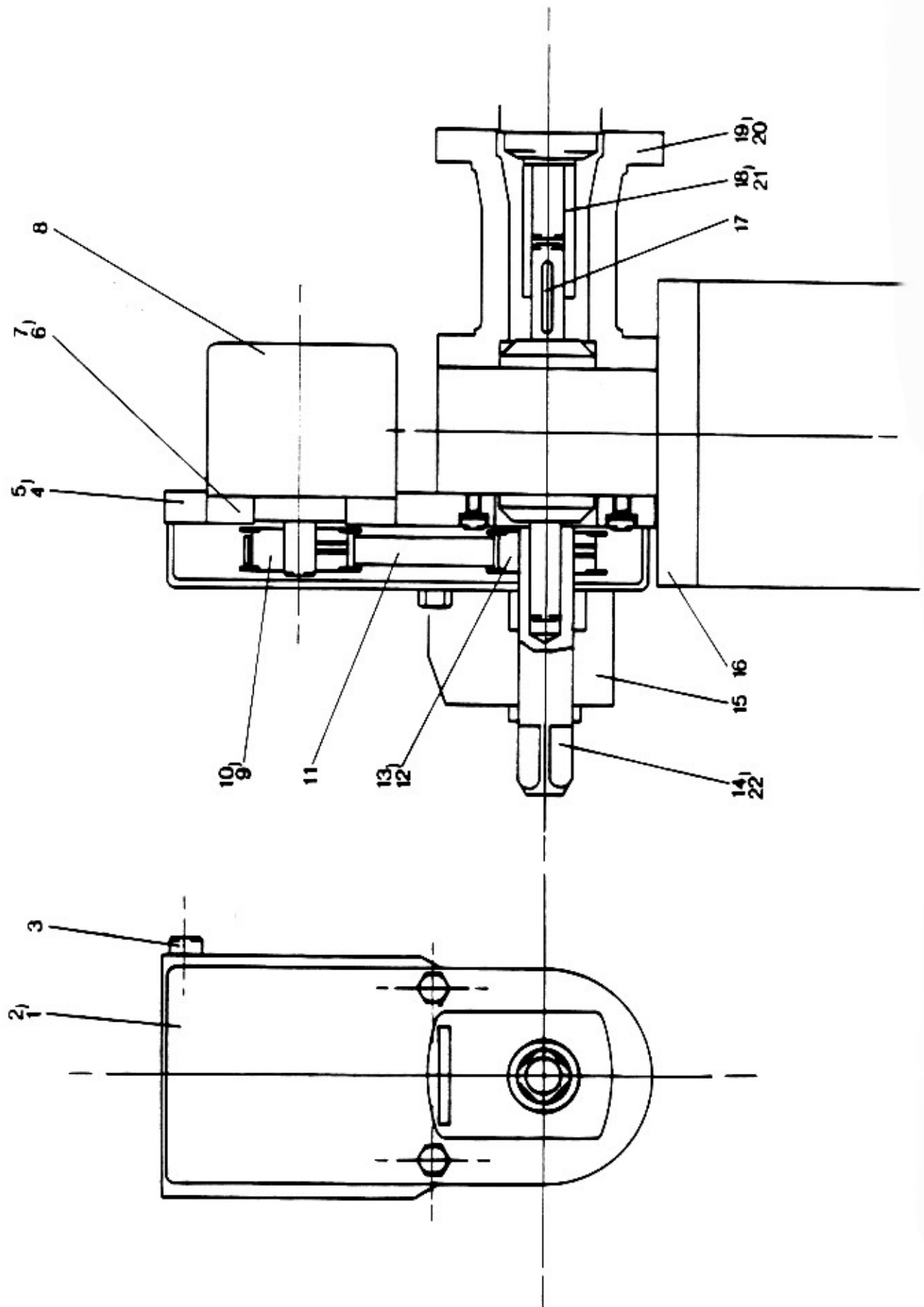


FIG.7 ELEC/MECH DRIVE ASSY.

ILLUSTRATED PARTS LIST

BRAKE FOR VERTICAL SPINDLE

Ref.No.	Description	Quantity
1	Brake shoe and pad assembly	1
2	Brake cylinder	1
3	Cylinder bracket	1
4	Hexagon cap screw M6 x 20LG	2
5	Stud M10 x 70LG	1
6	Brake Shoe spacer	1
7	Plain washer $\phi 10$	1
8	Hexagon self locking nut M10	1
9	Festo elbow GCK-1/4-PK-4-KU	1
20	Hexagon cap screw M5 x 25LG	4
21	Grub screw M6 x 6LG	1
22	Grub screw M6 x 8LG	1

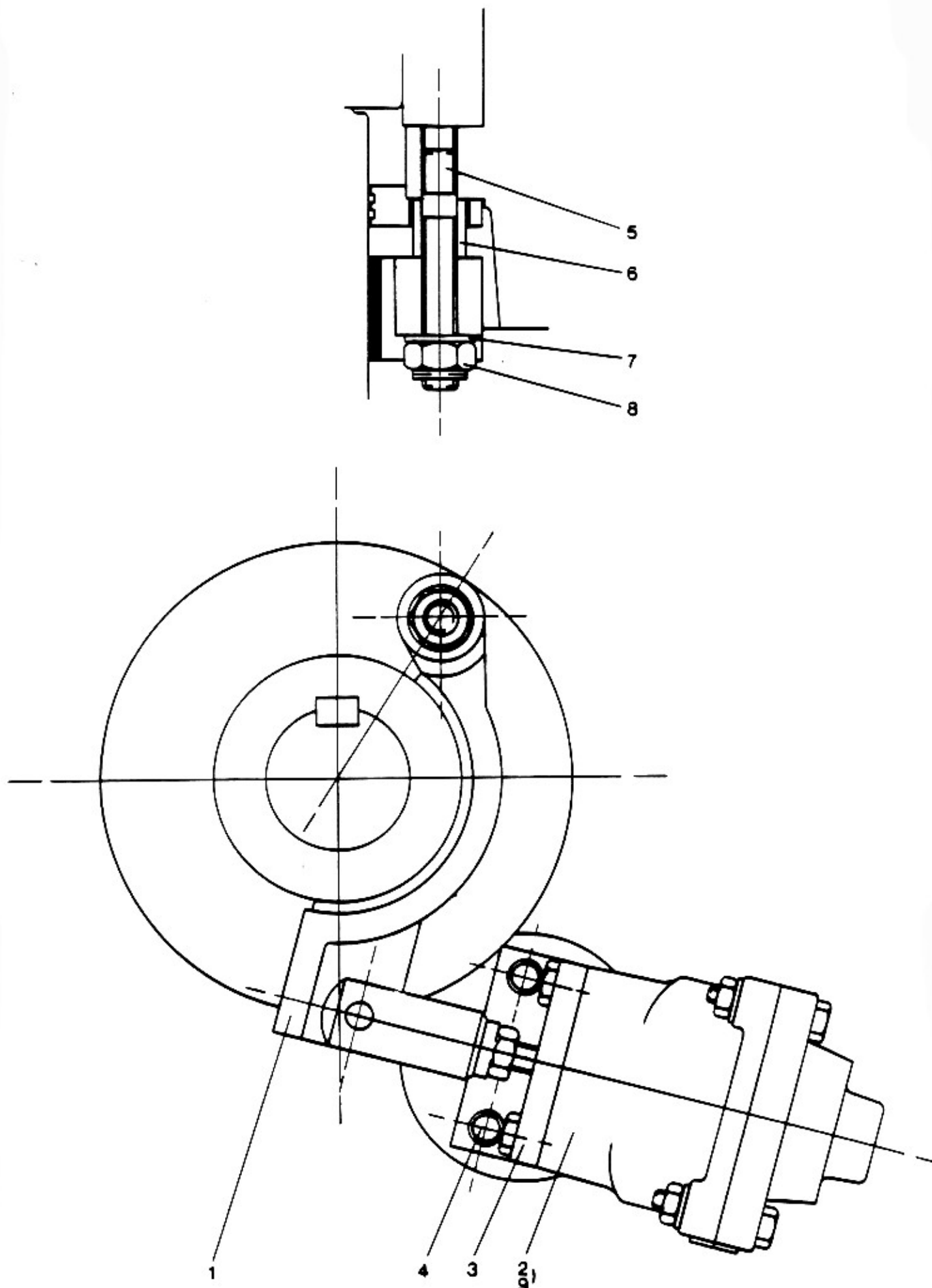


FIG.8 BRAKE FOR VERTICAL SPINDLE

ILLUSTRATED PARTS LIST

RISE AND FALL G/BOX ASSY.

Ref.No.	Description	Quantity
1	Gear box	1
2	End cap	2
3	Rise and fall worm gear and spline shaft	1
4	Worm wheel	1
5	Thrust bearing	4
6	Shim washer 47 O/D x 37 I/D	2
7	Hexagon lock nut M16	1
8	Hexagon head capscrew M5 x 16LG	6
9	Hexagon head capscrew M10 x 40LG	4
10	Tension pin ϕ 10 x 26LG	2

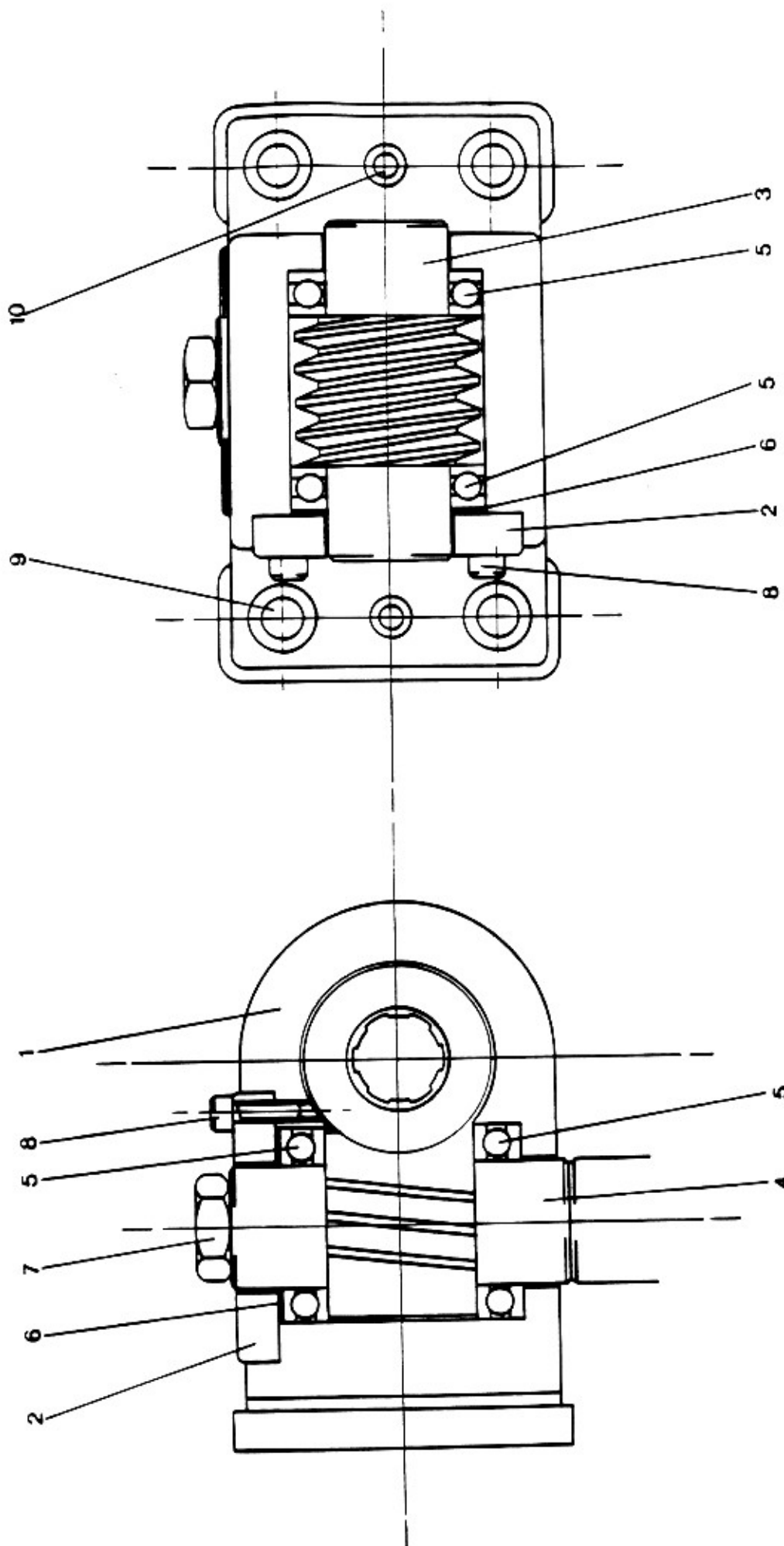


FIG. 9 RISE & FALL G/BOX ASSY.



ILLUSTRATED PARTS LIST

VERTICAL SPINDLE - IN/OUT

Ref.No.	Description	Quantity
1	Spline shaft	1
2	Digital indicator (Highspeed)	1
3	External circlip $\phi 20$	2
4	Thrust washer	2
5	Thrust Bearing	2
6	Thrust washer	2
7	Shim washer 32 x 20 x 2	1
8	Bush 25 x 20 x 25	1
9	Bearing pot	1
10	Hexagon capscrew M6 x 20LG	3

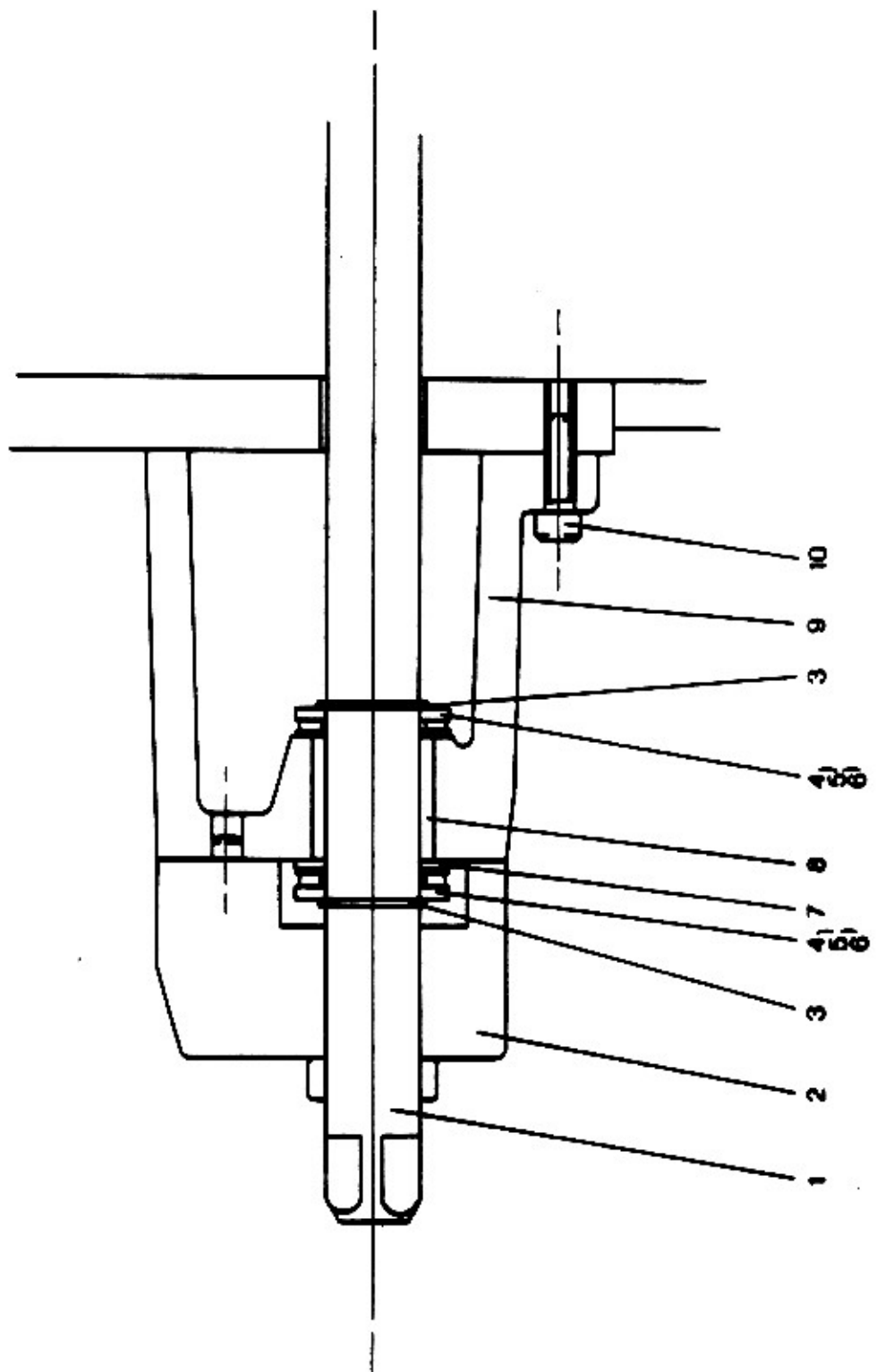


FIG. 10 VERTICAL SPINDLE - IN/OUT

ILLUSTRATED PARTS LIST

CAMS FOR RISE AND FALL ON VERTICAL SPINDLES

Ref.No.	Description	Quantity
1	Block - micro switch cams	1
2	Plate	1
3	Vertical datum cam	1
4	Vertical over-run cam	1
5	Hexagon screw M6 x 35LG	2
6	Hexagon lock nut M6	2
7	Hexagon cap screw M6 x 55LG	2
8	Hexagon screw M6 x 12LG	2
9	Large plain washer $\phi 6$	2
10	Micro-switch	3

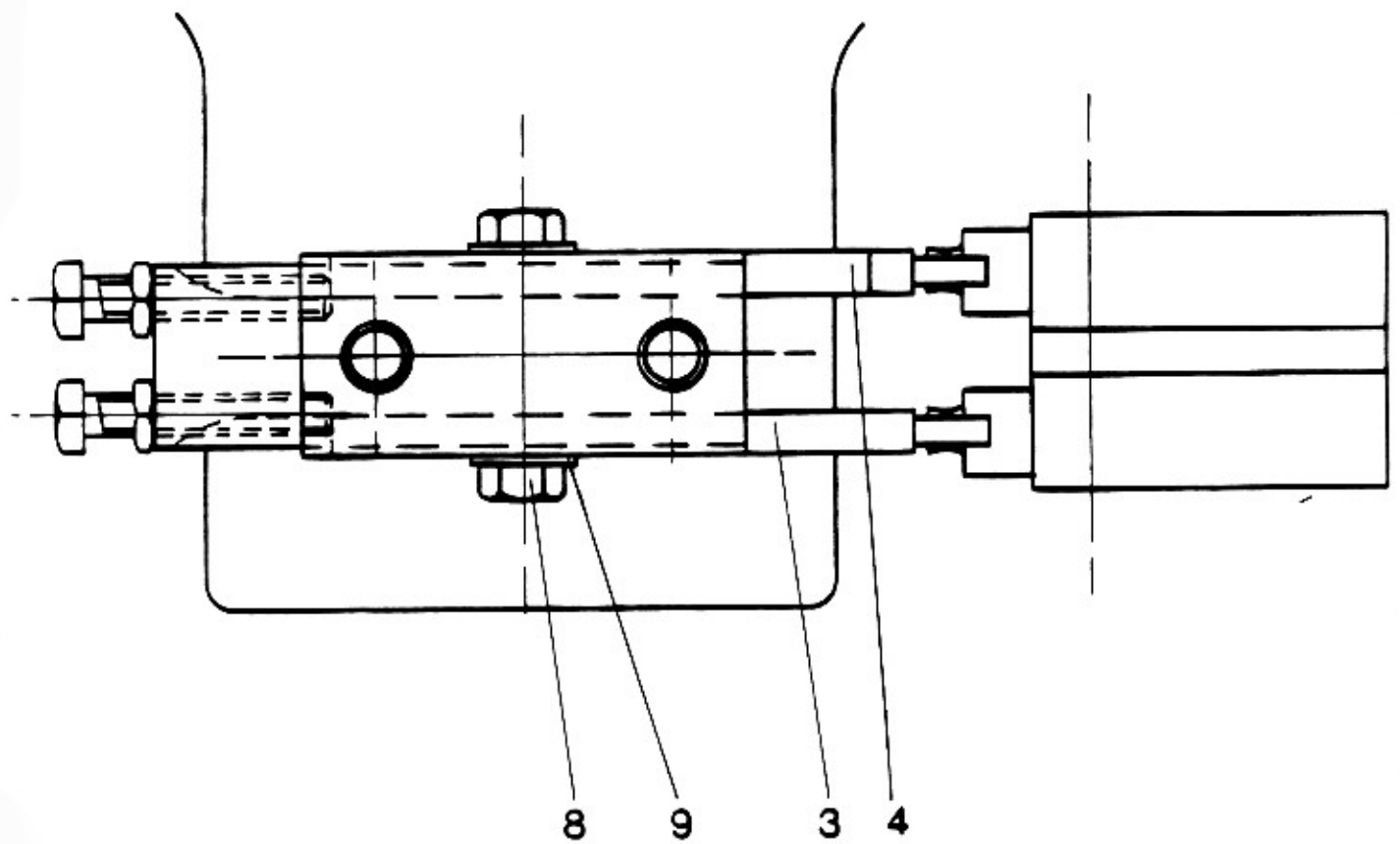
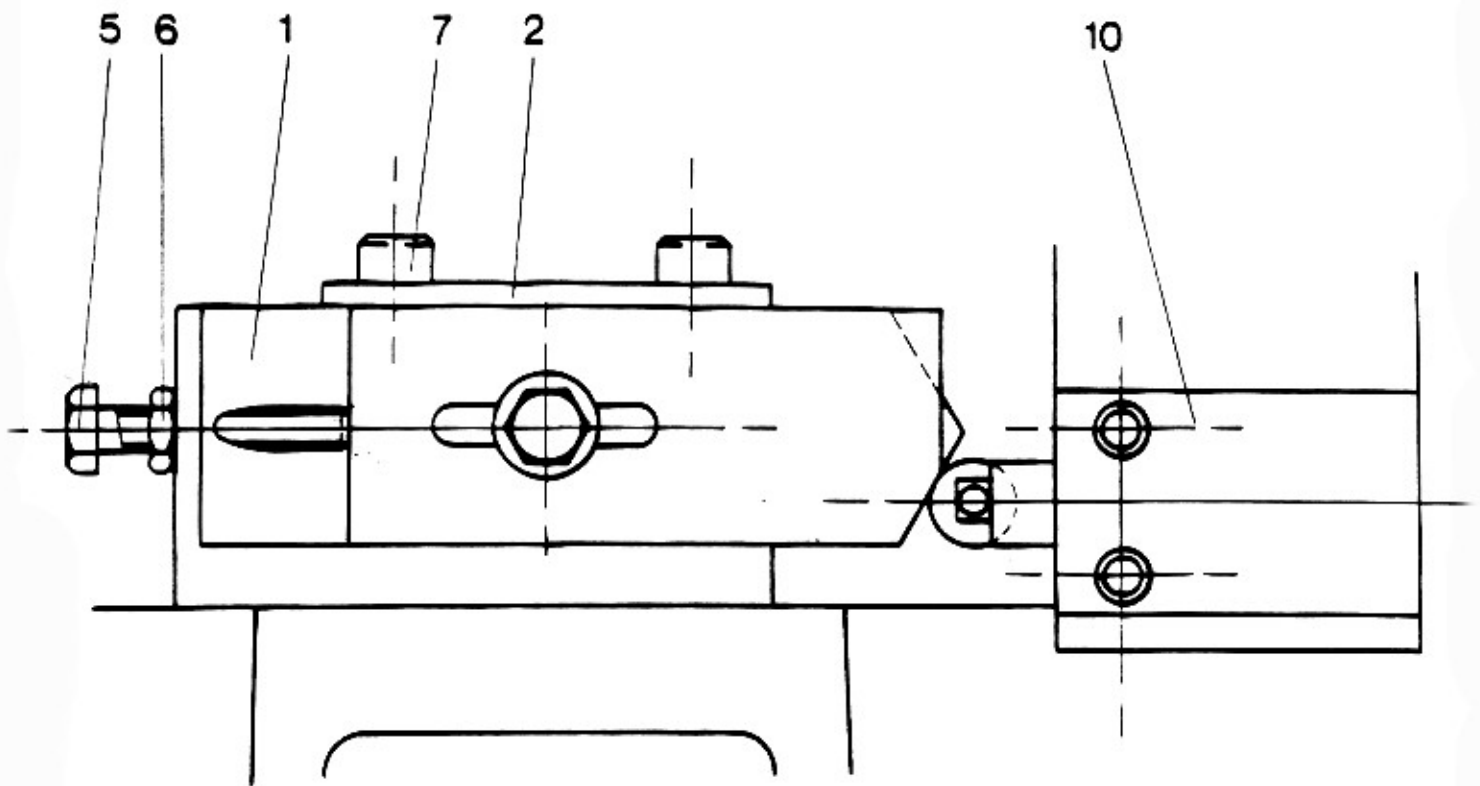


FIG.11 CAMS FOR RISE & FALL

ILLUSTRATED PARTS LIST
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SPINDLE LOCK FOR VERTICAL SPINDLES

Ref.No.	Description	Quantity
1	Handwheel	1
2	Tension pin $\phi 4$ x 32LG	1
3	Locking bolt	1
4	Locking bolt housing	1
5	Screwed post	1
6	Hexagon capscrew M6 x 50LG	3
7	Brake cable assy.	1
8	End cap	1
9	Spring	1
10	Locking pin	1
11	Locking pin housing	1
12	Grub screw M8 x 40LG	1
13	Grub screw M6 x 6L	2

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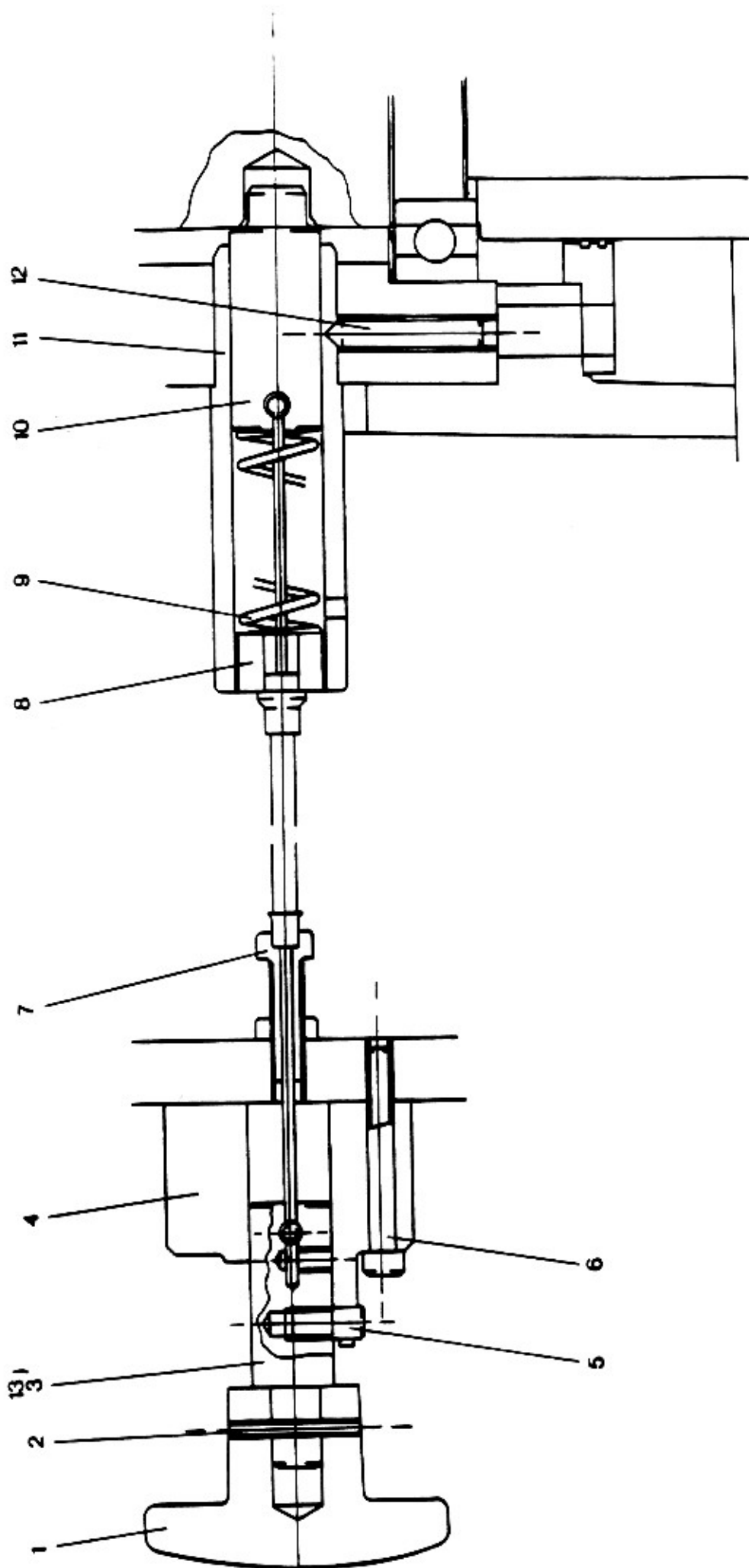


FIG.12 SPINDLE LOCK

ILLUSTRATED PARTS LIST

AUTO TURRET STOP

Ref.No.	Description	Quantity
1	Turret stop bar	6
2	Proximity switch ring	1
3	Proximity switch target	1
4	Thrust washer	2
5	Bearing cage	1
6	Proximity switch	6
7	Steel ball $\varnothing 8$	2
8	Compression spring	2
9	Thrust race cover	1
10	Ferado disc pad	1
11	Detent plate	1
12	Hexagon full nut M8	6
13	Stieder clutch	1
14	Plain washer $\varnothing 12$	1
15	Hexagon self locking nut M12	1
16	Key 4 x 4 x 30LG	1
17	Turret shaft assembly	1
18	Spacing stub	3
19	Bush 16 x 20 x 25	1
20	Turret mounting plate	1
21	Hexagon cap screw M10 x 25LG	3
22	Screwed stud M6 x 85LG	2
23	Hexagon nut M6	2
24	Cover	1
25	Hand wheel	1
26	Pneumatic cylinder	1
27	Proximity switch	2
28	Flow control valve	2
29	Cylinder clevis	1
30	Clutch arm	1
31	Clutch arm key	1
32	Hexagon cap screw M4 x 8LG	1

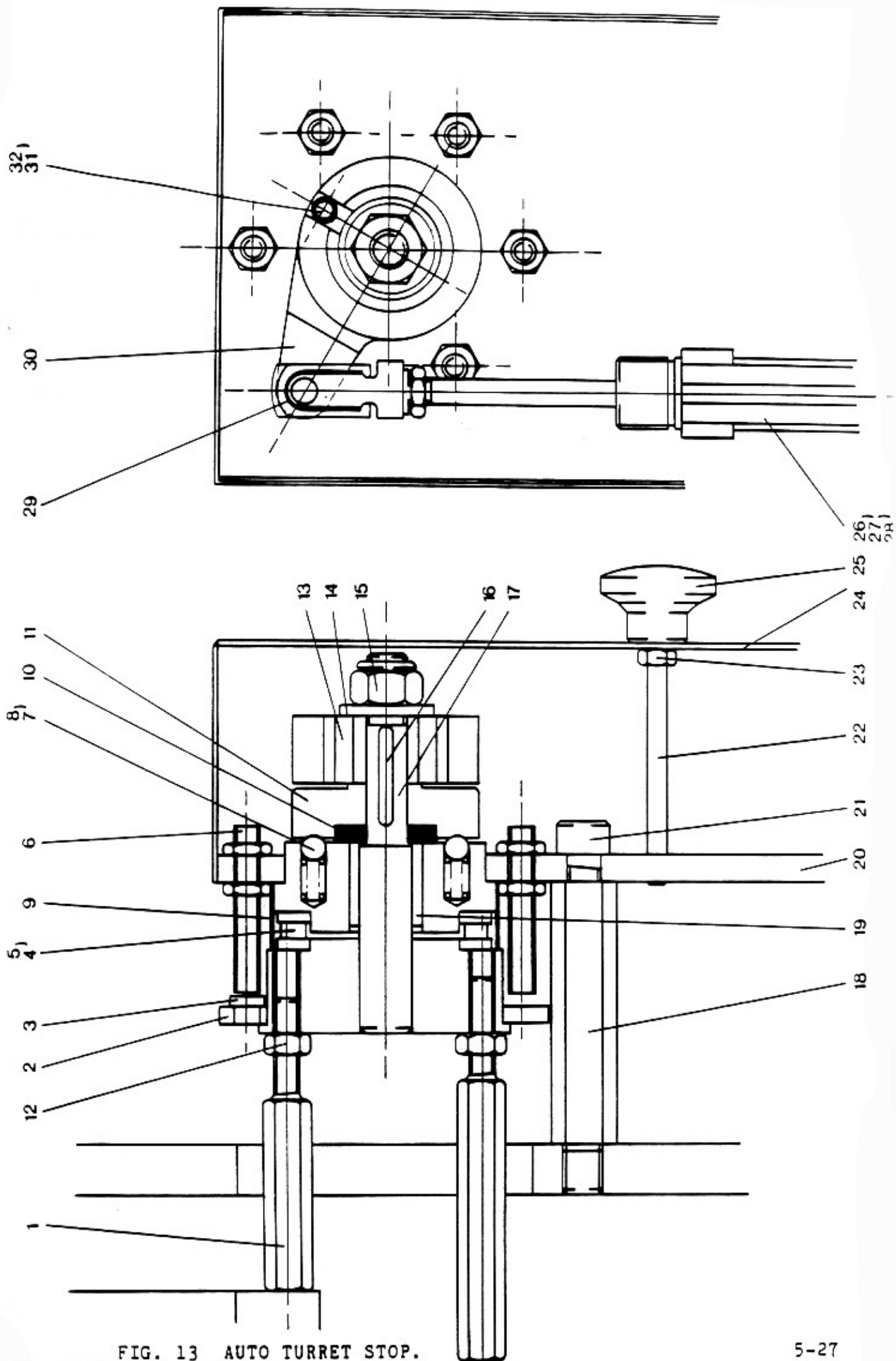


FIG. 13 AUTO TURRET STOP.

ILLUSTRATED PARTS LIST

RISE & FALL TRIP CAM ON FEEDWORKS

Ref.No.	Description	Quantity
1	Rise and fall screw	2
2	Rise and fall nut	2
3	Hexagon cap screw M6 x 20LG	10
4	Grease nipple	2
5	Beam Support arm bracket	2
6	'O' Ring Seal	4
7	Multi-limit switch	1
8	Oil nipple	2
9	Hexagon cap screw M6 x 30LG	4
10	Multi-limit switch bracket	1
11	Spacing tube	4
12	Cam trip rail	1
13	Pan head screw M6 x 25LG	4
14	Trip cam	6
15	Hexagon screw M12 x 40LG	2
16	Plain washer $\phi 12$	2

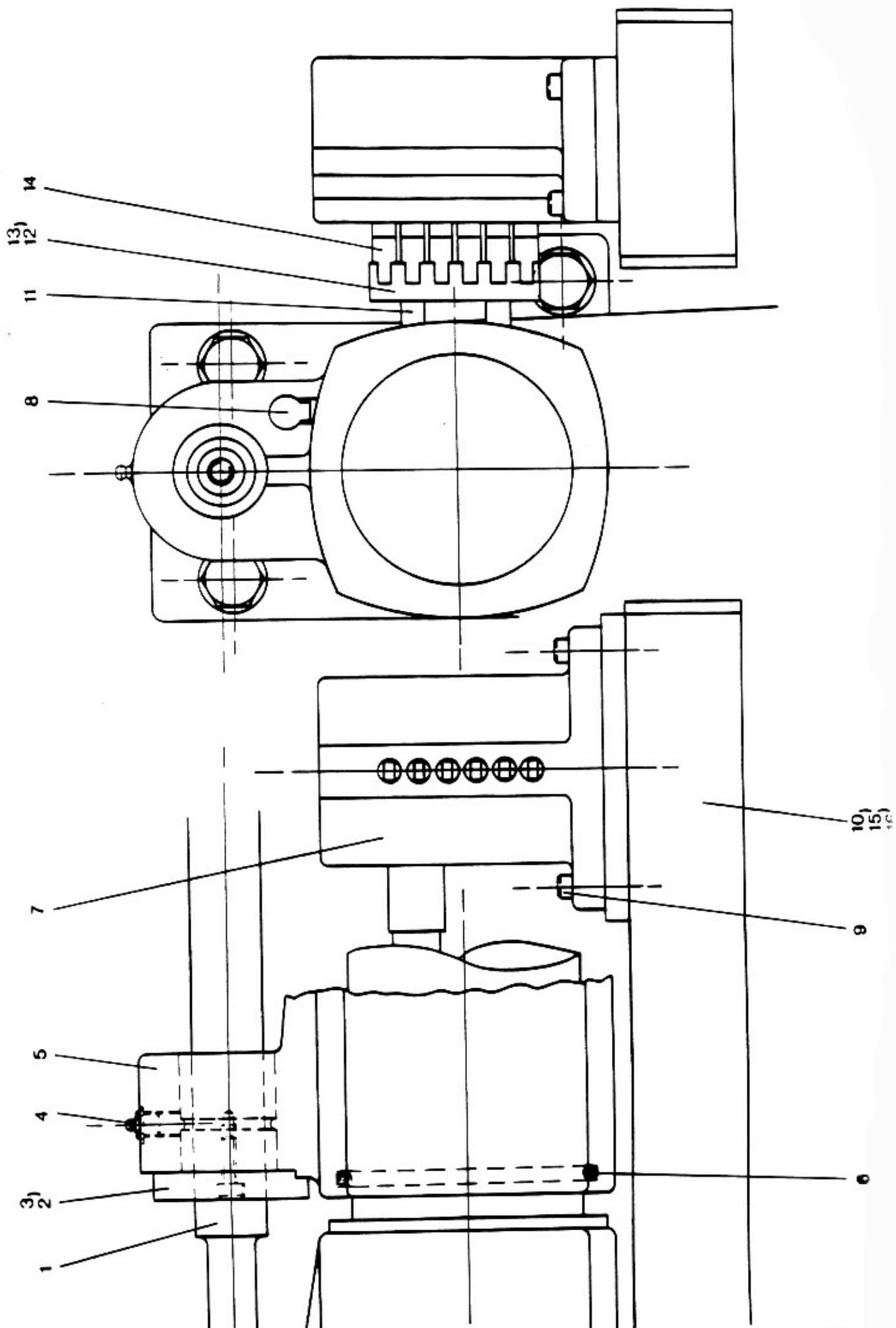


FIG.14 RISE & FALL TRIP CAM-FEEDWORKS

ILLUSTRATED PARTS LIST

FEEDWORKS WITH AXIS CONTROL

Ref. No.	Description	Quantity
1	Support pillar	2 or 3
2	Micro-switch	4
3	Micro-switch support	1
4	Spacers	2
5	Support arms	2 or 2
6	Micro-switch spacers	2
7	Micro-switch trip rail	1
8	Cam-datum trip	1
9	Cam-bottom limit	1
10	Hexagon capscrew M6 x 35LG	2
11	Hexagon capscrew M4 x 45LG	2
12	Hexagon capscrew M4 x 50LG	2

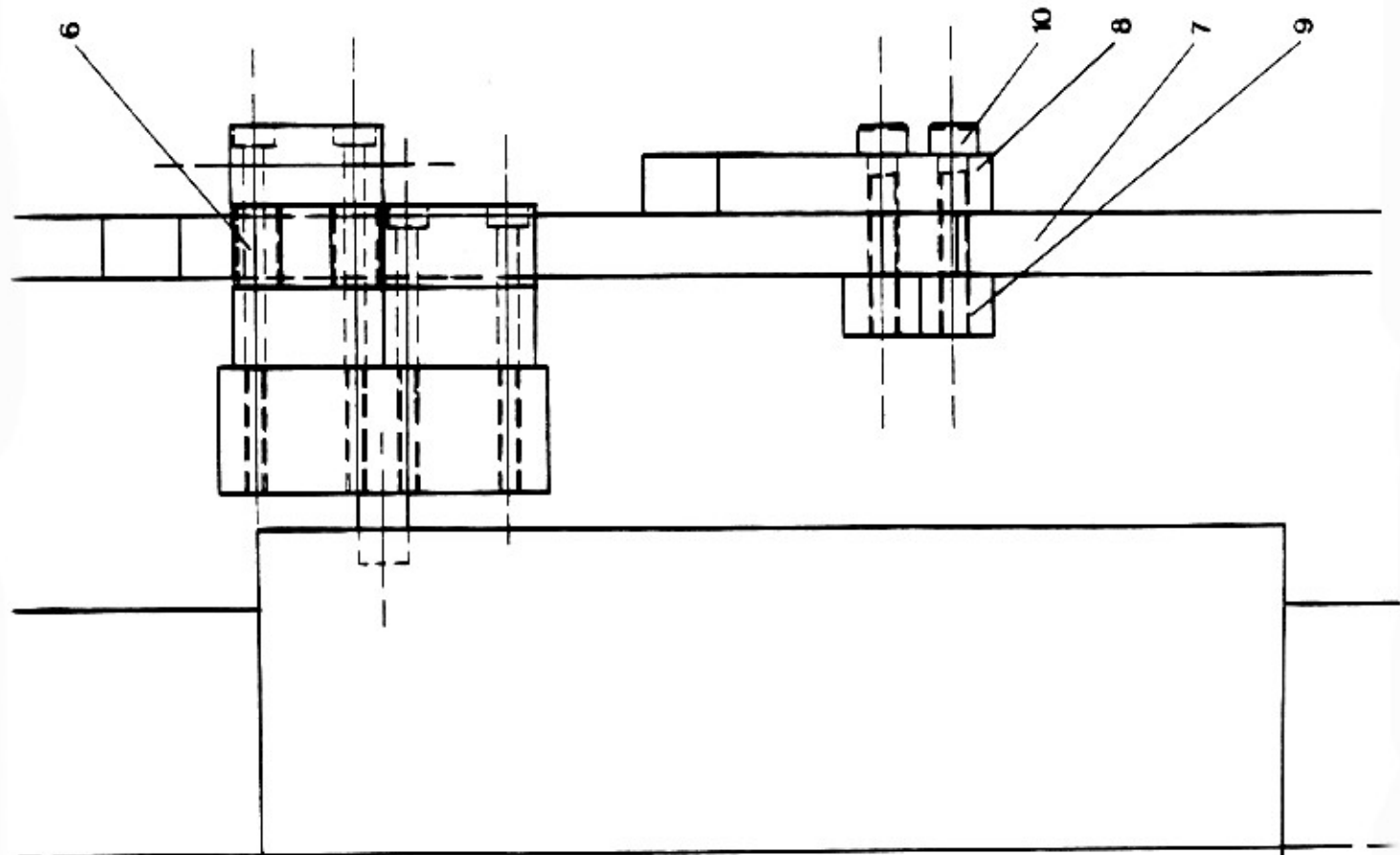
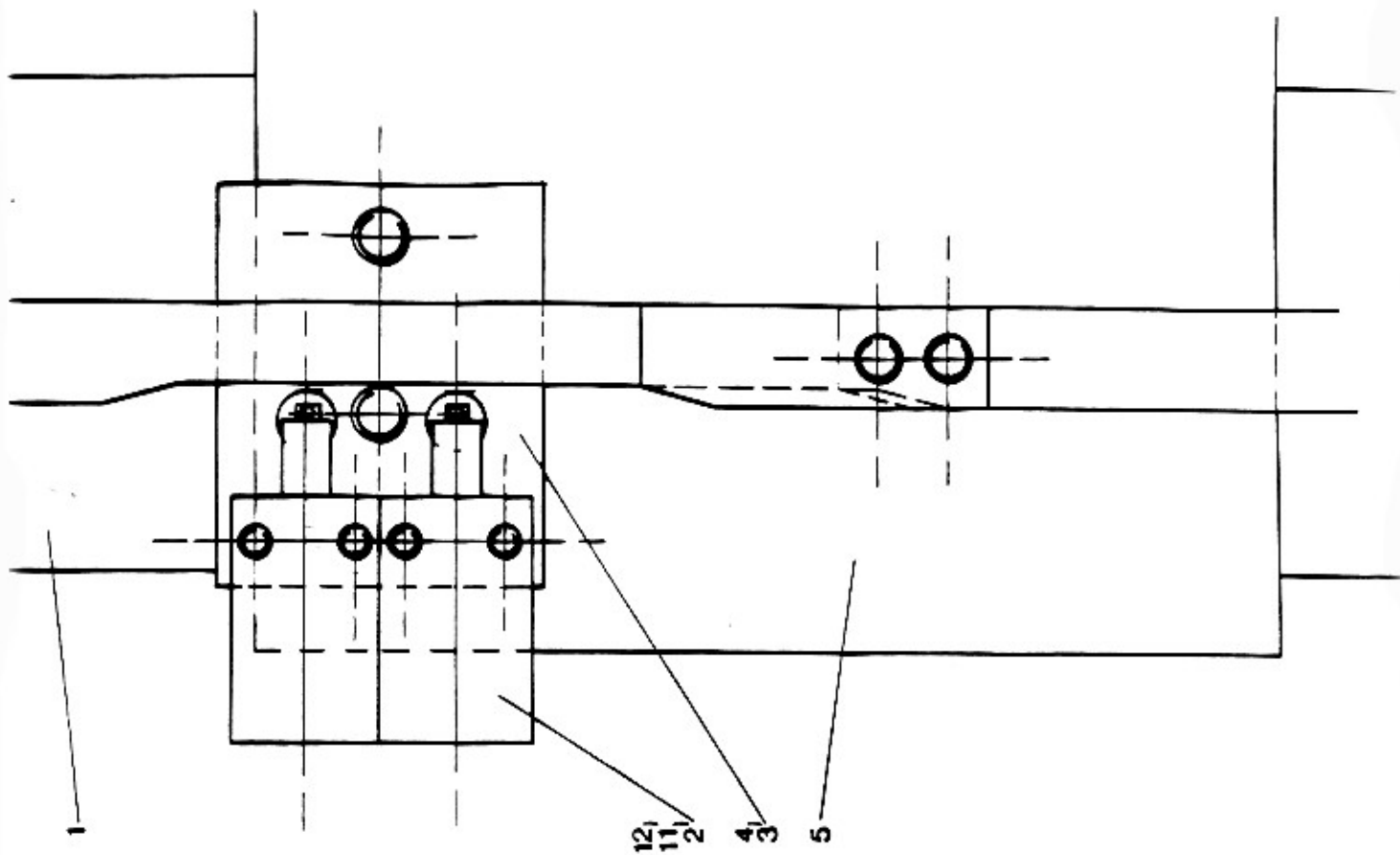


FIG. 15 FEEDWORKS WITH AXIS CONTROL

ILLUSTRATED PARTS LIST

G/BOX AND DRIVE FOR FEEDWORKS

Ref.No.	Description	Quantity
1	Motor/gearbox unit	1
2	Motor/gearbox flange mounting	1
3	Grub screw M8 x 20LG	2
4	Hexagon screw M10 x 25LG	4
5	Spring washer ϕ 10	4
6	Coupling	2
7	Coupling gear ring	1
8	End cap	1
9	Grub screw M5 x 8LG	2
10	Hexagon screw M10 x 35LG	4
11	Spring washer ϕ 10	4
12	Key 6 x 6 x 20LG	1
13	Drive shaft	1
14	Key 8 x 7 x 40LG	1
15	Seal	1
16	Thrust bearing	2
17	Bearing spacer	1
18	Grease nipple	1
19	Notch nut M20 x 1.0 Pitch	2
20	Seal	1
21	Bearing housing	1
22	Hexagon screw M10 x 35LG	4
23	Spring washer ϕ 10	4
24	Hexagon nut M10	4

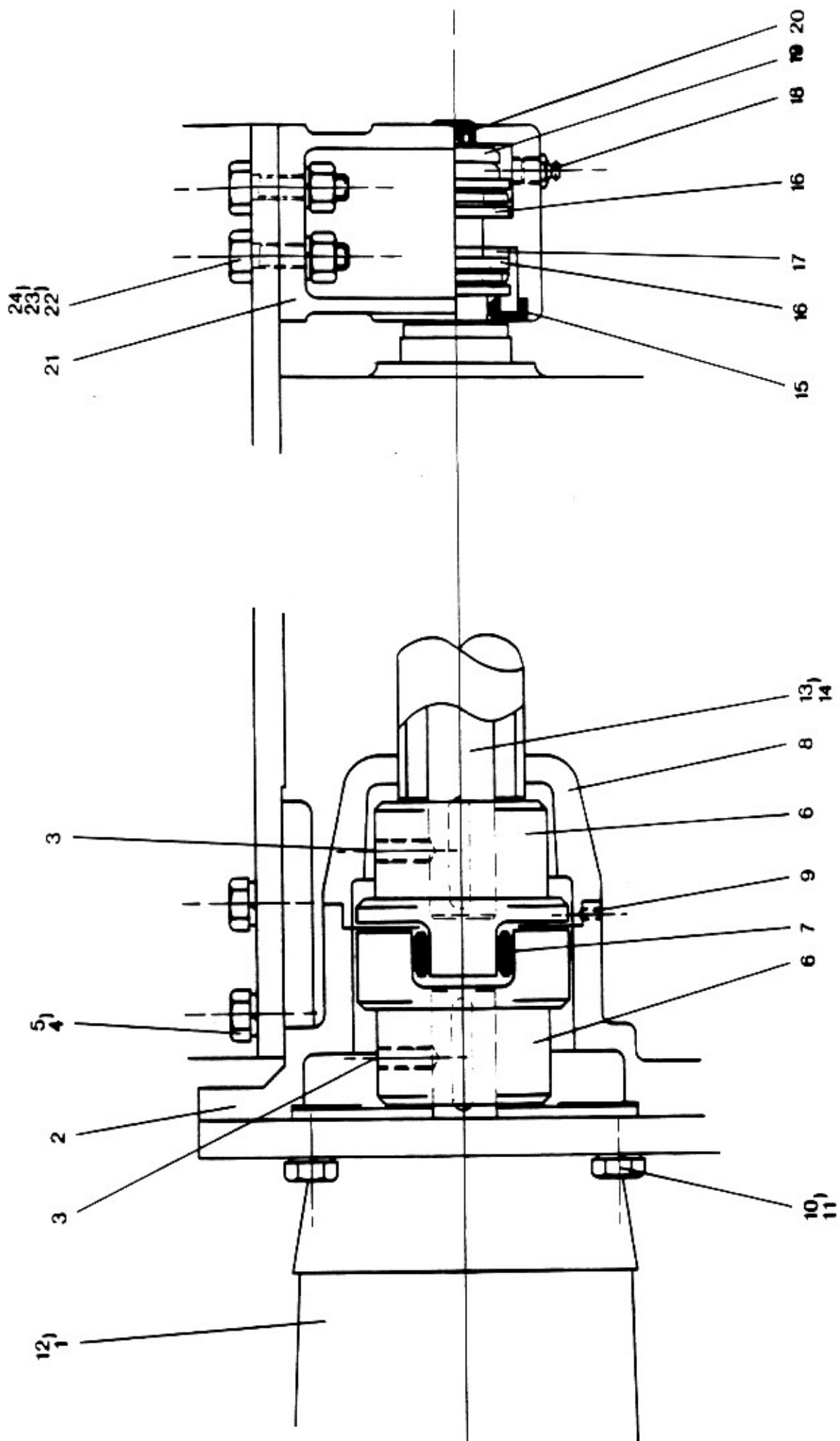


FIG.16 G/BOX & DRIVE FOR FEEDWORKS

ILLUSTRATED PARTS LIST

CAMS FOR TOP HORIZONTAL PLANING HEAD

Ref.No.	Description	Quantity
1	Plate	1
2	Block-microswitch cams	1
3	Vertical over-run cam	1
4	Hexagon capscrew M6 x 55LG	2
5	Vertical datum cam	1
6	Micro-switch	3
7	Micro-switch plate	1
8	Spacing stud	2
9	Hexagon capscrew M4 x 40LG	4
10	Hexagon capscrew M10 x 60LG	2
11	Support plate	1
12	Hexagon screw M6 x 35LG	2
13	Hexagon locknut M6	2
14	Hexagon screw M6 x 12LG	2
15	Large plain washer $\phi 6$	2
16	Hexagon capscrew M10 x 20LG	2

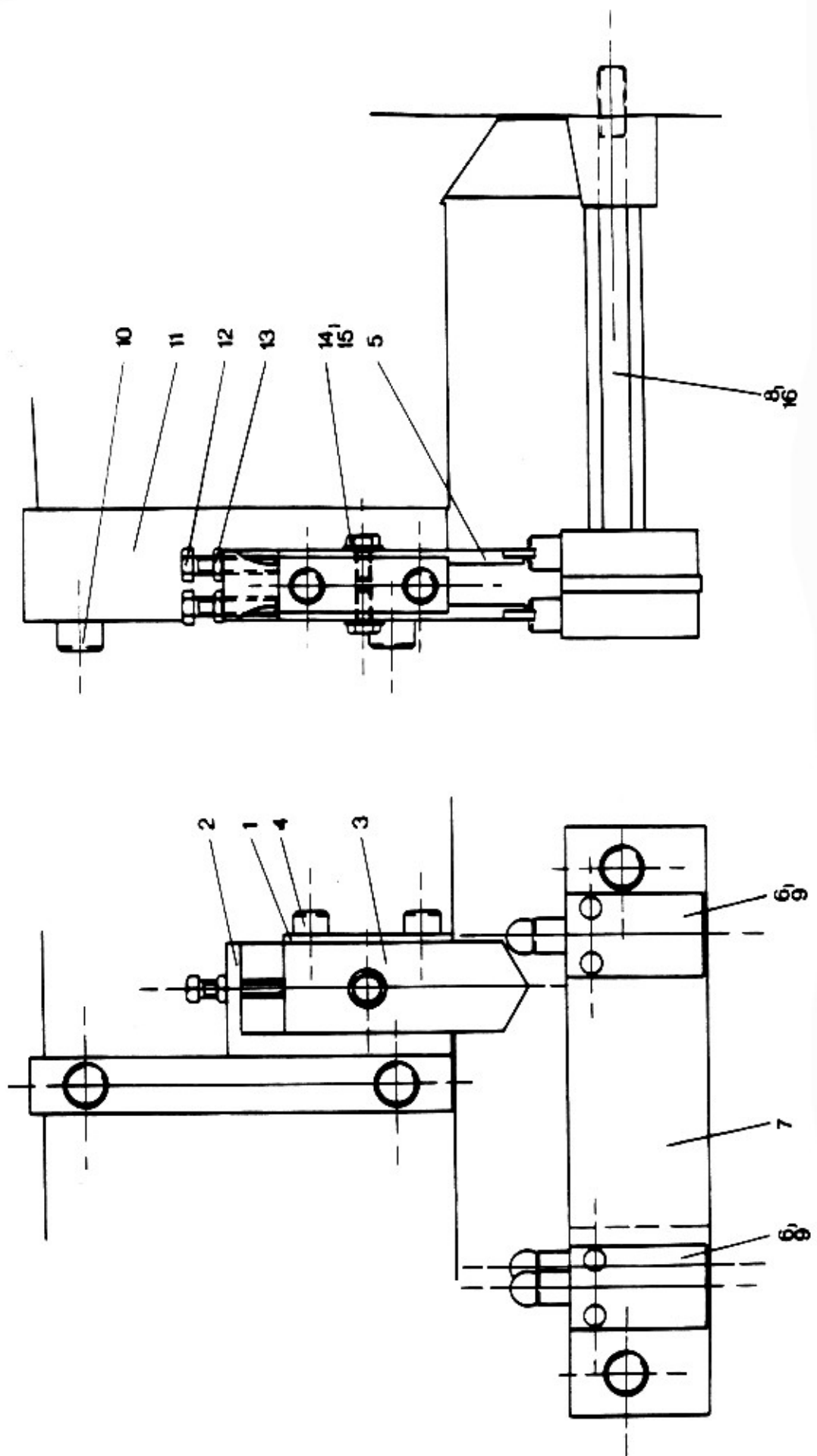


FIG. 17 CAMS FOR TOP HORZ. PLANING HEAD