

JET

**JTM-1230W3 METALWORKING
UNIVERSAL TOOL MILLING
MACHINE**

ITA1230 (X8130)

400/50/3

**PARTS LIST
ERSATZTEILLISTE
LISTE DE PIECES**

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P-ITA1230

03/1

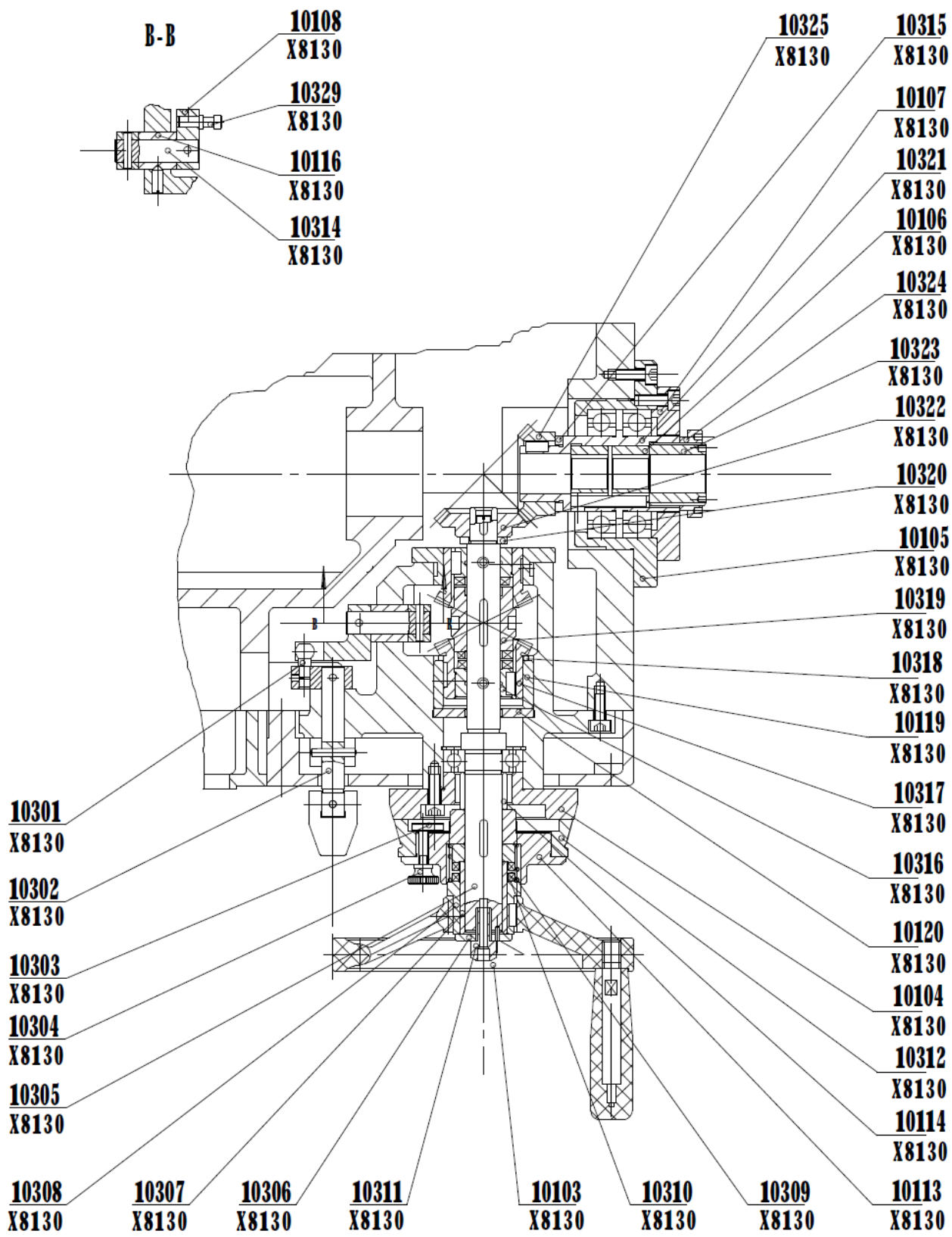


Fig.14

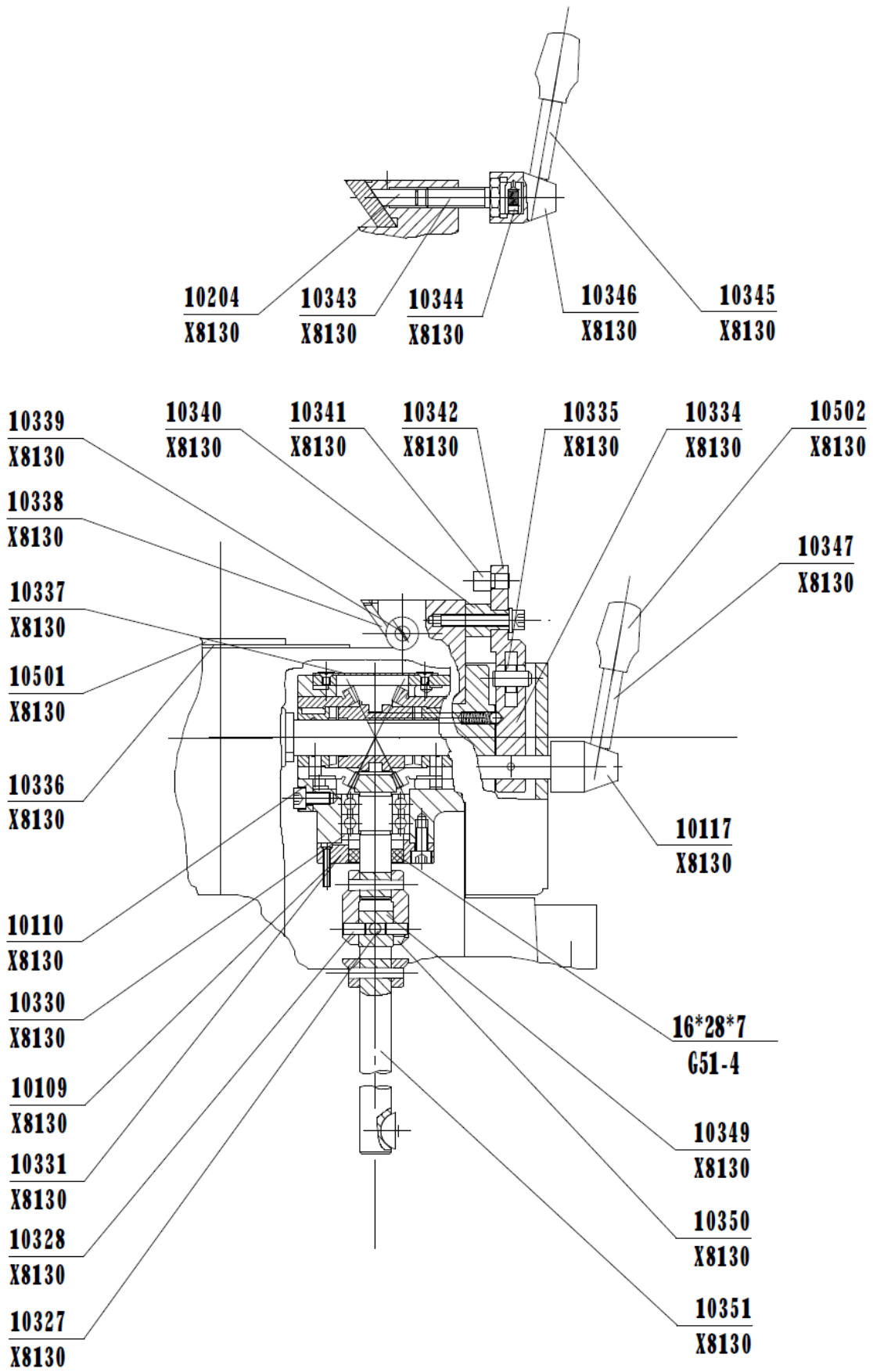


Fig.15

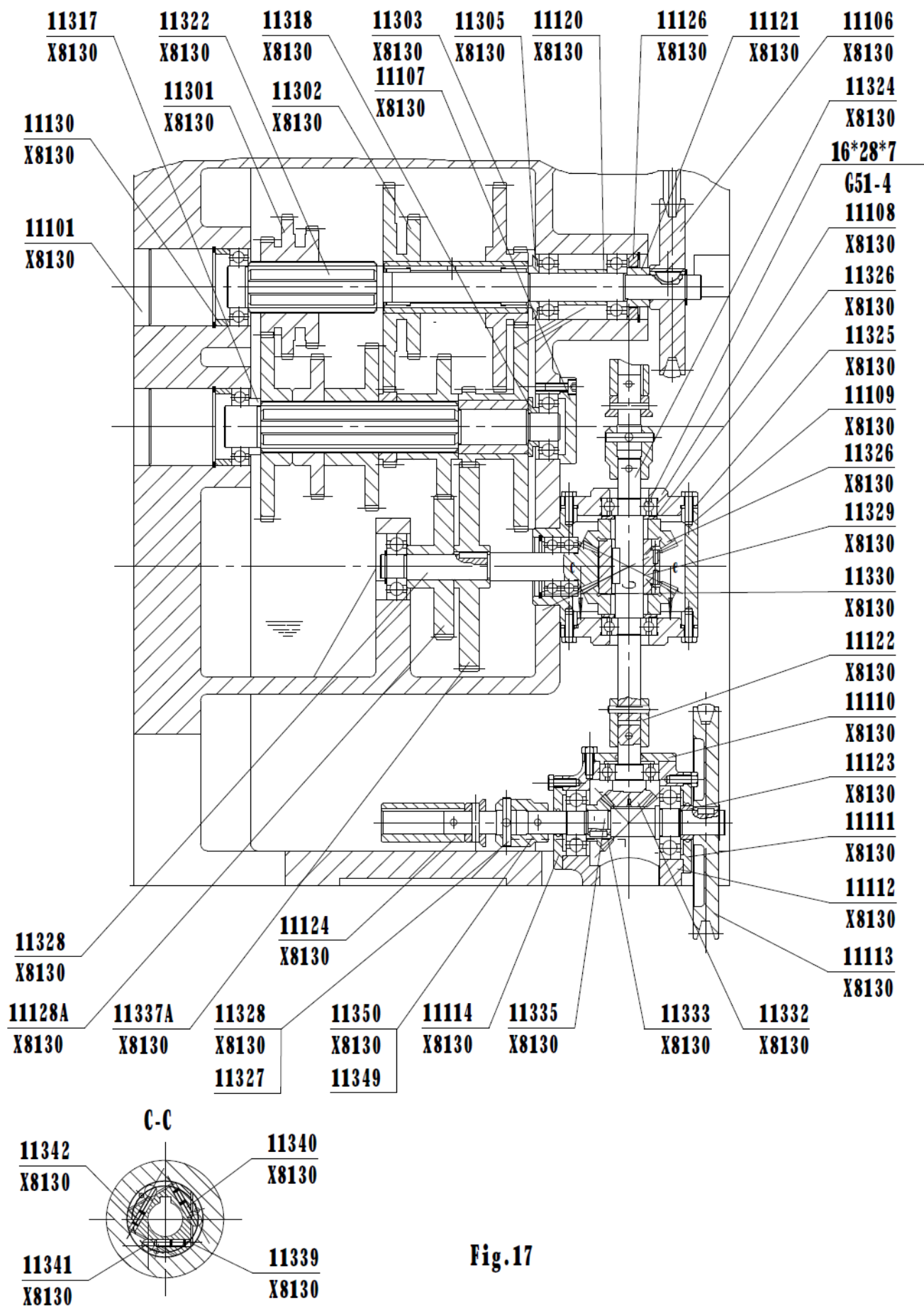


Fig. 17

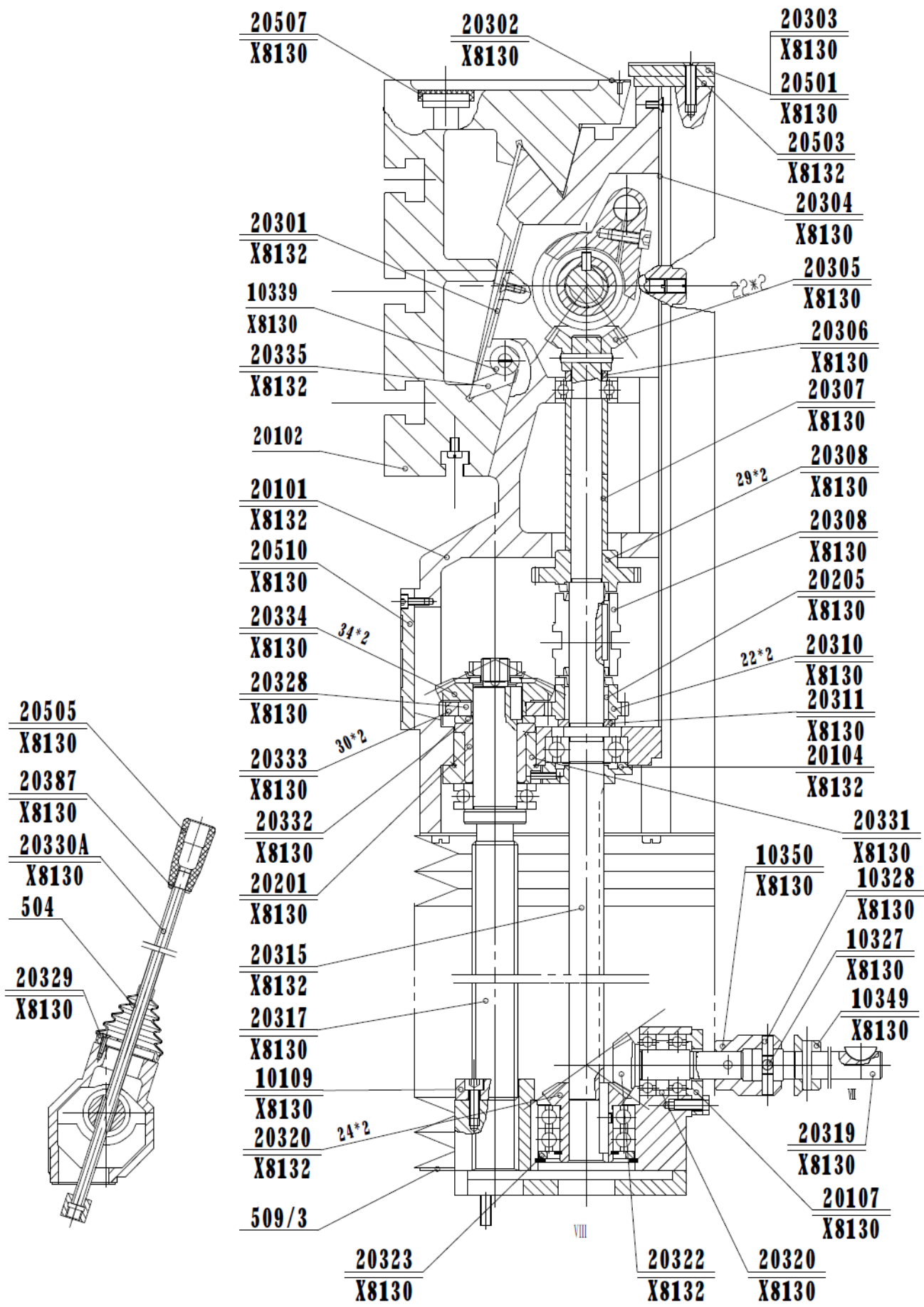


Fig. 18

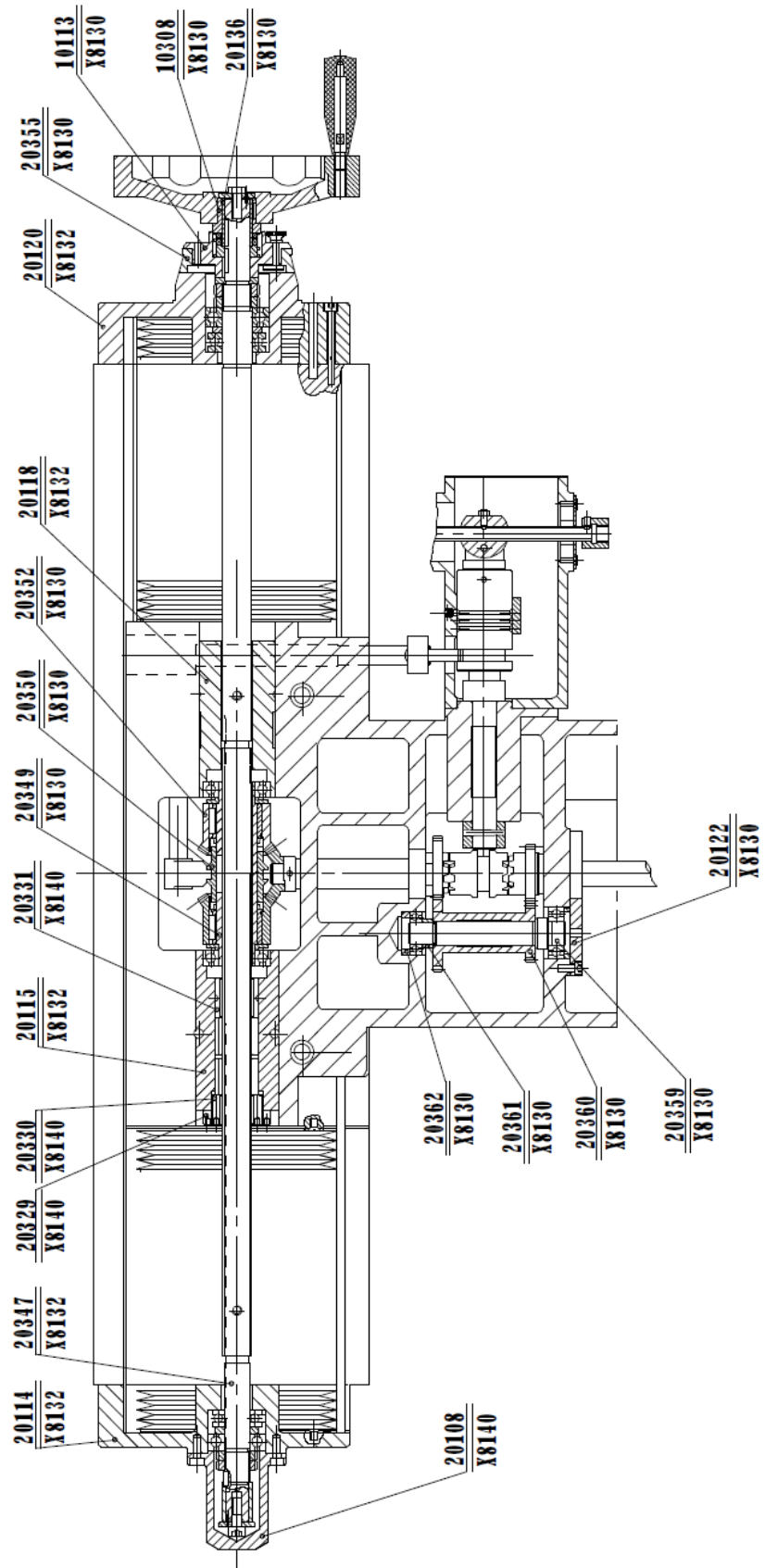


Fig. 19

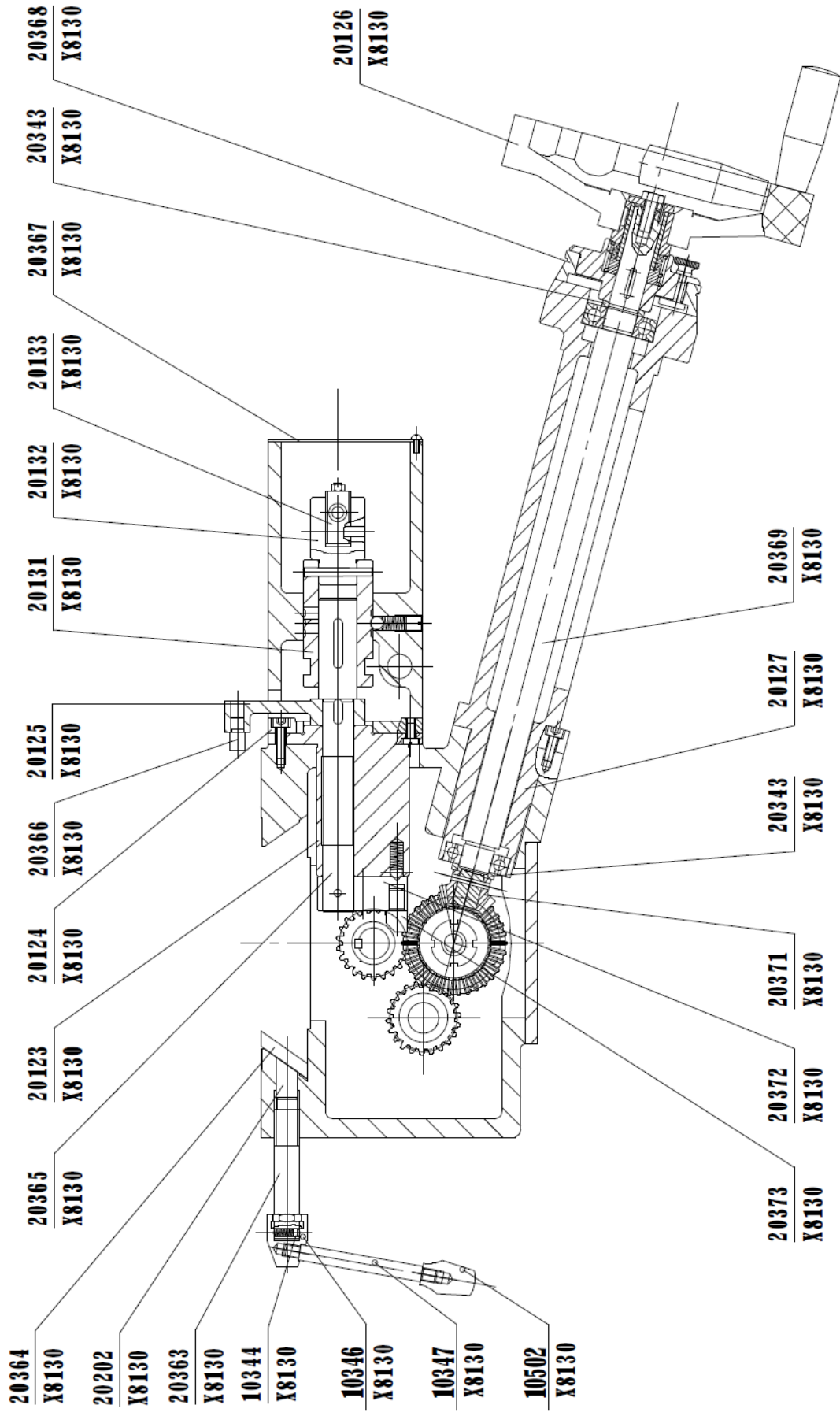


Fig.20

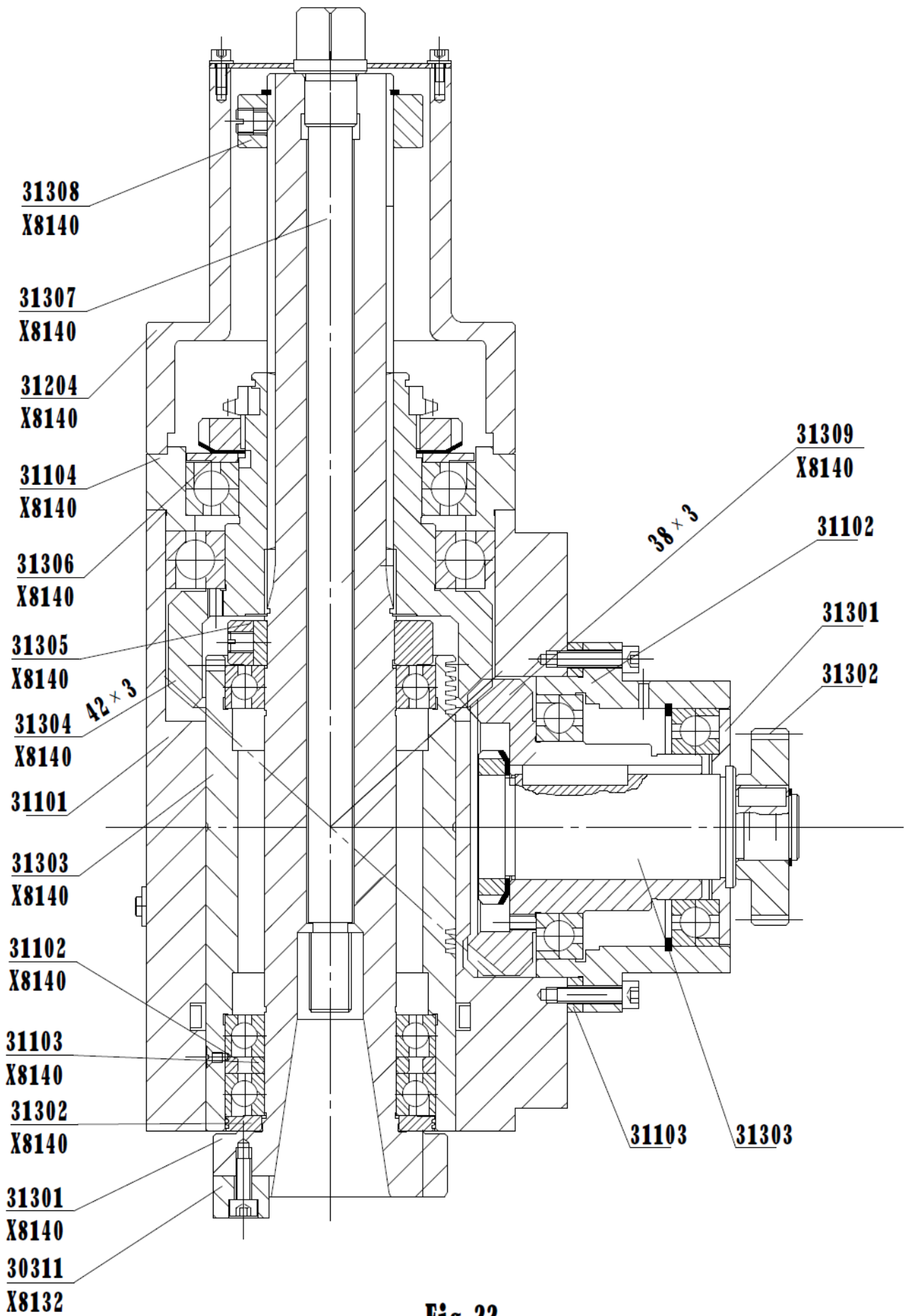


Fig.22

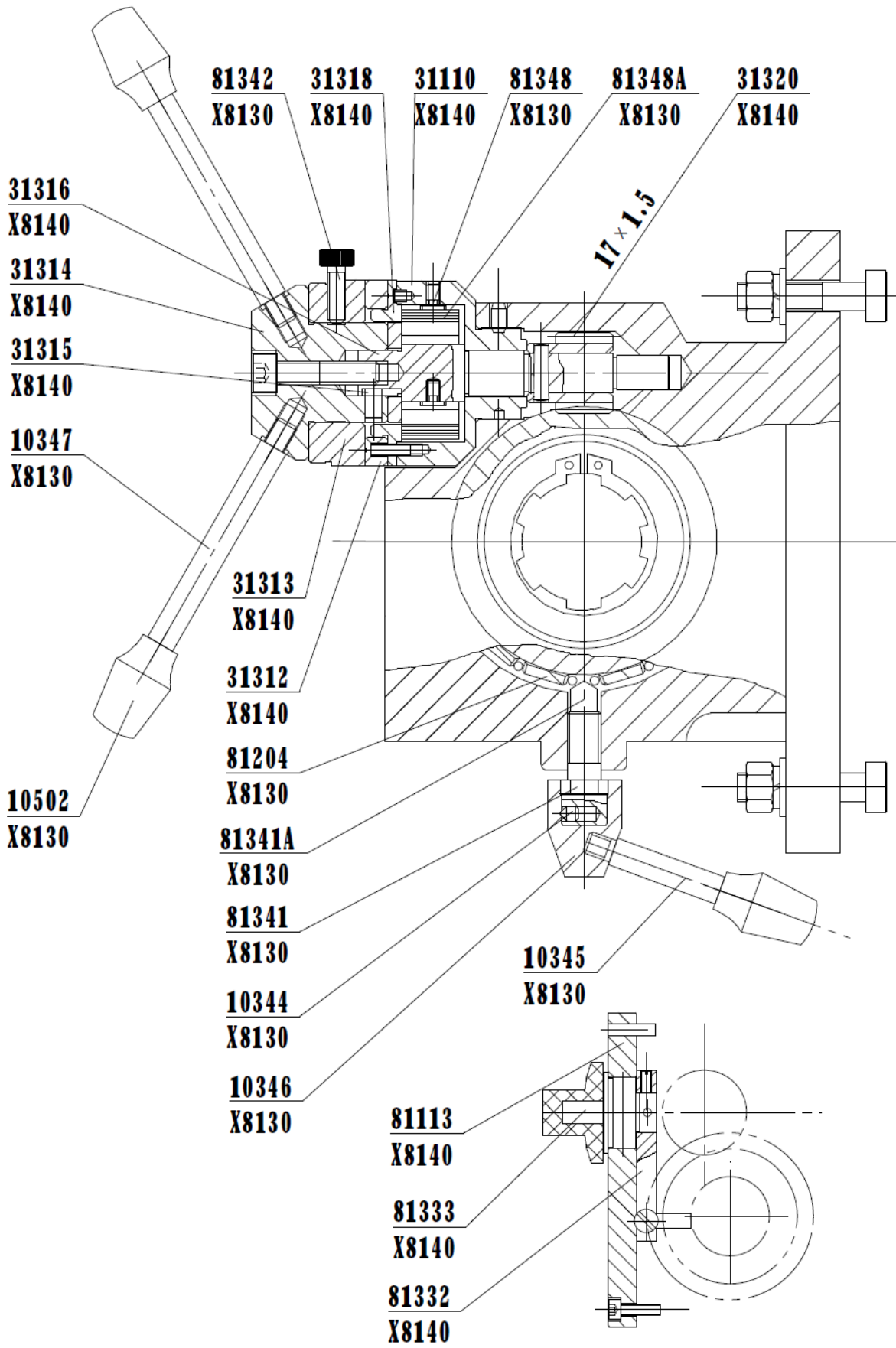


Fig. 23

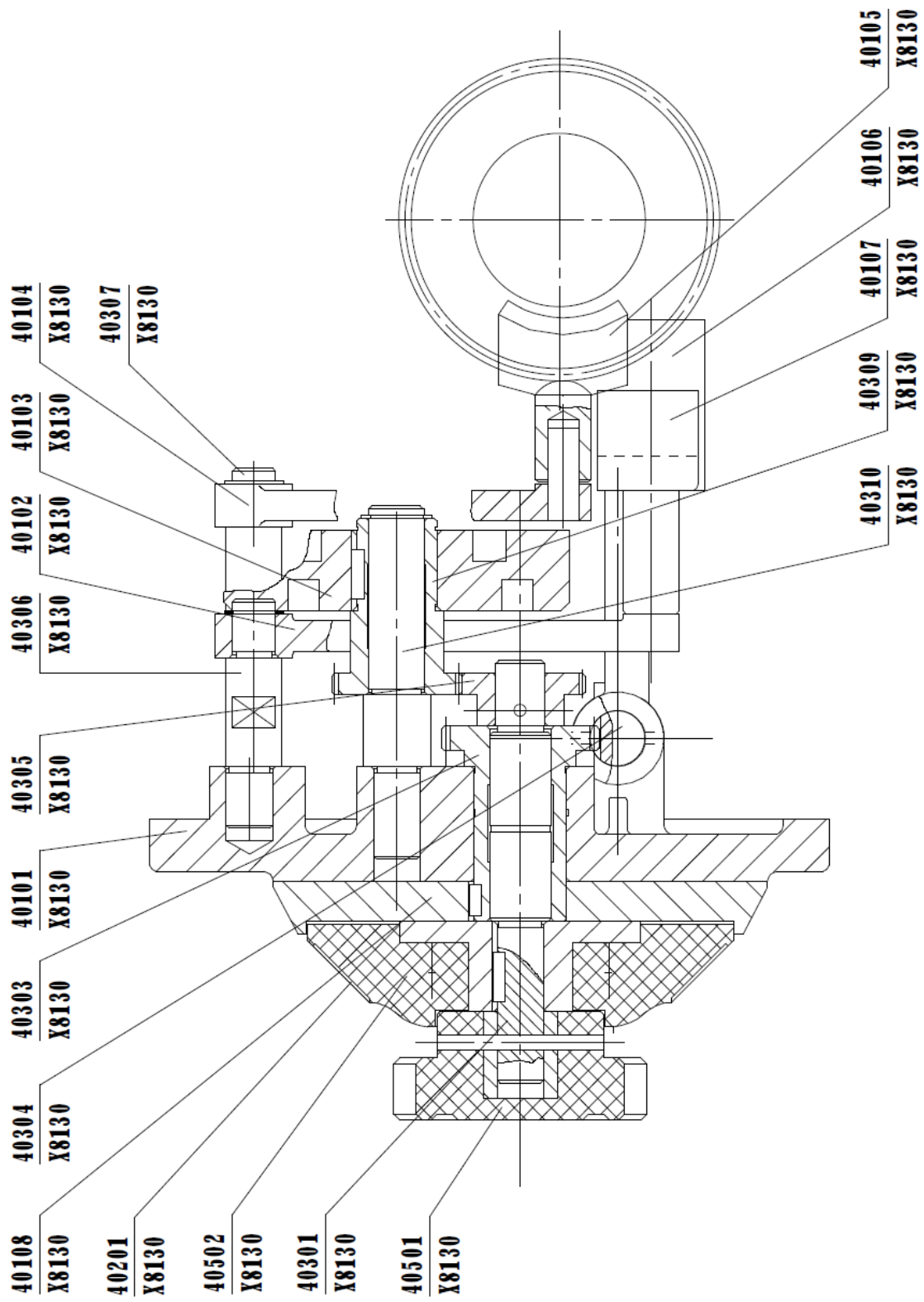


Fig.24

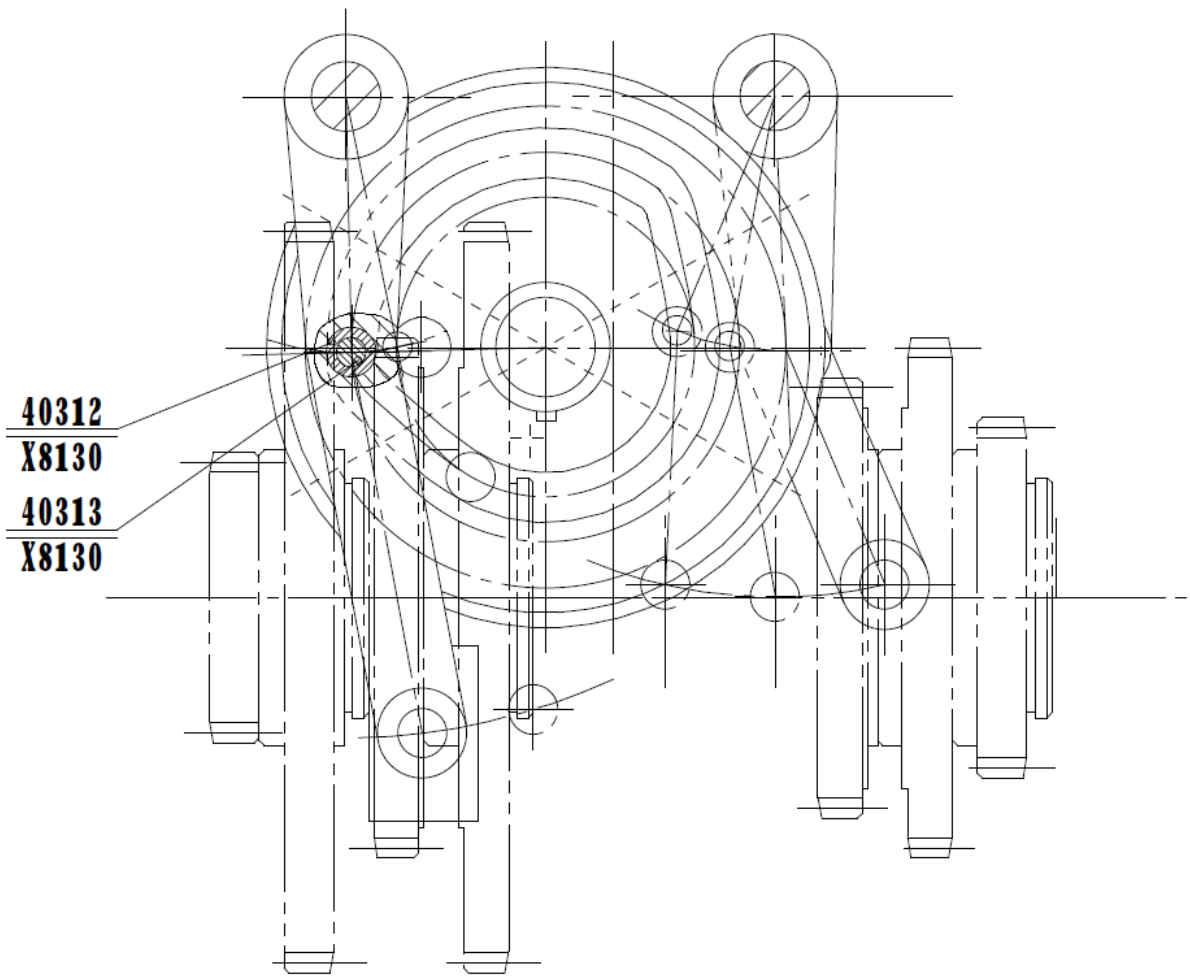


Fig.25

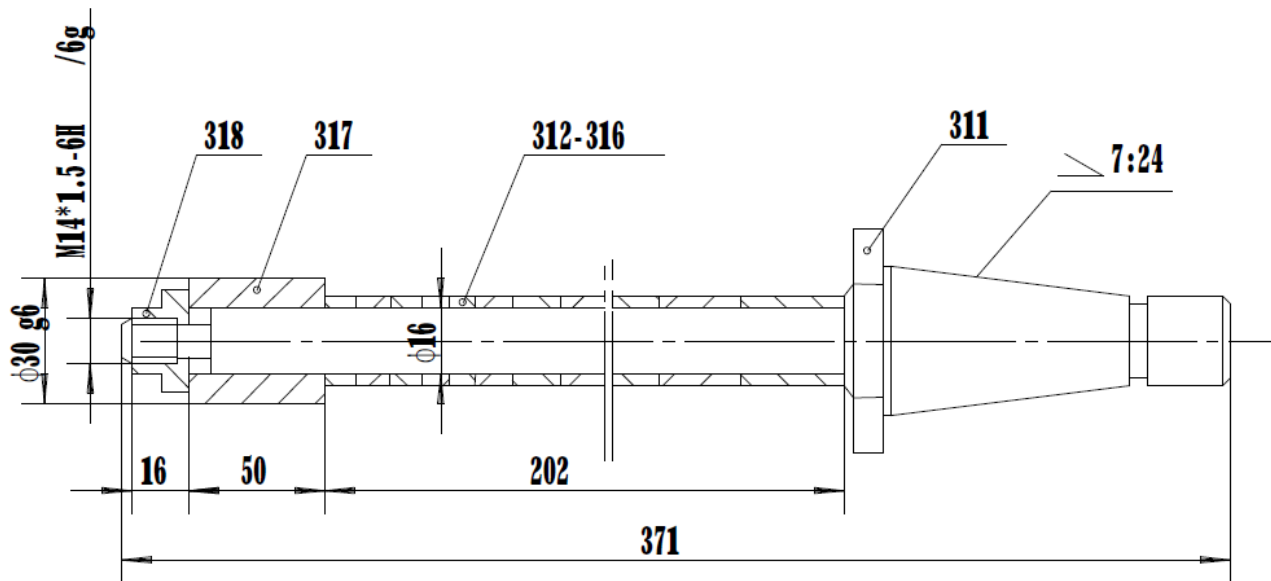
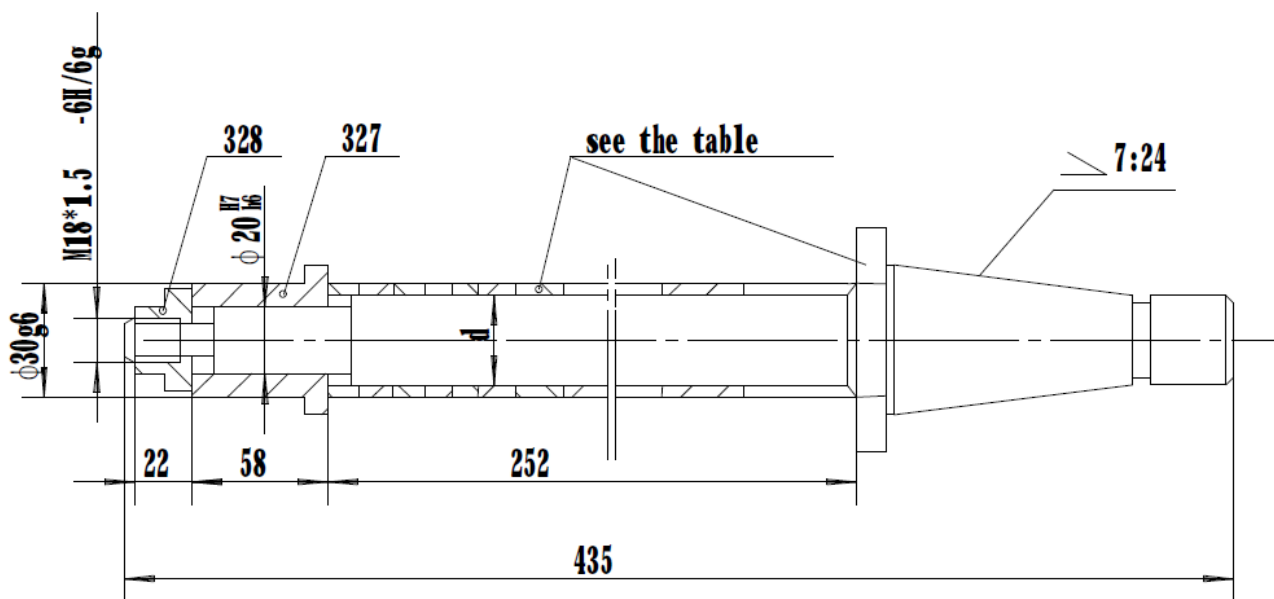


Fig. 26



d	part No. of arbor	part No. of washer
22	321	322-326
27	331	332-336
32	341	342-346

Fig. 27

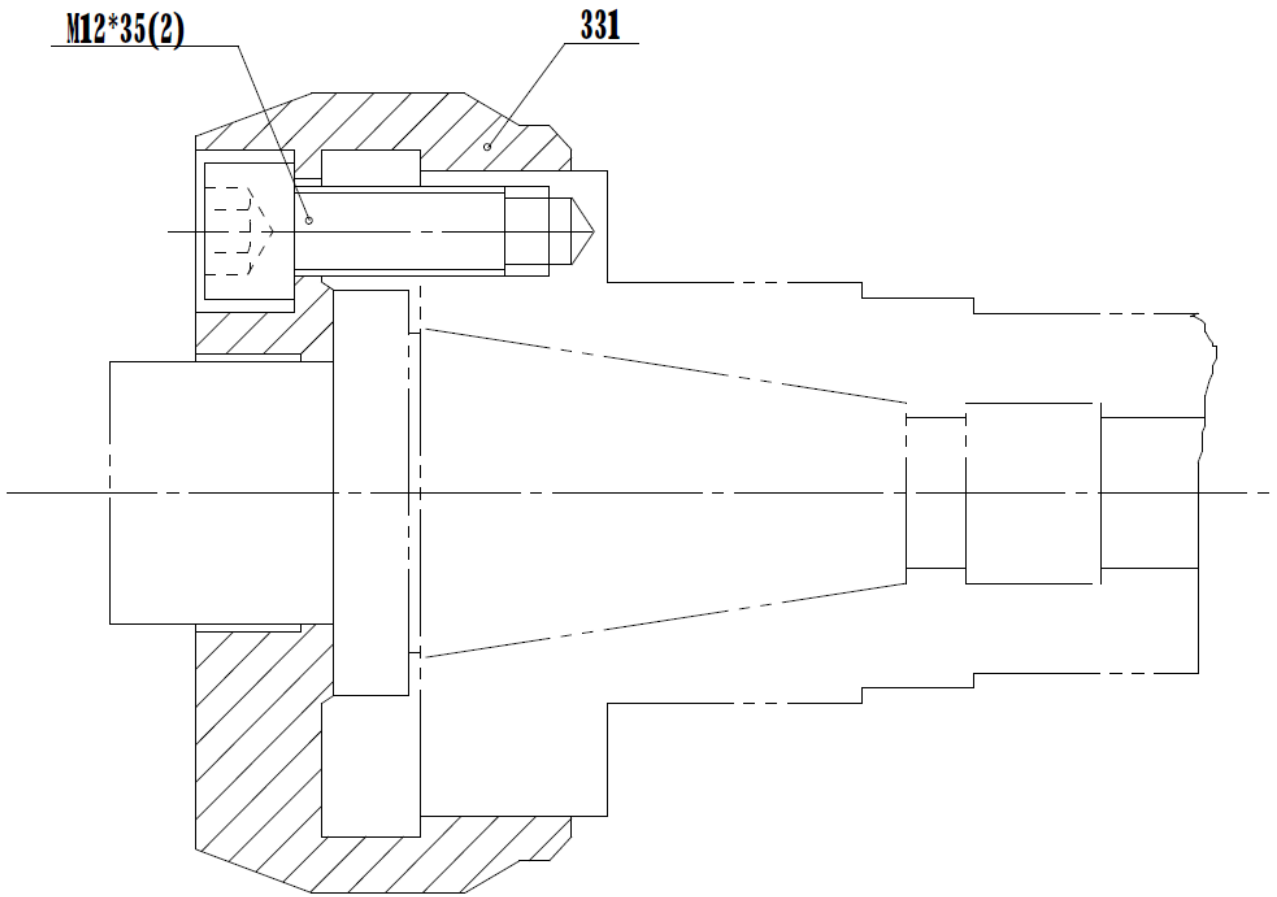


Fig.28

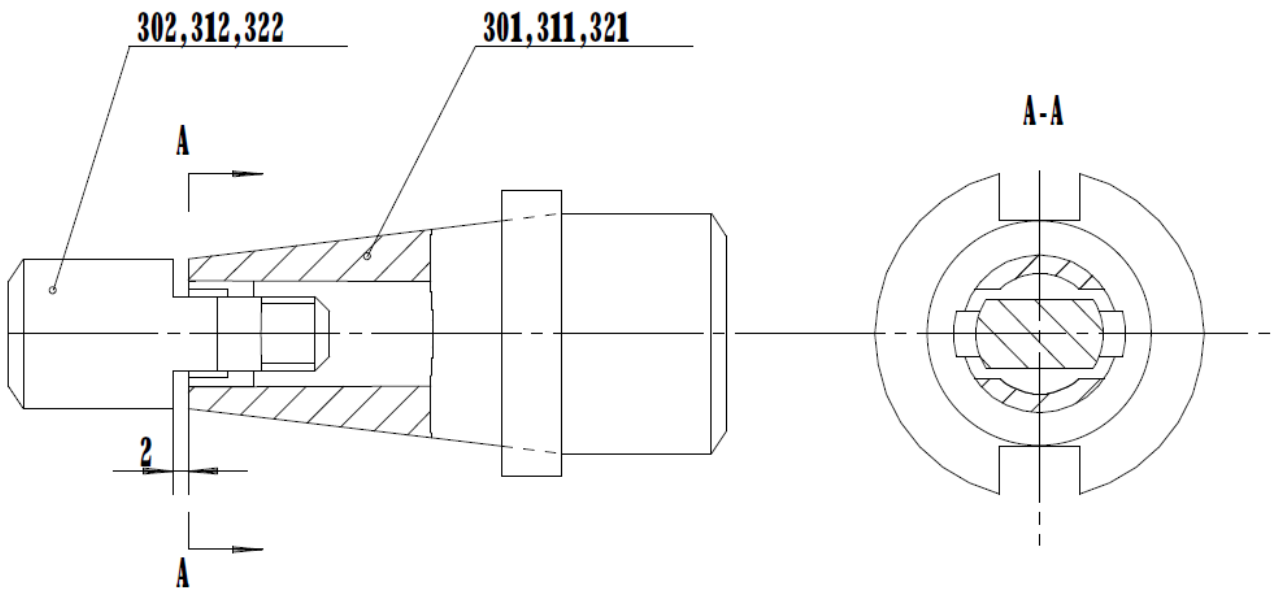


Fig.29

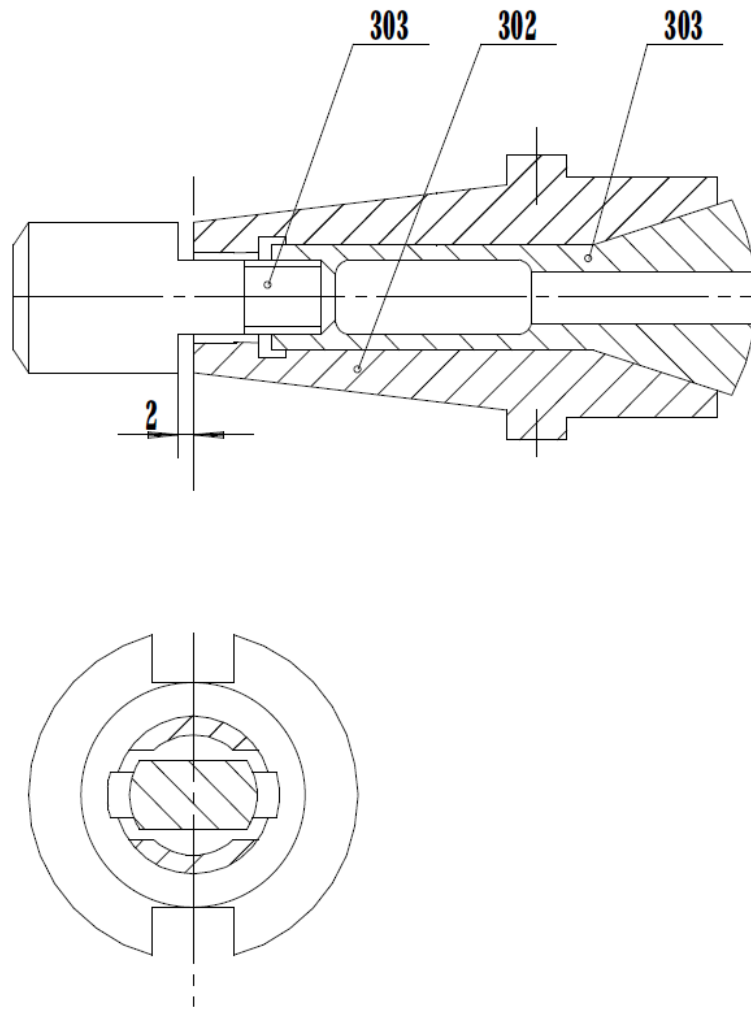


Fig.30

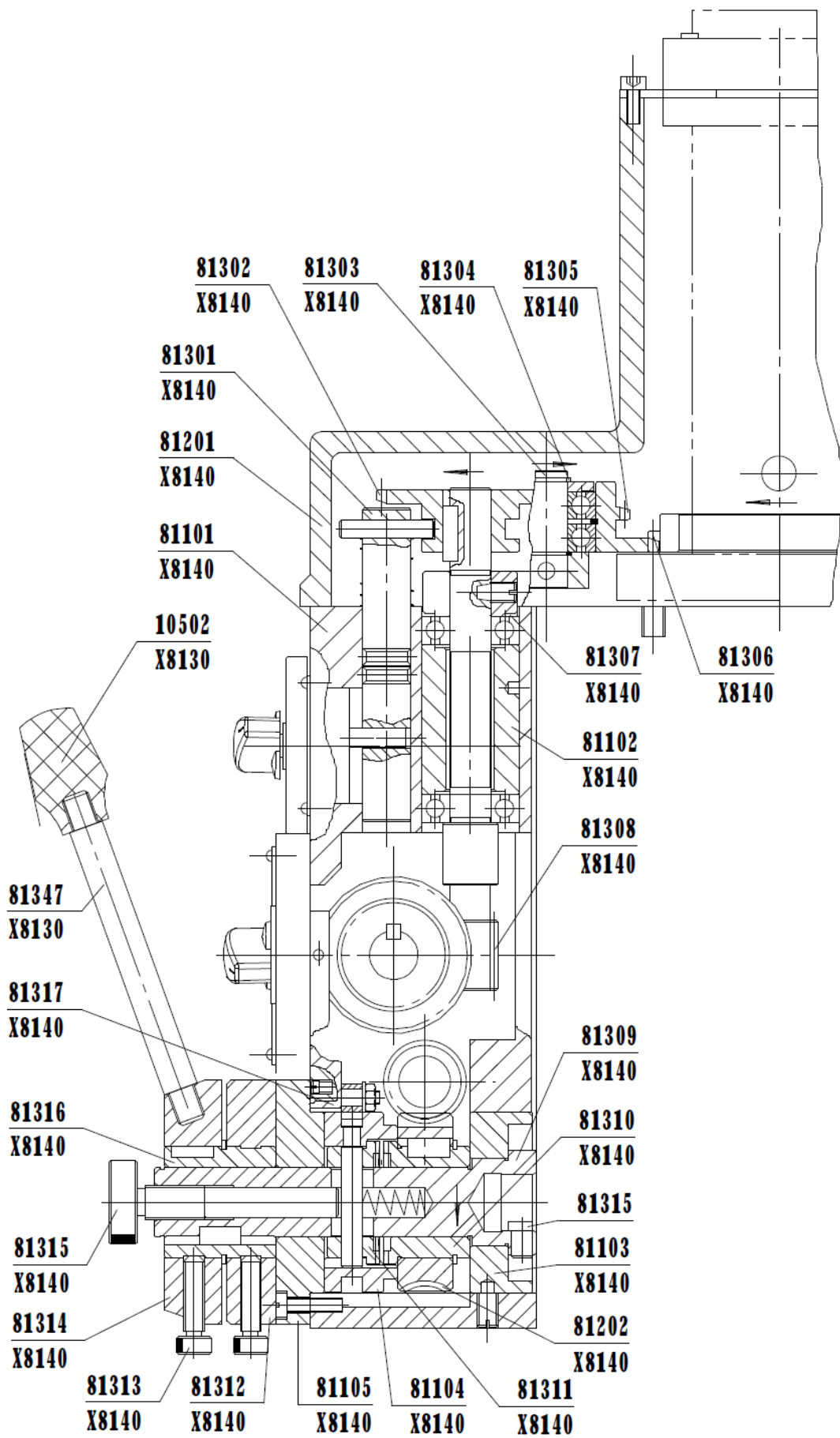
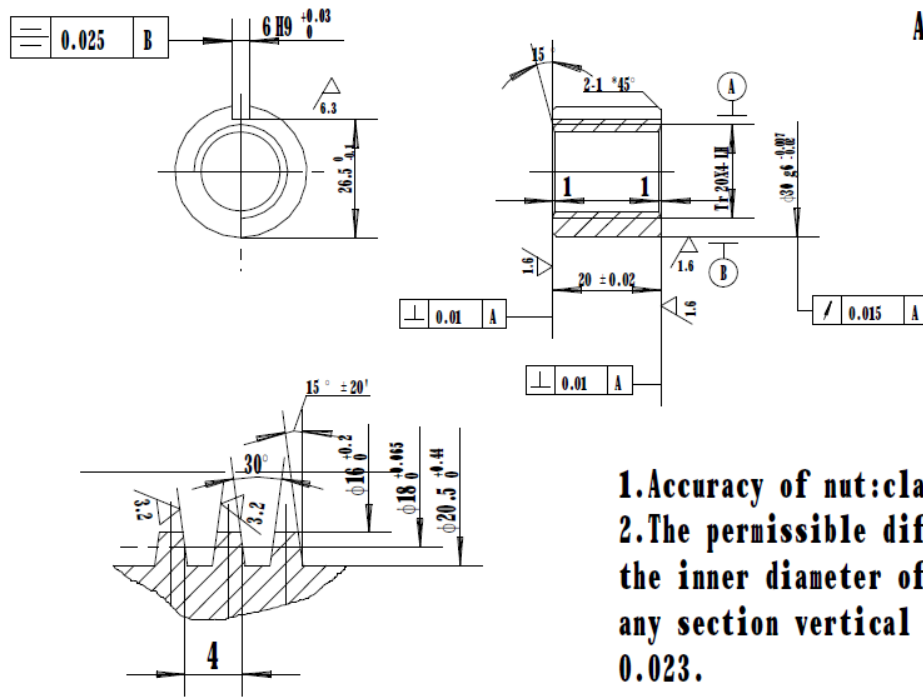


Fig. 31

Parts subject to wear

No.	Drawing No.	Description	Qty	Material
1	10106	Cross traverse	2	ZQSn6-6-3
2	10304	Lock nut	4	45
3	10502	Handle end	9	Urea-formaldehyde plastics
4	11201	Oiliness bearing	2	Fe-1.5C
5	11329	Clutch body	1	GCr15
6	11341	roller	6	GCr15
7	20109	Elevating nut	1	ZQSn6-6-3
8	20116	Shift fork	1	MTCrCu200
9	XE32-20116	Longitudinal nut	2	MTCrCu200
10	20201	bearing	1	ZQSn6-6-3
11	20373	pin	1	45
12	40105	Shift fork	2	ZG15
13	40106	Shift fork	2	ZG15

Surface finish not
marked $\sqrt{12.5}$
Acute edges rounded



1. Accuracy of nut: class 7.
2. The permissible difference of the inner diameter of the nut at any section vertical to its axis 0.023.

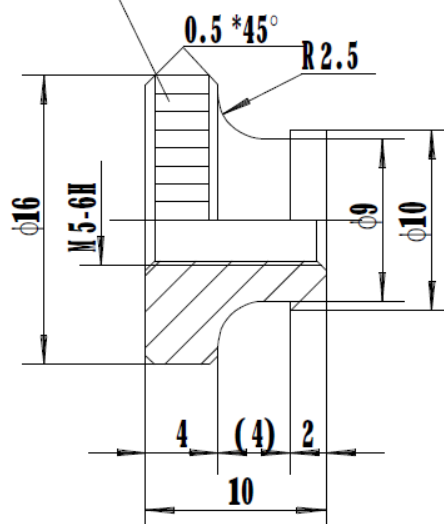
Drawing no. 10106

Name: Cross traverse nut

Material: ZQSn6-6-3

$\sqrt{3.2}$ Chromium
plating

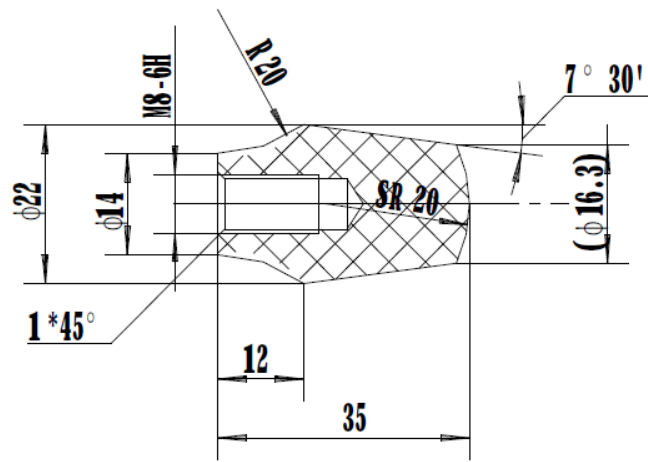
Straight knurling



Drawing no. 10304

Name: lock nut

Material: 45

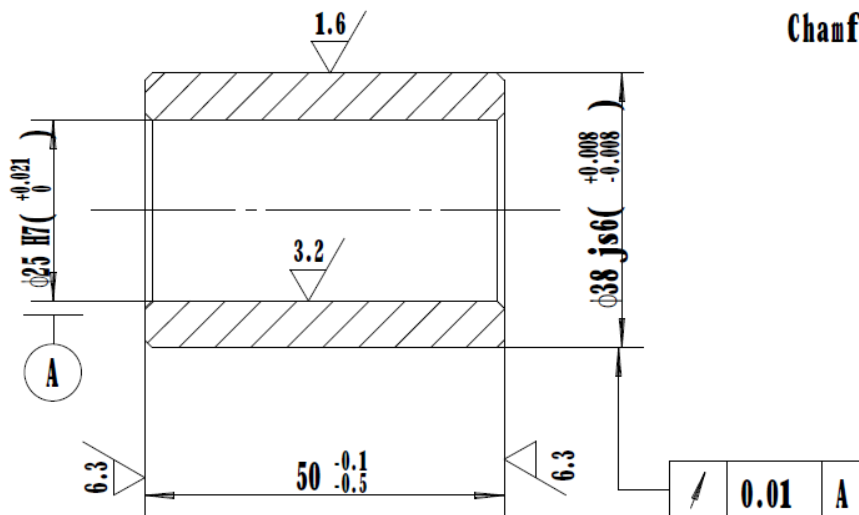


Drawing no. 10502

Name: Handle end

Material: Urea-formaldehyde plastics

Surface finish not marked $\sqrt{12.5}$
Chamfered 1X45°

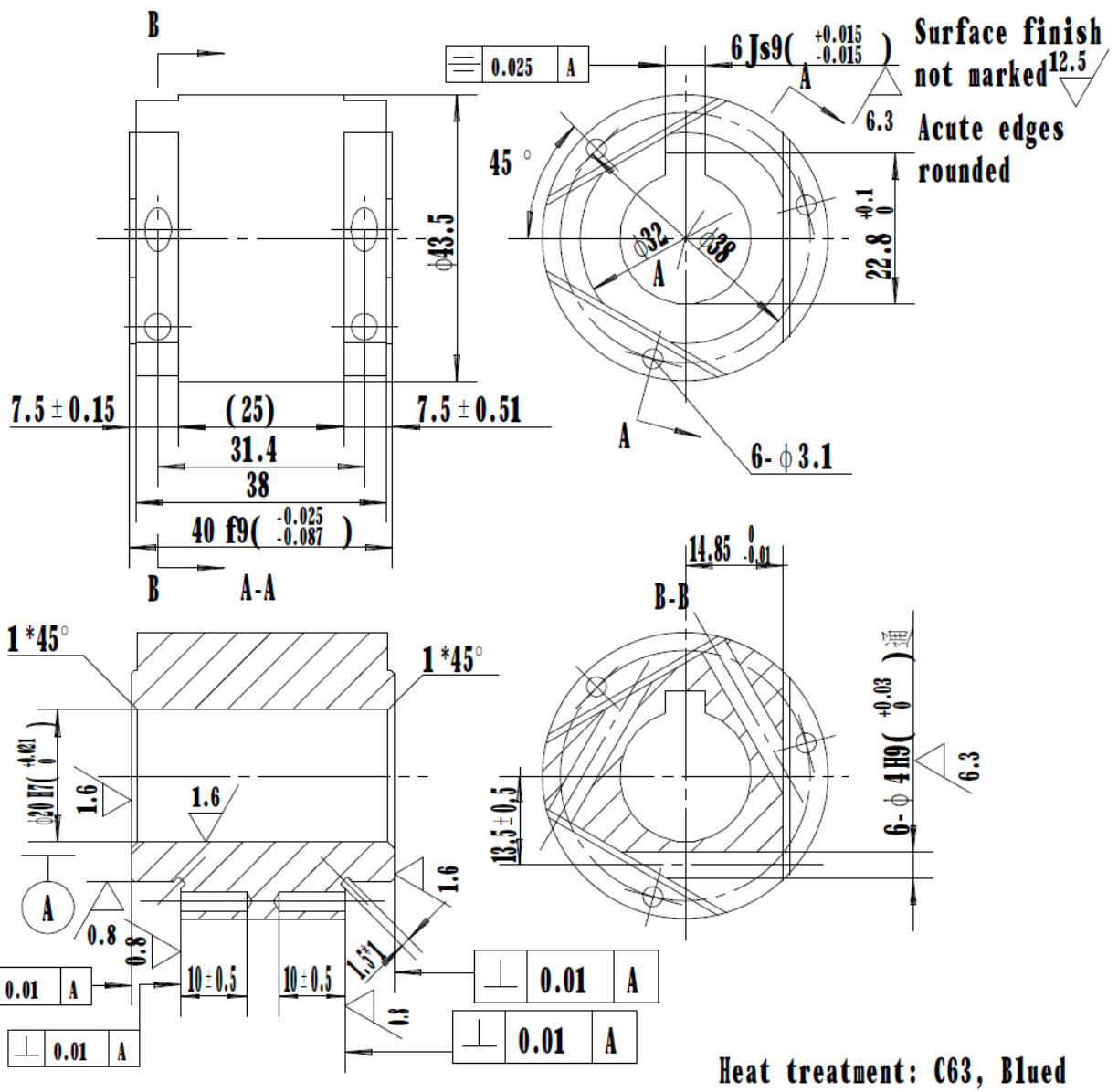


Dip in No.20 machine oil for 24 hours before assembly

Drawing no. 11201

Name: Oilless bearing

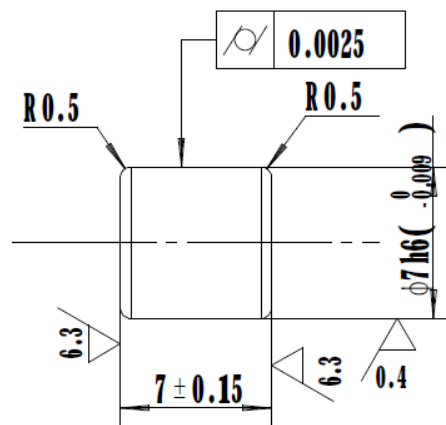
Material: Fe-1.5c



Drawing no. 11329

Name: Clutch body

Material: GCr15

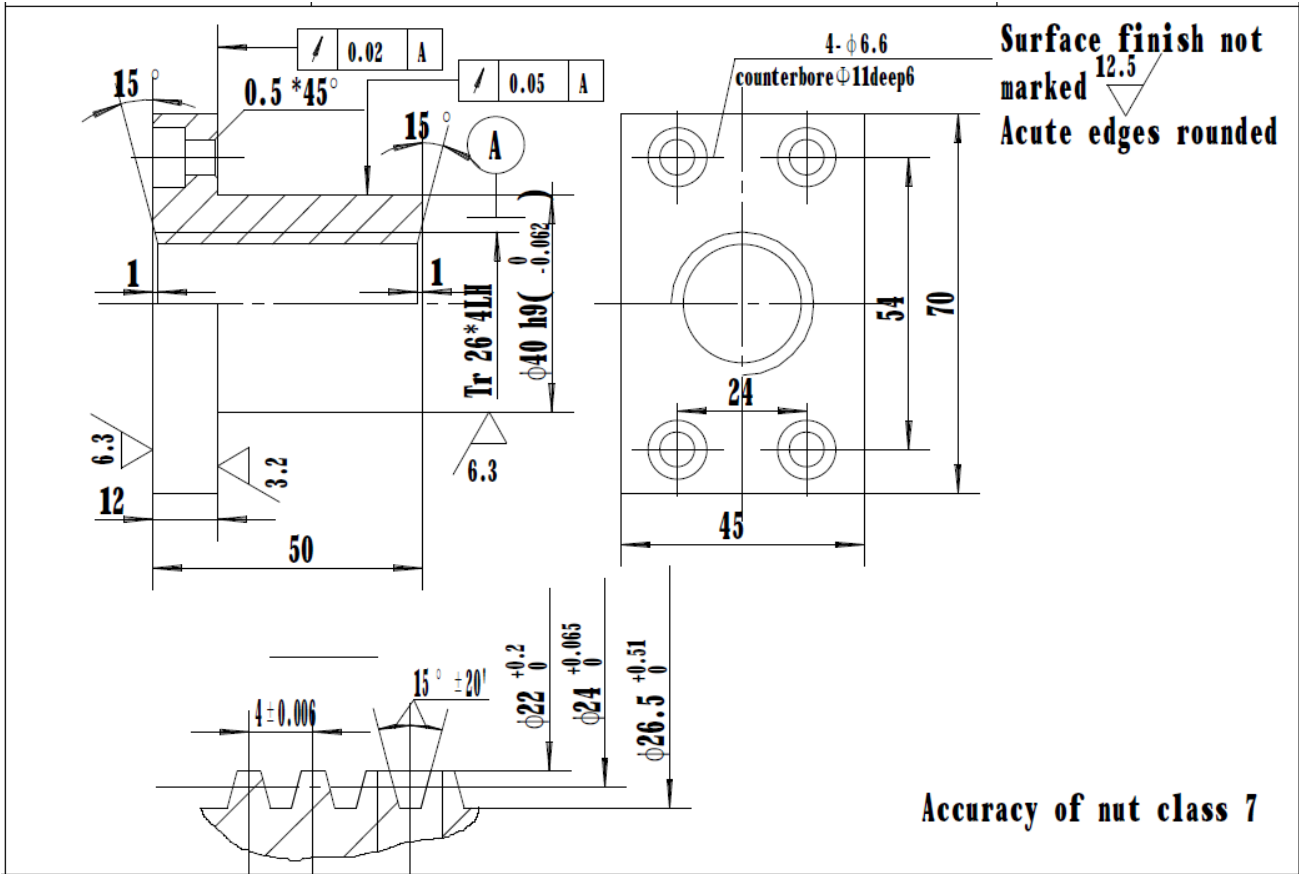


Heat treatment: C58

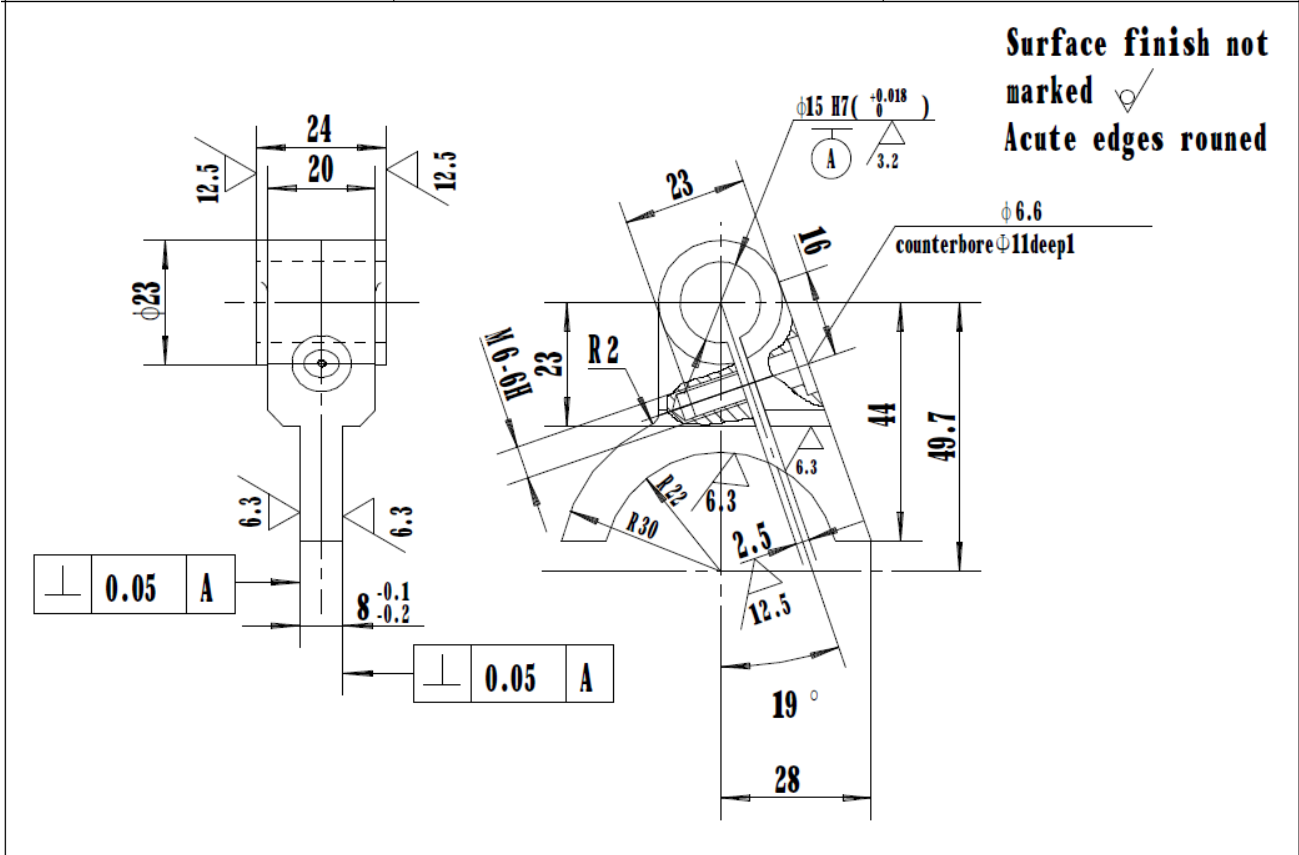
Drawing no. 11341

Name: Roller

Material: GCr15

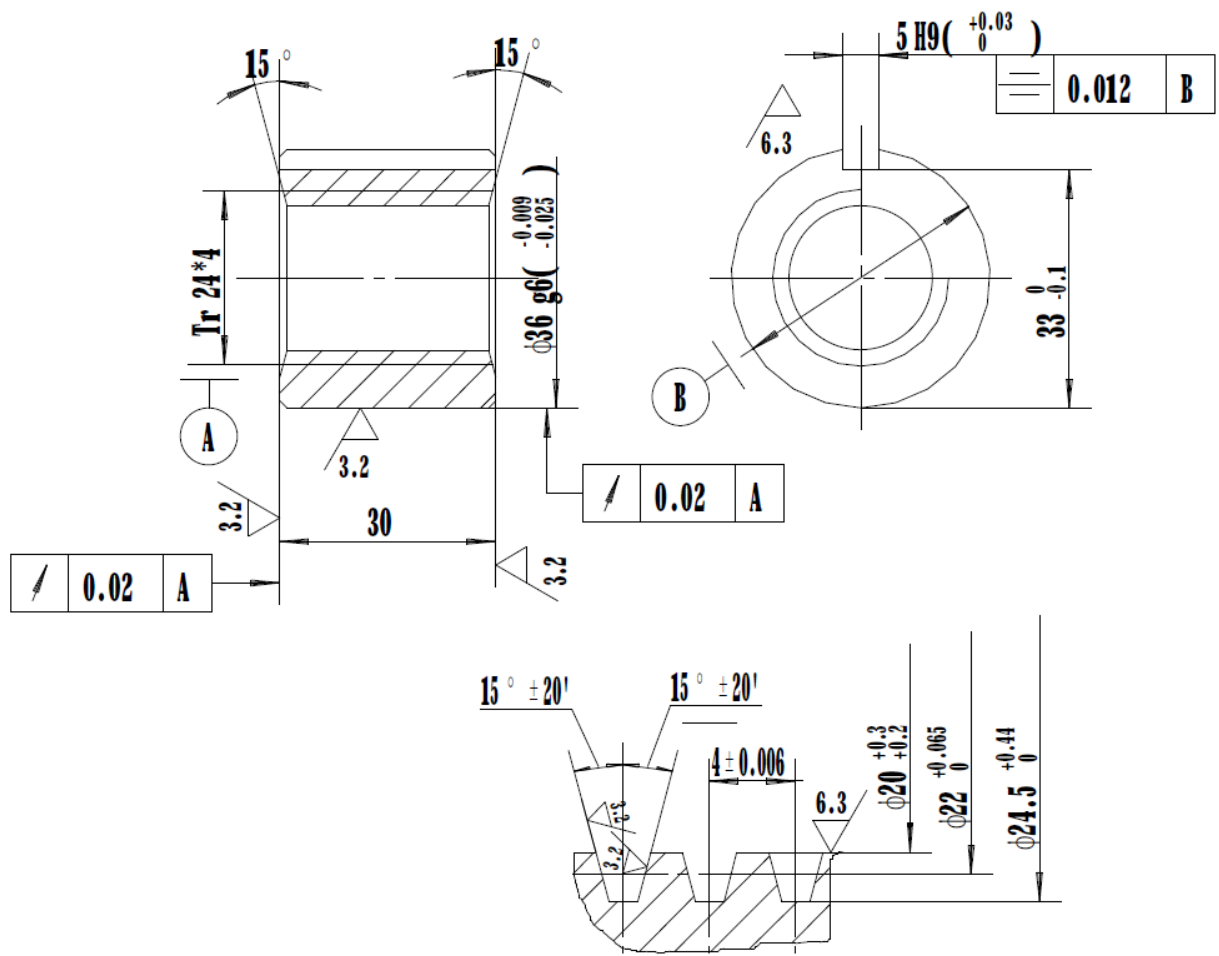


Drawing No. 20109	Name: Elevating nut	Material: ZA30-C
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Drawing No. 20116	Name: Shift fork	Material: MTCrCu200
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Surface finish not marked $\sqrt{12.5}$
 Chamfered

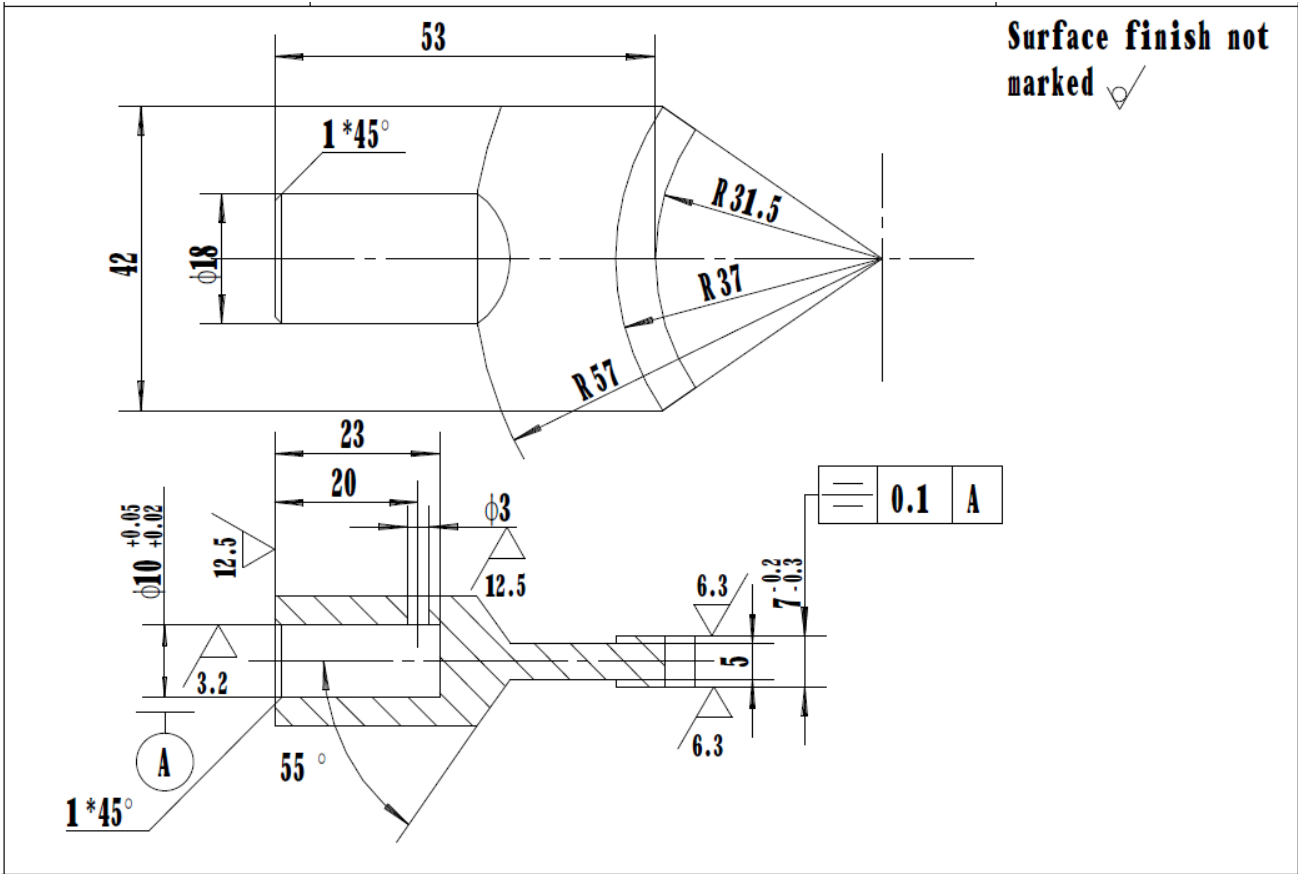


Accuracy of nut: class 7

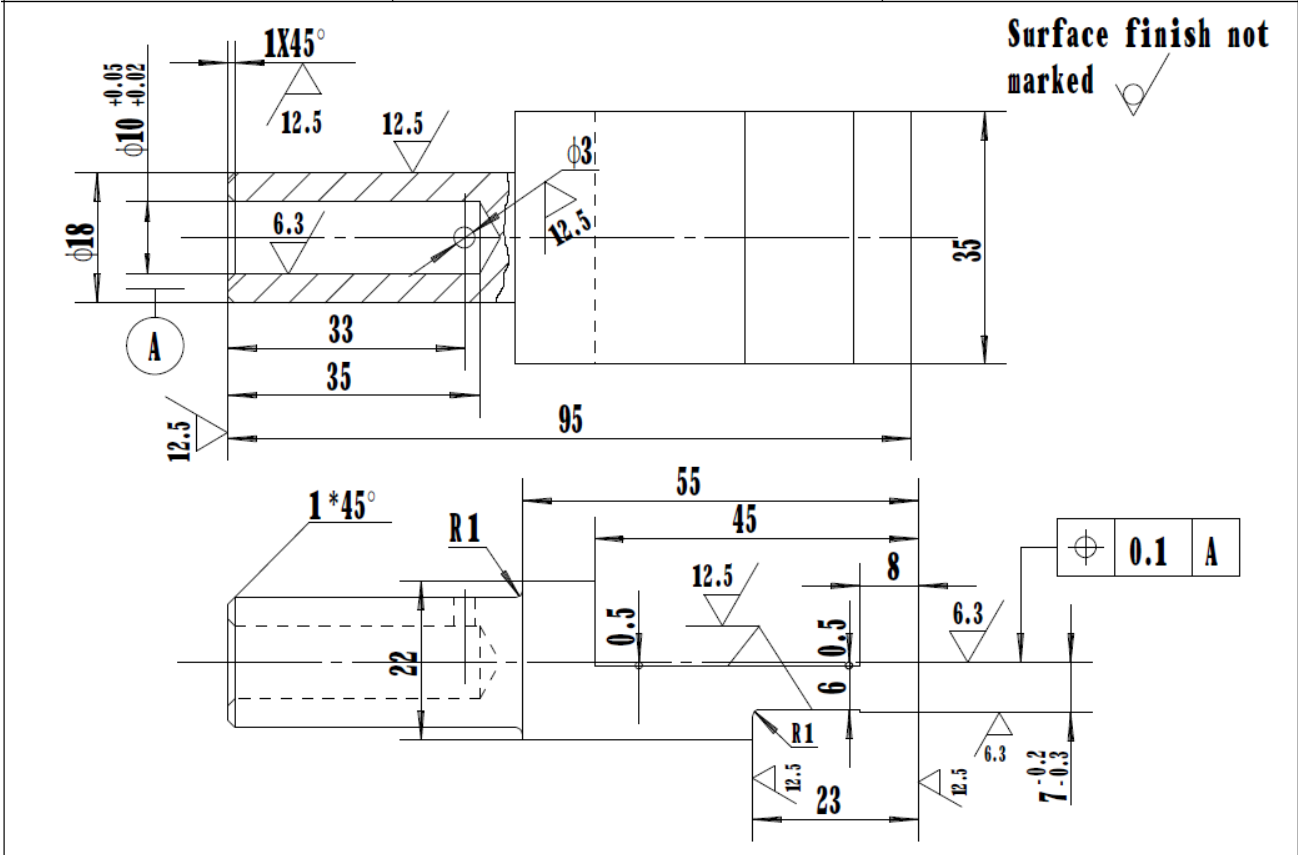
Drawing no. XE32-20116

Name: Longitudinal nut

Material: MTCrCu200



Drawing No. 40105	Name: Shift fork	Material: ZG45
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Drawing No. 40106	Name: Shift fork	Material: ZG45
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