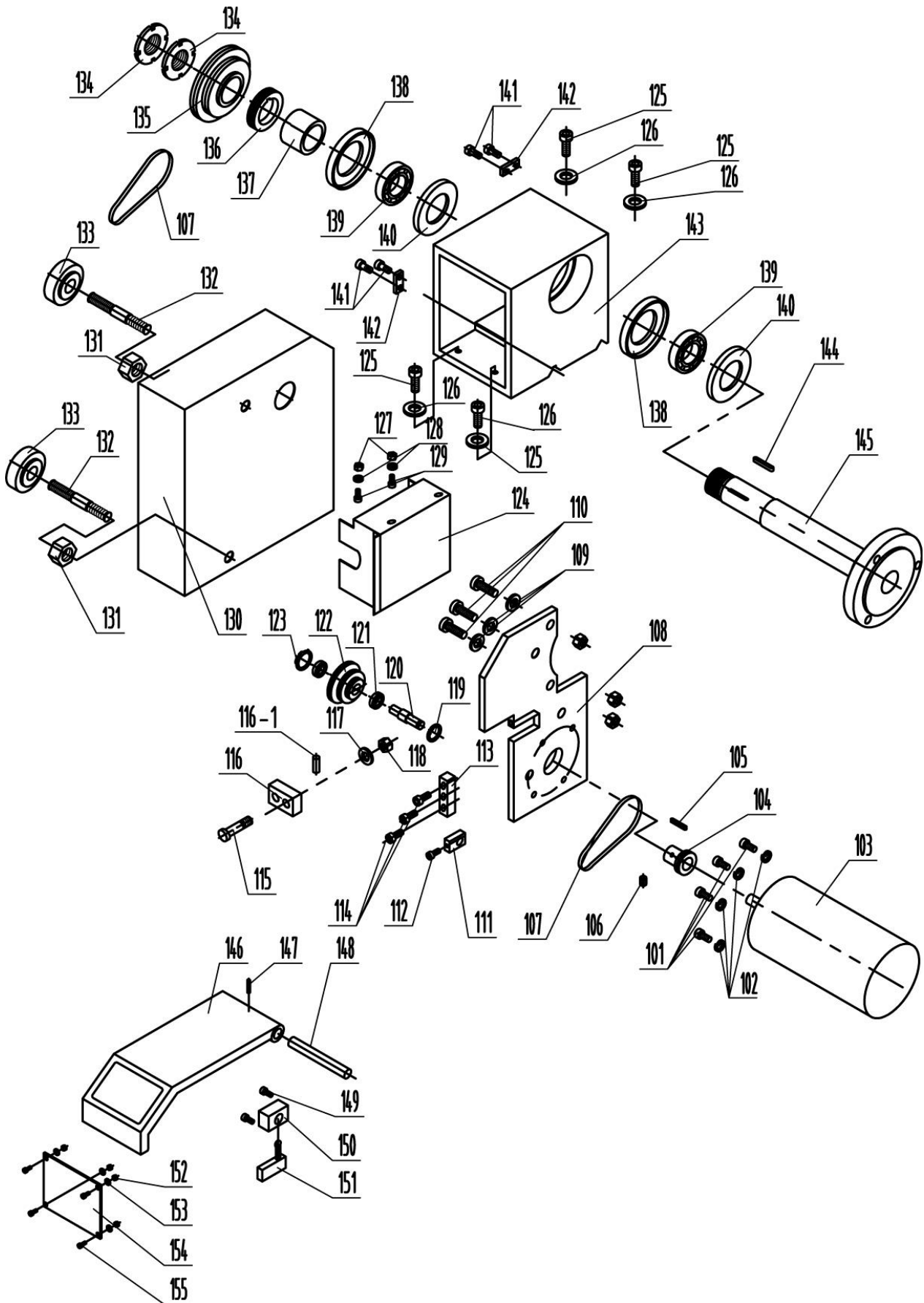


15.0 Replacement Parts

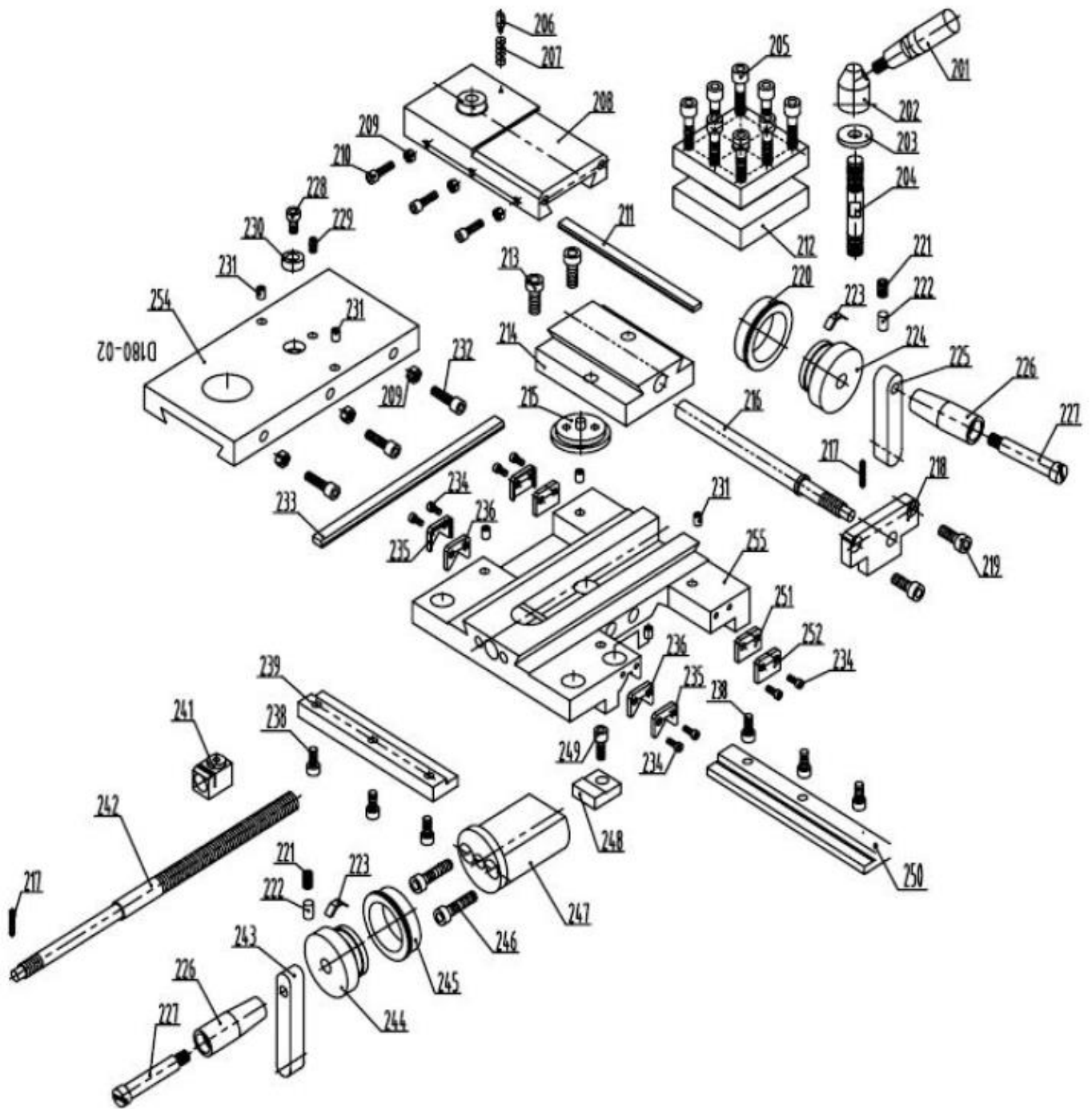
BD-8VS Assembly Breakdown -1



BD-8VS Parts List for Breakdown -1

| Index No. | Part No. | Description | Size | Qty. |
|-----------|--------------|---|-------------------|------|
| 101 | BD7VS-1 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M5x25 | 4 |
| 102 | BD7VS-2 | SPLIT WASHER DIN 127 | 5 | 4 |
| 103 | BD7VS-103 | D.C.MOTOR | | 1 |
| | BD7VS-103B | Brush for D.C MOTOR (not shown) | | 2 |
| 104 | BD7VS-104 | V-BELT PULLEY ENGINE | | 1 |
| 105 | BD7VS-3 | FEATHER KEY | DIN 6885-A4x4x20 | 1 |
| 106 | BD7VS-4 | SET SCREW DIN 915 | M6x8 | 1 |
| 107 | BD7VS-107 | SYNCHRONOUS BELT | Gates 5M-365 | 2 |
| 108 | BD7VS-108 | SUPPORTING PLATE | | 1 |
| 109 | BD7VS-5 | DISK | 8 | 3 |
| 110 | BD7VS-6 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M8x20 | 3 |
| 111 | BD7VS-111 | SLIDING PAD | | 1 |
| 112 | BD7VS-7 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M6x30 | 1 |
| 113 | BD7VS-113 | THRUST BEARING | | 1 |
| 114 | BD7VS-8 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M6x20 | 2 |
| 115 | BD7VS-115 | AXIS | | 1 |
| 116 | BD7VS-116 | BEARING BLOCK-INTER-MEDIATE WHEEL | | 1 |
| 116- 1 | BD7VS-9 | ALIGNMENT PIN | 4x22 | 1 |
| 117 | BD7VS-10 | DISK | 8 | 1 |
| 118 | BD7VS-11 | HEXAGON NUT | M8 | 3 |
| 119 | BD7VS-12 | LOCKING RING | DIN 471-8 x0.8 | 1 |
| 120 | BD7VS-120 | COUNTERSHAFT | | 1 |
| 121 | BD7VS-121 | DEEP GROOVE BALL BEARING | 608-RZ | 2 |
| 122 | BD7VS-122 | PULLEY COUNTERSHAFT | | 1 |
| 123 | BD7VS-13 | LOCKING RING | DIN 471-22x1 | 1 |
| 124 | BD7VS-124 | BOTTOM COVER | | 1 |
| 125 | BD7VS-14 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M8x25 | 4 |
| 126 | BD7VS-15 | DISK | 8 | 4 |
| 127 | BD7VS-16 | NUT. M5 | 2 | |
| 128 | BD7VS-17 | DISK | 5 | 2 |
| 129 | BD7VS-18 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M8x25 | 2 |
| 130 | BD7VS-130 | PROTECTIVE COVER CHANGE GEAR WHEELS | | 1 |
| 131 | BD7VS-19 | NUT. M10 | 2 | |
| 132 | BD7VS-132 | THREADED BOLT | M10x80 | 2 |
| 133 | BD7VS-20 | KNURLED NUT | M10 | 2 |
| 134 | BD7VS-134 | GROOVE NUT | DIN 1804- M27x1-w | 2 |
| 135 | BD7VS-135 | DRIVE PULLEY | | 1 |
| 136 | BD7VS-136 | TOOTHED WHEEL | (Z=40) | 1 |
| 137 | BD7VS-137 | CONTACT PRESSURE SLEEVE/COLLET | | 1 |
| 138 | BD7VS-138 | BEARING COVER | | 2 |
| 139 | BD7VS-139 | TAPERED ROLLER BEARING | 30206/P5 | 2 |
| 140 | BD7VS-140 | BEARING COVER | | 2 |
| 141 | BD7VS-21 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M4x10 | 4 |
| 142 | BD7VS-142 | FIXING PLATE PROTECTIVE COVER CHANGE WHEELS | | 2 |
| 143 | BD7VS-143 | HOUSING HEADSTOCK | | 1 |
| 144 | BD7VS-22 | FEATHER KEY | DIN 6885-A3x3x15 | 1 |
| 145 | BD7VS-145 | SPINDLE | | 1 |
| 146 | BD7VS-146 | CHUCK GUARD | | 1 |
| 147 | GB87986-3-20 | ROLL PIN | 3 x 20 mm | 1 |
| 148 | BD7VS-148 | SHAFT | | 1 |
| 149 | GB7085-5-12 | SOCKET HD SCREW | M5 x 12 mm | 2 |
| 150 | BD7VS-150 | BRACKET | | 1 |
| 151 | BD7VS-151 | MICRO SWITCH | | 1 |
| 152 | GB617286-4 | HEX NUT (THIN) | M4 | 4 |
| 153 | GB97185-4 | WASHER | 4 | 4 |
| 154 | BD7VS-154 | ARCRYLIC GLASS | | 1 |
| 155 | GB7085-4-10 | SOCKET HD SCREW | M4 x 10 mm | 4 |

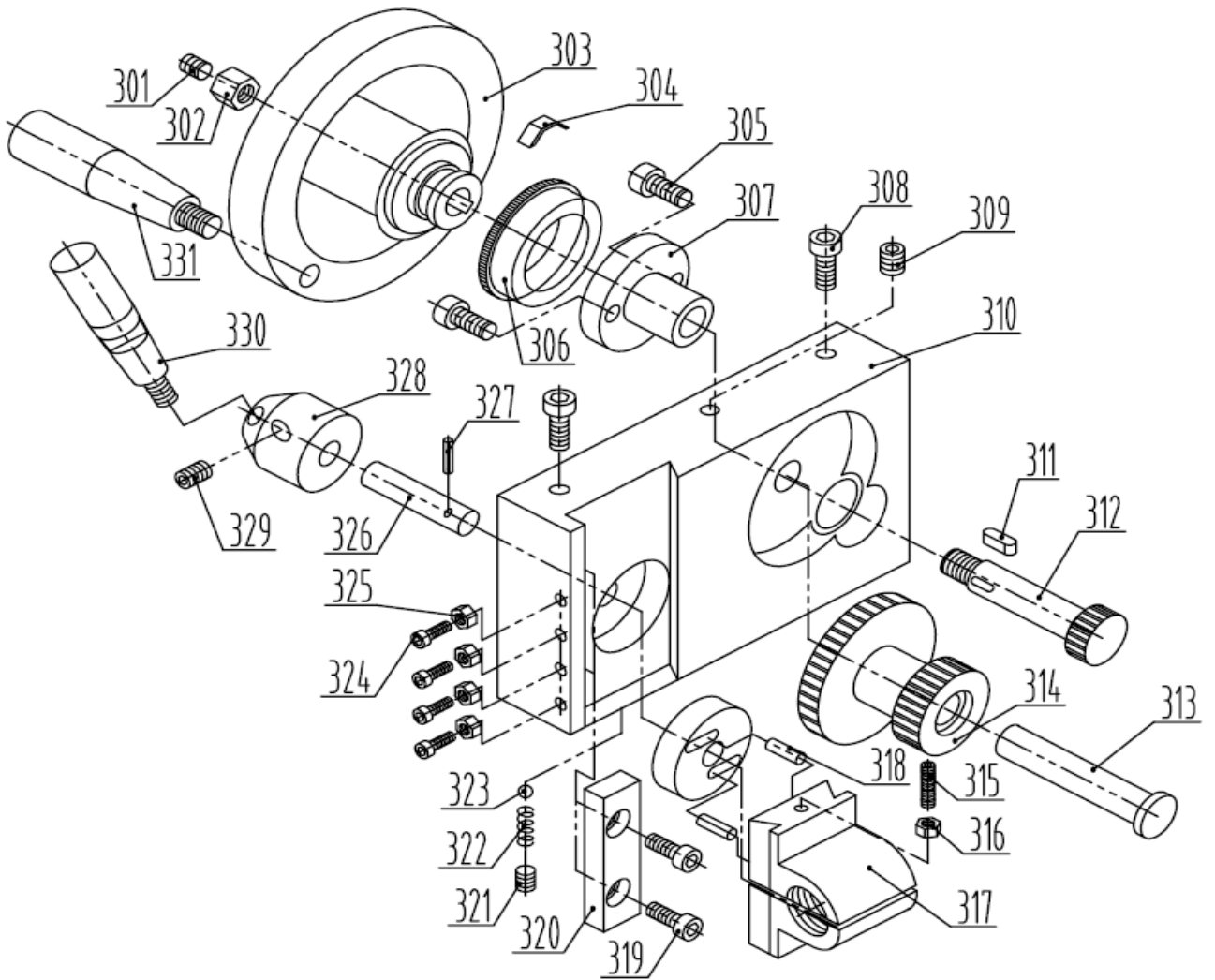
BD-8VS Assembly Breakdown -2



BD-8VS Parts List for Breakdown -2

| Index No. | Part No. | Description | Size | Qty. |
|-----------|-----------|--|-----------|------|
| 201 | BD7VS-201 | HANDLE | | 1. |
| 202 | BD7VS-202 | TIGHTENING NUT QUADRUPLICATE TOOL HOLDER | | 1 |
| 203 | BD7VS-203 | WASHER QUADRUPLICATE TOOL HOLDER | | 1. |
| 204 | BD7VS-204 | THREADED BOLT QUADRUPLICATE TOOL HOLDER | | 1 |
| 205 | BD7VS-23 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M6x25 | 8. |
| 206 | BD7VS-206 | STOP BOLT TOOL HOLDER | | 1. |
| 207 | BD7VS-207 | SPRING | ø5xø10xø1 | 1. |
| 208 | BD7VS-208 | TOP SLIDE | | 1. |
| 209 | BD7VS-24 | HEXAGON NUT | M4 | 1. |
| 210 | BD7VS-25 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M4x14 | 3. |
| 211 | BD7VS-211 | ADJUSTING GIB | | 1. |
| 212 | BD7VS-212 | QUADRUPLICATE TOOL HOLDER | | 1. |
| 213 | BD7VS-26 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M5x30 | 2. |
| 214 | BD7VS-214 | DOVETAIL GUIDE TOP SLIDE | | 1. |
| 215 | BD7VS-215 | SWIVEL TOP SLIDE | | 1. |
| 216 | BD7VS-216 | SPINDLE TOP SLIDE | | 1. |
| 217 | BD7VS-27 | DOWEL PIN | 3x12 | 2. |
| 218 | BD7VS-218 | BEARING BLOCK SPIN-DLE TOP SLIDE | | 1. |
| 219 | BD7VS-28 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M5x12 | 2. |
| 220 | BD7VS-220 | GRADUATED COLLAR HANDWHEEL TOP SLIDE | | 1. |
| 221 | BD7VS-29 | SET SCREW DIN 915 | M6x6 | 2. |
| 222 | BD7VS-222 | PIN | | 2 |
| 223 | BD7VS-30 | SPRING STEEL SHEET | | 2. |
| 224 | BD7VS-224 | GUIDING DISK GRADUATED COLLAR TOP SLIDE | | 2. |
| 225 | BD7VS-225 | LEVER TOP SLIDE | | 1. |
| 226 | BD7VS-226 | GRIP COLLAR | | 2. |
| 227 | BD7VS-227 | FIXING SCREW GRIP COL-LAR | | 2. |
| 228 | BD7VS-31 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M4x8 | 1. |
| 229 | BD7VS-32 | SET SCREW DIN 914 | M5x10 | 1. |
| 230 | BD7VS-230 | COLLAR | | 1. |
| 231 | BD7VS-33 | OILER | D6mm | 6 |
| 232 | BD7VS-34 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M4x20 | 3. |
| 233 | BD7VS-233 | ADJUSTING GIB COM-POUND SLIDE | | 1. |
| 234 | BD7VS-35 | TALLOW-DROP SCREW | M3x8 | 8. |
| 235 | BD7VS-235 | HANDLE FRONT STRIPPER | | 2. |
| 236 | BD7VS-236 | FRONT STRIPPER | | 2. |
| 238 | BD7VS-36 | HEXAGON SOCKET SCREW DIN 912 | M5x10 | 3. |
| 239 | BD7VS-239 | FASTENING GIB FRONT LATHE SADDLE | | 1. |
| 241 | BD7VS-241 | SPINDLE NUT COMPOUND SLIDE | | 1. |
| 242 | BD7VS-242 | SPINDLE COMPOUND SLIDE | | 1. |
| 243 | BD7VS-243 | LEVER COMPOUND SLIDE | | 1. |
| 244 | BD7VS-244 | GUIDE DISK GRADUATED COLLAR | | 1. |
| 245 | BD7VS-245 | GRADUATED COLLAR COMPOUND SLIDE | | 1. |
| 246 | BD7VS-37 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M6x50 | 2. |
| 247 | BD7VS-247 | BEARING BLOCK SPIN-DLE COMPOUND SLIDE | | 1. |
| 248 | BD7VS-248 | CLAMPING PLATE LATHE SLIDE | | 1. |
| 249 | BD7VS-38 | HEXAGON SOCKET SCREW DIN 912 | M8x25 | 1. |
| 250 | BD7VS-250 | FIXING GIB REAR LATHE SLIDE | | 1. |
| 251 | BD7VS-251 | REAR STRIPPER | | 2. |
| 252 | BD7VS-252 | HANDLE REARD STRIPPER | | 2. |
| 254 | BD7VS-254 | COMPOUND SLIDE | | 1. |
| 255 | BD7VS-255 | DOVETAIL GUIDE COM-POUND SLIDE | | 1. |

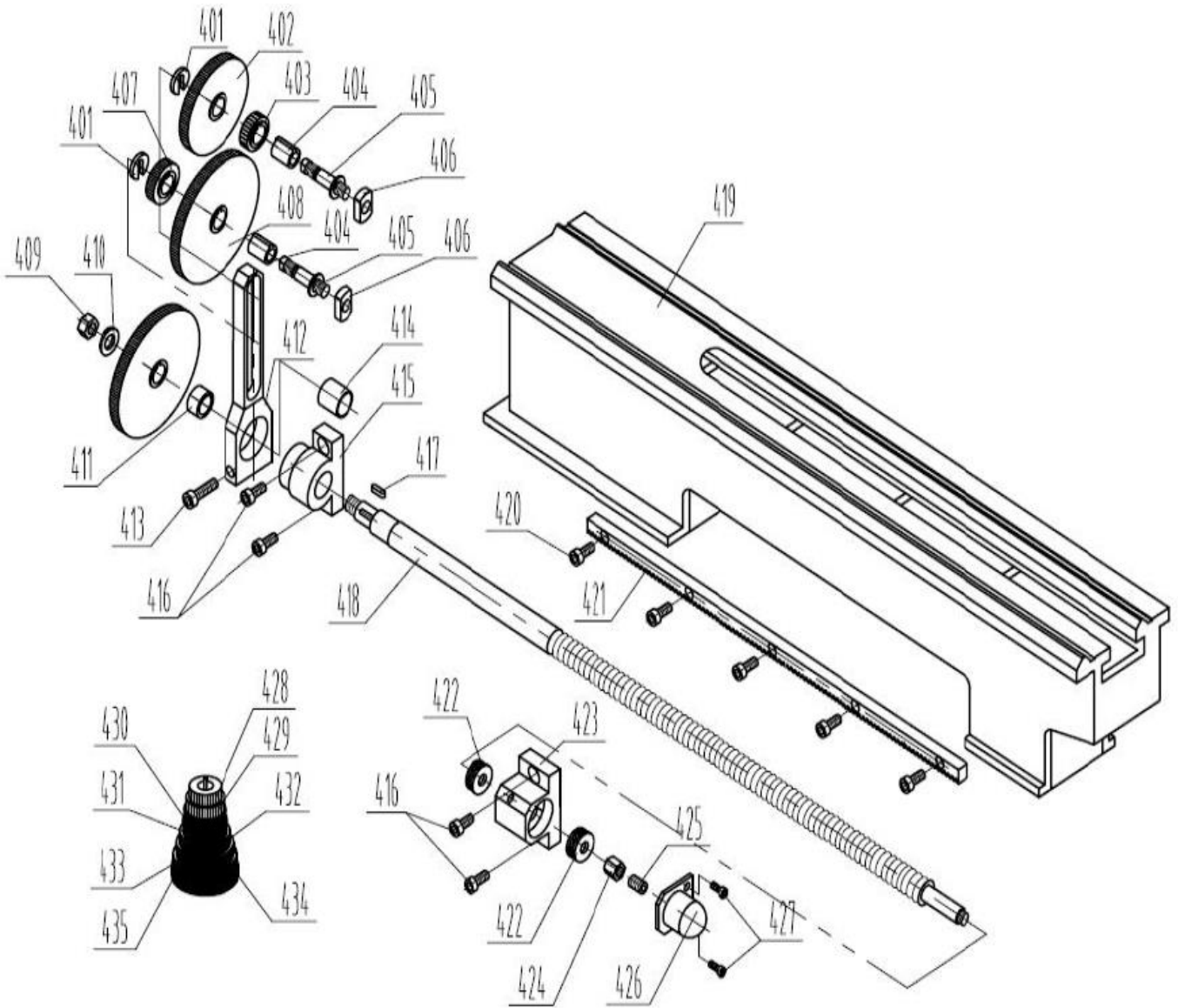
BD-8VS Assembly Breakdown -3



BD-8VS Parts List for Breakdown -3

| Index No. | Part No. | Description | Size | Qty. |
|-----------|-----------|--|-----------------|------|
| 301 | BD7VS-39 | SET SCREW DIN 914 | M8x8 | 1 |
| 302 | BD7VS-302 | FIXING NUT HANDWHEEL | M8, H=16mm | 1 |
| 303 | BD7VS-303 | HANDWHEEL LATHE SLIDE | | 1 |
| 304 | BD7VS-40 | SPRING PIECE | | 1 |
| 305 | BD7VS-41 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M5x10 | 2 |
| 306 | BD7VS-306 | GRADUATED COLLAR HANDWHEEL LATHE SLIDE | | 1 |
| 307 | BD7VS-307 | TRACK BED SHAFT HANDWHEEL LATHE SLIDE | | 1 |
| 308 | BD7VS-42 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M8x25 | 2 |
| 309 | BD7VS-43 | SET SCREW DIN 914 | M5x8 | 1 |
| 310 | BD7VS-310 | APRON | | 1 |
| 311 | BD7VS-44 | FEATHER KEY | DIN 6885-A3x3x8 | 1 |
| 312 | BD7VS-312 | SPLINE | Z=14, Module 1 | 1 |
| 313 | BD7VS-313 | SHAFT | | 1 |
| 314 | BD7VS-314 | GEAR SET 44/21 THEETH | Module 1 | 1 |
| 315 | BD7VS-45 | SET SCREW DIN 914 | M4x35 | 1 |
| 316 | BD7VS-46 | NUT. M4 | 1 | 1 |
| 317 | BD7VS-317 | LEADSCREW NUT | | 1 |
| 318 | BD7VS-47 | ALIGNMENT PIN | φ4x10 | 2 |
| 319 | BD7VS-48 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M4x10 | 2 |
| 320 | BD7VS-320 | READJUSTING GIB LEAD-SCREW NUT | | 1 |
| 321 | BD7VS-49 | SET SCREW DIN 913 | M6x8 | 1 |
| 322 | BD7VS-50 | SPRING | 0.6x3.5x12 | 1 |
| 323 | BD7VS-51 | STEEL BALL | 4.5 | 1 |
| 324 | BD7VS-52 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M4x12 | 4 |
| 325 | BD7VS-53 | NUT. M4 | 4 | 4 |
| 326 | BD7VS-326 | SHAFT | | 1 |
| 327 | BD7VS-54 | DOWEL PIN DIN 1481 | 3x30 | 1 |
| 328 | BD7VS-328 | TURNING KNOB ENGAGING LEVER | | 1 |
| 329 | BD7VS-55 | SET SCREW DIN 914 | M5x6 | 1 |
| 330 | BD7VS-330 | ENGAGING LEVER | | 1 |
| 331 | BD7VS-331 | GRIP HANDWHEEL LATHE SLIDE | | 1 |

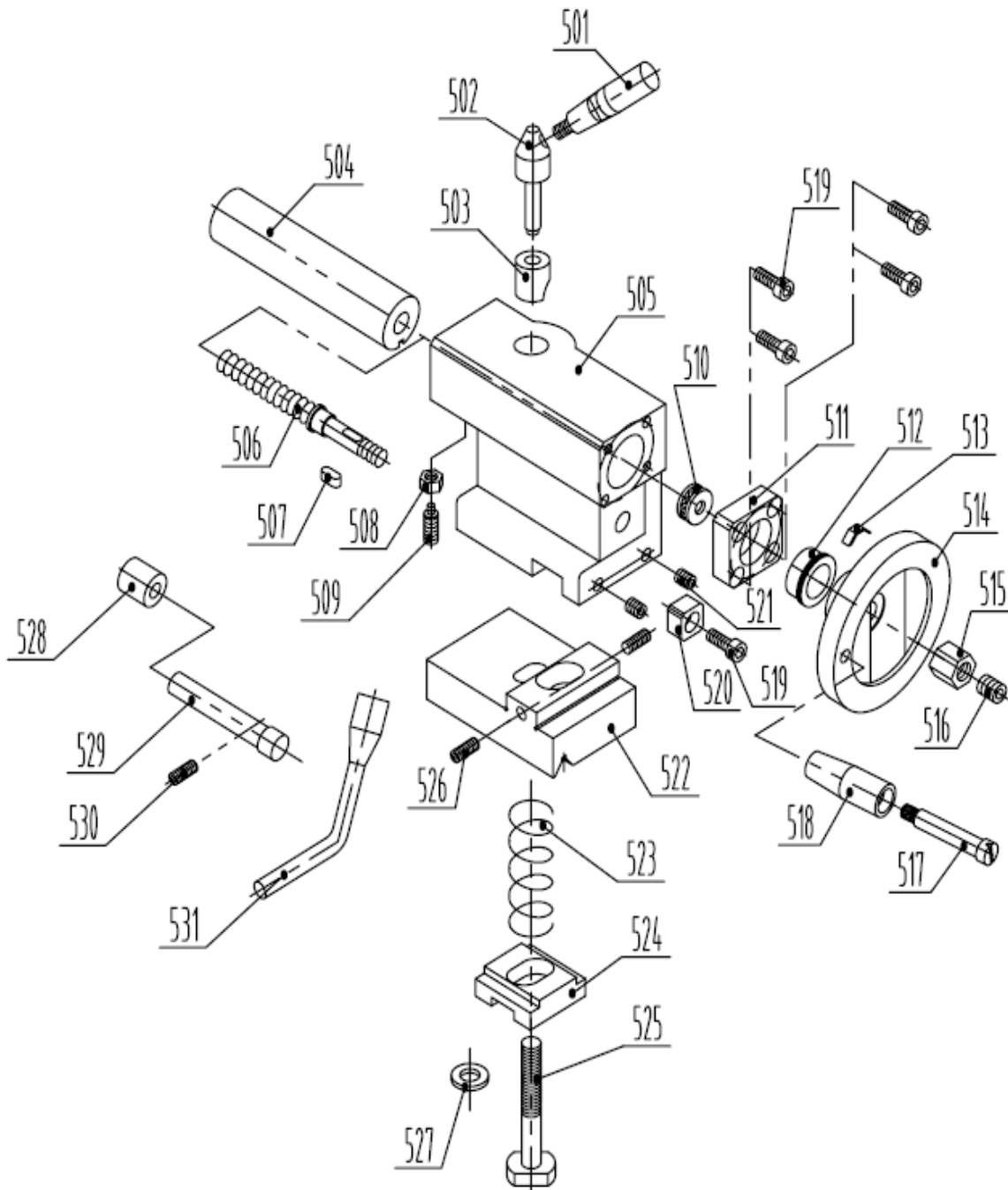
BD-8VS Assembly Breakdown -4



BD-8VS Parts List for Breakdown -4

| Index No. | Part No. | Description | Size | Qty. |
|--------------|-------------|---------------------------------------|------------------|------|
| 401 | BD7VS-401 | LOCKING WAHSER | | 2 |
| 402 | BD7VS-402 | TOOTHED WHEEL | Z=75 | 1 |
| 403 | BD7VS-403 | TOOTHED WHEEL | Z=30 | 1 |
| 404 | BD7VS-404 | COLLAR AXLE SHAFT | | 2 |
| 405 | BD7VS-405 | AXIE SHAFT | | 2 |
| 406 | BD7VS-406 | SLIDING BLOCK | M8 | 2 |
| 407 | BD7VS-407 | TOOLTHED WHEEL | Z=20 | 1 |
| 408 | BD7VS-408 | TOOLTHED WHEEL | Z=80 | 2 |
| 409 | BD7VS-56 | NUT. M10 | | 1 |
| 410 | BD7VS-57 | DISK 10 | | 1 |
| 411 | BD7VS-411 | COLLAR, SPREADER | | 1 |
| 412 | BD7VS-412 | CHNGE GEAR GIB | | 1 |
| 413 | BD7VS-58 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M6x35 | 1 |
| 414 | BD7VS-414 | SLIDE BEARING | | 1 |
| 415 | BD7VS-415 | LEFT BEARING BLOCK, LEADING SPINDLE | | 1 |
| 416 | BD7VS-59 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M6x14 | 4 |
| 417 | BD7VS-60 | FEATHER KEY | DIN 6885-A3x3x16 | 1 |
| 418 | BD7VS-418 | LEADING SPINDLE | | 1 |
| 419 | BD8VS-419 | ENGINE BED | | 1 |
| 420 | BD7VS-61 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M4x12 | 5 |
| 421 | BD7VS-421 | TOOTHED RACK | | 1 |
| 422 | BD7VS-422 | AXIAL DEEP GROOVE BALL BEARING | 51100 | 2 |
| 423 | BD7VS-423 | RIGHT BEARING BLOCK, LEADING SPINDLE | | 1 |
| 424 | BD7VS-424 | FIXING NUT LEADING SPINDLE | | 1 |
| 425 | BD7VS-62 | ADJUSTING SCREW SET SCREW DIN 915 | M8x6 | 1 |
| 426 | BD7VS-426 | PROTECTIVE COVER | | 1 |
| 427 | BD7VS-63 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M4x10 | 2 |
| 428 | BD8VS-428 | TOOTHED WHEEL | Z=30 | 1 |
| 429 | BD7VS-429 | TOOTHED WHEEL | Z=35 | 1 |
| 430 | BD7VS-430 | TOOTHED WHEEL | Z=40 | 1 |
| 431 | BD7VS-431 | TOOTHED WHEEL | Z=42 | 1 |
| 432 | BD7VS-432 | TOOTHED WHEEL | Z=50 | 1 |
| 433 | BD7VS-433 | TOOTHED WHEEL | Z=52 | 1 |
| 434 | BD7VS-434 | TOOTHED WHEEL | Z=60 | 1 |
| 435 | BD8VS-435 | TOOTHED WHEEL | Z=66 | 1 |

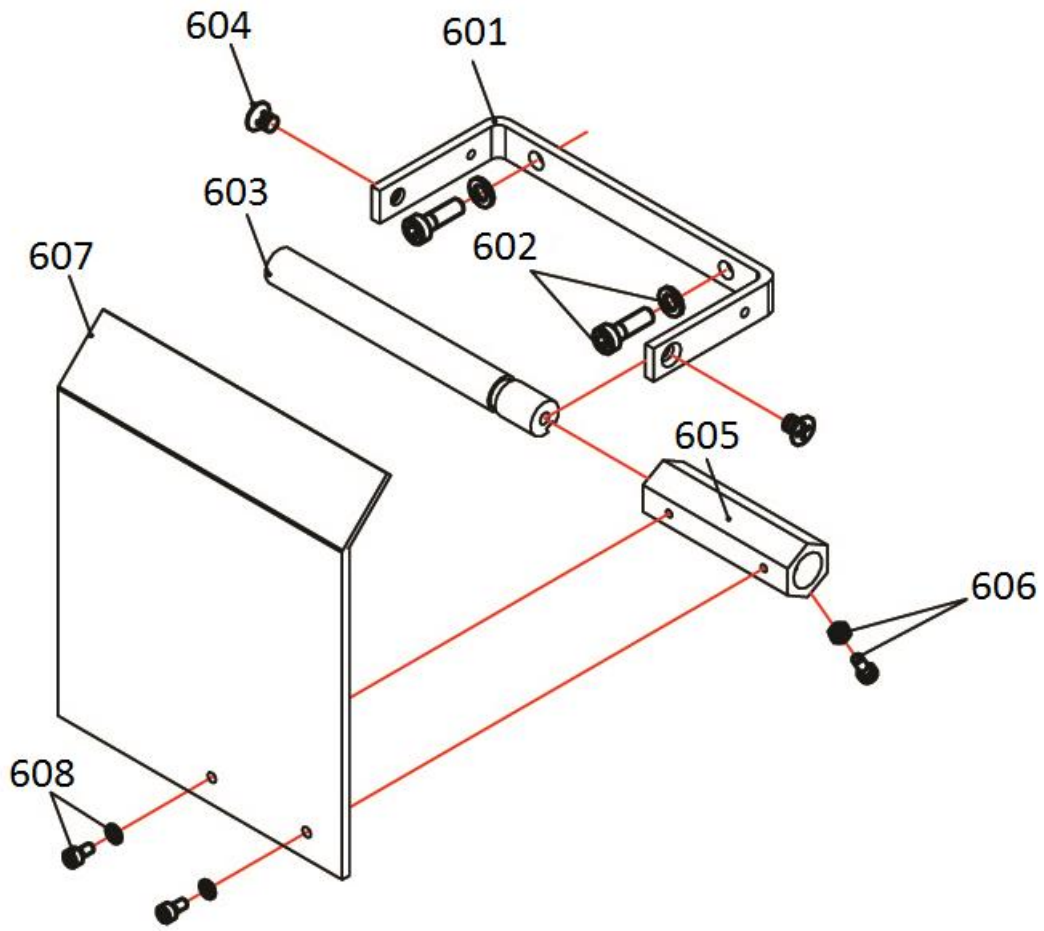
BD-8VS Assembly Breakdown -5



BD-8VS Parts List for Breakdown -5

| Index No. | Part No. | Description | Size | Qty. |
|-----------|-----------|---------------------------------------|-----------------|------|
| 501 | BD7VS-501 | CLAMPIND LEVER TAIL-STOCK | | 1 |
| 502 | BD7VS-502 | CLAMPING LEVER TAILSTOCK SLEEVE | | 1 |
| 503 | BD7VS-503 | SPLIT TAPER SOCKET TAILSTOCK SLEEVE | | 1 |
| 504 | BD7VS-504 | TAILSTOCK SLEEVE | | 1 |
| 505 | BD7VS-505 | TAILSTOCK HOUSING | | 1 |
| 506 | BD7VS-506 | TAILSTOCK SPINDLE | | 1 |
| 507 | BD7VS-64 | FEATHER KEY | DIN 6885-A3x3x8 | 1 |
| 508 | BD7VS-65 | NUT . M6 | .1 | |
| 509 | BD7VS-66 | SET SCREW DIN 915 | M6x14 | 1 |
| 510 | BD7VS-510 | AXIAL DEEP GROOVE BALL BEARING | 51100 | 1 |
| 511 | BD7VS-511 | BEARING BLOCK TAILSTOCK SPINDLE | | 1 |
| 512 | BD7VS-512 | GRADUATED COLLAR TAIL-STOCK | | 1 |
| 513 | BD7VS-67 | SPRING STEEL SHEET | | 1 |
| 514 | BD7VS-514 | HANDWHEEL TAILSTOCK | | 1 |
| 515 | BD7VS-515 | FIXING NUT HANDWHEEL | M8 H=16mm | 1 |
| 516 | BD7VS-68 | SET SCREW DIN 914 | M8x6 | 1 |
| 517 | BD7VS-517 | FIXING SCREW GRIP COL-LAR | | 1 |
| 518 | BD7VS-518 | GRIP COLLAR | | 1 |
| 519 | BD7VS-69 | HEXAGON SOCKET HEAD CAP SCREW DIN 912 | M5x12 | 5 |
| 520 | BD7VS-520 | STOP | .1 | |
| 521 | BD7VS-70 | SET SCREW DIN 915 | M6x12 | 2 |
| 522 | BD7VS-522 | TAILSTOCK BOTTOM PART | | 1 |
| 523 | BD7VS-523 | SPRING | 1x12xL | 1 |
| 524 | BD7VS-524 | CLAMPING PLATE | | 1 |
| 525 | BD7VS-71 | HEXAGON SCREW DIN 931 | M10x70 | 1 |
| 526 | BD7VS-72 | SET SCREW DIN 915 | M6x16 | 2 |
| 527 | BD7VS-73 | DISK 10 | .1 | |
| 528 | BD7VS-528 | COVER | | 1 |
| 529 | BD7VS-529 | ECCENTRIC SHAFT | | 1 |
| 530 | BD7VS-74 | SET SCREW DIN 915 | M5X8 | 1 |
| 531 | BD7VS-531 | LOCKING HANDLE | | 1 |

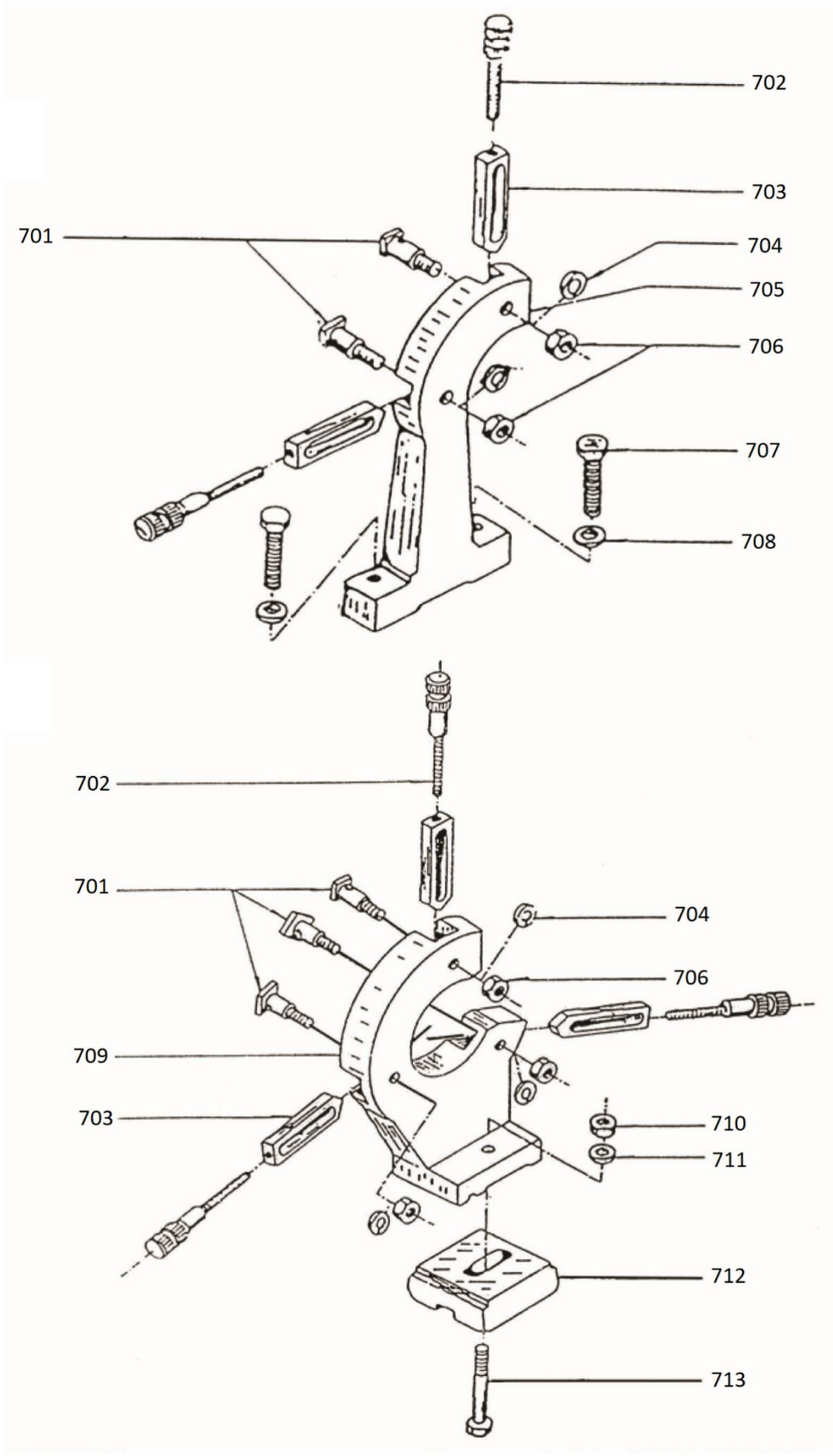
BD-8VS Assembly Breakdown -6



BD-8VS Parts List for Breakdown -6

| Index No. | Part No. | Description | Size | Qty. |
|-----------|-------------|------------------------------|------------|------|
| 601 | BD7VS-601 | SUPPORT | | 1 |
| 602 | GB7085-5-12 | SOCKET HD SCREW | M5 × 12 mm | 2 |
| 603 | BD7VS-603 | SHAFT | | 1 |
| 604 | GB81985-5-6 | CROSS RECESSED FLAT HD SCREW | M5 × 6 mm | 2 |
| 605 | BD7VS-605 | HEX SLEEVE | | 1 |
| 606 | GB7085-3-8 | SOCKET HD SCREW | M3 × 8 mm | 1 |
| 607 | BD7VS-607 | CHIP SHIELD | | 1 |
| 608 | GB7085-3-6 | SOCKET HD SCREW | M3 × 6 mm | 2 |

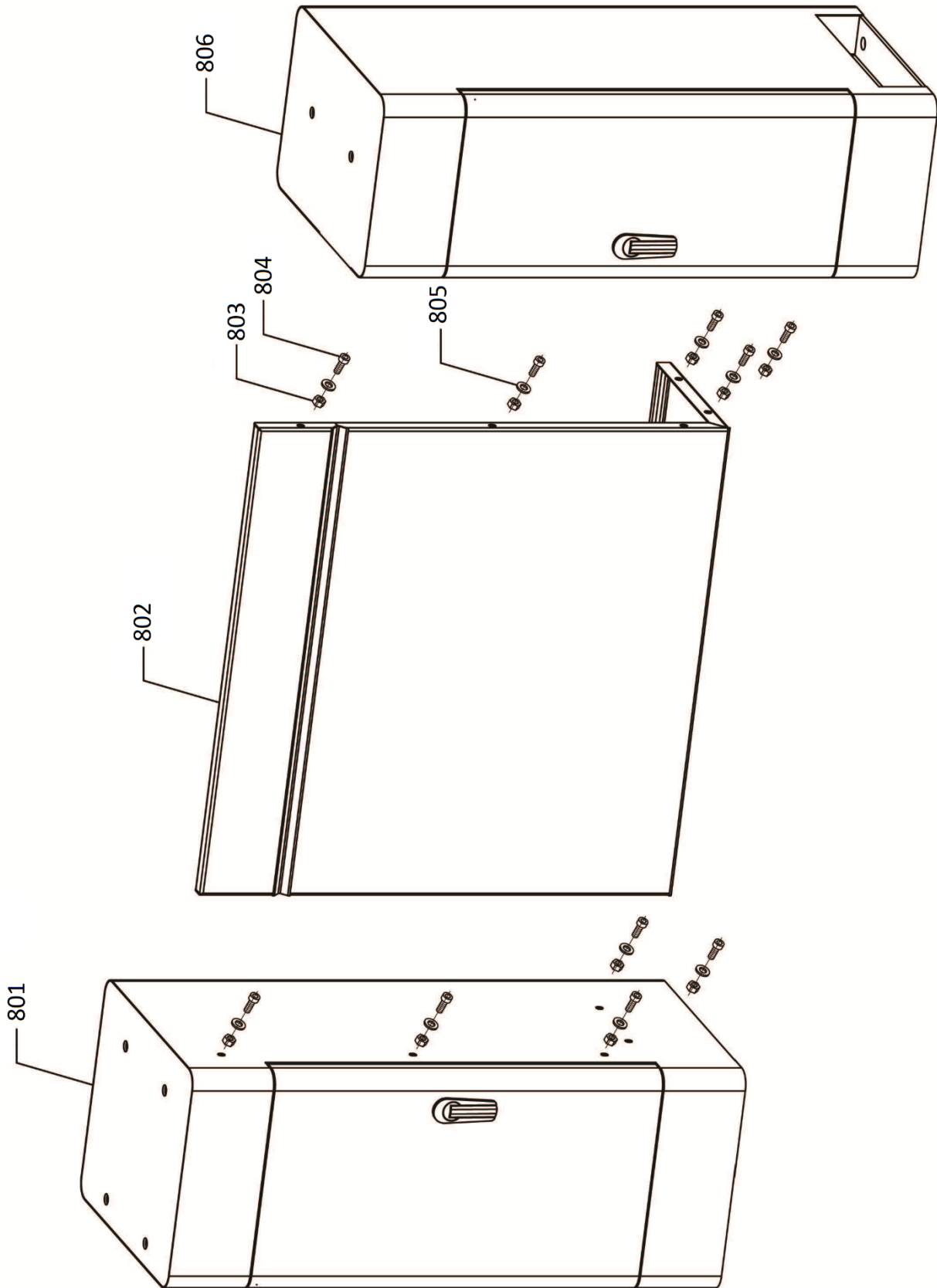
BD-8VS Assembly Breakdown -7



BD-8VS Parts List for Breakdown -7

| Index No. | Part No. | Description | Size | Qty. |
|-----------|----------------|---------------------|-------------|------|
| 701 | BD7VS-701 | SCREW | | 5 |
| 702 | BD7VS-702 | TIGHTENING SCREW | | 5 |
| 703 | BD7VS-703 | SLIDE JAW | | 5 |
| 704 | GB9785-8 | SPRING WASHER (STD) | 8 | 5 |
| 705 | BD7VS-705 | FOLLOW REST | | 1 |
| 706 | GB617086-8 | HEX NUT | M8 | 5 |
| 707 | GB578186-8-20 | HEX HD SCREW | M8 x 20 mm | 2 |
| 708 | GB97185-8 | WASHER | 8 | 2 |
| 709 | BD7VS-709 | STEADY REST | | 1 |
| 710 | GB617086-10 | HEX NUT | M10 | 1 |
| 711 | GB97185-10 | WASHER | 10 | 1 |
| 712 | BD7VS-712 | CLAMPING PLATE | | 1 |
| 713 | GB578186-10-45 | HEX HD SCREW | M10 x 45 mm | 1 |
| | BD7VS-714 | FOLLOW REST KIT | | 1 |
| | BD7VS-715 | STEADY REST KIT | | 1 |

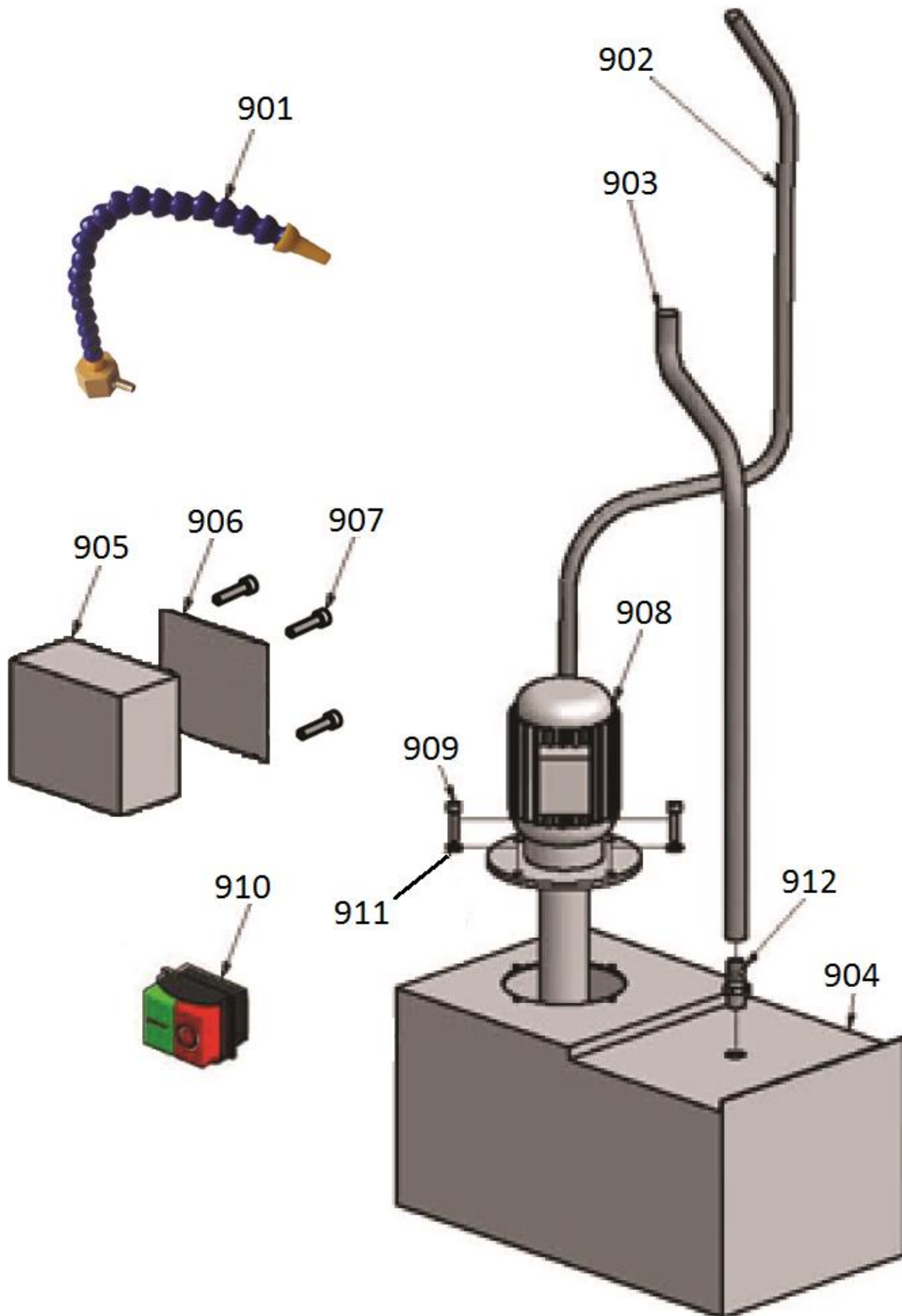
BD-8VS Assembly Breakdown -8



BD-8VS Parts List for Breakdown -8

| Index No. | Part No. | Description | Size | Qty. |
|-----------|-------------|------------------|------------|------|
| 801 | BD7VS-801 | LEFT STAND | | 1 |
| 802 | BD7VS-802 | CONNECTING PLATE | | 1 |
| 803 | GB617086-8 | HEX NUT | M8 | 10 |
| 804 | GB7085-8-16 | SOCKET HD SCREW | M8 x 16 mm | 10 |
| 805 | GB97185-8 | WASHER | 8 | 10 |
| 806 | BD7VS-806 | RIGHT STAND | | 1 |
| | BD7VS-807 | STAND KIT | | 1 |

BD-8VS Assembly Breakdown -9



BD-8VS Parts List for Breakdown -9

| Index No. | Part No. | Description | Size | Qty. |
|-----------|-------------|----------------------|------------|------|
| 901 | BD7VS-901 | NOZZLE | | 1 |
| 902 | BD7VS-902 | OUTLET PIPE | | 1 |
| 903 | BD7VS-903 | RETURNING PIPE | | 1 |
| 904 | BD7VS-904 | WATER TANK | | 1 |
| 905 | BD7VS-905 | ELECTRICAL BOX | | 1 |
| 906 | BD7VS-906 | ELECTRICAL BOX COVER | | 1 |
| 907 | GB7085-5-30 | SOCKET HD SCREW | M5 x 30 mm | 4 |
| 908 | BD7VS-908 | COOLANT PUMP | | 1 |
| 909 | GB7085-5-12 | SOCKET HD SCREW | M5 x 12 mm | 4 |
| 910 | BD7VS-910 | SWITCH | KJD17B | 1 |
| 911 | GB97185-5 | WASHER | 5 | 4 |
| 912 | BD7VS-912 | HOSE CLIP | | 1 |
| | 59500112 | COOLANT PUMP KIT | | 1 |

16.0 Wiring Diagrams

BD-8VS1~230V, PE, 50Hz

