

JET

JTM-1254LTS

**STEP SPEED
MILLING MACHINE**

JTM-1254LTS..... 50000682T 3~400V, 50Hz

PARTS LIST

JPW (Tool) AG.
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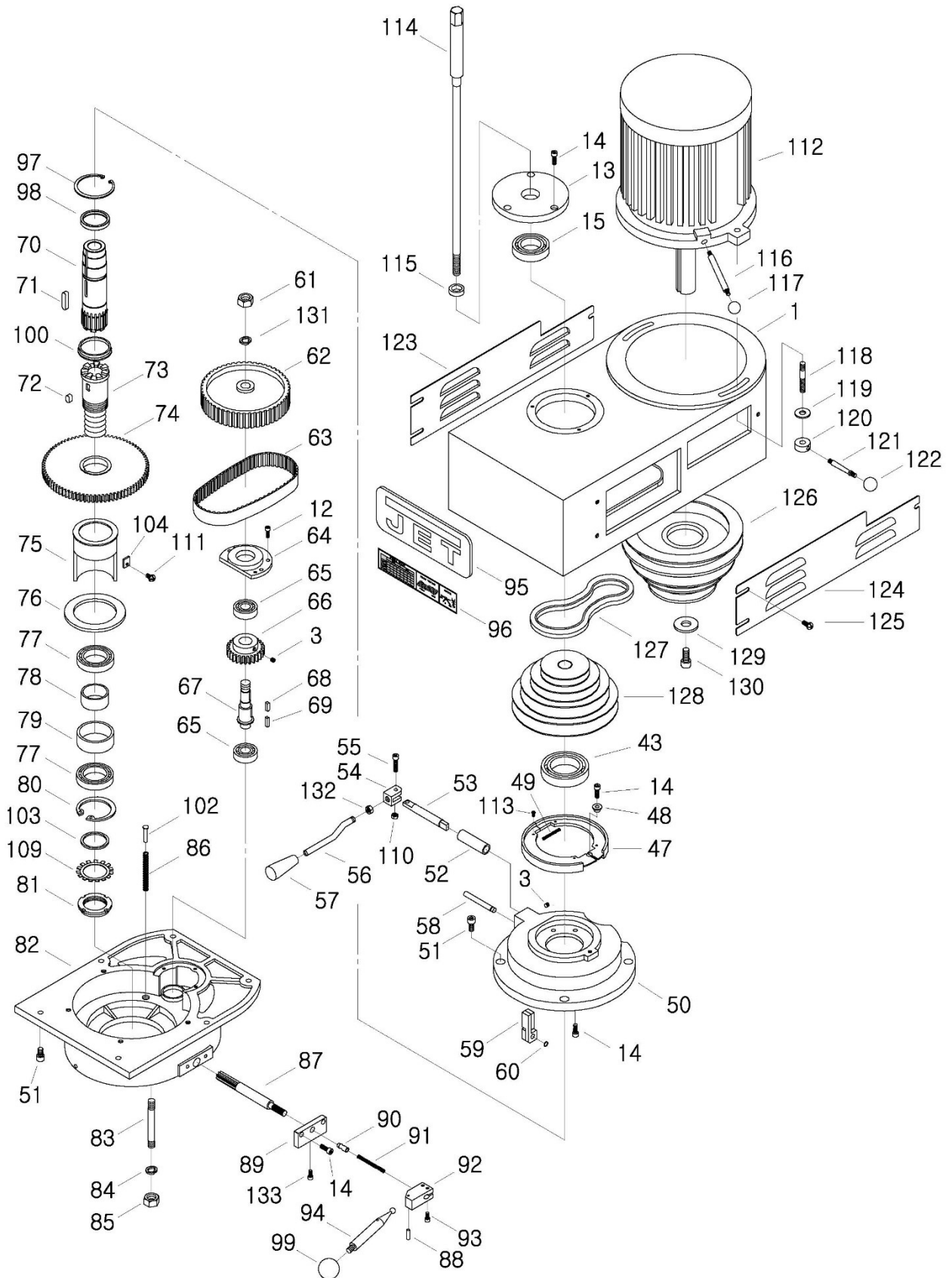
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JTM-1254LTS Upper Head Assembly – Exploded View

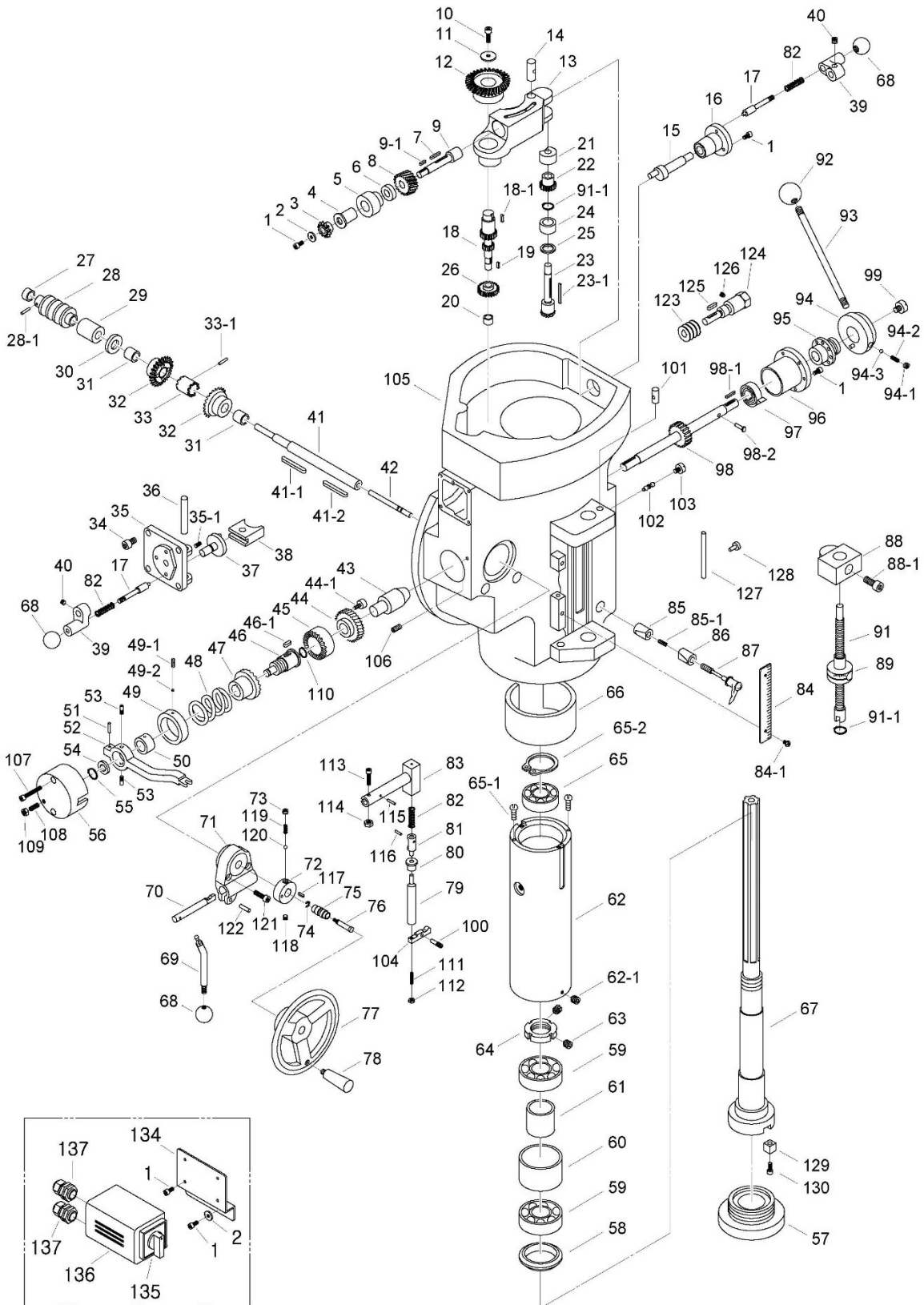


JTM-1254LTS Upper Head Assembly – Parts List

Index No	Part No	Description	Size	Q'ty
1	JTM1254LTS-01	Upper Pulley Housing		1
3	JTM1254LTS-03	Set Screw	M6x6	2
12	JTM1254LTS-12	Hex Socket Cap Screw	M6x6	4
13	JTM1254LTS-13	Upper Cover		1
14	JTM1254LTS-14	Hex Socket Cap Screw	M6x16	10
15	JTM1254LTS-15	Ball Bearing	6007ZZ	1
43	JTM1254LTS-43	Ball Bearing	6010ZZ	1
47	JTM1254LTS-47	Brake		1
48	JTM1254LTS-48	Lock Collar		1
49	JTM1254LTS-49	Spring		1
50	JTM1254LTS-50	Brake Plate		1
51	JTM1254LTS-51	Hex Socket Cap Screw	M8x20	10
52	JTM1254LTS-52	Sleeve		1
53	JTM1254LTS-53	Brake Rod		1
54	JTM1254LTS-54	Brake Bracket		1
55	JTM1254LTS-55	Hex Socket Cap Screw	M6x25	1
56	JTM1254LTS-56	Handle		1
57	JTM1254LTS-57	Handle		1
58	JTM1254LTS-58	Hand Rod		1
59	JTM1254LTS-59	Brake Bracket		1
60	JTM1254LTS-60	Retaining Ring	STW8	1
61	JTM1254LTS-61	Hex Nut	5/8"-18UNF	1
62	JTM1254LTS-62	Timing Wheel		1
63	JTM1254LTS-63	Timing Belt		1
64	JTM1254LTS-64	Ball Bearing Bracket		1
65	JTM1254LTS-65	Ball Bearing	6203ZZ	2
66	JTM1254LTS-66	Gear		1
67	JTM1254LTS-67	Gear Shaft		1
68	JTM1254LTS-68	Double Round Key	5x5x15	1
69	JTM1254LTS-69	Double Round Key	5x5x18	1
70	JTM1254LTS-70	Import Clutch		1
71	JTM1254LTS-71	Double Round Key	8x7x24	1
72	JTM1254LTS-72	Double Round Key	8x7x12	1
73	JTM1254LTS-73	Export Clutch		1
74	JTM1254LTS-74	Gear		1
75	JTM1254LTS-75	Bear Sleeve		1
76	JTM1254LTS-76	Washer		1
77	JTM1254LTS-77	Ball Bearing	6908ZZ	2
78	JTM1254LTS-78	Small Spacer		1
79	JTM1254LTS-79	Big Spacer		1
80	JTM1254LTS-80	Retaining Ring	RTW62	1
81	JTM1254LTS-81	Bearing Nut	AN08	1
82	JTM1254LTS-82	Gear Box Housing		1
83	JTM1254LTS-83	Stud	7/16"x4"	3
84	JTM1254LTS-84	Spring Washer	7/16"	3
85	JTM1254LTS-85	Hex Nut	7/16"	3
86	JTM1254LTS-86	Spring		3
87	JTM1254LTS-87	Speed Rod		1
88	JTM1254LTS-88	Spring Pin	3x20	1
89	JTM1254LTS-89	Connect Block		1
90	JTM1254LTS-90	Hi/Low Sleeve		1
91	JTM1254LTS-91	Spring		1
92	JTM1254LTS-92	Connect Bracket		1
93	JTM1254LTS-93	Hex Socket Cap Screw	M5x14	2
94	JTM1254LTS-94	Handle		1
95	JTM1254LTS-95	JET Logo	203x84 mm	1

Index No	Part No	Description	Size	Q'ty
97	JTM1254LTS-96	Retaining Ring	RTW80	1
98	JTM1254LTS-98	Collar		1
99	JTM1254LTS-99	Ball Handle	1/4"	1
100	JTM1254LTS-100	Clutch Collar		1
102	JTM1254LTS-102	Spring Rod		3
103	JTM1254LTS-103	Spacer		1
104	JTM1254LTS-104	Nut		1
109	JTM1254LTS-109	Bearing Washer	AW08	1
110	JTM1254LTS-110	Nut	M6	1
111	JTM1254LTS-111	Pan Head Screw	3/16"x1/2"	1
112	JTM1254LTS-112	Motor	3.75kW	1
113	JTM1254LTS-113	Pan head Cross Screw	1/8"x1/4"	4
115	JTM1254LTS-115	Spacer		1
116	JTM1254LTS-116	Handle		1
117	JTM1254LTS-117	Ball Handle	3/8"	1
118	JTM1254LTS-118	Screw		2
119	JTM1254LTS-119	Flat Washer		2
120	JTM1254LTS-120	Lock Collar		2
121	JTM1254LTS-121	Handle		2
122	JTM1254LTS-122	Ball Handle	5/16"	2
123	JTM1254LTS-123	Pulley Cover (Left)		1
124	JTM1254LTS-124	Pulley Cover (Right)		1
125	JTM1254LTS-125	Pan Head Screw	M5x8L	6
126	JTM1254LTS-126	Motor Pulley		1
127	JTM1254LTS-127	Belt		1
128	JTM1254LTS-128	Spindle Pulley		1
129	JTM1254LTS-129	Washer	Ø8	1
130	JTM1254LTS-130	Hex Socket Cap Screw	M8X30	1
131	JTM1254LTS-131	Spring Washer	5/8"	1
132	JTM1254LTS-132	Nut	3/8"	1
133	JTM1254LTS-133	Hex Socket Cap Screw	M5x20	1

JTM-1254LTS Lower Head Assembly – Exploded View



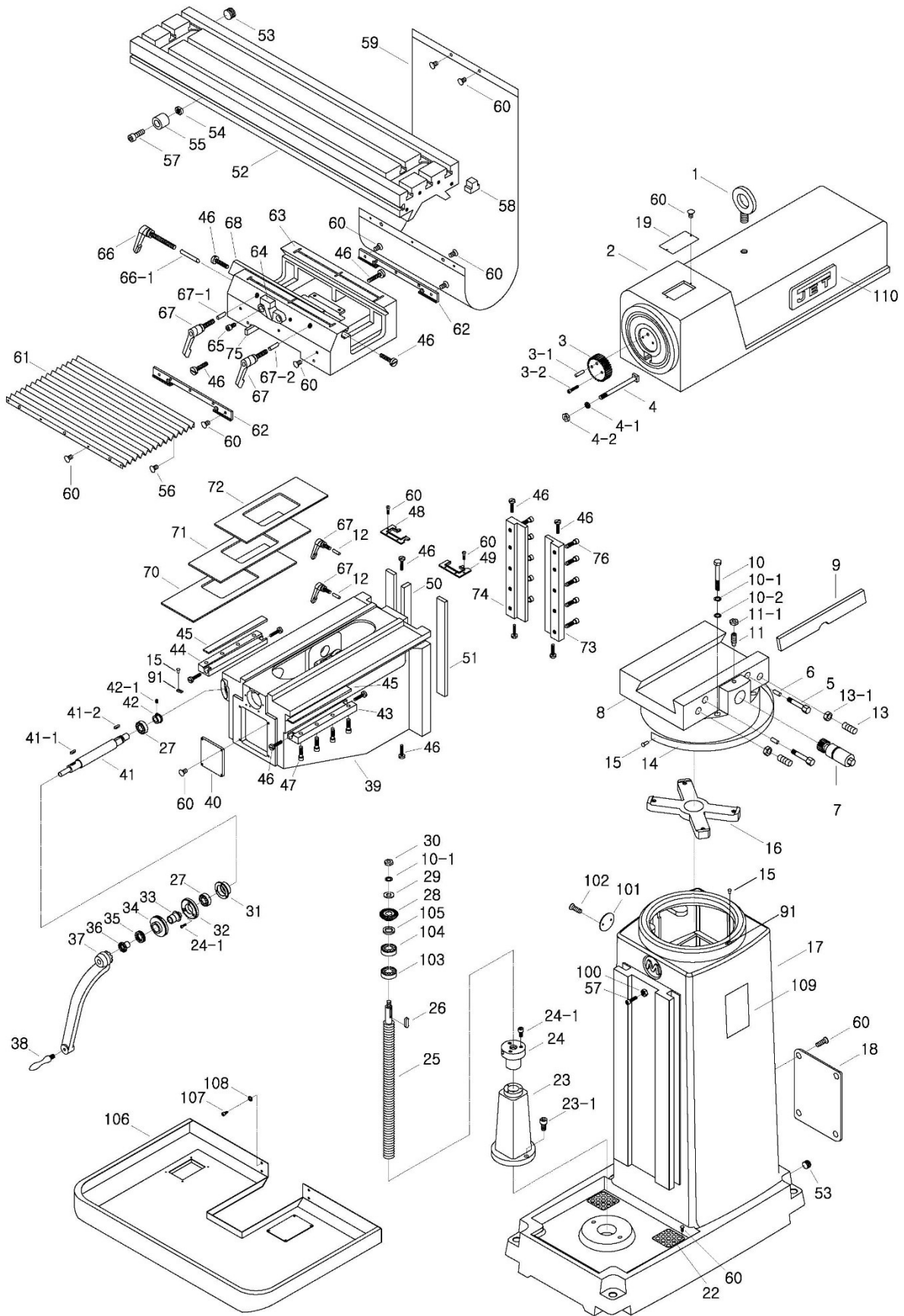
JTM-1254LTS Lower Head Assembly – Parts List

Index No	Part No	Description	Size	Q'ty
1.....	TS-1502031.....	Hex Socket Cap Screw.....	M5x12L.....	6
2.....	JTM949EVS-B02.....	Flat Washer.....	Ø5.....	1
3.....	JTM1254VS-B03.....	Feed Gear.....		1
4.....	JTM1254VS-B04.....	Shaft Sleeve.....		1
5.....	JTM1254VS-B05.....	Worm Cradle Bushing.....		1
6.....	JTM1254VS-B06.....	Worm Gear Spacer.....		1
7.....	KF2R3320.....	Key.....	3x3x20L.....	1
8.....	JTM1254VS-B08.....	Feed Drive Worm Gear.....		1
9.....	JTM1254VS-B09.....	Worm Gear Shaft.....		1
9-1.....	KF2R3308.....	Worm Shaft Key.....	3x3x10L.....	1
10.....	JTM1254VS-B10.....	Hex Socket Cap Screw.....	5/16"x1/2"L.....	1
11.....	JTM1254VS-B11.....	Washer.....	5/16".....	1
12.....	JTM1254VS-B12.....	Feed Reverse Bevel Gear.....		1
13.....	JTM1254VS-B13.....	Worm Gear Cradle.....		1
14.....	JTM1254VS-B14.....	Feed Engage Pin.....		1
15.....	JTM949EVS-B18.....	Cam Rod.....		1
16.....	JTM949EVS-B19.....	Shift Sleeve.....		1
17.....	JTM949EVS-B20.....	Lock Rod.....		2
18.....	JTM1254VS-B18.....	Feed Drive Gear.....		1
18-1.....	KF2R5508.....	Key.....	5x5x8L.....	1
19.....	KF2R5512.....	Key.....	5x5x12L.....	1
20.....	JTM1254VS-B20.....	Needle Bearing.....	BA66.....	1
21.....	JTM1254VS-B21.....	Upper Bushing.....		1
22.....	JTM1254VS-B22.....	Cluster Gear.....		1
23.....	JTM1254VS-B23.....	Bevel Gear Shaft.....		1
23-1.....	KF2R4445.....	Key.....	4x4x45L.....	1
24.....	JTM1254VS-B24.....	Bevel Gear Bushing.....		1
25.....	JTM1254VS-B25.....	Spacer.....		1
26.....	JTM1254VS-B26.....	Feed Drive Gear.....	TA2620Z.....	1
27.....	JTM1254VS-B27.....	Bushing.....		1
28.....	JTM1254VS-B28.....	Worm.....		1
28-1.....	JTM1254VS-B28-1.....	Spring Pin.....		1
29.....	JTM1254VS-B29.....	Feed Worm Shaft Bushing.....		1
30.....	JTM1254VS-B30.....	Bevel Gear Thrust Spacer.....		1
31.....	JTM1254VS-B31.....	Bushing.....		2
32.....	JTM1254VS-B32.....	Feed Reverse Bevel Gear.....		2
33.....	JTM1254VS-B33.....	Feed Reverse Clutch.....		1
33-1.....	JTM1254VS-B33-1.....	Spring Pin.....		1
34.....	TS-1502021.....	Hex Socket Cap Screw.....	M5x10L.....	4
35.....	JTM949EVS-B66.....	Cluster Gear Cover.....		1
35-1.....	TS-1522031.....	Socket Set Screw.....	M5x10L.....	1
36.....	JTM949EVS-B60.....	Feed Shift Rod.....		1
37.....	JTM1254VS-B37.....	Cluster Gear Shift Crank.....		1
38.....	JTM1254VS-B38.....	Feed Gear Shift Fork.....		1
39.....	JTM949EVS-B23.....	Crank.....		2
40.....	5302731.....	Socket Set Screw.....	M8x6.....	2
41.....	JTM1254VS-B41.....	Feed Worm Shaft.....		1
41-1.....	KF2R5515.....	Key.....	5x5x15L.....	1
41-2.....	KF2R5510.....	Key.....	5x5x10L.....	1
42.....	JTM1254VS-B42.....	Reverse Clutch Rod.....		1
43.....	JTM1254VS-B43.....	Pinion Shaft.....		1
44.....	JTM1254VS-B44.....	Overload Clutch Worm Gear.....		1
44-1.....	JTM1254VS-B44-1.....	Screw.....		3
45.....	JTM1254VS-B45.....	Overload Clutch Ring.....		1
46.....	JTM1254VS-B46.....	Overload Clutch Sleeve.....		1
46-1.....	KF2R5516.....	Key.....	5x5x16L.....	1
47.....	JTM1254VS-B47.....	Overload Clutch.....		1
48.....	JTM1254VS-B48.....	Safety Clutch Spring.....		1
49.....	JTM1254VS-B49.....	Overload Clutch Lockout.....		1
49-1.....	JTM1254VS-B49-1.....	Set Screw.....	M6x8L.....	1

Index No	Part No	Description	Size	Q'ty
49-2	JTM1254VS-B49-2	Lock Block		1
50	JTM1254VS-B50	Clutch Ring		1
51	JTM1254VS-B51	Spring Pin	Ø5x20L	1
52	JTM1254VS-B52	Trip Lever		1
53	JTM1254VS-B53	Clutch Ring Pin		2
54	JTM1254VS-B54	Washer		1
55	STW10	Retaining Ring	STW10	1
56	JTM1254VS-B56	Clutch Arm Cover		1
57	JTM1254VS-B57	Nose Piece		1
58	JTM1254VS-B58	Spindle Shield		1
59	JTM1254VS-B59	Ball Bearing	7010ZZ	2
60	JTM1254VS-B60	Bearing Spacer (large)		1
61	JTM1254VS-B61	Bearing Spacer (small)		1
62	JTM949EVS-B142	Quill	(2hole)	1
62-1	JTM1254VS-B62-1	Set Screw	M5x5L	1
63	TS-1523011	Set Screw	M6x6L	2
64	AN10	Bearing Nut	AN10	1
65	BB6008ZZ	Ball Bearing	6008ZZ	1
65-1	TS-1533032	Pan head Cross Screw	M5x10L	2
65-2	STW40	Retaining Ring	STW40	1
66	JTM1254VS-B66	Quill Skirt		1
67	JTM1254VS-B67	Spindle	NT40	1
68	BH1/4	Black Plastic Ball	1/4"	3
69	JTM949EVS-B104	Trip Handle		1
70	JTM1254VS-B70	Cam Rod		1
71	JTM1254VS-B71	Feed Trip Bracket		1
72	JTM1254VS-B72	Handle Wheel Clutch		1
73	5302731	Set Screw	M8x6L	1
74	ETW6	Retaining Ring	ETW6	1
75	JTM1254VS-B75	Shaft		1
76	JTM1254VS-B76	Rod		1
77	JTM949EVS-B125	Handwheel		1
77A	JTM949EVS-B125HA	Handwheel Assembly (#125,126)		1
78	JTM949EVS-B126	Handle		1
79	JTM1254VS-B79	Feed Trip Plunger		1
80	JTM1254VS-B80	Bushing		1
81	JTM1254VS-B81	Trip Plunger		1
82	JTM949EVS-B21	Spring		3
83	JTM1254VS-B83	Cam Rod Sleeve Assembly		1
84	JTM1254VS-B84	Micrometer Scale		1
84-1	TS-2171012	Pan head Cross Screw	M4x6L	2
85	JTM1254VS-B85	Quill Lock Sleeve		1
85-1	JTM1254VS-B85-1	Spring		1
86	JTM1254VS-B86	Quill Lock Sleeve		1
87	JTM1254VS-B87	Lock Handle		1
88	JTM1254VS-B88	Quill Stop Knob		1
88-1	TS-0209032	Hex Socket Cap Screw	3/8"-24UNFx3/4"	1
89	JTM949EVS-B162	Micrometer Nut		1
91	JTM949EVS-B164	Quill Micro-Screw		1
91-1	STW16	Retaining Ring	STW16	2
92	JTM949EVS-B77	Handle		1
93	JTM949EVS-B84	Handle		1
94	JTM949EVS-B138	Hub		1
94-1	JTM1254VS-B94-1	Set Screw	5/16"x3/8"	1
94-2	JTM1254VS-B94-2	Spring		1
94-3	JTM1254VS-B94-3	Steel Ball		1
95	JTM1254VS-B95	Hub Sleeve		1
96	JTM1254VS-B96	Spring Cover		1
97	JTM1254VS-B97	Adjustable Spring		1
98	JTM1254VS-B98	Quill Pinion Shaft		1
98-1	JTM1254VS-B98-1	Key	5x5x25L	1
98-2	JTM1254VS-B98-2	T type Pin		1

Index No	Part No	Description	Size	Q'ty
99	JTM1254VS-B99	Pinion Shaft Hub		1
100	JTM1254VS-B100	Trip Lever Pin		1
101	JTM1254VS-B101	Rod		1
102	JTM1254VS-B102	Lever		1
103	JTM1254VS-B103	Screw		1
104	JTM1254VS-B104	Feed Trip Lever		1
105	JTM1254VS-B105	Quill Housing		1
106	TS-1523021	Set Screw	M6x8L	1
107	TS-1502081	Hex Socket Cap Screw	M5x35L	2
108	TS-1523051	Set Screw	M6x16L	1
109	TS-2311061	Hex Nut	M6	1
110	STW22	Retaining Ring	STW22	1
111	TS-1521071	Set Screw	M4x20L	1
112	TS-1540021	Hex Nut	M4	1
113	TS-1502051	Hex Socket Cap Screw	M5x20L	1
114	TS-1540031	Hex Nut	M5	1
115	JTM1254VS-B115	Spring Pin		1
116	6295576	Spring Pin	Ø3x12L	1
117	KF2R3312	Key	3x3x12L	1
118	TS-1523011	Socket Set Screw	M6x6	1
119	JTM1254VS-B119	Spring		1
120	JTM1254VS-B120	Steel Ball		1
121	TS-1503051	Hex Socket Cap Screw	M6x20	2
122	5625391	Spring Pin	Ø5x16L	1
123	JTM1254VS-B123	Worm Gear		1
124	JTM1254VS-B124	Worm Shaft		1
125	KF2R4418	Key	4x4x18L	1
126	JTM1254VS-B126	Set Screw		1
127	JTM949EVS-B25	Indicator Rod		1
128	JTM949EVS-B26	Indicator Rod Screw		1
129	JTM1254VS-B129	Stop Block		2
130	TS-1504041	Hex Socket Cap Screw	M8x20L	2
134	JTM1254VS-B134	Bracket		1
135	JTM1254VS-B135	Reversible Switch	2/4P	1
136	JTM1254VS-B136	Switch Housing		1
137	JTM1254VS-B137	Cable Gland	PG-13.5	2

JTM-1254LTS Base Machine – Exploded View

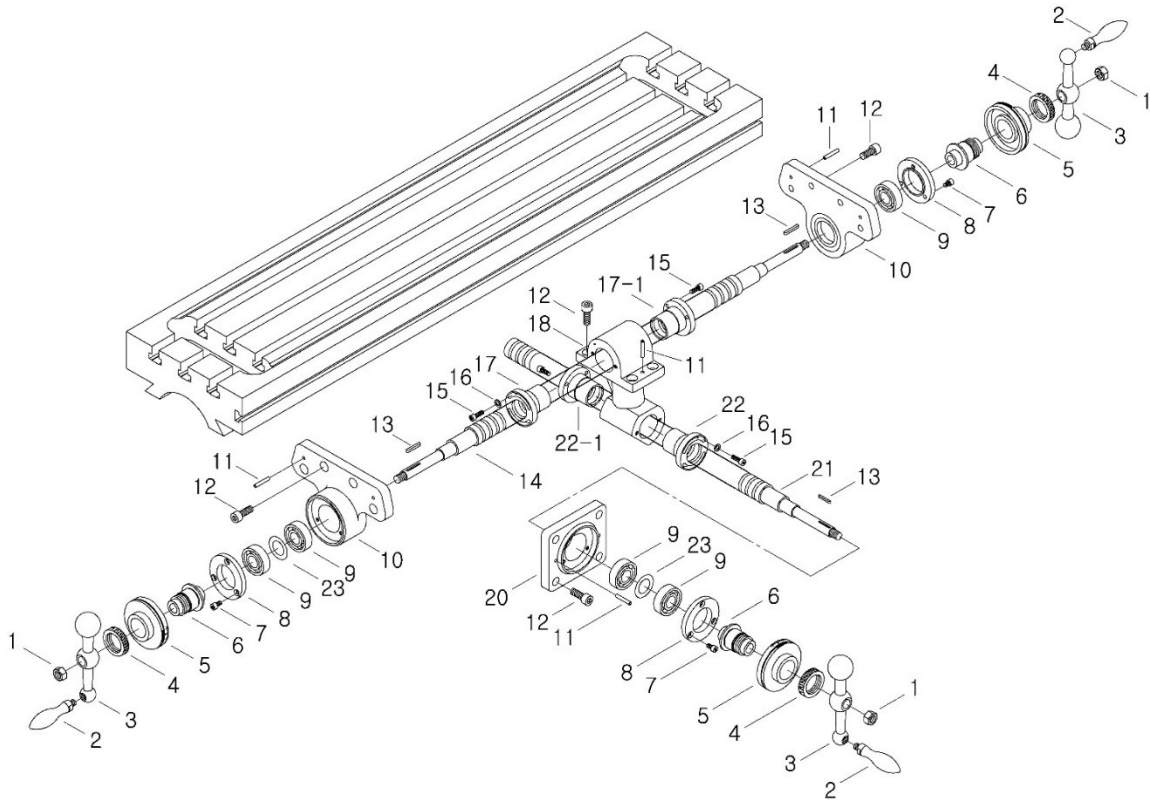


JTM-1254 LTS Base Machine – Parts List

Index No	Part No	Description	Size	Q'ty
1.....	JTM949EVS-C98.....	Lifting Ring.....	M24.....	1
2.....	JTM1254VS-C02.....	Ram.....		1
3.....	JTM949EVS-C02.....	Worm Gear.....		1
3-1.....	JTM949EVS-C03-1.....	Spring Pin.....	Ø6x30L.....	1
3-2.....	TS-1504061.....	Hex Socket Cap Screw.....	M8x30L.....	2
4.....	JTM1254VS-C04.....	Bolt.....	5/8".....	4
4-1.....	JTM1254VS-C04-1.....	Spring Washer.....	Ø16.....	4
4-2.....	JTM1254VS-C04-2.....	Hex Nut.....	5/8".....	4
5.....	JTM1254VS-C05.....	Ram Lock Bolt.....		2
6.....	JTM1254VS-C06.....	Ram Lock Plunger.....		2
7.....	JTM1254VS-C07.....	Ram Pinion.....		1
8.....	JTM1254VS-C08.....	Turret.....		1
9.....	JTM1254VS-C09.....	Ram/Turret Gib.....		1
10.....	JTM1254VS-C10.....	Hex Head Screw.....	M12x185L.....	4
10-1.....	TS-2361121.....	Spring Washer.....	Ø12.....	5
10-2.....	JTM949EVS-B120.....	Flat Washer.....	Ø13.....	4
11.....	JWS35X-222.....	Socket Set Screw.....	M8x30L.....	1
11-1.....	JTM1254VS-C11-1.....	Hex Nut.....	M8.....	1
12.....	JTM1254VS-C12.....	Knee Lock Plunger.....		2
13.....	JTM1254VS-C13.....	Set Screw.....	M10x60L.....	2
13-1.....	TS-2331101.....	Hex Nut.....	M10.....	2
14.....	JTM1254VS-C14.....	Turret Scale.....		1
15.....	RN2L6.....	Rivet.....	Ø2x6L.....	6
16.....	JTM1254VS-C16.....	Spider.....		1
17.....	JTM1254VS-C17.....	Column.....		1
18.....	JTM1254VS-C18.....	Plate.....		1
19.....	JTM1254VS-C19.....	Ram Cover.....		1
22.....	JTM1254VS-C22.....	Strainer Net.....		2
23.....	JTM1254VS-C23.....	Elevating Screw Housing.....		1
23-1.....	JTM1254VS-C23-1.....	Hex Socket Cap Screw.....	M10x45L.....	2
24.....	JTM1254VS-C24.....	Elevating Nut (Metric).....	Ø32 x 5 mm.....	1
24-1.....	TS-1503051.....	Hex Socket Cap Screw.....	M6x20L.....	6
25.....	JTM1254VS-C25A.....	Lead Screw (Metric).....	Ø35 x 5mm(590L).....	1
26.....	KF2R5520.....	Key.....	5x5x20L.....	1
27.....	BB6204ZZ.....	Bearing.....	6204ZZ.....	2
28.....	JTM949EVS-C58.....	Bevel Gear.....	36T.....	1
29.....	JTM949EVS-C59.....	Washer.....	Ø13xØ32x5t.....	1
30.....	JTM1254VS-C30.....	Hex Nut.....	1/2-20UNF.....	1
31.....	JTM1254VS-C31.....	Bearing Seat.....		1
32.....	JTM1254VS-C32.....	Cover.....		1
33.....	JTM1254VS-C33.....	Dial Holder.....		1
34.....	JTM949EVS-C66.....	Dial (Metric).....	0.02/ 2.5mm.....	1
35.....	JTM1254VS-C35.....	Dial Lock Nut.....		1
36.....	JTM1254VS-C36.....	Clutch Insert.....		1
37.....	JTM1050EVS2-75.....	Elevating Crank.....		1
38.....	JTM949EVS-C62.....	Handle.....		1
39.....	JTM1254VS-C39.....	Knee.....		1
40.....	JTM1254VS-C40.....	Knee Cover.....		1
41.....	JTM1254VS-C41.....	Elevating Shaft.....		1
41-1.....	JTM1254VS-C41-1.....	Key.....	3x3x10L.....	1
41-2.....	JTM1254VS-C41-2.....	Key.....	4x4x16L.....	1
42.....	JTM949EVS-C74.....	Bevel Gear.....	18T.....	1
42-1.....	TS-1523031.....	Socket Set Screw.....	M6x10L.....	1
43.....	JTM1254VS-C43.....	Support Plate-R.....		1
44.....	JTM1254VS-C44.....	Support Plate-L.....		1
45.....	JTM1254VS-C45.....	Gib.....		2
46.....	JTM1254VS-C46.....	Adjustable Screw.....		14
47.....	JTM1254VS-C47.....	Hex Socket Cap Screw.....	M12x35L.....	8
48.....	JTM1254VS-C48.....	Knee Wiper (left).....		1
49.....	JTM1254VS-C49.....	Knee Wiper (right).....		1

Index No	Part No	Description	Size	Q'ty
50	JTM1254VS-C50	Knee/ Column Gib		1
51	JTM1254VS-C51	Knee/ Column Gib		2
52	JTM1254VS-C52	Table	12"x54"	1
53	JTM1254VS-C53	Oil Plug	1/2"PT	3
54	JTM1254VS-C54	Nut		2
55	JTM1254VS-C55	Bushing		2
57	TS-1505041	Hex Socket Cap Screw	M10x30L	3
58	JTM1254VS-C58	Rubber		6
59	JTM1254VS-C59	Flat Way Cover (rear)		1
60	TS-2245102	Socket Head Button Screw	M5x10L	39
61	JTM1254VS-C61	Pleated Way Cover (front)		1
62	JTM1254VS-C62	Wiper		2
63	JTM1254VS-C63	Saddle		1
64	JTM949EVS-C35	Table Stop Bracket		1
65	JTM1254VS-C65	Hex Socket Cap Screw	M10X16L	2
66	JTM1254VS-C66	Lock Handle		2
66-1	JTM1254VS-C66-1	Pluger		2
67	JTM1254VS-C67	Lock Handle	M12x25L	4
67-1	JTM949EVS-C20	Pluger		1
67-2	JTM1254VS-C67-2	Pluger		1
68	JTM1254VS-C68	Gib		1
69	JTM1254VS-CGA	Chip Guard Assembly (including #70-72)		1
70	JTM1254VS-C70	Chip Guard (Big)		1
71	JTM1254VS-C71	Chip Guard (Middle)		1
72	JTM1254VS-C72	Chip Guard (Small)		1
73	JTM1254VS-C73	Knee Support Plate (Right)		1
74	JTM1254VS-C74	Knee Support Plate (Left)		1
75	JTM1254VS-C75	Gib		1
76	JTM1254VS-C76	Hex Socket Cap Screw	M14x35L	10
91	JTM1254VS-C91	Pointer		2
100	TS-1540071	Hex Nut	M10	1
101	JTM949EVS-C84	Side Cover		1
102	TS-1503031	Socket Head Button Screw	M6x12L	2
103	BTH51305	Thrust Bearing	51305	1
104	BB6205ZZ	Ball Bearing	6205ZZ	1
105	JTM949EVS-C44	Washer		1
106	JTM949EVS-C106	Chip Pan		1
107	TS-1504031	Hex Socket Cap Screw	M6x12L	4
108	TS-1550041	Flat Washer	Ø6	4
109	JTM1254VS-C109	ID/Warning Label		1
110	JET-254	JET Logo	254x105 mm	2
	JTM1254VS-TB	Tool Box Kit Complete (not shown)		1

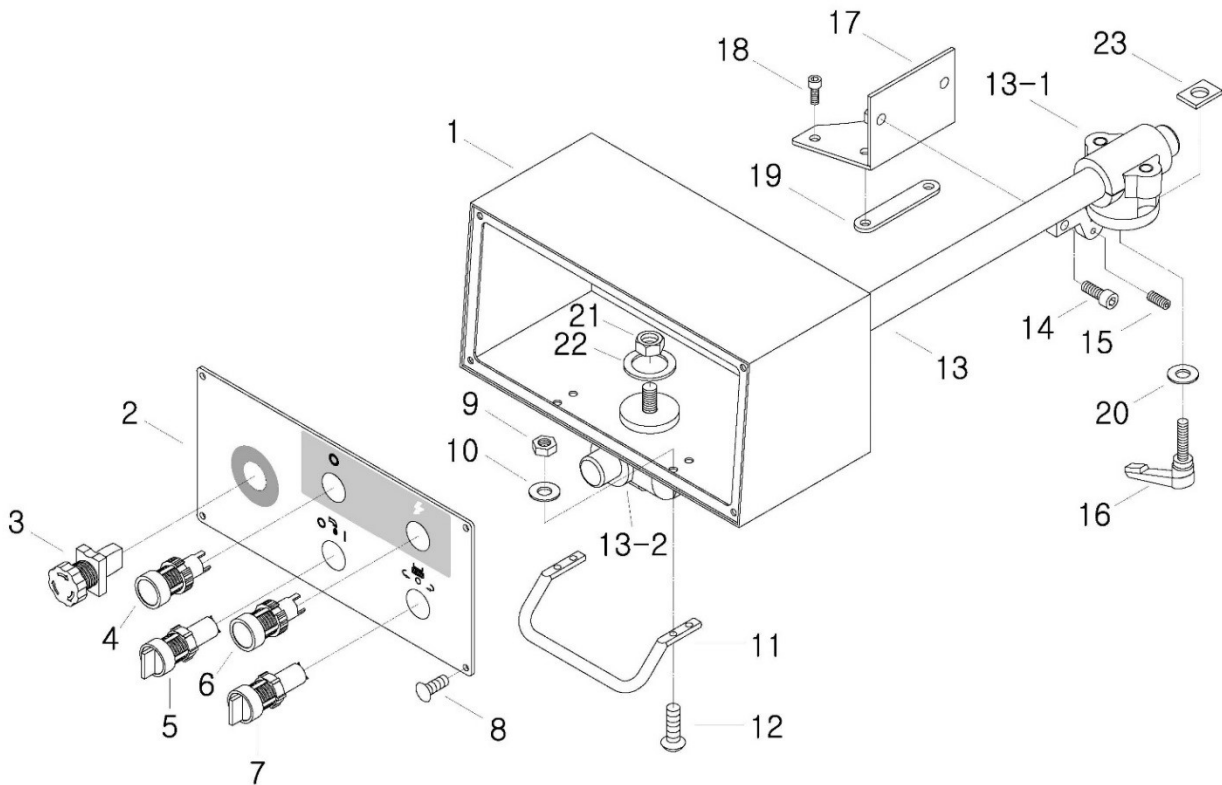
JTM-1254LTS Table Assembly – Exploded View



JTM-1254LTS Table Assembly – Parts List

Index No	Part No	Description	Size	Q'ty
1.....	TS-0561052.....	Hex Nut.....	1/2"-20UNF.....	3
2.....	JTM949GVS-D02.....	Handle.....	3/8".....	3
3.....	JTM949GEVS-D03.....	Ball Crank.....		3
4.....	JTM949GEVS-D04.....	Dial Nut.....		3
5.....	JTM949GEVS-D05.....	Dial (Metric).....	0.02/ 5 mm.....	3
6.....	JTM949GEVS-D06.....	Dial Holder.....		3
7.....	TS-1503031.....	Hex Socket Cap Screw.....	M6x12.....	9
8.....	JTM949GEVS-D08.....	Cover.....	60.....	3
9.....	BB6204.....	Ball Bearing.....	6204ZZ.....	5
10.....	JTM949GEVS-D10.....	Bearing Bracket.....	60.....	2
11.....	5311251.....	Spring Pin.....	Ø5x30.....	6
12.....	TS-1505031.....	Hex Socket Cap Screw.....	M10x25.....	16
13.....	KF2R3325.....	Key.....	3x3x25.....	3
14.....	JTM1050EVS2-D14.....	Longitudinal Feed Screw.....	Ø32 x 5 mm.....	1
15.....	TS-1503041.....	Hex Socket Cap Screw.....	M6x16.....	10
16.....	TS-1550041.....	Flat Washer.....	M6.....	4
17.....	JTM949GEVS-D17.....	Longitudinal Feed Adjustment Nut (Metric).....	Ø32 x 5 mm.....	1
17-1.....	JTM949GEVS-D17-1.....	Feed Screw Nut (Metric).....	Ø32 x 5 mm.....	1
18.....	JTM949GEVS-D18.....	Feed Nut Bracket.....		1
20.....	JTM949GEVS-D20.....	Cross Feed Bearing Bracket.....		1
21.....	JTM1050EVS2-D21.....	Cross Feed Screw (Metric).....	Ø32 x 5 mm.....	1
22.....	JTM949GEVS-D22.....	Cross Feed Adjustment Nut (Metric).....	Ø32 x 5 mm.....	1
22-1.....	JTM949GEVS-D22-1.....	Cross Feed Nut (Metric).....	Ø32 x 5 mm.....	1
23.....	JTM949GEVS-D23.....	Adjusting Washer.....	Ø45xØ34x0.15t.....	2

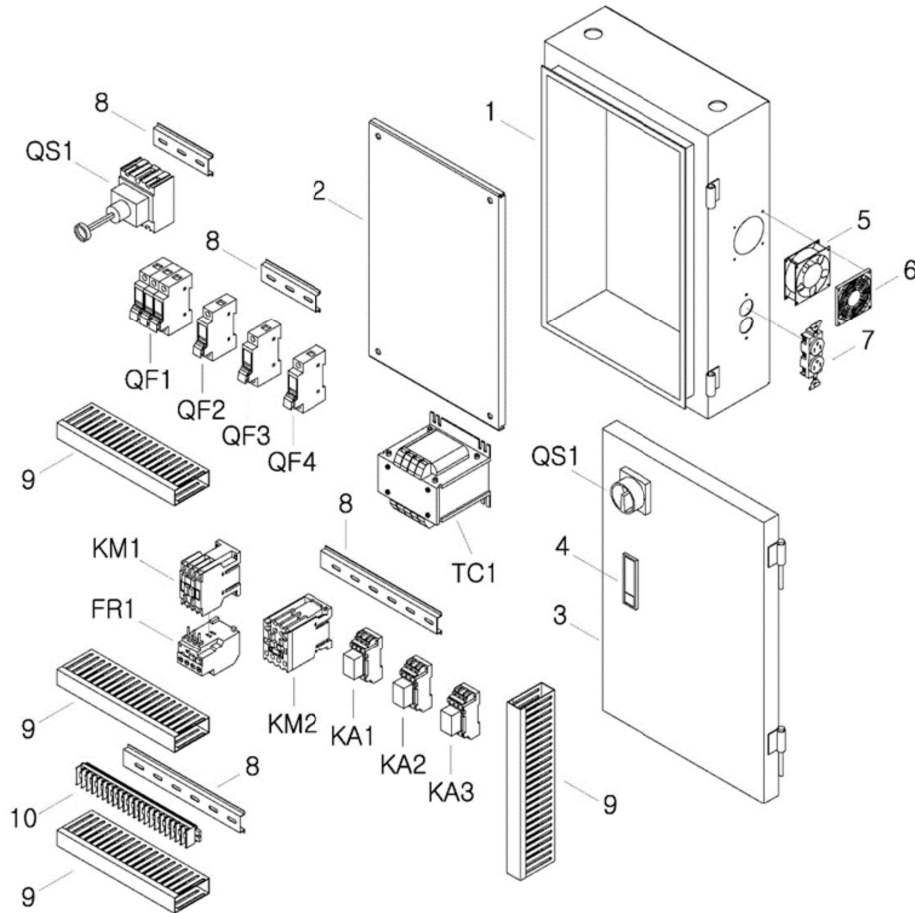
JTM-1254LTS Control Panel Assembly – Exploded View



JTM-1254LTS Control Panel Assembly – Parts List

Index No	Part No	Description	Size	Q'ty
.....	JTM1254VS-CBA.....	Control Box Assembly (includes #1~8).....		1
1.....	JTM949EVS-E01.....	Control Box.....		1
2.....	JTM949EVS-E02.....	Control Panel.....		1
3.....	JTM949EVS-E03.....	Emergency Switch.....		1
4.....	JTM949EVS-E04.....	Spindle Stop Button.....		1
5.....	JTM949EVS-E05.....	Coolant Pump Switch.....		1
6.....	JTM949EVS-E06.....	Power Start Button.....		1
7.....	JTM949EVS-E07.....	F/R Select Switch.....		1
8.....	TS-2245102.....	Socket Head Button Screw.....	M5x10L.....	4
9.....	TS-1540031.....	Hex Nut.....	M5.....	4
10.....	TS-1550031.....	Flat Washer.....	Ø5.....	4
11.....	JTM949EVS-E11.....	Handle.....		1
12.....	TS-2245162.....	Socket Head Button Screw.....	M5x16.....	4
13.....	JTM949EVS-E13.....	Rod.....		1
13-1.....	JTM949EVS-E13-1.....	Rotatable Bracket.....		1
13-2.....	JTM949EVS-E13-2.....	Control Box Bracket.....		1
14.....	TS-1504051.....	Hex Socket Cap Screw.....	M8X20L.....	2
15.....	TS-1523031.....	Socket Set Screw.....	M6x10.....	3
16.....	JTM949EVS-E16.....	Lock Handle.....	M12X35L.....	1
17.....	JTM949EVS-E17.....	Bracket.....		1
18.....	TS-1523051.....	Hex Socket Cap Screw.....	M6x16L.....	3
19.....	JTM949EVS-E19.....	Spacer.....		1
20.....	JTM949EVS-E20.....	Washer.....	Ø13xØ20x2t.....	1
21.....	JTM949EVS-E21.....	Locking Nut.....	5/16".....	1
22.....	JTM949EVS-E22.....	Rubber gasket.....		1
23.....	JTM949EVS-E23.....	Nut.....		1
.....	JTM1254VS-D19.....	Cable (Control Panel to Elec Box) – not shown.....		1

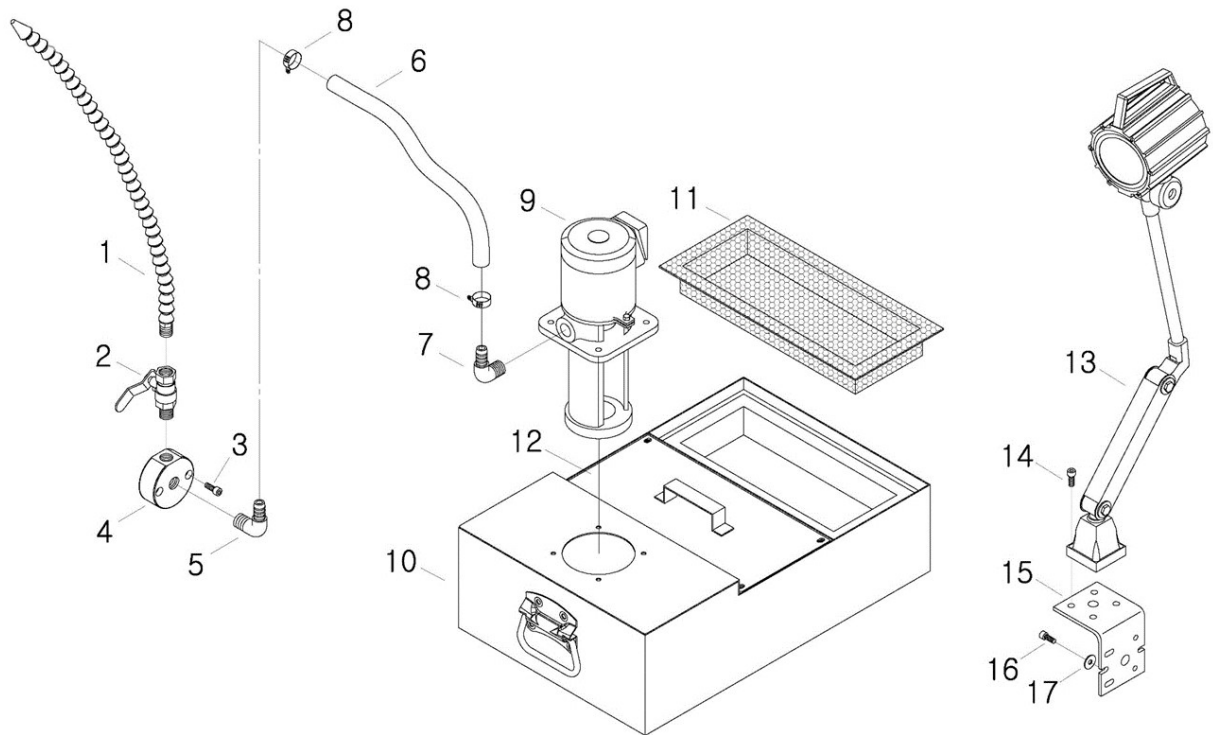
JTM-1254LTS Electrical Box – Exploded View



JTM-1254LTS Electrical Box – Parts List

Index No	Part No	Description	Size	Q'ty
1.....	JTM949EVS-F01.....	Electrical Cabinet.....		1
2.....	JTM949EVS-F02.....	Electrical Plate.....		1
3.....	JTM949EVS-F03.....	Electrical Cabinet Door.....		1
4.....	JTM949EVS-F04.....	Door Latch.....		1
5.....	JTM949EVS-F17.....	Fan.....		1
6.....	JTM949EVS-F18.....	Fan Cover.....		1
7.....	JTM949EVS-F19.....	Electric Receptacle.....		1
8.....	JTM949EVS-F16.....	Aluminum Rail.....		3
9.....	JTM949EVS-F14.....	Wire Casing.....		5
10.....	JTM949EVS-F15.....	Terminal Block.....		1
11.....	JTM949EVS-F21.....	Switch Bracket.....		1
QS1.....	JTM949EVS-F05.....	Door Switch Assembly.....	ZH-C316 (KEDU).....	1
TC1.....	JTM949EVS-F06.....	Transformer.....	400VA.....	1
KM1.....	JTM1254VS-FKM1.....	Magnetic Contactor.....	TECO / CU-11.....	1
FR1.....	JTM1254VS-FFR1.....	Flicker Relay.....		1
KM2.....	JTM1254VS-FKM2.....	Magnetic Contactor.....	TECO / CU-11.....	1
KA1.....	JTM1254VS-FKA1.....	Relay.....	RMIA4524VAC.....	1
KA2.....	JTM1254VS-FKA2.....	Relay.....	RMIA21024VAC.....	1
KA3.....	JTM1254VS-FKA3.....	Relay.....	RMIA4524VAC.....	1
QF1.....	JTM1254VS-FQF1.....	Power Circuit Breaker.....	3P 25A.....	1
QF2.....	JTM1254VS-FQF2.....	Power Circuit Breaker.....	1P 2A.....	1
QF3.....	JTM1254VS-FQF3.....	Power Circuit Breaker.....	1P 6A.....	1
QF4.....	JTM1254VS-FQF4.....	Power Circuit Breaker.....	1P 6A.....	1

JTM-1254LTS Coolant Pump – Exploded View
JTM-1254LTS Work Lamp – Exploded View



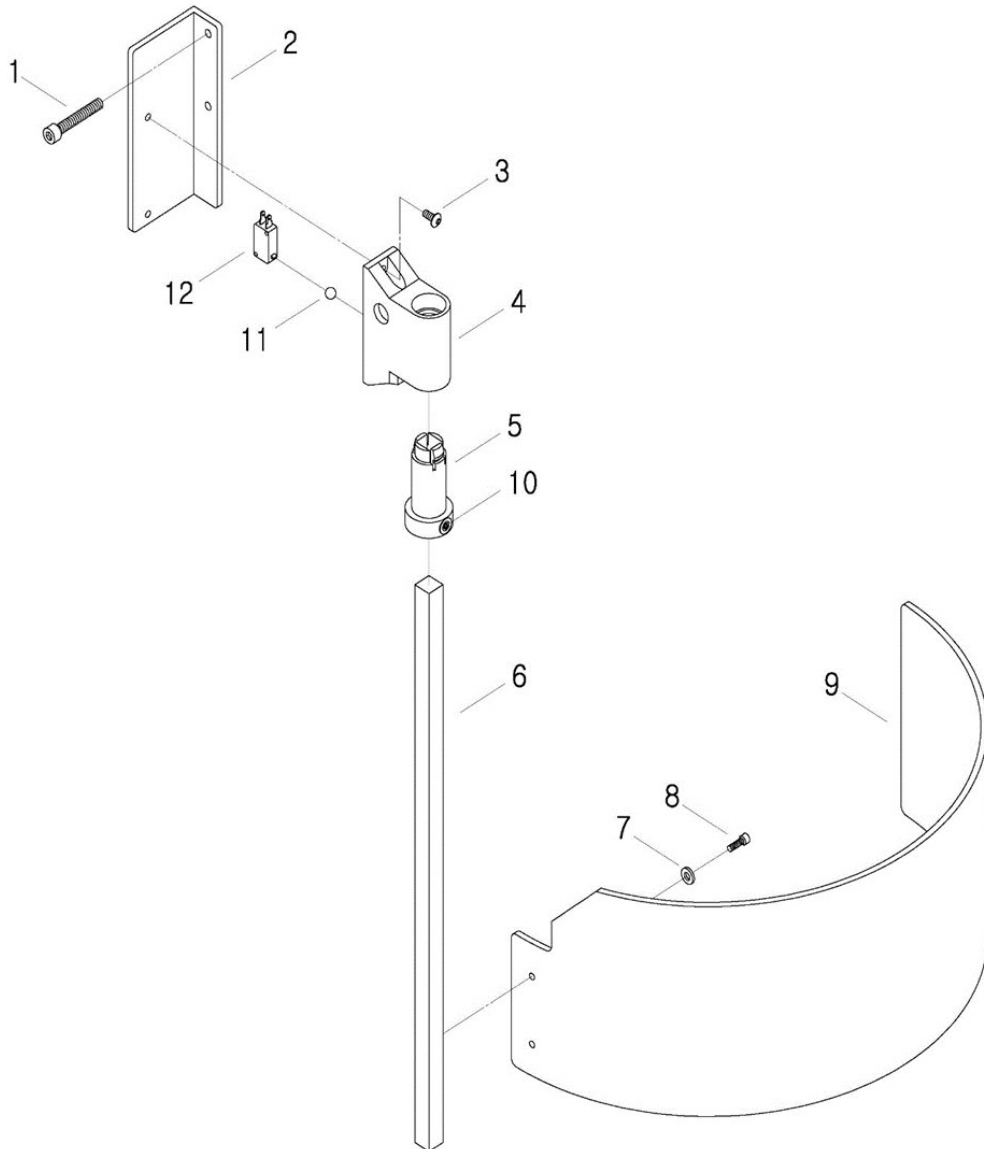
JTM-1254LTS Coolant Pump – Parts List

Index No	Part No	Description	Size	Q'ty
	JTM949LTS-CPK	Coolant Pump Kit (include #1 thru 12)		1
1	JTM949LTS-G01	Plastic Nozzle		1
2	JTM949LTS-G02	Valve	PT 3/8" x 1/2"	1
3	JTM949LTS-G03	Hex Socket Cap Screw	M6 x 40	2
4	JTM949LTS-G04	Block		1
5	JTM949LTS-G05	Hose Fitting	PT 3/8" x 1/2" (90°)	1
6	JTM949LTS-G06	Hose	1/2"	1
7	JTM949LTS-G07	Hose Fitting	PT 3/8" x 1/2" (90°)	1
8	JTM949LTS-G08	Hose Clamp	5/6" (11 ~ 20)	2
9	JTM949LTS-G09	Coolant Pump	1/8HP	1
10	JTM949LTS-G10	External Coolant Tank		1
11	JTM949LTS-G11	Strainer		1
12	JTM949LTS-G12	Cover with handle		1

JTM-1254LTS Work Lamp – Parts List

13	JTM949LTS-G13	Work Lamp	24V LED	1
14	JTM949LTS-G14	Hex Socket Cap Screw	M5X16	4
15	JTM949LTS-G15	Work Light Bracket		1
16	JTM949LTS-G16	Hex Socket Cap Screw	M6X16	6
17	JTM949LTS-G17	Flat Washer	Ø6	6
18	JTM949LTS-G18	LED Bulb (not show)	24V	1

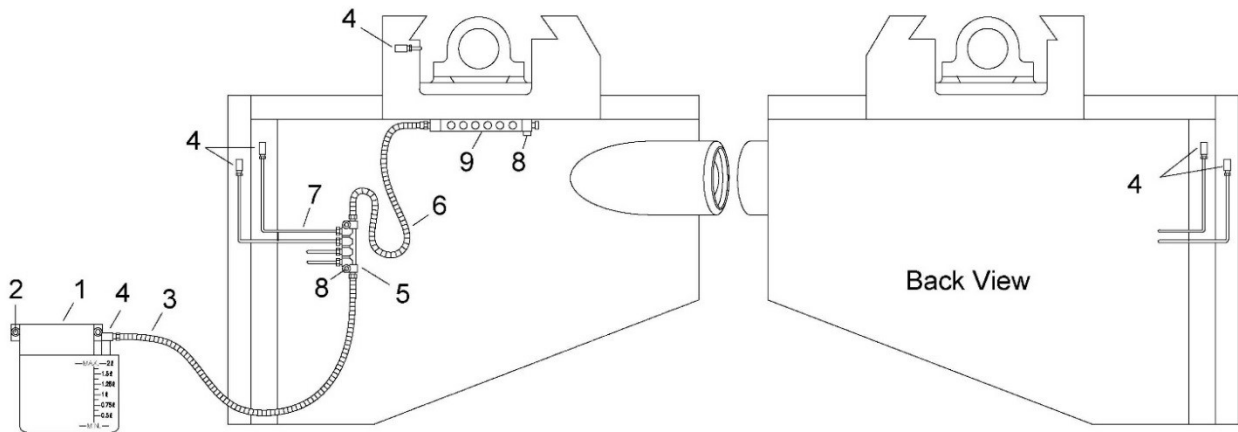
JTM-1254LTS Spindle Guard Assembly – Exploded View



JTM-1254LTS Spindle Guard Assembly – Parts List

Index No	Part No	Description	Size	Q'ty
	JTM949LTS-SGA	Spindle Guard Assembly (#1 thru 9)		1
1	JTM949LTS-H01	Hex Socket Cap Screw	M5x45	2
2	JTM949LTS-H02	Support Plate		1
3	JTM949LTS-H03	Hex Socket Round Screw	M5x10	2
4	JTM949LTS-H04	Bushing Bracket		1
5	JTM949LTS-H05	Bushing		1
6	JTM949LTS-H06	Support Rod		1
7	JTM949LTS-H07	Washer	Ø5	2
8	JTM949LTS-H08	Hex Socket Cap Screw	M5x12	2
9	JTM949LTS-H09	Spindle Guard		1
10	JTM949LTS-H10	Socket Set Screw	M5x8L	1
11	JTM949LTS-H11	Steel Ball	1/4"	1
12	JTM949LTS-H12	Limit Switch		1

JTM-1254LTS Lubrication System – Exploded View



JTM-1254LTS Lubrication System – Parts List

Index No	Part No	Description	Size	Q'ty
1.....	JTM949EVS-J01.....	Automatic Oiler.....	2L, 0~180min.....	1
2.....	TS-1503061.....	Hex Socket Cap Screw.....	M6x25L.....	2
3.....	JTM949EVS-J03.....	Flexible Steel Tube.....	Ø4.....	1
4.....	JTM949EVS-J04.....	Elbow Adaptor.....	Ø4.....	6
5.....	JTM949EVS-J10.....	Distributor.....	Ø4, 6 holes.....	1
6.....	JTM949EVS-J06.....	Flexible Steel Tube.....	Ø4.....	1
7.....	JTM949EVS-J07.....	Aluminum Pipe.....	Ø4.....	4
8.....	TS-1502061.....	Hex Socket Cap Screw.....	M5x25L.....	4
9.....	JTM1254VS-J09.....	Oil Distributor.....	Ø4, 8 holes.....	1
.....	JTM1254VS-J05A.....	Oil Distributor Kit (incl. #3,5,6,9).....	12

Electrical Connections – JTM-1254LTS

