

OTMT

GEARED HEAD ENGINE LATHE



**OPERATING INSTRUCTIONS & PARTS LIST
ITEM NO. 87-116-050
MODEL NO. CQ6232E**

Version date: 08/01/2011

Please Read These Instructions Before Operating Your Machine
Contents Subject To Change Without Notice

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LATHE EXTERIOR CHART

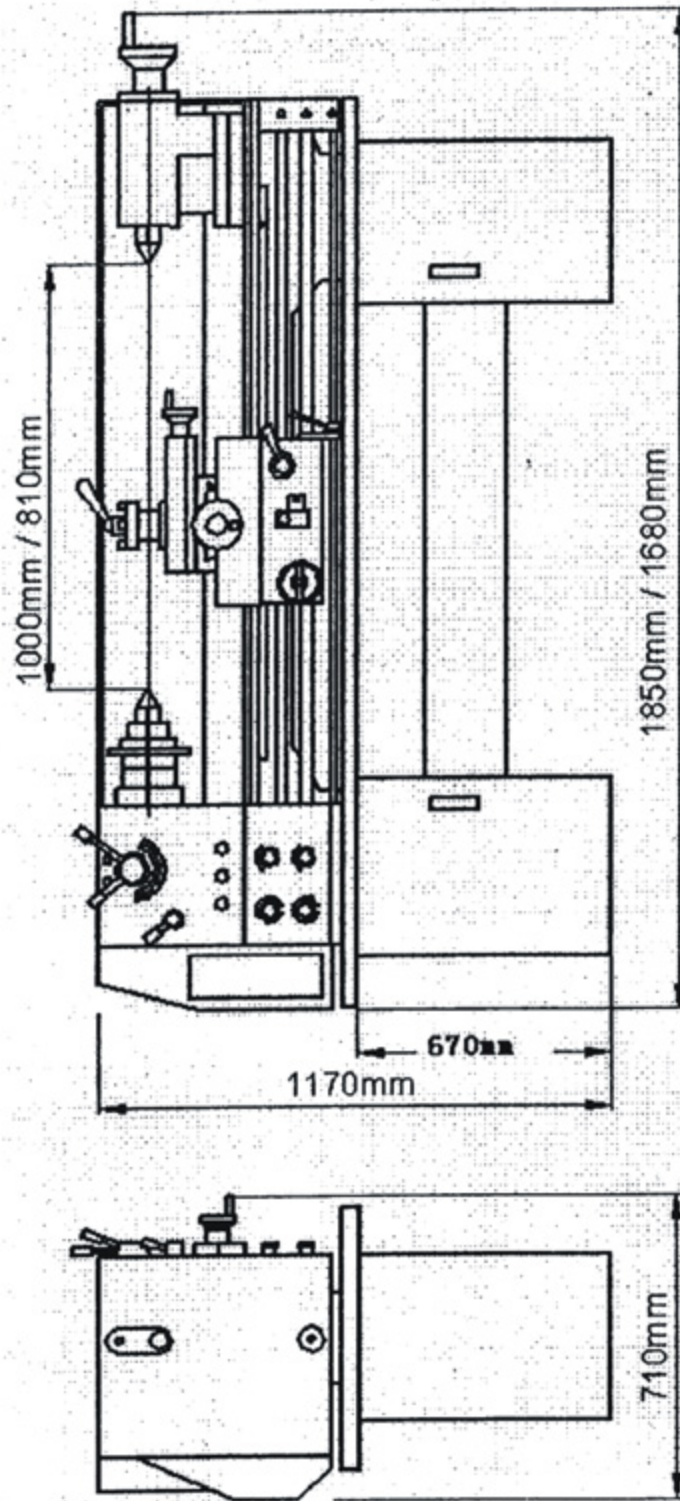


Figure 1: Lathe Exterior Chart

OVERVIEW

Thank you for purchasing this versatile, general purpose engine lathe. It's ideal for machinists, mechanics and repair technicians who depend on the precision and efficiency of a top quality lathe to drill or bore cylinders, cones, steps, end-surfaces or holes on the parts they need. It's also suitable for turning various metric and inch threads and can be used for metal manufacturing applications. Designed to work in smaller spaces, the lathe is easy to operate and features a large spindle bore to handle a variety of drilling/boring tasks.

LIFTING & INSTALLATION

1. Unpack lathe from wooden crate and check the packing list to ensure all parts and accessories are included.
2. Remove protective wrap from the unpainted side of the lathe. Clean the anti-rust oil off all surfaces using a mild commercial solvent, kerosene or diesel fuel.
3. Do not move the saddle and tailstock until the leading tracks are thoroughly cleaned.
4. Properly sling the lathe as shown in **Figure 2** while it is being transported and hoisted into place.
5. **IMPORTANT:** The lathe ways must remain level to ensure precision production work. For proper leveling, follow these steps. Move saddle to headstock until it reaches the end of the lathe ways. Place the level on the apron to form a right angle. Loosen the bolts and adjust the end of the lathe using shims. Repeat steps until both ends of the ways are level, and then tighten the bolts (length direction error $<0.02/1000$; horizontal direction error $<0.04/1000$).

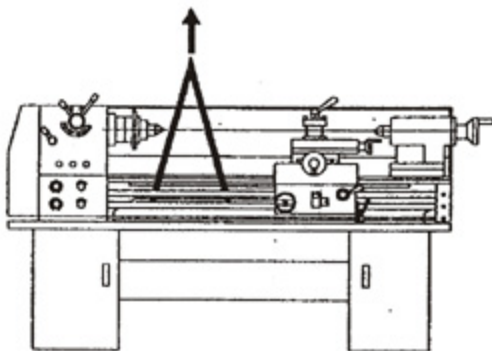


Figure 2: **Hoist lathe and position into place**

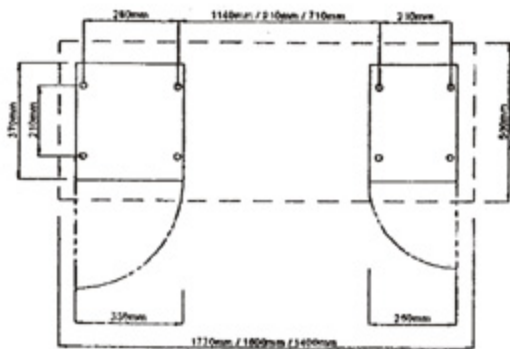


Figure 3: **Fixing dimensions for lathe's stand cabinet**

OPERATING INSTRUCTIONS

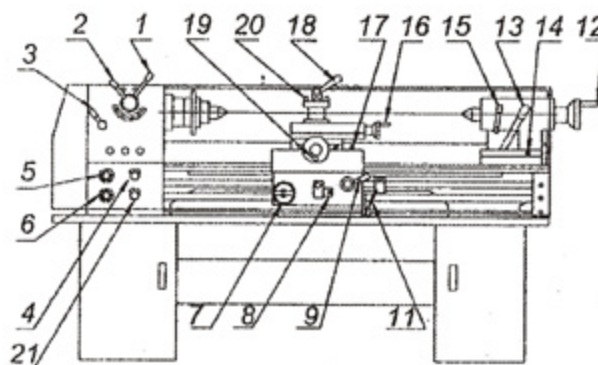


Figure 4: **Operation levers**

Before operating the lathe for the first time, read these instructions carefully, making sure you understand proper operation, adjustments, and maintenance and lubrication schedules.

- A. There are one or more V-belts from the motor to the low speed wheels. Before powering the lathe to the "ON" position, check the V-belt to make sure it's not too tight. Using your finger, press down on the V-belt. It should "give" about 2 inches. This is normal. If the V-belt is too tight, it can damage the bearings and needs to be immediately adjusted.
- B. Give the lathe a trial run to ensure that it is working properly. Simply put the speed change lever in the low speed position and keep the machine running for 20 minutes. If the lathe is operating normally, gradually increase the speed of the spindle to the fastest position (set the feed selection lever in moderate speed). Every spindle speed should be test ran for at least 5 minutes.
CAUTION: Speed can only be changed when the motor comes to a complete stop.

Lathe Operation Levers (see Figure 4)

A. Spindle:

With the help of spindles (1) and (2) and the V-belt, the headstock can achieve speeds from 70 to 2000 rpm (see speed diagram on the headstock). Move the starting lever (11) up and the spindle will turn counter-clockwise. Move the starting lever down and the spindle will turn clockwise.

B. Feed Box:

Select lever (4) for common cutting (on right position) and threading (on left position). Move lever (4) to the blank position in the middle to suspend speed and power to the feed box.

Use levers (5), (6) and (21) to adjust the feed box's output speed. Lever (5) has five positions. Lever (6) also has five positions. Lever (21) has two positions. Move levers (5), (6) and (21) to vary the feed rate (see diagram on left side of the headstock) and for metric and inch threading (see diagram on left side of the feed box).

CAUTION: Speed can only be changed when the spindle comes to a complete stop.

C. Carriage Assembly:

Rotate hand wheel (7) to make the carriage move along the bed-way.

Lever (19) makes the cross-slide move forward or backward.

Lever (16) moves the tool post and small slide. Adjust small slide to any angle to cut threads and process taper parts.

Lever (9) is used for engaging the half-nut for processing threads.

Lever (8) adjusts the feed heading, longitudinal or crossed. Lever (8) has three positions: 1) the neutral or non-combination position, 2) move it up to feed longitudinally, or 3) move it down to cross feed. A safety pin in the lever assembly helps prevent accidental and unexpected closing of the half-nut when the lathe is in a certain feeding state.

Lever (3) changes direction of the feeding movement either longitudinally or crossed when the spindle's moving direction is not changed.

Thread dial (10) makes the half-nut and guide screw close on the same thread when processing threads.

Clamping lever (18) locks the tool post and prevents it from loosening. When loosening the lever, turn the tool post counter-clockwise to change the cutting tools.

D. Tailstock:

Hand wheel (12) feeds or withdraws the tailstock quill. Reverse the hand wheel until it stops to automatically withdraw the using tool. Tailstock is clamped on the bed-way by lever (13). Move lever (13) up to lock the tailstock in position; move it down to unlock.

Adjustable quill clamping lever (15) locks the quill tightly into position, preventing the quill from moving before rotating the hand wheel (12).

Two bolts (14) allow you to move and adjust the tailstock. When set to the correct angle, tighten both bolts.

E. Adjust the clearance of the Cross Slide Nut (see Figure 5):

Simply rotate screw (1) on the nut as shown to move the cross slide and get acceptable clearance for cross feeding.

F. Chuck and Faceplate Mounting (see Figure 6):

The connection between the spindle and the chuck or faceplate is made by the D-Cam lock structure. When mounting, put the 3 pull pins of the chuck or faceplate into the 3 corresponding holes on the spindle face end, then use a square head wrench to turn the 3 cams. Turn the cams clockwise and the chuck or faceplate is locked. When turning the cams counter-clockwise, the chuck or faceplate can be detached.

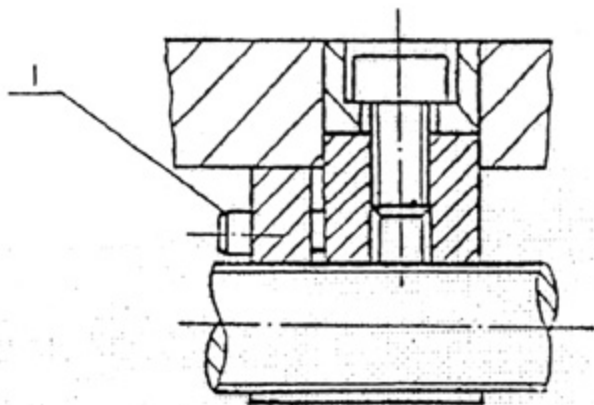


Figure 5: Adjust the clearance of the cross slide nut

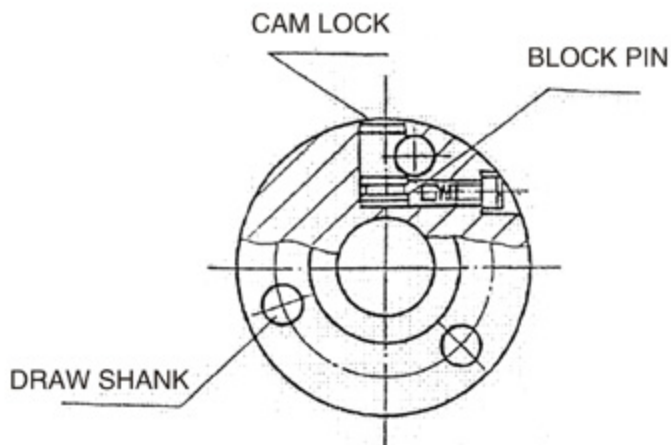


Figure 6: Locked cam structure of the chuck or faceplate

ROUTINE MAINTENANCE

Following these simple maintenance steps will help keep your lathe working properly, precisely and efficiently.

1. Before operation, check the oil indicator to make sure oil level is normal. Lubricate all sliding and rolling parts.
2. Clean the sliding surface and check the felts at each side of the saddle to help avoid injury from flying chips. If they are dirty or damaged, clean or replace them. Clean the guide screw to prevent it from rusting.
3. Periodically wash the headstock, feed box and apron, and change the lubrication oil.
4. Regularly check the motor and adjust the V-belt to help prevent oil leaks.
5. When running the spindle, do not attempt to change speed. This can damage the gears. If you can't move the speed change lever, use your hand to rotate the spindle.
6. Never attempt to change the rotating direction of the motor until the spindle comes to a complete stop.
7. When operating the steady rest or follow rest, the joint between the sliding part and the working part needs to be frequently lubricated.
8. Keep the spindle step, spindle taper and spindle bore smooth to ensure processing precision.

MAIN TECHNICAL SPECIFICATIONS

Major Specifications

| | |
|--------------------------|-----------------|
| Swing over bed | 13" (330mm) |
| Swing over cross slide | 7" (178mm) |
| Swing in gap diameter | 17.72" (450mm) |
| Center height | 6.54" (166mm) |
| Distance between centers | 39.37" (1000mm) |

Headstock

| | |
|-----------------------|-------------|
| Spindle bore | 1.5" (38mm) |
| Taper of spindle bore | 5 M.T. |
| Speed range | 70–2000 rpm |

Gear Change and Feed Box

| | |
|---------------------------|-----------------------|
| Threads imperial pitches | 4–60 TPI |
| Threads metric pitches | 0.4–7 mm |
| Longitudinal feeds metric | 0.0527–1.2912 mm/rev. |
| Cross feeds metric | 0.014–0.3448 mm/rev. |

Tool Post and Small Slide

| | |
|---|----------------|
| Maximum circumgyration angle by tool post | +/- 90° |
| Maximum travel of small slide | 2.99" (76mm) |
| Maximum travel of cross slide | 5.90" (150mm) |
| Maximum travel of saddle | 33.46" (850mm) |

Tailstock

| | |
|-----------------------------------|---------------|
| Diameter of tailstock quill | 1.26" (32mm) |
| Taper of tailstock quill bore | 3 M.T. |
| Maximum travel of tailstock quill | 3.94" (100mm) |

Motor (Comes 220V, 60Hz, 3 Phase as standard)

| | |
|-----------|---|
| Frequency | 50Hz or 60Hz |
| Power | 1.1kw (for 3 phase) or 1.5kw (for single phase) |
| Speed | 1440 rpm |
| Voltage | 400v or 220v or 110v |

Packing Size and Weight

| | |
|-------------------|---|
| Outside dimension | 73.6" x 28.3" x 55.1" (1870 x 720 x 1400) |
| Net weight | 1056 lbs. (480 kg) |
| Gross weight | 1199 lbs. (545 kg) |

LUBRICATION SYSTEM

Before using the lathe for the first time, all moving parts and the sliding surface should be properly oiled. In order to keep the lathe operating at peak performance levels, please follow lubrication guidelines below.

1. Check to see that the headstock, feed box and apron box have a sufficient amount of oil. Once the lathe is in use, change the oil after the first 3 months, then once a year afterwards. Remember to frequently check oil levels using the indicator mark on the oil window. If oil levels are low, refill until oil level returns to its proper level.
2. For change gears, add thick lubricating oil or lubricant grease once a week.
3. All oil cups need to be oiled daily using an oil gun.
4. All other sliding surfaces such as the worm wheel & worm, half nut in apron box and lead screws, etc. must be oiled before and after each operation.
5. No. 20 machine oil is recommended.

ELECTRICAL SYSTEM

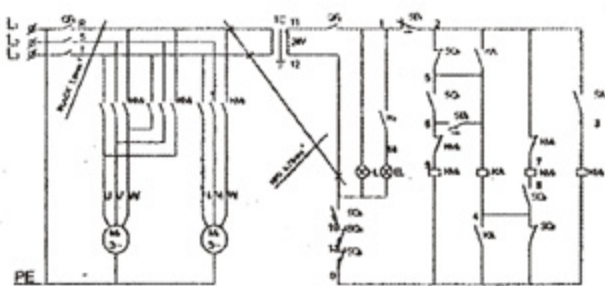
Note: You should always use a licensed electrician when doing electrical work.

For proper connection of the 220v or 400v three phase, 50Hz standard lathe, see **Figure 7**. For proper connection of the 110v or 220v single phase, 50Hz standard lathe, see **Figure 8**. If you need to make changes to the electrical connection, check the connection figure on the motor.

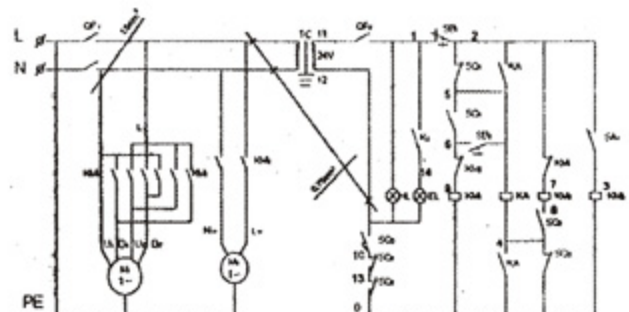
Turn the lathe's electrical power switch to the "OFF" position. The controlling level should remain in the middle so you can stop the lathe.

The electrical control box is located behind the headstock. For the electrical connection, connect power lines with the leading end of the lathe. The 15/30A fuse box must be connected to the machine's power lines. The lathe must also be properly connected to a grounded circuit.

Push the controlling lever up and the spindle will turn clockwise. Push the controlling lever down and the spindle will turn counter-clockwise. If this does not work properly, turn electrical power off and exchange the lines according to the connection figure on the motor.



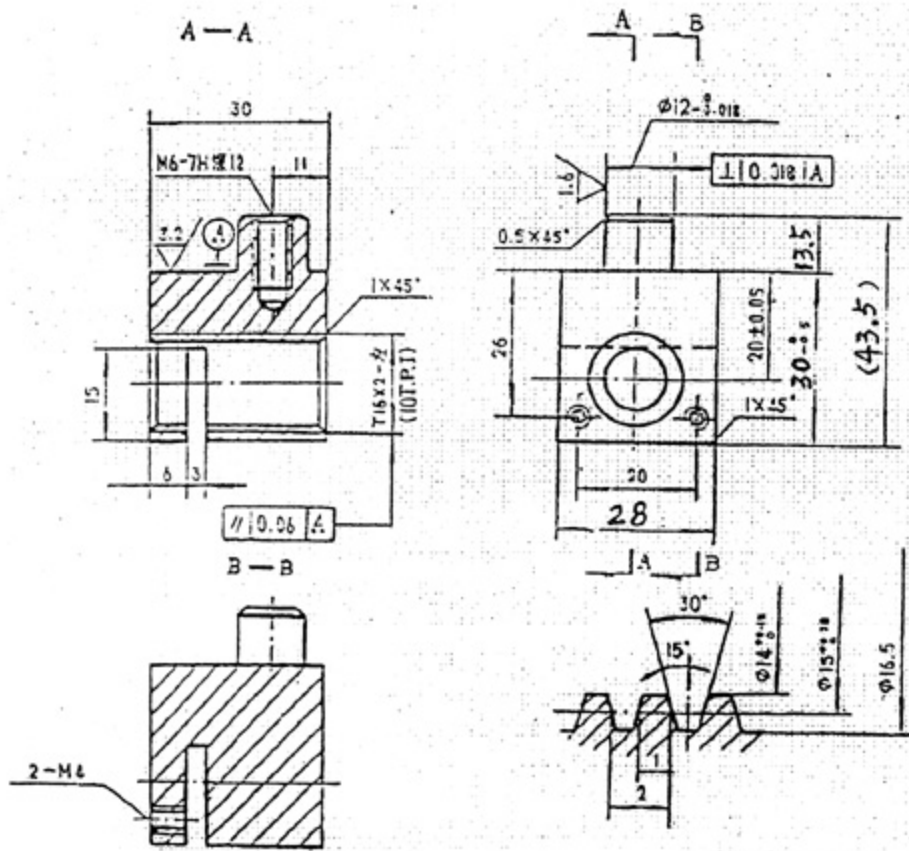
**Figure 7: 220-400v 50Hz/60Hz
Three Phase**



**Figure 8: 110-220v 50Hz/60Hz
Single Phase**

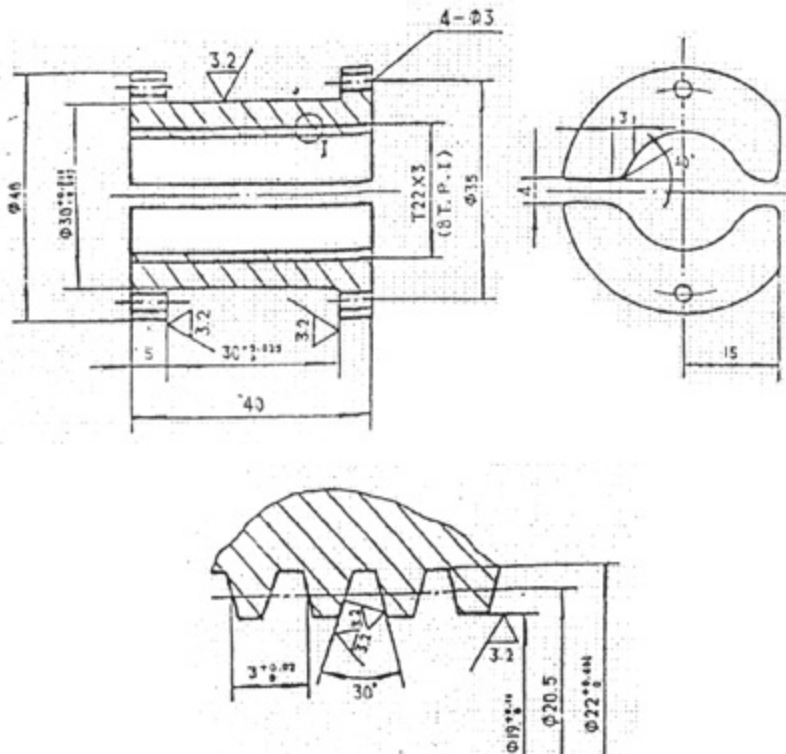
FRETTED PARTS

| NO. | NAME | MATERIAL | MOUNT | NOTE |
|-----|--------------------|-----------|-------|------|
| 1 | Nut of cross slide | ZQSn6-6-3 | 1 | |
| 2 | Half nut | ZQSn6-6-3 | 1 | |



Additional Figure 10: Nut of cross slide

其余 $\nabla 12.5$



Additional Figure 11: Half nut

OPTIONAL ACCESSORIES

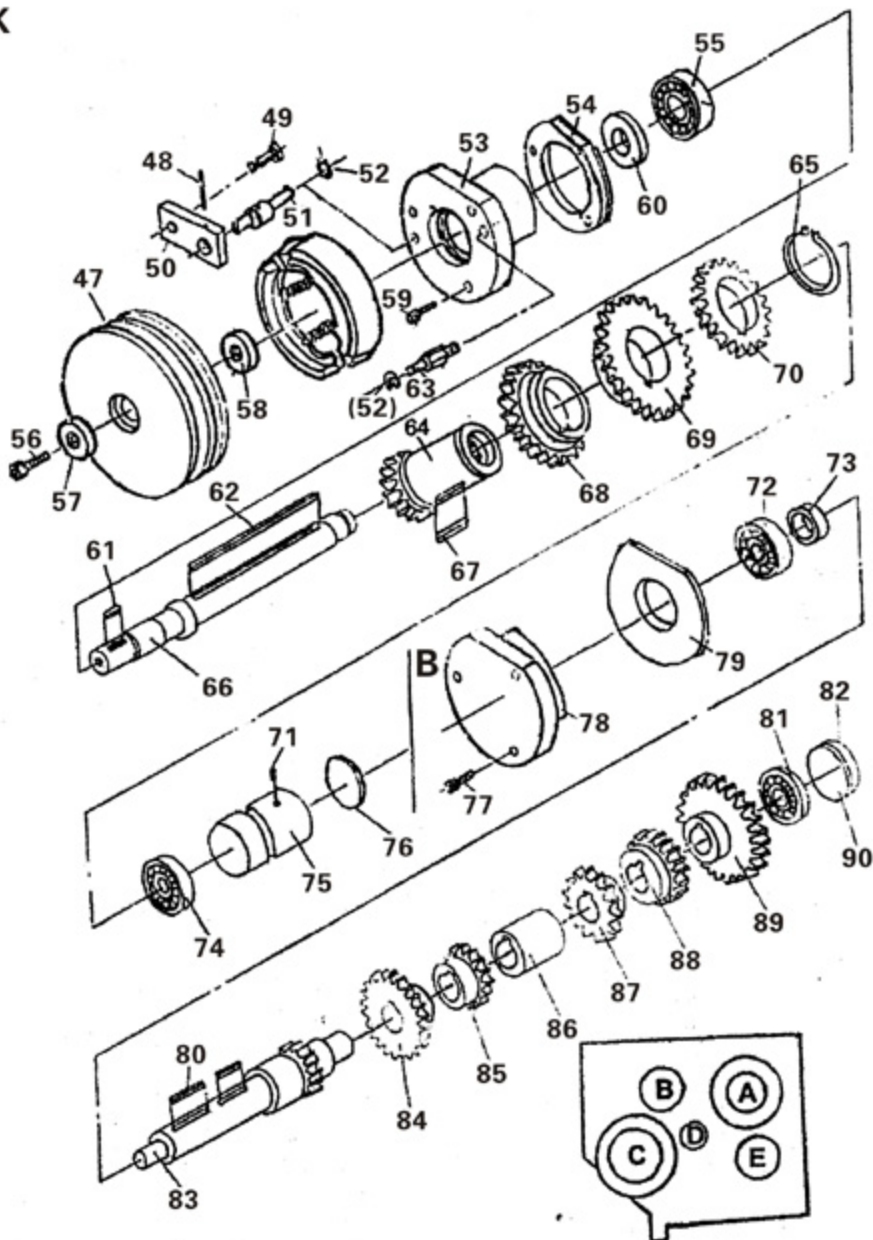
In order to meet the need of the customers, besides the standard accessories, we produce some optional accessories.

Optional Accessories:

| NO. | NAME | AMOUNT | NOTE |
|-----|---------------------|--------|-------------|
| 1 | Steady rest | 1 set | |
| 2 | Follow rest | 1 set | |
| 3 | 4-jaw chuck | 1 set | |
| 4 | Faceplate | 1 set | |
| 5 | Coolant system | 1 set | |
| 6 | Safety chuck cover | 1 set | With switch |
| 7 | Live center M.T. #3 | 1 set | |
| 8 | Foot brake system | 1 set | |

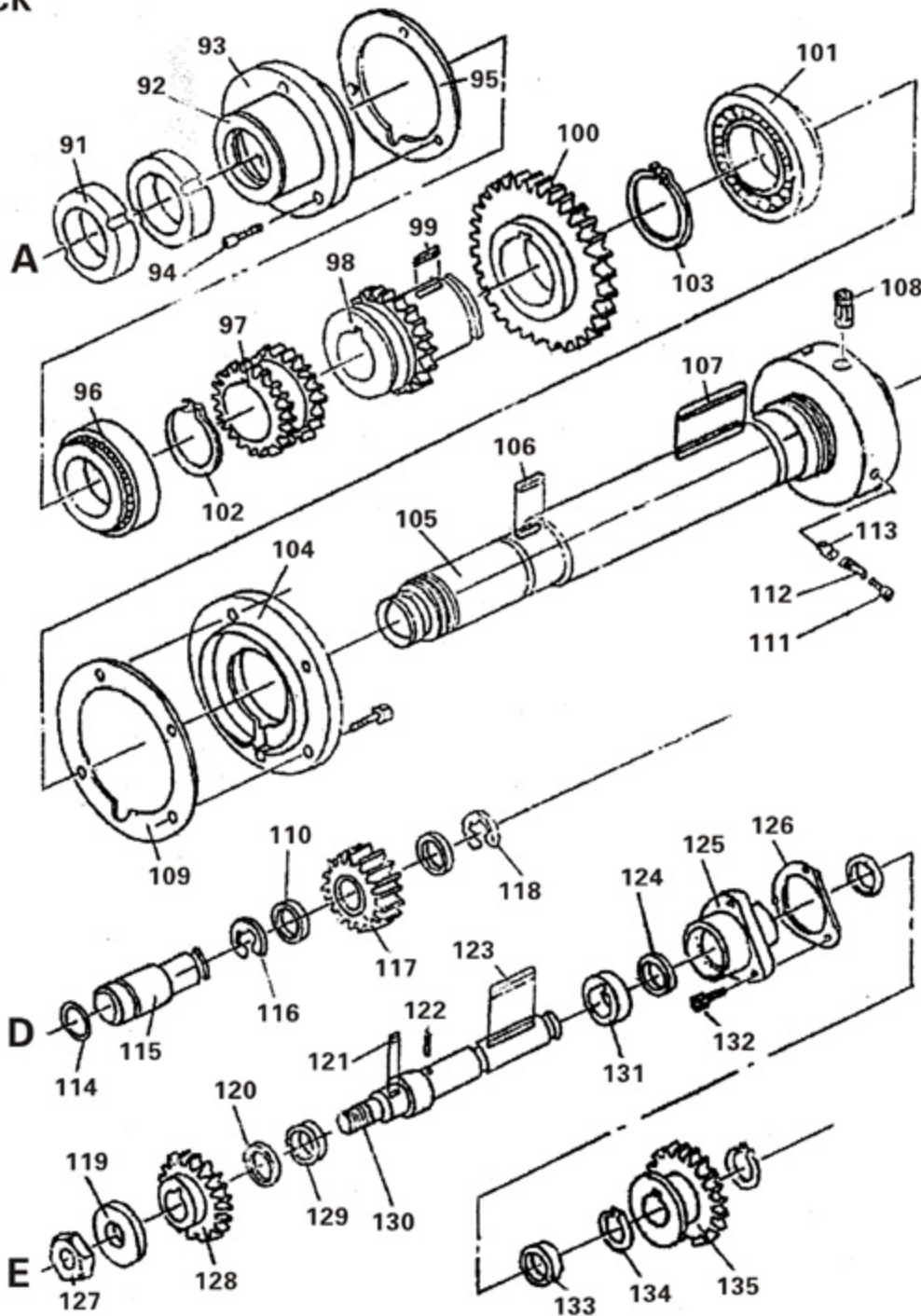
PARTS DIAGRAM AND LIST (FOR CQ6232E)

HEAD STOCK



PARTS DIAGRAM AND LIST (FOR CQ6232E)

HEAD STOCK



| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-----------|---------------|---------------|--------|
| 1 | 04109 | SHIFT LEVER | | |
| 2 | GB879-86 | SCREW | 5 X 32 | |
| 3 | GB70-85 | SCREW | M6 X 18 | |
| 4 | 04127 | CASTING COVER | | |
| 5 | 04506 | GASKET | | |
| 6 | 04232 | SHAFT | | |
| 7 | 04234 | GEAR | | |
| 8 | 04233 | SHIFT LEVER | | |
| 9 | GB1235-76 | O-RING | 14 X 2.4 | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|------------|---------------|---------------|--------|
| 10 | 04107 | MAIN CASTING | | |
| 11 | 04254 | GEAR | | |
| 12 | GB1096-79 | KEY | 5 X 15 | |
| 13 | 04126 | THRIFT COLLAR | | |
| 14 | 04403 | SHIFT FORK | | |
| 15 | GB5783-86 | SCREW | M8 X 45 | |
| 16 | GB6172-86 | NUT | M8 | |
| 17 | GB70-85 | SCREW | M10 X 35 | |
| 18 | GB78-85 | SCREW | M8 X 12 | |
| 19 | 04258 | WASHER | | |
| 20 | GB1235-76 | O-RING | 30 X 3.1 | |
| 21 | 04118 | HANDLE | | |
| 22 | GB70-85 | SCREW | M6 X 20 | |
| 23 | JB1342-76 | LEVER SLEEVE | M8 X 40 | |
| 24 | 04248 | HANDLE | | |
| 25 | 04402 | SHIFT FORK | | |
| 26 | 04255 | SHAFT | | |
| 27 | 04235 | COLLAR | | |
| 28 | GB308-84 | BELL STEEL | 6 | |
| 29 | GB2089-80 | SPRING | 1 X 6 X 7 | |
| 30 | 04249 | HANDLE | | |
| 31 | 04117 | HANDLE | | |
| 32 | 04111 | SHIFT SHAFT | | |
| 33 | GB879-86 | PIN | 4 X 18 | |
| 34 | GB1235-76 | O-RING | 10 X 1.9 | |
| 35 | GB78-85 | SCREW | M6 X 16 | |
| 36 | GB1235-76 | O-RING | 20 X 2.4 | |
| 37 | GB819-85 | SCREW | M4 X 8 | |
| 38 | 04248-1 | HANDLE | | |
| 39 | 04119 | HANDLE COVER | | |
| 40 | GB78-85 | SCREW | M8 X 8 | |
| 41 | GB894.1-86 | CIRCLIP | 30 | |
| 42 | GB78-85 | SCREW | M6 X 22 | |
| 43 | GB2089-80 | SPRING | 1 X 6 X 20 | |
| 44 | GB78-85 | SCREW | M8 X 10 | |
| 45 | 04120 | HANDLE | | |
| 46 | GB308-84 | BELL STEEL | 5 | |
| 47 | GB78-85 | SCREW | M6 X 10 | |
| 48 | 04122 | PULLEY | | |
| 49 | GB879-86 | PIN | 5 X 25 | |
| 50 | 11212 | PIN | | |
| 51 | 11210 | ROCKER | | |
| 52 | 11209 | POCKER SHAFT | | |
| 53 | GB894.1-86 | CIRCLIP | 8 | |
| 54 | 04124 | COVER | | |
| 55 | 04501-1 | GASKET | | |
| 56 | GB276-98 | THRUST | 105E | |
| 57 | GB70-85 | SCREW | M8 X 15 | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

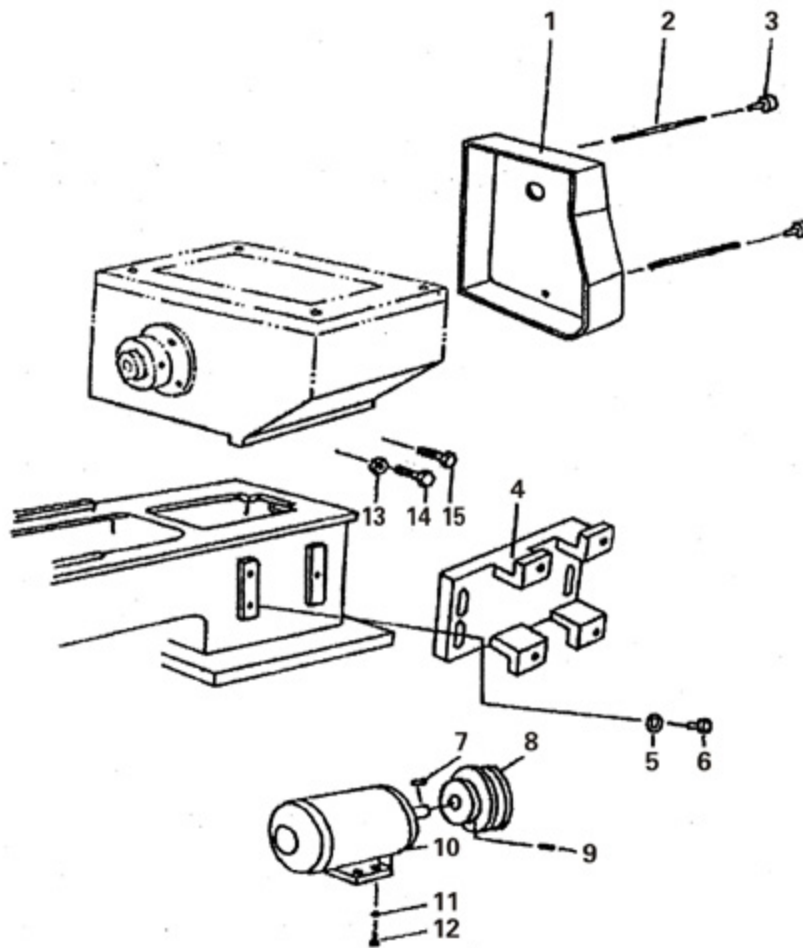
| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|------------|--------------|----------------|--------|
| 58 | 04253 | WASHER | | |
| 59 | 04216 | WASHER | | |
| 60 | GB70-85 | SCREW | M6 X 16 | |
| 61 | HG4-692-67 | OIL SEAL | SD25 X 40 X 10 | |
| 62 | GB1096-79 | KEY | 8 X 20 | |
| 63 | GB1096-79 | KEY | 6 X 120 | |
| 64 | 11211 | SHAFT | | |
| 65 | GB894.1-86 | CIRCLIP | 35 | |
| 66 | 04252 | SHAFT | | |
| 67 | 04217 | COLLAR | 2 X 2 | |
| 68 | GB1096-79 | KEY | 5 X 50 | |
| 69 | 04218 | GEAR | 2 X 29 | |
| 70 | 04219 | GEAR | 2 X 10 | |
| 71 | 04220 | GEAR | 2 X 38 | |
| 72 | GB78-85 | SCREW | M8 X 16 | |
| 73 | GB276-88 | THRUST | 204E | |
| 74 | 04211 | WASHER | | |
| 75 | GB276-88 | THRUST | 203 | |
| 76 | 04106 | FRONT PLUG | | |
| 77 | GB1235-76 | O-RING | 40 X 3.1 | |
| 78 | GB70-85 | SCREW | M4 X 12 | |
| 79 | 04123 | BEHIND COVER | | |
| 80 | 04502 | GASKET | | |
| 81 | GB1096-79 | KEY | 6 X 55 | |
| 82 | GB276-88 | THRUST | 204D | |
| 83 | GB1235-76 | O-RING | 47 X 3.1 | |
| 84 | 04212 | SHAFT | 2.25 X 16 | |
| 85 | 04210 | GEAR | 2 X 51 | |
| 86 | 04209 | GEAR | 2 X 43 | |
| 87 | 04221 | WASHER | | |
| 88 | 04222 | GEAR | 2 X 26 | |
| 89 | 04223 | GEAR | 2 x 34 | |
| 90 | 04224 | GEAR | 2.25 x 5 | |
| 91 | 04225 | FRONT PLUG | | |
| 92 | 04208 | NUT | | |
| 93 | 04102 | COLLAR | | |
| 94 | 04103 | BEHIND COVER | | |
| 95 | GB78-85 | SCREW | M6 x 25 | |
| 96 | 04503 | GASKET | | |
| 97 | GB297-89 | THRUST | 7210E | |
| 98 | 04207 | GEAR | 2 x 37 | |
| 99 | 04227 | GEAR | | |
| 100 | GB1096-79 | KEY | 8 x 18 | |
| 101 | 04226 | GEAR | | |
| 102 | GB297-89 | THRUST | 7212D | |
| 103 | GB894.1-86 | CIRCLIP | 50 | |
| 104 | GB894.1-86 | CIRCLIP | 72 | |
| 105 | 04108 | FRONT COVER | | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|------------|-----------|---------------|--------|
| 106 | 04228 | SPINDLE | | |
| 107 | GB1096-79 | KEY | 4 x 40 | |
| 108 | GB1096-79 | KEY | 8 x 85 | |
| 109 | 04231 | CAM | | |
| 110 | 04505 | GASKET | | |
| 111 | GB276-88 | THRUST | 7000101E | |
| 112 | GB70-86 | SCREW | M8 x 18 | |
| 113 | 04229 | SPINDLE | | |
| 114 | 04230 | PIN | | |
| 115 | GB1235-76 | O-RING | 25 x 2.4 | |
| 116 | 04238 | SHAFT | | |
| 117 | GB893.1-86 | CIRCLIP | 42 | |
| 118 | 04237 | WASHER | | |
| 119 | GB893.1-86 | CIRCLIP | 42 | |
| 120 | 04206 | WASHER | | |
| 121 | 04204 | WASHER | | |
| 122 | GB1096-79 | KEY | 5 x 18 | |
| 123 | GB879-86 | PIN | 3 x 10 | |
| 124 | GB1096-79 | KEY | 6 x 50 | |
| 125 | 04401 | COLLAR | | |
| 126 | 04101 | COLLAR | | |
| 127 | 04504 | GASKET | | |
| 128 | 04205 | GEAR | | |
| 129 | 04507 | OIL SEAL | | |
| 130 | 04239 | SHAFT | | |
| 131 | 04203 | WASHER | | |
| 132 | GB70-85 | SCREW | M5 x 16 | |
| 133 | 04202 | WASHER | | |
| 134 | GB894.1-86 | CIRCLIP | 20 | |
| 135 | 04201 | GEAR | | |
| 136 | GB117-86 | TAPER PIN | 6 x 60 | |
| 137 | GB70-85 | SCREW | M6 x 50 | |
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PARTS DIAGRAM AND LIST (FOR CQ6232E)

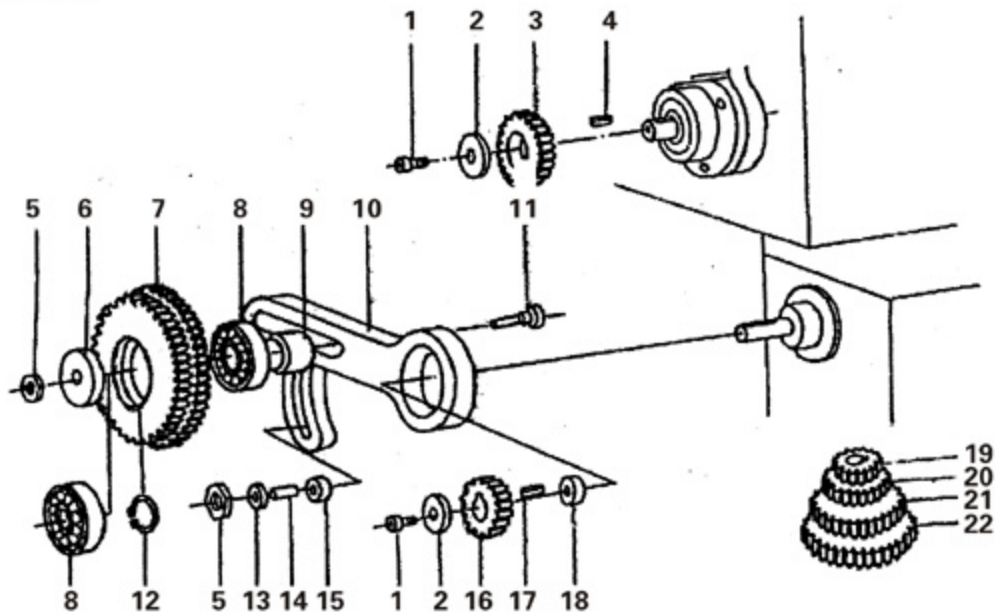
MOTOR & CHANGE GEAR BOX



| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-----------|---------|---------------|--------|
| 1 | 1021 | COVER | | |
| 2 | 1002 | SCREW | | |
| 3 | 1001 | NUT | | |
| 4 | 1024 | TRESTLE | | |
| 5 | 1013 | WASHER | | |
| 6 | GB5781-86 | SCREW | | |
| 7 | GB1096-86 | KEY | 8 X 40 | |
| 8 | 1003A5 | PULLEY | | |
| 9 | GB78-85 | SCREW | M6 X 8 | |
| 10 | Y90S-4TH | MOTOR | | |
| 11 | GB97.1-85 | SPACER | Φ8 | |
| 12 | GB5783-86 | SCREW | | |
| 13 | GB41-86 | NUT | M6 | |
| 14 | GB5781-86 | SCREW | M8 X 45 | |
| 15 | GB70-85 | SCREW | M8 X 30 | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

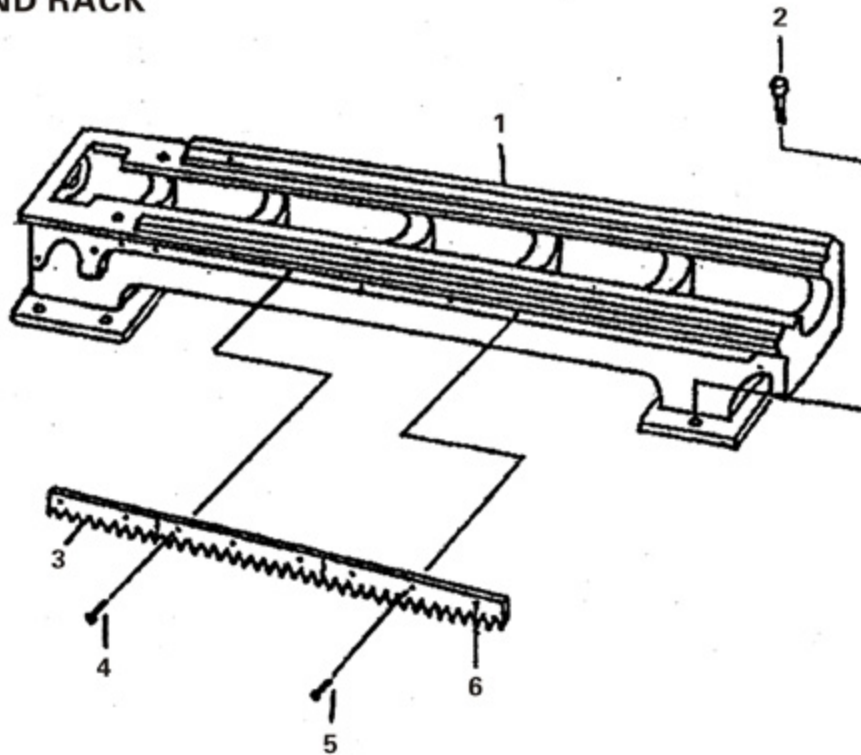
CHANGE GEAR



| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|------------|-------------|---------------|--------|
| 1 | GB70-85 | SCREW | M6 X 12 | |
| 2 | 2003 | WASHER | | |
| 3 | 2002B | GEAR | | |
| 4 | GB1096-79 | KEY | C5 X 8 | |
| 5 | GB41-85 | NUT | M10 | |
| 6 | 3036B | WASHER | | |
| 7 | 3038B | GEAR | | |
| 8 | GB26-89 | BEARING | 103 | |
| 9 | 3037B | COLLAR | | |
| 10 | 3043B | QUADRANT | | |
| 11 | 3035B | SCREW | | |
| 12 | GB893.1-86 | CIRCLIP | 35 | |
| 13 | GB97.1-85 | WASHER | 10 | |
| 14 | GB73-85 | SCREW | M10 X 60 | |
| 15 | 3048B | WASHER | | |
| 16 | 3039B | GEAR | | |
| 17 | GB1096-79 | KEY | 5 X 18 | |
| 18 | 3040 | WASHER | | |
| 19 | 3076C | CHANGE GEAR | | |
| 20 | 3075C | CHANGE GEAR | | |
| 21 | 3077C | CHANGE GEAR | | |
| 22 | 3078C | CHANGE GEAR | | |

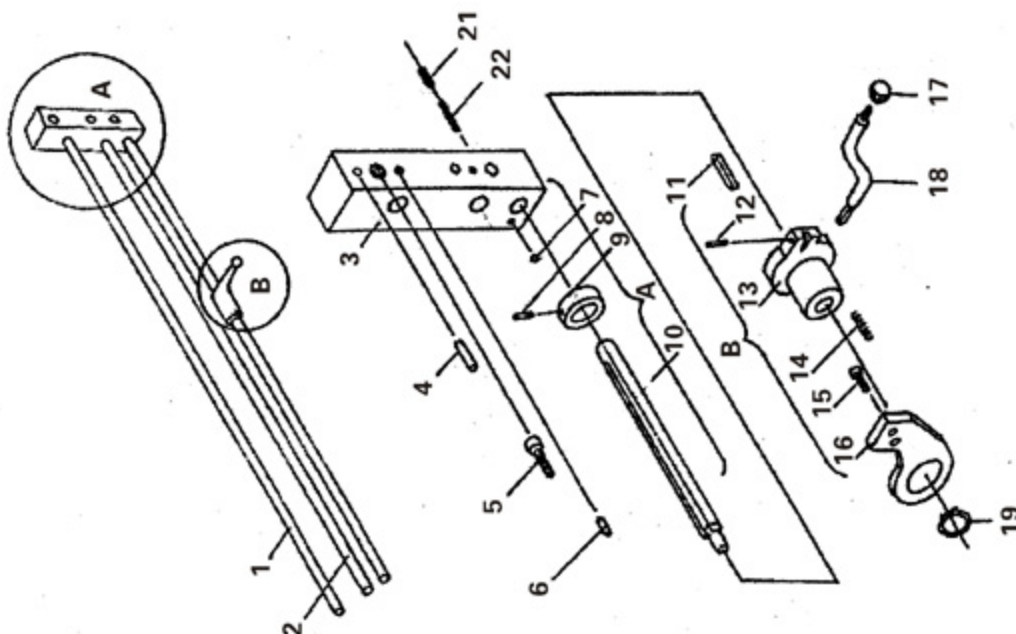
PARTS DIAGRAM AND LIST (FOR CQ6232E)

BED WAY AND RACK



| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-----------|-----------|---------------|--------|
| 1 | 1004 | LATHE BED | | |
| 2 | GB5783-86 | SCREW | M12 X 40 | |
| 3 | 1009 | RACK GEAR | | |
| 4 | GB70-85 | SCREW | M6 X 15 | |
| 5 | GB879-86 | PIN | 5 X 20 | |
| 6 | 1011 | RACK GEAR | | |

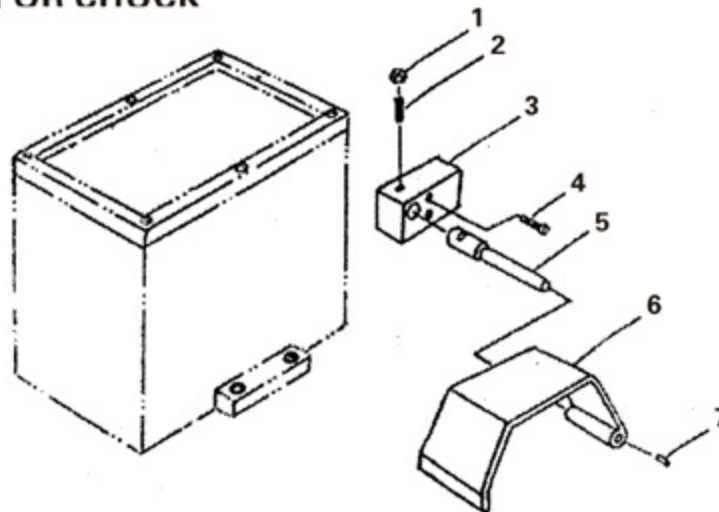
LEADSCREW, FEED ROD AND SWITCH ROD



PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|--------------|-------------|---------------|--------|
| 1 | 1005B | GUIDE SCREW | | |
| 2 | 1006B | ROD | | |
| 3 | 1012 | BRACKEET | | |
| 4 | GB118-86 | PIN | 6 X 65 | |
| 5 | GB70-85 | SCREW | M8 X 60 | |
| 6 | GB1155-79 | OIL CUP | 6 | |
| 7 | GB308-89 | BALL | 6 | |
| 8 | GB879-86 | PIN | 4 X 20 | |
| 9 | 1035 | BUSHING | | |
| 10 | 1010 | FEED ROD | | |
| 11 | J31-3A | KEY | 5 X 5 X 32 | |
| 12 | GB879-86 | PIN | 4 X 20 | |
| 13 | 1014 | BRACKET | | |
| 14 | GB2089-80 | SPRING | 1.2 X 8 X 10 | |
| 15 | GB70-85 | SCREW | M6 X 15 | |
| 16 | 1015 | BRACKET | | |
| 17 | GB4141.11-84 | HANDLE BALL | M10 X 32 | |
| 18 | 1016 | HANDLE | | |
| 19 | GB894.1-86 | CIRCLIP | 32 | |
| 20 | GB2089-80 | SPRING | 1 X 5 X 30 | |
| 21 | GB71-85 | SCREW | M8 X 10 | |

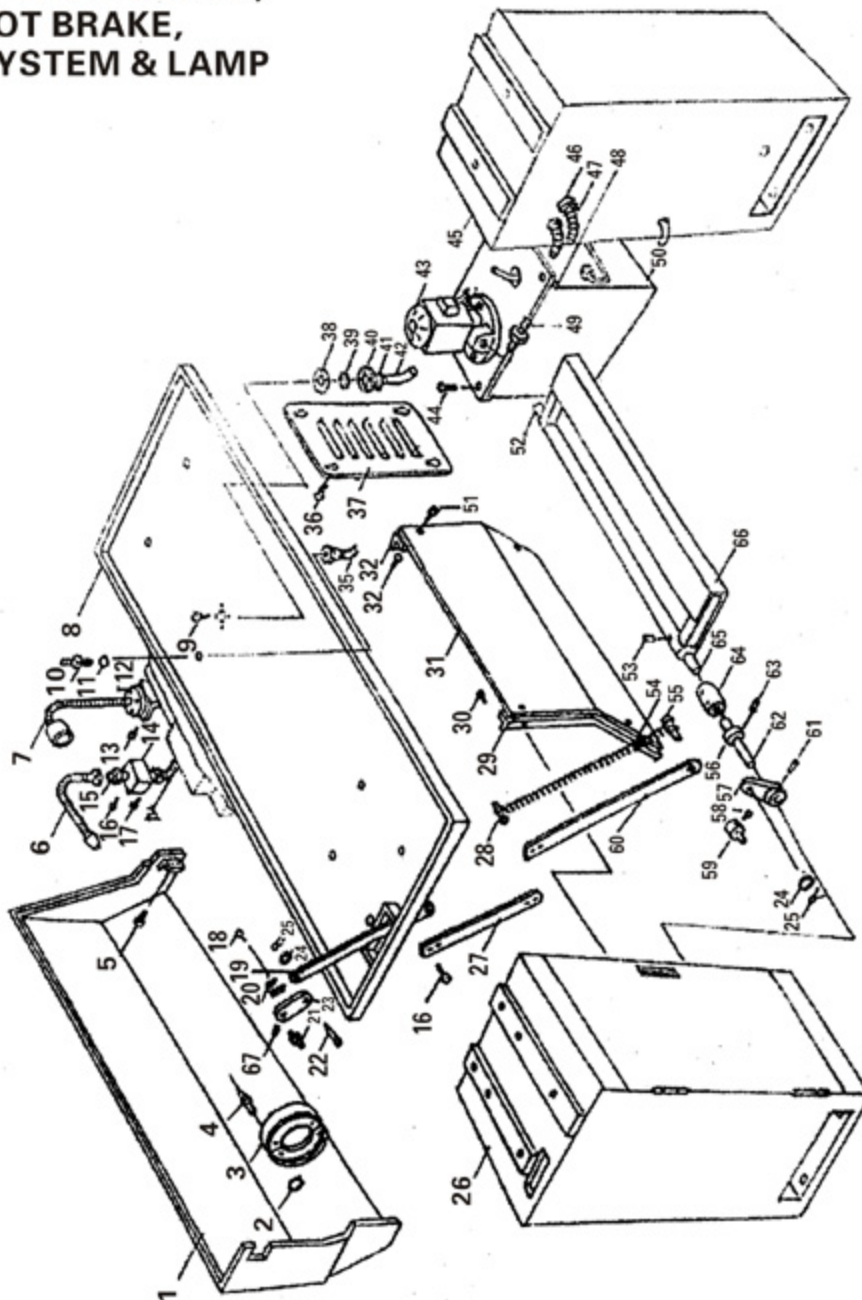
SAFETY COVER FOR CHUCK



| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|----------|------------------|---------------|--------|
| 1 | GB41-86 | NUT | M6 | |
| 2 | GB75-85 | SCREW | M6 X 16 | |
| 3 | 8901 | SWITCH BOX | | |
| 4 | GB70-85 | SCREW | M6 X 45 | |
| 5 | 8902 | SHAFT | | |
| 6 | 8903 | PRETECTING COVER | | |
| 7 | GB79-86 | PIN | 4 X 12 | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

OIL TRAY, SPLASH GUARD,
STANDS FOOT BRAKE,
COOLANT SYSTEM & LAMP



| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|--------------|-----------------|---------------|--------|
| 1 | 1023 | CHIP GUARD | | |
| 2 | GB894.1-86 | OPEN CIRCLIP | 8 | |
| 3 | | BRACK BLOCK | | |
| 4 | 1040 | SHAFT | | |
| 5 | GB70-85 | SCREW | M6 X 16 | |
| 6 | JB/GQ0435-89 | COOLANT PIPE | G3"/8 X 300 | |
| 7 | | WORK LIGHT | | |
| 8 | 1022 | OIL PAN | | |
| 9 | GB70-85 | SCREW | M5 X 12 | |
| 10 | 9206 | PIPE CENNECTING | | |
| 11 | 9207 | WASHER | | |

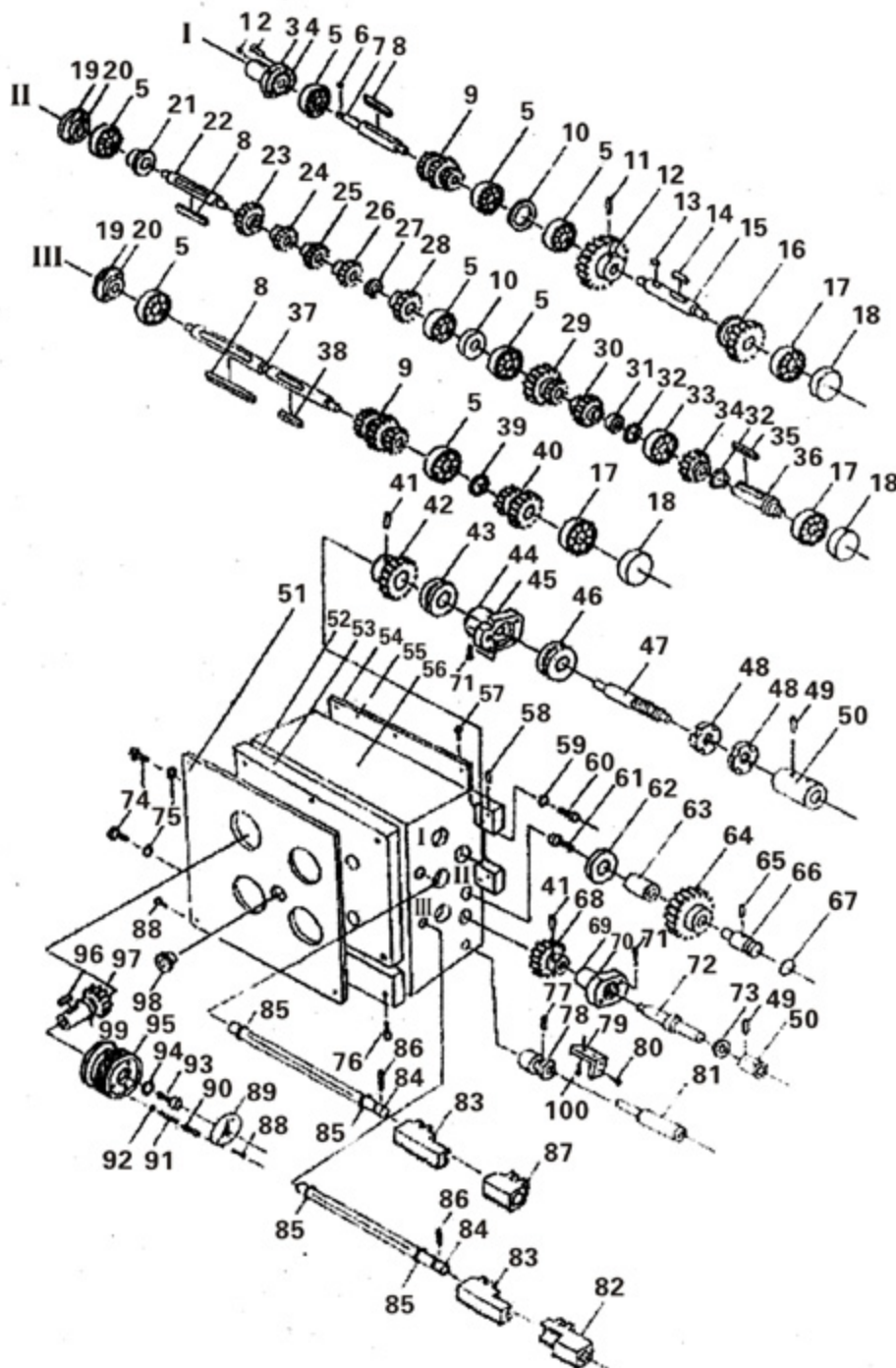
PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|--------------|---------------|---------------|--------|
| 12 | 7015 | BRACKET | | |
| 13 | GB70-85 | SCREW | M5 X 12 | |
| 14 | 9208 | BRACKET | | |
| 15 | 06011A | SHAFT | | |
| 16 | GB70-85 | SCREW | M6 X 12 | |
| 17 | GB70-85 | SCREW | M8 X 35 | |
| 18 | GB818-85 | SCREW | M4 X 10 | |
| 19 | 1043 | DRAW ROD | | |
| 20 | 1053 | BRACKET | | |
| 21 | 1042 | PIVOT | | |
| 22 | GB882-67 | PIN | 8 X 20 | |
| 23 | 1041 | SHIRTET | | |
| 24 | GB97.1-85 | WASHER | 8 | |
| 25 | GB91-86 | OPEN CLIP | 2.5 X 16 | |
| 26 | 8400 | LEFT CABINET | | |
| 27 | 1044 | DRAW ROD | | |
| 28 | GB70-85 | SCREW | M10 X 30 | |
| 29 | 8602 | LEFT BRACKET | | |
| 30 | GB70-85 | SCREW | M5 X 16 | |
| 31 | 8601 | BACK PLATE | | |
| 32 | GB41-86 | NUT | M6 | |
| 33 | 8603 | RIGHT BRACKET | | |
| 34 | JB/GQ0435-89 | COOLANT PIPE | G3"/8 X 800 | |
| 35 | JB/GQ0435-89 | COOLANT PIPE | G3"/8 X 800 | |
| 36 | GB818-86 | SCREW | M6 X 12 | |
| 37 | 6201A | COVER | | |
| 38 | 9205 | PAPET LINING | | |
| 39 | 9203 | FILTER | | |
| 40 | 9204 | PIPE | | |
| 41 | 2J51002-87 | HOOPING | 20 | |
| 42 | SG79-75 | PINE | 16 X 1000 | |
| 43 | GB-6B | COOLANT | | |
| 44 | GB70-85 | SCREW | M5 X 10 | |
| 45 | 8500 | RIGHT CABINET | | |
| 46 | M16-15 | PIPE | | |
| 47 | JB/GQ0574-85 | METAL PIPE | 8 X 800 | |
| 48 | 9210 | COVER | | |
| 49 | 9206 | PIPE | | |
| 50 | 9209 | COLLANT BOX | | |
| 51 | GB70-85 | SCREW | M6 X 16 | |
| 52 | 1051 | SHAFT | | |
| 53 | GB879-86 | SPRING PIN | 5 X 25 | |
| 54 | 1048 | SPRING | | |
| 55 | 1047 | SHAFT | | |
| 56 | GB8-85 | CIRCLIP | 20 | |
| 57 | 1045 | SHIFTER | | |
| 58 | 1052 | SHAFT | | |
| 59 | GB70-85 | SCREW | M6 X 30 | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|----------|-------------------|---------------|--------|
| 60 | 1054 | DREW ROD | | |
| 61 | GB879-86 | SPRING PIN | 5 X 40 | |
| 62 | 1049-1 | SHAFT | | |
| 63 | GB79-88 | SCREW | M6 X 12 | |
| 64 | 1049-3 | CONNECTING SLEEVE | | |
| 65 | 1049-2 | SHAFT | | |
| 66 | 1050 | PADDLE | | |
| 67 | GB879-86 | SPRING PIN | 4 X 25 | |

FEED BOX



PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|------------|----------|---------------|--------|
| 1 | GB1155-86 | OIL CUP | 6 | |
| 2 | GB70-85 | SCREW | M6 X 12 | |
| 3 | 3034B | COVER | | |
| 4 | 3035C | OIL SEAL | | |
| 5 | GB276-89 | BEARING | 103 | |
| 6 | GB1096-79 | KEY | 5 X 13 | |
| 7 | 3041B | SHAFT | | |
| 8 | GB1096-79 | KEY | 6 X 90 | |
| 9 | 3005B | GEAR | | |
| 10 | 3066B | WASHER | | |
| 11 | GB71-85 | SCREW | M6 X 8 | |
| 12 | 3027C | GEAR | | |
| 13 | GB1096-79 | KEY | 6 X 15 | |
| 14 | GB1096-79 | KEY | 6 X 35 | |
| 15 | 3067B | SHAFT | | |
| 16 | 3025C | GEAR | | |
| 17 | GB276-89 | BEARING | 102 | |
| 18 | 3017B | COVER | | |
| 19 | 3044B | COVER | | |
| 20 | 3046B | OIL SEAL | | |
| 21 | 3045B | WASHER | | |
| 22 | 3033B | SHAFT | | |
| 23 | 3029B | GEAR | | |
| 24 | 3031B | GEAR | | |
| 25 | 3032B | GEAR | | |
| 26 | 3003B | GEAR | | |
| 27 | 3030B | WASHER | | |
| 28 | 3002B | GEAR | | |
| 29 | 3026C | GEAR | | |
| 30 | 3007C | GEAR | | |
| 31 | 3008C | WASHER | | |
| 32 | GB893.1-86 | CIRCLIP | 35 | |
| 33 | GB276-89 | BEARING | 70001103 | |
| 34 | 3009B | GEAR | | |
| 35 | GB1096-79 | KEY | C5 X 40 | |
| 36 | 3019C | SHAFT | | |
| 37 | 3004B | SHAFT | | |
| 38 | GB1096-79 | KEY | 5 X 35 | |
| 39 | GB894.1-86 | CIECLIP | 17 | |
| 40 | 3006C | GEAR | | |
| 41 | GB117-86 | PIN | 5 X 25 | |
| 42 | 3018C | GEAR | | |
| 43 | GB301-86 | BEARING | 8103 | |
| 44 | 3084D | COVER | | |
| 45 | 3068D | OIL SEAL | | |
| 46 | GB301-84 | BEARING | 8104 | |
| 47 | 3021C | SHAFT | | |
| 48 | GB812-88 | NUT | M20 X 1.5 | |

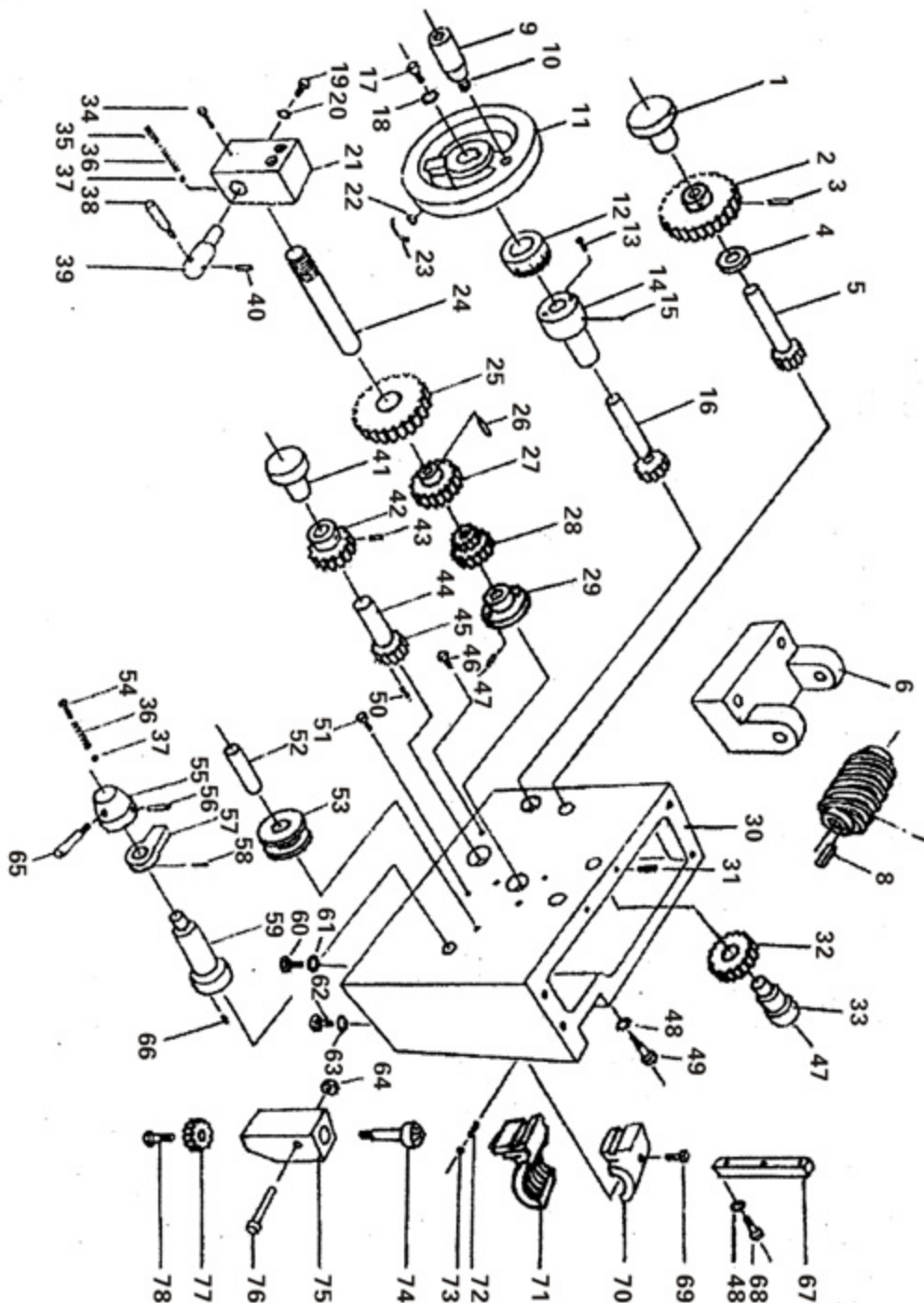
PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-------------|------------------|---------------|--------|
| 49 | GB117-86 | PIN | 5 X 25 | |
| 50 | 3020C | BUSHING | | |
| 51 | 3060E | FASICA | | |
| 52 | 3071B | OIL SEAL | | |
| 53 | 3059B | COVER | | |
| 54 | 3042C | COVER | | |
| 55 | 3070C | OIL SEAL | | |
| 56 | 3001D | GEAR BOX | | |
| 57 | GB68-85 | SCREW | M6 X 12 | |
| 58 | GB879-86 | PIN | 5 X 25 | |
| 59 | GB93-87 | SPRING WASHER | 10 | |
| 60 | GB70-85 | SCREW | M10 X 30 | |
| 61 | GB70-85 | SCREW | M6 X 10 | |
| 62 | GB892-86 | WASHER | 6 X 32 X 5 | |
| 63 | 3024C | BUSHING | | |
| 64 | 3016C | GEAR | | |
| 65 | GB71-85 | SCREW | M6 X 16 | |
| 66 | 3015C | SHAFT | | |
| 67 | GB3452.1-82 | OIL SEAL | 22 X 2.65 | |
| 68 | 3014C | GEAR | | |
| 69 | 3022F | COVER | | |
| 70 | 3086D | OIL SEAL | | |
| 71 | GB70-85 | SCREW | M6 X 25 | |
| 72 | 3013E | SHAFT | | |
| 73 | GB9877.1-89 | OIL SEAL | 18 X 30 X 10 | |
| 74 | GB1071-77 | SCREW | M16 X 1.5 | |
| 75 | GB97.1-86 | WASHER | 16 | |
| 76 | GB70-85 | SCREW | M8 X 15 | |
| 77 | GB71-85 | SCREW | M6 X 10 | |
| 78 | 3012D | POSITION PIEC | | |
| 79 | 7003B | SUPPORT | | |
| 80 | GB818-85 | SCREW | M4 X 20 | |
| 81 | 3011D | SHAFT | | |
| 82 | 3050C | GEAR RACK | | |
| 83 | 3049C | GEAR RACK | | |
| 84 | 3089 | SHAFT | | |
| 85 | GB1235-85 | OIL SEAL | 12 X 1.8 | |
| 86 | GB75-85 | SCREW | M4 X 6 | |
| 87 | 3062C | GEAR RACK | | |
| 88 | GB818-85 | SCREW | M3 X 6 | |
| 89 | 2060 | INDICATION PLATE | | |
| 90 | GB77-85 | SCREW | M8 X 6 | |
| 91 | GTB2089-80 | SPRING | 1 X 5 X 25 | |
| 92 | GB308-86 | STEEL BALL | Φ5 | |
| 93 | GB70-85 | SCREW | M6 X 10 | |
| 94 | GB96-85 | WASHER | 6 | |
| 95 | 3054F | HAND WHEEL | | |
| 96 | GB1096-79 | KEY | 5 X 8 | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-------------|------------|---------------|--------|
| 97 | 3088 | GEAR | | |
| 98 | GB1160.1-89 | OIL WINDOW | A12 | |
| 99 | GB1235-86 | OIL SEAL | 16 X 2.4 | |

APRON BOX



PARTS DIAGRAM AND LIST (FOR CQ6232E)

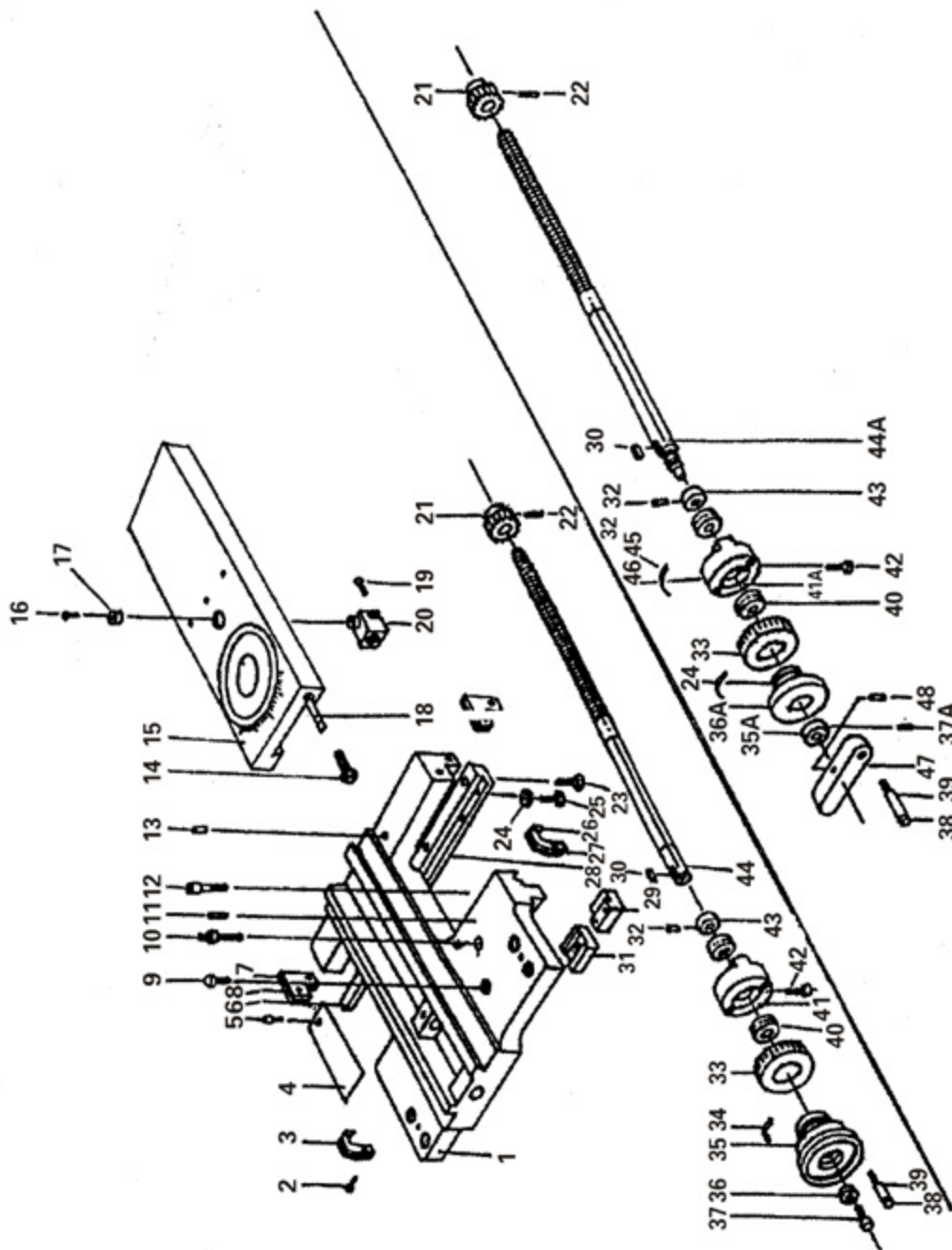
| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-----------|-------------|---------------|--------|
| 1 | 4026 | BUSHING | | |
| 2 | 4029 | GEAR | | |
| 3 | GB879-86 | PIN | 5 X 30 | |
| 4 | 4027 | SPACE | | |
| 5 | 4028 | GEAR SHAFT | | |
| 6 | 4008 | WORM AME | | |
| 7 | 4009 | WORM | | |
| 8 | GB1096-79 | FLAT KEY | B5 X 36 | |
| 9 | 4032 | HANDLE | | |
| 10 | 4033 | LEVER | | |
| 11 | 4034 | HAND WHEEL | | |
| 12 | 4036 | INDEX RING | | |
| 13 | GB70-85 | SCREW | M6 X 20 | |
| 14 | 4031 | BRACKET | | |
| 15 | GB1155-79 | OIL CUP | 6 | |
| 16 | 4030 | GEAR SHAFT | | |
| 17 | GB70-85 | SCREW | M6 X 12 | |
| 18 | 4035 | WASHER | | |
| 19 | GB70-85 | SCREW | M6 X 10 | |
| 20 | 4038 | WASHER | | |
| 21 | 4039 | BOSS | | |
| 22 | GB1096-79 | KEY | 5 X 16 | |
| 23 | 4037 | LEAF SPRING | | |
| 24 | 4015 | SHAFT | | |
| 25 | 4012 | GEAR | | |
| 26 | GB119-86 | PIN | 5 X 33 | |
| 27 | 4013 | GEAR | | |
| 28 | 4014 | GEAR | | |
| 29 | 4016 | BUSHING | | |
| 30 | 4001 | APRON CASE | | |
| 31 | GB78-85 | SCREW | M6 X 6 | |
| 32 | 4010 | GEAR | | |
| 33 | 4011 | SHAFT | | |
| 34 | GB70-85 | SCREW | M6 X 45 | |
| 35 | GB77-85 | SCREW | M8 X 8 | |
| 36 | GB2089-80 | SPRING | 1 X 45 X 6 | |
| 37 | GB308-89 | BALL | 6 | |
| 38 | 4041 | LEVER | | |
| 39 | 4042 | GEAR SHAFT | | |
| 40 | GB879-86 | PIN | 5 X 25 | |
| 41 | 4020 | BUSHING | | |
| 42 | 4019 | GEAR | | |
| 43 | GB879-86 | PIN | 5 X 25 | |
| 44 | 4018 | SHAFT | | |
| 45 | 4017 | WORM GEAR | | |
| 46 | GB1160-89 | OIL WINDOW | A12 | |
| 47 | GB818-85 | SCREW | M5 X 33 | |
| 48 | GB95-85 | WASHER | Φ6 | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-------------|----------------|---------------|--------|
| 49 | GB5780-85 | SCREW | M6 X 10 | |
| 50 | GB78-85 | SCREW | M6 X 6 | |
| 51 | 4043 | LIMIT BLOCK | | |
| 52 | 4025 | SAFETY SHIFTER | | |
| 53 | 4024 | SHASFT | | |
| 54 | GB77-85 | SCREW | M8 X 8 | |
| 55 | 4045 | BOSS | | |
| 56 | GB879-86 | PIN | 5 X 40 | |
| 57 | 4021 | CAM | | |
| 58 | GB71-85 | SCREW | M5 X 12 | |
| 59 | 4023 | SHAFT | | |
| 60 | GB5780-86 | SCREW | M8 X 30 | |
| 61 | GB95-85 | WASHER | Φ8 | |
| 62 | Q/Z220.2-77 | SCREW | M10 X 1X 20 | |
| 63 | GB95-85 | WASHER | Φ10 | |
| 64 | 4007 | SLEVER | | |
| 65 | 4044 | LEVER | | |
| 66 | GB119-86 | PIN | 5 X 10 | |
| 67 | 3022 | GIB | | |
| 68 | GB5780-86 | HALF NUT HOUSE | M6 X 25 | |
| 69 | GB5786-85 | SCREW | M6 X 15 | |
| 70 | 4002 | HALF NUT | | |
| 71 | 4003A1 | SCREW | | |
| 72 | GB77-85 | SCREW | M6 X 15 | |
| 73 | GB6170-86 | NUT | M6 | |
| 74 | 4006 | THREAD DIAL | | |
| 75 | 4005 | HOUSING | | |
| 76 | GB70-85 | SCREW | M6 X 65 | |
| 77 | 4044 | GEAR | | |
| 78 | GB70-85 | SCREW | M6 X 15 | |
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PARTS DIAGRAM AND LIST (FOR CQ6232E)

SADDLE AND CROSS SLIDE



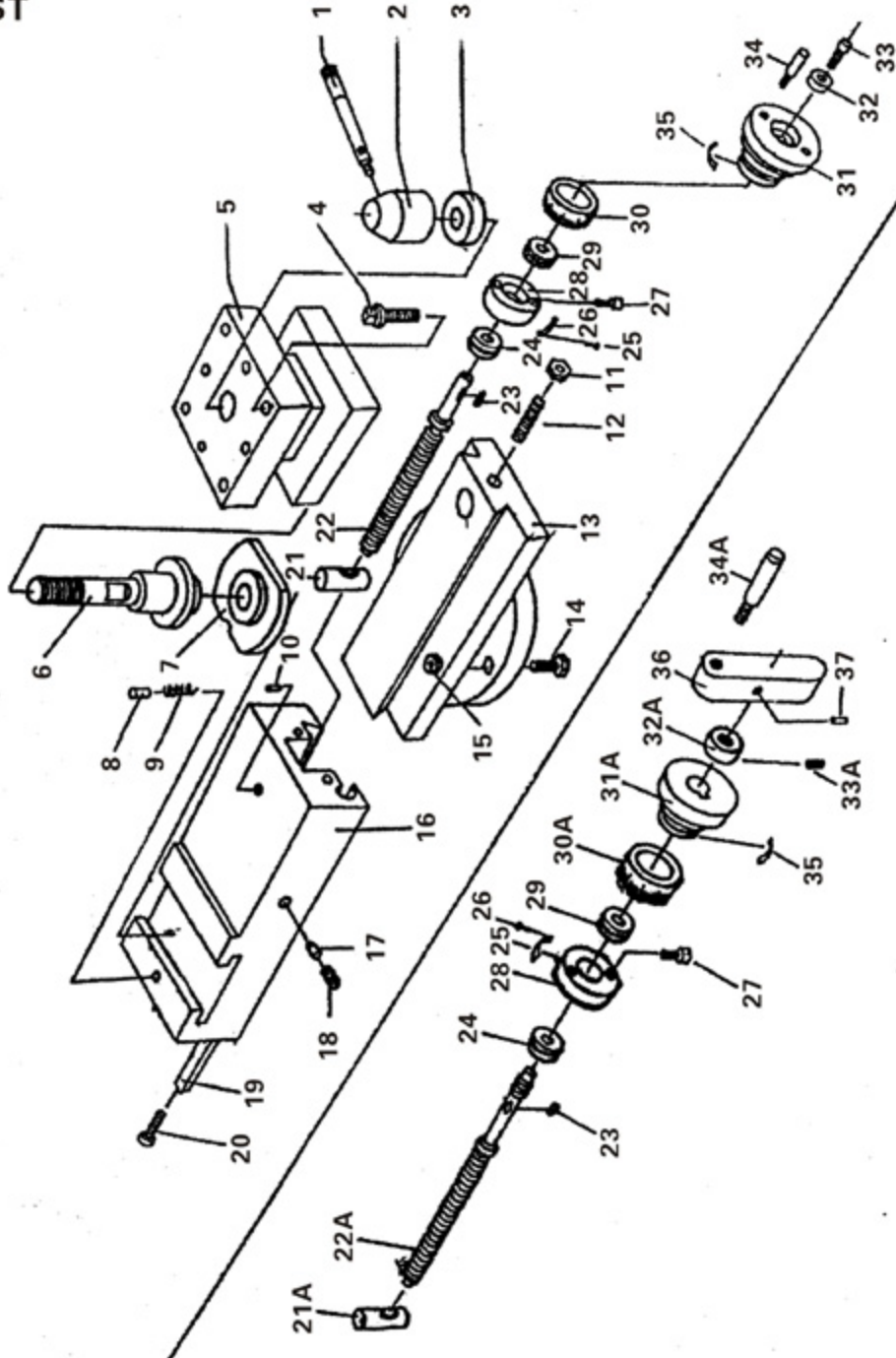
| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|----------|-------------|---------------|--------|
| 1 | 5101 | SADDLE | | |
| 2 | GB67-85 | SCREW | M5 X 12 | |
| 3 | 5108 | WIPPER | | |
| 4 | 5106 | COVER | | |
| 5 | GB65-85 | SCREW | M3 X 8 | |
| 6 | 5130 | PRESS PLATE | | |
| 7 | 5110 | PRESS PLATE | | |
| 8 | 5109 | WIPPER | | |
| 9 | 5113 | SCREW | | |
| 10 | 5128 | SCREW | | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-----------|-------------|---------------|--------|
| 11 | GB118-86 | PIN | 6 X 45 | |
| 12 | GB70-85 | SCREW | M10 X 30 | |
| 13 | GB1155-86 | OIL CUP | 6 | |
| 14 | 5115 | SCREW | | |
| 15 | 5102 | TOOL POST | | |
| 16 | GB68-85 | SCREW | M6 X 12 | |
| 17 | 5105 | BUSHING | | |
| 18 | 5114 | GIB | | |
| 19 | GB75-85 | SCREW | M4 X 12 | |
| 20 | 5104A2 | NUT | | |
| 21 | 5127 | GEAR | | |
| 22 | GB78-85 | SCREW | M6 X 8 | |
| 23 | GB5781-86 | SCREW | M8 X 25 | |
| 24 | GB41-86 | NUT | M8 | |
| 25 | GB85-88 | SCREW | M8 X 25 | |
| 26 | 5112 | PRESS PLATE | | |
| 27 | 5111 | WIPPER | | |
| 28 | 5131 | PRESS PLATE | | |
| 29 | 5116 | PRESS PLATE | | |
| 30 | GB1096-79 | KEY | 5 X 20 | |
| 31 | 5129 | PRESS PLATE | | |
| 32 | GB879-86 | PIN | 3 X 20 | |
| 33 | 5124A3 | INDEX RING | | |
| 34 | 5123 | LEAF SPRING | | |
| 35 | 5122A | HAND WHEEL | | |
| 36 | 5028 | WASHER | | |
| 37 | GB70-85 | SCREW | M6 X 16 | |
| 38 | 4033 | HAND | | |
| 39 | 4032 | LEVER | | |
| 40 | GB301-86 | BEARING | 8102 | |
| 41 | 5125A | BRACKET | | |
| 42 | GB70-85 | SCREW | M8 X 30 | |
| 43 | 5126 | WASHER | | |
| 44 | 5103A3 | GUIDE SCREW | | |
| 35A | 5122 | COLLAR | | |
| 36A | 5121 | NUT | | |
| 37A | GB77-85 | SCREW | M6 X 6 | |
| 41A | 5125A | BRACKET | | |
| 44A | 5103A2 | GUIDE SCREW | | |
| 45 | GB827-86 | RIVET | 2 X 4 | |
| 46 | 5133A2 | SCALE | | |
| 47 | 5120 | BRACKET | | |
| 48 | GB879-86 | PIN | 4 X 20 | |
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PARTS DIAGRAM AND LIST (FOR CQ6232E)

TOOL POST



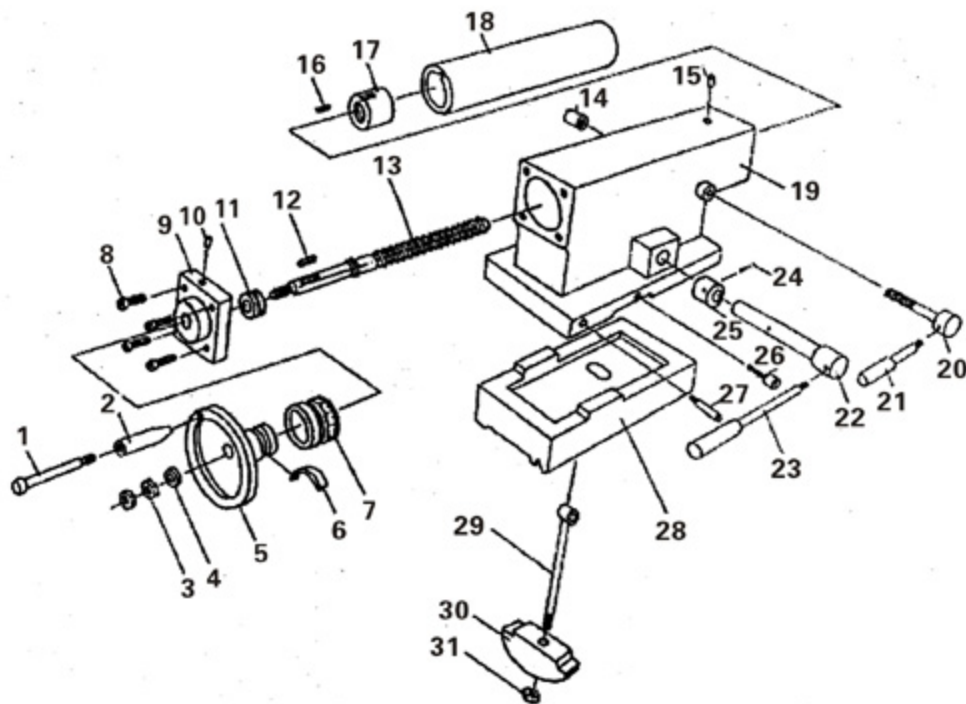
| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-----------|-----------|---------------|--------|
| 1 | 5010 | HANDLE | | |
| 2 | 5009 | BOSS | | |
| 3 | 5008 | COLLAR | | |
| 4 | GB83-88 | SCREW | M10 X 45 | |
| 5 | 5005 | TOOL POST | | |
| 6 | 5006 | SHAFT | | |
| 7 | 5003 | NUT | | |
| 8 | 5004 | PIN | | |
| 9 | GB2089-80 | SPRING | 1.2 X 4.8 X 8 | |
| 10 | GB1155-86 | OIL CUP | 6 | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|------------|-------------|---------------|--------|
| 11 | GB6170-85 | NUT | M6 | |
| 12 | GB73-85 | SCREW | M6 X 16 | |
| 13 | 5001 | COMPOUND | | |
| 14 | 5107 | SCREW | | |
| 15 | GB6172-80 | NUT | M10 | |
| 16 | 5002 | COMPOUND | | |
| 17 | 5024 | PIN | | |
| 18 | GB77-85 | SCREW | M6 X 8 | |
| 19 | 5023 | GIB | | |
| 20 | 5021 | SCREW | | |
| 21 | 5012A1 | NUT | | |
| 22 | 5011A3 | GUIDE SCREW | | |
| 23 | GB1096-79 | KEY | 4 X 8 | |
| 24 | GB301-84 | BEARING | 8101 | |
| 25 | 5026A2 | SCALE | | |
| 26 | GB827-86 | RIVET | 2 X 4 | |
| 27 | GB70-85 | SCREW | M6 X 25 | |
| 28 | 5013 | BRACKET | | |
| 29 | GB301-84 | BEARING | 8101 | |
| 30 | 5014A3 | INDEX RING | | |
| 31 | 5016A | HAND WHEEL | | |
| 32 | 5028 | WASHER | | |
| 33 | GB70-85 | SCREW | M6 X 12 | |
| 34 | 5031 | LEVER | | |
| 35 | 4037 | LEAF SPRING | | |
| 21A | 5012 | NUT | | |
| 22A | 5011 | GUIDE SCREW | | |
| 30A | 5014 | INDEX RING | | |
| 31A | 5016 | WASHER | | |
| 32A | 5025 | NUT | | |
| 33A | GB77-85 | SCREW | M6 X 8 | |
| 34A | GB414.5-84 | LEVER | M8 X 63 | |
| 36 | 5017 | BRACKET | | |
| 37 | GB879-86 | PIN | 3 X 16 | |
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PARTS DIAGRAM AND LIST (FOR CQ6232E)

TAILSTOCK

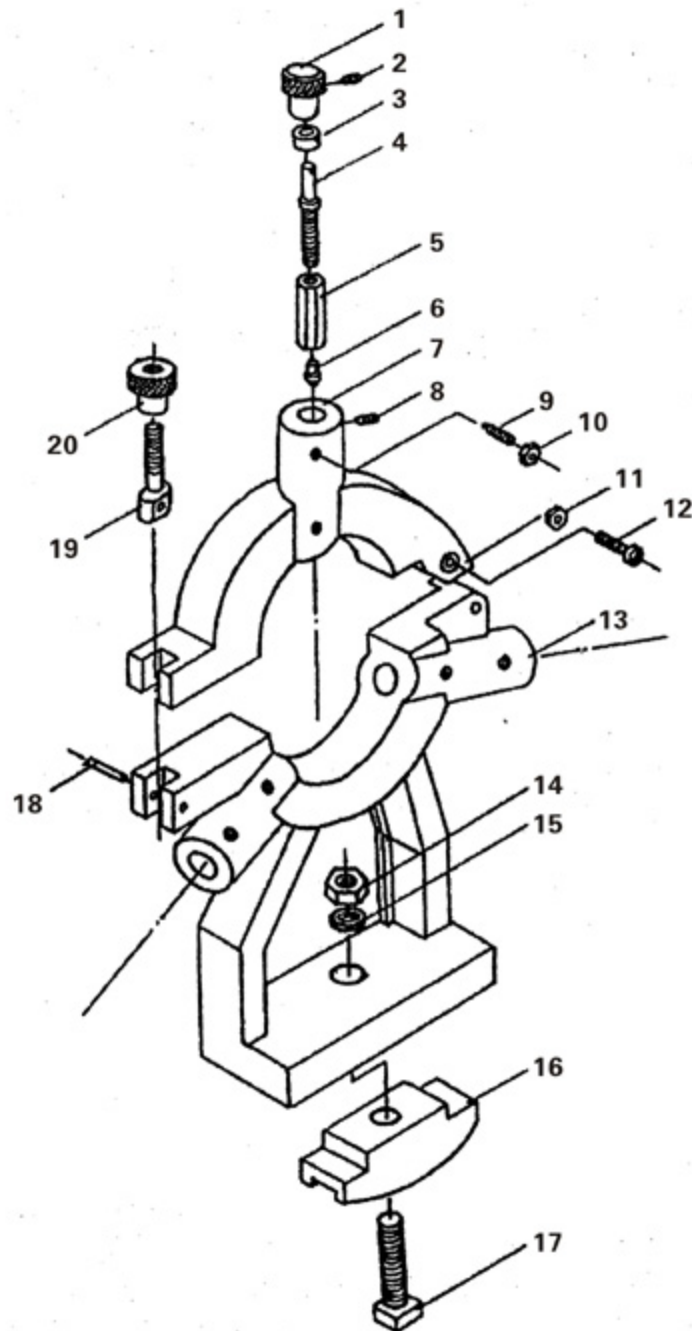


| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-----------|-------------|---------------|--------|
| 1 | 4033 | HANDLE | | |
| 2 | 4032 | LEVER | | |
| 3 | GB2172-86 | NUT | M10 | |
| 4 | GB97.1-85 | WASHER | A10 | |
| 5 | 6005 | HAND WHEEL | | |
| 6 | 4037 | LEAF SPRING | | |
| 7 | 6010 | INDEX RING | | |
| 8 | GB70-85 | SCREW | M6 X 16 | |
| 9 | 6011 | BRACKET | | |
| 10 | GB1155-86 | OIL CUP | 6 | |
| 11 | GB301-84 | BEARING | 8101 | |
| 12 | GB1096-79 | KEY | 4 X 15 | |
| 13 | 6006 | GUIDE SCREW | | |
| 14 | 6023 | LOCK NUT | | |
| 15 | GB1155-86 | OIL CUP | 6 | |
| 16 | GB77-85 | SCREW | M6 X 8 | |
| 17 | 6012 | NUT | | |
| 18 | 6013 | QUILL | | |
| 19 | 6001 | TAIL STOCK | | |
| 20 | 6022 | LOCK SCREW | | |
| 21 | 6021 | HANDLE | | |
| 22 | 6017 | SHAFT | | |
| 23 | 6004 | HANDLE | | |
| 24 | GB879-86 | PIN | 5 X 30 | |
| 25 | 6018 | COLLAR | | |
| 26 | GB70-85 | SCREW | M10 X 50 | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-----------|-----------------|---------------|--------|
| 27 | 6003 | SCREW | | |
| 28 | 6002 | BASE | | |
| 29 | 6019 | SHAFT | | |
| 30 | 6020 | BASE SHOE BLACK | | |
| 31 | GB6172-86 | NUT | M12 | |

STEADY REST

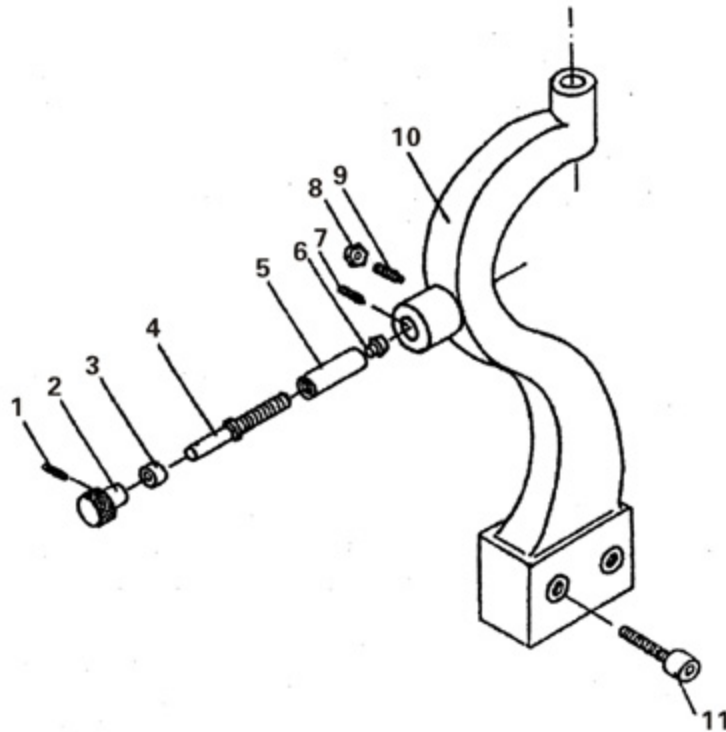


| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|----------|-----------------|---------------|--------|
| 1 | 8205 | KNOB | | |
| 2 | GB78-85 | SCREW | M6 X 8 | |
| 3 | 8207 | COLLAR | | |
| 4 | 8206 | PRESSING LEVER | | |
| 5 | 8208 | PRESSING COLLAR | | |

PARTS DIAGRAM AND LIST (FOR CQ6232E)

| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|-----------|-------------------|---------------|--------|
| 6 | 8209 | PRESSING BASE | | |
| 7 | 8202 | UPPER BODY | | |
| 8 | GB78-85 | SCREW | M6 X 10 | |
| 9 | GB79-85 | SCREW | M6 X 16 | |
| 10 | GB41-86 | HEX SCREW NUT | M6 | |
| 11 | GB41-86 | HEX SCREW NUT | M6 | |
| 12 | GB65-85 | SCREW | M6 X 25 | |
| 13 | 8201 | BASE BODY | | |
| 14 | GB41-86 | HEX SCREW NUT | M12 | |
| 15 | GB97.1-85 | WASHER | 12 | |
| 16 | 8210 | PRESSING PLATE | | |
| 17 | GB80-88 | SQUARE HEAD BOLT | M12 X 60 | |
| 18 | GB879-85 | SPRING PIN | 4 X 25 | |
| 19 | 8203 | LOCKING LEVER | | |
| 20 | 8204 | LOCKING SCREW NUT | | |

FOLLOW REST



| NO. | PART NO. | NAME | SPECIFICATION | REMARK |
|-----|----------|-----------------|---------------|--------|
| 1 | GB78-85 | SCREW | M6 X 6 | |
| 2 | 8205 | KNOB | | |
| 3 | 8207 | COLLAR | | |
| 4 | 8206 | PRESSING LEVER | | |
| 5 | 8208 | PRESSING COLLAR | | |
| 6 | 8209 | PRESSING BASE | | |
| 7 | GB78-85 | SCREW | M6 X 10 | |
| 8 | GB41-86 | HEX SCREW NUT | M6 | |
| 9 | GB79-85 | SCREW | M6 X 16 | |
| 10 | 8201 | BODY | | |
| 11 | GB70-85 | BOLT | M8 X 40 | |



OTMT