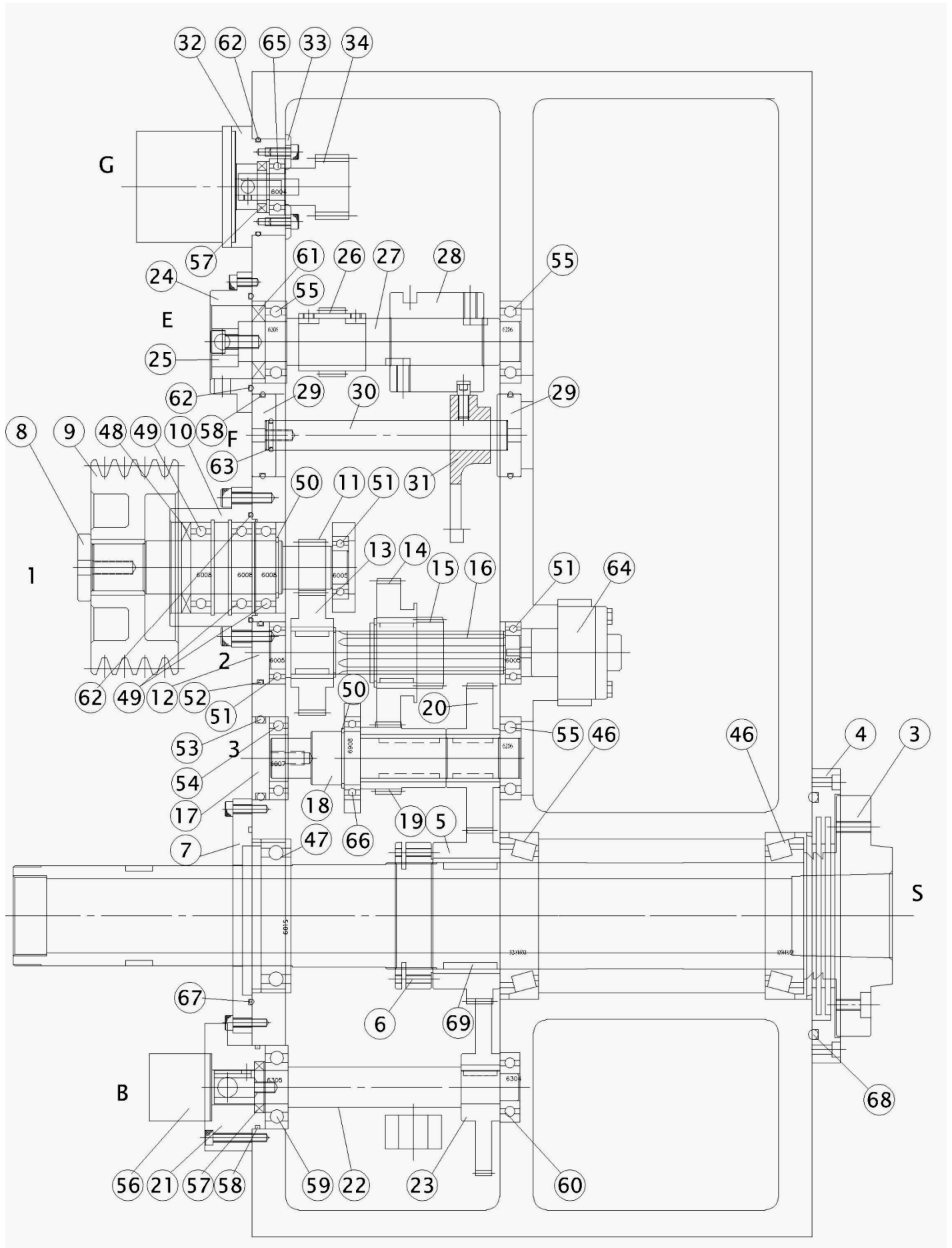
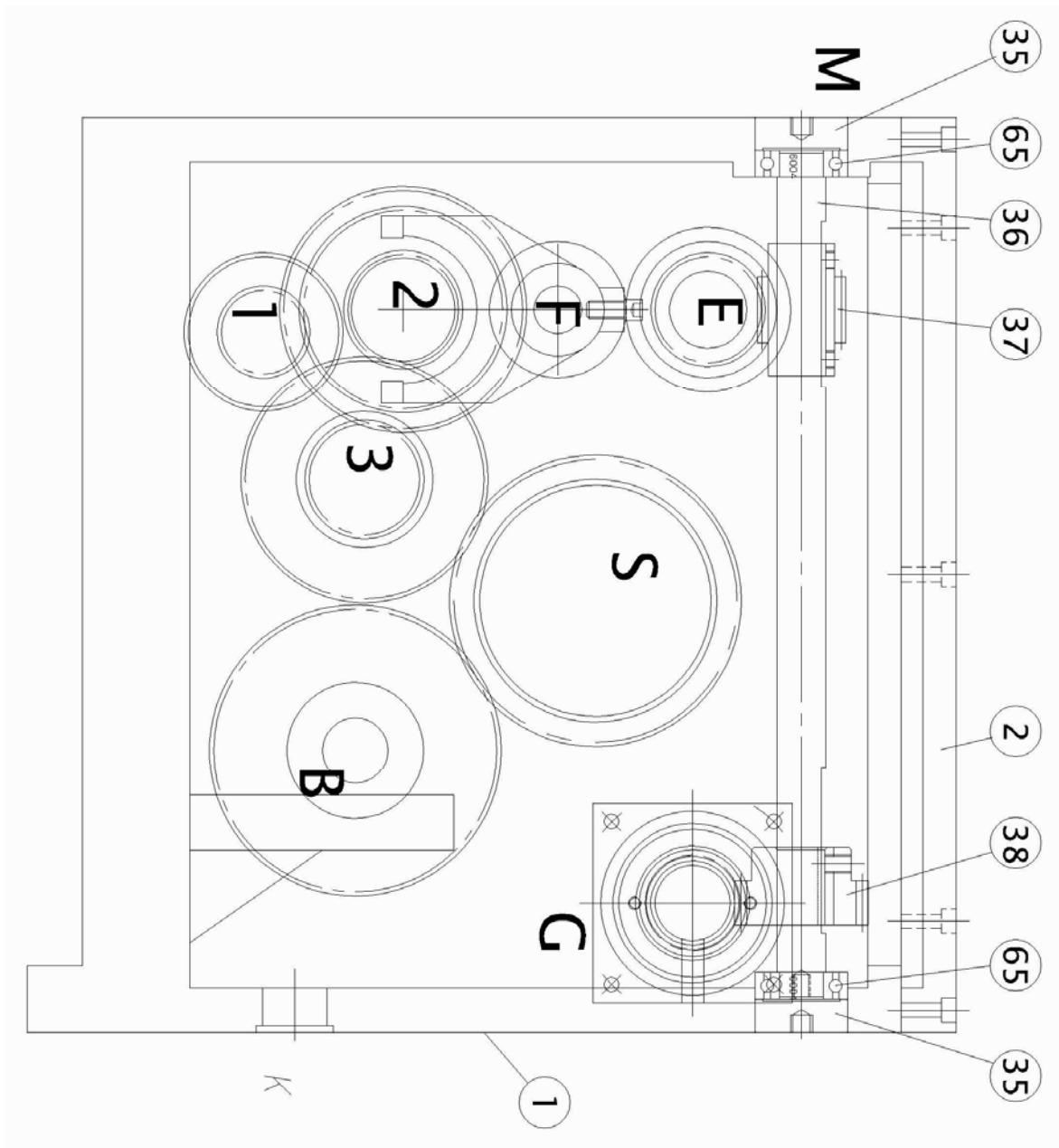


**Parts List**  
**(LC-1840)**

# Assembly of the transmission mechanism of Headstock ( I ) (automatic gears shafting)



## Assembly of the transmission mechanism of Headstock ( II ) (automatic gears shafting)

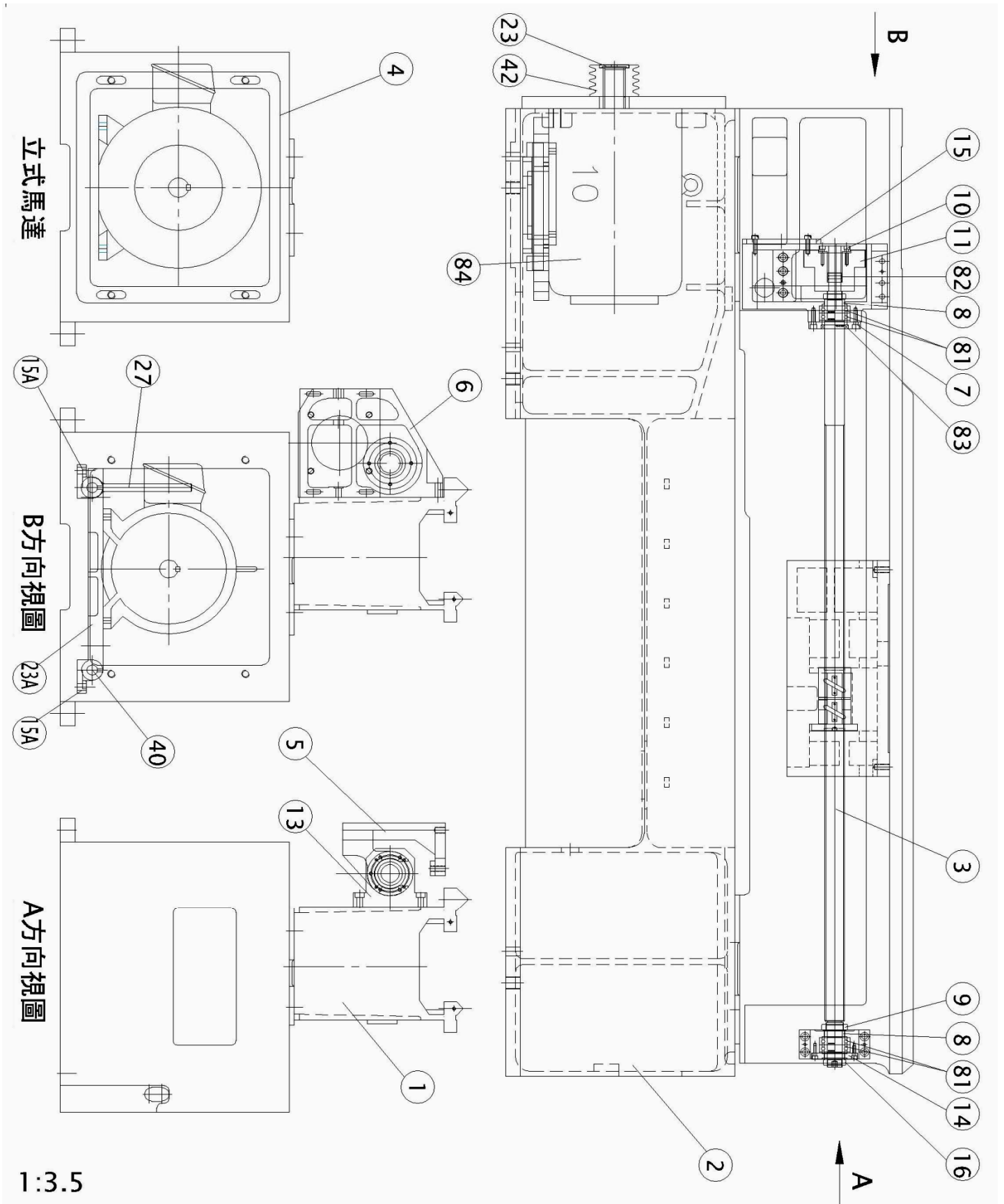


## Assembly of the transmission mechanism of Headstock (automatic gears shafting

Item	Parts No.	Description	Q'Ty	Item	Parts No.	Description	Q'Ty
1	18HT-001	Headstock	1	54		Bearing 6007	1
2	18HT-002	Cover	1	55		Bearing 6206	3
3	18HT-003	Spindle	1	56		Encoder	1
4	18HA-037	Snap Cover	1	57		Oil Seal 25*38*7	2
5	18HT-005	Spur Gear	1	58		Oil Ring G55	2
6	18HT-035	Master Nut	1	59		Bearing 6305	1
7	18HT-038	Snap Cover	1	60		Bearing 6304	1
8	18HA-004	Washer	1	61		Oil Seal 30*55*10	1

9	18HA-005	V-Pulley	1	62		O Ring G65	3
10	18HA-006	Plate	1	63		O Ring P18	1
11	18HT-011	Shaft	1	64		Oil Pump AM2A	1
12	18HT-012	Cover	1	65		Bearing 6004	3
13	18HT-013	Spur Gear	1	66		Bearing 6908	1
14	18HT-014	Spur Gear	1	67		O Ring G120	1
15	18HT-015	Spur Gear	1	68		O Ring G170	1
16	18HT-016	Keyway Shaft	1	69		Key 10*8*4	2
17	18HT-017	Cover	1				
18	18HT-018	Shaft	1				
19	18HT-019	Spur Gear	1				
20	18HT-020	Spur Gear	1				
21	18HB-015	Cover	1				
22	18HT-022	Shaft	1				
23	18HT-023	Spur Gear	1				
24	18HB-020	Supporting Post	1				
25	18HB-019	Block	1				
26	18HB-021	Gear	1				
27	18HT-027	Shaft	1				
28	18HA-044	Cam	1				
29	18HA-041	Cover	2				
30	18HT-030	Shaft	1				
31	18HA-045	Speed Change Fork	1				
32	18HB-028	Plate	1				
33	18HB-039	Washer	2				
34	18HB-027	Worm Shaft	1				
35	18HB-024	Plug	1				
36	18HT-036	Shaft	1				
37	18HB-025	Worm Shaft	1				
38	18HB-026	Gear Shaft	1				
46		Bearing 32016	2				
47		Bearing 6015	1				
48		Oil seal 40*68*7	1				
49		Bearing 6008	3				
50		C Locking C40	2				
51		Bearing 6005	3				
52		O Ring P41	1				
53		O Ring P52	1				

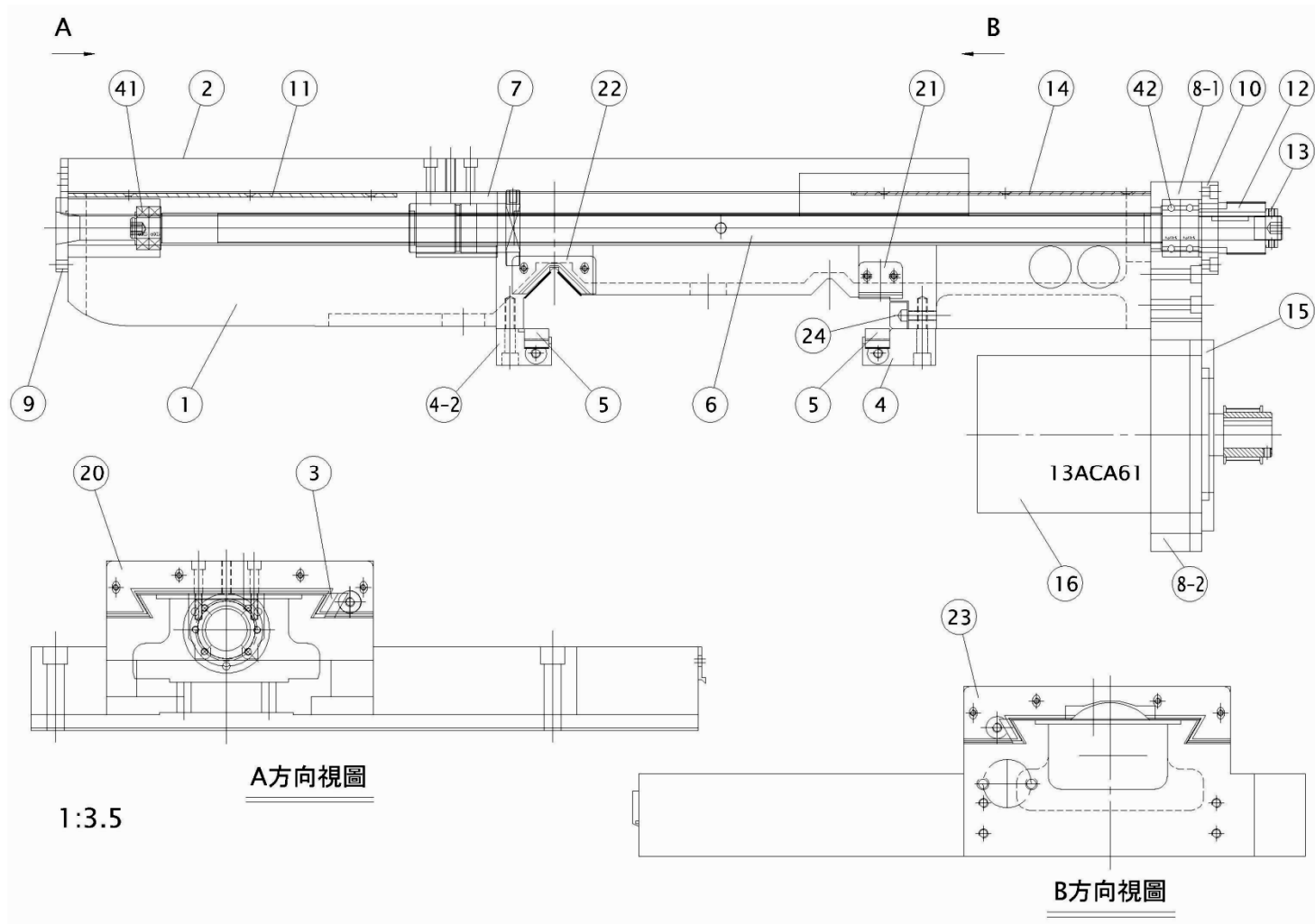
# Assembly of the Bed & Z-Axis



## Assembly of the Bedways & Z- Axis

Item	Parts No.	Description	Q'Ty
1	18BT-001	Bed	1
2	18BT-002	Stand	1
3	25CB-003	Ball Screw	1
4	18BT-004	Fixed Plate of Motor	1
5	25CB-005	Transmitting Post	1
6	25CB-006	Transmitting Box of Motor	1
7	25CB-007	Pressing Plate	1
8	25CB-008	Spacer Ring	3
9	25CB-009	Locking Nut	1
10	25CB-010	Cover	1
11	25CB-011	Timing Belt Pulley	1
13	25CB-013	End Bearing Post	1
14	25CB-014	Bearing Cover	1
15	25CS-015	Fixed Motor Plate	1
15A	33B-015A	Motor Post	2
16	25CB-016	Locking Nut	2
23	20B-023	Spacer Ring	1
23A	33B-023A	Fixed Motor Plate	1
27	33B-027	Bolt	1
40	20B-040	Bolt	1
42	20B-042	V-Pulley	1
81		Bearing BSD3062	4
82		Spacer Ring	3
83		Oil Seal 40*55*8	1
84		Main Motor	1

## Assembly of the Saddle & X- Axis

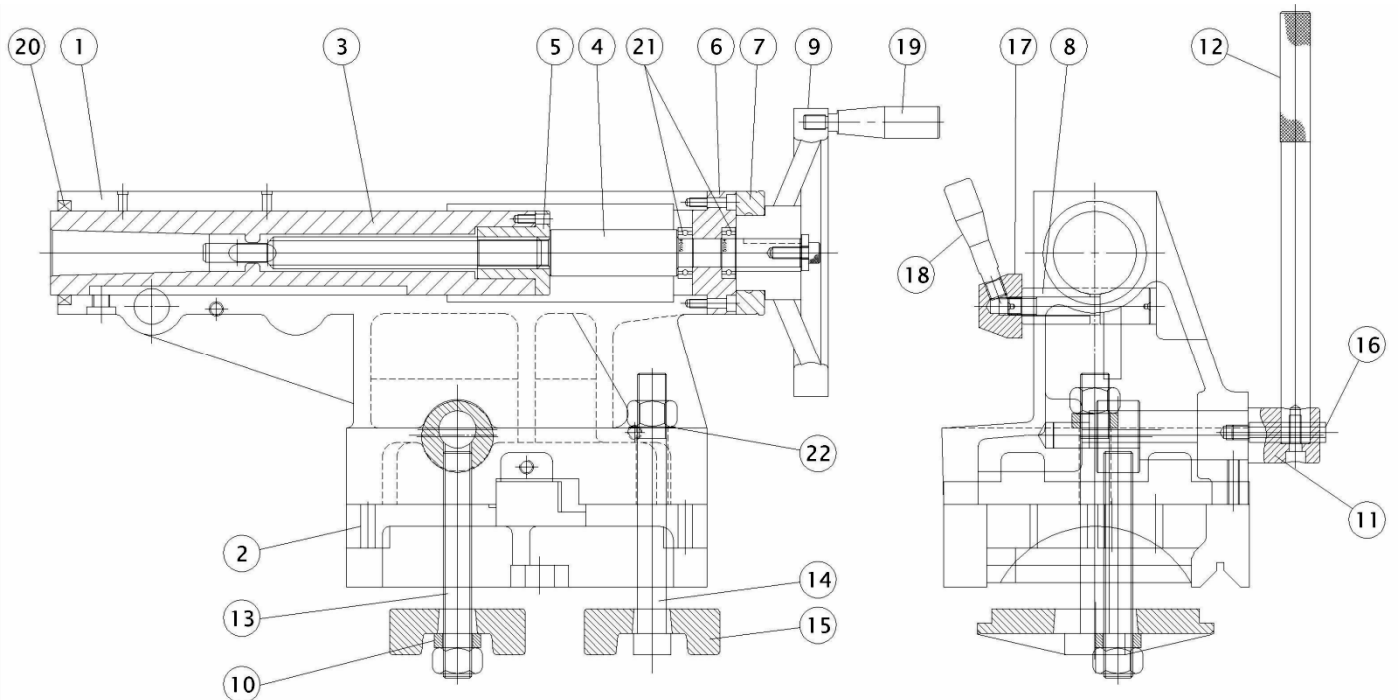


## Assembly of the Carriage & X- Axis

Item	Parts No.	Description	Q'Ty	
1	18ST-001	Carriage	1	
2	18ST-002	Cross Slide	1	
3	25CS-003	Gip	1	
4	18ST-004	Pressing Plate	1	
4-2	25CS-004-2	Pressing Plate	1	
5	25CS-005	Gip	2	
6	25CS-006	Ball Screw	1	
7	25CS-007	Screw Nut Post	1	
8-1	25CS-008-1	Transmitting Post	1	
8-2	25CS-008-2	Transmitting Post	1	
9	18ST-009	Bearing Post	1	
10	25CS-010	Bearing Post Cover	1	

11	18ST-011	Plate	1	
12	25CS-012	Timing Belt Pulley	1	
13	25CS-013	Locking Nut	1	
14	18ST-014	Plate	1	
15	25CS-015	Motor Fixed Plate	1	
16		Servo Motor	1	
20	25CS-020	Wiper	1	
21	21T-022	Wiper	2	
22	25CS-022	Wiper	2	
23	25CS-023	Wiper	1	
24	18ST-024	Gip	1	
33		Plate	1	
34		Limit Cover	1	
41		Bearing 6003	2	
42		Bearing BSD2047	2	

## Assembly of the Tailstock



Item	Parts No.	Description	Q'Ty
1	18TT-001	Tailstock Body	1
2	18T-002	Tailstock Base	1
3	18TT-003	Quill	1
4	18TT-004	Screw	1
5	18TT-005	Nut	1
6	18TT-006	Bracket	1
7	18TT-007	Dial	1
8	18TT-008	Nipping Bush	1
9	20A-010	Handwheel	1
10	25T-010	Washer	1
11	25T-011	Eccentric Lock Stud	1
12	25T-012	Locking Lever	1
13	18T-013	Clamping Bolt	1
14	18T-014	Clamping Bolt	1
15	25T-015	Holding Down Plate	2
16	25T-016	Stop Pin	1
17	25T-017	Nipping NUT	1
18	25T-018	Locking Hand	
19	20A-057	Handle	1
20		Oil Seal 58*72*9	1
21		Bearing 51104	2
22		Washer M20	1