

PARTS LIST
FOR THE
NEW BRITAIN - MODEL 61
SIX-SPINDLE
AUTOMATIC BAR MACHINES

THIS BOOK CONTAINS PLATES #6 & #12
TO IDENTIFY MODEL 686 CHUCKER PARTS.
PARTS NOT SHOWN ON THESE TWO PLATES
MAY IN MOST CASES BE IDENTIFIED FROM
THE MODEL 61 PLATES.

NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
NEW BRITAIN, CONN., U. S. A.

PARTS LIST

FOR

NEW BRITAIN-MODEL 61

SIX SPINDLE

AUTOMATIC BAR MACHINES

NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
NEW BRITAIN, CONN., U. S. A.

PREFACE TO THE PARTS LIST

This book is designed to aid in the identification of parts for the Model 61 New Britain Six Spindle Automatic Bar Machine. It contains a series of sectional views, each of which covers a number of machine units or a single unit. Each part shown on these plates is identified by a part number. Each plate is followed by a part list, numerically arranged and carrying a description of each individual part shown on the plate.

In using the book, first select the plate showing the unit and hence the part or parts in which you are interested, identifying these by part number shown on the plate and further, by the description appearing on the numerical list immediately following the plate with which you are working.

Some parts are shown on more than one plate and thus appear in more than one numerical list, merely being shown in greater detail in one plate than in the others.

When ordering parts from this list, do not omit the prefix. Always order by full part numbers, thus, 61-345, 402-503, 14-274, etc. ALWAYS INCLUDE THE SERIAL NUMBER OF THE MACHINE FOR WHICH THE PARTS ARE DESIRED. The serial number will be found stamped in the name plate and on the front of the power case in the space provided.

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"NEW BRITAIN" MODEL #61

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Rev. 11-2-49

T-207474

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STOCK FEED MECHANISM
SEE PLATE XV

LOCATING & LOCKING
MECHANISM
SEE PLATE XIII

STOCK STOP
SEE PLATE IX

CLUTCHES
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AUXILIARY CAM DRUM
PRIMARY DRIVE SHAFT
SEE PLATE V

402
906

61
483

402
905

MAIN DRIVE
SEE PLATE II

SERIAL NO

SPINDLE PARTS
SEE PLATE XII

CROSS SLIDES
SEE PLATE XI

TOOL SLIDE STOP
MAIN CAM SHAFT
SEE PLATE VIII

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SEE PLATE II

FORMING ARMS
FORMING CAM SHAFTS
SEE PLATE XIII

BRAKE
SEE PLATE III

61
336

61
1099

MAIN DRIVE
MOTOR

NEW BRITAIN-GRIDLEY

61
1076

61
1009

PLATE I
FRONT ELEVATION

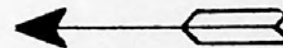
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A-163964

PLATE I
FRONT ELEVATION

61-336 Cover, Oil Pan-Front
61-483 Guard, Auxiliary Cam Drum
402-905 Chain, Main Drive
402-906 Chain, Auxiliary Cam Drum Drive
61-1009 Base, Motor
61-1076 Door, Oil Pan Compartment
61-1099 Cover, Conduit Box

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL
NUMBER OF THE MACHINE FOR WHICH THE PARTS ARE DESIRED.



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T-286802

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SPEED CHANGE GEARS 132 TEETH - TOTAL	
NO OF TEETH	PART NO.
23	C49-1540
109	C49-1584
25	C49-1541
107	C49-1583
27	C49-1542
105	C49-1582
29	C49-1543
103	C49-1581
31	C49-1544
101	C49-1580
33	C49-1545
99	C49-1579
35	C49-1546
97	C49-1578
37	C49-1547
95	C49-1577
39	C49-1548
93	C49-1576
41	C49-1549
91	C49-1575
43	C49-1550
89	C49-1574
45	C49-1551
87	C49-1573
47	C49-1552
85	C49-1572
49	C49-1553
83	C49-1571
51	C49-1554
81	C49-1570
53	C49-1555
79	C49-1569
55	C49-1556
77	C49-1568
57	C49-1557
75	C49-1567
59	C49-1558
73	C49-1566
61	C49-1559
71	C49-1565
63	C49-1560
69	C49-1564
65	C49-1561
67	C49-1563

FEED CHANGE GEARS 132 TEETH-TOTAL	
NO OF TEETH	PART NO.
23	C61-3579
109	C61-3578
25	C61-3580
107	C61-3577
27	C61-3581
105	C61-3576
29	C61-3139
103	C61-3140
31	C49-1586
101	C49-1622
33	C49-1587
99	C49-1621
35	C49-1588
97	C49-1620
37	C49-1589
95	C49-1619
39	C49-1590
93	C49-1618
41	C49-1591
91	C49-1617
43	C49-1592
89	C49-1616
45	C49-1593
87	C49-1615
47	C49-1594
85	C49-1614
49	C49-1595
83	C49-1613
51	C49-1596
81	C49-1612
53	C49-1597
79	C49-1611
55	C49-1598
77	C49-1609
57	C49-1599
75	C49-1608
59	C49-1600
73	C49-1607
61	C49-1601
71	C49-1606
63	C49-1602
69	C49-1605
65	C49-1603
67	C49-1604

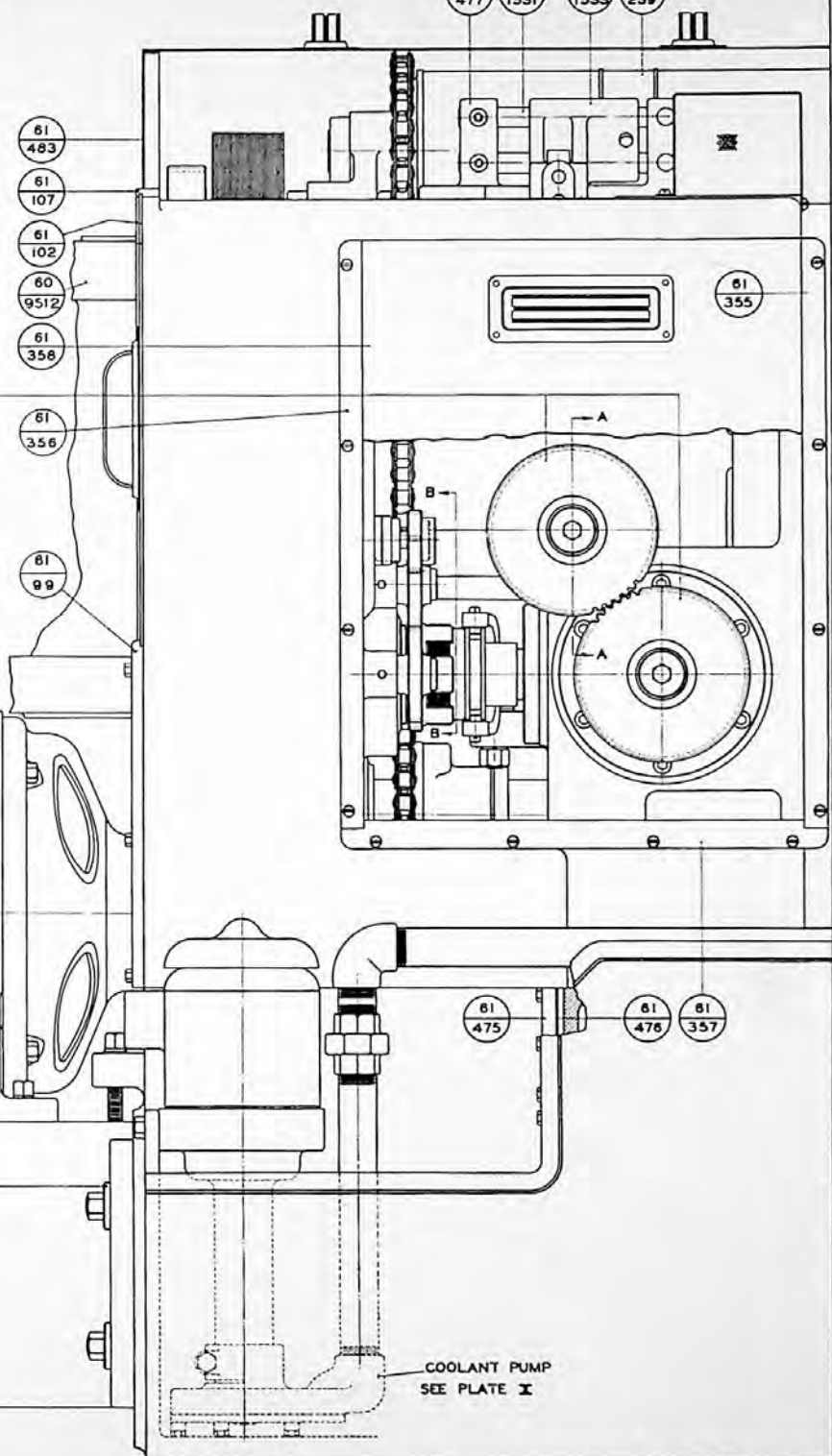
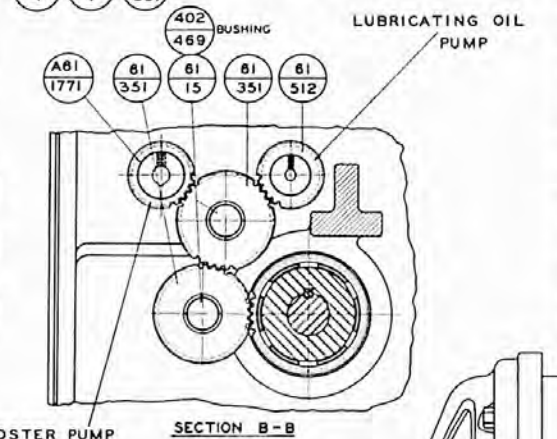
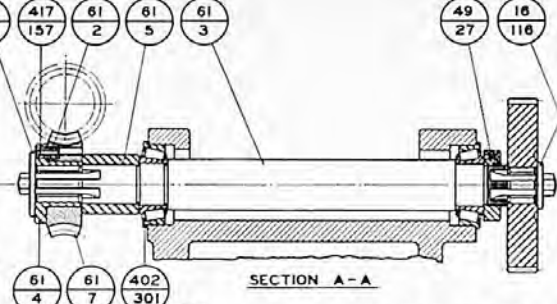
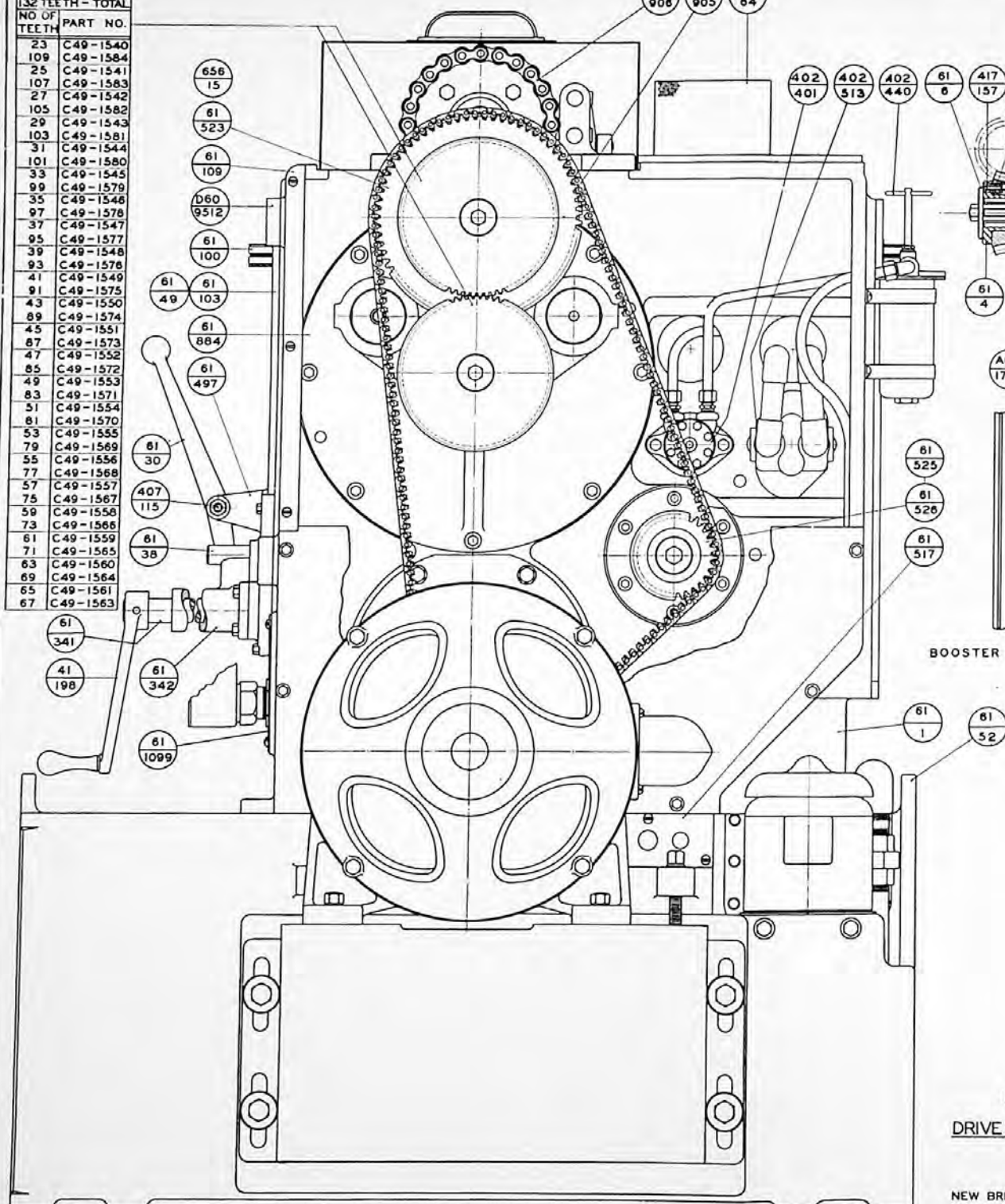


PLATE II
DRIVE END ELEVATION

NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
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PLATE II

DRIVE END ELEVATION

61-1	Case, Power	61-351	Gear, Pump Drive Idler
61-2	Bushing, Shearing Pin	61-355	Guide, Rear Power Case Door (R.H.)
61-3	Shaft, Feed Worm Gear	61-356	Guide, Rear Power Case Door (L.H.)
61-4	Sleeve, Shearing Pin	61-357	Guide, Rear Power Case Door (Bottom)
61-5	Spacer, Feed Worm Gear	61-358	Door, Rear Power Case
61-6	Washer, Feed Worm Gear	402-401	Pump, Lubricating Oil
61-7	Wheel, Feed Worm	402-440	Filter, Oil
61-15	Stud, Pump Idler Gear	402-469	Bushing, Pump Drive Idler Gear
656-15	Sprocket, Main Drive - 73T	61-475	Plate, Oil Retaining
49-27	Nut, Adjusting	61-476	Gasket, Oil Retaining Plate
61-30	Lever, Feed Clutch	61-477	Gib, Accelerating Slide (Rear)
61-38	Rod, Feed Clutch Control	61-483	Guard, Auxiliary Cam Drum
61-49	Guide, Front Power Case Door (R.H.)	61-497	Cover, Lower Power Case (Front)
61-52	Pan, Oil	61-503	Washer
61-64	Cover, Solenoid Terminal	61-512	Gear, Lub. Oil Pump Drive
61-99	Cover, Lower Power Case (End)	402-513	Pump, Coolant Booster
61-100	Door, Front Power Case	61-517	Support, Oil Pan Cable
61-102	Door, End Power Case	61-523	Sprocket, Main Drive - 47T
61-103	Guide, Front Power Case Door (L.H.)	61-525	Sprocket, Constant Speed - 47T
61-107	Guide, End Power Case Door Top	61-526	Sprocket, Constant Speed - 37T
61-109	Stop, End Power Case Door	61-884	Plate, Power Case (Rear)
407-115	Fulcrum, Feed Clutch Lever	402-905	Chain, Main Drive
16-116	Washer	402-906	Chain, Auxiliary Cam Drum Drive
417-157	Pin, Shearing	61-1009	Base, Motor
41-198	Crank, Hand	61-1099	Cover, Conduit Box
61-239	Drum, Auxiliary Cam	A61-1531	Shaft, Threading Clutch Cam Slide
402-301	Bearing, Feed Worm Gear Shaft	A61-1533	Slide, Threading Clutch Cam
61-341	Shaft, Hand Feed Crank	A61-1771	Gear, Booster Pump Drive
61-342	Bracket, Crank Shaft	D60-9512	Bar, Control Box Mounting

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL NUMBER OF THE MACHINE FOR WHICH THE PARTS ARE DESIRED.



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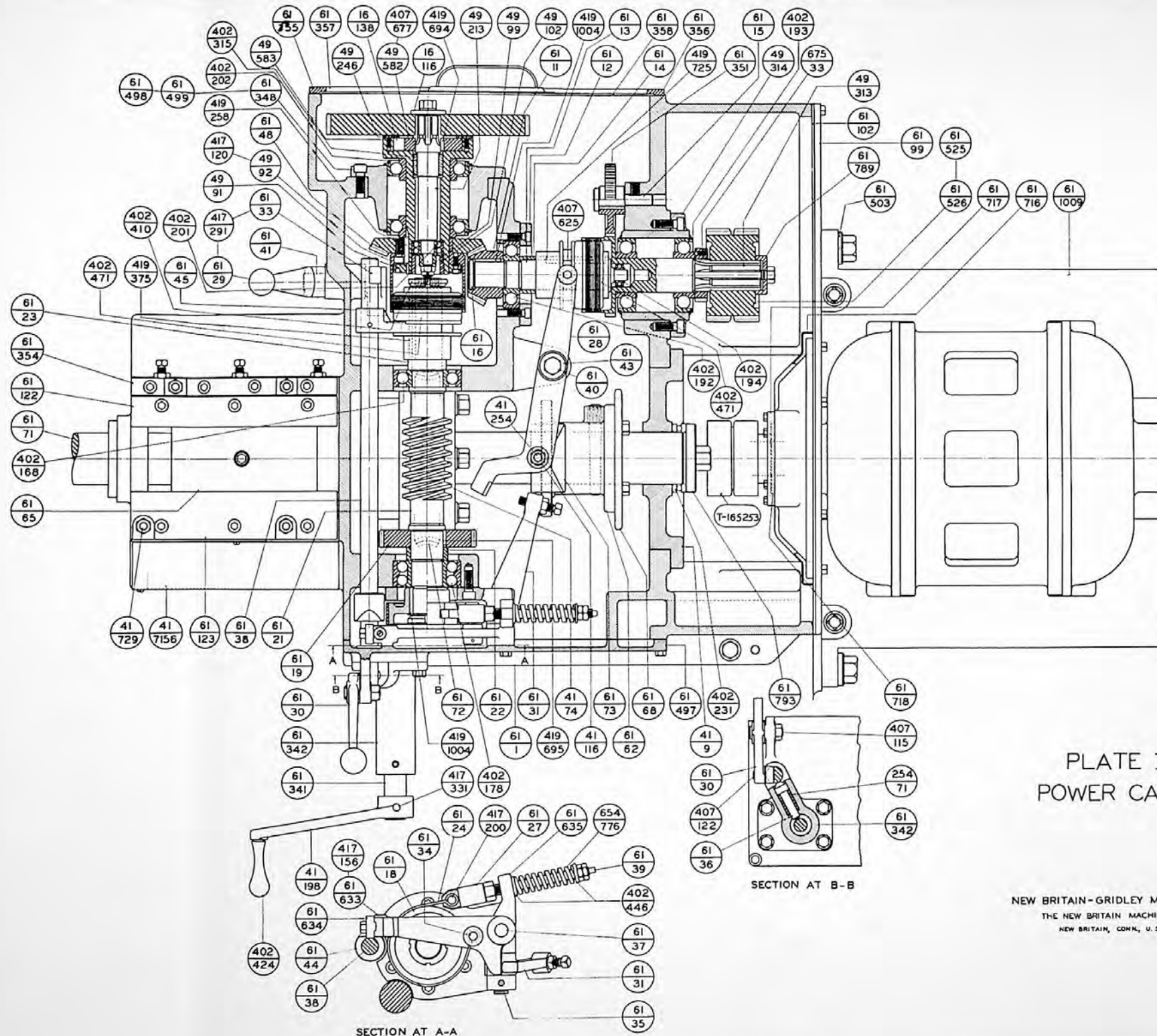


PLATE III
POWER CASE

NEW BRITAIN-GRIDLEY MACHINE DIV.
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NEW BRITAIN, CONN., U. S. A.

PLATE III

POWER CASE

61-1	Case, Power	61-43	Washer, Clutch Fork
41-9	Plate, Main Cam Shaft Thrust	61-44	Wedge, Brake Operating
61-11	Pinion, Constant Speed	61-45	Yoke, Feed Clutch
61-12	Retainer, Bearing	61-48	Gear, Constant Speed
61-13	Shaft, Constant Speed Clutch	61-62	Disc, Sprocket Hub and Cam
61-14	Spacer, Constant Speed Clutch	61-65	Drum, Main Cam
61-15	Stud, Pump Idler Gear	61-68	Sprocket, Auxiliary Cam Shaft
61-16	Washer, Pinion Retaining	61-71	Shaft, Main Cam
61-18	Drum, Brake	254-71	Spring, Plunger
61-19	Gear, Hand Feed	61-72	Wheel, Worm
61-21	Shaft, Cam Drum Drive	61-73	Cam, Constant Speed Clutch
61-22	Spacer, Hand Feed Gear	41-74	Plate, Main Cam Shaft Friction
61-23	Spacer, Cam Drum Drive Shaft Clutch	49-91	Nut, Feed Clutch Shell Lock
61-24	Band, Brake	49-92	Shell, Feed Clutch
61-27	Connection, Brake Adjusting Rod	61-99	Cover, Lower Power Case (End)
61-28	Fork, Constant Speed Clutch	49-99	Spacer
61-29	Handle, Positive Clutch Throwout	61-102	Door, Speed Change Gear
61-30	Lever, Feed Clutch	49-102	Nut, Bearing Lock
61-31	Lever, Brake Operating	407-115	Fulcrum, Feed Clutch Lever
61-33	Lever, Positive Clutch Throwout	41-116	Roll, Cam
675-33	Nut, Adjusting	16-116	Washer
61-34	Pin, Brake Lever	417-120	Pin, Dowel
61-35	Pin, Brake Lever	61-122	Guide, Tool Slide (Rear)
61-36	Plunger, Hand Crank Safety	407-122	Stud, Clutch Lever
61-37	Pin, Fulcrum	61-123	Guide, Tool Slide (Front)
61-38	Rod, Feed Clutch Control	16-138	Roll, Clutch
61-39	Rod, Brake Adjusting	417-156	Pin, Dowel
61-40	Stud, Clutch Fork	402-168	Bearing, Cam Drum Drive Shaft
61-41	Shaft, Clutch Throwout Lever	402-178	Bearing, Cam Drum Drive Shaft

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T-286804 6/24/44

PLATE III (Continued)

POWER CASE

402-192	Bearing, Constant Speed Clutch Shaft	402-446	Washer, Brake Spring
402-193	Bearing, Constant Speed Clutch Shell	402-471	Clutch, Feed
402-194	Bearing, Constant Speed Clutch Shaft	61-497	Cover, Lower Power Case (Front)
41-198	Crank, Hand	61-498	Shim, Overrunning Shaft Bearing Cup
417-200	Pin, Dowel	61-499	Shim, Overrunning Shaft Bearing Cup
402-201	Bearing, Roller Clutch Shaft	61-503	Washer
402-202	Bearing, Overrunning Shaft Cup	61-525	Sprocket, Constant Speed (47T)
49-213	Shaft, Roller Clutch	61-526	Sprocket, Constant Speed (37T)
402-231	Bearing, Main Cam Shaft Thrust	49-582	Disc, Roller Clutch
49-246	Plate, Overrunning Clutch	49-583	Cup, Roller Clutch
41-254	Stud, Cam Roll	407-625	Shoe, Clutch
419-258	Key, Roller Clutch Cup	61-633	Lever, Brake
417-291	Pin, Dowel	61-634	Shoe, Brake Lever
49-313	Shell, Constant Speed Clutch	61-635	Bracket, Brake Lever
49-314	Cup, Constant Speed Shaft Bearing	407-677	Spring, Roller Clutch Disc
402-315	Bearing, Roller Clutch Shaft	419-694	Key, Roller Clutch Shaft
417-331	Pin, Dowel	419-695	Key, Hand Feed Gear
61-341	Shaft, Hand Feed Crank	61-716	Guard, Drive Sprocket
61-342	Bracket, Crank Shaft	61-717	Cover, Oil Seal
61-348	Cup, Overrunning Shaft Bearing	61-718	Seal, Oil
61-351	Gear, Pump Drive Idler	419-725	Key, Clutch Shaft
61-354	Bar, Rear Guide Adjusting	41-729	Pin, Taper
61-355	Guide, Rear Power Case Door (Right)	654-776	Spring, Brake
61-356	Guide, Rear Power Case Door (Left)	61-789	Retainer, Sprocket
61-357	Guide, Rear Power Case Door (Bottom)	61-793	Washer, Cam Shaft
61-358	Door, Rear Power Case	419-1004	Key
419-375	Key, Feed Clutch	61-1009	Base, Motor
402-410	Locknut and Washer	41-7156	Guard, Tool Slide Cam
402-424	Handle, Hand Crank	T-165253	Sprocket, Motor--Specify no. of teeth and bore diameter

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6/29/44

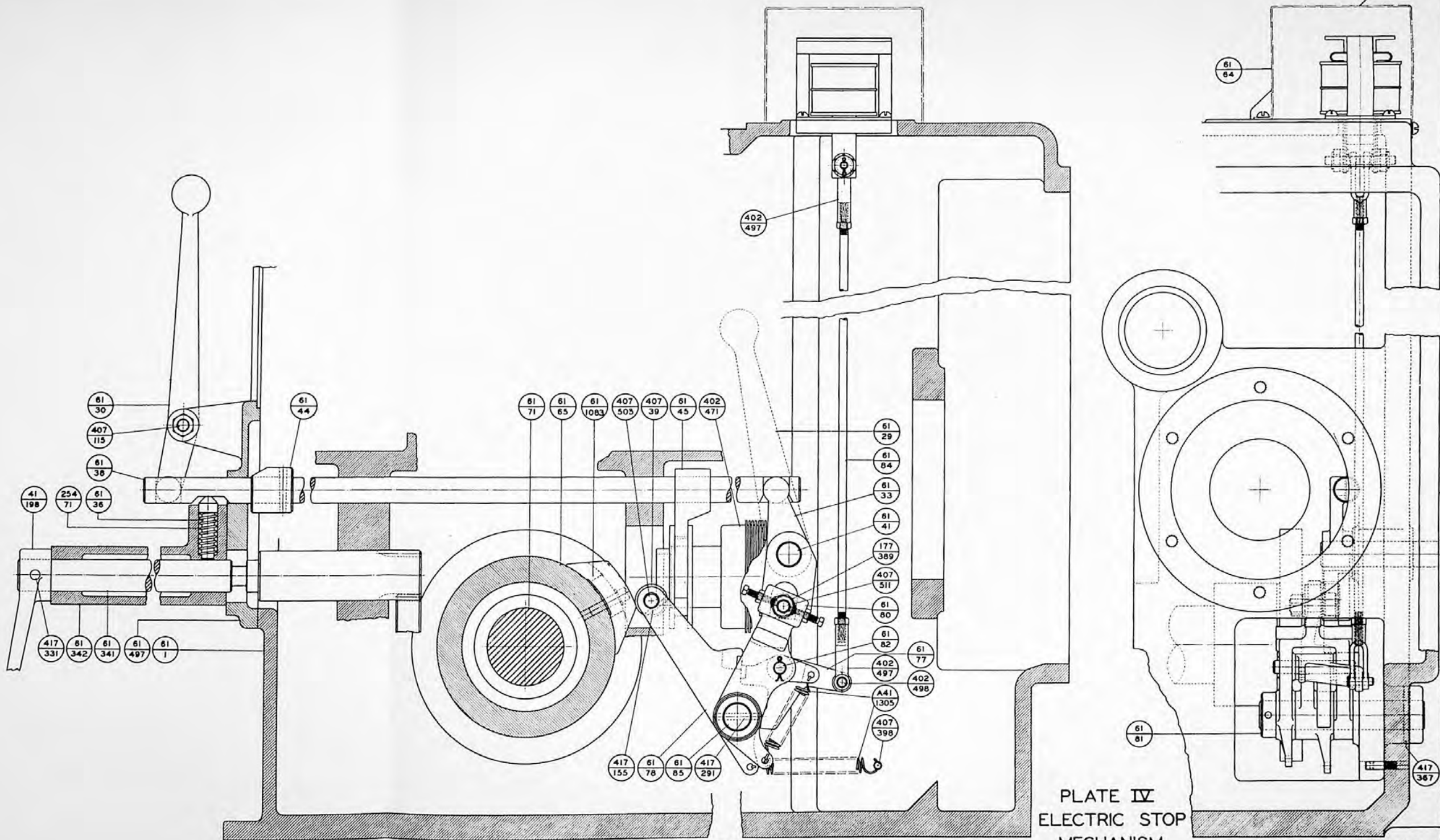


PLATE IV
ELECTRIC STOP
MECHANISM

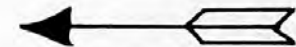
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PLATE IV
ELECTRIC STOP

61-1	Case, Power	61-85	Shaft, Cam Lever
61-29	Handle, Positive Clutch Throwout	407-115	Fulcrum, Feed Clutch Lever
61-30	Lever, Feed Clutch	417-155	Pin, Dowel
61-33	Lever, Positive Clutch Throwout	41-198	Crank, Hand
61-36	Plunger, Hand Crank Safety	417-291	Pin, Dowel
61-38	Rod, Feed Clutch Control	417-331	Pin, Dowel
407-39	Roll, Cam	61-341	Shaft, Hand Feed Crank
61-41	Shaft, Clutch Throwout Lever	61-342	Bracket, Crank Shaft
61-44	Wedge, Brake Operating	417-367	Pin, Dowel
61-45	Yoke, Feed Clutch	177-389	Washer
61-64	Cover, Solenoid Terminal	407-398	Stud, Spring
61-65	Drum, Main Cam	402-471	Clutch, Feed
61-71	Shaft, Main Cam	61-497	Cover, Lower Power Case - Front
254-71	Spring, Plunger	402-497	End, Yoke
61-77	Lever, Positive Stop Locking	402-498	Pin, Yoke End
61-78	Lever, Positive Stop Cam	407-503	Stud, Cam Roll
61-80	Lever, Intermediate	407-511	Stud, Intermediate Lever
61-81	Collar, Cam Lever Shaft	61-1083	Cam, Positive Stop
61-82	Pin, Locking Lever	A41-1305	Spring, Positive Stop Lever
61-84	Rod, Solenoid Connecting		

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T-286806

6/24/44

4

R. H. THREADING DRIVEN GEAR	
NO. OF TEETH	PART NO.
45	A61-1506
47	C61-3958
49	C61-4663
51	C467-3308
54	C61-4686
L. H. THREADING DRIVEN GEAR	
NO. OF TEETH	PART NO.
29	A61-1510
30	A61-1559
31	C61-4681
32	A61-1509
33	C61-3672

R. H. THREADING DRIVE GEAR	
NO. OF TEETH	PART NO.
51	C61-3495
49	C61-3497
47	C61-3499
45	C61-3501
42	C61-3504
L. H. THREADING DRIVE GEAR	
NO. OF TEETH	PART NO.
67	C61-3479
66	C61-3480
65	C61-3481
64	C61-3482
63	C61-3483

R. H. THREADING DRIVEN GEAR	
NO. OF TEETH	PART NO.
45	C61-3065
47	C41-3045
49	C41-3196
51	C41-9267
54	C41-2470

L. H. THREADING DRIVEN GEAR	
NO. OF TEETH	PART NO.
29	C41-2476
30	C41-3307
31	C41-3194
32	C41-3030
33	C42-3026

L. H. THREADING DRIVE GEAR	
NO. OF TEETH	PART NO.
67	C61-3554
66	C61-3553
65	C61-3552
64	C61-3551
63	C42-3141

SPEED CHANGE GEARS
SEE PLATE II

WHEN ANY POSITION IS NOT USED,
OPENING IS CLOSED BY FRONT PLATE
PLUG, *61-321.

NEW BRITAIN-GRIDLEY MACHINE DIV
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PLATE V
REVERSING, TAPPING &
DIE REVOLVING MECHANISM

A-284911

SCALE: NONE REF: 8-21-64

24 2-23

PLATE V

REVERSING TAPPING AND DIE REVOLVING MECHANISM

656-15	Sprocket, Main Drive - 73T.	402-415	Locknut and Washer, Th'd Drive Shaft
675-33	Nut, Adjusting	402-416	Clutch, Threading Drive Shaft
411-43	Retainer, Drill Speeder Idler Gear	402-422	Locknut and Washer
61-68	Sprocket, Auxiliary Cam Shaft	402-447	Washer
61-75	Bracket, Slack Adjusting Shoe	61-462	Plate, Power Case - Front
61-79	Support, Threading Spindle	61-477	Gib, Accelerating Slide - Rear
61-96	Bracket, Stub Shaft	61-523	Sprocket, Main Drive - 47T
16-116	Washer	61-587	Cam, Stock Stop Operating
41-116	Roll, Cam	407-625	Shoe, Clutch
402-163	Bearing, Idler Gear	402-658	Bushing, Auxiliary Cam Shaft
402-165	Bearing, Threading Drive Shaft	419-762	Key, Primary Spindle Drive Shaft
402-170	Bearing, Threading Drive Shaft	41-815	Bushing, Slack Adjusting Roll
402-193	Bearing, Stub Shaft Ball	61-860	Shaft, Primary Spindle Drive
61-199	Gib, Accelerating Slide - Front	61-861	Pin, Taper
402-216	Bearing, Primary Spindle Drive Shaft	61-862	Worm, Feed Shaft Drive
402-217	Bearing, Primary Spindle Drive shaft	61-866	Spacer, Threading Drive Gear
402-230	Bearing, Spindle Drive Shaft	61-867	Spacer, Primary Spindle Drive Shaft
61-239	Drum, Auxiliary Cam	61-868	Spacer, Primary Spindle Drive Shaft
61-240	Shaft, Auxiliary Cam	61-871	Disc, Driving
61-265	Support, Adjusting Shoe Bracket	419-878	Key, Threading Spindle Shaft
402-274	Bearing, Drill Speeder Shaft	61-884	Plate, Power Case - Rear
402-275	Bearing, Drill Speeder Shaft	61-1002	Collar, Auxiliary Cam Shaft
454-276	Screw, Cam Shaft Sprocket	61-1003	Spacer, Auxiliary Cam Drum
49-314	Cup, Stub Shaft Bearing	61-1011	Washer, Spindle Drive Spring
61-321	Plug, Front Plate (Not Illus.)	61-1012	Coupling, Spindle Drive Shaft
61-340	Shaft, Stub	A61-1502	Slide, Accelerating
61-352	Retainer, Primary Spindle Drive Shaft	A61-1505	Collar, Th'd Clutch Lever Shaft
402-404	Locknut and Washer	A61-1510	Gear, Threading Shaft
402-411	Locknut and Washer		

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL
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PLATE V (Continued)

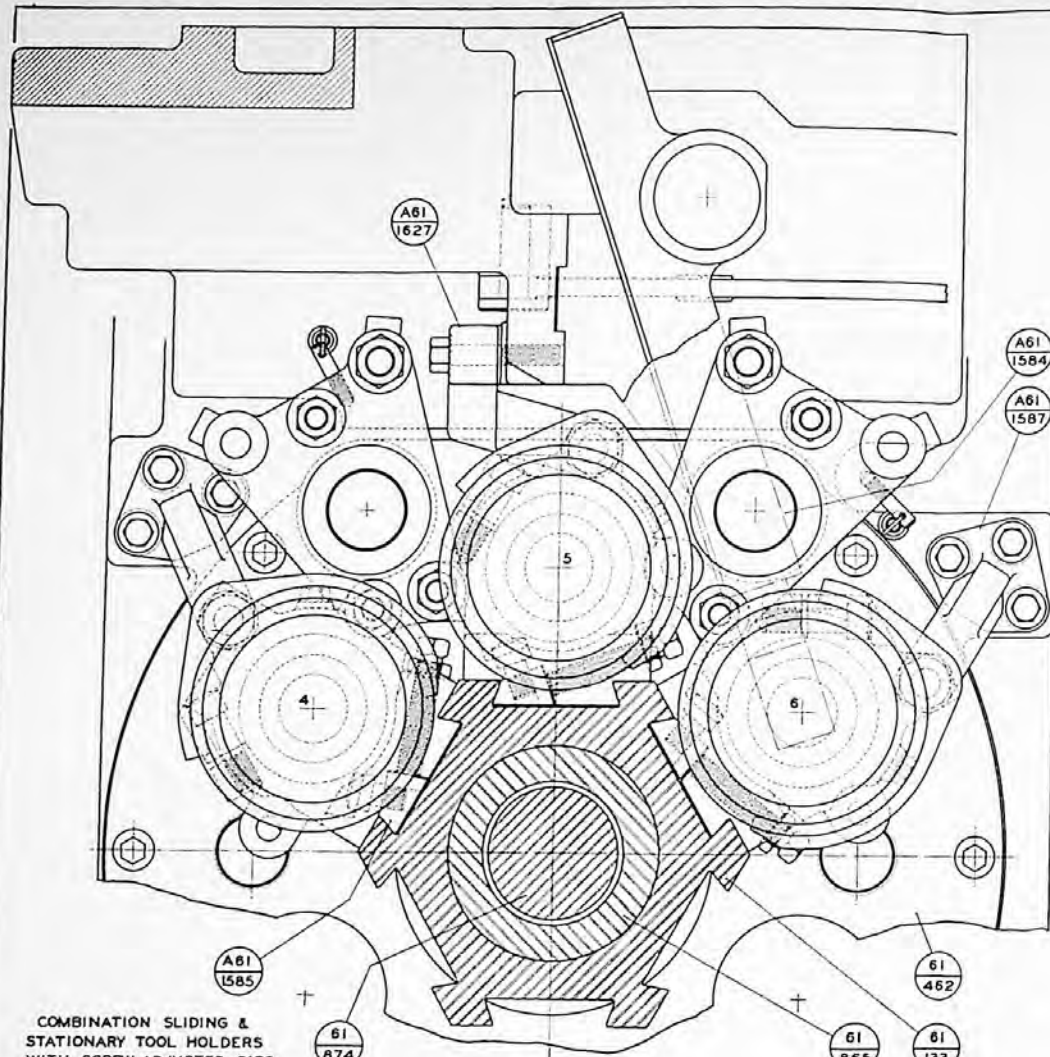
REVERSING TAPPING & DIE REVOLVING MECHANISM

A61-1513 Key
A61-1516 Lever, Threading Clutch Yoke
A61-1519 Plate, Bearing Retaining
A61-1521 Shaft, Threading Clutch Lever
A61-1523 Shaft, Threading Drive
A61-1526 Sleeve, Driving
A61-1528 Spacer, Drill Speeder Shaft
A61-1530 Spacer, Threading Drive Shaft Gear
A61-1531 Shaft, Threading Clutch Cam Slide
A61-1532 Yoke, Threading Clutch
A61-1533 Slide, Threading Clutch Cam
A61-1537 Stud, Drill Speeder Idler Gear
A61-1538 Spacer, Threading Drive Shaft Bearing - Front
A61-1539 Spacer, Threading Drive Shaft Bearing - Rear
A61-1540 Bushing, Threading Shaft Bearing
A61-1546 Lever, Threading Clutch Yoke Intermediate
A61-1635 Spacer, Drill Speeder Idler Gear
A61-1637 Bracket, Drill Speeder Idler
A61-1638 Sleeve, Drill Driving Spindle
A61-1737 Sleeve, Threading Spindle
A61-1738 Stud, Clutch Slide or Yoke Lever Roll
A61-1739 Shaft, Drill Speeder - Long
A61-1740 Spacer, Threading & Drill Speeder
A61-1741 Bushing
A61-1742 Cover, Drill Driving Spindle
41-7098 Shoe, Slack Adjusting
41-7107 Stud, Accelerating Slide Roll
C41-9301 Gear, Drill Speeder Idler

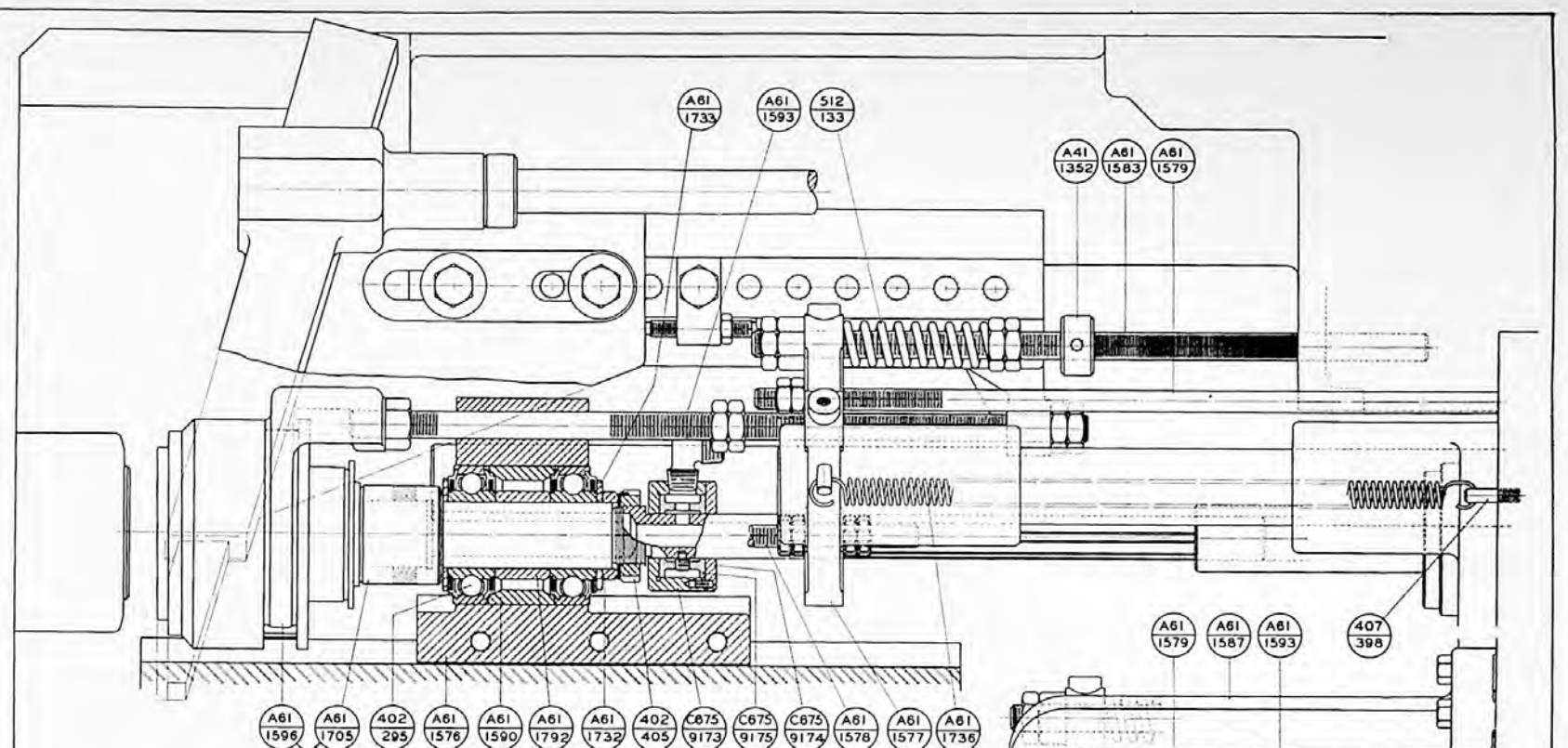
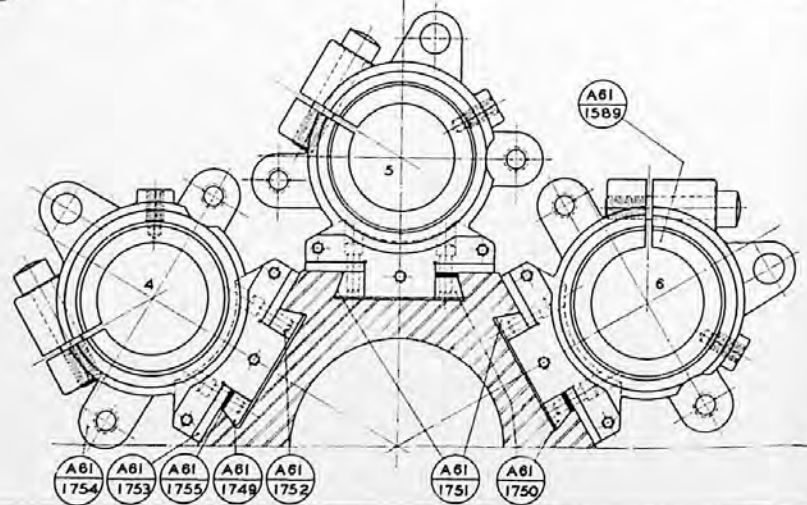
WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL
NUMBER OF THE MACHINE FOR WHICH THE PARTS ARE DESIRED.



NEW BRITAIN-GRIDLEY MACHINE DIV.,
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New Britain, Conn., U.S.A.



COMBINATION SLIDING & STATIONARY TOOL HOLDERS WITH SCREW ADJUSTED GIBS SHOWN ABOVE.

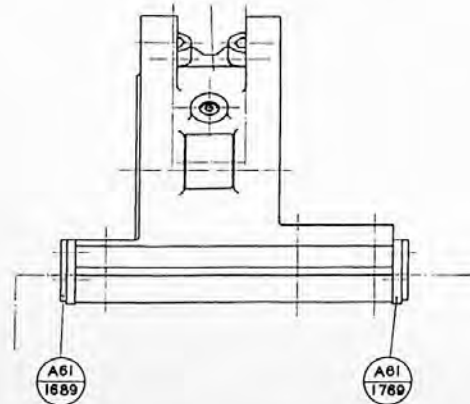


BLANK
SEE CUSTOMER'S SPEC'S

WHEN ORDERING DIE TRIP FORKS SPECIFY MANUFACTURER, STYLE, AND SIZE OF DIE HEAD USED. ALSO SPECIFY POSITION USED IN.

DIE HEAD
SEE CUSTOMER'S SPEC'S.

COMBINATION SLIDING & STATIONARY TOOL HOLDERS WITH SHIM & SPACER TYPE GIBS SHOWN AT LOWER LEFT.



NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
NEW BRITAIN, CONN. U.S.A.

PLATE VI
DIE TRIP MECHANISM

PLATE VI

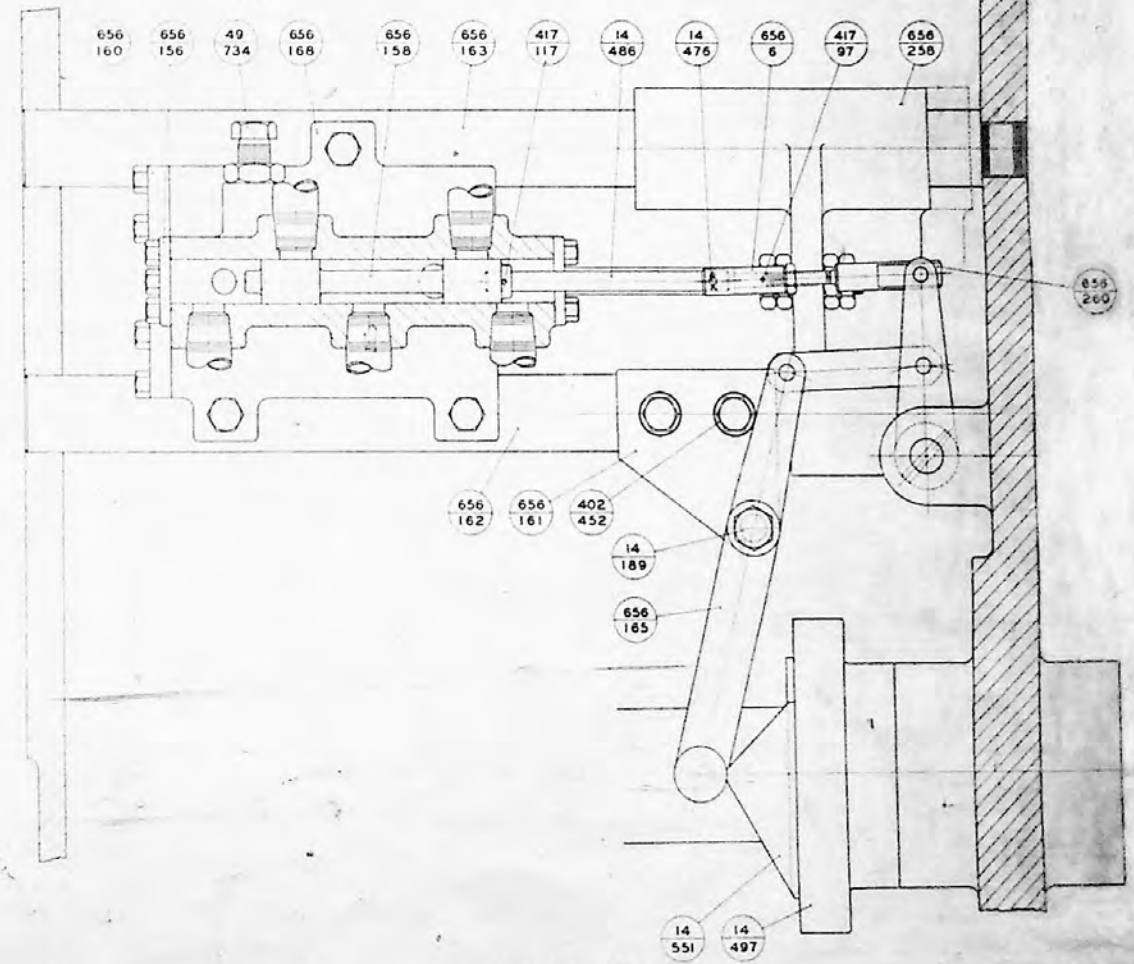
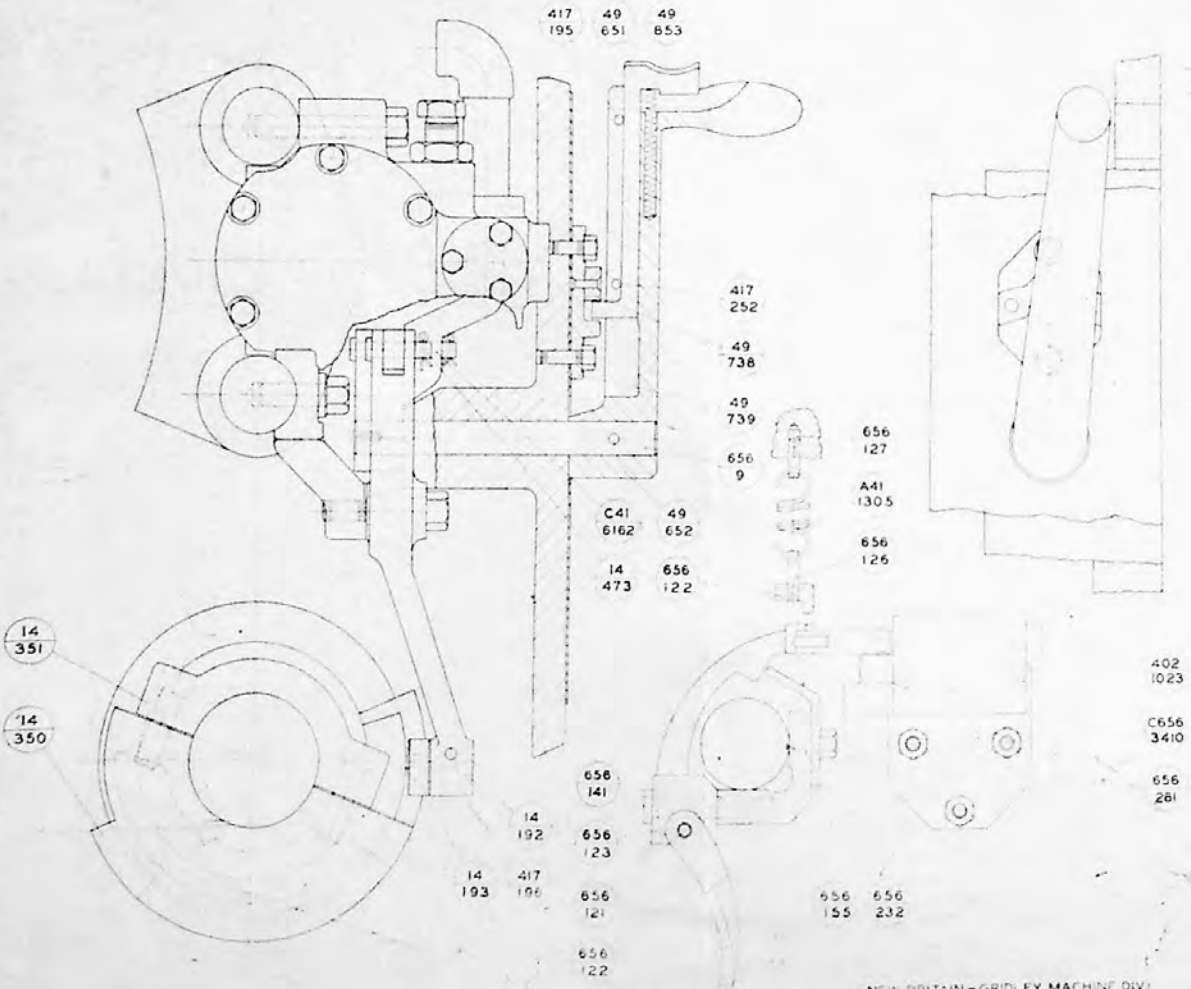
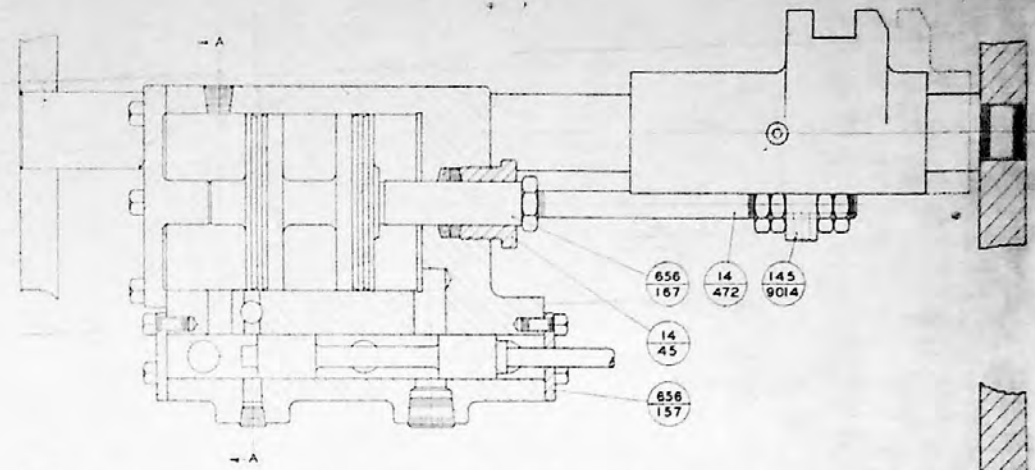
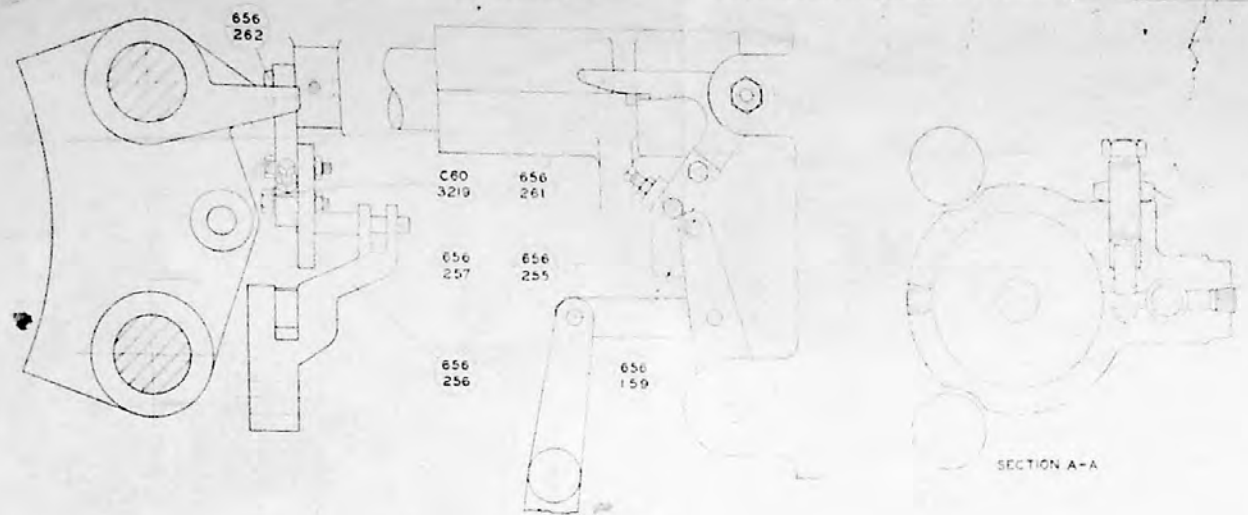
DIE TRIP MECHANISM & COMB. TOOL SLIDE TOOL HOLDERS

61-133	Slide, Tool	A61-1612	Rod, Aux. Slide Actuating (4th & 6th Pos.)
512-133	Spring, Draw Rod	A61-1627	Bracket, Die Trip Rod
402-295	Bearing, Die Head Spindle	A61-1689	Retainer, Tool Holder Wiper
407-398	Stud, Return Spring	A61-1705	Spindle, Die Head (Blank)
402-405	Locknut & Washer	A61-1732	Spacer, Bearing (External)
61-462	Plate, Power Case (Front)	A61-1733	Washer, Bearing Protecting
61-865	Stem, Carrier	A61-1736	Spring, Aux. Slide Return
61-874	Shaft, Spindle Drive	A61-1749	Gib, Tool Holder (4th Pos.)
A41-1352	Collar, Aux. Slide Stop	A61-1750	Gib, Tool Holder (5th & 6th Pos.)
A61-1576	Holder, Comb. Tool (Screw Adj.Type)	A61-1751	Gib, Tool Holder (5th & 6th Pos.)
A61-1577	Arm, Aux. Slide Connecting	A61-1752	Gib, Tool Holder (4th Pos.)
A61-1578	Rod, Aux. Slide Actuating-5th Pos.	A61-1753	Spacer, Tool Holder
A61-1579	Rod, Stop	A61-1754	Holder, Comb. Tool (Shim & Spacer Type)
A61-1583	Rod, Aux. Tool Slide Actuating	A61-1755	Shim, Laminated
A61-1584	Guide, Aux. Slide Connecting Arm	A61-1769	Wiper, Comb. Tool Holder
A61-1585	Gib, Tool Holder (Screw Adj. Type)	A61-1792	Spacer, Bearing (Inner)
A61-1587	Bracket, Die Trip Rod	A61-1797	Collar, Adjusting
A61-1589	Bushing, Tool Holder	C675-9173	Housing, Oil Distributor
A61-1590	Spacer, Bearing (Outer)	C675-9173	Retainer, Oil Distributor
A61-1593	Rod, Die Trip	C675-9175	Ring, Oil Distributor
A61-1596	Fork, Die Trip (Blank)		

WHEN ORDERING REPAIR PARTS, ALWAYS INCLUDE THE SERIAL NUMBER OF THE MACHINE FOR WHICH THE PARTS ARE DESIRED.



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NEW BRITAIN, CONN., U.S.A.

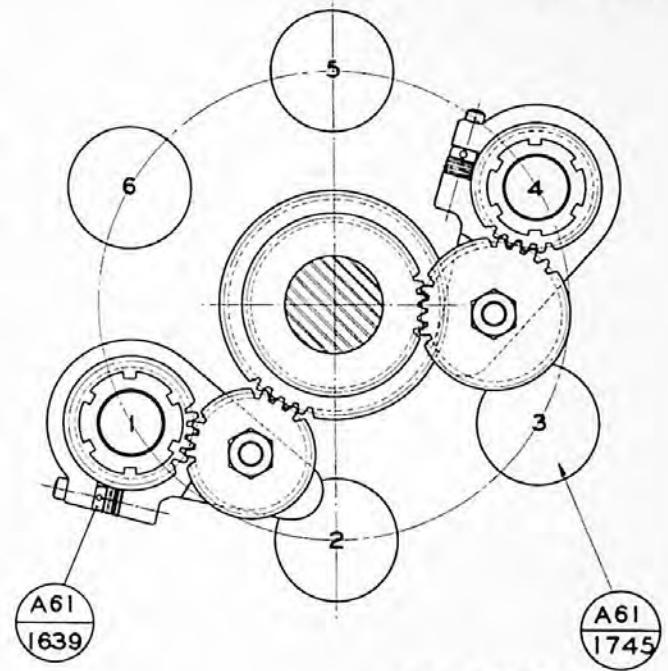
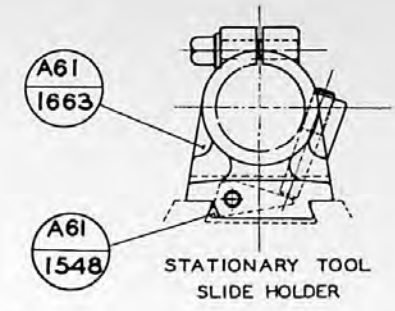
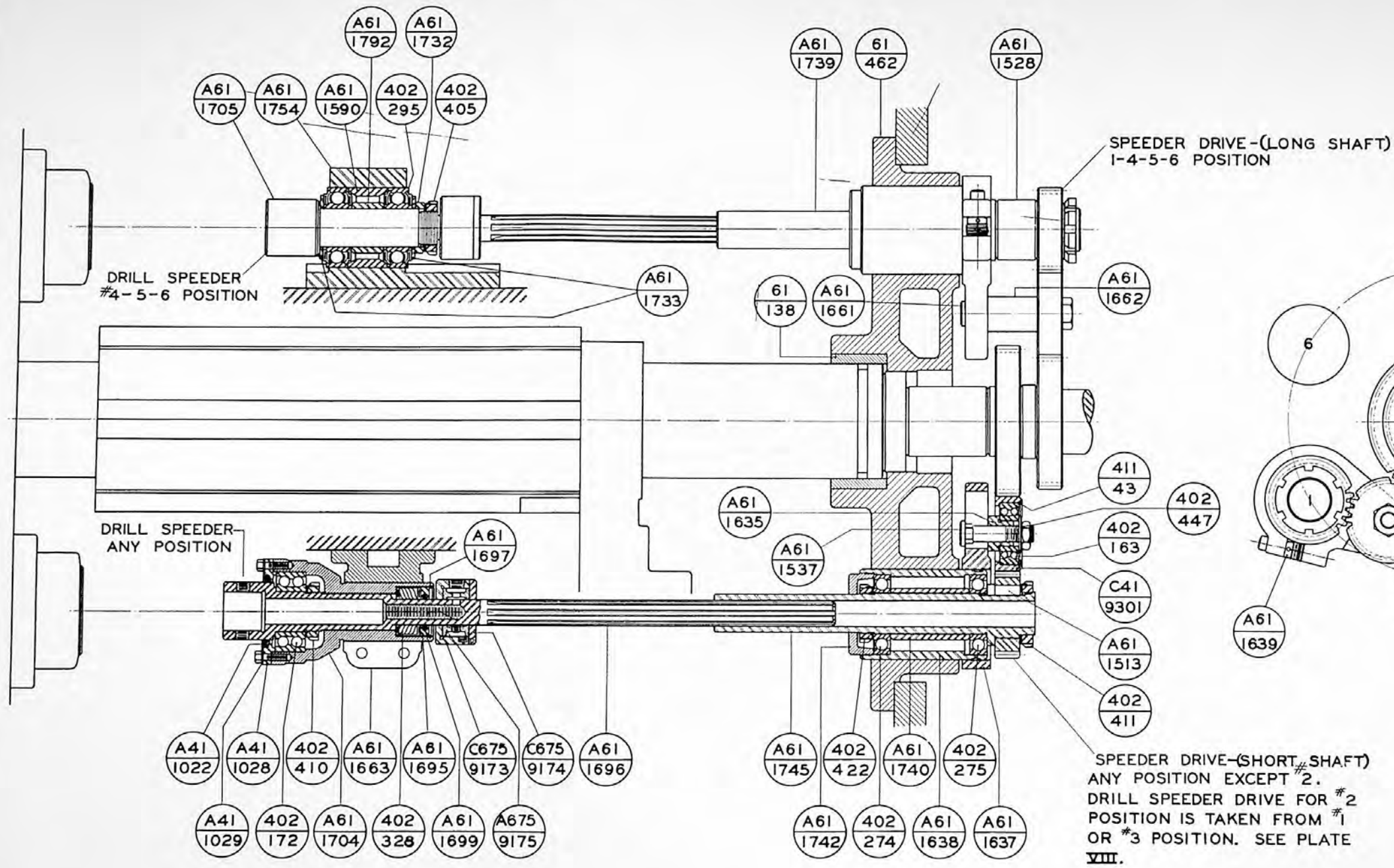
PLATE VI
CHUCK & CLUTCH OPER. VALVE MECHANISM

PLATE VI
CHUCKING & CLUTCH OPERATING VALVE

656-6	End, Valve Connecting Rod	417-252	Pin, Retaining
656-9	Shaft, Operating Lever	656-255	Lever, Safety Stop Latch
14-45	Nut, Gland Packing	656-256	Lever, Piston Connecting Rod
417-97	Pin, Dowel	656-257	Pin, Pivot
417-117	Pin, Dowel	656-258	Slide, Spindle Clutch Operating
656-121	Pin, Actuating Lever Fulcrum	656-260	Rod, Piston Valve Connecting
656-122	Lever, Limit Switch Actuating	656-261	Latch, Slide Safety Stop
656-123	Block, Actuating Lever Swivel	656-262	Stud, Stop Latch Lever
656-126	Stud, Spring Retaining	656-281	Plate, Limit Switch Support
656-127	Stud, Spring Retaining	14-350	Cam, Safety
656-141	Stud, Swivel Block	14-351	Cap, Safety Cam
656-155	Bracket, Actuating Lever	402-452	Washer, Cam Lever Bracket
656-156	Cap, Piston Valve Cylinder (Left)	14-472	Rod, Clutch Operating Piston
656-157	Cap, Piston Valve Cylinder (Right)	14-473	Pin, Pivot
656-158	Valve, Chuck Operating Piston	14-476	Pin, Pivot
656-159	Link, Spindle Stopping Lever	14-486	Stem, Piston Valve
656-160	Cover, Valve Body	14-497	Disc, Cam
656-161	Bracket, Cam Lever	14-551	Cam, Clutch Throw Out
656-162	Guide, Clutch Operating Slide (Lower)	49-651	Trigger, Operating Lever
656-163	Guide, Clutch Operating Slide (Upper)	49-652	Lever, Chuck & Clutch Operating
656-165	Lever, Spindle Stopping	49-734	Valve, Chuck Operating Needle
656-167	Piston, Clutch Operating Valve	49-738	Stop, Operating Lever
656-168	Body, Chuck & Clutch Valve	49-739	Bracket, Lever Stop
14-189	Stud, Lever Fulcrum	49-853	Spring, Operating Lever
14-192	Stud, Cam Roll	402-1023	Switch, Limit
14-193	Roll, Spindle Stopping Cam	A41-1305	Spring, Actuating Lever Pullback
417-195	Pin, Retaining	C60-3219	Washer
417-196	Pin, Dowel	C656-3410	Stud, Limit Switch
656-232	Stop, Limit Switch Actuating Lever	C41-6162	Pin, Pivot
		145-9014	Key, Piston Rod

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THE SHORT SHAFT DRILL SPEEDER MUST BE USED IN THE #3 POSITION.

SPEEDER DRIVE-(SHORT SHAFT) ANY POSITION EXCEPT #2. DRILL SPEEDER DRIVE FOR #2 POSITION IS TAKEN FROM #1 OR #3 POSITION. SEE PLATE VIII.

PLATE VII
DRILL SPEEDERS

NEW BRITAIN-GRIDLEY MACHINE DIV,
THE NEW BRITAIN MACHINE CO.,
NEW BRITAIN, CONN., U.S.A.

PLATE VII

DRILL SPEEDERS

411-43	Retainer, Drill Speeder Idler Bearing	A61-1638	Sleeve, Drill Driving Spindle
61-138	Bushing, Carrier Stem	A61-1639	Lock, Idler Bracket
402-163	Bearing, Drill Speeder Idler Gear	A61-1661	Stud, Idler Gear
402-172	Bearing, Drill Speeder Spindle	A61-1662	Bushing, Drill Speeder Idler Gear
402-274	Bearing, Driving Spindle Sleeve	A61-1663	Holder, Stationary Tool Slide Tool
402-275	Bearing, Driving Spindle Sleeve	A61-1695	Ring, Packing
402-295	Bearing, Die Head Spindle	A61-1696	Spindle, Drill Speeder (Blank)
402-328	Bearing, Drill Speeder Spindle	A61-1697	Retainer, Packing Ring
402-405	Locknut and Washer	A61-1699	Packing, Retainer (Rear)
402-410	Locknut and Washer	A61-1704	Quill, Drill Speeder
402-411	Locknut and Washer	A61-1705	Spindle, Die Head (Blank)
402-422	Locknut and Washer	A61-1732	Spacer, External
402-447	Washer, Idler Stud	A61-1733	Washer, Bearing Protecting
61-462	Plate, Power Case (Front)	A61-1739	Shaft, Drill Speeder (Long)
A41-1022	Packing, Retainer (Front)	A61-1740	Spacer, Drill Speeder Sleeve
A41-1028	Retainer, Bearing	A61-1742	Cover, Drill Driving Spindle
A41-1029	Plate, Felt Retaining	A61-1745	Shaft, Drill Speeder (Short)
A61-1513	Key	A61-1754	Holder, Comb. Tool Slide Tool
A61-1528	Spacer, Drill Speeder Shaft	A61-1792	Spacer, Bearing (Inner)
A61-1537	Stud, Drill Speeder Idler Gear	C675-9173	Housing, Oil Distributor
A61-1548	Cam, Tool Holder	C675-9174	Retainer, Oil Ring
A61-1590	Spacer, Bearing (Outer)	C675-9175	Ring, Oil
A61-1635	Spacer, Drill Speeder Idler Gear	C41-9301	Gear, Drill Speeder Idler
A61-1637	Bracket, Drill Speeder Idler		

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NEW BRITAIN-GRIDLEY MACHINE DIV.
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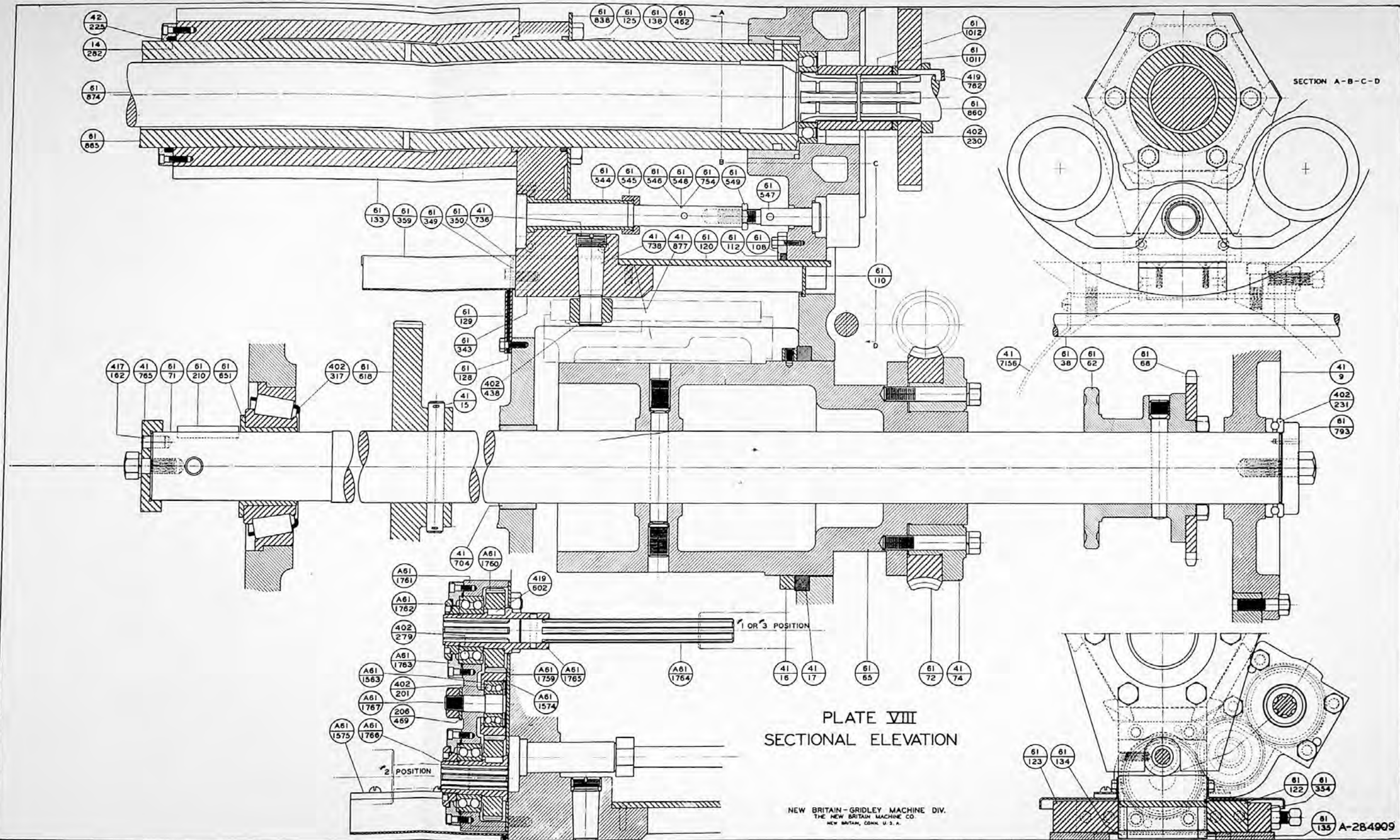


PLATE VIII
SECTIONAL ELEVATION

41-9	Plate, Main Cam Shaft Thrust	402-201	Bearing, Drill Speeder Idler Gear
41-15	Pin, Main Cam Shaft Gear	61-210	Key, Main Cam Shaft
41-16	Ring, Felt Retaining	42-225	Retainer, Tool Slide Packing
41-17	Packing, Main Cam Drum	402-230	Bearing, Spindle Drive Shaft
61-38	Rod, Feed Clutch Control	402-231	Bearing, Main Cam Shaft Thrust
61-62	Disc, Sprocket Hub and Cam	402-279	Bearing, Drill Speeder Gear Sleeve
61-65	Drum, Main Cam	14-282	Packing, Tool Slide - Front
61-68	Sprocket, Main Cam Shaft	402-317	Bearing, Main Cam Shaft
61-71	Shaft, Main Cam	61-343	Plate, Tool Slide Thrust
61-72	Wheel, Worm	61-349	Retainer, Thrust Plate Wiper
41-74	Plate, Main Cam Shaft Friction	61-350	Wiper, Thrust Plate
61-108	Retainer, Chip Guard Wiper	61-354	Bar, Rear Guide Adjusting
61-110	Stop, End Plate Oil	61-359	Guard, Thrust Plate Chip
61-112	Wiper, Chip Guard	402-438	Ring, Main Cam Roll Retaining
61-120	Guard, Thrust Plate Chip	61-462	Plate, Power Case - Front
61-122	Guide, Tool Slide - Rear	206-469	Washer, Drill Speeder Idler Gear
61-123	Guide, Tool Slide - Front	61-544	Sleeve, Tool Slide Stop
61-125	Packing, Thrust Plate	61-545	Nut, Tool Slide Stop Bushing
61-128	Wiper, Chip Guard Felt	61-546	Rod, Tool Slide Stop - 6" Max. Stroke
61-129	Retainer, Chip Guard Wiper	61-547	Screw, Tool Slide Stop Adj.
61-133	Slide, Tool	61-548	Rod, Tool Slide Stop - 3" Max. Stroke
61-134	Shoe, Thrust Plate - Front	61-549	Nut, Tool Slide Stop Check
61-135	Shoe, Thrust Plate - Rear	419-602	Key, Drill Speeder Gear
61-138	Bushing, Carrier Stem	61-618	Gear, Main Cam Shaft
417-162	Pin, Carrier Relief Cam Dowel	61-651	Bushing, Main Cam Shaft Bearing

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL
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NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
New Britain, Conn., U.S.A.

PLATE VIII (Continued)

SECTIONAL ELEVATION

41-704 Bushing, Main Cam Shaft
41-736 Plug, Tool Slide
41-738 Stud, Cam Roll
61-754 Rod, Tool Slide Stop - 4" Max. Stroke
419-762 Key, Primary Spindle Drive Shaft
41-765 Cam, Carrier Relief
61-793 Washer, Main Cam Shaft
61-838 Retainer, Thrust Plate Wiper
61-860 Shaft, Primary Spindle Drive
61-865 Stem, Carrier
61-874 Shaft, Spindle Drive
41-877 Roll, Tool Slide Cam
61-1011 Washer, Spindle Drive Spring
61-1012 Coupling, Spindle Drive Shaft
A61-1563 Gear, Drill Speeder Idler
A61-1574 Retainer, Drill Speeder Idler Gear Bearing
A61-1575 Guard, Tool Slide Thrust Plate (Alternate for 61-359)
A61-1759 Cover, Drill Speeder Housing
A61-1760 Gear, Drill Speeder
A61-1761 Housing, Drill Speeder
A61-1762 Nut, Drill Speeder Gear Sleeve Retaining
A61-1763 Retainer, Drill Speeder Bearing
A61-1764 Shaft, Drill Speeder Extension
A61-1765 Sleeve, Drill Speeder Gear - Long
A61-1766 Sleeve, Drill Speeder Gear - Short
A61-1767 Stud, Drill Speeder Idler Gear
41-7156 Guard, Tool Slide Cam

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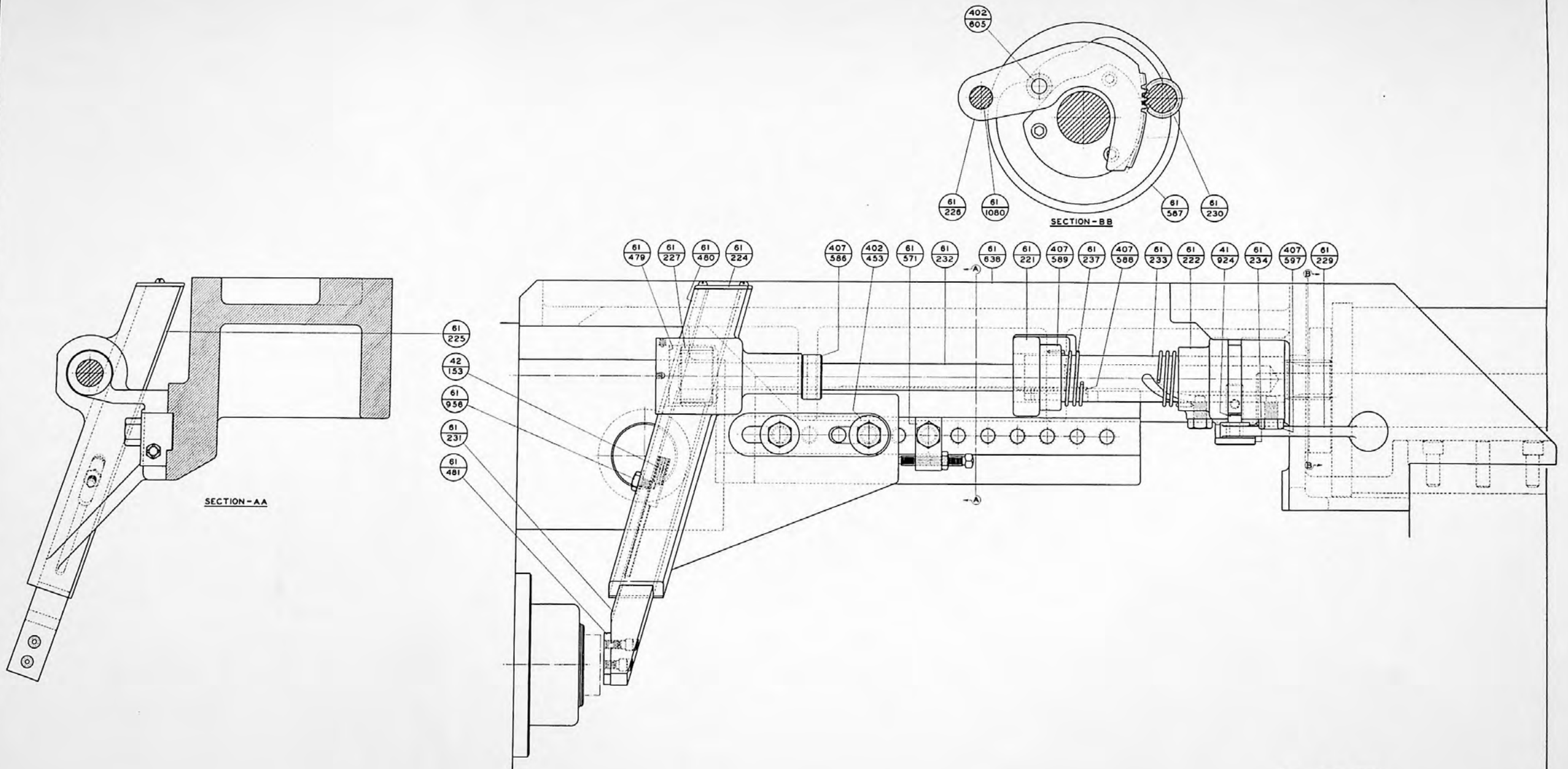


PLATE IX
STOCK STOP

NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
NEW BRITAIN, CONN. U.S.A.

A-152589
E.C.A. 9-1954

PLATE IX

STOCK STOP

42-153 Spring, Stock Stop Backlash
61-221 Bracket, Spring Thrust
61-222 Bushing, Connecting
61-224 Cover, Holder Top
61-225 Cover, Holder
61-226 Gear, Segment
61-227 Gear, Rack
61-229 Lever, Hand
61-230 Pinion, Stock Stop
61-231 Rack, Stock Stop
61-232 Shaft, Stock Stop
61-233 Sleeve, Stock Stop Shaft
61-234 Stud, Hand Lever Fulcrum
61-237 Spring, Reset
402-453 Washer, Stock Stop Holder
61-479 Cap, Holder
61-480 Holder, Stock Stop
61-481 Pad, Stock Stop Rack
61-571 Block, Check
407-586 Collar, Shaft
61-587 Cam, Stock Stop Oper.
407-588 Key, Sleeve
407-589 Collar, Reset Spring Tension
407-597 Screw, Connecting Bushing
402-605 Stud, Stock Stop Cam Roll And
61-638 Plate, Top
41-924 Stud, Hand Lever
61-956 Screw, Stock Stop Rack
61-1080 Stud, Segment Gear

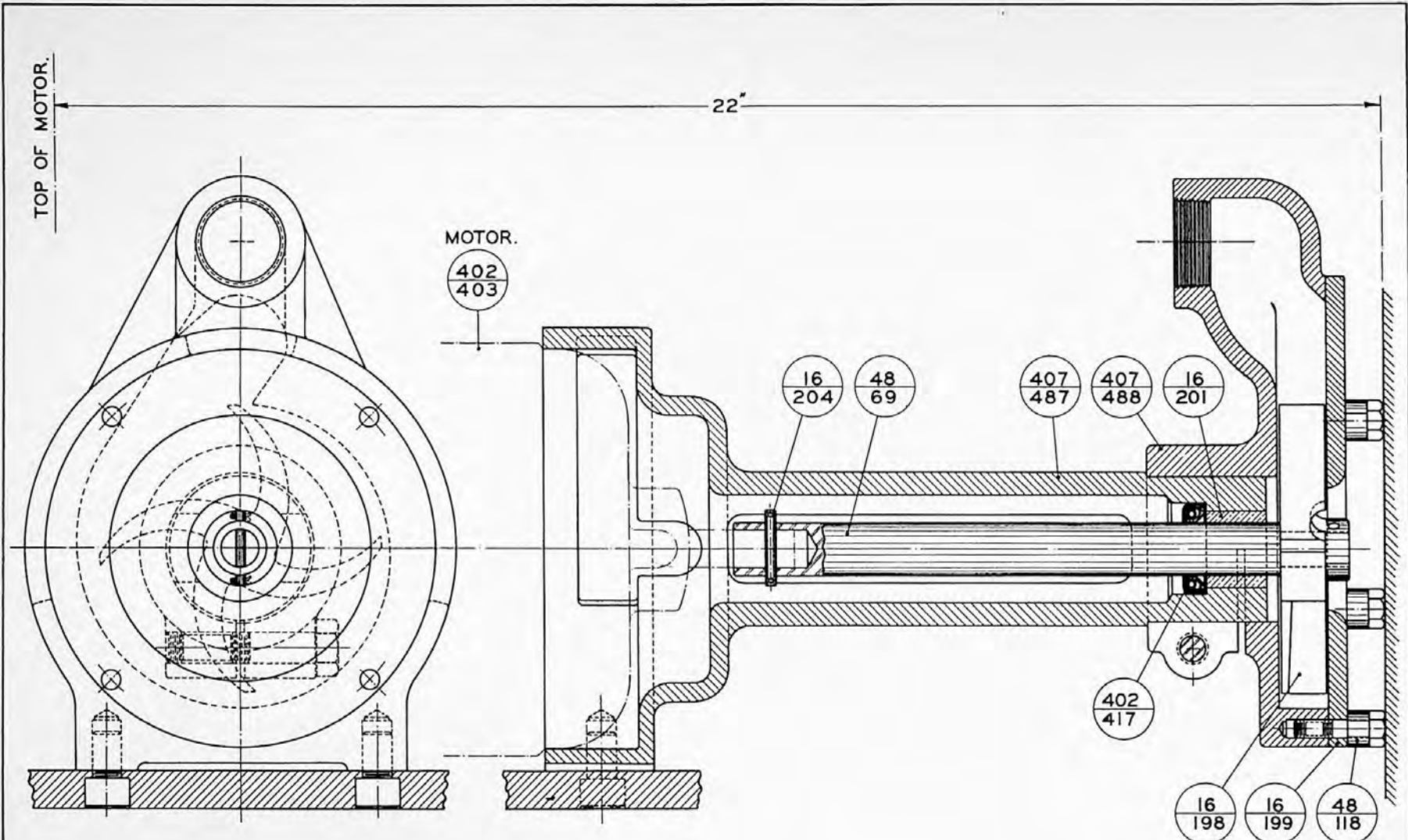
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NEW BRITAIN-GRIDLEY MACHINE DIV.
 THE NEW BRITAIN MACHINE CO.
 NEW BRITAIN, CONN., U. S. A.

PLATE X.
 COOLANT PUMP.

R-143453

PLATE X

COOLANT PUMP

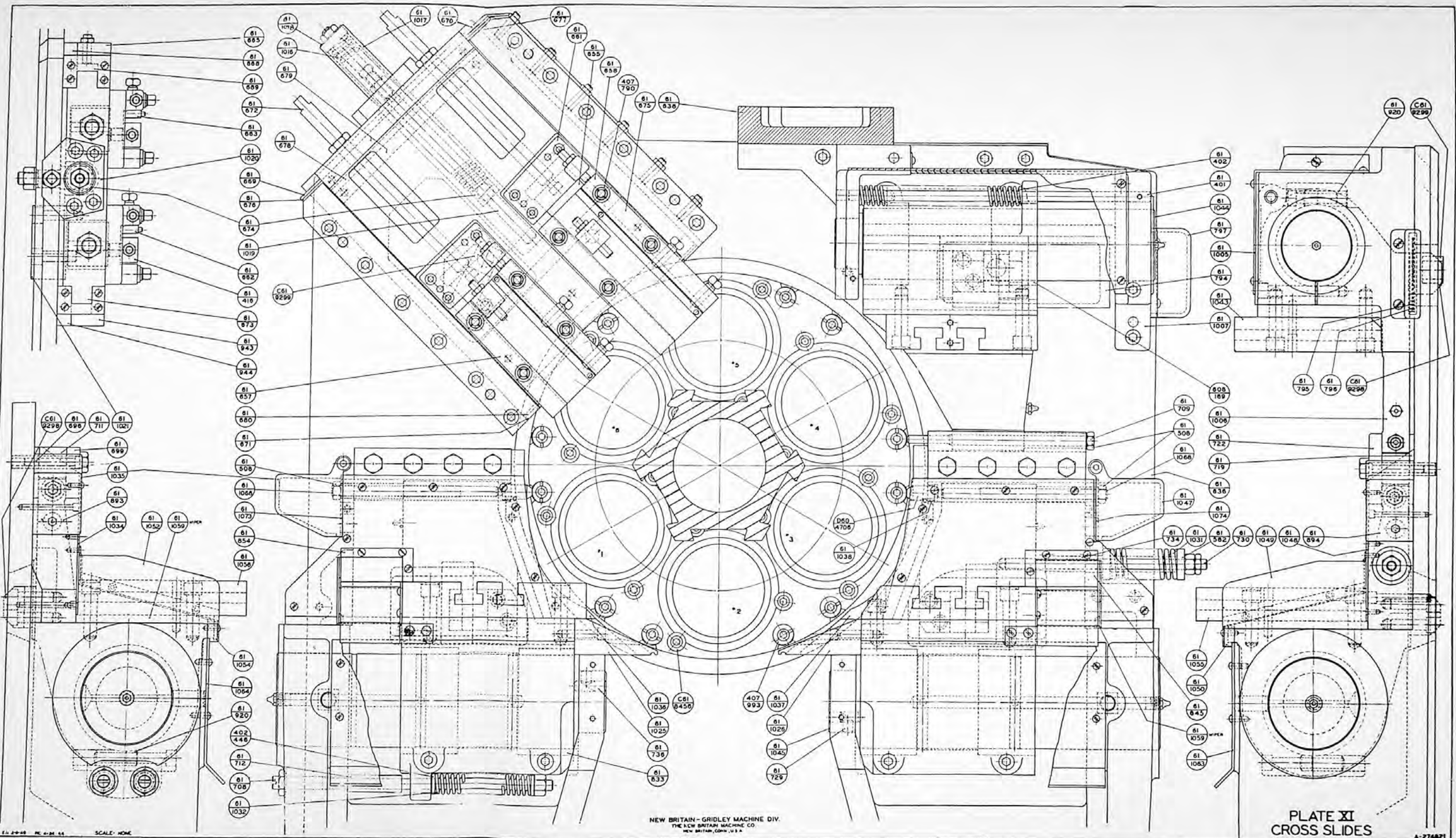
48-69 Shaft, Drive
48-118 Spacer,
16-198 Impeller
16-199 Cover, Impeller
16-201 Bushing, Pump Shaft
16-204 Pin, Drive Shaft
402-403 Motor, 1/3 H.P., 1800 R.P.M.
402-417 Seal, Oil
407-487 Bracket, Motor
407-488 Body, Pump

NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
New Britain, Conn., U.S.A.

8-10-37

T-177581

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EN 2048 NC 40 44 SCALE: NONE

NEW BRITAIN - GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
NEW BRITAIN, CONNECTICUT, U.S.A.

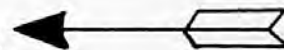
PLATE XI
CROSS SLIDES

A-274821

PLATE XI
CROSS SLIDES

608-169	Bushing, Upper Rear Forming Slide	61-708	Rod, Forming Slide Check Spring Guide
61-401	Rod, Upper Rear Check Spring Guide	61-709	Screw, Forming Slide Stop
61-402	Spring, Upper Forming Slide	61-711	Spacer, Forming Slide Guide
61-416	Post, Adjusting Screw	61-712	Spacer, L.F. Forming Slide Check Spring
402-446	Washer, Check Spring	61-719	Base, Rear Forming Slide Guide
61-508	Nut, Forming Stop Screw Check	61-722	Cap, Rear Forming Slide Guide
61-582	Retainer	61-729	Plug, Clamping Screw
61-636	Frame	61-730	Rod, L.R. Forming Slide Check Spring Guide
61-638	Plate, Top	61-734	Spacer, L. R. Forming Slide Check Spring
61-655	Wedge, Cut Off Slide Adjusting	61-736	Screw, Forming Slide Stud Clamping
61-657	Adapter, Tool Holder (6th Pos.)	407-790	Washer
61-658	Adapter, Tool Holder (5th Pos.)	61-794	Plate, Upper Forming Slide
61-661	Block, Adapter Thrust	61-795	Plate, Upper Filler
61-662	Block, Adapter Gage (6th Pos.)	61-796	Seal, Upper Rear Chip Guard
61-663	Block, Adapter Gage (5th Pos.)	61-797	Guard, Upper Forming Slide Dust Plate
61-665	Guide, Upper Cut Off Slide	61-833	Bushing, Forming Slide
61-668	Plate, Upper Cut Off Slide Wear	61-845	Plate, L.R. Forming Slide Guard Retainer
61-669	Retainer, Cut Off Slide Guide Wiper (L)	61-854	Plate, L. F. Forming Slide Guard Retainer
61-670	Retainer, Cut Off Slide Guide Wiper (U)	61-893	Slide, Lower Front Forming
61-671	Retainer, Cut Off Slide Wiper	61-894	Slide, Lower Rear Forming
61-672	Screw, Cut Off Slide Adjusting	61-920	Binder, Forming Slide
61-673	Slide, Double Cut Off	61-943	Guide, Lower Cut Off Slide
61-674	Stud, Cut Off Slide Spring	61-944	Plate, Lower Cut Off Slide Wear
61-675	Plate, Cut Off Slide Chip Guard	407-993	Stop, Forming Slide
61-676	Wiper, Cut Off Slide Guide (Lower)	61-1005	Guard, Upper Rear Cross Slide
61-677	Wiper, Cut Off Slide Guide (Upper)	61-1006	Slide, Upper Rear Forming
61-678	Wiper, Cut Off Slide	61-1007	Bracket, Upper Forming Slide
61-679	Retainer, Cut Off Slide Wiper	61-1016	Spring, Double Cut Off Slide
61-680	Wiper, Cut Off Slide	61-1017	Tube, Spring
61-689	Gib, Cut Off Slide	61-1018	Plug, Tube
61-696	Base, Front Forming Slide Guide	61-1019	Guide, Cut Off Slide Check Spring
61-699	Cap, Front Forming Slide Guide	61-1020	Block, Cut Off Slide Stop

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NEW BRITAIN-GRIDLEY MACHINE DIV.,
THE NEW BRITAIN MACHINE CO.
New Britain, Conn., U.S.A.

7-286814

6/24/44

PLATE XI (Continued)

CROSS SLIDES

61-1021 Block, Cut Off Slide Thrust
61-1025 Chute, Front Forming Slide Chip
61-1026 Chute, Rear Forming Slide Chip
61-1031 Spring, L.R. Forming Slide Check
61-1032 Spring, L.F. Forming Slide Check
61-1034 Cover, L.F. Forming Slide Dust
61-1035 Guard, L.F. Forming Slide Chip
61-1036 Spacer, L.F. Dust Cover
61-1037 Spacer, Lower Rear Dust Cover
61-1038 Spring, Forming Slide Stop Plug
61-1043 Block, Upper Rear Forming Slide
61-1044 Shaft, Upper Forming Stud
61-1045 Stud, Lower Rear Forming Slide
61-1047 Guard, Lower Rear Forming Slide Chip
61-1048 Cover, L.R. Forming Slide Guide Dust
61-1049 Guard, L.R. Forming Slide
61-1050 Clip, L.R. Forming Slide Guard
61-1052 Guard, L.F. Forming Slide
61-1054 Clip, L.F. Forming Slide Guard
61-1055 Block, L.R. Forming Slide
61-1056 Block, L.F. Forming Slide
61-1059 Wiper, Forming Slide Guard
61-1063 Cover, L.R. Forming Slide Chip
61-1064 Cover, L.F. Forming Slide Chip
61-1068 Screw, Forming Slide Stop
61-1073 Block, L.F. Dust Cover Filler
61-1074 Bracket, L.R. Forming Slide Check Spring
D60-4706 Plug, Forming Slide Stop
C61-8456 Plug, Spindle Carrier
C61-9298 Guide, Forming Slide Arm
C61-9299 Block, Guide

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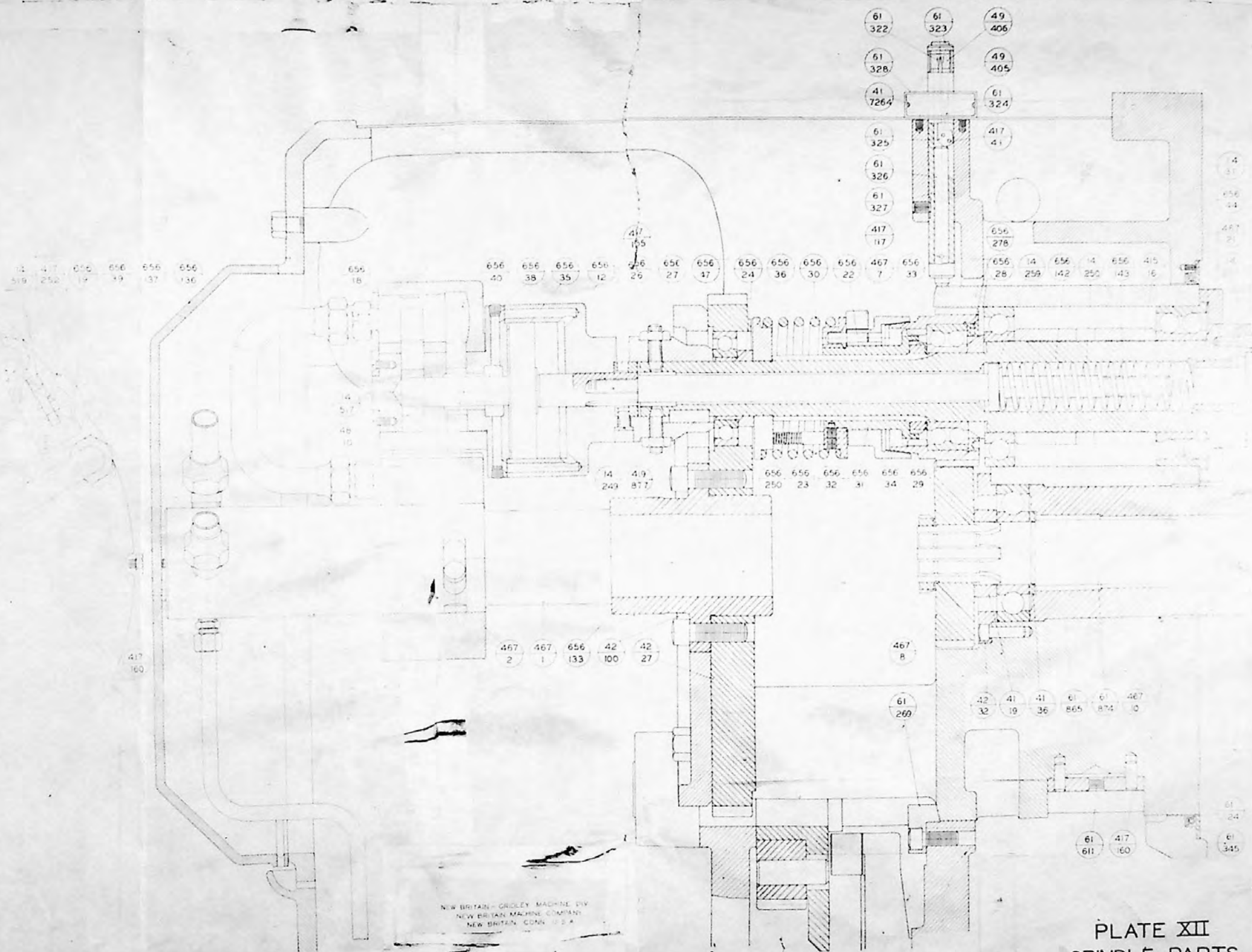


NEW BRITAIN-GRIDLEY MACHINE DIV.,
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New Britain, Conn., U.S.A.

7-2868/5

6/24/44

11



NEW BRITAIN OROLEY MACHINE DIV
 NEW BRITAIN MACHINE COMPANY
 NEW BRITAIN, CONN. U.S.A.

PLATE XII
 SPINDLE PARTS

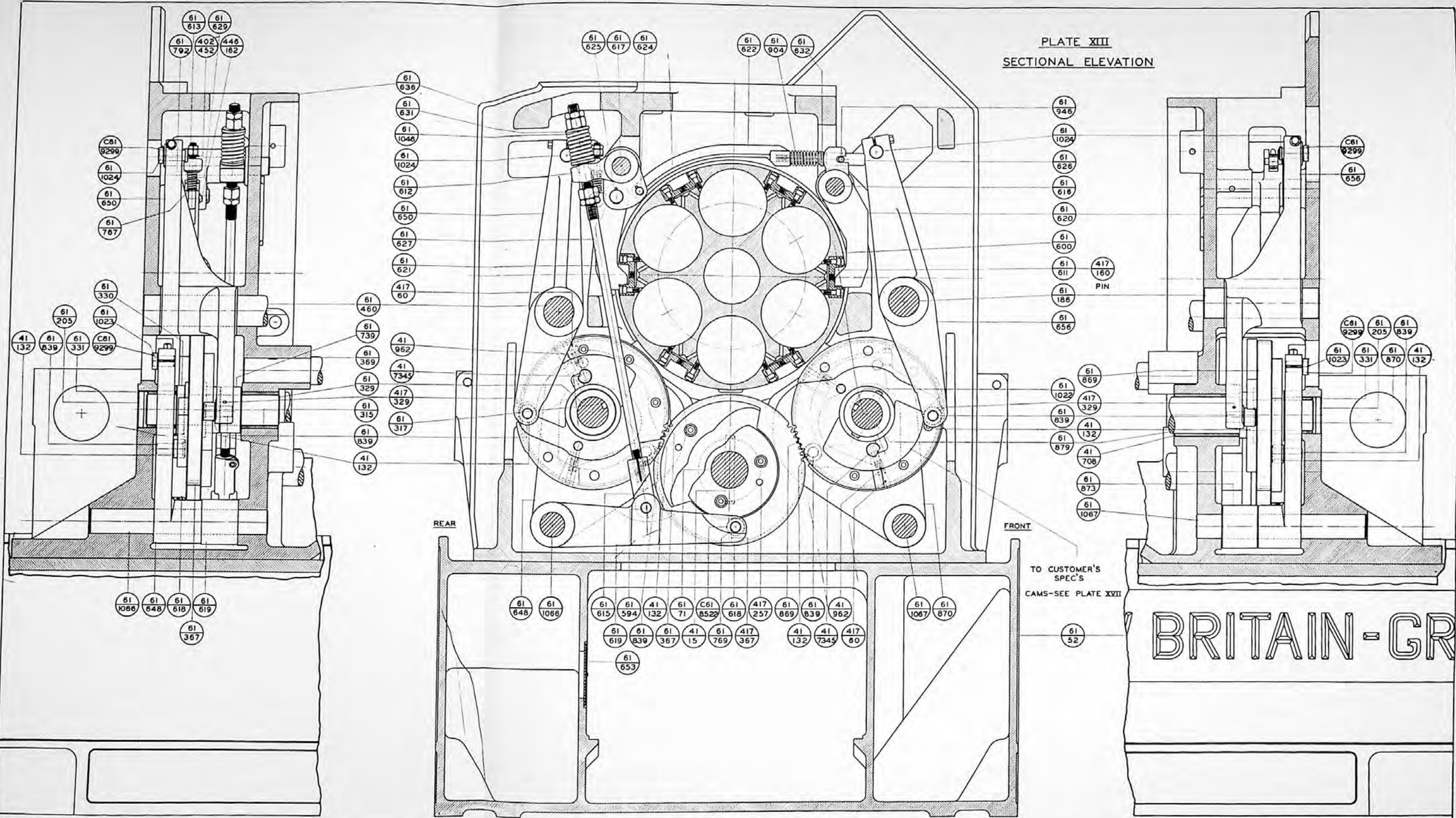
PLATE X11 - SPINDLE PARTS

467-1	Distributor	42-100	Disc, Carrier Lifting
467-2	Shell, Distributor	417-117	Pin, Dowel
467-7	Fork, Clutch Operating	61-124	Packing, Spindle Carrier
467-8	Gear, Spindle Drive	656-133	Sleeve, Index Plate Support
467-10	Carrier, Spindle	656-136	Plate, End
48-10	Plate, Retainer (For Hub)	656-137	Door, End Plate
656-12	Cylinder, Spindle	656-142	Rod, Chuck Draw
415-16	Spacer, Spindle Bearing	656-143	Spindle
656-18	Valve, Reversing	417-155	Pin, Draw Rod Retaining
656-19	Plate, Reversing Valve Retaining	417-160	Pin, Dowel
41-19	Spacer, Spindle Driving Gear	14-249	Screw, Spindle Cylinder Set
467-21	Plate, Spindle Retaining	656-250	Spring, Friction Clutch Drive Pin
656-22	Pin, Spindle Friction Clutch	14-250	Spring, Spindle Draw Rod
656-23	Pin, Spindle Friction Clutch Drive	417-252	Pin, Reversing Valve Handle
656-24	Adapter, Spindle Bearing	14-257	Bushing, Spindle Nose
656-26	Lock, Piston Adjustment	14-259	Washer, Draw Rod Spring
656-27	Screw, Cylinder Retaining	61-269	Block, Carrier Thrust
42-27	Gear, Index Carrier	656-278	Shoe, Lockscrew
656-28	Spacer, Spindle Bearing	61-322	Dial, Indicator
656-29	Nut, Bearing Retainer	61-323	Cap, Housing
656-30	Spring, Spindle Positive Clutch	61-324	Spring, Pointer
656-31	Clutch, Positive (Driven)	61-325	Pointer
14-31	Key, Chuck Driving	61-326	Pin, Pointer Lift
656-32	Flange, Positive Clutch	61-327	Housing, Lift Indicator
49-32	Plate, Drive Shaft Retaining	61-328	Bracket, Warning Plate
656-33	Clutch, Spindle Friction	61-345	Retainer, Spindle Carrier Wiper
656-34	Clutch, Positive (Driver)	49-405	Retainer, Indicator Window
656-35	Piston, Spindle Cylinder	49-406	Window, Indicator
656-36	Collar, Spindle Clutch Spring	14-517	Bushing, Spindle Cylinder Cover
41-36	Washer, Thrust	14-519	Lock, Reversing Valve
656-38	Cover, Spindle Cylinder	61-611	Block, Locating & Locking
656-39	Tubing, Distributor	61-865	Stem, Carrier
656-40	Head, Distributor (Spindle Cylinder)	61-874	Shaft, Spindle Drive
417-41	Pin, Dowel	419-877	Key, Spindle Cylinder
656-44	Washer, Oil Retaining	41-7264	Plate, Warning
656-47	Bell, Accumulator		

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL
NUMBER OF THE MACHINE FOR WHICH THE PARTS ARE DESIRED.

NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
NEW BRITAIN, CONN. U.S.A.

PLATE XIII
SECTIONAL ELEVATION



61 613 61 629
61 792 61 402 61 448
61 452 61 162

61 625 61 617 61 624

61 622 61 904 61 632

C61 9299
61 1024
61 650
61 787

61 330
61 205 61 1023
41 132 61 839 61 331 C61 9299

61 1066 61 648 61 618 61 619
61 367

61 636
61 631
61 1046
61 1024
61 612
61 650
61 627
61 621
417 60
61 460
61 739
41 962
61 369
41 7345
61 329
417 329
61 315
61 839
41 132

61 648 61 1066

61 615 61 594 41 132 61 71 C61 8522 61 618 417 257 61 869 61 839 41 962
61 619 61 839 61 367 41 15 61 769 417 367 41 132 41 7345 417 60
61 653

61 1067 61 870

61 946
61 1024
61 626
61 616
61 620
61 600
61 611 417 160
61 186 PIN
61 656

61 869
61 1022 417 329
61 839 41 132
61 879 41 708
61 873
61 1067

C61 9299
61 656

C61 9299 61 205 61 839
61 1023 61 331 61 870 41 132

61 52

PLATE XIII

SECTIONAL ELEVATION

41-15	Pin, Main Cam Shaft Gear	61-625	Pin, Locking Lever
61-52	Pan, Oil	61-626	Rod, Locating Lever Adjusting
417-60	Pin, Dowel	61-627	Rod, Connecting
61-71	Shaft, Main Cam	61-629	Spring
41-132	Roll, Forming Slide Arm Cam	61-631	Washer, Locating & Locking Spring
417-160	Pin, Locating & Locking Block Dowel	61-632	Washer, Connecting Link Spring
446-162	Pin, Eye Bolt	61-636	Frame
61-186	Shaft, Cut Off Slide Arm	61-648	Arm, Forming Slide - Lower Rear
61-205	Plug, Forming Cam Shaft	61-650	Arm, Forming Slide - Upper Rear
417-257	Pin, Locating & Locking Cam Dowel	61-653	Plate, Overflow Oil
61-315	Bushing, Rear Forming Shaft - Long	61-656	Arm, Cut Off Slide
61-317	Key, Rear Forming Cam Gear	41-708	Bushing, Front Forming Shaft
417-329	Pin, Cut Off & Forming Arm	61-739	Spacer, Rear Forming Cam Shaft
61-329	Shaft, Forming Cam - Rear	61-767	Washer, Locking Lever Spring - Lower
61-330	Spacer, Forming Cam Gear	61-769	Stud, Locking Cam Lever Roll
61-331	Bushing, Forming Shaft - Short	61-792	Washer, Locking Lever Spring - Upper
61-367	Gear, Forming Cam - Rear	61-839	Stud, Cam Roll
417-367	Pin, Cam Roll Stud	61-857	Carrier, Spindle
61-369	Stud, Index Idler Gear	61-869	Gear, Forming Cam - Front
402-452	Washer, Locking Lever Eye Bolt	61-870	Arm, Forming Slide - Lower Front
61-460	Shaft, Forming Arm - Upper Rear	61-873	Spacer, Lower Front Forming Arm
61-594	Stud, Rod End	61-879	Shaft, Front Forming Cam
61-611	Block, Locating & Locking	61-904	Spring, Connecting Link
61-612	Block, Toggle	61-946	Pin, Locating Lever Adj. Rod
61-613	Bolt, Eye	41-962	Screw, Clamping
61-615	End, Rod	61-1022	Key, Front Forming Cam Gear
61-616	Fulcrum, Locating Lever	61-1023	Stud, Guide Block - Lower
61-617	Fulcrum, Locking Lever	61-1024	Stud, Guide Block - Upper
61-618	Gear, Main Cam Shaft	61-1046	Spring, Locating & Locking
61-619	Lever, Locking Cam	61-1066	Shaft, Forming Arm - Lower Rear
61-620	Lever, Locating	61-1067	Shaft, Forming Arm - Lower Front
61-621	Lever, Locking	41-7345	Bolt, Forming Cam Clamping
61-622	Link, Locating Lever Connecting	C61-8522	Roll, Locking Cam Lever
61-624	Pin, Locating Lever Connecting Link	C61-9299	Block, Guide

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL NUMBER OF THE MACHINE FOR WHICH THE PARTS ARE DESIRED.



NEW BRITAIN-GRIDLEY MACHINE DIV.,
THE NEW BRITAIN MACHINE CO.
New Britain, Conn., U.S.A.

PLATE XIV
SECTIONAL ELEVATION

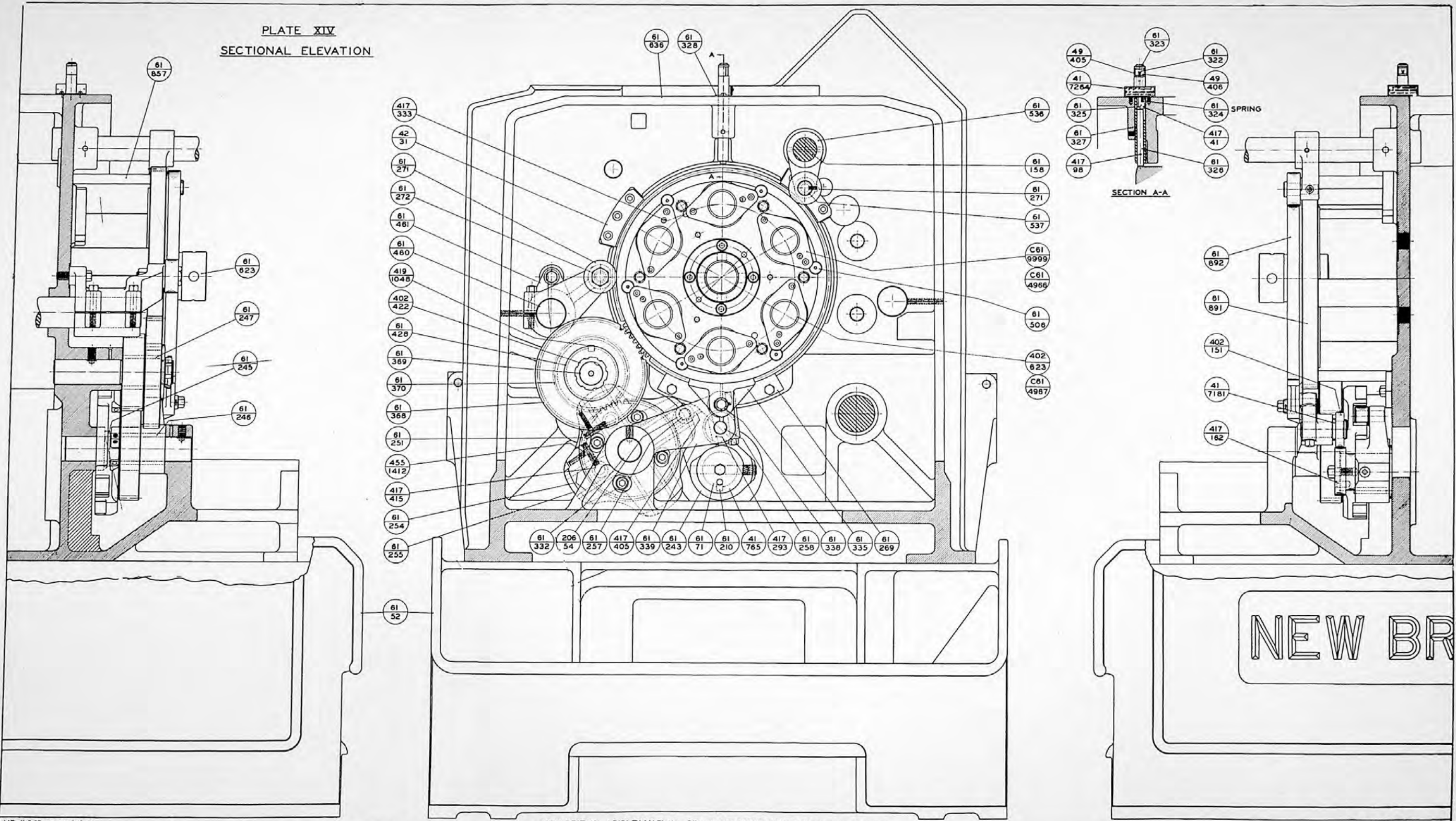


PLATE XIV

SECTIONAL ELEVATION

42-31	Block, Upper Thrust	61-335	Shoe, Carrier Lifting
417-41	Pin	61-338	Stud, Carrier Lifting Shoe
61-52	Pan, Oil	61-339	Arm, Lifting
206-54	Roll, Index	61-368	Gear, Index Idler - 53T
61-71	Shaft, Main Cam	61-369	Stud, Index Idler Gear
417-98	Pin	61-370	Gear, Index Idler - 36T
402-151	Roll, Lifting Arm	417-405	Pin, Dowel
61-158	Support, Stock Feed Guard Ring	49-405	Retainer, Indicator Window
417-162	Pin, Dowel	49-406	Window, Indicator
61-210	Key, Main Cam Shaft	417-415	Pin, Index Plate
61-243	Arm, Index	402-422	Locknut and Washer
61-245	Bushing, Index Plate	61-428	Washer, Idler Gear Retaining
61-246	Bushing, Index Plate Stud	61-460	Shaft, Forming Arm - Upper Rear
61-247	Bushing, Idler Gear	61-461	Bracket, Index Thrust
61-251	Gear, Index Plate - 48T	61-506	Rod, Chuck Operating Fork
61-254	Liner, Index Plate	61-536	Bracket, Carrier Roll - Upper
61-255	Plate, Index	61-537	Stud, Thrust Roll
61-257	Stud, Index Arm Roll	61-623	Sleeve, Stock Reel Supporting
61-258	Stud, Lifting Arm Bearing	402-623	Bearing, Stock Feed Tube
61-269	Block, Carrier Thrust	61-636	Frame
61-271	Roll, Thrust	41-765	Cam, Carrier Relief
61-272	Stud, Thrust Roll	61-857	Carrier, Spindle
417-293	Pin, Dowel	61-891	Gear, Index Carrier - 106T
61-322	Dial, Indicator	61-892	Disc, Carrier Lifting
61-323	Cap, Housing	419-1048	Key, Idler Gear
61-324	Spring, Pointer	455-1412	Shoe, Index Plate Adj. Screw
61-325	Pointer	C61-4966	Housing, Stock Feed Tube Bearing
61-326	Pin, Pointer Lift	C61-4967	Bearing, Stock Feed Tube
61-327	Housing, Lift Indicator	41-7181	Spacer, Carrier Relief Roller
61-328	Bracket, Warning Plate	41-7264	Plate, Warning
61-332	Stud, Index Plate	C61-9999	Housing, Stock Feed Tube Bearing
417-333	Pin, Dowel		

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL
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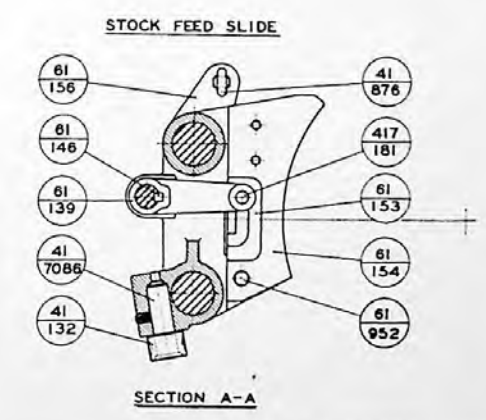
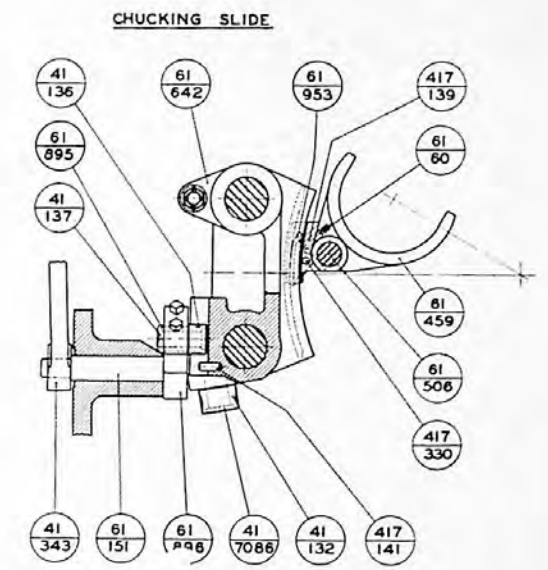
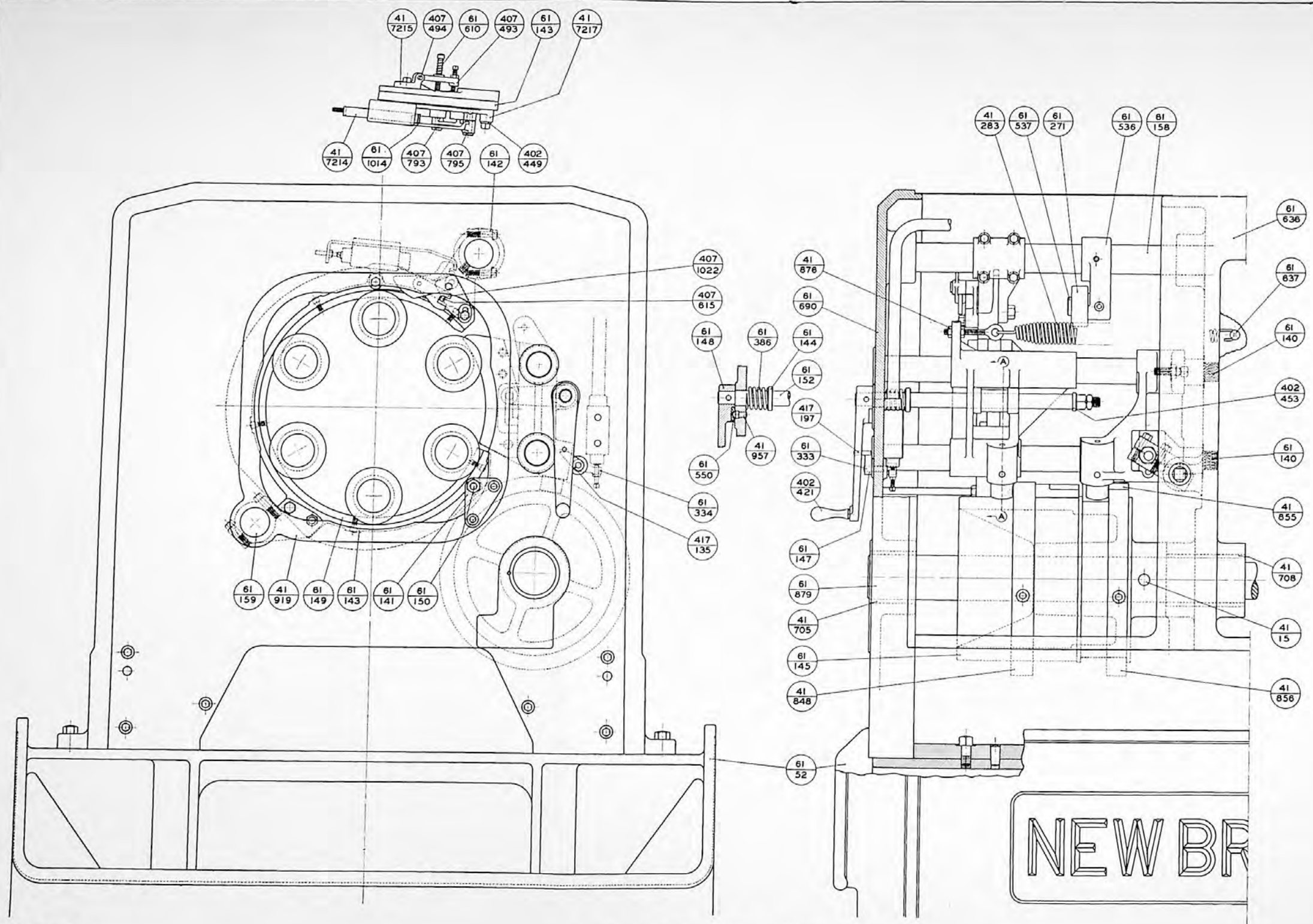


NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
New Britain, Conn., U.S.A.

T-286818

6/24/44

PLATE XV
 CHUCK OPERATING
 & STOCK FEED



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PLATE XV

CHUCK OPERATING & STOCK FEED

- | | | | |
|---------|----------------------------------|---------|-----------------------------------|
| 41-15 | Pin, Cam Drum Dowel | 61-154 | Shoe, Stock Feed Return |
| 61-52 | Pan, Oil | 61-156 | Slide, Stock Feed |
| 61-60 | Spring, Locking Latch | 61-158 | Support, Stock Feed Guard Ring |
| 41-132 | Roll, Cam | 61-159 | Support, Lower Feed Guard Ring |
| 417-135 | Pin, Switch Oper. Lever | 417-181 | Pin, Feed Shoe Operating Arm |
| 41-136 | Roll, Chuck Operating Lever | 417-197 | Pin, Operating Lever Trip |
| 41-137 | Stud, Chuck Operating Lever Roll | 61-271 | Roll, Thrust |
| 61-139 | Arm, Feed Shoe Operating | 41-283 | Spring, Stock Feed |
| 417-139 | Pin, Locking Latch | 417-330 | Pin, Chuck Operating Fork Latch |
| 61-140 | Bar, Chuck & Feed Slide Guide | 61-333 | Stud, Switch Operating Lever |
| 61-141 | Bracket, End Plate | 61-334 | Lever, Switch Operating - Inner |
| 417-141 | Pin, Chuck Oper. Lever Stop | 41-343 | Lever, Manual Chuck Operating |
| 61-142 | Bracket, Upper Feed Guard Ring | 61-386 | Spring, Feed Shoe Operating Shaft |
| 61-143 | Carrier, Stock Feed Guard Ring | 402-421 | Handle, Feed Shoe Operating Lever |
| 61-144 | Collar, Spring | 402-449 | Washer |
| 61-145 | Drum, Chuck & Feed Operating Cam | 402-453 | Washer, Operating Arm Shaft |
| 61-146 | Key, Feed Shoe Operating Arm | 61-459 | Fork, Chuck Operating |
| 61-147 | Lever, Switch Operating - Outer | 407-493 | Shoe, Feed Spool Cam |
| 61-148 | Lever, Feed Shoe Operating | 407-494 | Pin, Feed Spool Cam Shoe |
| 61-149 | Ring, Stock Feed Guard | 61-506 | Rod, Chuck Operating Fork |
| 61-150 | Rod, Guard Ring Thrust | 61-536 | Bracket, Carrier Roll - Upper |
| 61-151 | Shaft, Chuck Operating Lever | 61-537 | Stud, Thrust Roll |
| 61-152 | Shaft, Feed Shoe Operating Arm | 61-550 | Plate, Feed Shoe Operating Lever |
| 61-153 | Shoe, Stock Feed | | |

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL
NUMBER OF THE MACHINE FOR WHICH THE PARTS ARE DESIRED.



NEW BRITAIN-GRIDLEY MACHINE DIV.,
THE NEW BRITAIN MACHINE CO.,
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6/24/44

PLATE XV (Continued)

CHUCK OPERATING & STOCK FEED

61-610 Spring, Feed Spool Cam Shoe
407-615 Pin, Trip Latch Locking
61-636 Frame
61-637 Stud, Stock Feed Spring
61-642 Slide, Chucking
61-690 Plate, End
41-705 Bushing, Front Forming Shaft - End Plate
41-708 Bushing, Front Forming Shaft
407-793 Stud, Switch Lever Trip Latch
407-795 Stud, Switch Operating Lever
41-848 Cam, Stock Feed Guide
41-855 Cam, Chuck Operating
41-856 Cam, Chucking Slide Guide
41-876 Bolt, Stock Feed Spring Eye
61-879 Shaft, Front Forming Cam
61-895 Bushing, Chuck Oper. Lever Eccentric
61-896 Lever, Chuck Operating
41-919 Bracket, Lower Feed Guard Ring
61-952 Fulcrum, Stock Feed Shoe
61-953 Latch, Chuck Fork Locking
41-957 Pin, Feed Slide Drawback
61-1014 Lever, Switch Operating
407-1022 Latch, Switch Lever Trip
41-7086 Stud, Chuck & Feed Slide Roll
41-7214 Bar, Switch Operating
41-7215 Bracket, Feed Spool Cam Shoe
41-7217 Bracket, Feed Tube Switch

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL
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NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
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6/26/44

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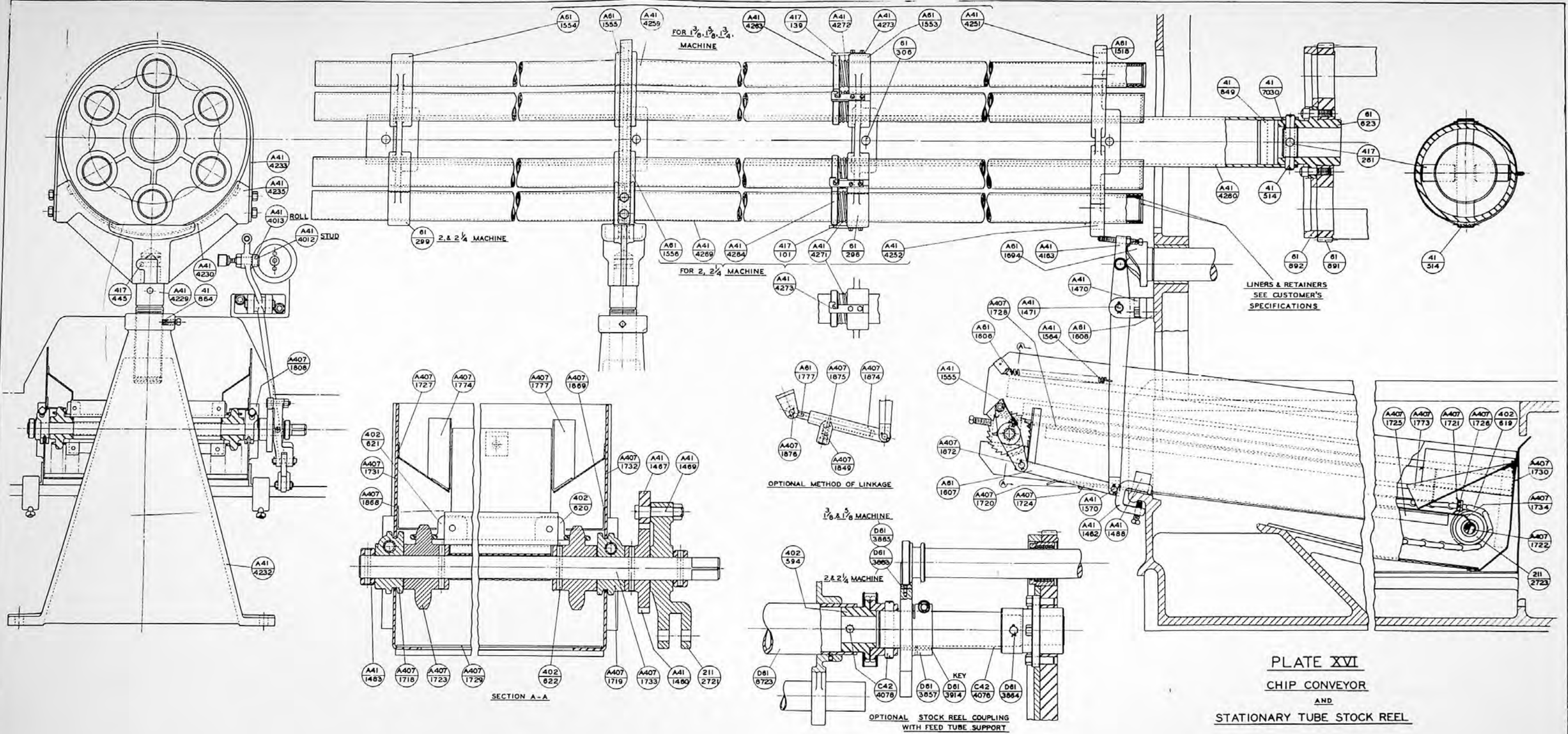


PLATE XVI
CHIP CONVEYOR
AND
STATIONARY TUBE STOCK REEL

PLATE XVI

CHIP CONVEYOR AND STATIONARY TUBE STOCK REEL

24-16Y	Crank (Not Illustrated)	A41-1570	Pin, Resilient Lever
417-261	Pin, Stock Reel Coupling Block	A61-1606	Holder, Spring
61-306	Pin, Taper	A61-1607	Link, Operating Lever
417-445	Pin, Stock Reel Saddle	A61-1608	Spacer, Operating Lever Fulcrum
41-514	Pin, Driving	A61-1694	Cam
402-594	Coupling	A407-1718	Bearing, Upper Shaft - Left
402-619	Link, Plain	A407-1719	Bearing, Upper Shaft - Right
402-620	Link, Right Hand Scraper	A407-1720	Clip, Bottom Plate
402-621	Link, Left Hand Scraper	A407-1721	Scraper
402-622	Pin, Sprocket	A407-1722	Shaft, Lower
61-623	Sleeve, Stock Reel Supporting	A407-1723	Sprocket (6 teeth)
41-849	Plug, Stock Reel Supporting Tube	A407-1724	Strip, Bottom Plate Clip
41-864	Shoe, Stock Reel Stand Screw	A407-1725	Support, Middle Plate
61-891	Gear, Index Carrier	A407-1726	Support, Scraper
61-892	Disc, Carrier Lifting	A407-1727	Guard, Chain
A41-1460	Ratchet	A407-1728	Plate, Middle (adjustable)
A41-1462	Clamp	A407-1729	Plate, Bottom
A41-1467	Pawl, Ratchet	A407-1730	Plate, End
A41-1469	Stud, Ratchet Pawl	A407-1731	Plate, Side - Left
A41-1470	Fulcrum, Lever	A407-1732	Plate, Side - Right
A41-1471	Stud, Lever Fulcrum	A407-1733	Shaft, Upper
A41-1483	Collar, Ratchet Lever	A407-1734	Plate, Middle
A41-1488	Foot, Side Rail	A407-1773	Door, Trap
A61-1518	Spider, Stock Reel Front	A407-1774	Guard, Trap Door Chip - Left
A41-1555	Spring, Ratchet Pawl	A61-1777	Rod, Operating (Optional)
A41-1564	Spring, Return	A407-1777	Guard, Trap Door Chip - Right

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL
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NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
New Britain, Conn., U.S.A.

T-261621

1-21-43

PLATE XVI

CHIP CONVEYOR AND STATIONARY TUBE STOCK REEL
(Cont'd.)

A407-1808	Stop, Chip Conveyor Adj.	For 1-3/8", 1-5/8" & 1-3/4" Machines Only
A407-1849	Spring (Optional)	
A407-1868	Shield, Chain (Left Hand)	417-139 Pin, Tube Retaining Collar
A407-1869	Shield, Chain(Right Hand)	A61-1553 Spider, Stock Reel (2nd Front)
A407-1872	Pin, Ratchet Lever	A61-1554 Spider, Stock Reel (End)
A407-1874	Sleeve, Operating (Optional)	A61-1555 Spider, Stock Reel (Rear Bearing)
A407-1875	Plunger (Optional)	D61-3865 Bushing, Spool Support
A407-1876	Pin (Optional)	A41-4251 Collar, Front Bearing
211-2721	Lever, Ratchet	A41-4259 Tube, Stock Reel
211-2723	Roller, Small	A41-4263 Collar, Tube Retaining
D61-3857	Spider, Feed Tube Spool Support	A41-4272 Spring, Tube Retaining
D61-3864	Pin	
D61-3914	Key	For 2" & 2-1/4" Machines Only
A41-4012	Stud, Cam Lever Roll	
A41-4013	Roll, Cam	417-101 Pin, Tube Retaining Collar
C42-4076	Shaft, Stock Reel Drive	61-296 Spider, Stock Reel (2nd front)
C42-4078	Pin	61-299 Spider, Stock Reel (End)
A41-4163	Lever, Operating	A61-1556 Spider, Stock Reel (Rear Bearing)
A41-4229	Screw, Stock Reel Adjusting	D61-3883 Bushing, Spool Support
A41-4230	Shoe, Stock Reel Saddle	A41-4252 Collar, Front Bearing
A41-4232	Stand, Stock Reel	A41-4264 Collar, Tube Retaining
A41-4233	Strip, Spider	A41-4269 Tube, Stock Reel
A41-4235	Saddle, Stock Reel	A41-4271 Spring, Tube Retaining
A41-4260	Tube, Stock Reel Support	
A41-4273	Latch, Tube Retaining	
41-7030	Block, Stock Reel Coupling	
D61-8723	Tube, Stock Reel Support(Optional)	

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL
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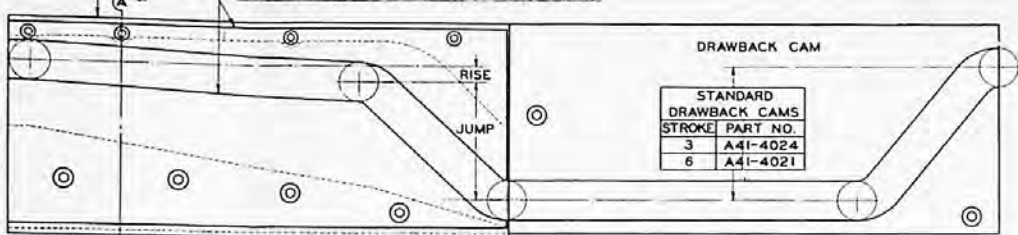
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FEED CAM ADAPTERS	
STROKE	PART NO.
3	A41-4025
6	41-941
FEED CAM SPACERS	
3	A41-1234
3	A41-1375

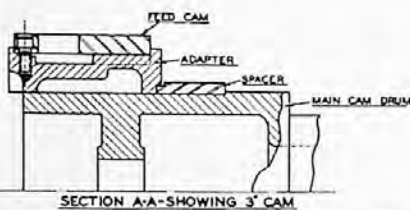
NOTE:

FEED CAMS ARE MADE TO ORDER AND CONSIST OF TWO PARTS AS SHOWN IN THE DEVELOPMENT. THEY ARE MADE FOR TWO STANDARD STROKES, 3" & 6". OTHER STROKES ARE SPECIAL. THE RISE OR RISES PLUS THE JUMP EQUALS THE STROKE. SEPARATE DRAWBACK CAMS ARE REQUIRED FOR THE 3" & 6" STROKE. LIKEWISE SEPARATE ADAPTERS FOR MOUNTING THE FEED CAMS ARE REQUIRED FOR THE 3" & 6" STROKE.

FEED CAM CONSISTS OF THESE TWO PARTS.

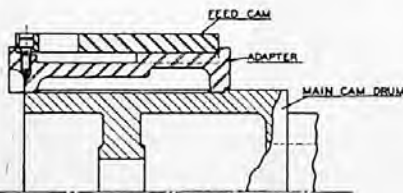


DEVELOPMENT OF TOOL SLIDE CAM



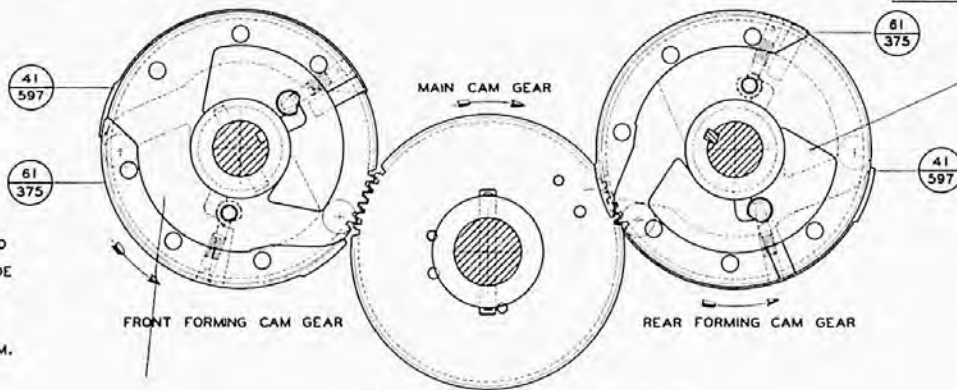
SECTION A-A-SHOWING 3' CAM

THE 3" STROKE CAM IS ILLUSTRATED MOUNTED AT THE FORWARD END OF THE MAIN CAM DRUM PROVIDING THE MINIMUM TOOL SLIDE POSITION. THE TOOL SLIDE POSITION CAN BE ADJUSTED BACK 3" BY REMOVING THE TWO SPACERS AND MOVING THE ADAPTER AND DRAWBACK CAM BACK AGAINST THE SHOULDER ON THE CAM DRUM.



SECTION A-A-SHOWING 6' CAM

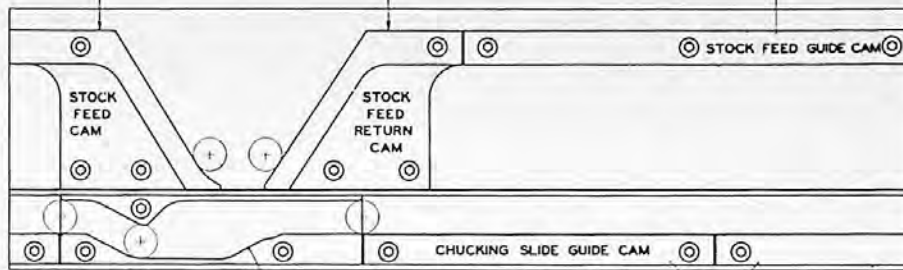
NOTE:
FOR FURTHER INFORMATION
ON CAMMING REFER TO
INSTRUCTION BOOK



VIEW LOOKING TOWARDS SPINDLES
FROM POWER CASE

STOCK FEED CAMS	PART NO.	A41 4187	A41 4166	A41 1533	A61 1780	A41 4301
STROKE		1	2 1/4	3 1/2	5	6

STOCK FEED RETURN CAMS	PART NO.	A41 4169	A41 4168	A41 1531	A41 4176	A41 1534
STROKE		1	2 1/4	3 1/2	5	6



DEVELOPMENT OF CHUCK
OPERATING & STOCK FEED CAMS

CROSS SLIDE FEED CAMS

RISE	PART NO. OF CAMS		RISE	PART NO. OF CAMS	
	8 DEG. DWELL	3 DEG. DWELL		8 DEG. DWELL	3 DEG. DWELL
1/32	C61-9951		9/16	C61-9982	C61-9979
1/16	C61-9952	C61-9989	19/32	C42-3714	C61-9981
3/32	C61-9985	C61-9970	5/8	C61-9240	C61-9982
1/8	C61-4408	C61-9971	11/16	C42-3715	C61-9984
5/32	C61-8030	C61-8548	3/4	C61-9235	C61-9986
3/16	C61-4409	C61-8644	13/16	C61-9958	C61-9987
7/32	C61-9953	C61-8658	7/8	C61-9959	C61-9988
1/4	C42-3712	C61-9972	15/16	C61-9980	C61-9989
9/32	C61-8747	C61-9973	1	C61-9981	C61-9990
5/16	C42-3713	C61-9974	1 1/16	C61-9982	C61-9991
11/32	C61-9954	C61-8629	1 1/8	C61-9983	C61-9992
3/8	C61-4410	C61-9975	1 3/16	C42-3716	C61-9993
13/32	C61-9093	C61-9976	1 1/4	C42-3717	C61-9994
7/16	C61-4406	C61-9977	1 5/16	C61-9984	C61-9995
15/32	C61-8631	C61-9978	1 3/8	C61-9985	C61-9996
1/2	C61-4411	C61-9979	1 1/2	C61-9987	C61-9997
17/32	C61-9955	C61-9980	1 1/2	C61-9988	C61-9998

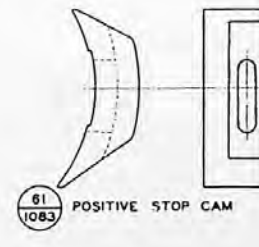
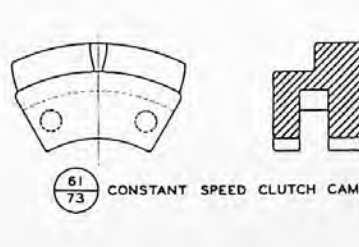
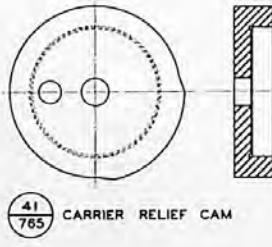
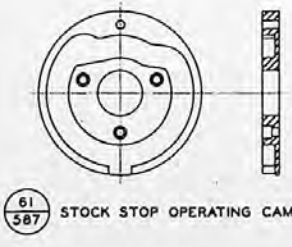
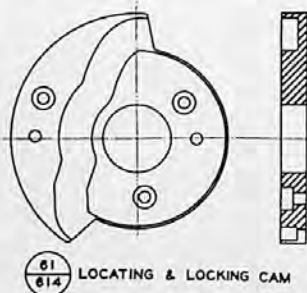


PLATE XVII
CAMS

PLATE XVII

CAMS

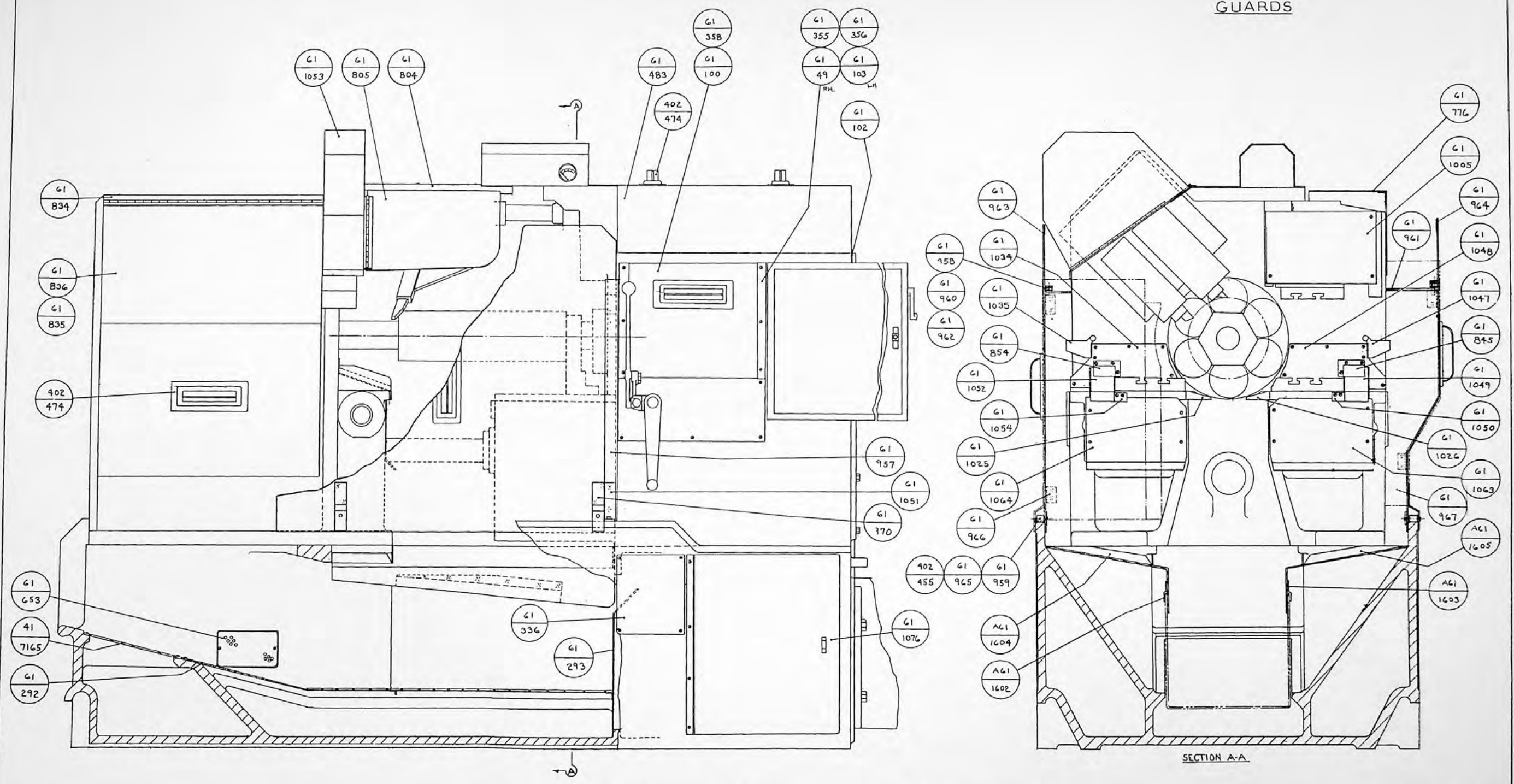
61-73	Cam, Constant Speed Clutch
61-375	Cam, Lower Forming Slide Drawback
61-587	Cam, Stock Stop Operating
41-597	Cam, Upper Forming Slide Drawback
61-614	Cam, Locating and Locking
41-765	Cam, Carrier Relief
41-848	Cam, Stock Feed Guide
41-855	Cam, Chuck Operating
41-856	Cam, Chucking Slide Guide
41-941	Adapter, 6 Inch Tool Slide Feed Cam
61-1083	Cam, Positive Stop
A41-1234	Spacer, 3 Inch Tool Slide Feed Cam
A41-1375	Spacer, 3 Inch Tool Slide Feed Cam
A41-1531	Cam, $3\frac{1}{2}$ Inch Stock Feed Return
A41-1533	Cam, $3\frac{1}{2}$ Inch Stock Feed
A41-1534	Cam, 6 Inch Stock Feed Return
A61-1780	Cam, 5 Inch Stock Feed
A41-4021	Cam, 6 Inch Tool Slide Drawback
A41-4024	Cam, 3 Inch Tool Slide Drawback
A41-4025	Adapter, 3 Inch Tool Slide Feed Cam
A41-4166	Cam, $2\frac{1}{4}$ Inch Stock Feed
A41-4167	Cam, 1 Inch Stock Feed
A41-4168	Cam, $2\frac{1}{4}$ Inch Stock Feed Return
A41-4169	Cam, 1 Inch Stock Feed Return
A41-4176	Cam, 5 Inch Stock Feed Return
A41-4301	Cam, 6 Inch Stock Feed
	Cam, Cross Slide Feed - See Plate
	Cam, Tool Slide Feed - See Plate - Specify Rise & Jump

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL
NUMBER OF THE MACHINE FOR WHICH THE PARTS ARE DESIRED.



NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
New Britain, Conn., U.S.A.

PLATE XVIII
GUARDS



SECTION A-A

PLATE XVIII

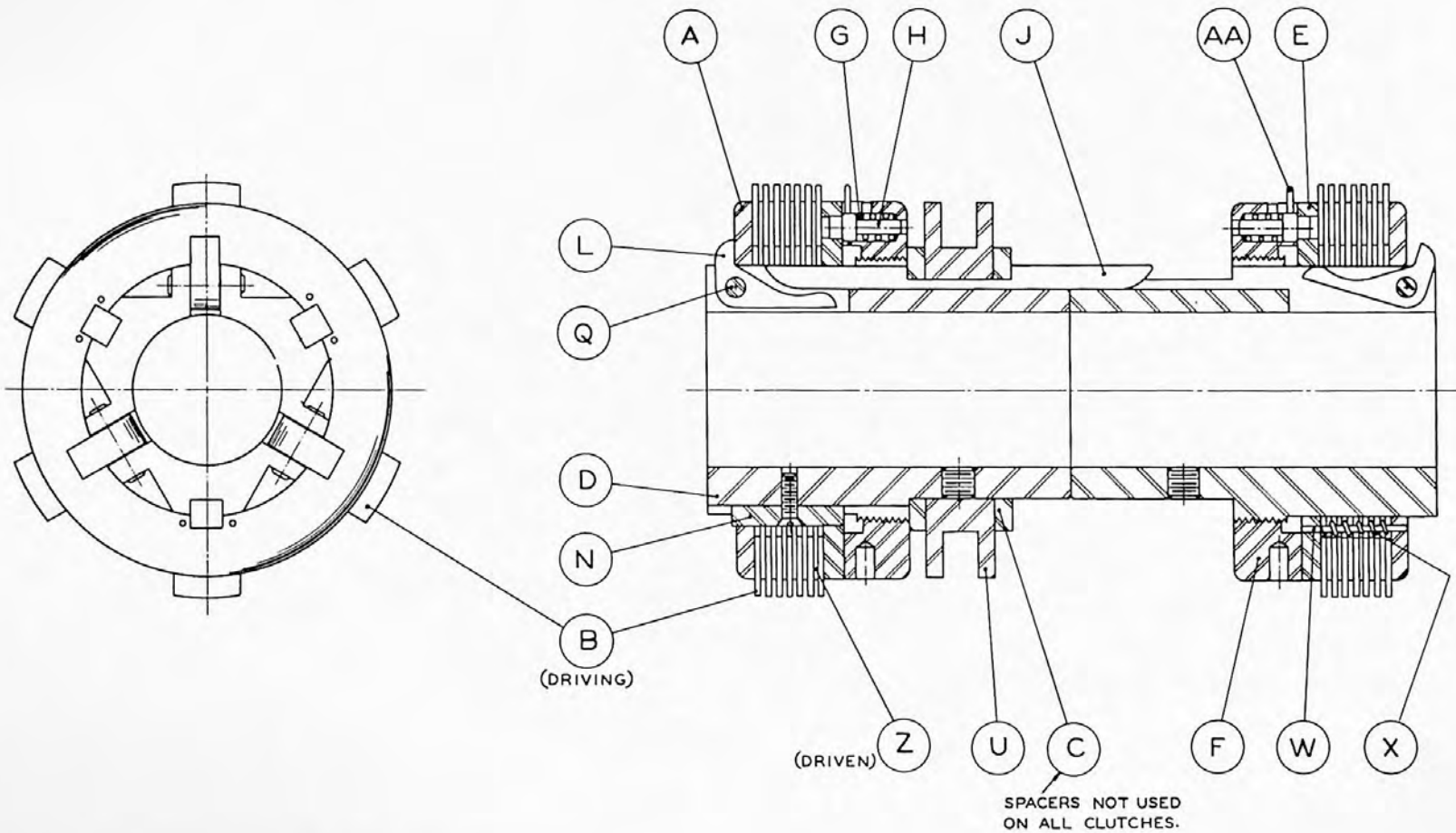
GUARDS

61-49	Front Power Case Door Right Hand Guide	61-962	Upper Roll Stud For Front Splash Apron
61-100	Front Power Case Door	61-963	Front Splash Apron
61-102	Speed Change Gear Door	61-964	Rear Splash Apron
61-103	Front Power Case Door Left Hand Guide	61-965	Bottom Roll
61-292	Oil Pan Cover (Not used when mach. is equipped with chip conveyor)	61-966	Splash Apron Support
61-293	Oil Screen	61-967	Rear Splash Apron End Guard
61-336	Oil Pan Cover	61-970	Bottom Roll Support
61-355	Rear Power Case Door Right Hand Guide (Not illus.)	61-1005	Upper Rear Forming Slide Guard
61-356	Rear Power Case Door Left Hand Guide (Not illus.)	61-1025	Lower Front Forming Slide Chip Chute
61-358	Rear Power Case Door (Not illus.)	61-1026	Lower Rear Forming Slide Chip Chute
402-455	Roll Pin Washer	61-1034	Lower Front Forming Slide Guide Dust Cover
402-474	Handle	61-1035	Lower Front Forming Slide Chip Guard
61-483	Aux. Cam Drum Guard (Includes Handle)	61-1047	Lower Rear Forming Slide Chip Guard
61-653	Overflow Oil Plate	61-1048	Lower Rear Forming Slide Guide Dust Cover
61-776	Upper Rear Oil Splash Guard	61-1049	Lower Rear Forming Slide Guard
61-804	Double Cut-Off Slide Guard Support	61-1050	Lower Rear Forming Slide Guard Clip
61-805	Cut-Off Slide Splash Guard	61-1051	Front Splash Apron End Support
61-834	Chucking & Stock Feed Mech. Top Guard	61-1052	Lower Front Forming Slide Guard
61-835	Chucking & Stock Feed Mech. Rear Guard	61-1053	Double Cut-Off Slide Top Guard
61-836	Chucking & Stock Feed Mech. Front Guard	61-1054	Lower Front Forming Slide Guard Clip
61-845	Lower Rear Forming Slide Guard Retainer Plate	61-1063	Lower Rear Forming Slide Chip Cover
61-854	Lower Front Forming Slide Guard Retainer Plate	61-1064	Lower Front Forming Slide Chip Cover
61-957	Front Splash Apron End Guard	61-1076	Starter Box Door
61-958	Splash Apron Upper Roll Stud	A61-1602	Front Deflector Clip
61-959	Lower Roll Pin	A61-1603	Rear Deflector Clip
61-960	Upper Roll	A61-1604	Front Deflector (Used only with chip conveyor)
61-961	Upper Roll Stud For Rear Splash Apron	A61-1605	Rear Deflector (Used only with chip conveyor)
		41-7165	Oil Pan Cover

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL NUMBER OF THE MACHINE FOR WHICH THE PARTS ARE DESIRED.

NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
New Britain, Conn., U.S.A.

TWIN DISC CLUTCHES



THIS PLATE MAY BE USED TO IDENTIFY PARTS FOR EITHER A SINGLE OR DUPLEX CLUTCH.

NEW BRITAIN-GRIDLEY MACHINE DIV.,
THE NEW BRITAIN MACHINE COMPANY,
NEW BRITAIN, CONN, U.S.A.

TWIN DISC CLUTCH
"NEW BRITAIN" MODEL #61

<u>NAME</u>	<u>ITEM</u>	<u>NAME</u>	<u>ITEM</u>
Floating Plate	A	Finger Lever	L
Driving Plate	B	Drive Key	N
Spacer	C	Finger Pin	Q
Clutch Hub	D	Wedge Collar	U
Lock Plate	E	Release Spring Pin	W
Adjusting Ring	F	Release Spring	X
Adj. Lock Pin Spring	G	Driven Plate	Z
Adjusting Lock Pin	H	Pin	AA
Operating Wedge	J		

When a complete clutch is desired, specify by name and number from plate III, IV, or V.

When an individual part is desired, specify by name and item letter from above tabulation stating quantity desired and identify clutch for which parts are desired from plate III, IV, or V.

Always specify serial number of machine for which parts are desired.

Note: If quantity is not specified, we will quote or ship parts for a complete clutch.

WHEN ORDERING REPAIR PARTS ALWAYS INCLUDE THE SERIAL NUMBER OF THE MACHINE FOR WHICH THE PARTS ARE DESIRED.



NEW BRITAIN-GRIDLEY MACHINE DIV.
THE NEW BRITAIN MACHINE CO.
New Britain, Conn., U.S.A.

10-31-49

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