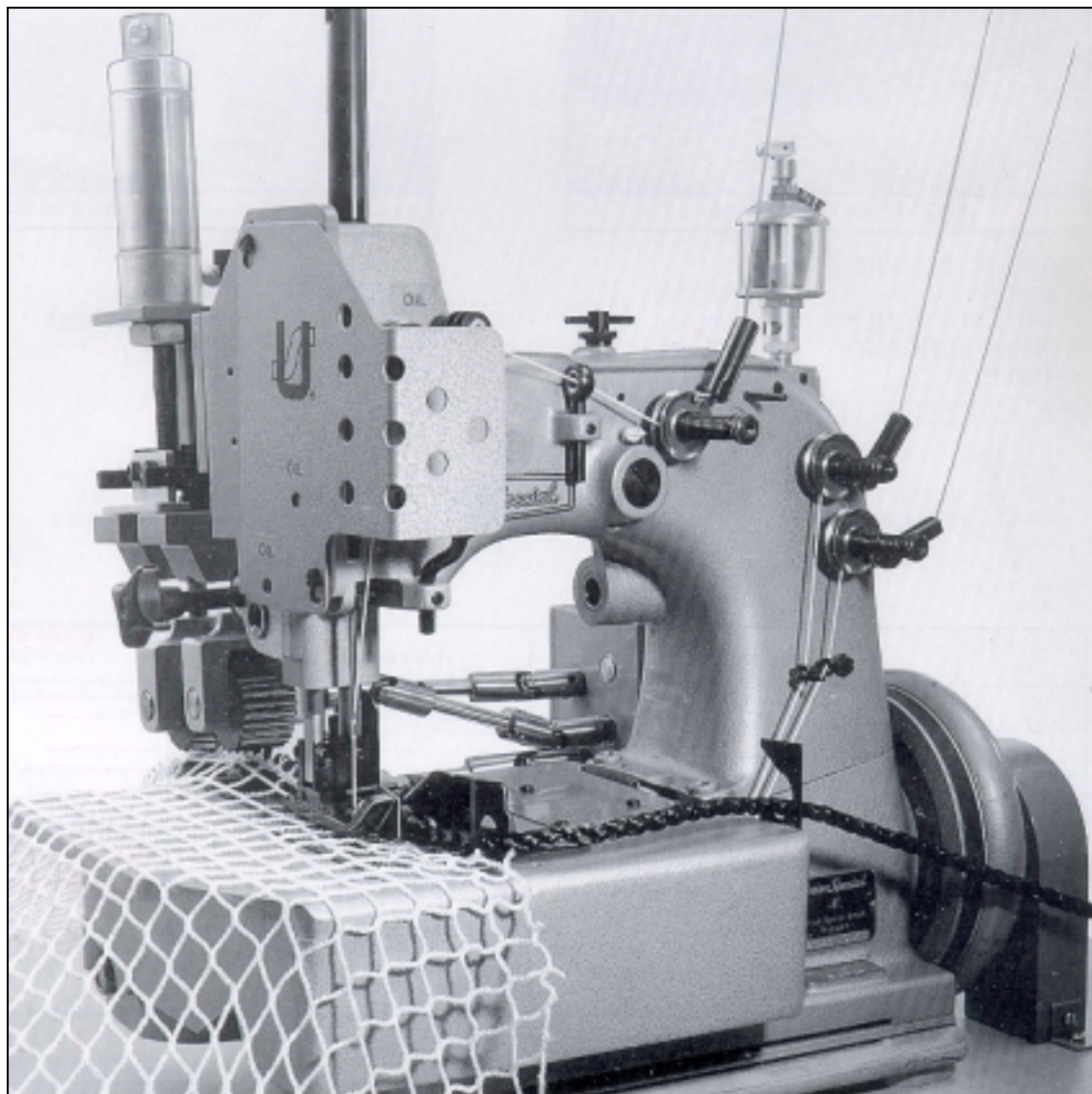


**ILLUSTRATED PARTS MANUAL
ILLUSTRIERTES TEILEVERZEICHNIS**



**MANUAL NO. / KATALOG NR. G234CZ
FOR STYLES / FÜR TYPEN
81500CZ3374A, 81500CZ3374B**

**SUPPLEMENT TO MANUAL NO. G234
ZUSATZ ZUM KATALOG NR. G234**

APPLICATION OF THIS MANUAL

This manual is a supplement to the manual No. G234 and should be used in conjunction therewith.

OBSERVE THE SAFETY RULES IN MANUAL NO. G234!



Only the parts found on Styles 81500CZ3374A and 81500CZ3374B are illustrated which are different from those of Style 81500C. INSTALLATION, LUBRICATION, NEEDLES, OPERATING INSTRUCTIONS, MAINTENANCE and INSTRUCTIONS FOR MECHANICS are the same as described in manual No. G234 for Style 81500C.

HINWEISE FÜR DIE BENÜTZUNG DIESES KATALOGS

Dieser Katalog ist ein Zusatz zum Katalog Nr. G234 und muß in Verbindung mit diesem verwendet werden.



BEACHTEN SIE DIE SICHERHEITSHINWEISE IM KATALOG NR. G234!

Es sind nur die Teile für die Maschinen 85100CZ3374A und 81500CZ3374B abgebildet, die sich von denen für die Maschinen 81500C unterscheiden. AUFSTELLUNG, ÖLEN, NADELN, BEDIENUNGSANLEITUNG, WARTUNG und MECHANIKERANLEITUNG sind gleich wie im Katalog Nr. G234 für die Maschine 81500C beschrieben.

Subject to change without notice / Änderungen vorbehalten

G234CZ 06-03
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IDENTIFICATION OF MACHINES

Each UNION SPECIAL 81500 series machine is identified by a style number, which is stamped on the style plate affixed to the right front of machine. Serial number is stamped into bed casting at the right front base of machine.

STYLES OF MACHINE

81500CZ3374A: Single Needle, Three Thread Overedging Sewing Machine for attaching ropes from 5/64 inch to 19/32 inch (2 - 10 mm) - depending on the thickness of the net and size of knots - as border or tensioning rope to nets used for sports, protection or safety.

Maximum Speed: 1200 stitches / min.,
depending on fabric and
sewing operation

Recommended operating speed: 950 stitches / min.

Stitch Range: 2 - 5 SPI (4 - 12 mm)

Standard Setting: 2.5 SPI (10 mm)

Sewing Capacity: 3/64 - 5/8 inch (2 - 16 mm)

Standard Needle: 9853GA300/120

Needle Stroke: 2 51/64 inch (71 mm)

Handwheel pitch dia = 5 27/32 inch (150 mm)

Needle Thread: Net Yarn 210/24 or 210/3
PP Yarn, 4000 Denier

Looper Thread: Net Yarn 210/24 or 210/30
PP Yarn, 4000 Denier

Feed: Intermittend stepper twin puller,
two driven upper and one driven lower roller. Roller
pitch 5 mm.

Required Installation: UN280G132

Sewing table with clutch motor
Motor pulley pitch dia = 3 15/16 inch (100 mm)

For nets sewn parallel to the meshes, no feed dog is used and the throat plate has no slots (Standard version).

For nets sewn diagonal to the meshes a feed dog with matching throat plate is included.

Max. SPI 2.5 (10 mm).

For joining nets larger than 45 mm mesh width.

81500CZ3374B: Same as 81500CZ3374A but for attaching ropes from 25/64 inch to 5/8 inch (10 - 16 mm) - depending on the thickness of the net and size of knots.

Performance tests necessary for both machines.

BEZEICHNUNG DER MASCHINEN

Jede UNION SPECIAL 81500 Maschine hat eine in das Typenschild eingeprägte Typennummer, das rechts vorne am Gehäuse befestigt ist. Die Seriennummer ist in das Gußgehäuse rechts vorne im Sockel der Maschine eingepägt.

MASCHINENTYPEN

81500CZ3374A: Einnadel-Dreifaden-Überwendlich-Nähmaschine zum Annähen von Seilen mit einem Durchmesser von 2 bis 10 mm (abhängig von Netzdicke und Größe der Knoten) als Randabschluß oder als Spannseil an Netze, besonders an Sport-, Schutz- und Sicherheitsnetzen.

Maximale Drehzahl: 1200 Stiche / min.,
je nach Material und
Nähoperation

Empfohlene Betriebsdrehzahl: 950 Stiche / min.

Stichlänge: 4 - 12 mm

Standardstichlänge: 10 mm

Nähgutdurchgang: 2 - 16 mm

Standardnadel: 9853GA300/120

Nadelhub: 71 mm

Handrad-Durchmesser = 150 mm

Nadelfaden: Netzgarn 210/24 oder 210/30
PP-Garn, 4000 Denier

Greiferfaden: Netzgarn 210/24 oder 210/30
PP-Garn, 4000 Denier

Transport: Intermittierender Schritt-Doppel-
puller, zwei obere und eine untere Rolle angetrieben,
Rollenzahlteilung 5 mm.

Erforderlicher Arbeitsplatz: UN280G132

Nähtisch mit Kupplungsmotor
Motor-Scheibendurchmesser = 100 mm

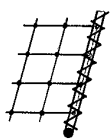
Für Netze, an denen parallel zu den Maschen genäht wird, wird in der Nähmaschine kein Transporteur verwendet; die Stichplatte ist ohne Transporteurschlitz (Standardausführung). Für Netze, an denen diagonal zu den Maschen genäht wird, wird ein Transporteur mit passender Stichplatte verwendet (beigepackt), Stichlänge max. 10 mm.

Zum Zusammennähen von Netzen ab 45 mm Maschenweite.

81500CZ3374B: Wie 81500CZ3374A, jedoch zum Annähen von Seilen von 10 - 16 mm, abhängig von Netzdicke und Größe der Knoten.

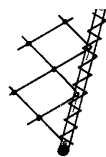
Nähversuche für beide Maschinen erforderlich.

Stitch Type / Seam Type

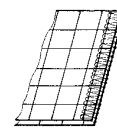
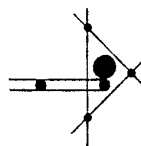


Net parallel
to rope

Stitch Type 504
Seam Type EFD-1

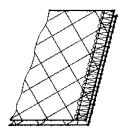


Net diagonal
to rope

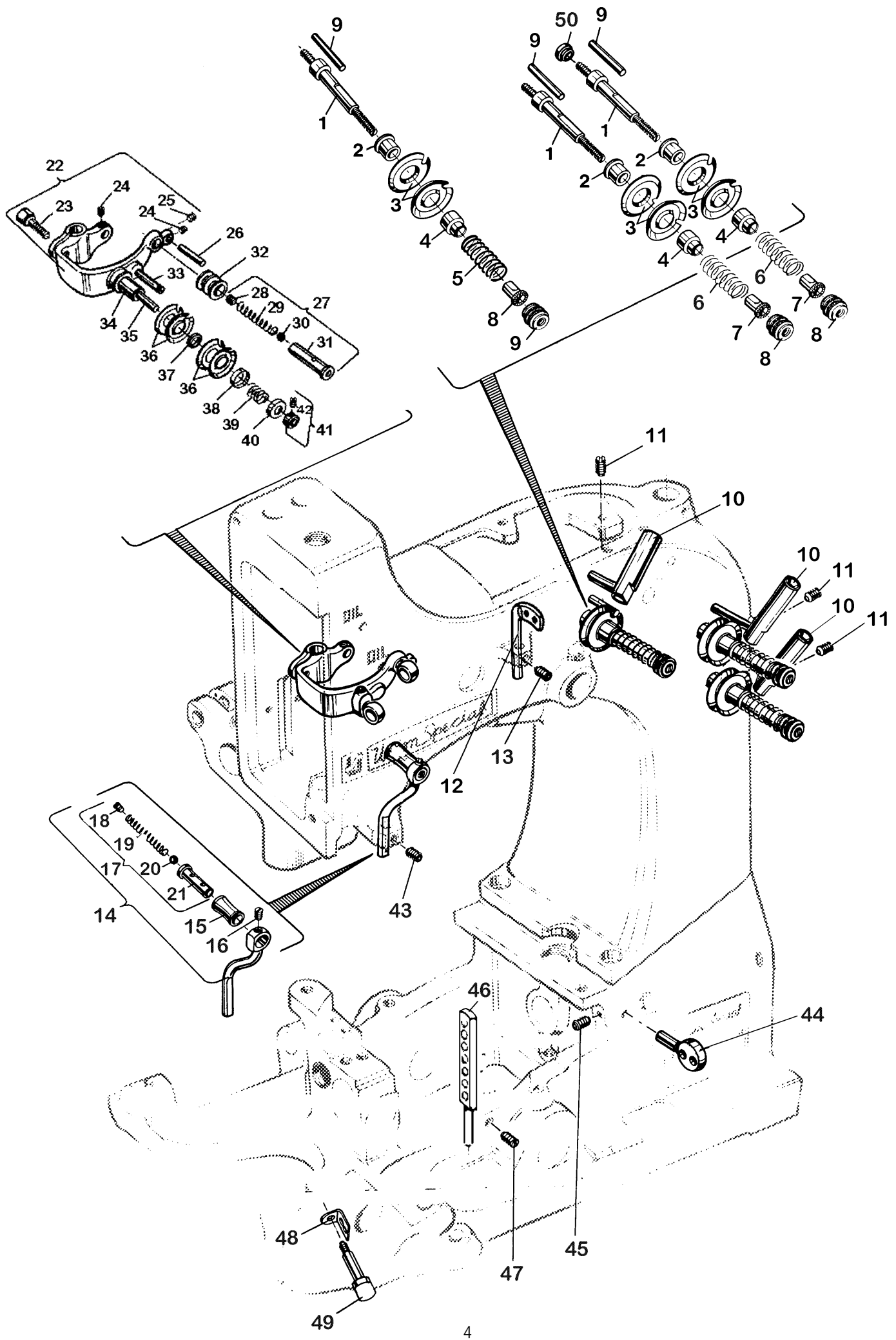


Nets joined
parallel

Stitch Type 504
Seam Type SSA-1

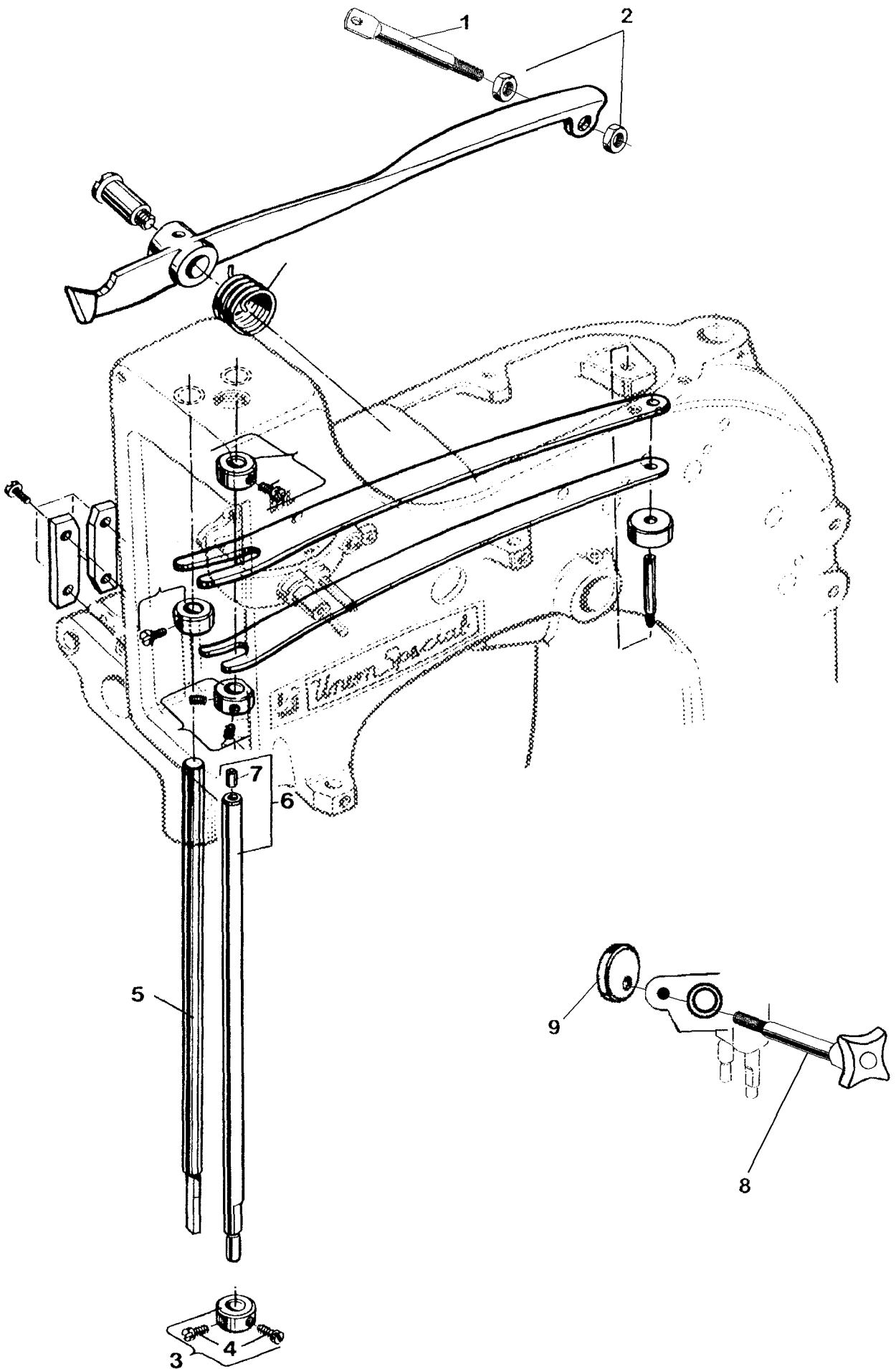


Nets joined
diagonal



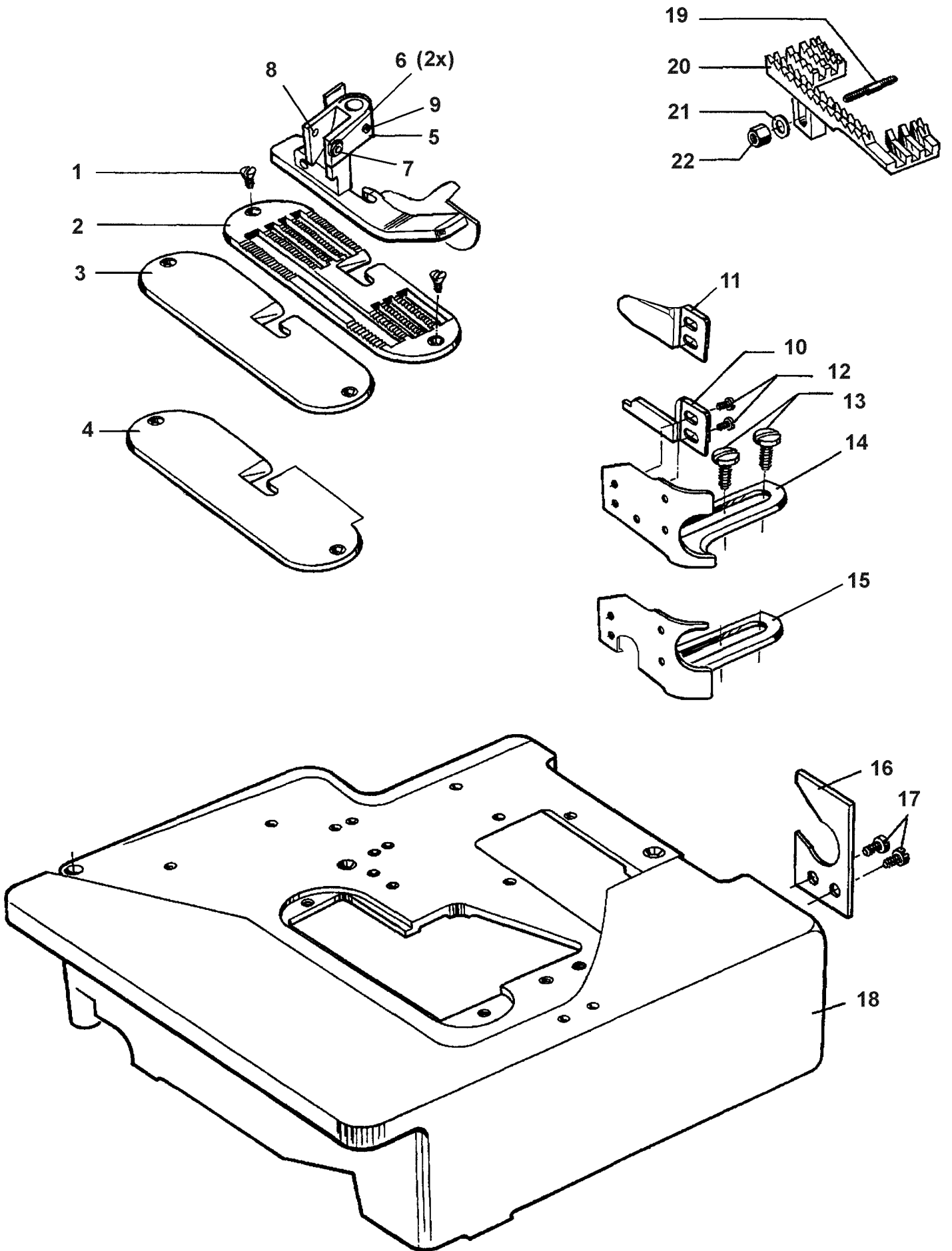
THREAD TENSION AND GUIDE PARTS
FADENSPANNUNGEN UND FADENFÜHRUNGSTEILE

| <u>Ref. No.</u> <u>Pos. No.</u> | <u>Part No.</u> <u>Teil Nr.</u> | <u>Description</u> | <u>Beschreibung</u> | <u>Amt. Req.</u> <u>Anzahl</u> |
|------------------------------------|------------------------------------|---|--|-----------------------------------|
| 1 | HS106 | Tension Post | Spannungsbolzen | 3 |
| 2 | 80669B | Tension Post Ferrule | Hülse für Spannungsbolzen | 3 |
| 3 | 80676A | Tension Disc | Spannungsscheibe | 6 |
| 4 | HA1349 | Tension Sleeve | Federhülse | 3 |
| 5 | HS110A | Spring for Needle Thread Tension | Feder für Nadelfadenspannung | 1 |
| 6 | 110-2 | Spring for Looper Thread Tension | Feder für Greiferfadenspannung | 2 |
| 7 | 107 | Tension Spring Ferrule | Spannungsfeder-Hülse | 3 |
| 8 | 108 | Tension Nut | Spannungsmutter | 3 |
| 9 | 80667 | Pin for Tension Discs | Stift für Spannungsscheiben | 3 |
| 10 | 81256A | Thread Sleeve | Fadenhülse | 3 |
| 11 | 22560B | Set Screw | Gewindestift | 3 |
| 12 | 80858AX | Needle Thread Guide | Nadelfadenführung | 1 |
| 13 | 22894AD | Set Screw | Gewindestift | 1 |
| 14 | 80665D | Needle Thread Take-up Roller Assm. | Nadelfadenabzugsrolle, komplett | 1 |
| 15 | 80668 | Take-up Roller | Abzugsrolle | 1 |
| 16 | 88 | Set Screw | Gewindestift | 1 |
| 17 | HS53B | Roller Stud Assembly | Rollenbolzen, komplett | 1 |
| 18 | 22560 | Set Screw | Gewindestift | 1 |
| 19 | HA1286B | Spring | Feder | 1 |
| 20 | 12964C | Spring Ball | Federkugel | 1 |
| 21 | 81086G | Roller Stud | Rollenbolzen | 1 |
| 22 | 80759 | Needle Bar Connection | Nadelstangenmitnehmer | 1 |
| 23 | BP108 | Hex. Head Cap Screw | Sechskantschraube | 1 |
| 24 | 22894AY | Set Screw | Gewindestift | 2 |
| 25 | 22894W | Set Screw | Gewindestift | 1 |
| 26 | 80655D | Thread Guide Pin | Fadenführungsstift | 1 |
| 27 | HS52B | Roller Stud Assembly | Rollenbolzen komplett | 1 |
| 28 | 22560 | Set Screw | Gewindestift | 1 |
| 29 | HA1286B | Spring | Feder | 1 |
| 30 | 12964C | Spring Ball | Federkugel | 1 |
| 31 | 81086C | Roller Stud | Rollenbolzen | 1 |
| 32 | 81293 | Thread Guide Roller | Fadenführungsrolle | 1 |
| 33 | 92132 | Shank Screw | Zapfenschraube | 1 |
| 34 | 80669A | Tension Post Ferrule | Hülse für Spannungsbolzen | 1 |
| 35 | 81246 | Tension Post | Spannungsbolzen | 1 |
| 36 | 80676 | Tension Disc | Spannungsscheibe | 4 |
| 37 | 81294 | Spacer Ring | Distanzring | 1 |
| 38 | HA58C | Spring Ferrule | Federhülse | 1 |
| 39 | HA58F | Spring | Feder | 1 |
| 40 | HA58D | Spring Ferrule | Federhülse | 1 |
| 41 | 21111 | Collar | Stelling | 1 |
| 42 | 22743 | Set Screw | Gewindestift | 1 |
| 43 | 22894AD | Set Screw | Gewindestift | 1 |
| 44 | 81254A | Eyelet for looper threads | Fadenführung für Greiferfäden | 1 |
| 45 | 22894AD | Set Screw | Gewindestift | 1 |
| 46 | 81287A | Looper Thread Guide | Greiferfadenführung | 1 |
| 47 | 88 | Set Screw | Gewindestift | 1 |
| 48 | 81350D | Looper Thread Guide | Greiferfadenführung | 1 |
| 49 | 80696A | Stud | Bolzen | 1 |
| 50 | 99623A | Spacer for lower looper thread tension post | Distanzbuchse für unteren Greiferfaden-Spannungsbolzen | 1 |



PRESSER BARS AND PRESSERFOOT LIFTER
DRÜCKERFUßSTANGEN UND DRÜCKERFUßLIFTERHEBEL

| <u>Ref. No.</u> <u>Pos. No.</u> | <u>Part No.</u> <u>Teil Nr.</u> | <u>Description</u> | <u>Beschreibung</u> | <u>Amt. Req.</u> <u>Anzahl</u> |
|------------------------------------|------------------------------------|------------------------|--------------------------|-----------------------------------|
| 1 | 35780B | Lifter Lever Extension | Lifterverlängerung | 1 |
| 2 | 258 | Nut | Mutter | 2 |
| 3 | 81566 | Collar | Stellring | 1 |
| 4 | 22836 | Screw | Schraube | 2 |
| 5 | 80760A | Presser Bar, left | Drückerfußstange, links | 1 |
| 6 | 80661B | Presser Bar, right | Drückerfußstange, rechts | 1 |
| 7 | CO67D | Cork Plug | Korkstopfen | 1 |
| 8 | 81567B | Eccentric Disc | Exzentrerscheibe | 1 |
| 9 | 81567A | Handle Screw | Griffschraube | 1 |



SEWING PARTS AND CLOTH PLATE
NÄHTEILE UND STOFFPLATTE

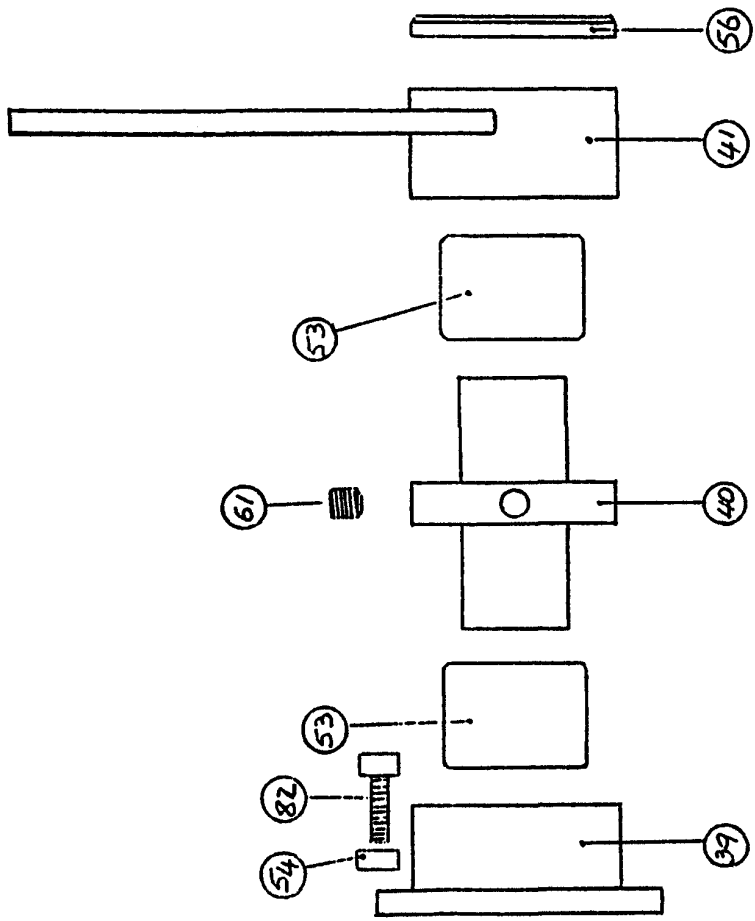
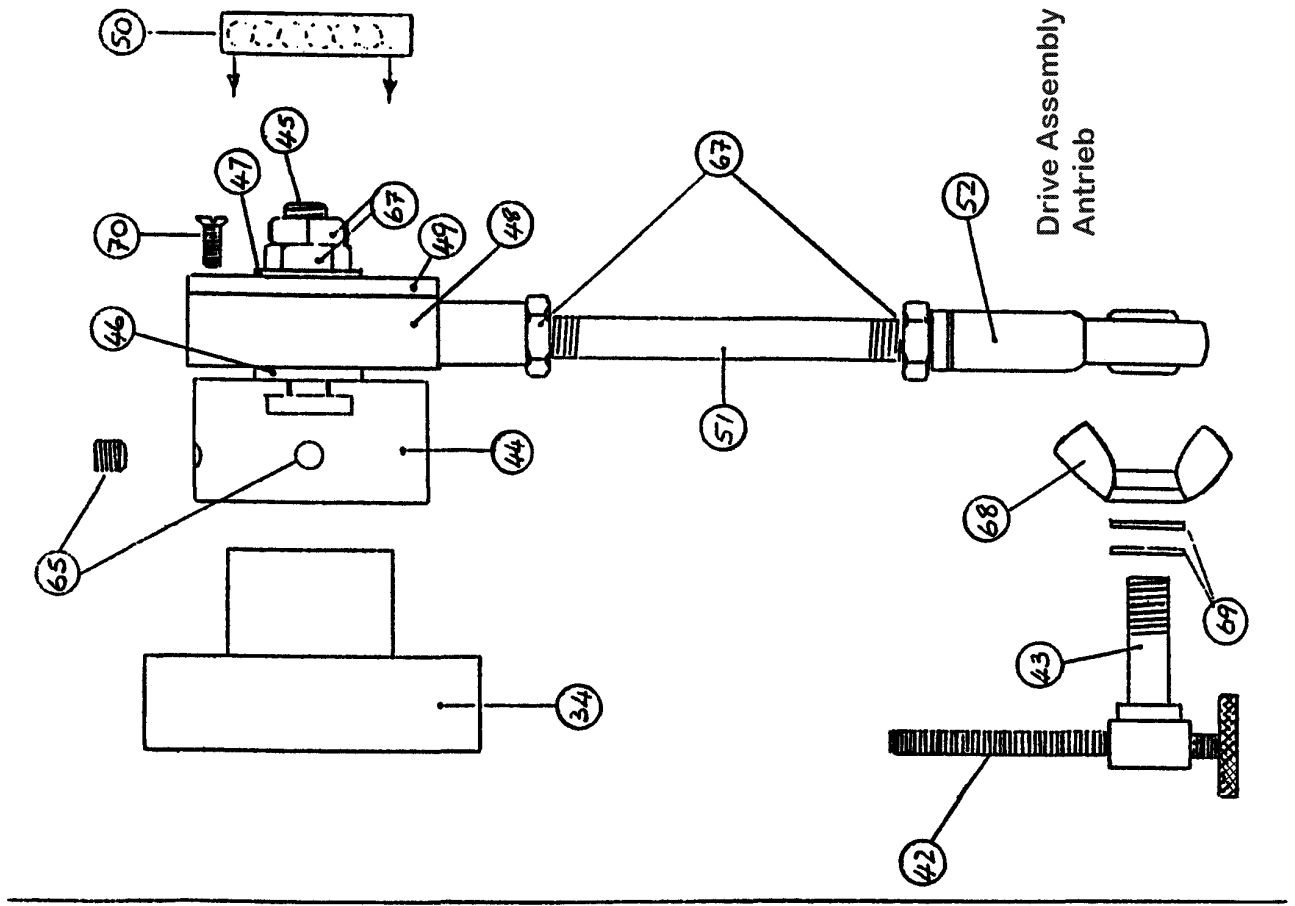
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|------------------------------------|------------------------------------|------------------------------|---|-----------------------------------|
| 1 | 78057 | Screw | Linsensenkschraube | 2 |
| 2 | 81524B | Throat Plate | Stichplatte | 1 |
| 3 | 81524L | Throat Plate for 3374A | Stichplatte ohne Transportschlitz für 3374A | 1 |
| 4 | 81524LA | Throat Plate for 3374B | Stichplatte ohne Transportschlitz für 3374B | 1 |
| 5 | 81520LA | Presser Foot | Drückerfuß | 1 |
| 6 | 12934A | Nut | Sechskantmutter | 2 |
| 7 | 89 | Screw | Gewindestift J2x4,8 | 1 |
| 8 | 22560A | Screw | Gewindestift J2x8,7 | 1 |
| 9 | 22894AD | Screw | Gewindestift Q2x6,4 | 1 |
| 10 | 81503M | Cloth Guide Tongue for 3374A | Stoffführungszunge für 3374A | 1 |
| 11 | 81503MA | Cloth Guide Tongue for 3374B | Stoffführungszunge für 3374B | 1 |
| 12 | HS24C | Screw | Zylinderschraube | 2 |
| 13 | 22514 | Screw | Zylinderschraube | 2 |
| 14 | 81303FL | Edge Guide for 3374A | Stoffkantenführung für 3374A | 1 |
| 15 | 81303FLA | Edge Guide for 3374B | Stoffkantenführung für 3374B | 1 |
| 16 | 81503N | Rope Guide | Seilführung | 1 |
| 17 | 94 | Screw | Zylinderschraube | 2 |
| 18 | 81501LP | Cloth Plate | Stoffplatte | 1 |
| 19 | 22686C | Screw | Gewindestif, Innensechskant | 1 |
| 20 | 81505L | Feed Dog | Transporteur | 1 |
| 21 | 69H | Washer | Unterlagscheibe | 1 |
| 22 | 51487 | Nut | Sechskantmutter | 1 |

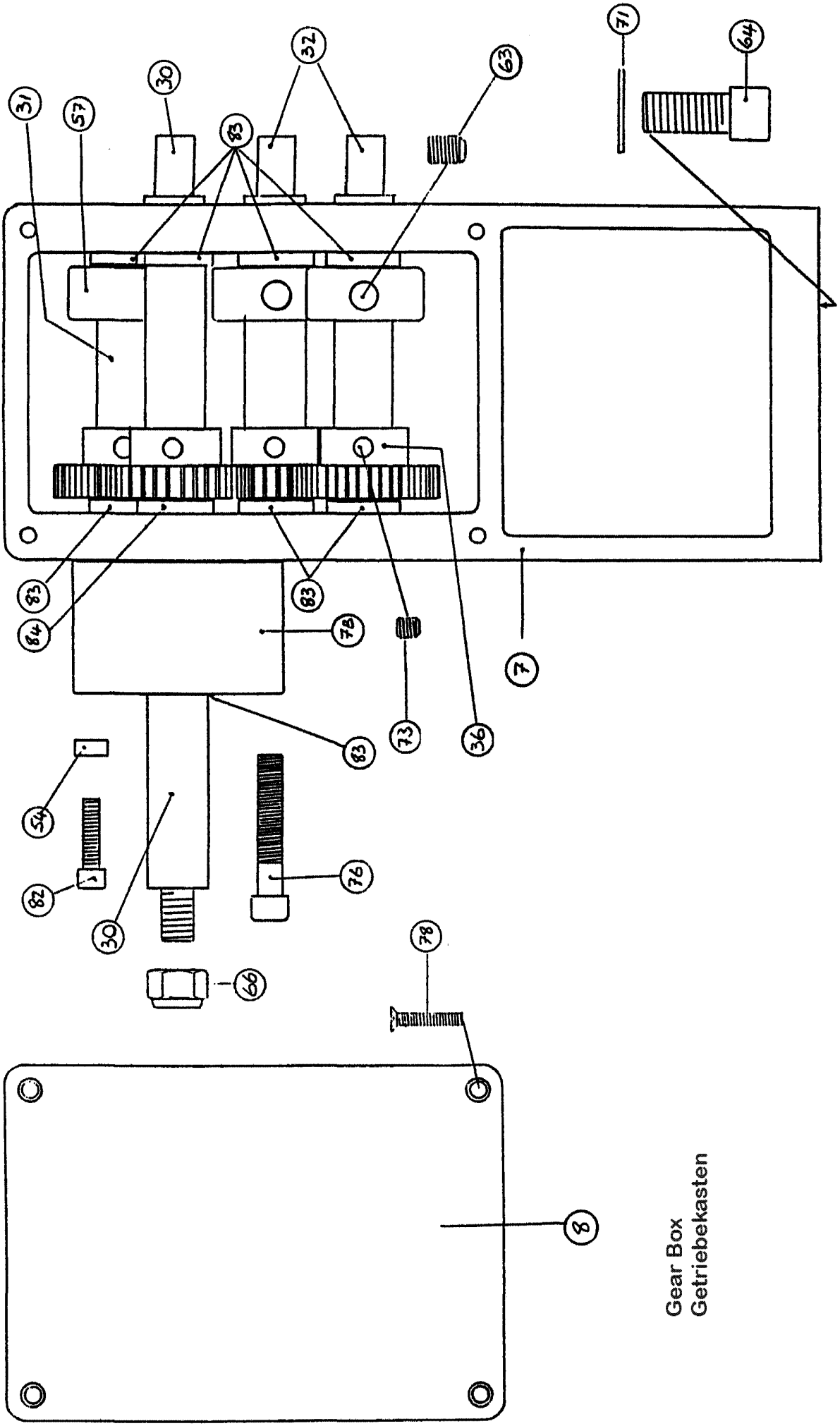


STEPPER TWIN PULLER
SCHRITT-DOPPELPULLER



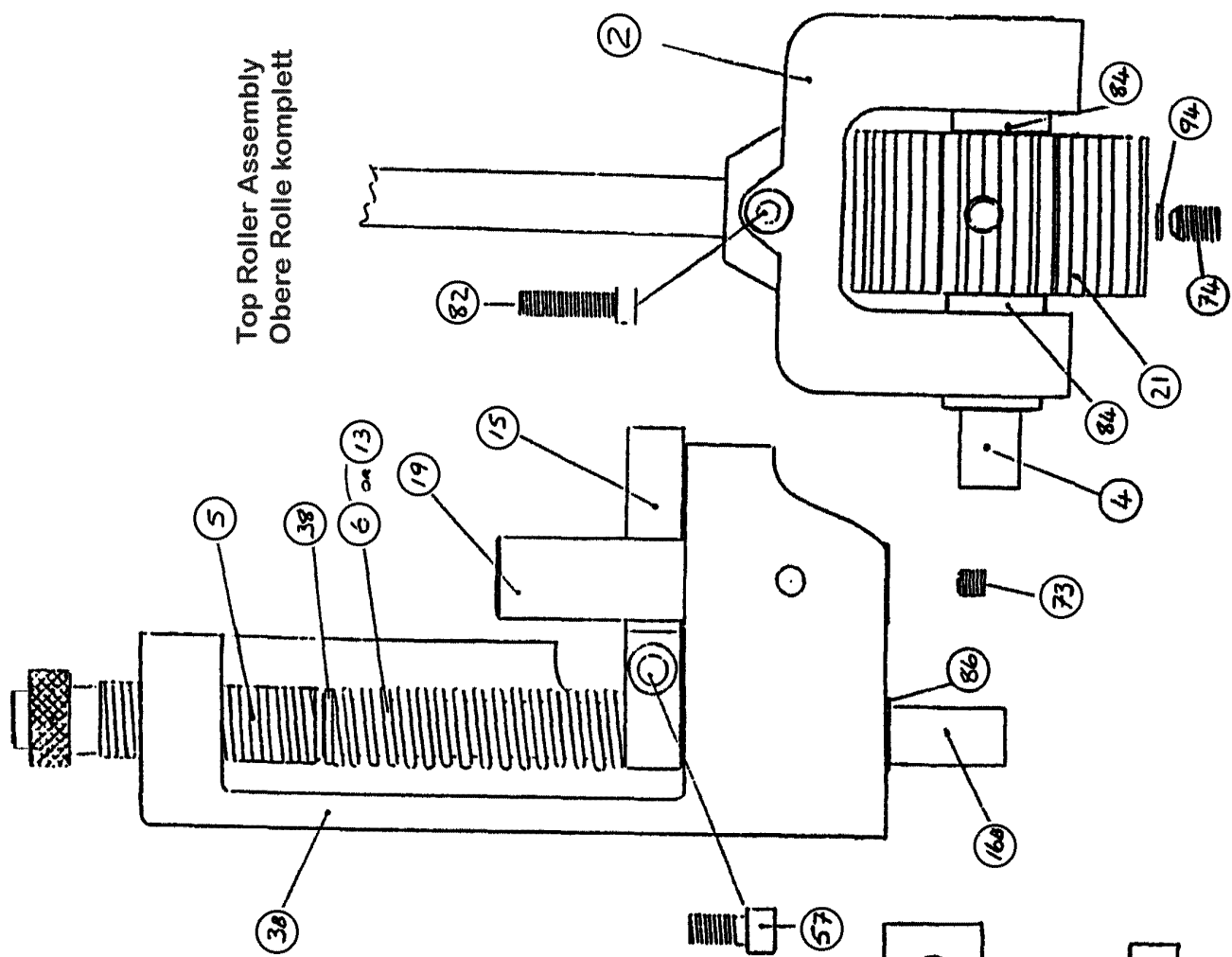
STEPPER TWIN PULLER
SCHRITT-DOPPELPULLER



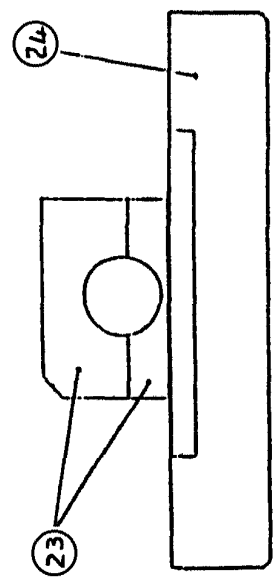


Gear Box
Getriebekasten

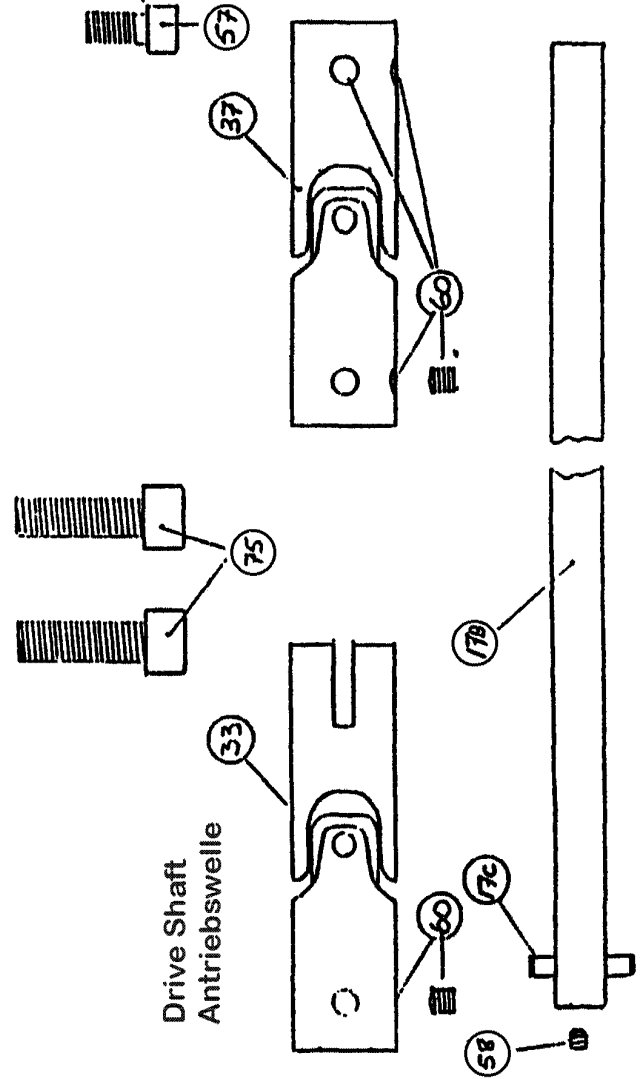
Top Roller Assembly
Obere Rolle komplett

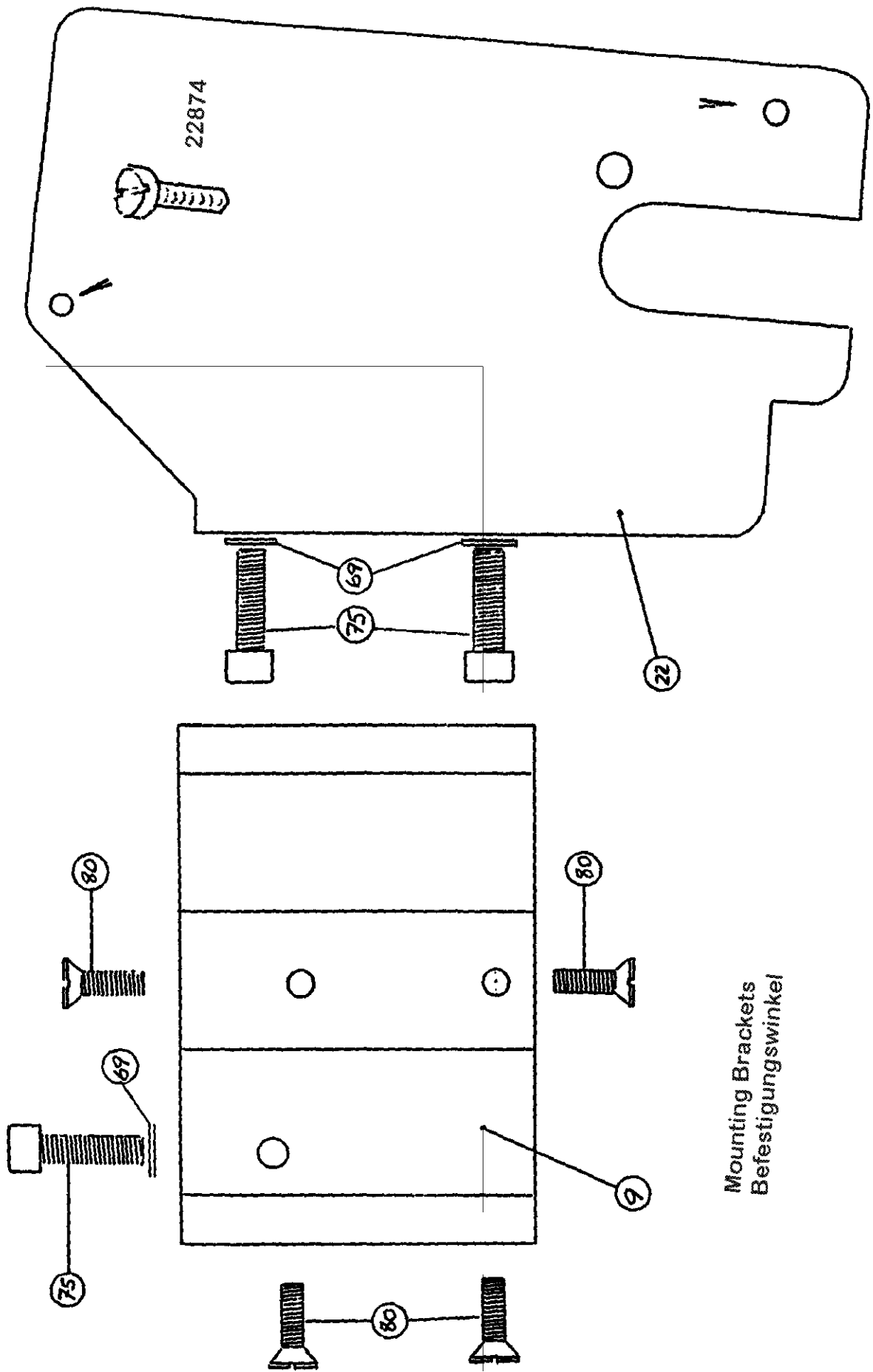


Roller Lifter
Rollenlifter

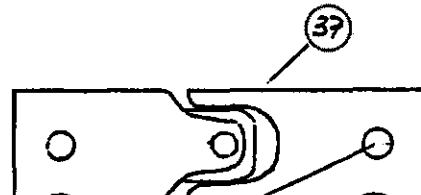
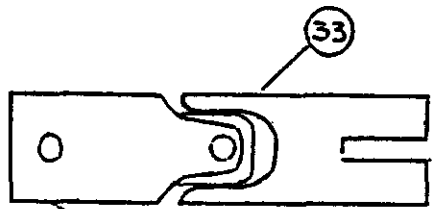


Drive Shaft
Antriebswelle

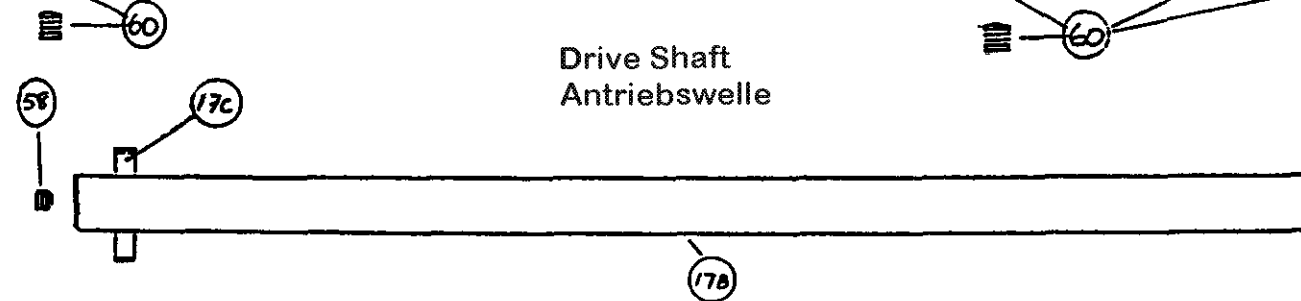




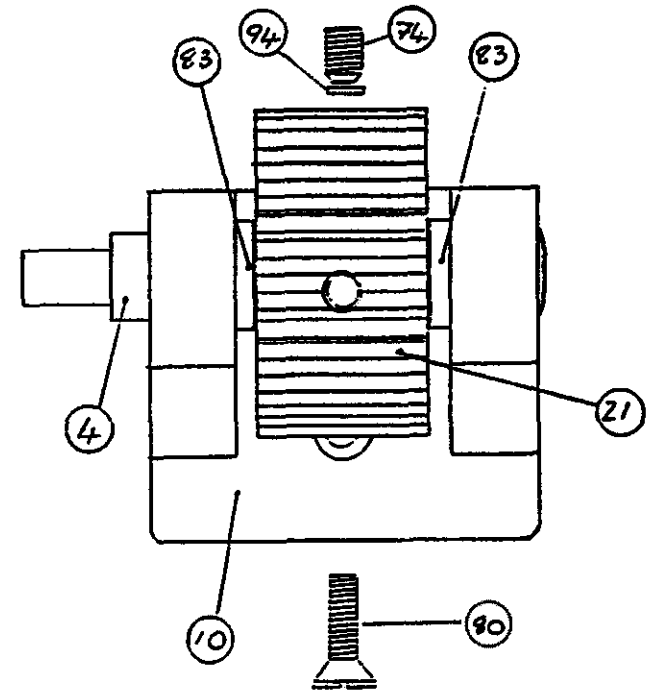
Mounting Brackets
 Befestigungswinkel



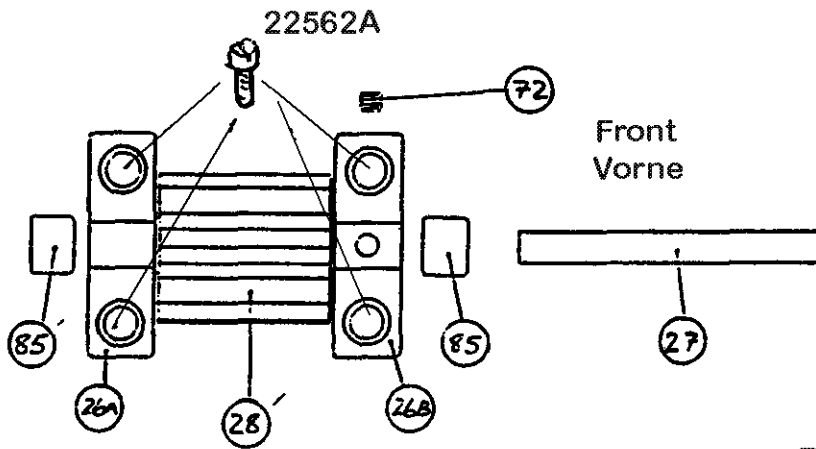
Drive Shaft
Antriebswelle



15

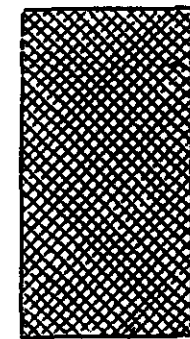


Rear
Hinten

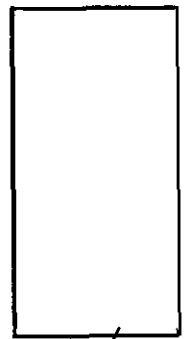


Front
Vorne

Bottom Roller Assembly
Untere Rolle komplett



Knurled Roller
geraendelte
Rolle

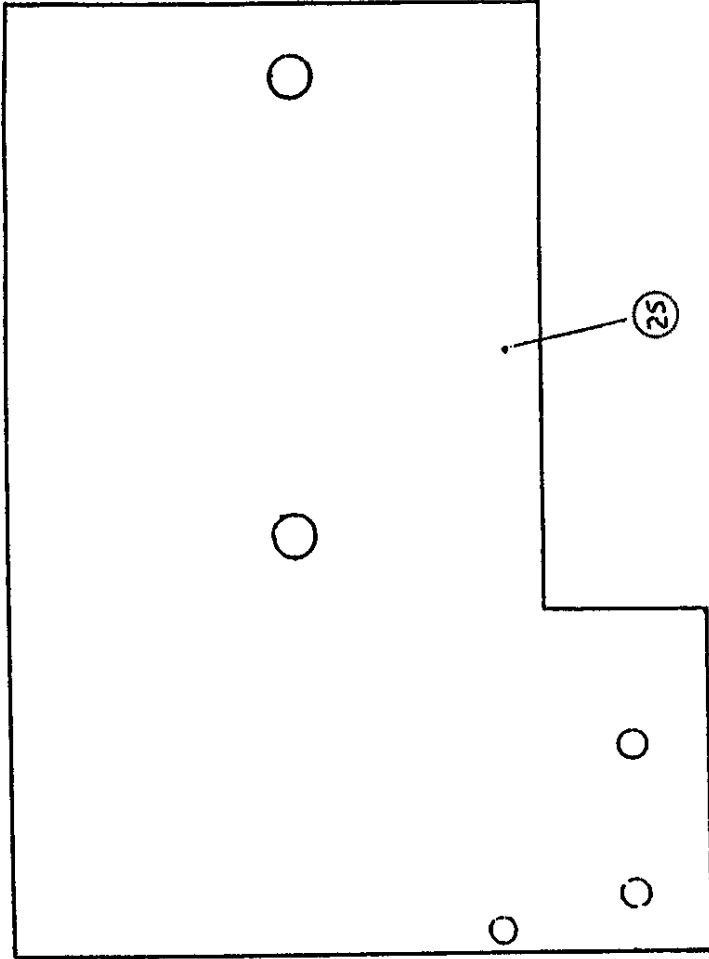
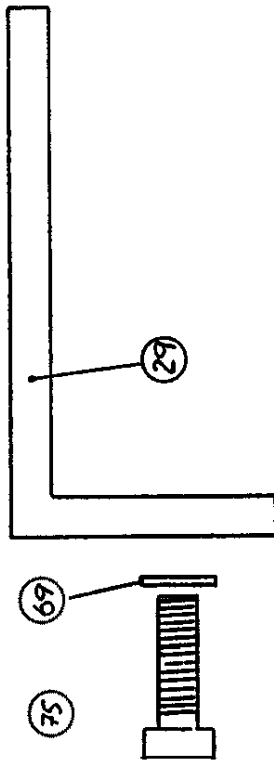


Polypropylene
Roller
Kunststoffrolle

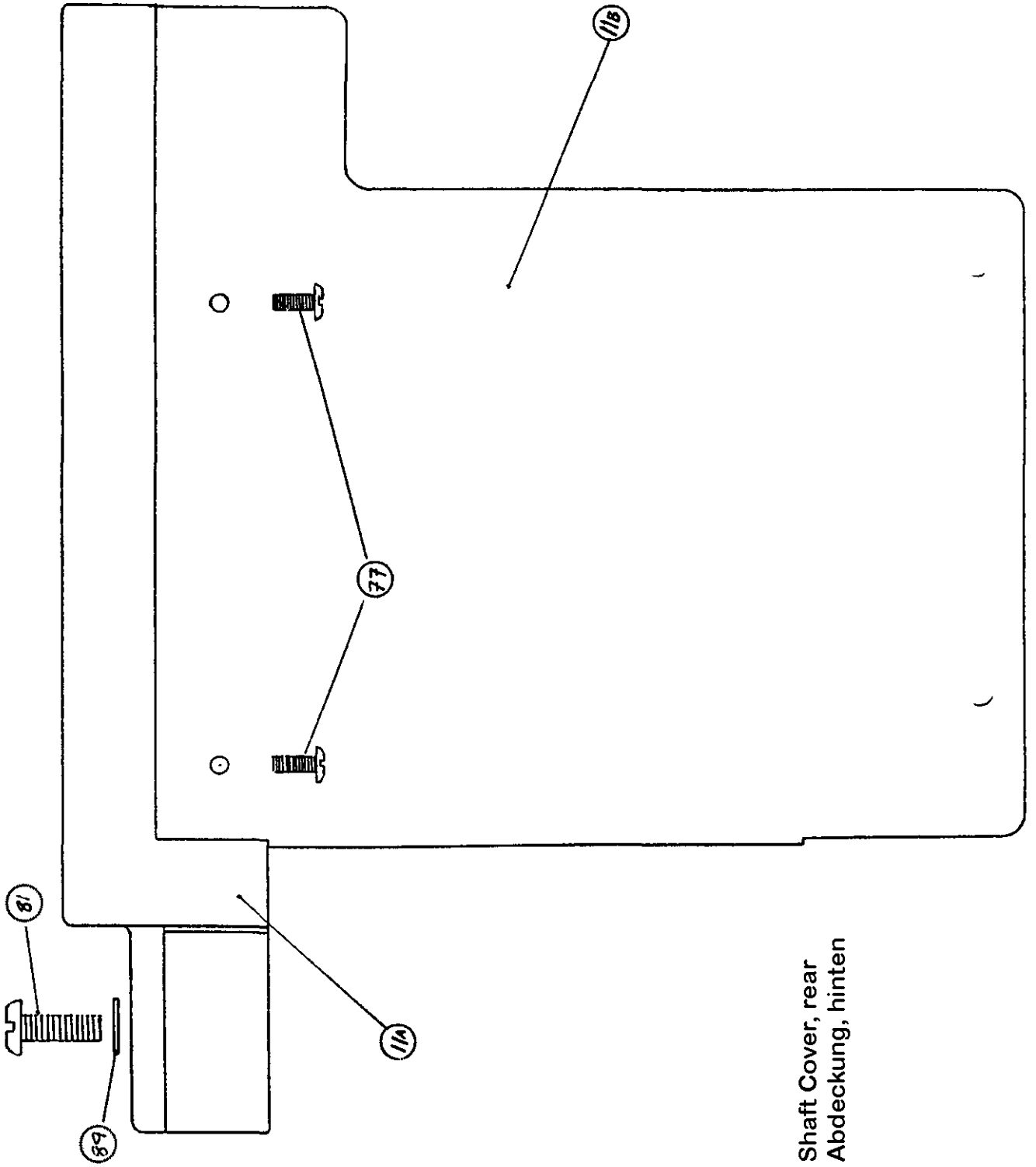
91

92

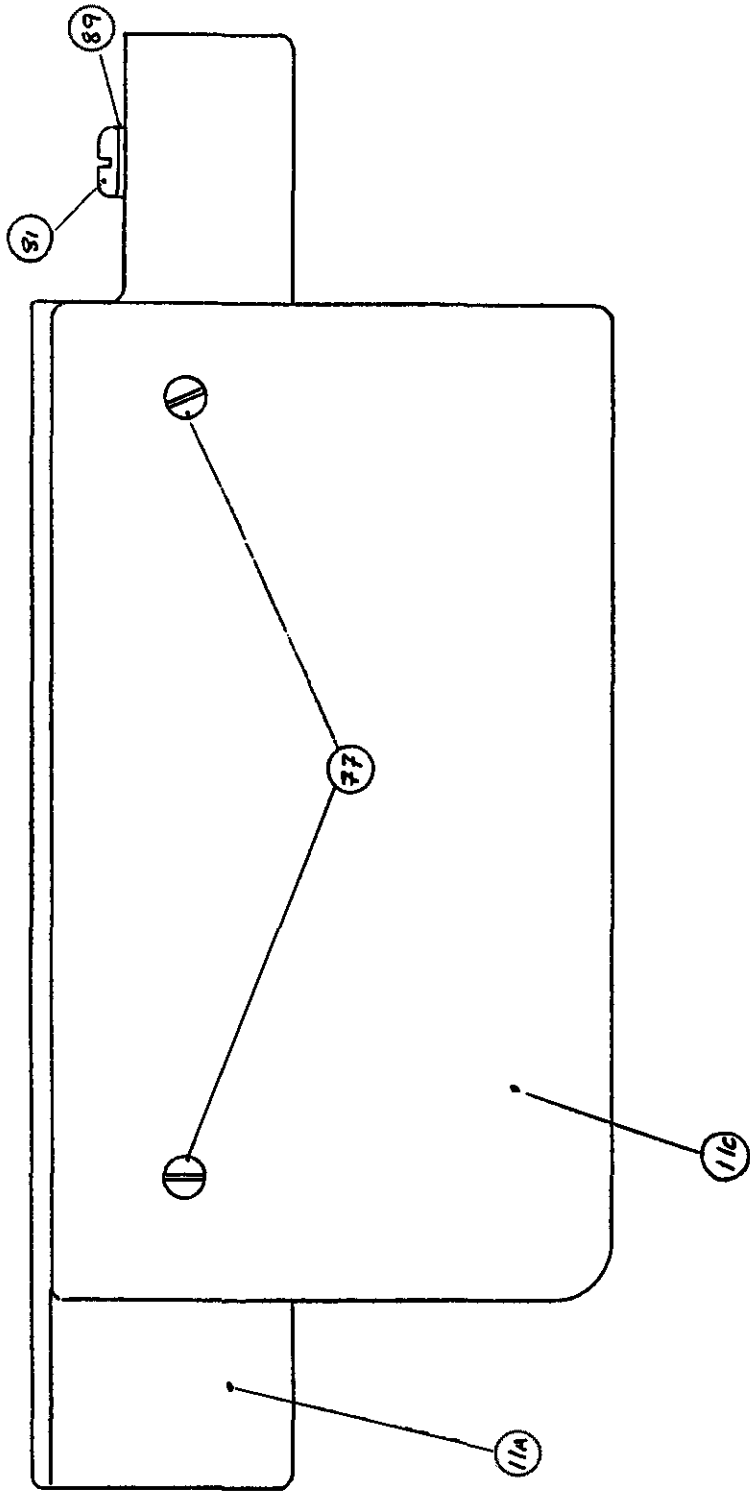
Air Cylinder Bracket
Halter fuer Luftzylinder



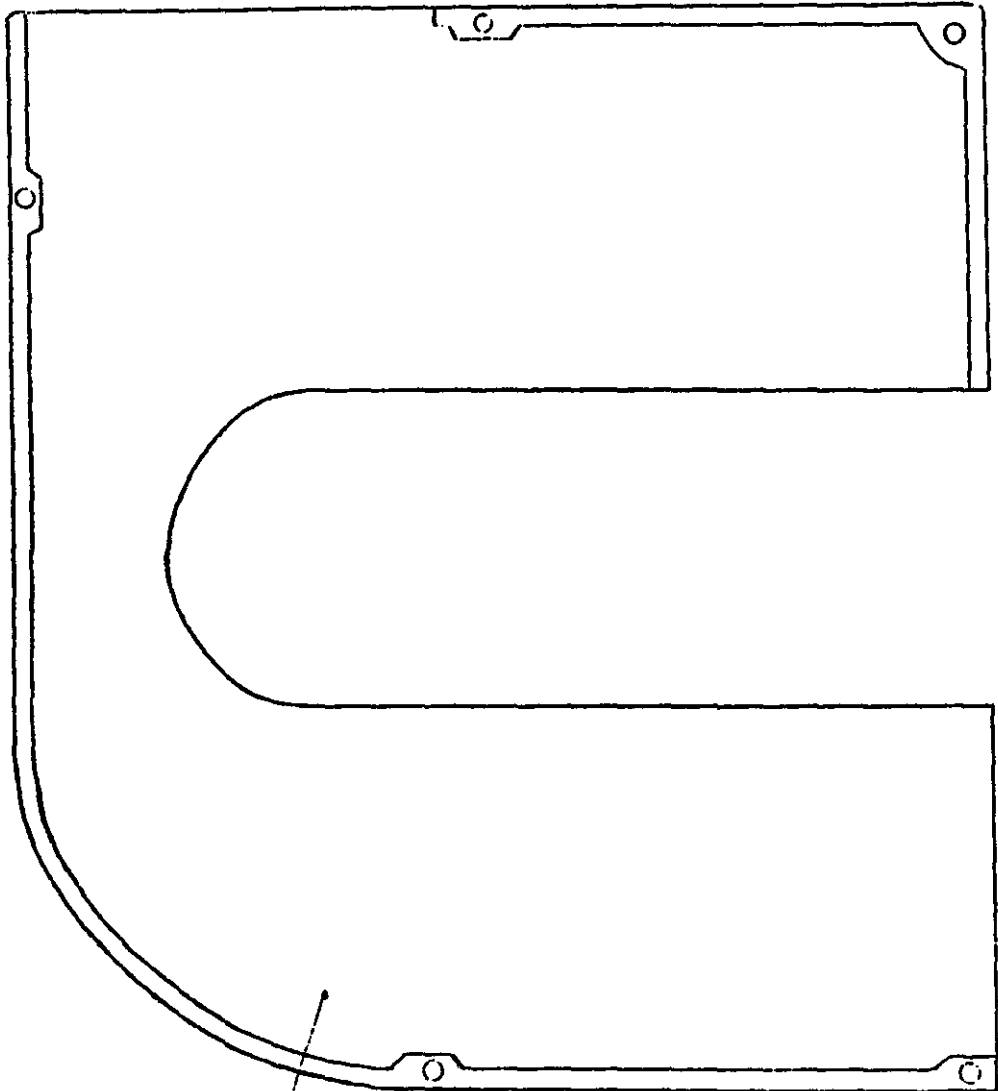
Base Plate
Grundplatte



Shaft Cover, rear
Abdeckung, hinten

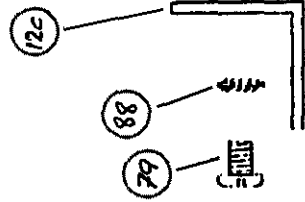


Shaft Cover, front
Abdeckung, vorn



12A

Belt Cover
Riemenabdeckung



| <u>Ref. No.</u> <u>Pos. No.</u> | <u>Part No.</u> <u>Teil Nr.</u> | <u>Description</u> | <u>Beschreibung</u> | <u>Amt. Req.</u> <u>Anzahl</u> |
|------------------------------------|------------------------------------|--|---|-----------------------------------|
| 1 | 99706A | Stepper Twin Puller Assembly | Schritt-Doppelpuller komplett | 1 |
| | 999-126 | Coupling | Schraubanschlußstück | 1 |
| | 999-127 | Corner Connection | Eckanschlußstück | 1 |
| | 999-234B | Air Cylinder | Einfach wirkender Zylinder | 1 |
| | G29912 | Knee Pressure Valve | Pneumatikventil für Kniebetätigung | 1 |
| | 99683M | Filter Regulator | Filterdruckminderer | 1 |
| | 22874 | Screw for stepper twin puller and face cover | Schraube für Schritt-Doppelpuller und Stirndeckel | 2 |
| | 22562A | Screw for front lower roller | Schraube für vordere, untere Rolle | 4 |
| | 99706 | Stepper Twin Puller | Schrittpuller | 1 |
| 2 | 99706-2 | Roller Yoke | Joch für Rolle | 2 |
| 3B | 99706-3B | Main Roller Bracket | Haltewinkel | 2 |
| 4 | 99706-4 | Roller Shaft | Welle für Rolle | 3 |
| 5 | 99706-5 | Roller Pressure Screw | Druckschraube | 2 |
| 6 | 99706-6 | Roller Pressure Spring (standard) | Druckfeder | 1 |
| 7 | 99706-7 | Gearbox | Getriebekasten | 1 |
| 7B | 99706-7B | Gearbox Clutch Mounting Block | Lager für die Kupplung | 1 |
| 8 | 99706-8 | Gearbox Cover | Abdeckung für Getriebekasten | 1 |
| 9 | 99706-9 | Roller Units Mounting Block | Träger | 1 |
| 10 | 99706-10 | Bottom Roller Housing (rear) | Gehäuse für Rolle hinten | 1 |
| 11A | 99706-11A | Shaft Cover (rear) | Abdeckung hinten | 1 |
| 11B | 99706-11B | Shaft Cover (rear) | Abdeckung hinten | 1 |
| 11C | 99706-11C | Shaft Cover(front) | Abdeckung vorn | 1 |
| 12A | 99706-12A | Belt Cover | Riemenabdeckung | 1 |
| 12B | 99706-12B | --- | --- | - |
| 12C | 99706-12C | Bracket for Cover | Winkel für Abdeckung | 1 |
| 13 | 99706-13 | Roller Pressure Spring (heavy) | Druckfeder | 1 |
| 14 | 99706-14 | --- | --- | - |
| 15 | 99706-15 | Yoke Shaft Clamp | Pullerstangemitnehmer | 2 |
| 16B | 99706-16 | Yoke Shaft | Pullerstange | 2 |
| 17B | 99706-17B | Drive Shaft | Welle | 3 |
| 17C | 99706-17C | Pin | Stift | 3 |
| 18 | 99706-18 | --- | --- | - |
| 19 | 99706-19 | Lever Support | Träger | 2 |
| 20 | 99706-20 | --- | --- | - |
| 21 | 99706-21 | Crimping Roller | Rolle | 3 |
| 22 | 99706-22 | Face Plate Mounting Bracket | Befestigungswinkel | 1 |
| 23 | 99706-23 | Lifter Clamp | Pratze | 1 |
| 24 | 99706-24 | Roller Lifter | Rollenlifter | 1 |
| 25 | 99706-25 | Base Plate | Grundplatte | 1 |
| 26A | 99706-26A | Bottom Roller Bearers (front) | Halter für Rolle vorn | 1 |
| 26B | 99706-26B | Bottom Roller Bearers (front) | Halter für Rolle vorn | 1 |
| 27 | 99706-27 | Bottom Roller Shaft (front) | Achse | 1 |
| 28 | 99706-28 | Bottom Crimping Roller (front) | Rolle | 1 |
| 29 | 99706-29 | Air Cylinder Bracket | Halter für Luftzylinder | 1 |
| 30 | 99706-30 | Clutch Shaft | Welle | 1 |
| 31 | 99706-31 | Jockey Gear Shaft | Getriebewelle | 1 |
| 32 | 99706-32 | Gear Shaft | Getriebewelle | 2 |
| 33 | 99706-33 | Universal Coupling (slotted) | Gelenk | 3 |
| 34 | 99706-34 | Pulley Adapter | Adapter für Handrad | 1 |
| 35 | 99706-35 | --- | --- | - |
| 36 | 99706-36 | Gear 32 DP 40 theeth | Zahnrad | 4 |
| 37 | 99706-37 | Universal Coupling | Gelenk | 3 |
| 38 | 99706-38 | Spring Head Washer | Federscheibe | 2 |
| 39 | 99706-39 | Clutch Flange End | Kupplungsflansch | 1 |
| 40 | 99706-40 | Clutch Center | Aufnahme für Kupplungslager | 1 |
| 41 | 99706-41 | Clutch Lever End | Kupplungshebel | 1 |
| 42 | 99706-42 | Clutch Vernier Adjusting Screw | Stellschraube | 1 |
| 43 | 99706-43 | Clutch Vernier Slide Bolt | Bolzen | 1 |
| 44 | 99706-44 | Handwheel Real Spigot Sleeve | Muffe für Handradadapter | 1 |
| 45 | 99706-45 | T Bolt | T-Bolzen | 1 |
| **46 | 99706-46 | Ballrace Rod End Enter Bushing | Buchse | 1 |
| 47 | 99706-47 | Ballrace Rod End Retaining Washer | Sicherungsscheibe | 1 |
| **48 | 99706-48 | Ballrace Rod End Body | Kugellagergehäuse | 1 |
| **49 | 99706-49 | Ballrace Rod End Cover | Abdeckung für Kugellagergehäuse | 1 |
| **50 | 99706-50 | Ballrace (EE4) | Kugellager | 1 |

| <u>Ref. No.</u> <u>Pos. No.</u> | <u>Part No.</u> <u>Teil Nr.</u> | <u>Description</u> | <u>Beschreibung</u> | <u>Amt. Req.</u> <u>Anzahl</u> |
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| 51 | 99706-51 | Connecting Rod | Verbindungsstange | 1 |
| 52 | 99706-52 | Ball End (RF4) | Verbindung | 1 |
| 53 | 99706-53 | Needle Roller Clutch (RC10141FS) | Nadellager | 2 |
| 54 | 99706-54 | Clutch Anti Rotation Stop | Anschlag | 1 |
| 55 | 99706-55 | --- | --- | - |
| 56 | 99706-56 | Clutch Washer | Scheibe | 1 |
| 57 | 99706-57 | 2BA x 3/8 inch Socket Cap Head Screw | Schraube mit Innensechskant | 2 |
| 58 | 99706-58 | 4BA x 1/8 inch Socket Set Screw | Gewindestift | 3 |
| *59 | 99706-59 | 4BA x 1/2 inch Socket Cap Screw (used in yokes before units numbered) | Schraube (für Gabelgelenke) | - |
| 60 | 99706-60 | 2BA x 3/16 inch Socket Set Screw | Gewindestift | 16 |
| 61 | 99706-61 | 2BA x 1/4 inch Socket Set Screw | Gewindestift | 1 |
| 62 | 99706-62 | --- | --- | - |
| 63 | 99706-63 | 1/4 inch Whitworth x 1/4 inch Socket Set Screw | Gewindestift | 3 |
| 64 | 99706-64 | 5/16 inch BSF x 3/4 inch Socket Cap Head Screw | Schraube | 2 |
| 65 | 99706-65 | M6x6 mm Socket Set Screw | Gewindestift M6x6 | 2 |
| 66 | 99706-66 | 1/4 inch BSF Nylock Nut | Mutter | 1 |
| 67 | 99706-67 | 1/4 inch BSF Half Nut | Mutternsatz | 4 |
| 68 | 99706-68 | 1/4 inch BSF Wing Nut | Flügelmutter | 1 |
| 69 | 99706-69 | 1/4 inch Washer | Scheibe | 5 |
| **70 | 99706-70 | 6BA x 5/16 inch Instrum. Head Screw | Schraube | 3 |
| 71 | 99706-71 | 5/16 inch Washer | Scheibe | 2 |
| 72 | 99706-72 | M3x3 mm Socket Set Screw | Gewindestift M3x3 | 1 |
| 73 | 99706-73 | M5x5 mm Socket Set Screw | Gewindestift M5x5 | 6 |
| 74 | 99706-74 | M6x8 mm Socket Set Screw | Gewindestift M6x8 | 3 |
| 75 | 99706-75 | M6 x20 mm S. Cap Head Screw | Schraube M6x20 | 5 |
| 76 | 99706-76 | M5x30 mm S. Cap Head Screw | Schraube M5x30 | 2 |
| 77 | 99706-77 | M3x8 mm Pan Head Screw | Schraube M3x8 | 9 |
| 78 | 99706-78 | M3x16 mm Countersink Head Screw | Schraube M3x16 | 4 |
| 79 | 99706-79 | M3.5x5 mm Pan Head Screw | Schraube M3,5x5 | 1 |
| 80 | 99706-80 | M5X16 mm Countersink Head Screw | Schraube M5x16 | 6 |
| 81 | 99706-81 | M5X16 mm Pan Head Screw | Schraube M5x16 | 2 |
| 82 | 99706-82 | M4 x15 mm Socket Cap Head Screw | Schraube M4x15 | 3 |
| 83 | 99706-83 | 1/2 x 5/8 x 5/8 inch Self Lubrication Bronze Bearing | Bronzelager | 10 |
| 84 | 99706-84 | 1/2 x 5/8 x 3/4 inch Self Lubrication Bronze Bearing | Bronzelager | 5 |
| 85 | 99706-85 | 3/16 x 5/16 x 1/4 inch Self Lubrication Bronze Bearing | Bronzelager | 2 |
| 86 | 99706-86 | 3/8 x 1/2 x 1/2 inch Self Lubrication Bronze Bearing | Bronzelager | 2 |
| 87 | 99706-87 | 1/2 inch Collar | Stelling | 3 |
| 88 | 99706-88 | 3.5 mm Shakeproof Washer | Scheibe | 1 |
| 89 | 99706-89 | 5 mm Washer | Scheibe | 2 |
| 90 | 99706-90 | --- | --- | - |
| 91 | 99706-91 | Knurled Steel Roller | Rolle, gerändelt | - |
| 92 | 99706-92 | Polypropylene Roller | Rolle, Kunststoff | - |
| 93 | 99706-93 | --- | --- | - |
| 94 | 99706-94 | Brass Pad | Messingunterlage | 3 |

* Not shown

* Nicht abgebildet

** Pos. 46, 49, 50 and 70 are Part
of Pos. No. 48

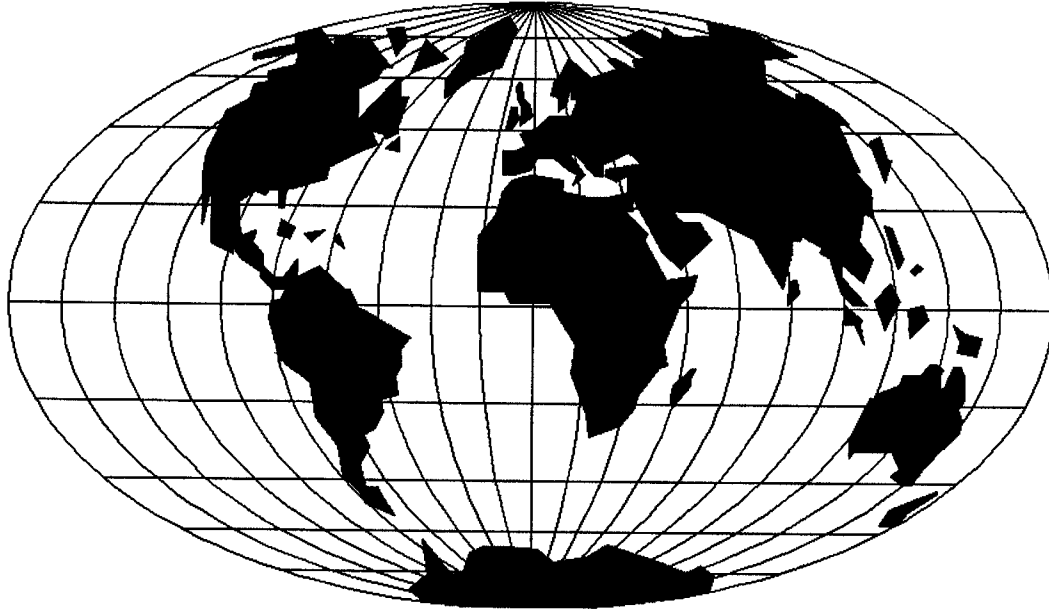
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