

REPAIR PARTS FOR VE424MC Roll Grooving Tool



PARTS ORDERING INFORMATION

When ordering parts, the following information is necessary for the Victaulic Tool Company to promptly process the order and send the correct part(s).

1. Tool Model Number. VE424MC
2. Tool Serial Number.
The Serial Number (found on the back of the tool).
3. Quantity, Item Number, Part Number, Description.
Example: (1), 103, R-003-424-MAC, Main Shaft.
4. Where to send the part(s).
Company Name. Address
5. To whose attention to send the part(s).
Person's Name.
6. Purchase Order Number

Parts may be ordered from the nearest Victaulic Sales Office. Consult Victaulic Tool Company for the nearest Victaulic Sales Office.

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Victaulic Company of America
Phone: 1-800-PICK-VIC (1-800-742-5842)
Fax: 610-250-8817
e-mail: pickvic@victaulic.com

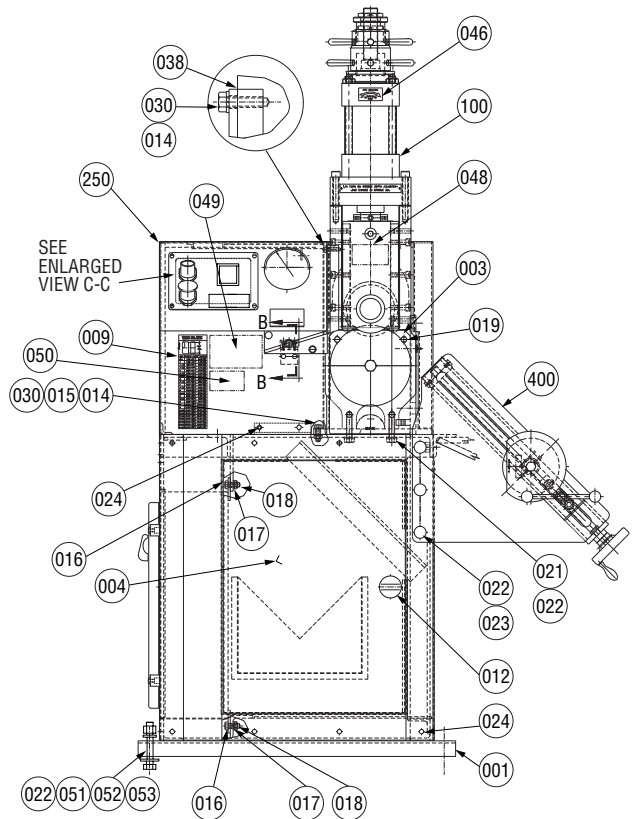
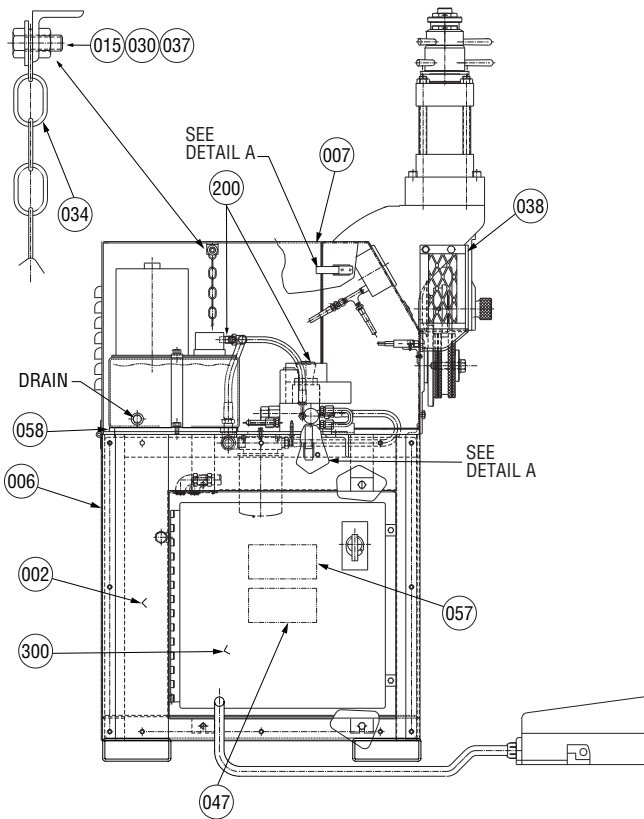
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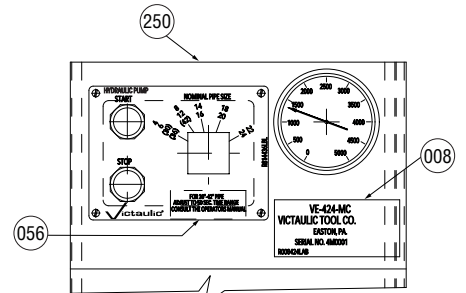
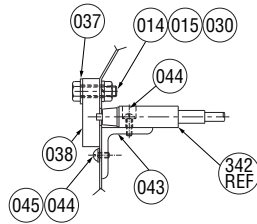
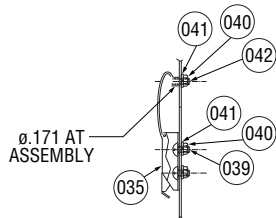
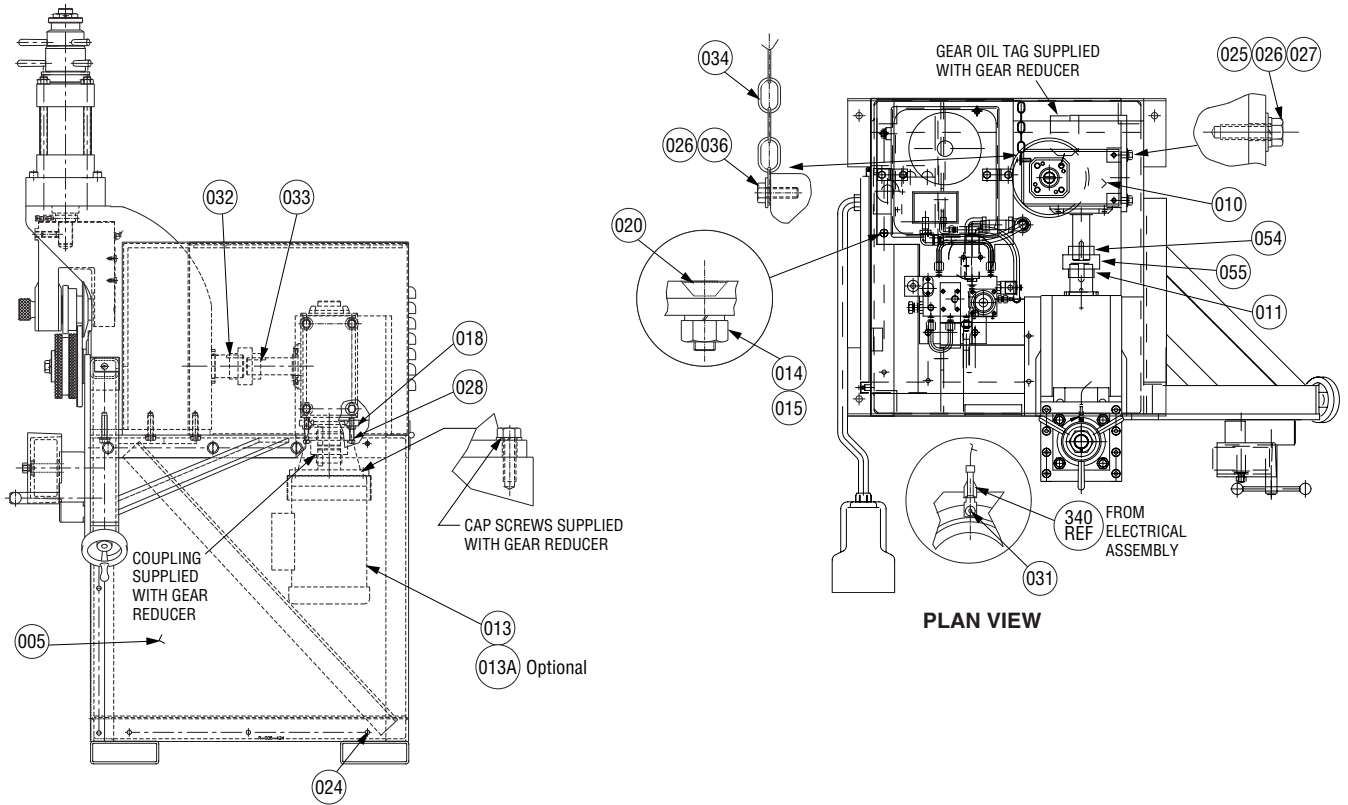
VE424 ASSEMBLY



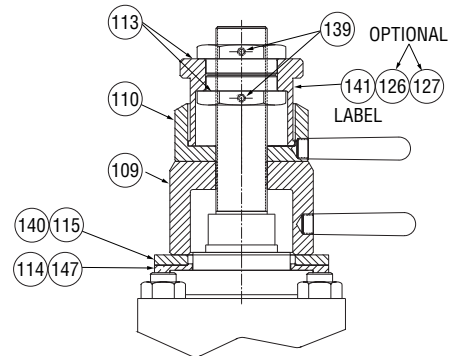
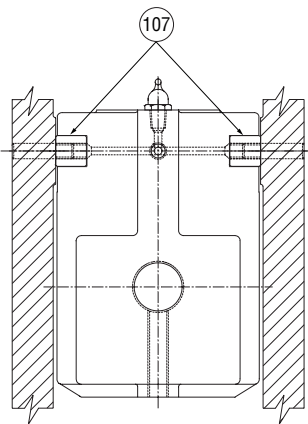
Item #	Part #	Qty.	Description
001	R-001-424-PNT	1	Frame
002	R-002-424-PNT	1	Left Side Enclosure
003	R-003-424-MAC	1	Seal Housing Machining
004	R-004-424-PNT	1	Front Enclosure with Door
005	R-005-424-PNT	1	Right Side Enclosure
006	R-006-424-PNT	1	Rear Enclosure
007	R-007-424-PNT	1	Top Enclosure
008	R-008-424-LBL	1	Identification/Serial No. Plate
009	R-009-424-LBL	1	"C" Diameter Reference Label
010	R-010-424-VEO	1	Gear Reducer Assembly
011	N-M10-000-01C	1	Chain Coupling
012	N-M07-000-001	1	Door Latch
013	N-E01-000-001	1	Motor
013A	-	-	Motor, 5 HP, 1740 RPM, special re-wind for 380V, 50/60 Hz. Service
014	N-W03-050-001	14	5/16" ID Split Lockwasher, Stl. Pltd.
015	N-N01-050-000	13	5/16"-18UNC Hex Nut, Stl. Pltd.
016	N-S01-060-100	4	3/8"-16UNC x 1.0 Hex Hd. Cap Screw, Stl. Pltd.
017	N-W03-060-000	4	3/8" ID Split Lockwasher, Stl. Pltd.
018	N-N01-060-000	6	3/8"-16UNC Hex Nut, Stl. Pltd.
019	N-S01-050-012	4	5/16"-18UNC x .75 Hex Hd. Cap Screw, Stl. Pltd.
020	N-S04-050-100	4	5/16"-18UNC x 1.0 Sock. Flat Hd. Cap Screw, Stl. Pltd.
021	N-S01-080-112	6	1/2"-13UNC x 1.75 Hex Hd. Cap Screw, Stl. Pltd.
022	N-W03-080-000	16	1/2" ID Split Lockwasher, Stl. Pltd.
023	N-S01-080-108	6	1/2"-13UNC x 1.5 Hex Hd. Cap Screw, Stl. Pltd.
024	N-S30-012-014	42	#12-24UNC x .88 Hvy. Duty Hex Washer Hd. Structural Self Drilling & Tapping Screw
025	N-S02-070-104	4	7/16"-14UNC x 1.25 Hex Hd. Cap Screw, Stl. Pltd.
026	N-W01-070-000	5	7/16" ID Flat Washer, Stl. Pltd.
027	N-W03-070-000	4	7/16" ID Split Lockwasher, Stl. Pltd.
028	N-S81-060-200	2	3/8"-16UNC x 2.0 Cup Pt. Set Screw
030	N-S01-050-100	11	5/16"-18UNC x 1.0 Hex Hd. Cap Screw, Stl. Pltd.
031	N-S07-006-008	1	#6-32UNC x .5 Rnd. Hd. Slotted Screw, Pltd.

Item #	Part #	Qty.	Description
032	N-K02-080-100	1	Square Key, .50 x 1.0 Lg.
033	N-K02-060-210	1	Square Key, .38 x 2.63 Lg.
034	N-M09-000-001	1	Chain
035	N-M07-000-002	2	Draw Latch Assembly
036	N-S01-070-012	1	7/16"-14UNC x .75 Hex Hd. Cap Screw, Stl. Pltd.
037	N-W01-050-000	3	5/16" ID Flat Washer, Stl. Pltd.
038	R-038-424-PNT	1	Roll Guard
039	N-S08-008-080	4	#8-32UNC x .50 Slot. Truss Hd. Mach. Screw, Pltd.
040	N-N01-008-000	6	#8-32UNC Hex Nut, Stl. Pltd.
041	N-W03-008-000	6	#8 ID Split Lockwasher, Stl. Pltd.
042	N-S04-008-080	2	#8-32UNC x .50 Slot. Flat Hd. Mach. Screw, Pltd.
043	R-043-424-PNT	1	Guard Interlock Switch Bracket
044	N-S06-010-010	4	#10-24UNC x .63 Pan Hd. Phillips Screw, Pltd.
045	N-W03-010-000	2	#10 ID Split Lockwasher, Stl. Pltd.
046	R-073-260-LAB	1	Pipe Rotation Label
047	R-090-424-LAB	1	Danger Label #1
048	R-091-424-LAB	1	Warning Label #2
049	R-031-272-LAB	1	Instruction Warning Label
050	R-010-416-LAB	1	Std. Wall Thickness Label
051	N-S01-080-308	4	1/2"-13UNC x 3.5 Hex Hd. Cap Screw, Stl. Pltd.
052	N-W01-080-000	4	1/2" ID Flat Washer, Stl. Pltd.
053	N-N01-080-000	4	1/2"-13UNC Hex Nut, Stl. Pltd.
054	N-M10-000-015	1	Chain Coupling
055	N-M10-000-022	1	Chain
056	R-095-424-LBL	1	Control Panel Warning Label
057	R-024-268-LBL	1	Operating Specifications Label
058	R-058-424-MCH	1	Vibration Isolator
100	R-100-424-VEO	1	VE424 Tool Head Assembly
200	R-200-424-VEO	1	VE424 Hydraulic Power Unit Assembly
250	R-250-424-VEO	1	Hydraulic Panel Assembly
300	R-300-424-VEO	1	VE424 Electrical Assembly
400	R-400-424-VEO	1	VE424 Stabilizer Assembly

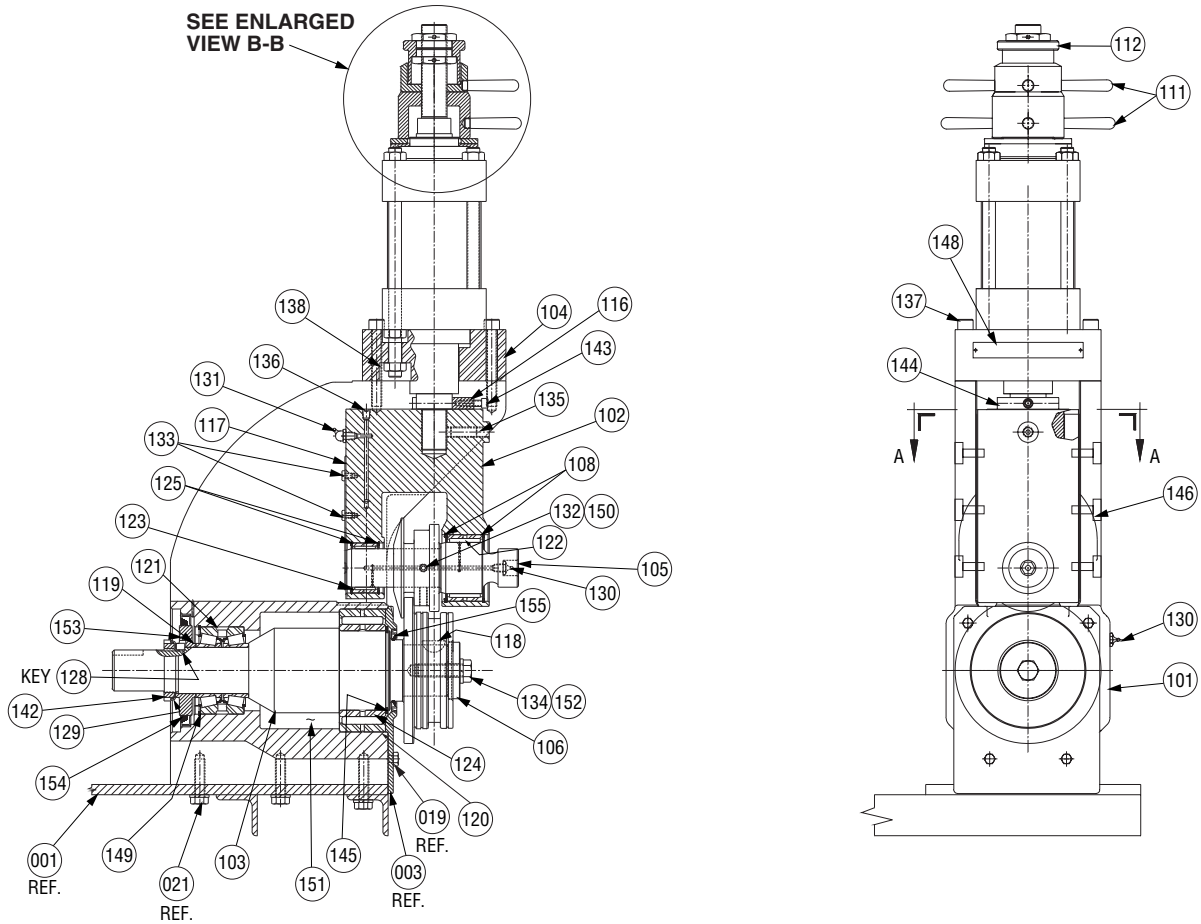
VE424 ASSEMBLY



VE424 TOOL HEAD ASSEMBLY



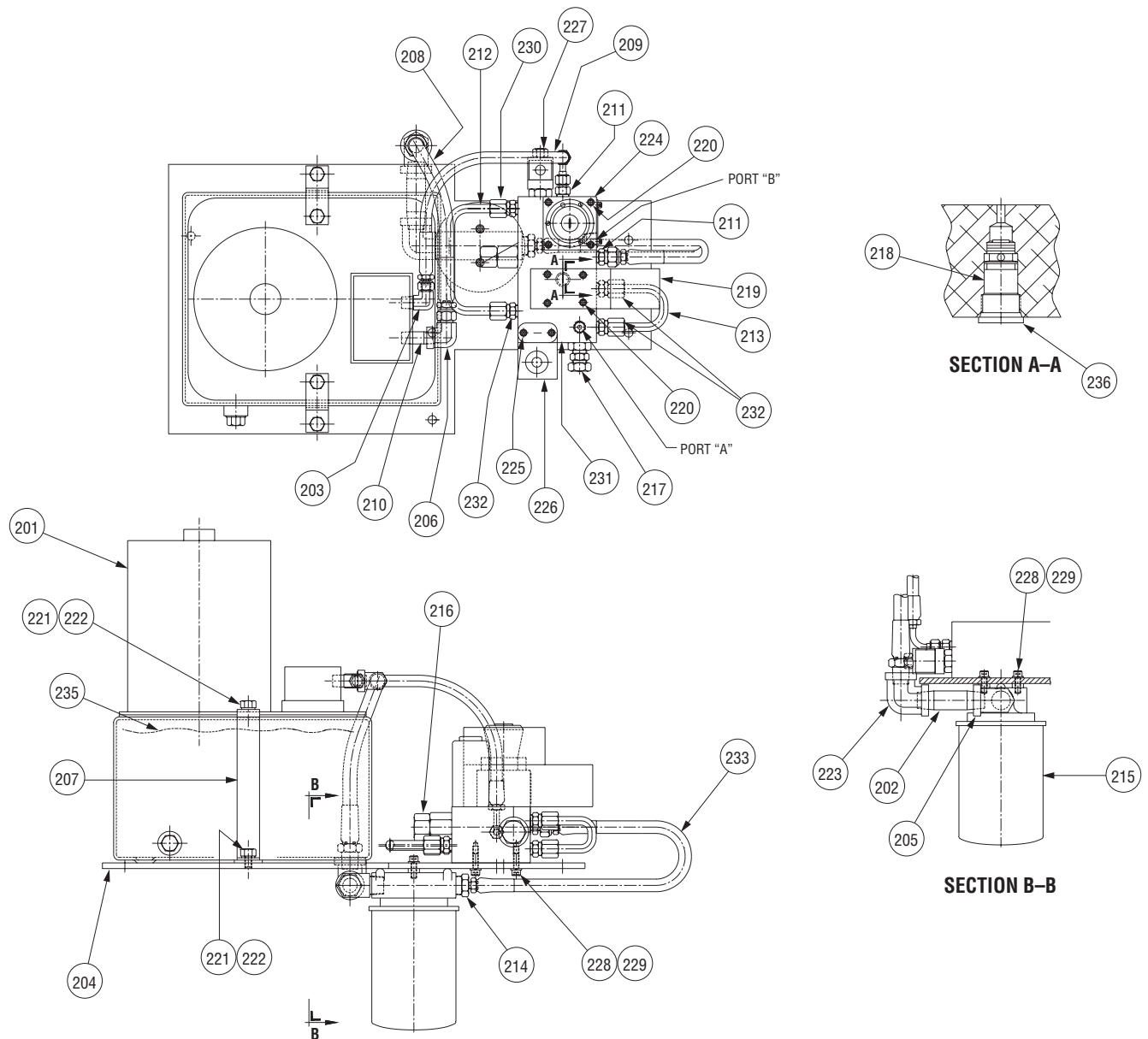
VE424 TOOL HEAD ASSEMBLY



Item #	Part #	Qty.	Description
101	R-101-424-MAC	1	Tool Head Housing Machining
102	R-102-424-MAC	1	Slide Machining
103	R-103-424-MAC	1	Main Shaft
104	R-104-424-VE0	1	Cylinder Mounting Block
105	R-105-424-VE0	1	Upper Shaft
106	R-106-424-PLT	1	Lower Roll Washer
107	R-107-424-MAC	2	Gib
108	N-T53-000-325	2	Retaining Ring
109	R-109-424-PLT	1	Depth Adjuster Lock
110	R-110-424-PLT	1	Depth Adjuster
111	R-111-424-PLT	6	Depth Adjuster Handle
112	R-112-424-PLT	1	Depth Adjuster Barrel
113	R-113-424-PLT	2	Depth Calibration Nut
114	R-114-424-MAC	1	Insulation Ring
115	R-115-424-PLT	1	Grounding Ring
116	R-116-424-MAC	1	Slide Spacer
117	R-110-350-MC2	1	Upper Shaft Spring
118	N-K01-080-900	1	#809 Woodruff Key
119	N-B02-225-001	2	Bearing Cone
120	N-B02-450-001	1	Rolling Bearing
121	N-B04-425-001	1	Bearing Cup
122	N-B02-250-002	1	Roller Bearing
123	N-B02-187-001	1	Roller Bearing
124	N-B04-387-001	1	Bearing Race
125	N-T53-000-243	2	Retaining Ring
126	R-167-424-LAB	1	Pipe Size Indicator Label, JIS & British
127	R-168-424-LAB	1	Pipe Size Indicator Label, DIN
128	R-164-424-MAC	1	Grease Seal Collar Key
129	N-B61-000-111	1	Lockwasher
130	N-M01-000-002	2	Lub. Fitting

Item #	Part #	Qty.	Description
131	N-M01-000-001	1	Lub. Fitting
132	N-S81-060-010	10	3/8-16UNC x .63 Cup Pt. Set Screw
133	N-S06-040-006	2	1/4-20UNC x .38 Pan Hd. Phillips Screw, Pltd.
134	N-S02-100-200	1	5/8-11UNC x 2.0 Hex Hd. Cap Screw Grade 8, Stl. Pltd.
135	N-S80-080-108	1	1/2-13UNC x 1.5 Brass Tip Set Screw
136	N-H16-002-001	1	1/8" Flush Socket Plug
137	N-S03-080-308	8	1/2-13UNC x 3.5 Sock Hd. Cap Screw, Blk. Ox.
138	N-N02-100-000	4	5/8-18UNF Hex Nut, Stl. Pltd.
139	N-S83-010-004	2	#10-32UNC x .25 Brass Tip Set Screw
140	N-S04-006-006	2	#6-32UNC x .38 Flat Hd. Slotted Screw, Pltd.
141	R-141-424-LAB	1	Pipe Size Indicator Label
142	N-B63-000-011	1	Locknut
143	N-S03-050-100	1	3/16-18UNC x 1.0 Sock. Hd. Cap Screw, Blk. Ox.
144	N-M12-000-001	2	Ball Plunger
145	N-T56-000-387	1	Retaining Ring
146	N-S03-060-104	6	3/8-16UNC x 1.25 Sock. Hd. Cap Screw, Blk. Ox.
147	N-S81-006-006	3	#6-32UNC x .38 Cup Pt. Set Screw
148	R-148-424-LAB	1	Groove Dia. Adj. Plate
149	N-T53-000-425	1	Retaining Ring
150	N-S82-060-003	10	3/8-16UNC x .19 Sock. Jam Screw
151	N-M02-000-001	As Req'd	Lubriplate
152	N-W03-100-000	1	5/8" ID Split Lockwasher, Stl. Pltd.
153	R-153-424-MAC	1	Grease Seal Collar
154	N-M11-000-001	1	Grease Seal
155	N-M11-000-002	1	Grease Seal

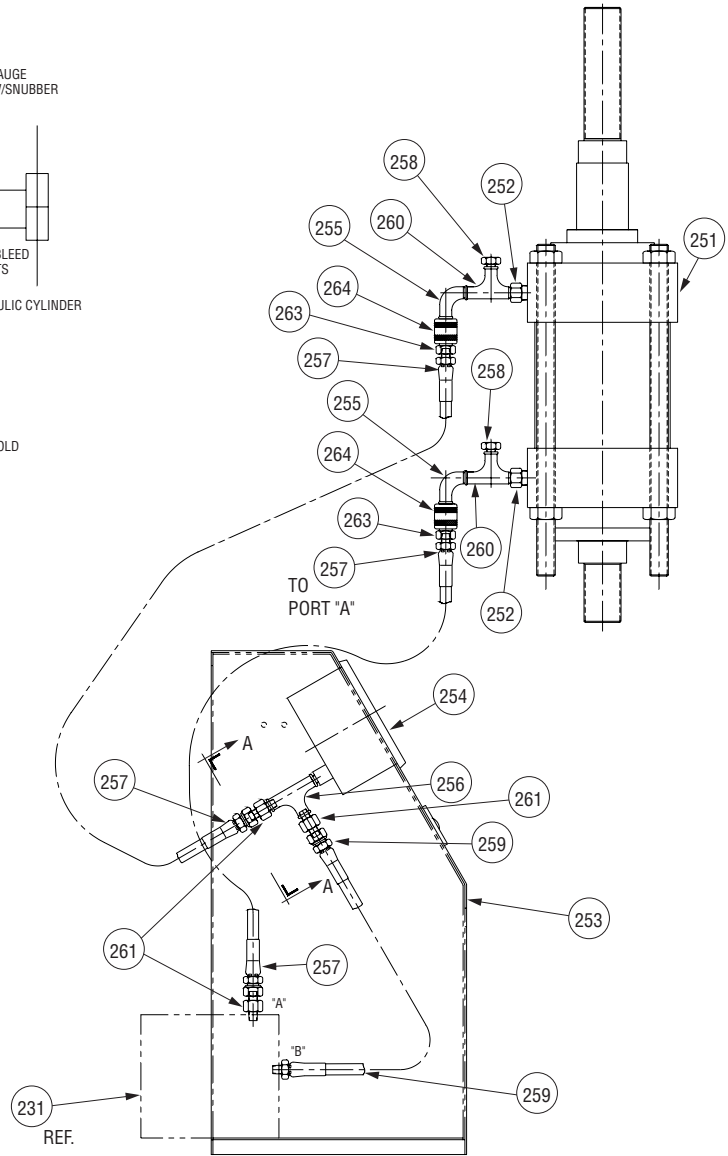
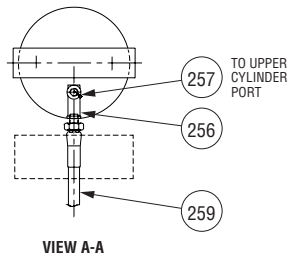
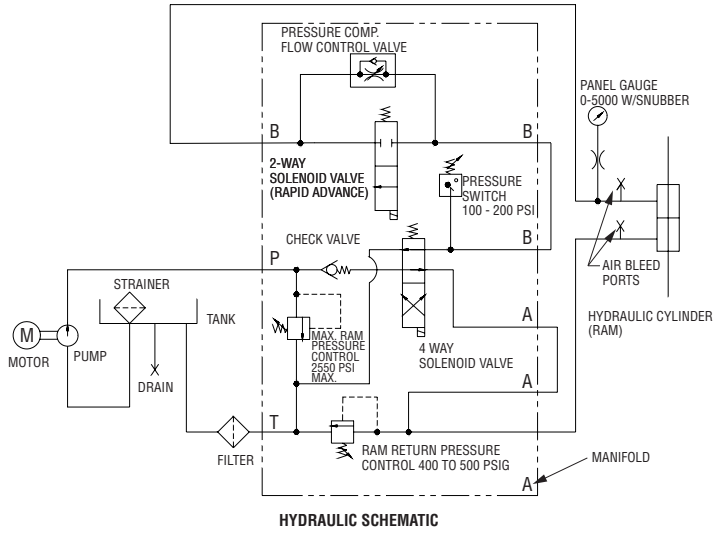
VE424 HYDRAULIC POWER UNIT ASSEMBLY



Item #	Part #	Qty.	Description
201	N-H05-000-005	1	Hydraulic Power Unit
202	N-H11-008-003	1	Pipe Nipple
203	N-H12-004-004	1	90° Elbow
204	R-204-424-PNT	1	VE424 Hydraulic System Mounting Plate
205	N-H12-008-002	1	90° Street Elbow
206	N-H12-004-006	1	90° Elbow
207	R-207-424-PNT	2	VE424 Hydraulic System Mounting Bracket
208	R-208-424-VE0	1	VE424 Hose Assembly
209	R-209-424-VE0	1	VE424 Hose Assembly
210	N-H11-004-002	1	Pipe Nipple
211	N-H11-004-001	2	Male Connector
212	R-277-424-MAC	1	Hydraulic Tubing Detail
213	R-276-424-MAC	1	Hydraulic Tubing Detail
214	N-H11-008-001	1	Reducing Bushing
215	N-H08-000-002	1	Return Line Filter
216	N-H04-000-030	1	Relief Valve
217	N-H04-000-002	1	Relief Valve
218	N-H04-000-003	1	Check Valve
219	N-H04-000-004	1	4-Way Valve

Item #	Part #	Qty.	Description
220	N-S03-010-200	8	#10-24UNC x 2.0 Sock. Hd. Cap Screw, Blk. Ox.
221	N-S16-050-008	4	5/16"-24UNF x .50 Hex Hd. Cap Screw, Stl. Pltd.
222	N-W03-050-000	4	5/16" ID Split Lockwasher, Stl. Pltd.
223	N-H12-008-001	1	90° Elbow
224	N-H04-000-006	1	2-Way Valve
225	N-S03-010-100	2	#10-24UNC x 1.0 Sock. Hd. Cap Screw, Blk. Ox.
226	N-H18-000-001	1	Pressure Switch
227	N-H04-000-005	1	Solenoid Valve
228	N-W03-040-000	4	1/4" ID Split Lockwasher, Stl. Pltd.
229	N-S03-040-012	4	1/4"-20UNC x .75 Sock. Hd. Cap Screw, Blk. Ox.
230	N-H11-006-002	1	Connector
231	R-262-424-MAC	1	Hydraulic Manifold
232	N-H11-006-001	3	Connector
233	R-259-424-VE0	1	VE424 Hose Assembly
234	-	As Req'd	Ribbon Dope
235	-	As Req'd	ISO 32 Hydraulic Oil
236	N-H16-010-001	1	O-ring Plug

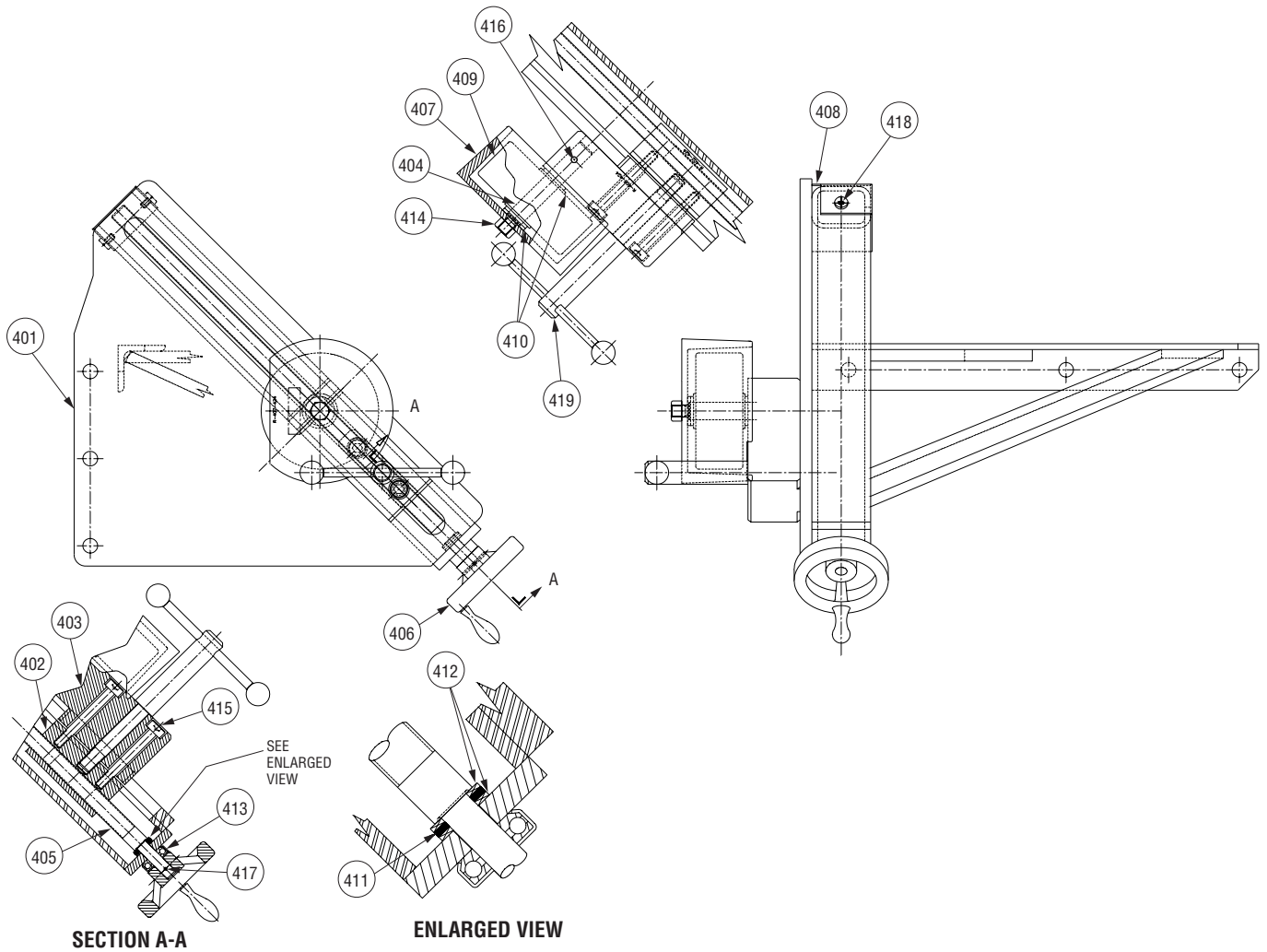
VE424 HYDRAULIC PANEL ASSEMBLY



Item #	Part #	Qty.	Description
251	R-201-424-VE0	1	Hydraulic Cylinder
252	N-H11-012-002	2	Bushing
253	R-203-424-VE0	1	Hydraulic Panel
254	N-H03-000-001	1	Gauge
255	N-H12-004-002	2	90° Elbow
256	N-H14-004-001	1	Female Tee
257	R-257-424-VE0	2	VE424 Hose Assembly

Item #	Part #	Qty.	Description
258	N-H16-004-001	2	Hex Hd. Plug
259	R-259-424-VE0	1	VE424 Hose Assembly
260	N-H14-004-002	2	Street Tee
261	N-H11-004-001	4	Male Connector
262	—	As Req'd	Ribbon Dope
263	N-H50-040-00F	2	Male Quick-Disconnect
264	N-H11-004-012	2	Coupler Quick-Disconnect

VE424 STABILIZER ASSEMBLY



Item #	Part #	Qty.	Description
401	R-401-424-PNT	1	Stabilizer Main Body
402	R-402-424-PLT	1	Stabilizer Guide Unit
403	R-403-424-PLT	1	Stabilizer Guide
404	R-404-424-MAC	1	Stabilizer Roller Shaft
405	R-405-424-MAC	1	Stabilizer Adjusting Screw
406	R-406-424-MAC	1	Stabilizer Hand Wheel
407	R-407-424-PNT	1	Stabilizer Roller Guard
408	R-408-424-PNT	1	Stabilizer Tube Cap
409	N-M05-000-002	1	Wheel, Polyurethane Tread 5 x 2 x 3/4
410	N-B05-075-004	3	Thrust Washer

Item #	Part #	Qty.	Description
411	N-B03-050-001	1	Thrust Bearing
412	N-B05-050-003	2	Thrust Washer
413	N-B03-050-002	1	Thrust Bearing
414	N-N02-080-000	1	1/2-20UNF Std. Hex Nut, Stl. Pltd.
415	N-S03-080-208	2	.50 Dia. x 2.50 Lg. Soc. Hd. Shoulder Screw, Blk. Ox.
416	N-P01-004-208	1	.25 Dia. x 2.50 Lg. Roll Pin
417	N-P01-002-104	1	.13 Dia. 1.25 Lg. Roll Pin
418	N-S06-040-006	2	1/4-20UNC x .38 Lg. Pan Hd. Phillips Screw
419	R-419-424-PLT	1	Stabilizer Locking Handle

NOTICE

- Victaulic has updated the electrical assembly for the model VE424. The tables below show the Victaulic part numbers for both the original and updated fuses and thermal units. Refer to the tool's electric schematic for complete information.
- It is important to determine if you have the updated Cutler-Hammer assembly or the original Square D assembly.
 - a) Tools that are updated with the new electrical assembly contain an "R" on the "specifications" label, shown below.
- If you need additional information concerning the tool's electrical assembly, contact the Victaulic Tool Company.

UPDATED (CUTLER-HAMMER)


FUSES (220 VOLT)			FUSES (380 VOLT)			FUSES (440 VOLT)		
MOTOR	BUSS NO.	PART NUMBER	MOTOR	BUSS NO.	PART NUMBER	MOTOR	BUSS NO.	PART NUMBER
5 HP	FNM 25	N-E13-000-009	5 HP	FNQ 15	N-E13-000-002	5 HP	FNQ 15	N-E13-000-002
1/2 HP	FNM 4	N-E13-000-010	1/2 HP	FNQ 2	N-E13-000-006	1/2 HP	FNQ 2	N-E13-000-006
THERMAL UNITS			THERMAL UNITS			THERMAL UNITS		
MOTOR	C-H NO.	PART NUMBER	MOTOR	C-H NO.	PART NUMBER	MOTOR	C-H NO.	PART NUMBER
5 HP	H-2012 B	N-E11-000-015	5 HP	H-2010 B	N-E11-000-017	5 HP	H-2011B	N-E11-000-019
1/2 HP	H-2006 B	N-E11-000-020	1/2 HP	H-2004 B	N-E11-000-018	1/2 HP	H-2004 B	N-E11-000-018

ORIGINAL (SQUARE D)

FUSES (220 VOLT)			FUSES (380 VOLT)			FUSES (440 VOLT)		
MOTOR	BUSS NO.	PART NUMBER	MOTOR	BUSS NO.	PART NUMBER	MOTOR	BUSS NO.	PART NUMBER
5 HP	FNQ 30	N-E13-000-001	5 HP	FNQ 20	N-E13-000-007	5 HP	FNQ 15	N-E13-000-002
1/2 HP	FNQ 5	N-E13-000-003	1/2 HP	FNQ 3	N-E13-000-008	1/2 HP	FNQ 2.5	N-E13-000-014
THERMAL UNITS			THERMAL UNITS			THERMAL UNITS		
MOTOR	SQUARE D NO.	PART NUMBER	MOTOR	SQUARE D NO.	PART NUMBER	MOTOR	SQUARE D NO.	PART NUMBER
5 HP	B 25	N-E11-000-006	5 HP	B 12.8	N-E11-000-009	5 HP	B 11.5	N-E11-000-007
1/2 HP	B 3.7	N-E11-000-004	1/2 HP	B 1.67	N-E11-000-021	1/2 HP	B 1.88	N-E11-000-003

The "specifications" label, shown below, details the information concerning the tool's operating voltage, full-load current, and power supply phase. This label is affixed to the inside face of the cabinet door. Refer

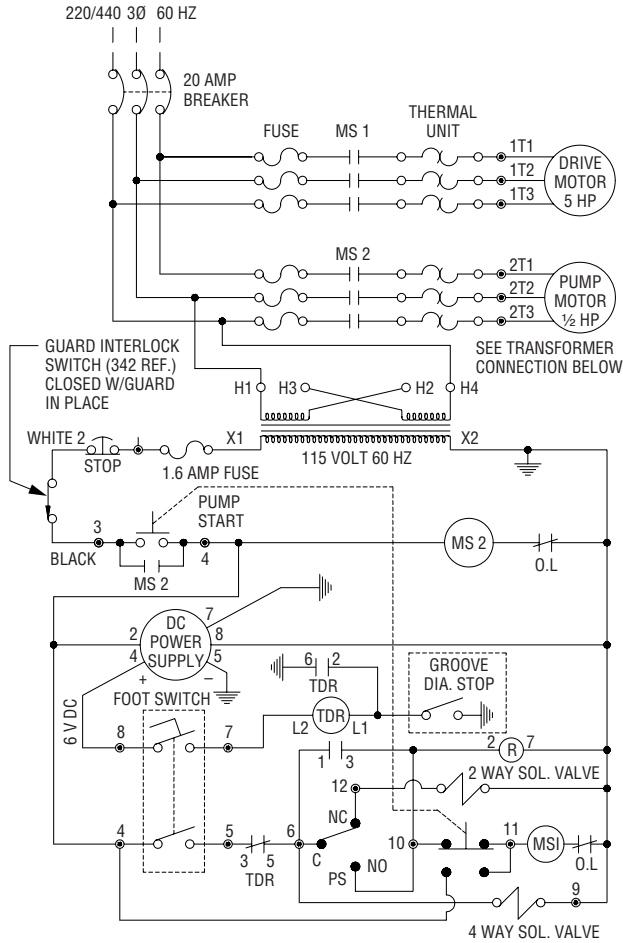
to the "Power Hookup" section of the operating and maintenance manual for additional information.

MODEL					R024-268LBL
SERIAL NUMBER					
VOLTS	PHASE	HERTZ	FULL-LOAD CURRENT		
208/230	1	50 Hz	AMPS AT 230 VOLTS		
440/460	3	60 Hz	AMPS AT 460 VOLTS		
380/400		50/60 Hz	AMPS AT 380 VOLTS		
<ul style="list-style-type: none"> • GEAR OIL – AGMA 7 • HYDRAULIC OIL – HIGH-PRESSURE, ANTI-WEAR ISO GRADE 32 • BEARING LUBE – ANTI-WEAR, EXTREME PRESSURE NLGI GRADE 2 			Electrical Assembly		
			Drawing Revision Level		

3359 Rev.A 11/01

ORIGINAL VE424 ELECTRICAL ASSEMBLY

NOTE: Refer to drawing on page 10.

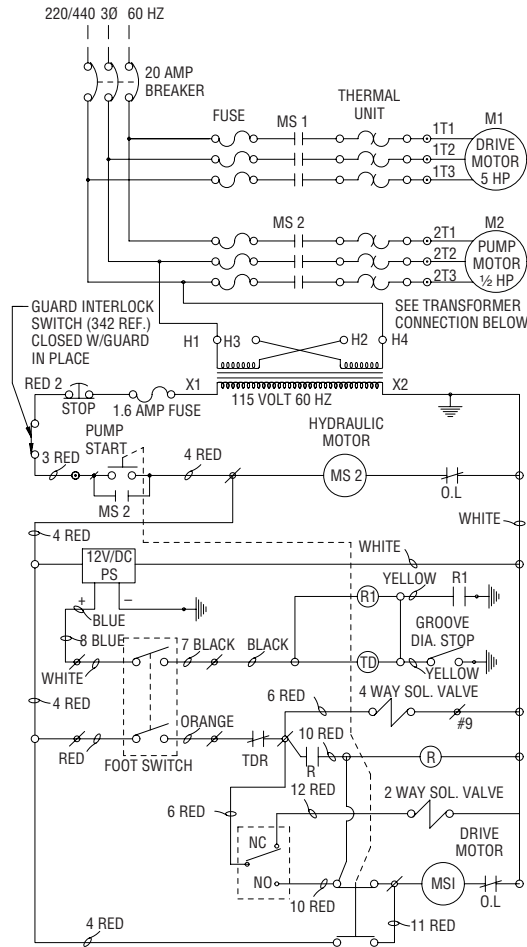


TRANSFORMER CONNECTIONS					
220 VOLT 220 V 230 V 240 V			440 VOLT 440 V 450 V 480 V		
FUSES			FUSES		
MOTOR	BUSS NO.	PART NO.	MOTOR	BUSS NO.	PART NO.
5 HP	FNQ 30	NE13000001	5 HP	FNQ 15	NE13000002
1/2 HP	FNQ 5	NE13000003	1/2 HP	FNQ 2.5	NE13000004
THERMAL UNITS			THERMAL UNITS		
MOTOR	SQ. D NO.	PART NO.	MOTOR	SQ. D NO.	PART NO.
5 HP	B 25	NE11000006	5 HP	B 11.50	NE11000005
1/2 HP	B 3.70	NE11000004	1/2 HP	B 1.88	NE11000003
5 HP MOTOR, WIRE FOR LOW VOLTAGE PER MOTOR NAME-PLATE TO PRODUCE CLOCK-WISE ROTATION OF TOOL'S LOWER SHAFT.			5 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAME-PLATE TO PRODUCE CLOCK-WISE ROTATION OF TOOL'S LOWER SHAFT.		
1/2 HP MOTOR, WIRE FOR LOW VOLTAGE PER MOTOR NAME-PLATE TO PRODUCE DOWNWARD MOVEMENT OF UPPER ROLL WHEN FOOTSWITCH IS PRESSED.			1/2 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAME-PLATE TO PRODUCE DOWNWARD MOVEMENT OF UPPER ROLL WHEN FOOTSWITCH IS PRESSED.		

Item #	Part #	Qty.	Description
401	R-401-424-PNT	1	Stabilizer Main Body
402	R-402-424-PLT	1	Stabilizer Guide Unit
403	R-403-424-PLT	1	Stabilizer Guide
404	R-404-424-MAC	1	Stabilizer Roller Shaft
405	R-405-424-MAC	1	Stabilizer Adjusting Screw
406	R-406-424-MAC	1	Stabilizer Hand Wheel
407	R-407-424-PNT	1	Stabilizer Roller Guard
408	R-408-424-PNT	1	Stabilizer Tube Cap
409	N-M05-000-002	1	Wheel, Polyurethane Tread 5 x 2 x 3/4
410	N-B05-075-004	3	Thrust Washer

Item #	Part #	Qty.	Description
411	N-B03-050-001	1	Thrust Bearing
412	N-B05-050-003	2	Thrust Washer
413	N-B03-050-002	1	Thrust Bearing
414	N-N02-080-000	1	1/2-20UNF Std. Hex Nut, Stl. Pltd.
415	N-S03-080-208	2	.50 Dia. x 2.50 Lg. Soc. Hd. Shoulder Screw, Blk. Ox.
416	N-P01-004-208	1	.25 Dia. x 2.50 Lg. Roll Pin
417	N-P01-002-104	1	.13 Dia. 1.25 Lg. Roll Pin
418	N-S06-040-006	2	1/4-20UNC x .38 Lg. Pan Hd. Phillips Screw
419	R-419-424-PLT	1	Stabilizer Locking Handle

UPDATED VE424 ELECTRICAL ASSEMBLY



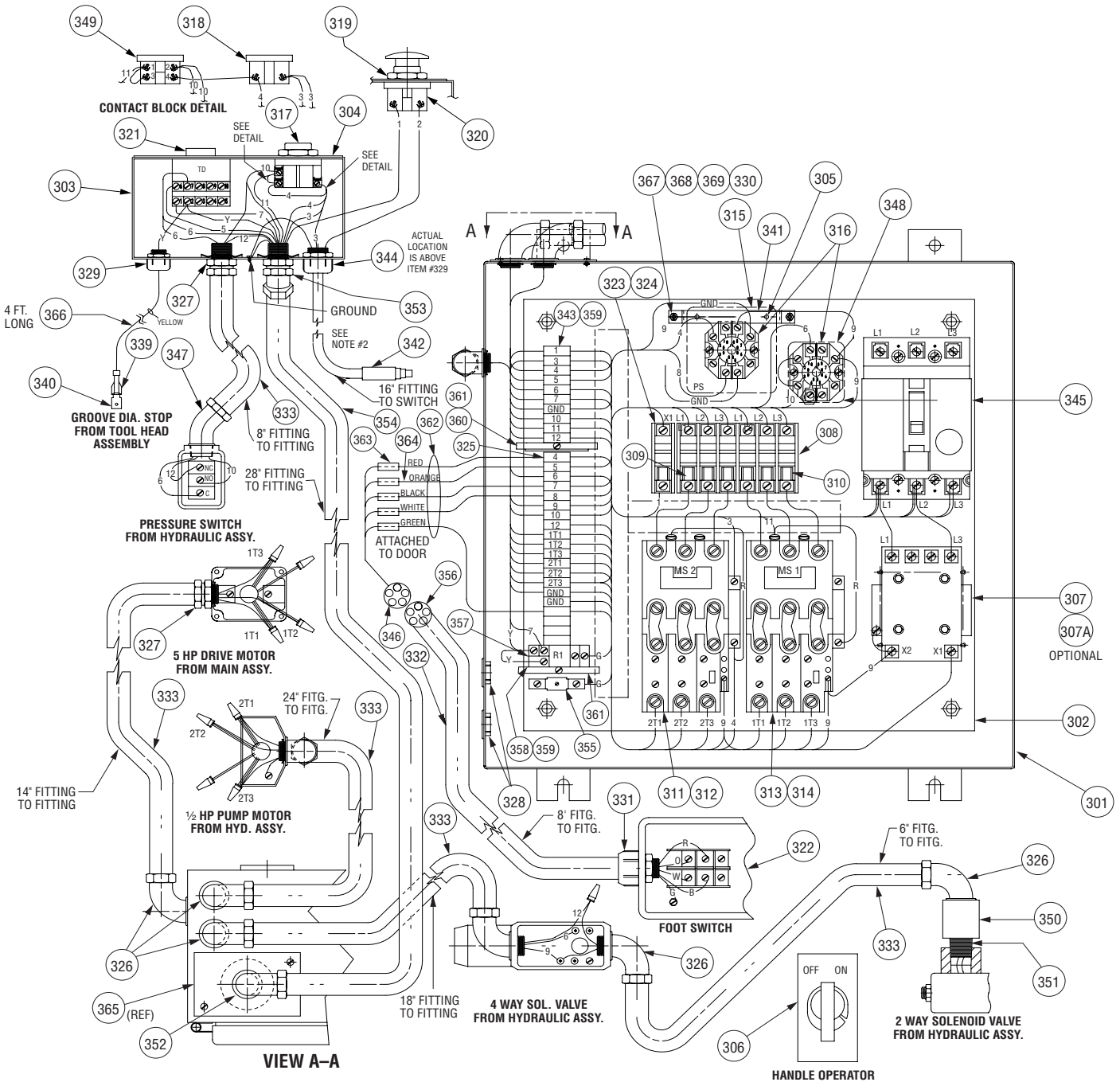
TRANSFORMER CONNECTIONS								
220 VOLT 220 V 230 V 240 V			440 VOLT 440 V 450 V 480 V			380VOLT 207V 277V 380V		
FUSES			FUSES			FUSES		
MOTOR	BUSS NO.	PART NO.	MOTOR	BUSS NO.	PART NO.	MOTOR	BUSS NO.	PART NO.
5 HP	FNM 25	NE13000009	5 HP	FNQ 15	NE13000002	5 HP	FNQ 15	NE13000002
1/2 HP	FNM 4	NE13000010	1/2 HP	FNQ 2	NE13000006	1/2 HP	FNQ 2	NE13000006
THERMAL UNITS			THERMAL UNITS			THERMAL UNITS		
MOTOR	C-H NO.	PART NO.	MOTOR	C-H NO.	PART NO.	MOTOR	C-H NO.	PART NO.
5 HP	H-2012 B	NE11000015	5 HP	H-2010 B	NE11000017	5 HP	H-2011 B	NE11000019
1/2 HP	H-2006 B	NE11000020	1/2 HP	H-2004-B	NE11000018	1/2 HP	H-2004 B	NE11000018
5 HP MOTOR, WIRE FOR LOW VOLTAGE PER MOTOR NAMEPLATE TO PRODUCE CLOCKWISE ROTATION OF TOOL'S LOWER SHAFT.			5 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAMEPLATE TO PRODUCE CLOCKWISE ROTATION OF TOOL'S LOWER SHAFT.			5 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAMEPLATE TO PRODUCE CLOCKWISE ROTATION OF TOOL'S LOWER SHAFT.		
1/2 HP MOTOR, WIRE FOR LOW VOLTAGE PER MOTOR NAMEPLATE TO PRODUCE DOWNWARD MOVEMENT OF UPPER ROLL WHEN FOOTSWITCH IS PRESSED.			1/2 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAMEPLATE TO PRODUCE DOWNWARD MOVEMENT OF UPPER ROLL WHEN FOOTSWITCH IS PRESSED.			1/2 HP MOTOR, WIRE FOR HIGH VOLTAGE PER MOTOR NAMEPLATE TO PRODUCE DOWNWARD MOVEMENT OF UPPER ROLL WHEN FOOTSWITCH IS PRESSED.		

Item #	Part #	Qty.	Description
301	R-301-424-PNT	1	Main Electrical Enclosure
302	R-302-424-MAC	1	Main Enclosure Panel
303	R-303-424-VE0	1	VE424 Control Station Enclosure
304	R-814-436-LBL	1	Control Station Plate
305	N-S07-006-004	2	#6-32UNC x .25 Lg. Slotted Rnd. Hd. Mach. Screw, Pltd.
306	N-E90-000-001	1	Handle Oper. Mech.
307	N-E10-000-001	1	Transformer
307A	N-E10-000-007	1	Transformer
308	N-E12-000-003	2	Fuse Holder
309	—	3	Fuse Buss (See Notes)
310	—	3	Fuse Buss (See Notes)
311	N-E11-000-001	1	Magnetic Starter
312	—	3	Thermal Unit (See Notes)
313	N-E11-000-002	1	Magnetic Starter
314	—	3	Thermal Unit (See Notes)
315	N-E16-000-001	1	Power Supply
316	N-E12-000-001	2	Relay Socket
317	N-E02-000-001	1	Push Button Operator
318	N-E02-000-004	1	Contact Block
319	N-E02-000-010	1	Push Button Operator
320	N-E02-000-005	1	Contact Block
321	N-E09-000-004	1	Time Delay Relay
322	N-E03-000-003	1	Foot Switch
323	N-E14-000-002	1	Fuse Holder
324	N-E13-000-005	1	Fuse Buss
325	N-E05-000-004	20pt	Track Mtd. Contact
326	N-E06-000-002	7	Connector
327	N-E06-000-003	2	Connector
328	N-E90-000-002	2	Knock-Out Bushing

Item #	Part #	Qty.	Description
329	N-E06-000-004	1	Strain Relief
330	N-S04-008-102	2	#8-32UNC x 1.13 Lg. Slotted Rnd. Hd. Mach. Screw, Pltd.
331	N-E06-000-006	1	Straight Liquid Tight Strain Relief Connector
332	N-E04-000-002	8ft. Fit to Fit	Multiconductor Cable 18/5
333	—	75"	1/2" Plastic Extra Flex
334	—	As Req'd	12 Ga. Black MTW (Line Voltage Circuits)
335	—	As Req'd	16 Ga. Red MTW (AC Control Circuits)
336	—	As Req'd	16 Ga. White MTW (Neutral)
337	—	As Req'd	16 Ga. Blue MTW (DC Control Circuits)
338	—	As Req'd	12 Ga. Green MTW (Ground)
339	N-E05-000-003	1	Female Disconnect
340	N-E05-000-002	1	Male Tab
341A	R-310-424-MCH	1	Power Supply Mounting Bracket
341B	R-341-424-MAC	1	Alternate Power Supply Mounting Bracket
342	N-E02-000-006	1	Switch
343	N-E05-000-005	1	Fanning Strip Terminal
344	N-E06-000-001	1	St. Strain Relief
345	N-E15-000-001	1	Circuit Breaker
346	N-E19-000-002	1	Receiver
347	N-E06-000-036	1	1/2" 45° Liquid Tight Connector
348	N-E09-000-001	1	Relay
349	N-E02-000-003	1	Contact Block
350	N-E06-000-037	1	1/2" Coupling

Continued on page 12.

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Item #	Part #	Qty.	Description
351	N-E06-000-038	1	1/2" Close Nipple
352	N-E06-000-039	1	3/4" 90° Connector
353	N-E06-000-045	1	3/4" 45° Connector
354	—	30"	3/4" Plastic Extra Flex
355	N-E06-000-014	2	Grounding Clamps
356	N-E08-000-001	1	Male Plug
357	N-E09-000-003	1	12V DC Relay
358	N-E12-000-003	1	Relay Socket
359	N-E05-000-008	1	Terminal Plug
360	—	1	Track Mounted Contact End

Item #	Part #	Qty.	Description
361	—	2	Track Mounted Contact End Clamp
362	—	24"	Spiral Wrap
363	—	5	Crimp on Lug
364	—	As Req'd	16 Ga. Orange MTW (AC Control Circuits)
365	R-301-424-PNT	Ref.	Cover Plate
366	—	As Req'd	12 Ga. Yellow MTW (Interrupted Ground)
367	N-N01-008-000	2	#8-32 UNC Hex Nut, Pltd.
368	N-W01-008-000	2	#8 Flat Washer, Pltd.
369	—	2	Stand-Offs, 1/4" Mech. Tubing, .63 Lg.

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