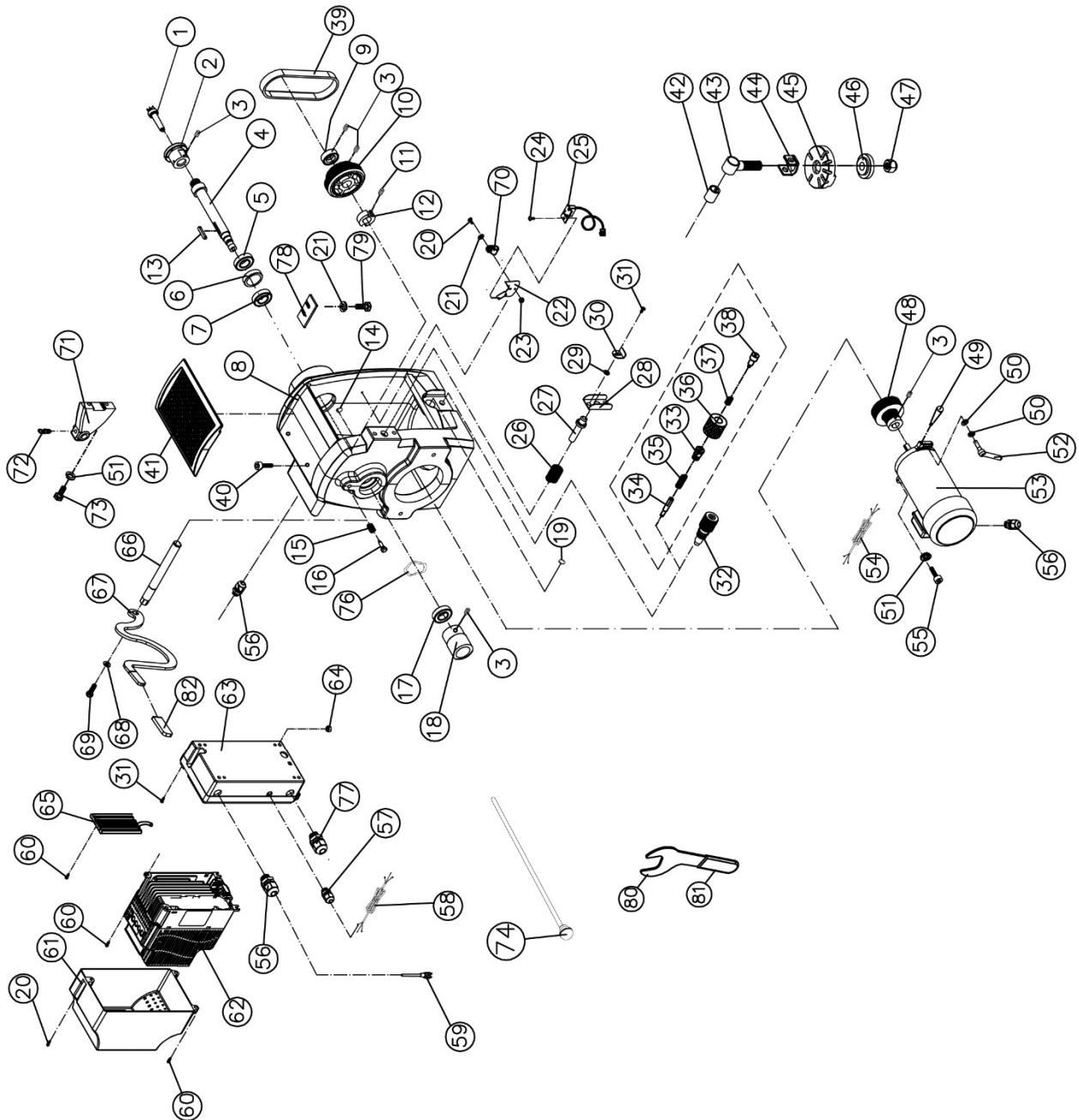


### 14.1.1.1 JWL-1640EVS Headstock Assembly – Exploded View

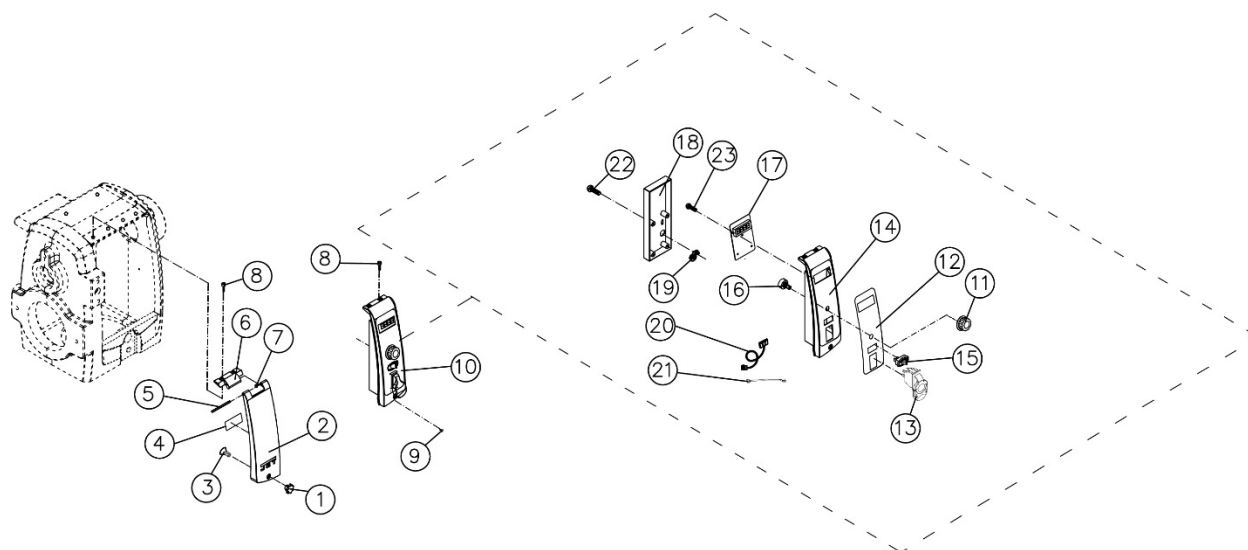


### 14.1.2 JWL-1640EVS Headstock Assembly – Parts List

| Index No. | Part No.       | Description                               | Size          | Qty |
|-----------|----------------|-------------------------------------------|---------------|-----|
| 1         | JWL1642-102    | Spur Center                               | MT2           | 1   |
| 2         | 6294736        | Faceplate                                 | 3"            | 1   |
| 3         | 6295796        | Nylon Insert Socket Set Screw             | 1/4-20x3/8"   | 10  |
| 4         | JWL1640EVS-104 | Spindle                                   |               | 1   |
| 5         | BB-6207VV      | Bearing                                   | 6207-LLB      | 1   |
| 6         | 3520B-208      | Bushing                                   |               | 1   |
| 7         | BB-6207ZZ      | Bearing                                   | 6207ZZ        | 1   |
| 8         | JWL1640EVS-108 | Headstock Casting                         |               | 1   |
| 9         | JWL1640EVS-109 | Sensor Collar                             |               | 1   |
| 10        | JWL1640EVS-110 | Spindle Pulley                            |               | 1   |
| 11        | TS-0270031     | Set Screw                                 | 5/16"-18x3/8" | 2   |
| 12        | JWL1642-174    | Locking Collar                            |               | 1   |
| 13        | JWL1640EVS-113 | Key                                       | 8 x 8 x 80    | 1   |
| 14        | JWL1640EVS-114 | C-Ring                                    | S-8           | 1   |
| 15        | JWL1640EVS-115 | Spring                                    |               | 1   |
| 16        | JWL1640EVS-116 | Index Pin                                 |               | 1   |
| 17        | BB-6205ZZ      | Bearing                                   | 6205ZZ        | 1   |
| 18        | JWL1640EVS-118 | Handwheel                                 |               | 1   |
| 19        | JWL1640EVS-119 | C-Ring                                    | S-19          | 2   |
| 20        | TS-081C052     | Pan Head Screw                            | #10-24x3/4"   | 4   |
| 21        | TS-069204      | Flat Washer                               | #10           | 2   |
| 22        | JWL1640EVS-122 | Cover for Sensor                          |               | 1   |
| 23        | TS-0560071     | Hex Nut                                   | #10-24        | 3   |
| 24        | TS-2283102     | Pan Head Screw                            | M3x10         | 2   |
| 25        | JWL1640EVS-125 | Sensor for Spindle                        |               | 1   |
| 26        | JWL1442-116    | Spring                                    |               | 1   |
| 27        | JWL1640EVS-127 | Spindle Lock Pin                          |               | 1   |
| 28        | JWL1442-121    | Bracket                                   |               | 1   |
| 29        | 4224B-143      | Resist Washer                             |               | 1   |
| 30        | 4224B-1122E    | Sliding Plate                             |               | 1   |
| 31        | TS-0253031     | Socket Head Button Screw                  | #10-24x1/2"   | 6   |
| 32        | JWL1640EVS-PPA | Pivot Pin Assembly (includes #33 thru 38) |               | 1   |
| 33        | JWL1442-176    | Index Bushing                             |               | 1   |
| 34        | JWL1640EVS-134 | Pivot Index Pin                           |               | 1   |
| 35        | JWL1442-175    | Spring                                    |               | 1   |
| 36        | JWL1442-173    | Index Knob                                |               | 1   |
| 37        | JWL1442-172    | Spring                                    |               | 1   |
| 38        | JWL1440-177    | Socket Head Cap Screw                     |               | 1   |
| 39        | JWL1640EVS-139 | Belt                                      | 208J-8        | 1   |
| 40        | JWL1640EVS-140 | Socket Head Cap Screw                     | 10#-24x1/4"   | 2   |
| 41        | JWL1640EVS-141 | Cushion                                   |               | 1   |
| 42        | JWL1442-127    | Bushing                                   |               | 1   |
| 43        | JWL1442-128A   | Bolt                                      |               | 1   |
| 44        | JWL1442-129    | Support Bracket                           |               | 1   |
| 45        | JWL1440-133    | Index Bracket                             |               | 1   |
| 46        | JWL1442-154    | Clamp                                     |               | 1   |
| 47        | TS-0650081     | Nylon Nut                                 | 3/4"-10       | 1   |
| 48        | JWL1640EVS-148 | Motor Pulley                              |               | 1   |
| 49        | 4224B-165      | Handle                                    |               | 1   |
| 50        | TS-0680041     | Flat Washer                               | 3/8"          | 2   |
| 51        | TS-0720091     | Lock Washer                               | 3/8"          | 3   |
| 52        | 6350031        | Lock Handle                               |               | 1   |
| 53        | JWL1640EVS-153 | Motor                                     |               | 1   |
| 54        | JWL1642-172    | Motor Cord                                |               | 1   |
| 55        | TS-0209051     | Socket Head Cap Screw                     | 3/8"-16x1"    | 1   |
| 56        | JWL1440-141    | Strain Relief                             | M16           | 3   |
| 57        | JML-70E        | Strain Relief                             | PG9           | 1   |
| 58        | JWL1640EVS-158 | Signal Cord                               |               | 1   |
| 59        | JWL1640EVS-159 | Power Cord                                |               | 1   |
| 60        | JWL1640EVS-160 | Pan Head Screw                            | #10 - 24 x1"  | 8   |

| Index No. | Part No.       | Description                                     | Size             | Qty |
|-----------|----------------|-------------------------------------------------|------------------|-----|
| 61        | JWL1640EVS-161 | Inverter Upper Cover                            |                  | 1   |
| 62        | JWL1640EVS-162 | Inverter                                        | VFD007E11A       | 1   |
| 63        | JWL1640EVS-163 | Inverter Lower Box                              |                  | 1   |
| 64        | TS-0560071     | Hex Nut                                         | #10-24           | 7   |
| 65        | JWL1642-169    | Braking Resistor                                |                  | 1   |
| 66        | JWL1640EVS-166 | Eccentric Rod                                   |                  | 1   |
| 67        | JWL1640EVS-167 | Handle with Rubber Grip (includes #82)          |                  | 1   |
| 68        | TS-0680042     | Flat Washer                                     | 3/8"             | 1   |
| 69        | TS-0209011     | Socket Head Cap Screw                           | 3/8"-16x1/2"     | 1   |
| 70        | JWL1642-183    | Clamp                                           |                  | 2   |
| 71        | JWL1640EVS-171 | Safety Guard Bracket                            |                  | 1   |
| 72        | 6644005        | Plunger                                         |                  | 1   |
| 73        | JWL1640EVS-173 | Hex Bolt                                        | 3/8"-16 x 1-3/8" | 2   |
| 74        | JWL1442-164    | Knock Out Rod                                   |                  | 1   |
| 76        | JWL1442-108    | Wave Washer                                     |                  | 1   |
| 77        | JWL1642-196E   | Strain Relief                                   | PG 13.5          | 1   |
| 78        | JWL1640EVS-178 | Plate                                           |                  | 1   |
| 79        | TS-0206041     | Socket Head Cap Screw                           | #10-24x 3/4"     | 2   |
| 80        | JWL1221VS-269E | Wrench (includes #81)                           |                  | 1   |
| 81        | JWL1221VS-270  | Rubber Grip                                     |                  | 1   |
| 82        | JWL1640EVS-182 | Rubber Grip                                     |                  | 1   |
|           | LM000172       | Caution Label – Anti-rotation Block (not shown) |                  | 1   |

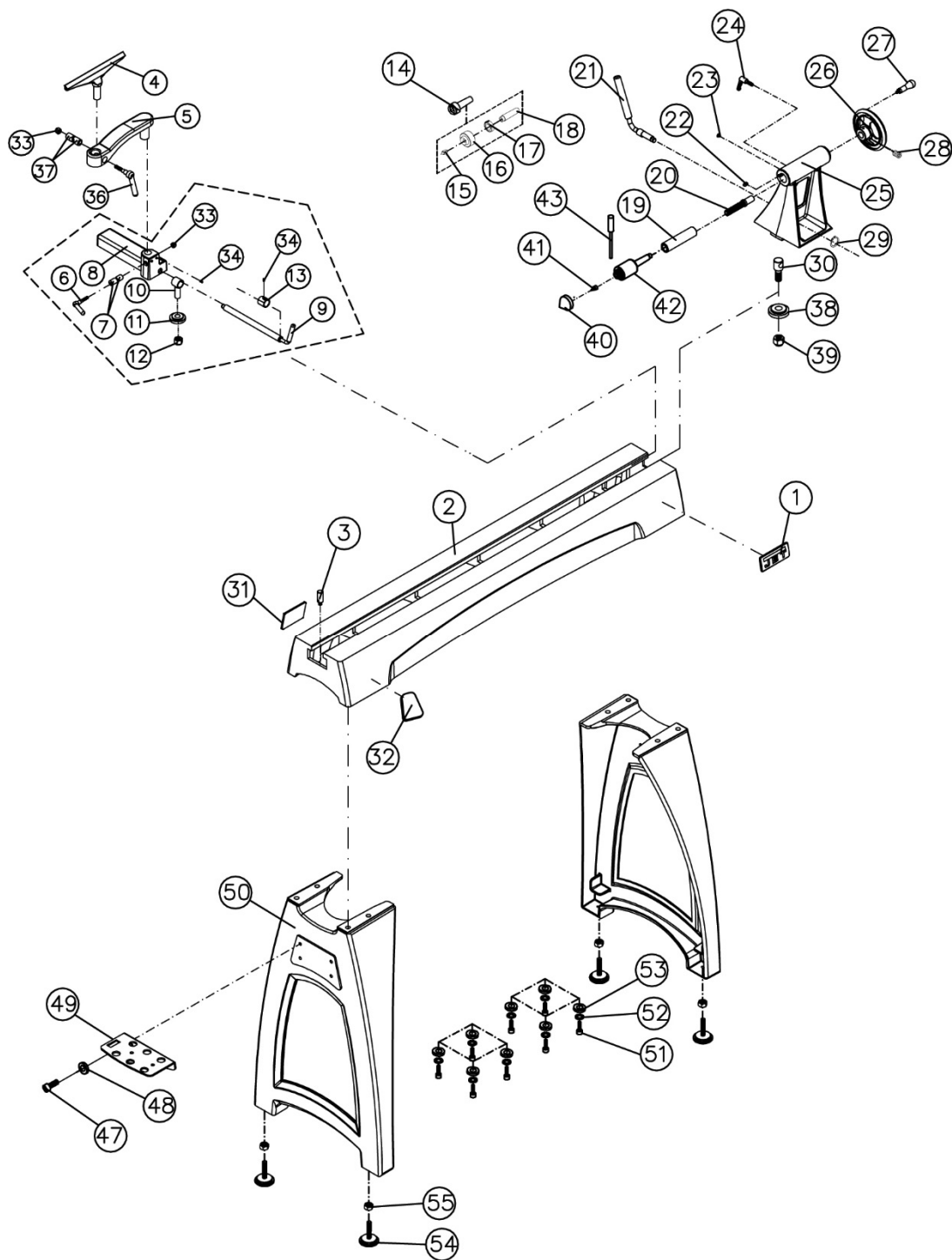
### 14.2.1 JWL-1640EVS Controller Assembly – Exploded View



### 14.2.2 JWL-1640EVS Controller Assembly – Parts List

| Index No. | Part No.       | Description                                  | Size        | Qty |
|-----------|----------------|----------------------------------------------|-------------|-----|
| 1         | JWL1640EVS-201 | Knob                                         |             | 1   |
| 2         | JWL1640EVS-202 | Access Door (With Magnets)                   |             | 1   |
| 3         | TS-2248252     | Socket Head Button Screw                     | M8-1.25Px25 | 1   |
| 4         | LM000171       | Speed Label                                  |             | 1   |
| 5         | JWL1640EVS-205 | Pin                                          |             | 1   |
| 6         | JWL1640EVS-206 | Hinge                                        |             | 1   |
| 7         | JWL1640EVS-207 | O- Ring                                      |             | 1   |
| 8         | TS-0253031     | Socket Head Button Screw                     | #10-24x1/2" | 4   |
| 9         | JWL1640EVS-160 | Pan Head Screw                               | #10-24x1"   | 1   |
| 10        | JWL1640EVS-CA  | Controller Assembly (includes #11 thru 23)   |             | 1   |
| 11        | JWL1642-143    | Variable Speed Knob                          |             | 1   |
| 12        | LM000066       | Control Panel Label                          |             | 1   |
| 13        | JWL1640EVS-213 | Main Switch                                  |             | 1   |
| 14        | JWL1640EVS-214 | Control Front Cover (includes #12)           |             | 1   |
| 15        | 4224B-148      | Switch Fwd/Rev                               |             | 1   |
| 16        | 6295915        | Control Pot Assembly                         |             | 1   |
| 17        | JWL1640EVS-217 | PC Board                                     |             | 1   |
| 18        | JWL1640EVS-218 | Back Box                                     |             | 1   |
| 19        | JWL1221VS-320  | Strain Relief                                |             | 1   |
| 20        | JWL1640EVS-220 | Signal Cord (inverter to control box)        |             | 1   |
| 21        | JWL1640EVS-221 | Connection Cord (Spindle Sensor to PC board) |             | 1   |
| 22        | TS-2284082     | Machine Screw                                | M4x8        | 4   |
| 23        | TS-2171012     | Machine Screw                                | M4x6        | 4   |

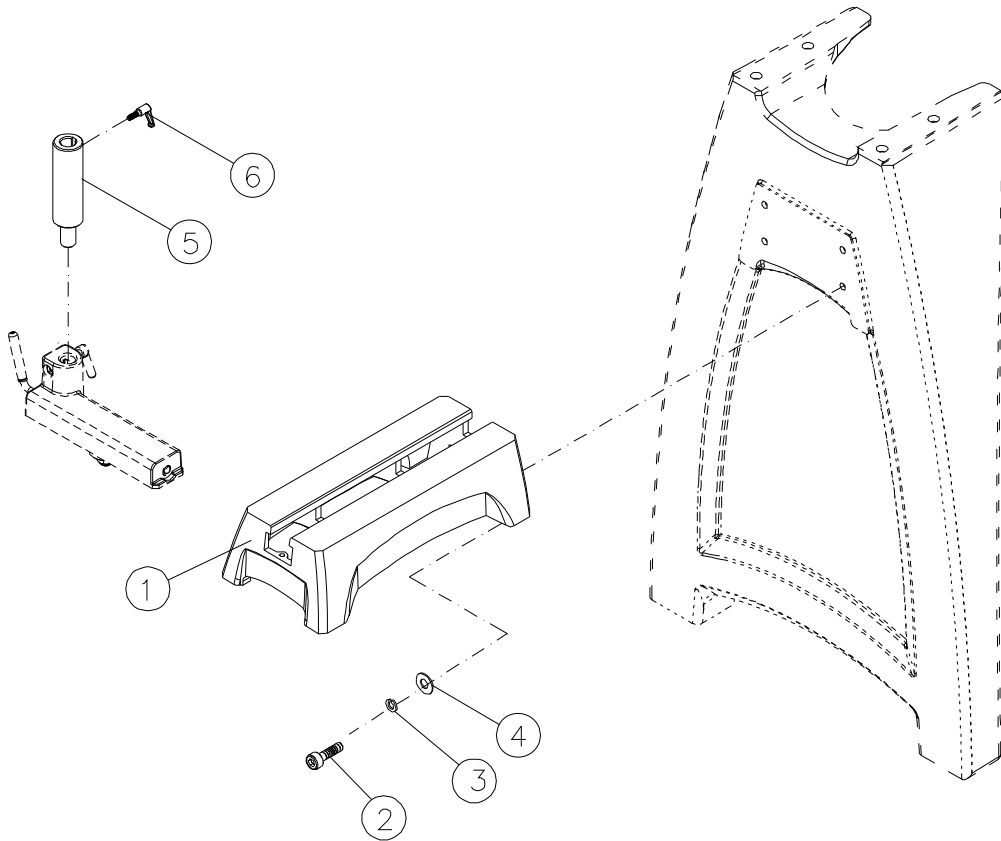
### 14.3.1 JWL-1640EVS Bed and Stand Assemblies – Exploded View



### 14.3.2 JWL-1640EVS Bed and Stand Assembly – Parts List

| Index No. | Part No.       | Description                                           | Size            | Qty |
|-----------|----------------|-------------------------------------------------------|-----------------|-----|
| 1         | JET-113        | JET Logo                                              | 113 x 47 mm     | 1   |
| 2         | JWL1440-202    | Bed                                                   |                 | 1   |
| 3         | JWL1440-203    | Stud                                                  |                 | 2   |
| 4         | JWL1642-211    | Tool Rest                                             | 14"             | 1   |
| 5         | JWL1440-205    | Tool Rest Extension                                   |                 | 1   |
|           | JWL1440-TBA    | Tool Rest Base Assembly (includes #6 thru 13, 33, 34) |                 | 1   |
| 6         | JWL1440-206    | Handle                                                |                 | 1   |
| 7         | JWL1440-207    | Tool Rest Lock Bushing Set                            |                 | 1   |
| 8         | JWL1440-208    | Tool Rest Base                                        |                 | 1   |
| 9         | JWL1442-210A   | Tool Support Rod                                      |                 | 1   |
| 10        | JWL1442-128    | Clamp Bolt                                            |                 | 1   |
| 11        | JWL1442-154    | Clamp                                                 |                 | 1   |
| 12        | TS-0650081     | Hex Nylon Lock Nut                                    | 3/4"-10         | 1   |
| 13        | JWL1440-213    | Bushing                                               |                 | 1   |
| 14        | 708331         | Live Center Assembly (includes #15 thru 18)           |                 | 1   |
| 15        | JML-52A        | Center Point for Live Center                          |                 | 1   |
| 16        | JML-52         | Live Center Head                                      |                 | 1   |
| 17        | BB-6002ZZ      | Ball Bearing                                          | 6002ZZ          | 1   |
| 18        | JML-54         | Live Center Shaft                                     |                 | 1   |
|           | JWL1640EVS-TA  | Tailstock Assembly (includes #19 thru 30, 38, 39)     |                 | 1   |
| 19        | JWL1640EVS-319 | Quill                                                 | MT-2            | 1   |
| 20        | JWL1640EVS-320 | Lead Screw                                            |                 | 1   |
| 21        | JWL1440-221    | Tailstock Rod                                         |                 | 1   |
| 22        | JWL1221VS-227  | Key                                                   |                 | 1   |
| 23        | F009674        | Socket Head Button Screw                              | #10-32x5/8"     | 1   |
| 24        | JML-59A        | Tailstock Lock Handle                                 |                 | 1   |
| 25        | JWL1640EVS-325 | Tailstock Casting                                     |                 | 1   |
| 26        | JWL1440-226    | Handwheel                                             |                 | 1   |
| 27        | JWL1442-211    | Handle                                                |                 | 1   |
| 28        | TS-0267041     | Set Screw                                             | 1/4"-20x 3/8"   | 2   |
| 29        | JWL1440-229    | C-Ring                                                | S-12            | 1   |
| 30        | JWL1440-230    | Bolt                                                  |                 | 1   |
| 31        | LM000170       | ID Label                                              |                 | 1   |
| 32        | JWL1221VS-211  | Warning Label                                         |                 | 1   |
| 33        | TS-0570031     | Hex Nut                                               | 3/8"-16         | 2   |
| 34        | TS-0267021     | Set Screw                                             | 1/4"-20x1/4"    | 4   |
| 36        | JWL1440-206    | Handle                                                |                 | 1   |
| 37        | JWL1440-207    | Tool Rest Lock Bushing Set                            |                 | 1   |
| 38        | JWL1442-154    | Clamp                                                 |                 | 1   |
| 39        | TS-0650081     | Hex Nylon Lock Nut                                    | 3/4"-10         | 1   |
|           | 6295902        | Live Center Assembly (includes #40 thru 43)           |                 | 1   |
| 40        | 6295905        | Live Center Cone                                      |                 | 1   |
| 41        | 6295904        | Live Center Tip                                       |                 | 1   |
| 42        | 6295903        | Live Center Body                                      |                 | 1   |
| 43        | 6295906        | Live Center Rod                                       |                 | 1   |
| 47        | TS-0209061     | Socket Head Cap Screw                                 | 3/8"-16x1-1/4"  | 2   |
| 48        | TS-0680041     | Flat Washer                                           | 3/8"            | 2   |
| 49        | JWL1640EVS-349 | Tool Shelf                                            |                 | 1   |
| 50        | JWL1440-401    | Leg                                                   |                 | 2   |
| 51        | TS-0208071     | Socket Head Cap Screw                                 | 5/16"-18x1-1/4" | 8   |
| 52        | TS-0720081     | Lock Washer                                           | 5/16"           | 8   |
| 53        | TS-0680031     | Flat Washer                                           | 5/16"           | 8   |
| 54        | JWL1642-206    | Adjustable Foot                                       | 3/8"            | 4   |
| 55        | TS-0561031     | Hex Nut                                               | 3/8"-16         | 4   |
|           | JWL1440-HP1    | Hardware Package (includes #51, 52, 53)               |                 |     |

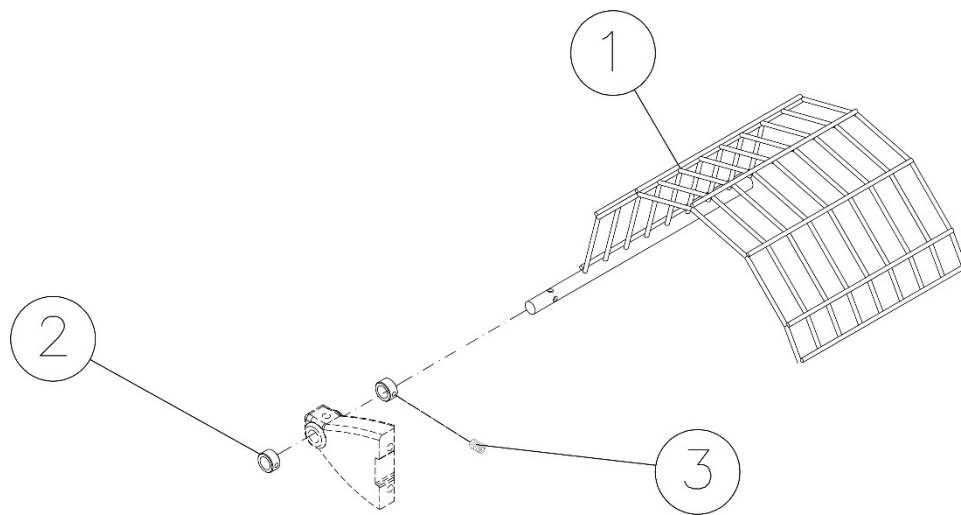
#### 14.4.1 JWL-1640EVS Extension Bed Assembly (OPTIONAL) – Exploded View



#### 14.4.2 JWL-1640EVS Extension Bed Assembly (OPTIONAL) – Parts List

| Index No. | Part No.    | Description                                    | Size           | Qty |
|-----------|-------------|------------------------------------------------|----------------|-----|
| .....     | 719401      | 20" Extension Bed w/ Post (includes #1 thru 6) |                | 1   |
| 1         | JWL1440-301 | Extension Bed                                  | 20"            | 1   |
| 2         | TS-0209071  | Socket Head Cap Screw                          | 3/8"-16x1-1/2" | 4   |
| 3         | TS-0720091  | Lock Washer                                    | 3/8"           | 4   |
| 4         | TS-0680041  | Flat Washer                                    | 3/8"           | 4   |
| 5         | 3520B-310   | Extension Post                                 |                | 1   |
| 6         | 6294763     | Locking Handle                                 |                | 1   |

### 14.5.1 JWL-1640EVS Guard Assembly (OPTIONAL) – Exploded View



### 14.5.2 JWL-1640EVS Guard Assembly (OPTIONAL) – Parts List

| Index No. | Part No.    | Description                               | Size            | Qty   |
|-----------|-------------|-------------------------------------------|-----------------|-------|
| .....     | 719002      | Lathe Guard Assembly (includes #1 thru 3) | .....           | ..... |
| 1         | JWL1642-179 | Guard                                     | .....           | 1     |
| 2         | JWL1642-187 | Collar                                    | .....           | 2     |
| 3         | TS-0270011  | Set Screw                                 | 5/16"-18 x 1/4" | 2     |



# 15.0 Electrical Connections for JWL-1640EVS

