



# Operating Instructions and Parts Manual Variable Speed Turret Mill

Model: JTM-1054R



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**Part No. M-690053**  
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# Warranty and Service

JET® warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

## Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

## Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

## What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

## Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

## How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

## More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

## How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

## Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

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## Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

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The specifications in this manual are given as general information and are not binding. JET, reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.

# Warnings

1. For your own safety read instruction manual before operating the variable speed turret mill.
2. Read and understand the entire owner's manual before attempting assembly or operation.
3. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
4. Replace the warning labels if they become obscured or removed.
5. This manual is intended to familiarize you with the technical aspects of this milling machine. It is not, nor is it intended to be, a training manual.
6. This mill is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a variable speed turret mill, do not use until proper training and knowledge have been obtained.
7. Do not use this mill for other than its intended use. If used for other purposes, JET, disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
8. Wear eye protection and always use guards and eye shields.
9. Always wear approved safety glasses/face shields while using this machine. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
10. Before operating the variable speed turret mill, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do **not** wear gloves.
11. Wear ear protectors (plugs or muffs) during extended periods of operation.
12. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
  - Lead from lead based paint.
  - Crystalline silica from bricks, cement and other masonry products.
  - Arsenic and chromium from chemically treated lumber.Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.
13. Some coolants used for machining contain chemicals that may be hazardous to your health if not used properly. Read and understand all user information listed on the coolant container and protect yourself accordingly.
14. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
15. Make certain the switch is in the **OFF** position before connecting the machine to the power supply.
16. Make certain the machine is properly grounded.
17. Make all machine adjustments or maintenance with the machine unplugged from the power source.
18. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
19. **KEEP GUARDS IN PLACE** and in working order at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
20. Make sure the variable speed turret mill is firmly secured before use.
21. Keep visitors a safe distance from the work area. **Keep children away.**



## Warnings

22. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
23. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
24. Provide for adequate space surrounding work area and non-glare, overhead lighting.
25. Make your workshop child proof with padlocks, master switches or by removing starter keys.
26. KEEP WORK AREA CLEAN. Cluttered areas and benches invite accidents. DON'T USE IN DANGEROUS ENVIRONMENT. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted. Keep the floor around the machine clean and free of scrap material, oil and grease.
27. Maintain a balanced stance at all times so that you do not fall or lean against the grinding wheels or other moving parts. Do not overreach or use excessive force to perform any machine operation.
28. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
29. DISCONNECT TOOLS before servicing; when changing accessories, such as blades, bits, cutters, and the like. Use recommended accessories. Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injury to persons. Improper accessories may be hazardous.
30. Frequently clean this machine. MAINTAIN TOOLS WITH CARE. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
31. Make sure the work piece is securely attached or clamped to the table. Never use your hand to hold the work piece.
32. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
33. Do not stand on the machine. Serious injury could occur if the machine tips over.
34. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
35. Remove loose items and unnecessary work pieces from the area before starting the machine.
35. DON'T FORCE TOOL. It will do the job better and safer at the rate for which it was designed.

**Familiarize yourself with the following safety notices used in this manual:**



This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.



This means that if precautions are not heeded, it may result in serious injury or possibly even death.

**- - SAVE THESE INSTRUCTIONS - -**

## Introduction

This manual is provided by JET, covering the safe operation and maintenance procedures for the JET JTM-1054R Variable Speed Turret Mill. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide consistent, long-term operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or JET. JET can also be reached at our web site: [www.jettools.com](http://www.jettools.com).

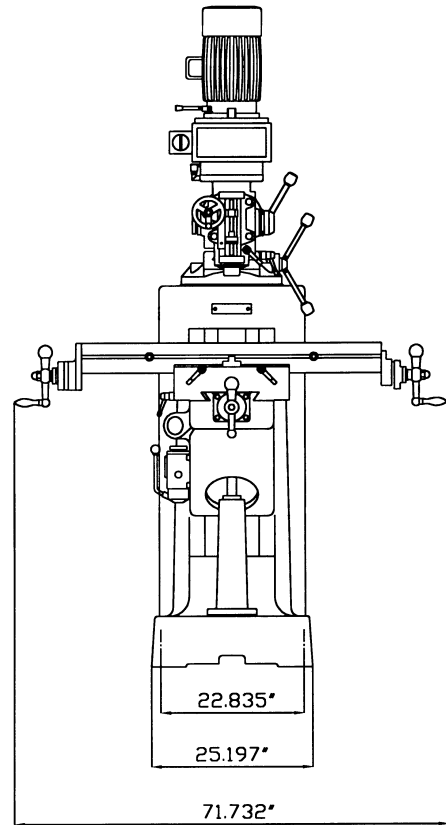
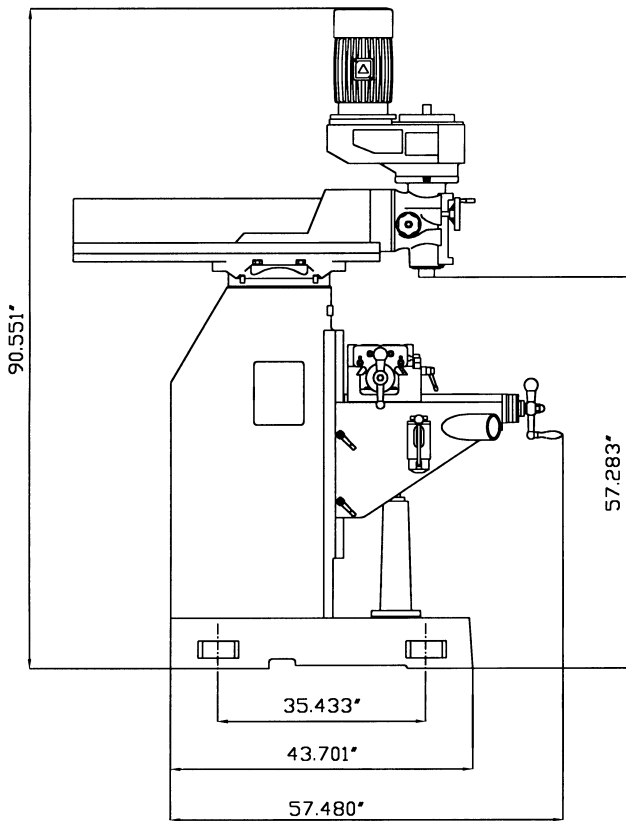
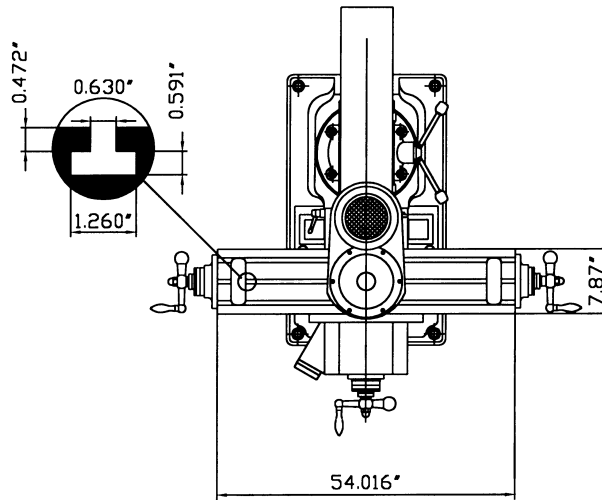
## Specifications

Model .....	JTM-1054R
Stock Number.....	690053
Spindle Taper.....	R-8
Diameter of Quill.....	3-3/8"
Number of Spindle Speeds .....	Variable
Range of Spindle Speeds .....	80 to 3800 RPM
Downfeeds per Revolution of Spindle .....	0.0015", 0.003", 0.006"
Spindle Travel .....	5"
Head Movement .....	90° L and R; 45° F and B
Turret Rotation .....	360°
Maximum Distance Spindle to Table.....	20"
Maximum Distance Spindle to Column.....	26"
Collet Capacity .....	1/8"-7/8"
Table Size .....	10" x 54"
Longitudinal Table Travel.....	32"
Table Cross Travel .....	16"
Number of T-Slots .....	3
Size of T-Slots.....	5/8"
T-slot Centers.....	2-1/2"
Maximum Table Load .....	800 lbs.
Knee Travel.....	17-1/2"
RAM Travel .....	20-1/2"
Overall Dimensions .....	108"W x 80"D x 92"H
Motor.....	5 HP, 3PH, 230/460V <b>prewired 230 Volt</b>
Net Weight (approx.).....	3,300 Lbs.

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

**⚠WARNING** Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury

# JTM-1054R Layout



## Shipping Container Contents

- 1 Mill
- 1 Flat Way Cover (rear)
- 1 Accordion Way Cover (front)
- 1 Elevating Crank
- 1 Quill Handle
- 1 Drawbar
- 1 Pin & Nut
- 1 ToolBox: found in base through rear cover
  - 1 Hex Wrench Set (1.5 – 10mm)
  - 1 Wrench Set
  - 1 19mm Combination Wrench
  - 1 #2 Cross Point Screw Driver
  - 1 #2 Flat Blade Screw Driver
  - 1 Plastic Oil Can
  - 1 Owner's Manual
  - 1 Warranty Card
  - 1 Eye Bolt
  - 3 Handles
  - 4 Leveling Bolts
  - 4 Leveling Pads



## Unpacking and Clean-Up

- 1. Finish removing the crate. Leave the mill bolted to the pallet until it is ready to be moved to its final location.
- 2. Remove the toolbox from the base. It is accessed by removing four screws that hold the rear cover in place.
- 3. Clean all rust protected surfaces with kerosene, or a light solvent. Do not use gasoline, paint thinner, or lacquer thinner. These will damage painted surfaces.
- 4. Cover all machined surfaces with a film of light machine tool oil to inhibit rust.

## Site Preparation

**CAUTION** Mill must be supported equally under all four corners. Failure to comply may cause the column to twist and put a bind in the bedways.

The mill must be placed on an even surface, bolted to the floor, or placed on the leveling pads. Choose a location for the mill that is dry, has good lighting, and has enough room to be able to service the mill on all four sides. Review the JTM-1054R Layout on page 7.



## Lifting the Mill

1. Remove the four nuts that hold the unit to the pallet.
2. Raise the head by loosening four nuts, (A, Fig. 1) with a 22mm wrench, just enough to allow the head to raise into position. **Do not** remove the nuts; just break the nuts loose.
3. Turn the hex head of the worm shaft (B, Fig. 2) using a 19mm socket and breaker bar. Raise the head aligning the zero marks on the scales. With the help of another person support the head while it is raising.
4. Tighten the four bolts (A, Fig. 1).
5. Loosen the two ram locking handles (C, Fig. 1) and move the ram forward by turning the hex head of the ram pinion (D, Fig. 1) with a 19mm socket and breaker bar.
6. Tighten the ram locking handles before lifting.

The preferred method for lifting the mill is with a hook through the eye bolt in the ram (E, Fig. 1). Make sure the chain and hook are properly rated for the weight of the mill. Make sure the chain is not twisted and lift slowly. Make sure the mill is balanced before moving

Carefully move the mill over the site. Lower the mill over the anchor bolts, or leveling pads. The leveling pads included in the toolbox and the leveling screws will help you to reach a level position. Check the mill for level with a machinist's level placed on the table. Mill must be level back to front and side to side. Shim if necessary when bolting to the floor, but remember that the mill must be supported equally at all four corners. Check for level before tightening the anchor bolt nuts and after tightening them. Adjust as necessary.

## Electrical Connections

**⚠WARNING** All electrical connections must be made by a qualified electrician! Failure to comply may cause serious injury!

The JTM-1054R mill is rated at 230/460V, 3Ph and comes from the factory prewired at 230V.

Confirm power at the site matches power requirements of the mill before connecting to the power source. The power source should be dedicated to the JTM-1054R mill. The main power switch is located on the right side of the machine. Remove the cover, and run the main

power cable through the box and attach the ground, followed by power leads. Replace the cover.

Check for proper spindle rotation in the high speed range. The spindle should rotate clockwise when viewed from the top of the machine. If the spindle rotates counter-clockwise, disconnect from the power source, and switch two of the power leads.

To change from 230V to 460V operation, remove the junction box cover on the motor, and change the wires according to the diagram found on the inside of the cover. Also see the wiring diagram at the back of this manual.

The mill must be properly grounded.

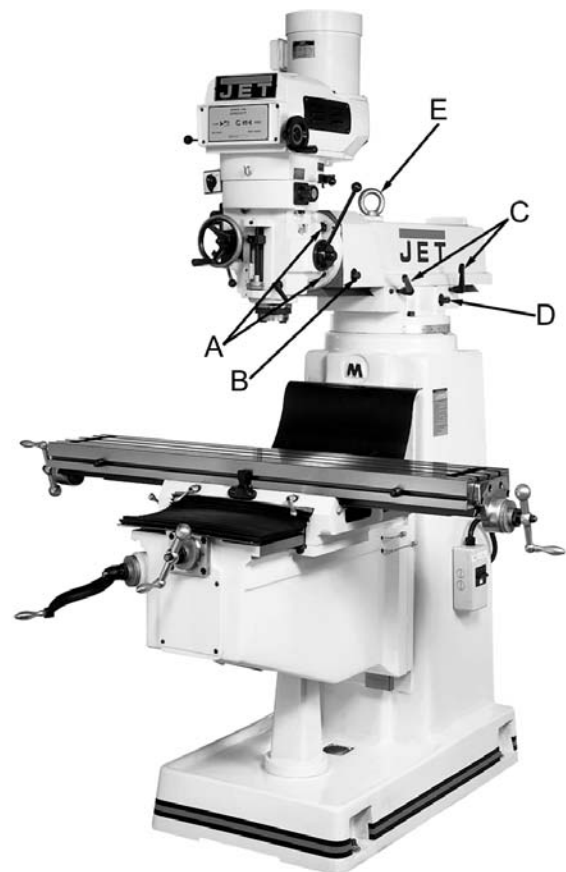


Figure 1

## Lubrication

**CAUTION** Do not operate the mill before lubricating the machine fully. Failure to comply may cause damage to the machine.

1. Spindle Bearings & Quill (A, Fig. 2)- fill oil cups once daily with Mobil DTE® Oil Light.
2. Oil Pump (B, Fig. 2)- fill reservoir as needed by removing cap on top of tank and filling with Mobil DTE® Oil Light. Pump oil with release handle daily. Way surfaces and leadscrews are lubricated in this manner.
3. Grease Fitting for Spindle Gear (not shown): located on the backside of the head's lower housing. Lubricate every month using Mobilith AW2.
4. Knee Leadscrew – lubricate with #2 tube grease once weekly.

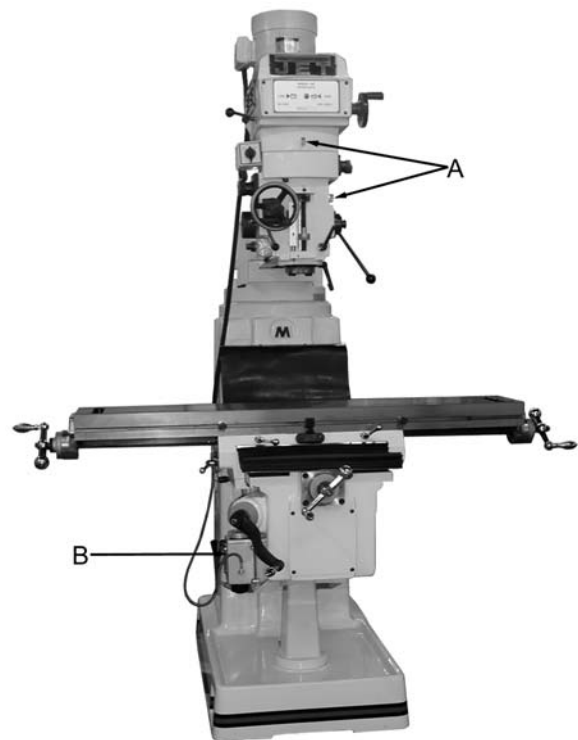


Figure 2

## Controls

Referring to Figures 3 through 6:

- A. **Variable Speed Control (A)** - located on the right side of the head assembly. Turn clockwise or counter-clockwise to adjust spindle speed.

**CAUTION** Change speed only when spindle is turning.

- B. **Variable Speed Dial Indicator (B)** - located on the front of the head assembly. Indicates selected speed in high, or low range.

- C. **Spindle Brake (C)** - located on left side of the head. Move in either direction to stop spindle once power has been turned off.

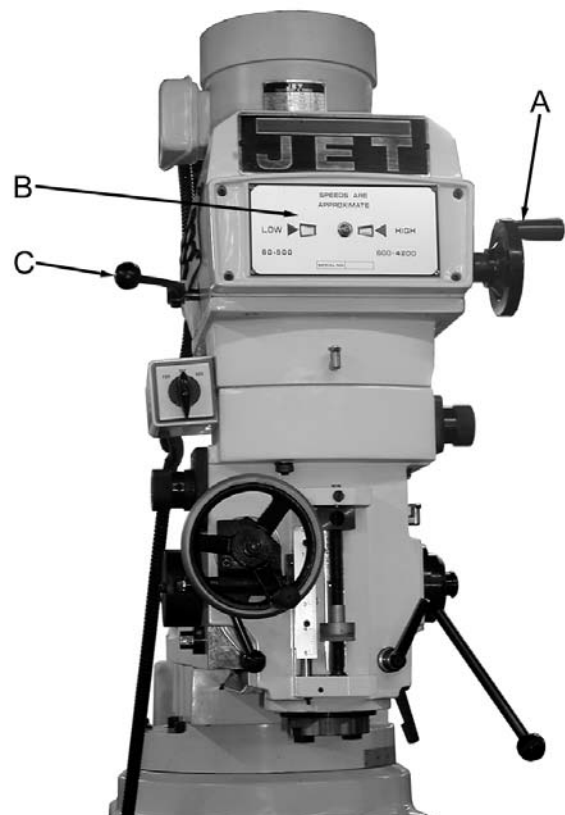


Figure 3

- D. **High-Neutral-Low Lever (D)** - located on the right side of the head. Upper position is high speed (direct drive). Middle position is neutral. Lower position is low speed (back gear). The photo shows the lever in the low speed range. Push the lever in and rotate 90° clockwise for neutral. Rotate the lever another 90° for the high speed range.

**CAUTION** Do not shift High-Low Gear while motor is running. Rotate the spindle by hand to facilitate changing lever positions.

- E. **Power Feed Transmission Engagement Knob (E)** - located on right side of head. When pointer indicates towards the rear of the machine, power feed worm gear is engaged. To disengage power feed, turn so pointer indicates towards the front of the machine.

**CAUTION** Power feed may be engaged when spindle is rotating, however, it must be engaged gently to avoid damage to the worm gear.

- Do not use power feed at speeds above 2700 R.P.M.
- It is recommended that the power feed worm gear be disengaged whenever the power feed is not required. This avoids unnecessary wear on the worm gear.
- Maximum loading is a 3/8" (9.5mm) diameter bit for drilling in steel. Use manual feed for bits larger than 3/8".

- F. **Quill Feed Handle (F)** - located on right side of head. Rotate clockwise to lower spindle. Return spring will retract the spindle automatically once the handle is released.

- G. **Quill Lock (G)** - located on the right side of the head. Rotate the handle clockwise to lock the quill in a desired position. Rotate the handle counter-clockwise to release.

- H. **Micro Adjusting Nut (H)**, - located on the front of the head. Use for setting specific spindle depth.

**Note:** One complete rotation of the micro nut equals 0.05".

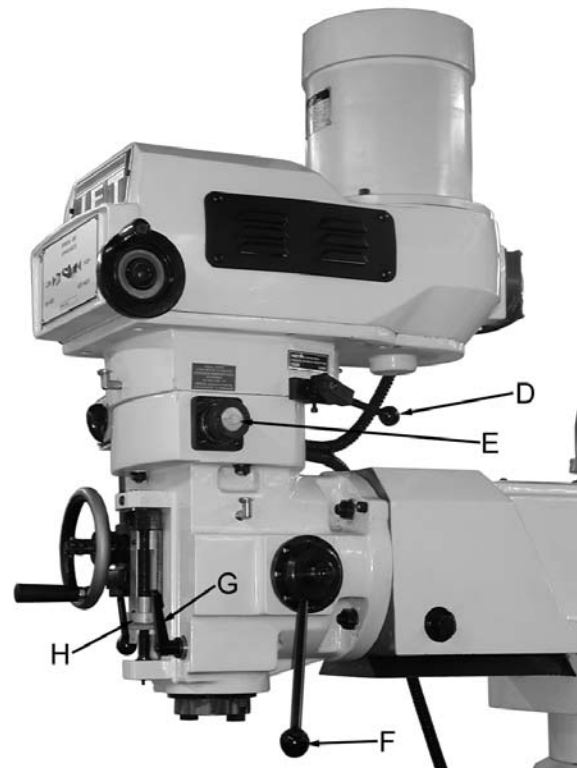


Figure 4

I. **Feed Control Lever (I)** - located on the left side of the head. Engages overload clutch on pinion shaft when the lever is positioned to the left. Stays engaged until quill stop comes in contact with micro adjusting nut (forcing feed control lever to drop out automatically), or until lever is released manually by positioning lever to the right.

J. **Manual Feed Handle and Handwheel (J)** - located on the left front of the head. *Feed reversing knob (K)* must be in the neutral position. The *feed control lever (I)* must be engaged. **Note:** The *manual feed handle and handwheel* may be taken off when not in use.

K. **Feed Reversing Knob (K)** - located in center of manual feed handwheel. Position of the knob depends upon the direction of spindle rotation. If boring with right hand cutting tools, pull feed knob towards operator until clutch becomes engaged. Neutral position is between forward and reverse position.

**CAUTION** It is recommended that the knob be left in the neutral position when not in use.

L. **Quill Stop (L)** - located on the front of head. Used to disengage the automatic feed in either direction as well as the setting point for working to a given depth.

M. **Quill Feed Speed Selector (M)** - located on the left side of the head. Pull out and turn the knob and indicate pointer towards one of three feed speeds (0.0015", 0.003", and 0.006") per spindle revolution. Feed is more readily engaged when spindle is turning.

N. **Reversing Switch (N)** - located on the left side of the head. Switches rotation of spindle.

O. **Drawbar (O)** - located on the top of the head. Used to secure the tool holder in the taper. Use the spindle brake while tightening the drawbar.

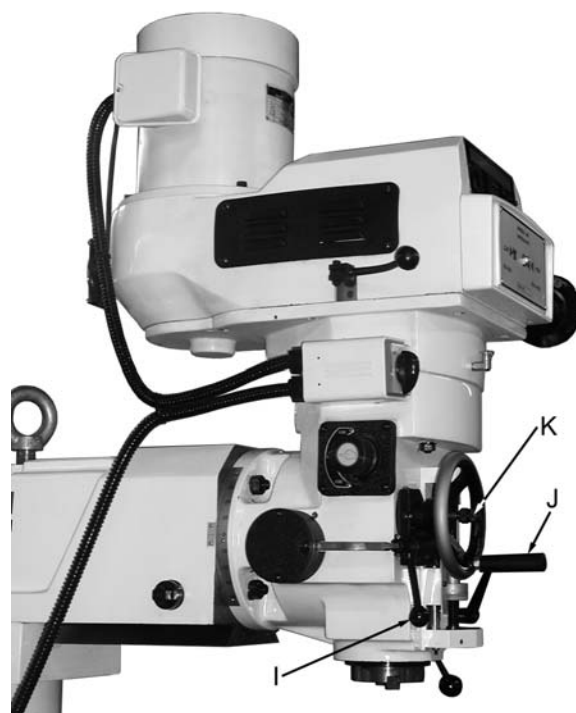


Figure 5

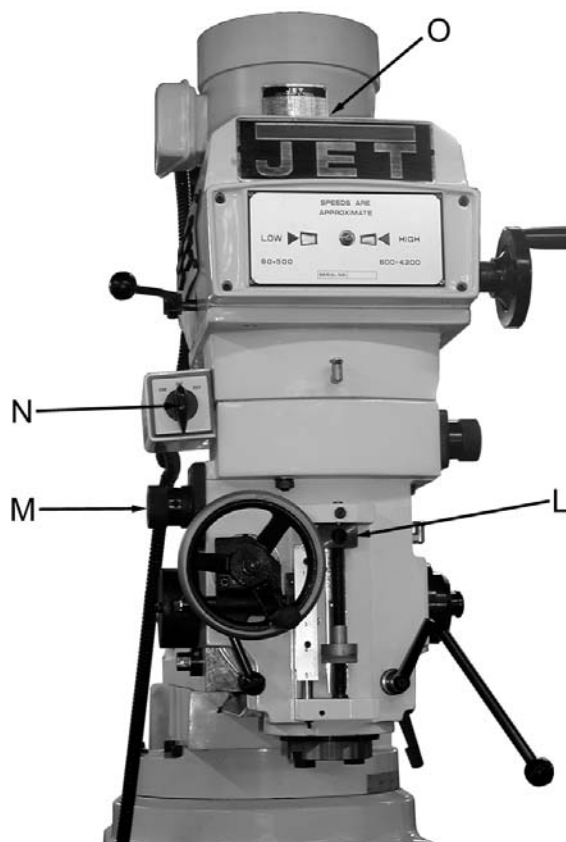


Figure 6

## Operating Precautions

- Do not attempt to change spindle RPM while motor is stopped.
- Be certain the spindle brake is released before starting the motor.
- Rotate the spindle by hand to facilitate meshing of the clutch and gears.
- Do **not** use the quill power feed at speeds above 2700 RPM.
- It is recommended that the power feed worm gear be disengaged whenever the power feed is not required. This will avoid unnecessary wear on the worm gear.
- Maximum loading is a 3/8" (9.5mm) diameter bit for drilling in steel. Use manual feed for bits larger than 3/8".
- Overload clutch is factory set to hold up to 200 lbs. down feed pressure on the quill (accommodates drills up to 3/8"). Do **not** attempt to adjust clutch pressure.
- Only change spindle speeds while the motor is running.

## Changing Speed Range

To change from high to low speed range, move lever (A, Fig. 7) by pressing in and rotating almost 180. Do not change gears while the spindle is running.

**CAUTION** It is recommended to rotate the spindle by hand to ensure the clutch is engaged prior to turning on. Do not turn on the machine unless the spindle can be moved freely.

## Manual Fine Feed (handwheel)

1. Disengage automatic feed by pulling out and turning knob (B, Fig. 7) so that the pointer indicates towards the front of the machine.
2. Locate the feed reversing knob (C, Fig. 7) in the center or neutral position.
3. Engage feed trip lever (D, Fig. 7) by pulling away from the head assembly.
4. The quill can now be moved up or down by turning the hand wheel.

## Manual Rapid Feed (handle)

1. Disengage automatic feed by turning knob (B, Fig. 7) so that the pointer indicates towards the front of the machine.
2. Locate the feed reversing knob (C, Fig. 7) in the center or neutral position.
3. Disengage feed trip lever (D, Fig. 7) by pushing towards head assembly.
4. Engage the manual quill handle (E, Fig. 7) and push, or pull to raise, or lower the quill.

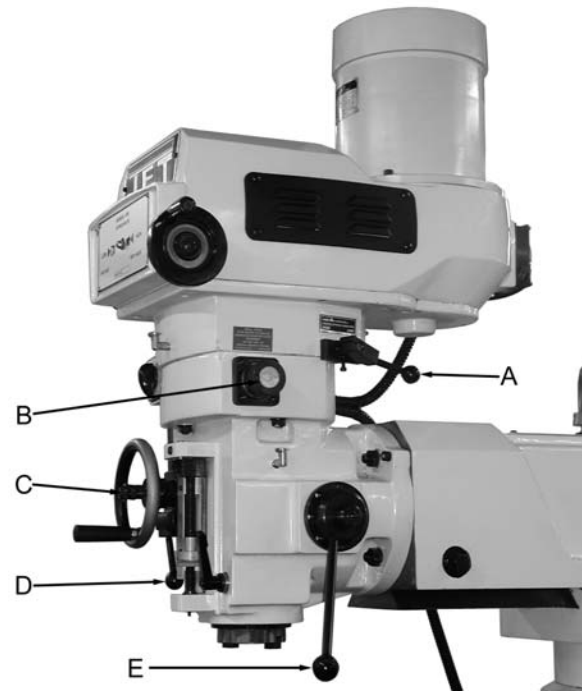


Figure 7

## Micro Adjusting Nuts for Manual Feed

1. Lower the quill to the required depth.
2. Tighten the quill lock (A, Fig. 9).
3. Screw the micro nut (B, Fig. 9) against the quill stop (C, Fig. 9), and tighten the micro jam nut (D, Fig. 9).
4. Loosen the quill lock.
5. Use rapid, or fine manual downfeed.

**Note:** Always make a test cut to verify that the depth of cut is correct.

## Setting Up for Automatic Feed

1. Ensure quill lock (A, Fig. 8) is off by rotating counter-clockwise.
2. Set micrometer dial (B, Fig. 8) to desired depth.
3. Engage auto quill feed knob (C, Fig. 8) by turning so pointer indicates towards the rear of the machine.
4. Select feed direction by pulling or pushing the knob (D, Fig. 8) for up/down feed, neutral is in the middle.
5. Select feed rate from feed selector knob (E, Fig. 8) 0.0015", 0.003", and 0.006" per spindle revolution. It is easier to change feed rate while the spindle is turning.
6. Engage feed trip lever (F, Fig. 8) by pulling away from head assembly.

**CAUTION** Power feed may be engaged when spindle is rotating; however, it must be engaged gently to avoid damage to the worm gear.

- Do not use power feed at speeds above 2700 R.P.M.
- It is recommended that the power feed worm gear be disengaged whenever the power feed is not required.
- Maximum loading is a 3/8" (9.5mm) diameter bit for drilling in steel. Use manual feed for bits larger than 3/8".

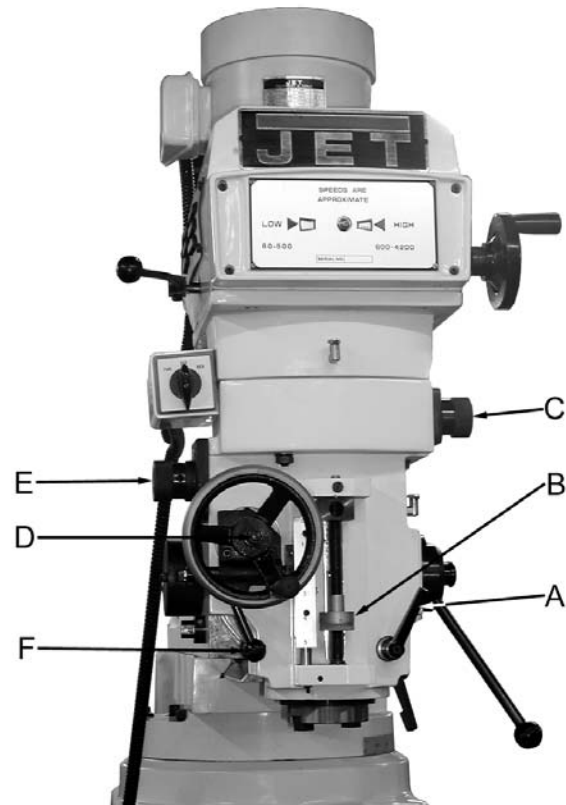


Figure 8

## Micro Adjusting Nuts for Auto Feed

1. Lower the quill to the required depth.
2. Tighten the quill lock (A, Fig. 9).
3. Screw the micro nut (B, Fig. 9) against the quill stop (C, Fig. 9), and tighten the micro jam nut (D, Fig. 9).
4. Loosen the quill lock, and engage the power feed knob (E, Fig. 9).
5. Choose the downfeed rate (F, Fig. 9).
6. Engage the feed reversing knob (G, Fig. 9).
7. Engage the feed trip lever (H, Fig. 9).

**Note:** Always make a test cut to verify that the depth of cut is correct.

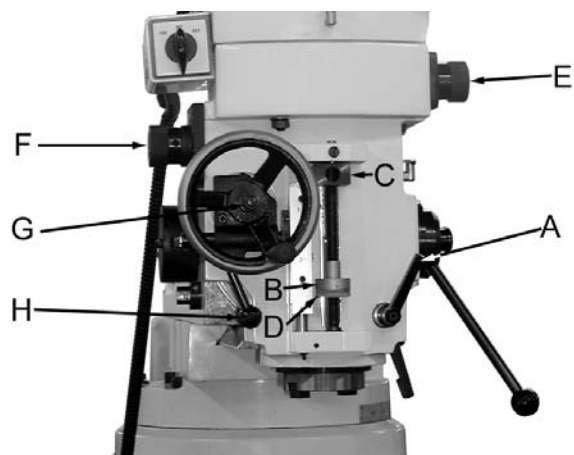


Figure 9

## Head Alignment

The quill housing, and ram were pinned at the factory. The pin has been removed for shipping. The pin can be found in the toolbox.

1. Loosen four nuts (A, Fig. 10) with a 22mm wrench, just enough to allow the head to pivot into position. **Do not** remove the nuts; just break the nuts loose.
2. Back off the nut so it is flush with the end of the pin. This will allow you to tighten the nut and remove the pin if needed.
3. Gently tap the pin into the hole while slightly rocking the hex head of the worm shaft (C, Fig. 10) back and forth.

The scale on the ram adapter and for head rotation are guides only. Close tolerance work will require the use of a dial indicator to make sure the head is 90° to the table in the X and Y axis. Please note the table is fitted to be slightly higher in the front, usually about .0005".

## Pivoting the Head

1. Remove the pin (B, Fig. 10) by tightening the nut.
2. Loosen four nuts, (A, Fig. 10) with a 22mm wrench, just enough to allow the head to move into position. **Do not** remove the nuts; just break the nuts loose.
3. Turn the hex head of the worm shaft (C, Fig. 10) using a 19mm socket and breaker bar. Pivot the head aligning the scale marks to the desired angle.
4. Tighten the four bolts (A, Fig. 10).

**Note:** Always make a test cut to verify that the angle of cut is correct.

## Pivot the Ram

1. Loosen four bolts, (A, Fig. 11) with a 21mm wrench.
2. Remove the pin (B, Fig. 11) by tightening the nut.
3. Pivot the head and ram assembly to the required angle and tighten four bolts.

## Moving the Ram

1. Loosen two ram locking handles (A, Fig. 12).
2. Move the ram by turning the hex head of the ram pinion (B, Fig. 12) with a 19mm socket and breaker bar.



Figure 10



Figure 11



Figure 12

## Table Movement Controls

Referring to Figure 13:

- A. **Longitudinal Movement (A)** - handles located on opposite ends of the table; controls the X-axis.
- B. **Stops (B)** - located on the front of the table; controls how far the table travels in either direction.
- C. **Table Locks (C)** - located on the front of the saddle used for locking the table in position.
- D. **Cross Feed Movement (D)** - located on the front of the knee; controls the Y-axis.
- E. **Knee Handle (E)** - located on the corner of the knee; controls the Z-axis.

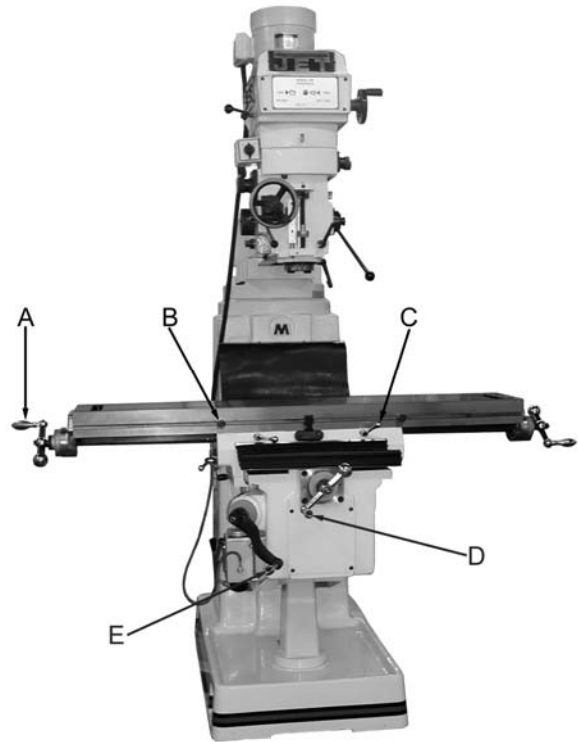


Figure 13

## Maintenance

**⚠WARNING** Always disconnect the machine from the power source before performing any maintenance. If you do not have the knowledge or the training to complete the maintenance, have an authorized JET service center maintain your mill. Failure to comply may cause serious bodily injury!

### Feed Trip Adjustment

1. Loosen lock nut (A, Fig. 14).
2. Engage trip handle (C, Fig. 14) by pulling away from head assembly.
3. Adjust micro nuts (E, Fig. 14) against quill stop (B, Fig. 14).
4. Slowly turn adjusting screw (D, Fig. 14) until lever (C, Fig. 14) trips.
5. Tighten lock nut (A, Fig. 14)

### Knee Gib Adjustment

**Note:** When adjusting the gibs for the knee, the saddle, and the table always start with the knee first, the saddle second, and adjust the table last.

Adjust three gibs located between the knee and the base. Use a dial indicator to measure the amount of movement in the knee. Adjust the gib until the indicator reading is within 0.003".

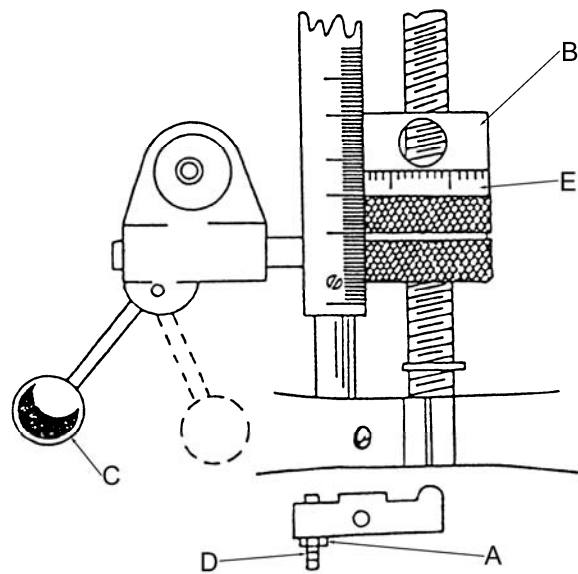


Figure 14



## Saddle Gib Adjustment

Adjust two gibs located between the saddle and the knee. Use a dial indicator to measure the amount of movement in the saddle. Adjust the gib until the indicator reading is within 0.003".

## Table Gib Adjustment

Adjust one gib located between the table and the saddle. Use a dial indicator to measure the amount of movement in the table. Adjust the gib until the indicator reading is within 0.003".

## Ram Wear Plate Adjustment

Adjust one wear plate located between the ram and the turret. Use a dial indicator to measure the amount of movement in the ram. Adjust the wear plate until the indicator reading is within 0.003".

## Removing the Motor

Referring to Figure 15:

1. Adjust the head to the lowest speed.
2. Disconnect the machine from the power source.
3. Remove three screws (A) and plate (B).
4. Use two screws (A-1) to compress the spring (C).
5. Rotate the high-neutral-low lever (D, Fig. 4) to the high speed range.
6. Remove the reversing switch (N, Fig. 6) from the belt housing.
7. Remove two locking nuts (D).
8. Lift and tilt the motor so that it rests on stud (E).
9. Ease the belt over the lower drive disc and remove the motor.

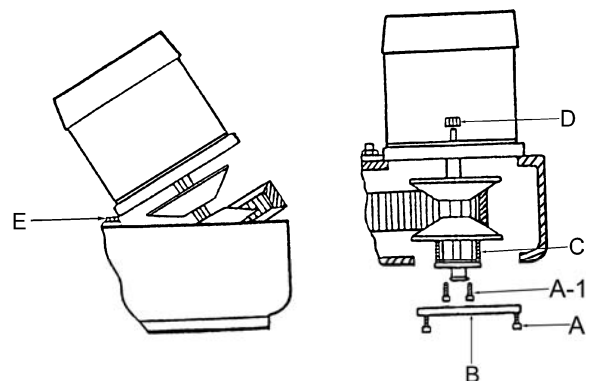


Figure 15

## Timing Belt Replacement

Referring to Figure 16:

1. Disconnect the machine from the power source.
2. Remove the motor.
3. Lower the quill to the full extent.
4. Remove the two lower screws (A) from the variable speed housing.
5. Remove six screws (B) from underneath.
6. Remove the top assembly (C) and tap to clear dowels.
7. Replace the belt.

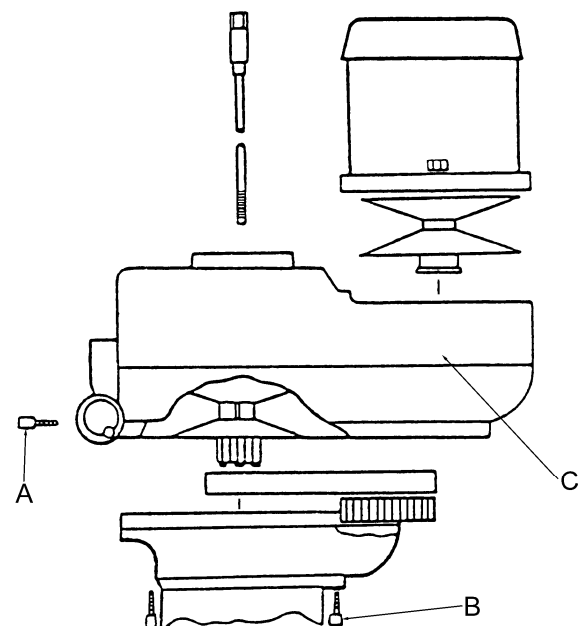


Figure 16

## Drive Belt Replacement

1. Disconnect the machine from the power source.
2. Remove the motor.
3. Remove the three screws (A, Fig. 17). Thread the screws into the adjacent tapped holes and back off the cover (B, Fig. 17).
4. Remove the two screws and bushings (C, Fig. 17) from the tilting plate.
5. Remove four screws (D, Fig. 17) and one screw (E, Fig. 17).
6. Remove four screws from the variable speed housing (F, Fig. 17).
7. Remove the top housing (G, Fig. 17) and tap to clear dowels.
8. Replace the belt.

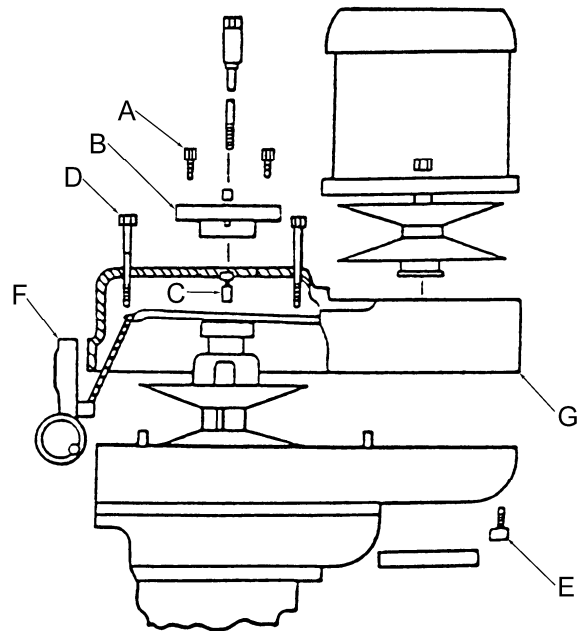


Figure 17

## Brake Shoe Replacement

1. Disconnect the machine from the power source.
2. Remove the top section.
3. Remove the two screws (A, Fig. 18).
4. Remove the clutch hub assembly (B & D, Fig. 18).
5. Replace the brake shoes (C, Fig. 18).

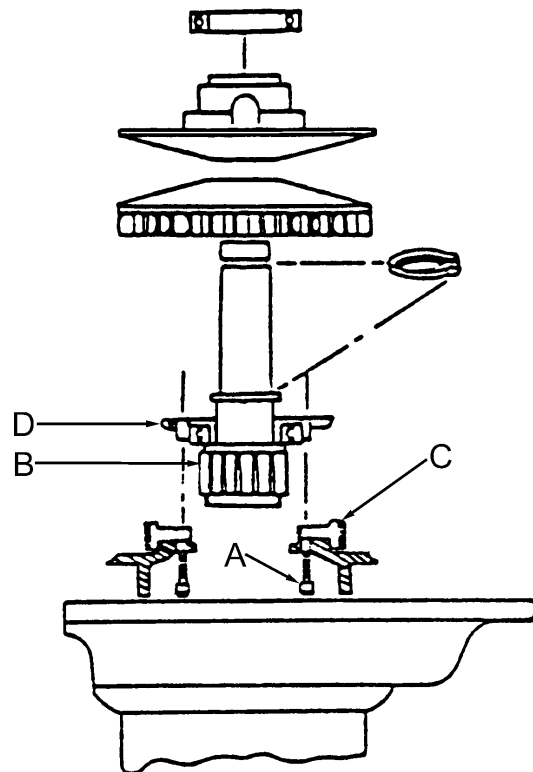


Figure 18

# Parts

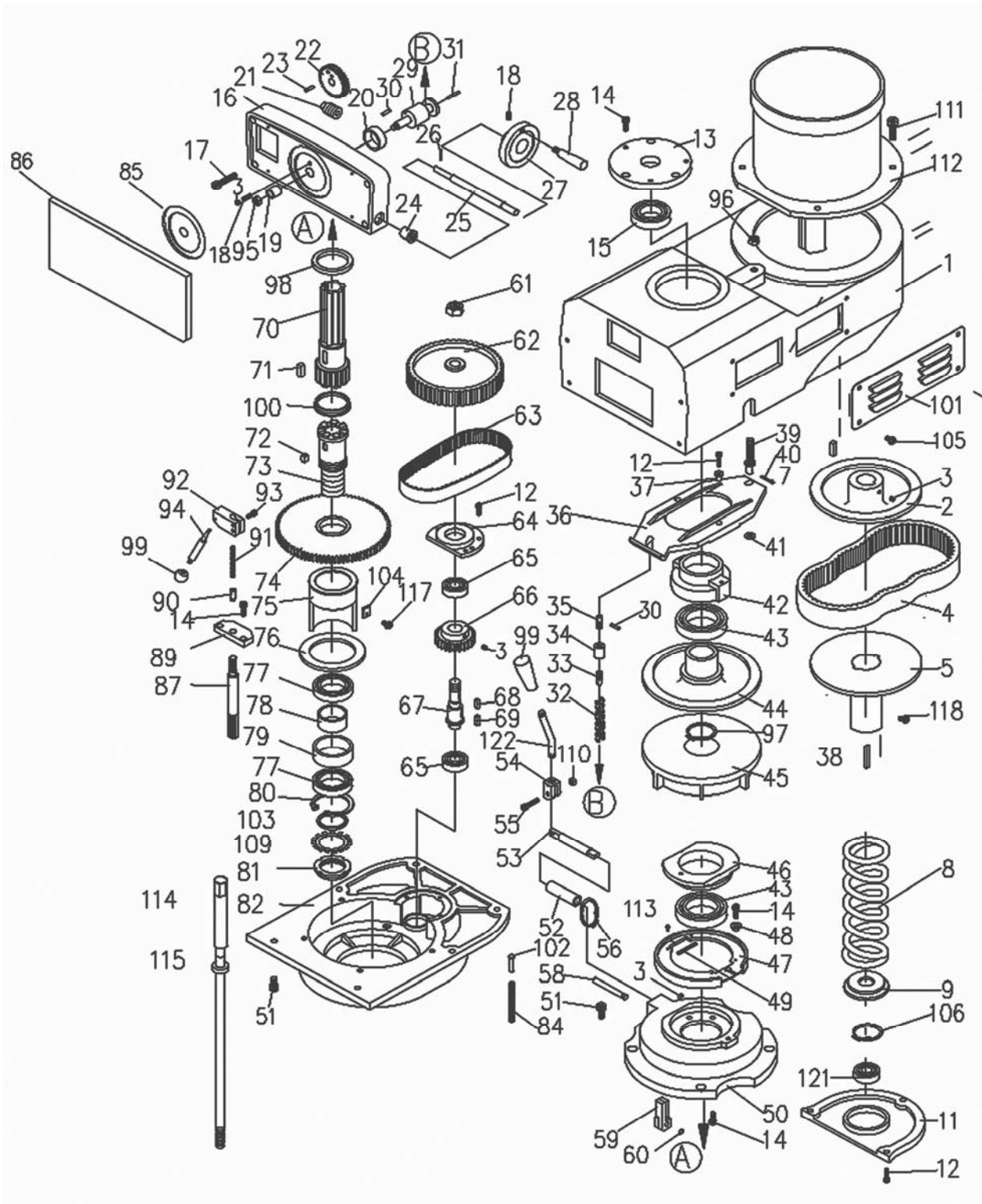
## Variable Speed Head Assembly

Index No	Part No	Description	Size	Qty
1	PVS-001G	Housing		1
2	PVS-002	Motor Pulley		1
3	TS-1523011	Set Screw	M6x6	4
4	PVS-004	Belt	3830900	1
5	PVS-005	Motor Pulley		1
7	KEY7725	key	7x7x25	1
8	PVS-008	Motor Pulley Spring		1
9	PVS-009	Spring Stop Washer		1
11	PVS-011G	Motor Pulley Cover		1
12	TS-1502051	Hex Socket Cap Screw	M5x20	9
13	PVS-013G	Cover		1
14	TS-1502041	Hex Socket Cap Screw	M5x16	1
15	BB-6007ZZ	Ball Bearing	6007ZZ	1
16	PVS-016G	Dial Cover		1
17	TS-1502081	Hex Socket Cap Screw	M5x35	4
18	TS-1503041	Hex Socket Cap Screw	M6x16	3
19	PVS-019	Bushing		1
20	PVS-020	Bushing		1
21	PVS-021	Worm		1
22	PVS-022	Worm Gear		1
23	PVS-023	Spring Pin	5x10	2
24	PVS-024	Bushing		2
25	PVS-025	Dial Control Shaft		1
26	PVS-026	Spring Pin	3x12	2
27	PVS-027	Dial Wheel		1
28	PVS-028	Wheel Handle		1
29	PVS-029	Shaft		1
30	PVS-030	Spring Pin	4x35	2
31	PVS-031	Spring Pin	3x25	1
32	PVS-032	Speed Change Chain		1
33	PVS-033	Adjustment Stud		1
34	PVS-034	Sleeve Nut		1
35	PVS-035	Adjustment Stud		1
36	PVS-036	Tilter		1
37	PVS-037	Bushing		2
38	KEY8760	Key	8x7x60	2
39	PVS-039	Regulating Screw		1
40	PVS-040	Spring Pin	4x12	1
41	PVS-041	Washer		1
42	PVS-042	Support		1
43	BB-6010ZZ	Ball Bearing	6010ZZ	2
44	PVS-044	Drive Pulley Assembly		1
45	PVS-045	Steady Pulley		1
46	PVS-046	Bearing Cover		1
47	PVS-047	Brake Lining		1
48	PVS-048	Lock Screw		1
49	PVS-049	Brake Spring		2
50	PVS-050	Lower Housing Cover		1
51	TS-1503051	Hex Socket Cap Screw	M6x20	10
52	PVS-052	Brake Shaft Sleeve		1
53	PVS-053	Brake Lock Shaft		1
54	PVS-054	Brake Lock Block		1
55	TS-1503061	Hex Socket Cap Screw	M6x25	1
56	PVS-056	Snap Ring	S-12	1

## Variable Speed Head Assembly

Index No	Part No	Description	Size	Qty
58	PVS-058	Brake Finger Pivot Stud		1
59	PVS-059	Brake Stud		2
60	PVS-060	Snap Ring	S-8	1
61	PVS-061	Nut	5/8"-18NF	1
62	PVS-062	Timing Belt Pulley		1
63	PVS-063	Timing Belt	225L100	1
64	PVS-064	Bearing Housing		1
65	BB-6203ZZ	Ball Bearing	6203ZZ	2
66	PVS-066	Bull Gear		1
67	PVS-067	Counter Shaft		1
68	KEY5515	Key	5x5x15	1
69	KEY5518	Key	5x5x18	1
70	PVS-070	Spindle Pulley Hub		1
71	KEY8720	Key	8x7x20	1
72	KEY8712	Key	8x7x12	1
73	PVS-073	Spindle Gear Hub		1
74	PVS-074	Gear		1
75	PVS-075	Rack Cup		1
76	PVS-076	Washer		1
77	BB-6908ZZ	Ball Bearing	6908ZZ	2
78	PVS-078	Bearing Washer		1
79	PVS-079	Bearing Washer		1
80	PVS-080	Snap Ring	C-62	1
81	PVS-081	Nut		1
82	PVS-082G	Housing		1
84	PVS-084	Spring		3
85	PVS-085	Vari-Speed Plate		1
86	PVS-086	Plastic Face Plate		1
87	PVS-087	Gear Shaft Pinion		1
89	PVS-089	Deter Plate		1
90	PVS-090	Bearing Stop		1
91	PVS-091	Spring		1
92	PVS-092	Pinion Block		1
93	TS-1503011	Hex Socket Cap Screw	M5x14	2
94	PVS-094	Pinion Crank		1
95	PVS-095	Cap Nut		1
96	PVS-096	Nut	3/8"	1
98	PVS-098	Wave Washer		1
99	PVS-099	Plastic Ball		2
100	PVS-100	Collar		1
101	PVS-101	Cover		2
102	PVS-102	Spring Shaft		3
103	PVS-103	Washer		1
105	PVS-105	Round Head Screw	3/16"x3/8"	1
106	PVS-106	Snap Ring	S-28	1
109	PVS-109	Lock Washer		1
110	TS-1540041	Nut	M6	1
111	TS-0209051	Hex Socket Cap Screw	3/8"x1"	2
112	PVS-112G	Motor		1
113	PVS-113	Round Head Screw	1/8"x1/4"	4
114	PVS-114	Draw Bar		1
115	PVS-115	Draw Bar Washer		1
118	PVS-118	Hex Socket Cap Screw	M5x6	1
121	BB-6024ZZ	Ball Bearing	6204ZZ	1
122	PVS-122	Handle		1

# Variable Speed Head Assembly



## Head Assembly

Index No	Part No	Description	Size	Qty
1	TS-1503031	Hex Socket Cap Screw	M6x12	1
2	B-2	Washer		1
3	B-3	Feed Bevel Pinion		1
4	B-4	Worm Gear Shaft Sleeve		1
5	B-5	Bushing		1
6	TS-1522011	Set Screw		1
8	B-8	Worm Gear		1
10	KEY3312	Key	3x312	1
12	TS-1504031	Hex Socket Cap Screw	M8x16	1
13	B-13	Washer		1
14	KEY3308	Key	3x3x8	2
15	B-15	Bevel Gear		1
16	B-16	Feed Engage Pin		1
17	1050B-17	Worm Gear Cradle		1
18	B-18	Worm Gear Cradle Shaft		1
19	1050B-19	Shaft Sleeve		1
20	B-20	Gear Shaft Plunger		2
21	B-21	Spring		2
22	1050B-22	Spring Pin	3x20	2
23	B-23	Shift Crank		2
24	B-24	Black Plastic Ball		3
25	TS-1503010	Hex Socket Cap Screw	M5/12	3
27	B-27	Bushing		1
28	B-28	Gear		1
29	KEY3345	Key	3x3x45	1
31	1050B-31	Gear Shaft		1
32	1050B-32	Snap Ring	S-16	1
33	1050B-33	Bevel Gear Bushing		1
34	1050B-34	Spacer		1
36	1050B-36	Gear		1
39	TS-1540031	Nut	M5	1
40	1050B-40	Feed Drive Gear		1
41	1050B-41	Needle Bearing		1
42	1050B-42	Bushing		1
43	1050B-43	Worm Gear		1
44	B-44	Bushing		1
47	B-47	Washer		1
48	B-48	Bushing		2
49	B-49	Bevel Gear		2
50	B-50	Feed Reverse Clutch		1
54	TS-1503061	Hex Socket Cap Screw	M6x25	1
55	B-55	Reverse Clutch Rod		1
56	B-56	Spring Pin	3x20	1
57	B-57	Feed Worm Shaft		1
58	TS-1523011	Set Screw	M6x6	1
59	B-59	Spring Pin	3x12	2
60	B-60	Chip Guards		1
61	TS-1522031	Set Screw	M5x10	1
62	KEY3315	KEY	3x3x15	2
63	B-63	Feed Gear Shift Fork		1
64	B-64	Gear Shift Crank		1
66	B-66	Cluster Gear Cover		1
67	TS-1502031	Hex Socket Cap Screw	M5x12	4
73	TS-1502081	Hex Socket Cap Screw	M5x35	2
74	B-74	Clutch Ring Pin		2
75	B-75	Clutch Ring		1

## Head Assembly

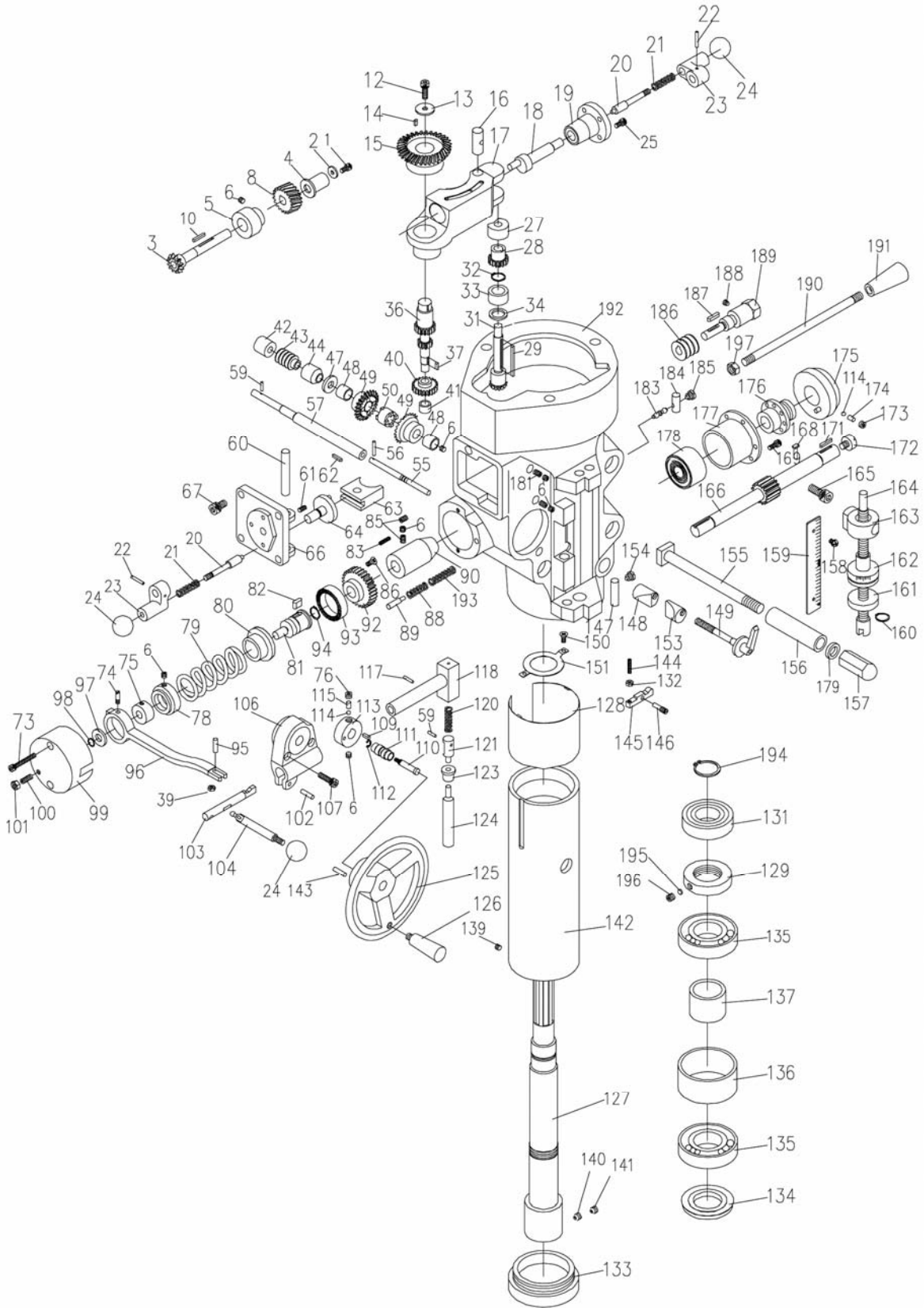
Index No	Part No	Description	Size	Qty
76	TS-1523021	Set Screw	M6x8	1
78	B-78	Clutch Locknut		1
79	B-79	Safety Clutch Locknut		1
80	B-80	Overload Clutch		1
81	B-81	Overload Clutch Sleeve		1
82	KEY5813	Key	5x8x13	1
83	B-83	Hex Socket Head Bolt		3
85	TS-1523011	Set Screw	M6x6	2
86	B-86	Cross Plate Screw	M4x16	4
88	B-88	Spring		1
89	B-89	Spring Plunger		1
90	B-90	Bushing		1
92	B-92	Worm Gear		1
93	B-93	Clutch Ring		1
94	B-94	Snap Ring	S-10	1
95	TS-1502051	Hex Socket Cap Screw	M5x20	1
96	B-96	Clutch Trip Lever		1
97	B-97	Clutch Washer		1
98	B-98	Snap Ring	S-10	1
99	B-99	Clutch Arm Cover		1
100	C-19-1	Set Screw	M6x16	1
101	TS-1540041	Nut	M6	1
102	B-102	Spring Pin	5x18	1
103	B-103	Cam Rod		1
104	B-104	Trip Handle		1
106	B-106	Feed Trip Bracket		1
107	TS-1503051	Hex Socket Cap Screw	M6x20	1
108	TS-1523031	Set Screw	M6x10	1
109	KEY3310	Key	3x3x10	1
110	B-110	Knob Stud		1
111	B-111	Reverse Knob		1
112	B-112	E-Ring	E-6	1
113	B-113	Handle Wheel Clutch		1
114	B-114	Steel Ball	3/16"	2
115	B-115	Compression Spring		2
116	B-116	Set Screw	M8x6	1
117	B-117	Spring Pin	3x15	1
118	B-118	Cam Rod Sleeve		1
119	B-119	Spring Pin	3x12	1
120	B-120	Compression Spring		1
121	B-121	Trip Plunger		1
123	B-123	Bushing		4
124	B-124	Feed Trip Plunger		1
125	B-125BR	Hand Wheel		1
126	B-126	Handle		1
127	B-127	Spindle		1
128	B-128	Quill Skirt		1
129	B-129	Locknut		1
131	BB-6206ZZ	Ball Bearing	6206ZZ	1
132	B-132	Nut	M4	1
133	B-133	Nose Piece		1
134	B-134	Spindle Dirt Shield		1
135	BB-7207C	Angular Bearing	7207	1
136	B-136	Spacer		1
137	B-137	Spacer		1
138	BB-7207C	Angular Bearing	7207	1

## Head Assembly

Index No	Part No	Description	Size	Qty
139	B-139	Set Screw		1
140	B-140	Set Screw		1
141	TS-1523011	Set Screw	M6x6	1
142	B-142	Quill		1
143	B-143	Spring Pin	3x16	1
144	B-144	Set Screw	M4x20	1
145	B-145	Feed Trip Lever		1
146	B-146	Trip Lever Pin		1
147	B-147	Indicator Rod		1
148	B-148	Quill Lock Sleeve		1
149	B-149	Lock Handle		1
150	B-150	Round Head Screw	M5x8	2
151	B-151	Washer	M5	2
153	B-153	Quill Lock Sleeve		1
154	B-154	Indicator Rod Screw		1
155	B-155	T-Bolt		4
156	B-156	Spacer		4
157	B-157	Adaptor Nut		4
158	B-158	Round Head Screw		2
159	B-159	Micrometer Scale		1
160	B-160	Snap Ring	S-16	1
161	B-161	Quill Micro-Stop Nut		1
162	B-162	Quill Micro-Stop Nut		1
163	B-163	Quill Stop Knob		1
164	B-164	Quill Micro-Stop Nut		1
165	B-165	Round Head Screw	M10x15	1
166	B-166	Quill Pinion Shaft		1
168	B-168	Pin		1
169	TS-1503010	Hex Socket Cap Screw	M5x12	2
171	KEY3320	Key	3x3x20	1
172	B-172	Pinion Shaft Hub Screw		1
173	B-173	Set Screw	5/16"x1/4"	1
174	B-174	Compression Spring		1
175	B-175	Handle Hub		1
176	B-176	Hub Sleeve		1
177	B-177	Spring Cover		1
178	B-178	Clock Spring		1
179	B-179	Washer		4
181	TS-1523041	Set Screw	M6x12	2
183	B-183	Reverse Trip Ball Lever		1
184	B-184	Reverse Trip Plunger		1
185	B-185	Trip Ball Lever Screw		1
186	B-186	Worm Gear		1
187	KEY4418	Key	4x4x18	1
188	B-188	Set Screw		1
189	B-189	Worm Shaft		1
190	B-190	Pinion Shaft Hub Handle		1
191	B-191	Black Plastic Ball		1
192	B-192G	Quill Housing		1
193	B-193	Compression Spring		1
194	B-194	Snap Ring	S-30	1
195	B-195	Bush		1
196	TS-1523011	Set Screw	M6x6	1
197	B-197	Nut		1
198	JET-165	JET Logo (not shown)	165 x 68mm	1



# Head Assembly



## Base Assembly

Index No	Part No	Description	Size	Qty
1	JTM1050C-11	Hook		1
2	1050C-10G	Ram		1
3	1050C-1	Worm Gear		1
3-1	1050C-14	Spring Pin		1
3-2	TS-1504061	Hex Socket Cap Screw	M8*30	2
4	1050C-4	Lock Nut		1
5	1050C-3	Adaptor Scale		1
6	1050C-16	Rivet		6
7	C-120	Ram Pinion		1
7-1	JTM1054R-7-1	Crank		1
7-2	JTM1054R-7-2	Plastic Ball		1
8	C-124G	Turret		1
9	C-111	Gib		1
10	C-127	Bolt		4
10-1	C-123	Spring Washer		4
11	C-128	Set Screw		1
12	C-38A	Lock Handle	1/2"x25L	2
13	C-110	Set Screw	3/8"X60	2
13-1	C-109	Hex Nut	3/8"	2
13-2	C-126	Ram Lock Plunger		2
14	JTM1054R-14	Scale Label		1
15	JTM1055-B15	Rivet		4
16	C-118	Spider		1
17	JTM1055-B17NG	Base		1
18	JTM1055-B18G	Cover		1
18-1	JTM1055-B18-1	Round Head Screw	M5x10	4
19	C-132AB	Breaker Box (W/#21)		1
20	C-133	Beaker		1
21	C-134B	Breaker Box Cover		1
	C-133AB	Breaker Box Assembly		1
22	JTM1055-B22	Strainer		1
23	JTM1055-B23G	Lead Screw Housing		1
23-1	TS-1503041	Hex Socket Cap Screw	M6x16	3
24	JTM1055-B24	Flange		1
24-1	TS-1503061	Hex Socket Cap Screw	M6x35	2
25	JTM1055-B25	Lead Screw		1
25-1	JTM1055-B25-1	Key	5x5x20	1
26	JTM1055-B26	Flange		1
26-1	TS-1503051	Hex Socket Cap Screw	M6x20	3
27	JTM1055-B27	Ball Bearing	6204ZZ	3
28	JTM1055-B28	Bevel Gear		1
29	JTM1055-B29	Washer		1
30	JTM1055-B30	Hex Nut		1
31	JTM1055-B31	Bearing Cover		1
32	JTM1055-B32	Bearing Stop		1
33	JTM1055-B33	Dial Holder		1
34	JTM1055-B34	Dial Ring		1
35	JTM1055-B35	Dial Lock Nut		1
36	JTM1055-B36	Gear Shear Clutch		1
37	JTM1055-B37G	Elevating Crank		1
38	JTM1055-B38BR	Handle		1
39	JTM1055-B39NG	Knee		1
40	JTM1055-B40	Knee Front Cover		1
40-1	JTM1055-B40-1	Cross Head Screw	M5x20	4
41	JTM1055-B41	Shaft		1

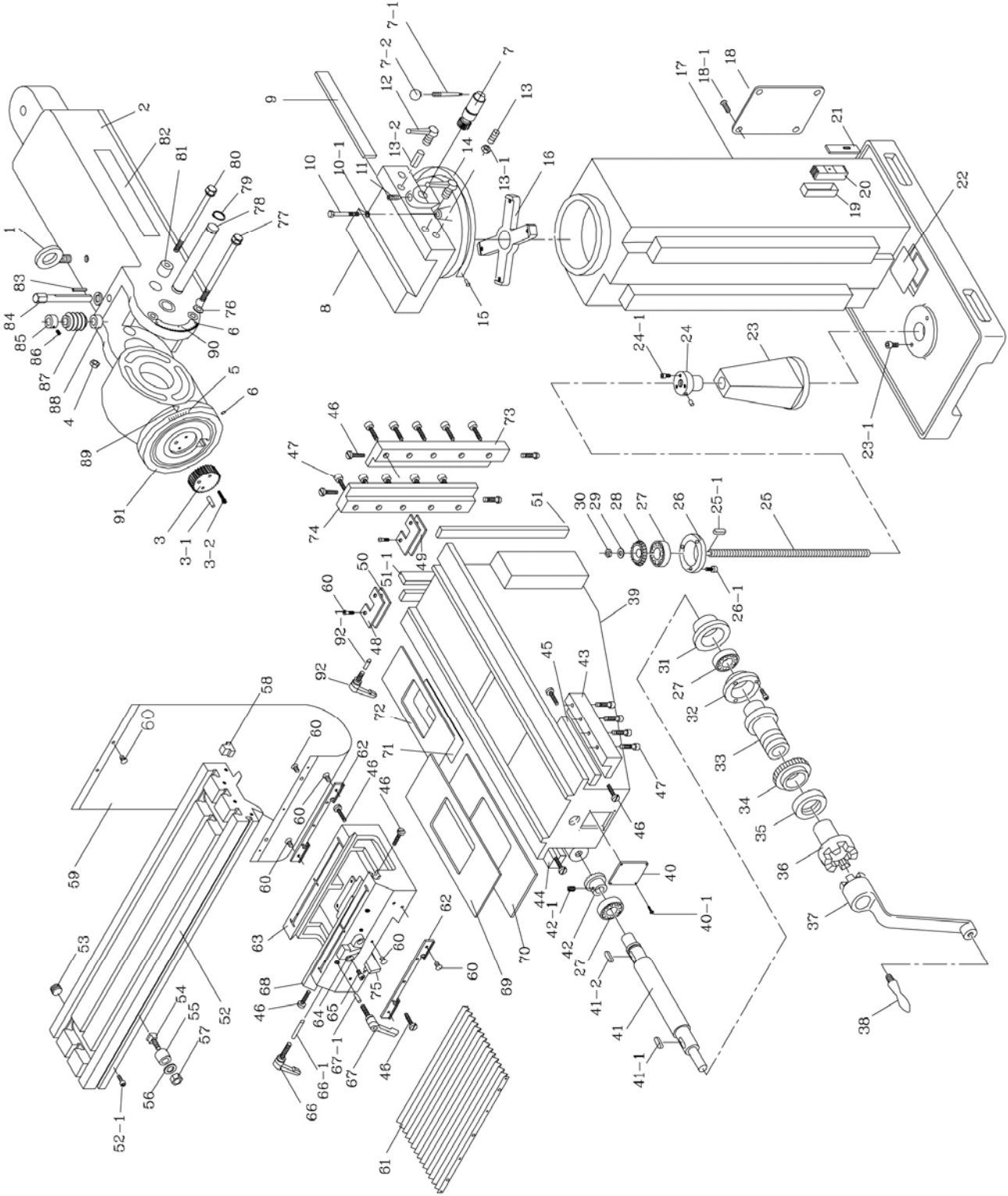
## Base Assembly

Index No	Part No	Description	Size	Qty
41-1	JTM1055-B41-1	Key	3x3x10	1
41-2	JTM1055-B41-2	Key	4x4x16	1
42	JTM1055-B42	Bevel Gear		1
42-1	JTM1055-B42-1	Set Screw	M6x20	1
43	JTM1055-B43G	Gib Holder-R		1
44	JTM1055-B44G	Gib Holder-L		1
45	JTM1055-B045	Gib		2
46	JTM1055-B46	Adjusting Screw		12
47	JTM1055-B47	Hex Socket Cap Screw	M12x35	18
48	JTM1055-B48	Wiper Cover		2
49	JTM1055-B49	Wiper-R		1
50	JTM1055-B50	Wiper-L		1
51	JTM1055-B51N	Gib (s/n 120xxxx and higher)		2
51-1	JTM1055-B51-1N	Gib (s/n 120xxxx and higher)		1
52	JTM1055-B52	Table		1
52-1	TS-1502061	Hex Socket Cap Screw	M5x25	2
53	JTM1055-B53	Plug		2
54	JTM1055-B54	T-Bolt		2
55	JTM1055-B55	Bushing		2
56	JTM1055-B56	Flat Washer		2
57	JTM1055-B57	Hex Nut		2
58	JTM1055-B58	Rubber T-Nut		6
59	JTM1055-B59	Chip Guard		1
60	JTM1055-B60	Screw		22
61	JTM1055-B61	Dust Protective Cover		1
62	JTM1055-B62N	Wiper (s/n 120xxxx and higher)		2
63	JTM1055-B63G	Saddle		1
64	JTM1055-B64	Stop Block		1
65	JTM1055-B65	Hex Socket Cap Screw		2
66	JTM1055-B66	Handle		2
66-1	JTM1055-B66-1	Brass Block		2
67	JTM1055-B67BR	Handle		2
67-1	JTM1055-B67-1	Brass Block		2
68	JTM1055-B68N	Gib (s/n 120xxxx and higher)		1
69	JTM1055-B69	Chip Guard-XL		1
70	JTM1055-B70	Chip Guard-L		1
71	JTM1055-B71	Chip Guard-M		1
72	JTM1055-B72	Chip Guard-S		1
73	JTM1055-B73G	Gib Holder-R		1
74	JTM1055-B74G	Gib Holder-L		1
75	JTM1055-B75N	Gib (s/n 120xxxx and higher)		1
	JTM1055-TBC	Tool Box complete(not shown)		1
	JTM1055-LP	Leveling Pad(not shown)		4
	JTM1055-LB	Leveling Bolt w/Nut(not shown)		4
	JTM1055-JS	JET Striping(not shown)		1
	JTM1055-ID	ID & Warning Label(not shown)		1
76	C-18	Washer		2
77	C-19	Locking Bolt		2
78	JTM1050C-17	Adaptor Pivot Stud		1
79	JTM1050C-79	C-Ring		1
80	C-19	Locking Bolt		1
81	C-19-1	Collar		1
82	JET-254	JET Logo	254 x 105mm	1
83	KEY5550	KEY	5*5*50	1
84	1050C-8	Worm Shaft		1

## Base Assembly

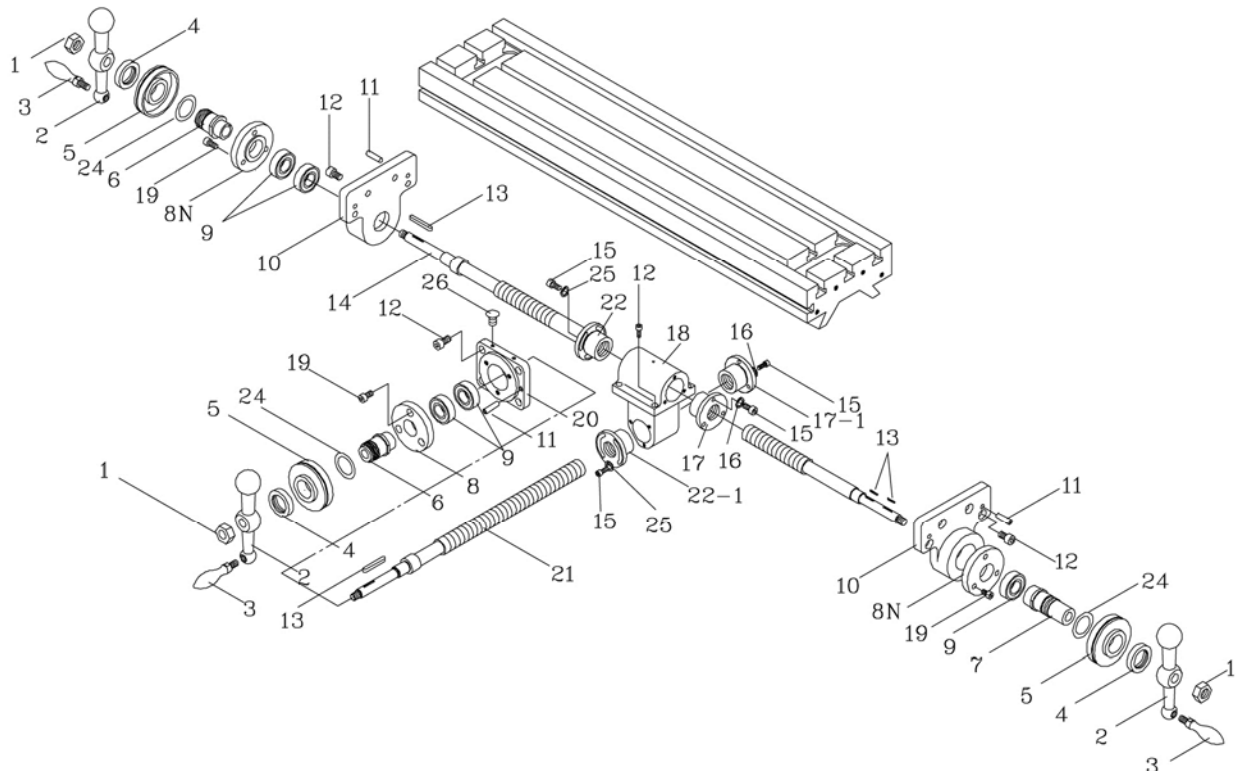
Index No	Part No	Description	Size	Qty
85	C-7-1	Washer		1
86	JTM1050-C86	Set Screw	M6*8L	1
87	1050C-6	Worm Gear		1
88	1050C-12	Collar		1
89	JTM-1050C-89	Index Plate		1
90	JTM-1050C-15	Angle Plate	90°	1
91	1050C-2G	Ram Adaptor		1
92	JTM1055-B12	Lock Handle	1/2"x40L	2
92-1	JTM1055-B12-1	Brass Block		2
	STRIPE-1-3/4	JET Striping (not shown)	1-3/4" W	per ft.

# Base Assembly



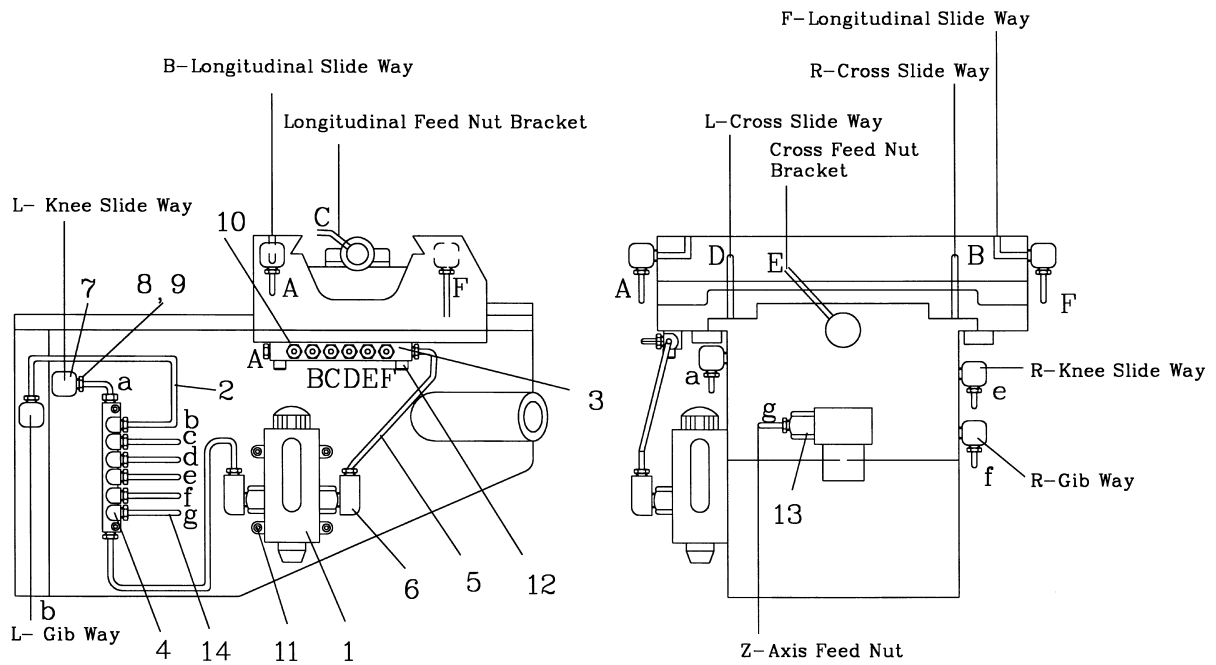
## Lead Screw Assembly

Index No	Part No	Description	Size	Qty
1	JTM1055-L01	Nut	1/2-20UNF	3
2	JTM1055-L02BR	Ball Crank		3
3	JTM1055-L03BR	Handle		3
4	JTM1055-L04	Dial Lock Nut		3
5	JTM1055-L05	Dial		3
6	JTM1055-L06	Dial Holder		2
7	JTM1055-L07	Dial Holder (left)		1
8	JTM1055-L08	Bearing Stop for Y-Axis		1
8N	JTM1055-L08N	Bearing Stop for X-Axis (s/n 120xxx and higher)		2
9	BB-6204ZZ	Ball Bearing		5
10	JTM1055-L10NG	Extended Bearing Bracket		2
11	JTM1055-L11	Spring Pin	M5X20	6
12	TS-1505031	Hex Socket Cap Screw	M10X25	16
13	JTM1055-L13	Key	3X3X25	4
14	JTM1055-L14N	Lead Screw for Ext. Bearing Bracket (s/n 120xxx and higher)		1
15	TS-1503041	Hex Socket Cap Screw	M6X25	8
16	TS-1550041	Washer	M6	2
17	JTM1055-L17	Feed Screw Nut for X axis		1
17-1	JTM1055-L17-1	Feed Screw Nut for Y axis		1
18	JTM1055-L18	Feed Nut Bracket		1
19	TS-1514011	Hex Socket Cap Screw	M6X12	9
20	JTM1055-L20	Cross Feed Bearing Bracket		1
21	JTM1055-L21	Cross Feed Screw		1
22	JTM1055-L22	Adjustable Feed Nut for X axis		1
22-1	JTM1055-L22-1	Adjustable Feed Nut for Y axis		1
24	JTM1055-L24	Spacer		3
25	JTM1055-L25	Lock Washer	M6	2
26	JTM1055-L26	Cross Head Screw		2



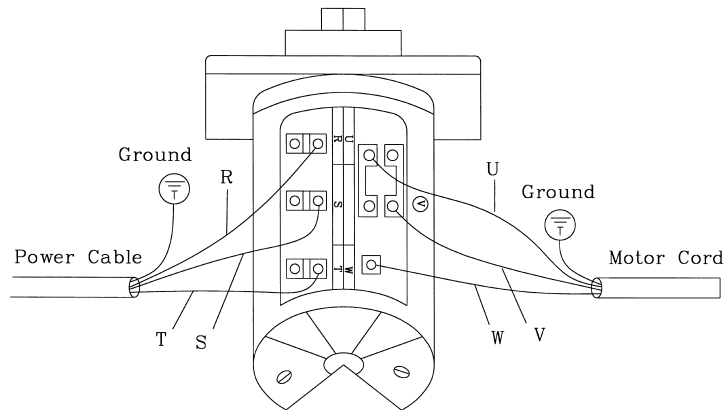
# One Shot Lubrication System

Index No	Part No	Description	Size	Qty
1	JTM1055-CLA	Lubricating Pump		1
2	ALMP-04	Aluminum Pipe	13.5x450L	1
3	A-8	Oil Regulating Distributor		1
4	JTM1055-A4	Oil Regulating Distributor		1
5	A-5	Flexible Steel Tube	4X550	1
6	PH-4011	Elbow joint		2
7	PI-401	Elbow joint		8
8	PA-4	Thimble Nut		26
9	PB-4	Thimble		26
10	PG-004	Union		1
11	TS-1503031	Hex Socket Cap Screw	M6X12	4
12	TS-1502061	Hex Socket Cap Screw	M5X25	4
13	PD-401	Straight Joint		1
14	A-14	Nylon Piece	4X700	1

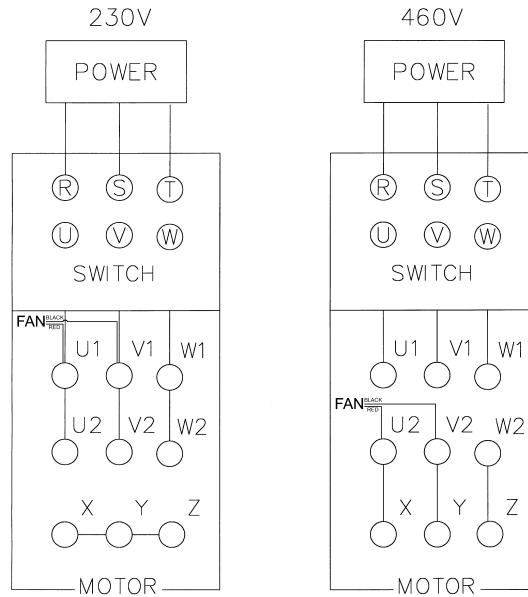


# Wiring

## Forward/Reverse Switch



## 230V and 460V Motor Configurations



## Ordering Replacement Parts

To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.



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