

J E T

BD-920W

METAL LATHE

321373M

230/50/1

**PARTS LIST
ERSATZTEILLISTE
LISTE DE PIECES**

WMH Tool Group AG

Bahnstrasse 24, CH – 8603 Schwerzenbach

www.wmhtoolgroup.ch; info@wmhtoolgroup.ch

Tel +41 (0) 44 806 47 48

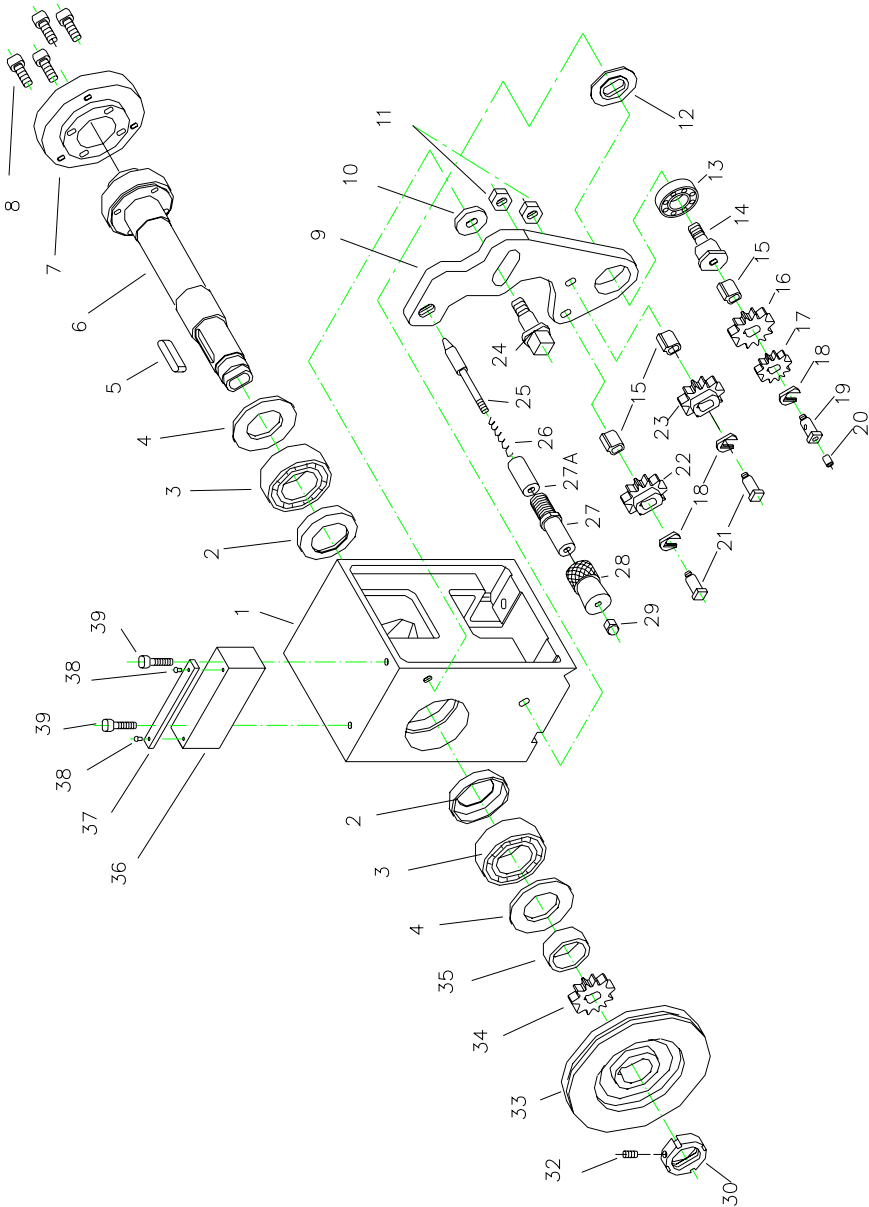
Fax +41 (0) 44 806 47 58



Table of contents

Table of contents	2
Headstock Assembly	3-4
Drive Assembly	5-7
Tension Roller Assembly	8-9
Quadrant Assembly	10-11
Electrical assembly.....	12-13
Gear Box Assembly.....	14-15
Apron Assembly	16-17
Apron Assembly(continued)	18-19
Saddle and Cross Slide Assembly	20-21
Top Slide Assembly	22-23
Tailstock Assembly	24-25
Steady Rest Assembly.....	26-27
Travel Rest Assembly.....	28-29
Lathe Bed Assembly.....	30-31
Wiring Diagram	32

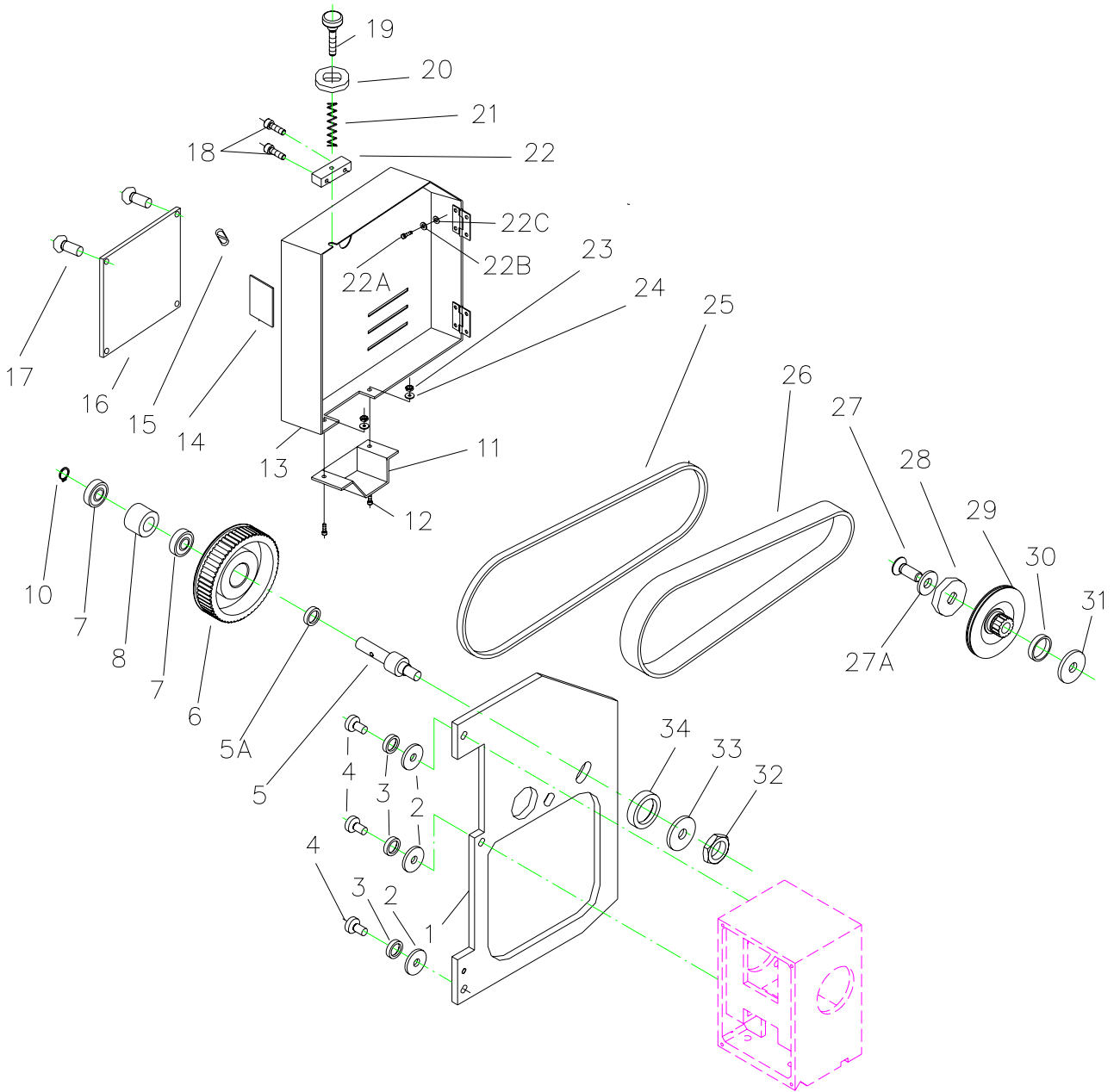
Headstock Assembly



Headstock Assembly

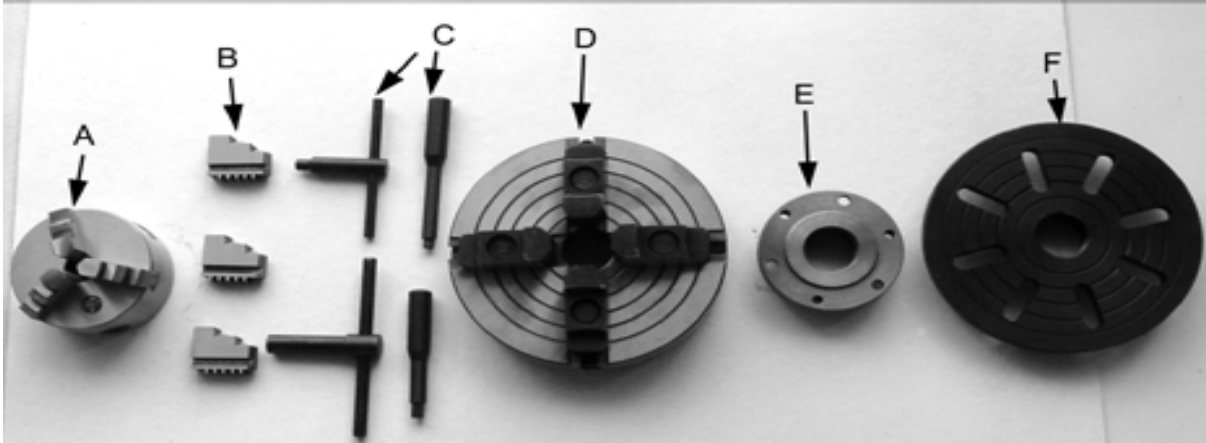
Index No.	Part No.	Description	Size	Qty.
1	1002	Headstock Casting		1
2	1003	Cover		2
3	32007	Ball Bearing		2
4	1005	Gasket		2
5	2008	Key	8X5X38	1
6	2106	Spindle		1
7	2107/1	Flange Joint		1
8	GB70-85	Hex Socket Cap Screw	M8x30	4
9	2133	Bracket		1
10	2129	Collar		1
11	GB6170-85	Hex Nut	M6	2
12	2127	Collar		1
13	61904	Ball Bearing	6904Z	1
14	2126/1	Shaft		1
15	1112	Bushing		3
16	1018	Gear	40T	1
17	2027	Gear	32T	1
18	1013	Washer		3
19	2126/2	Shaft		1
20	BD920N-009	Oil Port	6	1
21	2128	Shaft		2
22	1110	Gear	35T	1
23	1111	Gear	46T	1
24	2130	Screw		1
25	3004	Plunger		1
26	3005	Spring		1
27	3003	Bushing		1
27A	3003A	Spacer		1
28	3006	Handling		1
29	GB923-88	Cap Nut		1
30	1012	Nut		1
32	GB77-85	Set Screw	M5x6	1
33	1008	Pulley		1
34	1011	Gear	40T	1
35	1007	Spacing Ring		1
36	1114	Bracket		1
37	1115	Name Plate		1
38	GB818-85	Hex Screw	M3x5	4
39	GB70-85	Hex Socket Cap Screw	M6x35	2

Drive Assembly



Drive Assembly

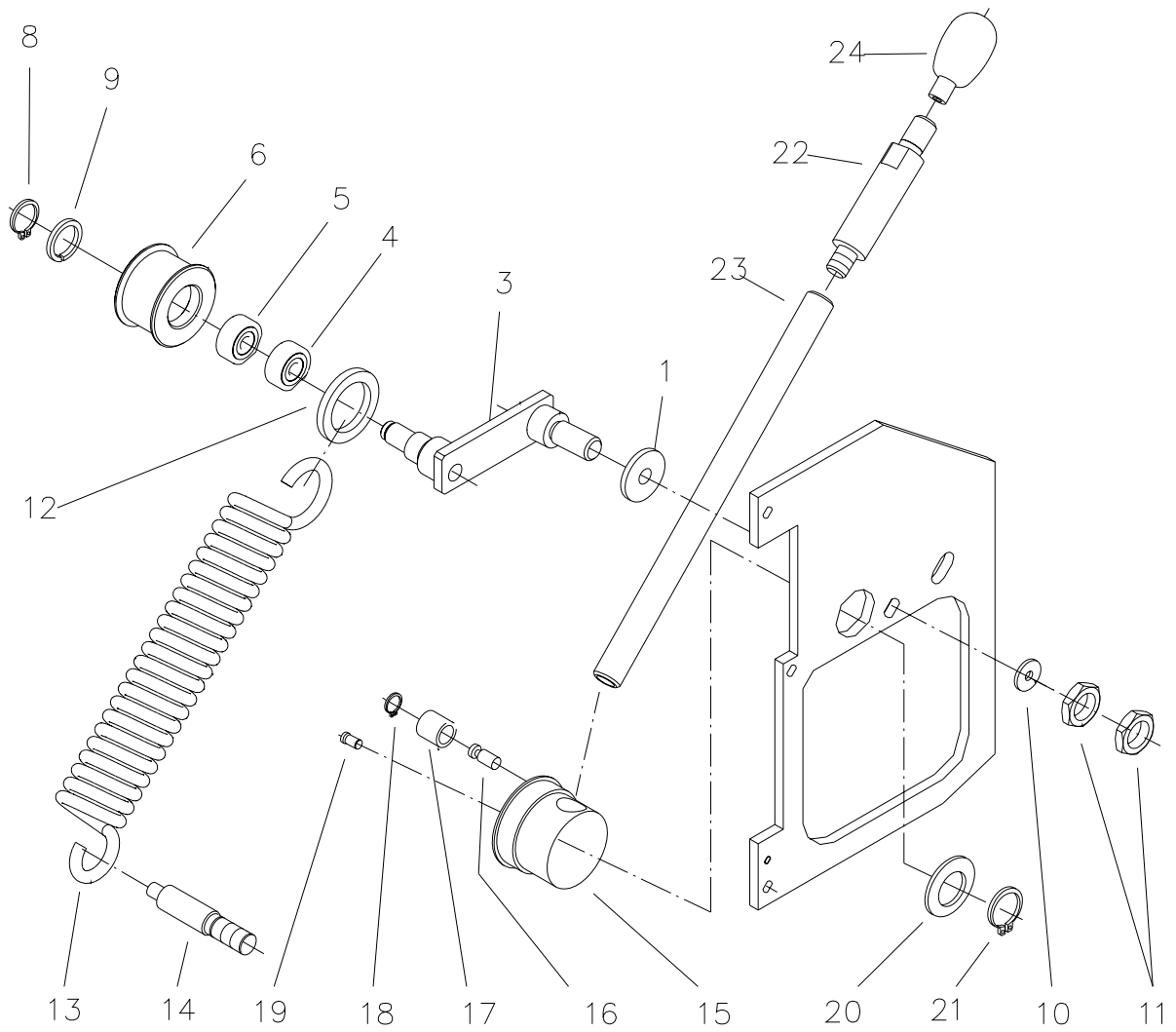
Index No.	Part No.	Description	Size	Qty.
A.....	BD920W-3JBSE.....	100mm 3-Jaw Chuck w/Back plate.....		1
B.....	BD920N-CJ3.....	Chuck Jaw Set.....		1
C.....	BD920N-ST.....	Spanner Tool for Chuck.....		1
D.....	FJ1001E.....	180mm 4-Jaw Chuck D1-38.....		1
E.....	FJ1002E.....	Back plate D1-38.....		1
F.....	FJ1003E.....	180mm Face Plate D1-38.....		1



Drive Assembly

Index No.	Part No.	Description	Size	Qty.
1	BD920W-0006	Bracket		1
2	GB95-85	Washer	8	3
3	GB95-87	Lock Washer	8	3
4	GB70-85	Hex Socket Cap Screw	M8x20	3
5	2113	Shaft		1
5A	1028	Washer		1
6	2112	Pulley		1
7	6001ZZ	Ball Bearing		1
8	2114	Spacer		1
9	6001ZZ	Ball Bearing		1
10	GB894-76	Snap Ring	12	2
11	GB818-85	Screw	M5x10	2
12	2110/1	Cover		1
13	BD920W-0007	Cover		1
14	2104	Label		1
15	1108	Label		1
16	2105	Name Plate		1
17	GB818-85	Screw	M3x4	4
18	GB70-85	Hex Socket Cap Screw	M6x20	2
19	GB70-85	Hex Socket Cap Screw	M6x25	1
20	GB93-87	Lock Washer	6	1
21	2003	Spring		1
22	2004	Bracket		1
22A	TS-1503011	Hex Socket Cap Screw	M6x12	4
22B	GB971-85	Lock Washer	6	4
22C	GB93-87	Washer	6	4
23	GB6170-85	Hex Nut	M5	2
24	GB93-87	Washer	5	2
25	VB-5M710	V-Belt		1
26	VB-170xL050	Cog Belt		1
27	GB818-85	Screw	M6X10	1
27A	GB971-85	Lock Washer	6	1
28	4033	Washer	6	1
29	1012	Pulley		1
30	1013	Collar		1
31	1014	Collar		1
32	GB6170-85	Hex Nut	M10	1
33	GB93-87	Lock Washer	10	1
34	2041/1	Washer	10	1

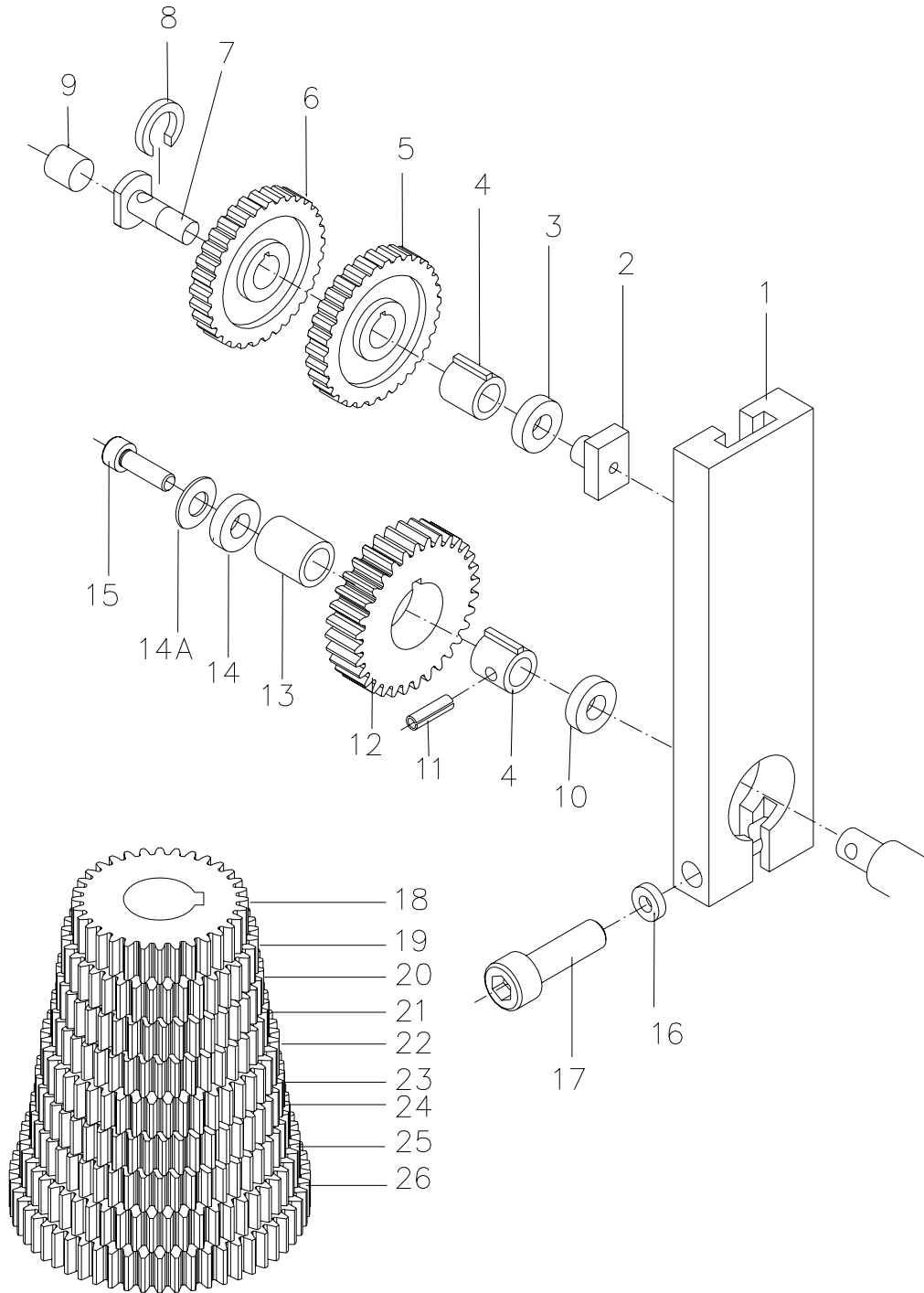
Tension Roller Assembly



Tension Roller Assembly

Index No.	Part No.	Description	Size	Qty.
1	1040N	Washer	12	1
3	1035A	Swing Arm		1
4	BD920N-TR05	Ball Bearing	6001RS	1
5	BD920N-TR05	Ball Bearing	6001RS	1
6	1039	Roller		1
8	BD920N-TR08	Snap Ring	12	1
9	BD920N-TR09	Snap Ring	28	1
10	TS-1550071	Washer	10	1
11	TS-1540071	Nut	M10	2
12	1036	Washer		1
13	1037	Spring		1
14	1050	Stud Bolt		1
15	1032	Toggle		1
16	1051	Pin		1
17	1033	Roller		1
18	BD920N-TR18	Snap Ring	6	1
19	TS-1524031	Set Screw	M8x12	1
20	1034	Wave Washer		1
21	BD920N-TR21	Snap Ring	34	1
22	1042	Lever		1
23	1043	Lever		1
24	1044A	Knob	M10x32	1

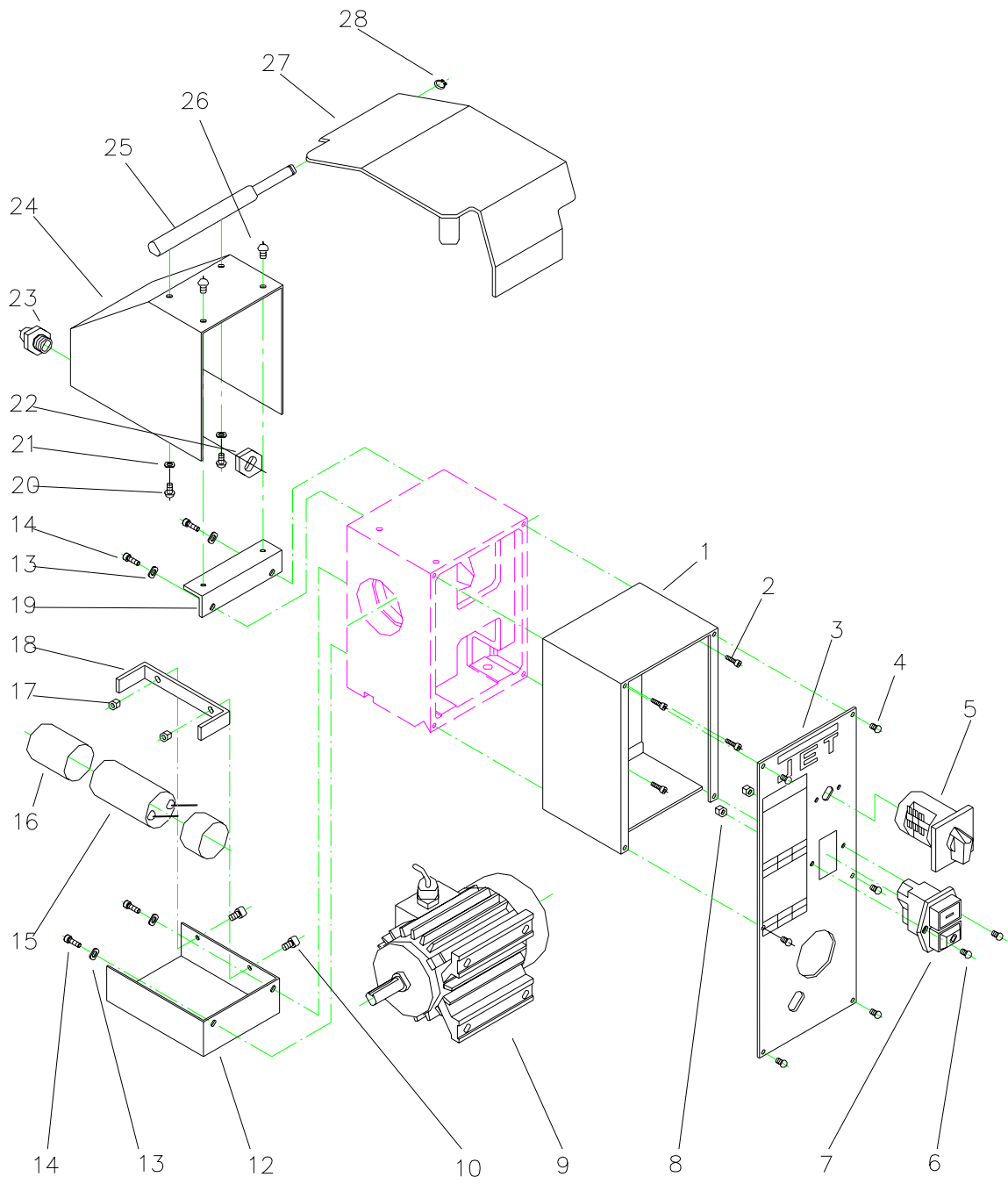
Quadrant Assembly



Quadrant Assembly

Index No.	Part No.	Description	Size	Qty.
1	2003A	Bracket		1
2	2004	T-Nut		1
3	TS-1550041	Washer		1
4	2009	Bushing		2
5	2001	Gear	127T	1
6	2002	Gear	120T	1
7	2005	Shaft		1
8	2006	Washer		1
9	BD920N-Q09	Oil Port	6	1
10	TS-1550071	Washer	10	1
11	BD920N-Q11	Pin	3x12	1
12	2071	Gear	60T	1
13	2008	Spacing Ring		1
14	TS-1550041	Washer	6	1
14A	GB971-85	Lock Washer	6	1
15	TS-1503011	Hex Socket Cap Screw	M6x12	1
16	TS-1551041	Lock Washer	6	1
17	TS-1503091	Hex Socket Cap Screw	M6x40	1
18	2070	Gear	32T	2
19	2011	Gear	36T	1
20	2020	Gear	38T	1
21	2072	Gear	40T	1
22	2073	Gear	44T	1
23	2074	Gear	46T	1
24	2075	Gear	48T	1
25	2076	Gear	52T	1
26	2014	Gear	56T	1

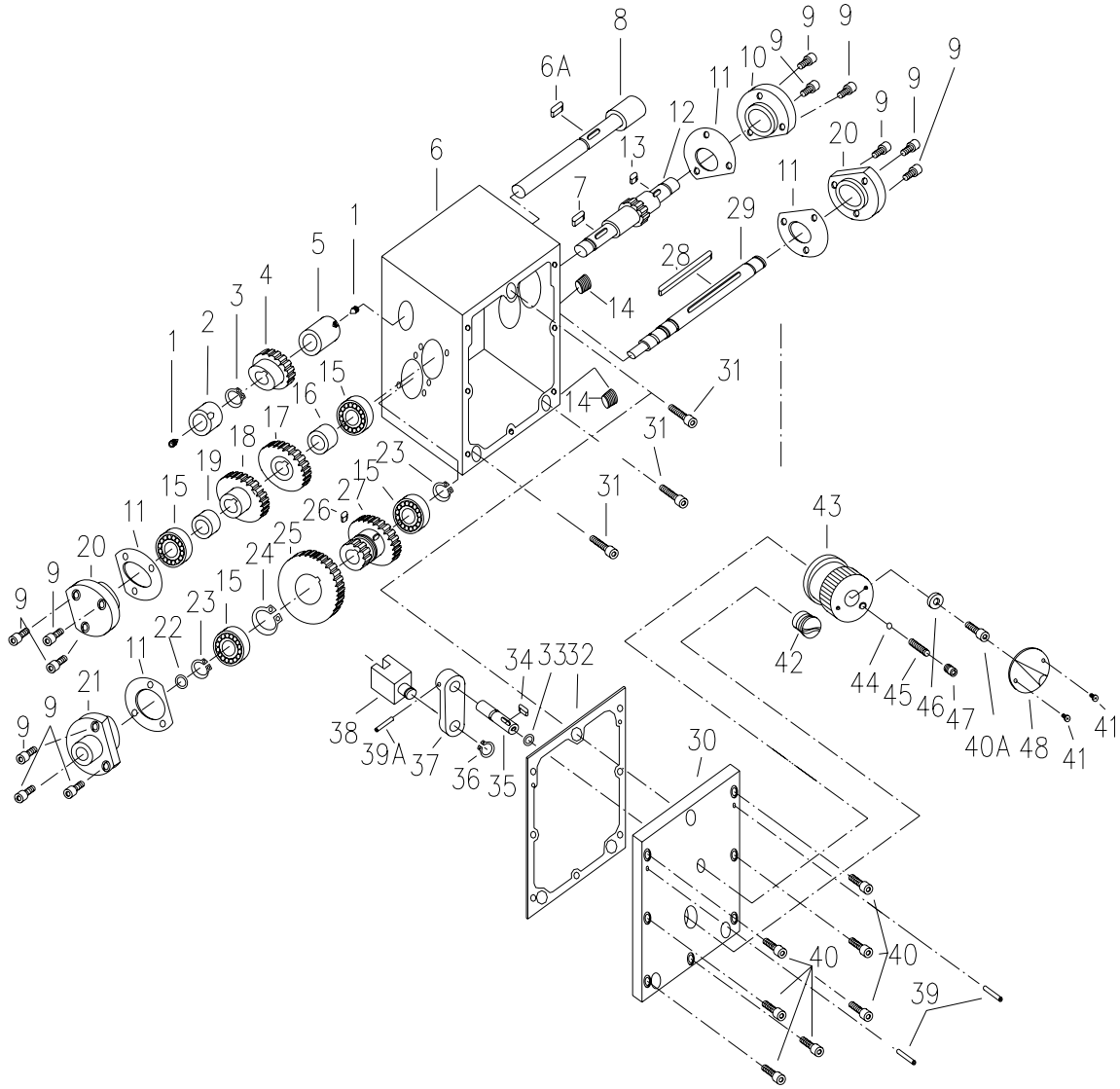
Electrical Assembly



Electrical Assembly

Index No.	Part No.	Description	Size	Qty.
1	1116	Electrical Control Box		1
2	GB70-85	Hex Socket Cap Screw	M5x12	4
3	BD920W-02001E	Plate		1
4	GB67-85	Screw	M3x5	6
5	BD920N-E21E	Switch	ZH-B	1
6	GB818-85	Screw	M4x12	2
7	BD920N-E20E	OFF Switch	KJD17B	1
8	GB6170-85	Hex Nut	M4	2
9	BD920N-E10E	Motor	230V,50HZ	1
10	TS-1502021	Screw	M4x8	2
12	1104	Housing		1
13	GB971-85	Lock Washer	6	4
14	GB70-85	Screw	M6x12	4
15	BD920N-E06	Condenser		1
16	BD920N-E05	Condenser Clip		1
17	TS-1540031	Nut	M5	2
18	BD920N-E16	Capacitor Support		1
19	1103	Bracket		1
20	GB818-85	Hex Screw	M5x10	2
21	GB95-85	Lock Washer	5	2
22	BD920N-E07	Lock Nut		1
23	BD920N-E08	Screw Coupling		1
24	1105	Housing		1
25	2108	Shaft		1
26	GB818-85	Hex Screw	M5x6	2
27	2109	Cover		1
28	GB893-76	Snap Ring	10	1

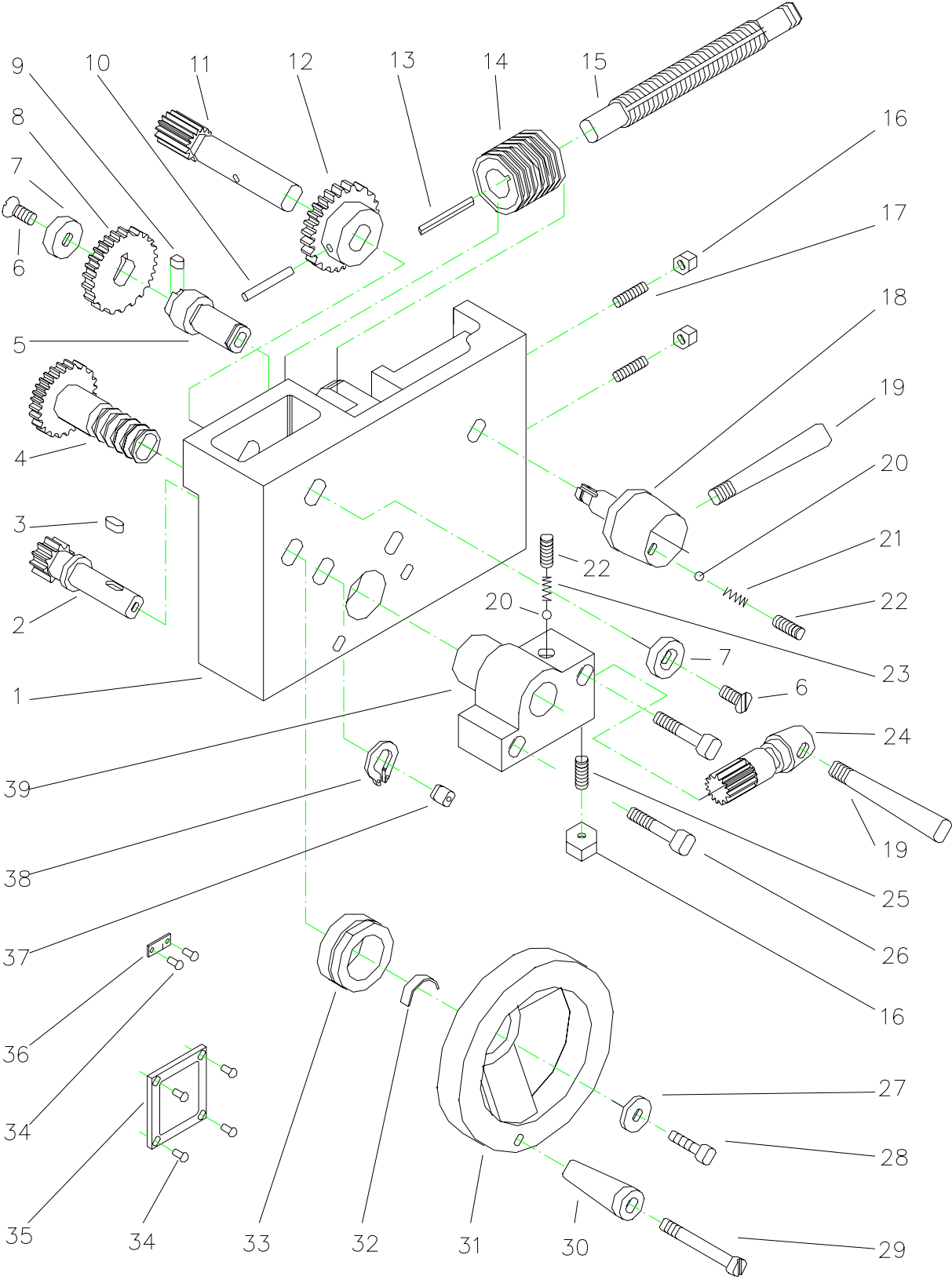
Gear Box Assembly



Gear Box Assembly

Index No.	Part No.	Description	Size	Qty.
1	BD920N-GB01	Set Screw	M5x6	2
2	BD920N-GB02	Bushing		1
3	BD920N-GB03	Snap Ring	16	1
4	CQ6123B-3114	Gear	27T	1
5	CQ6123B-3115	Bushing		1
6	CQ6123B-3101	Gear Box Casting		1
6A	CQ6123B-3101A	Key	5x8	1
7	BD920N-GB07	Key	5x16	1
8	CQ6123B-3113	Shaft		1
9	BD920N-GB09	Hex Socket Cap Screw	M6x10	12
10	CQ6123B-3122	Cover		1
11	CQ6123B-3110	Gasket		4
12	CQ6123B-3108	Gear Shaft Assembly		1
13	BD920N-GB13	Key	5x10	1
14	BD920N-05-75	Oiling Plug		1
15	6202ZZ	Ball Bearing	6202ZZ	4
16	CQ6123B-3123	Bushing		1
17	CQ6123B-3124	Gear	27T	1
18	CQ6123B-3111	Gear	36T	1
19	CQ6123B-3109	Bushing		1
20	CQ6123B-3107	Cover		2
21	CQ6123B-3105	Cover		1
22	BD920N-GB22	O-Ring	10.6x1.8	1
23	BD920N-GB23	Snap Ring	15	2
24	BD920N-GB24	Snap Ring	30	1
25	CQ6123B-3103	Gear	36T	1
26	CQ6123B-3121	Key	5x8	1
27	CQ6123B-3102	Gear	18T 27T	1
28	CQ6123B-3104	Key	5x68	1
29	CQ6123B-3106	Shaft		1
30	CQ6123B-3118	Cover		1
31	BD920N-GB31	Hex Socket Cap Screw	M8x20	3
32	CQ6123B-3117	Gasket		1
33	GB3452.1-82	O-Ring	8.75x1.8	1
34	GB1096-79	Key	4x12	1
35	CQ6123B-3116	Shaft		1
36	BD920N-GB36	Snap Ring	12	1
37	CQ6123B-3119	Shift Lever		1
38	CQ6123B-3120	Shift Fork		1
39	BD920N-GB39	Spring Pin	4x20	2
39A	BD920N-GB39A	Spring Pin	5x25	1
40	BD920N-GB40	Hex Socket Cap Screw	M5x14	7
40A	BD920N-GB40A	Hex Socket Cap Screw	M6x12	1
41	BD920N-GB41	Pan Head Machine Screw	M3x6	2
42	BD920N-GB42	Oil Sight Glass		1
43	BD920N-05-09	Knob		1
44	GB308-84	Steel Ball	6	1
45	GB2089-80	Spring	1x6x30	1
46	BD920N-05-08	Washer		1
47	BD920N-GB47	Set Screw	M8x8	1
48	BD920N-05-70	Plate		1

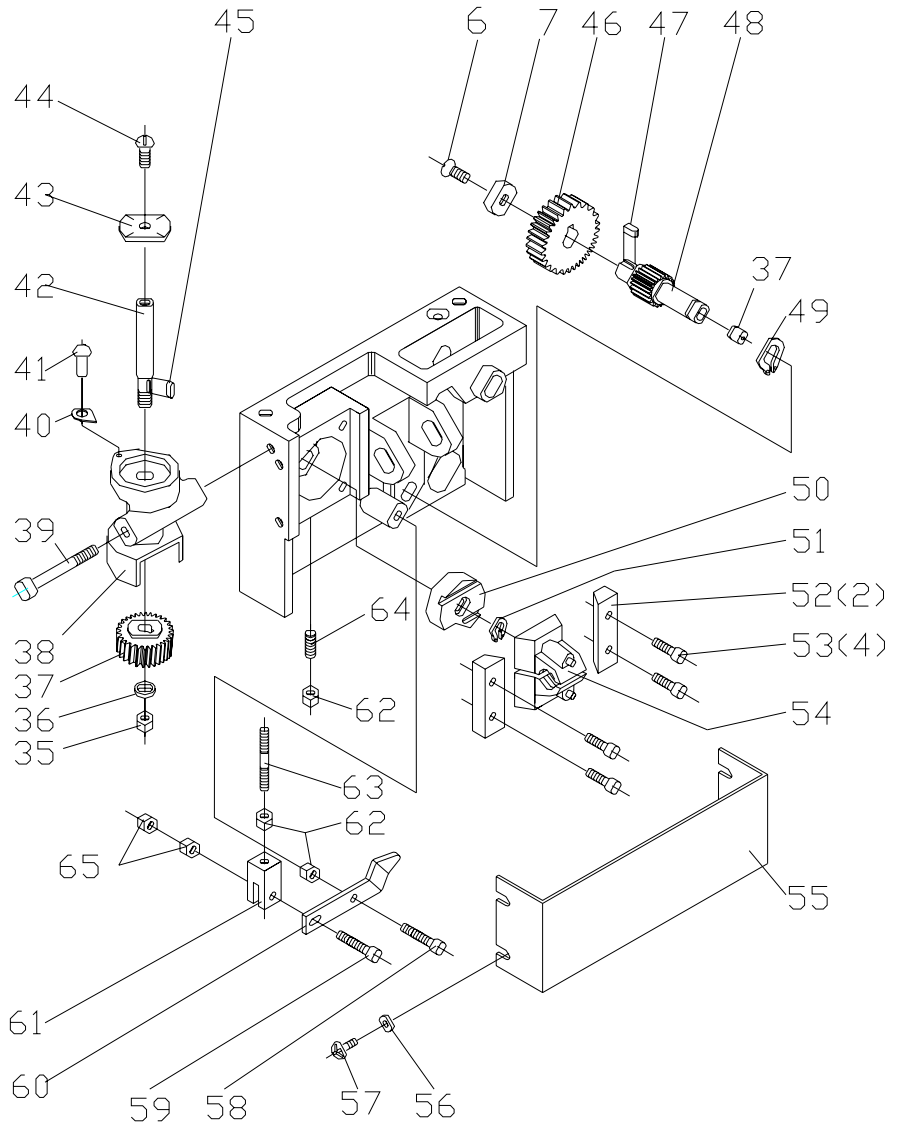
Apron Assembly



Apron Assembly

Index No.	Part No.	Description	Size	Qty.
1	4006	Apron Casting		1
2	4109	Gear	17T	1
3	GB1196-79	Key	4x10	1
4	4011	Gear	36T	1
5	4009	Shaft		1
6	BD920N-A14	Flat Head Screw	M6x12	3
7	4005	Washer		3
8	4010	Gear	41T	1
9	BD920N-A26	Key	4x6	1
10	BD920N-A16	Spring Pin	4x30	1
11	4008	Gear	12T	1
12	4007	Gear	43T	1
13	BD920N-A04	Key	3x28	1
14	4033	Worm		1
15	7003E	Feed Screw		1
16	TS-1540021	Nut	M4	3
17	TS-1521051	Set Screw	M4x12	2
18	0002	Shaft		1
19	4106	Handle		2
20	BD920N-A09	Steel Ball	5	2
21	4021	Spring		1
22	TS-1523011	Set Screw	M6x6	2
23	4025	Spring		1
24	4014	Gear	13T	1
25	TS-1521041	Set Screw	M4x10	1
26	TS-1503071	Hex Socket Cap Screw	M6x30	2
27	4111	Washer		1
28	GB70-85	Hex Socket Cap Screw	M6x12	1
29	4002	Screw		1
30	4001	Handle		1
31	4003	Hand Wheel		1
32	5023	Spring		1
33	4108	Micrometer Collar		1
34	BD920N-A36	Rivet	M2x6	6
35	4018	Label		1
36	4110	Label		1
37	BD920N-A29	Oil Port	6	2
38	BD920N-A28	Ring	14	1
39	4013	Bracket		1

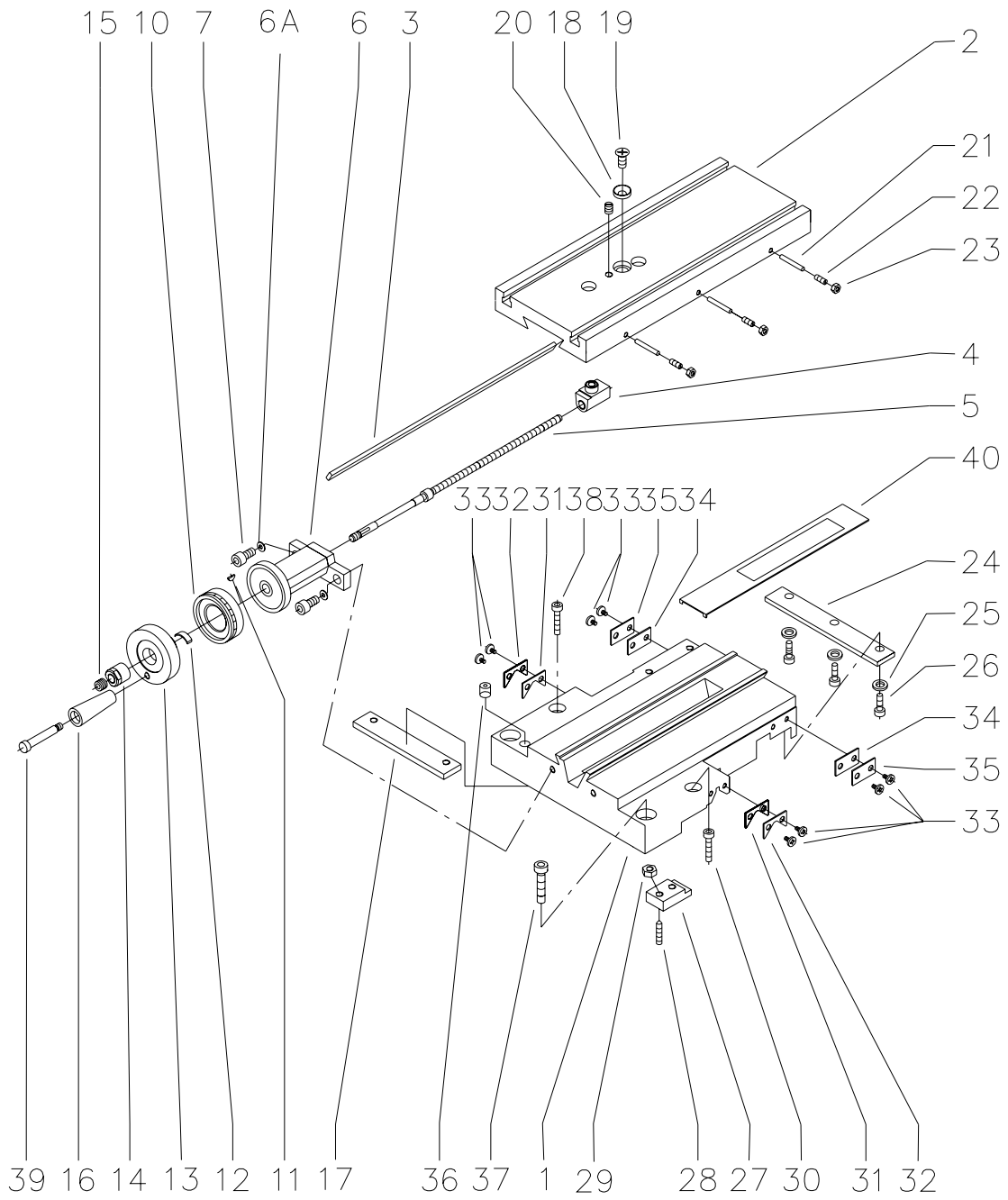
Apron Assembly (continued)



Apron Assembly (continued)

Index No.	Part No.	Description	Size	Qty.
35	TS-1540061	Hex Nut	M8	1
36	TS-1550061	Lock Washer	8	1
37	4029	Worm Gear	64T	1
38	4036	Thread Dial Body		1
39	TS-1503131	Hex Socket Cap Screw	M6x65	1
40	4024	Pointer		1
41	BD920N-A62	Rivet	1.5x5	2
42	4028	Shaft		1
43	4027	Dial		1
44	TS-1503011	Screw	M6x8	1
45	BD920N-A56	Key	3x8	1
46	4012	Worm Gear	42T	1
47	BD920N-A38	Key	4x10	1
48	4016	Gear	18T	1
49	BD920N-A40	Snap Ring	12	1
50	4019	Locking Cam		1
51	BD920N-A44	Ring	8	1
52	4020	Guide		2
53	TS-1501051	Hex Socket Cap Screw	M4x16	4
54	4017E	Half Nut		1
55	4023	Apron Cover		1
56	TS-1550021	Washer	4	4
57	TS-1532021	Screw	M4x6	4
58	TS-1502041	Hex Socket Cap Screw	M5x16	1
59	TS-1501061	Hex Socket Cap Screw	M4x20	1
60	4032	Joint Plate		1
61	4030	Control Block		1
62	TS-1540031	Hex Nut	M5	3
63	4031	Screw		1
64	BD920N-A46	Set Screw	M5x35	1
65	BD920N-GB65	Hex Nut	M4	2

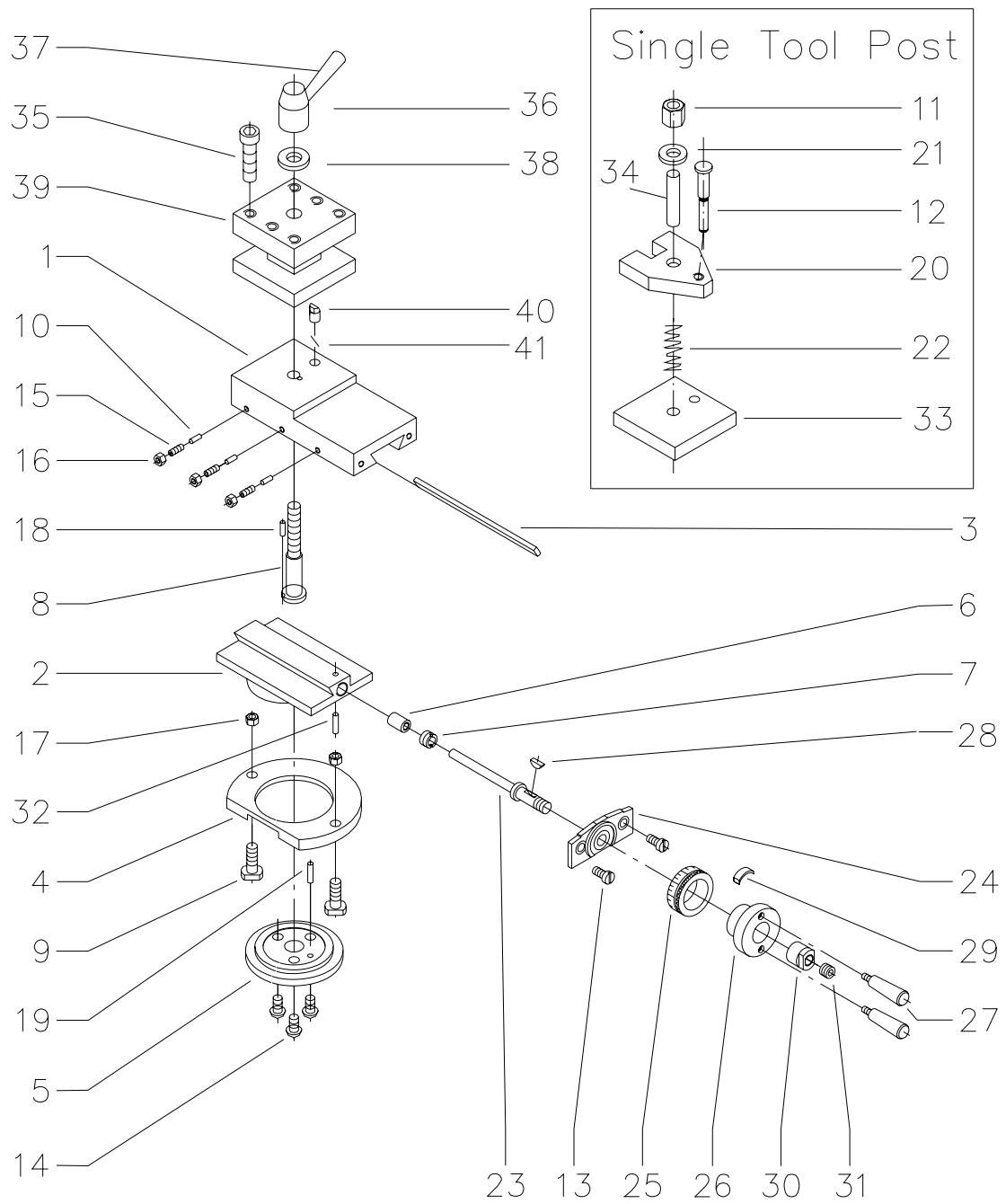
Saddle and Cross Slide Assembly



Saddle and Cross Slide Assembly

Index No.	Part No.	Description	Size	Qty.
1	5005	Saddle		1
2	5006	Cross Slide		1
3	5002	Gib		1
4	5036	Nut		1
5	5018	Lead Screw		1
6	5019	Bracket		1
6A	GB93-87	Washer	6	2
7	TS-1503031	Hex Socket Cap Screw	M6x16	2
10	5020	Graduated Ring		1
11	BD920N-CS11	Key	3x10	1
12	5023	Spring		1
13	5021	Hand Wheel		1
14	5022	Nut		1
15	BD920N-CS15	Set Screw	M8x6	1
16	5025	Handle		1
17	5003	Slide Block		1
18	5037	Bushing		1
19	TS-1534041	Flat Head Screw	M6x10	1
20	TS-1523021	Set Screw	M6x8	1
21	5001	Pin		3
22	TS-1521041	Set Screw	M4x10	3
23	TS-1540021	Nut	M4	3
24	5016	Slide Block		1
25	TS-1550041	Washer	6	3
26	TS-1503041	Hex Socket Cap Screw	M6x12	3
27	5017	Clip		1
28	TS-1523061	Set Screw	M6x20	1
29	TS-1540041	Nut	M6	1
30	TS-1503061	Hex Socket Cap Screw	M6x25	1
31	5042	Way Cover		2
32	5041	Cover Mount		2
33	TS-1532012	Pan Head Screw	M4x10	8
34	5040	Way Cover		2
35	5039	Cover Mount		2
36	BD920N-CS36	Oil Port	8	1
37	TS-1504061	Hex Socket Cap Screw	M8x30	2
38	TS-1503061	Hex Socket Cap Screw	M6x25	2
39	5024	Handle Screw		1
40	5038	Cover Mount		1

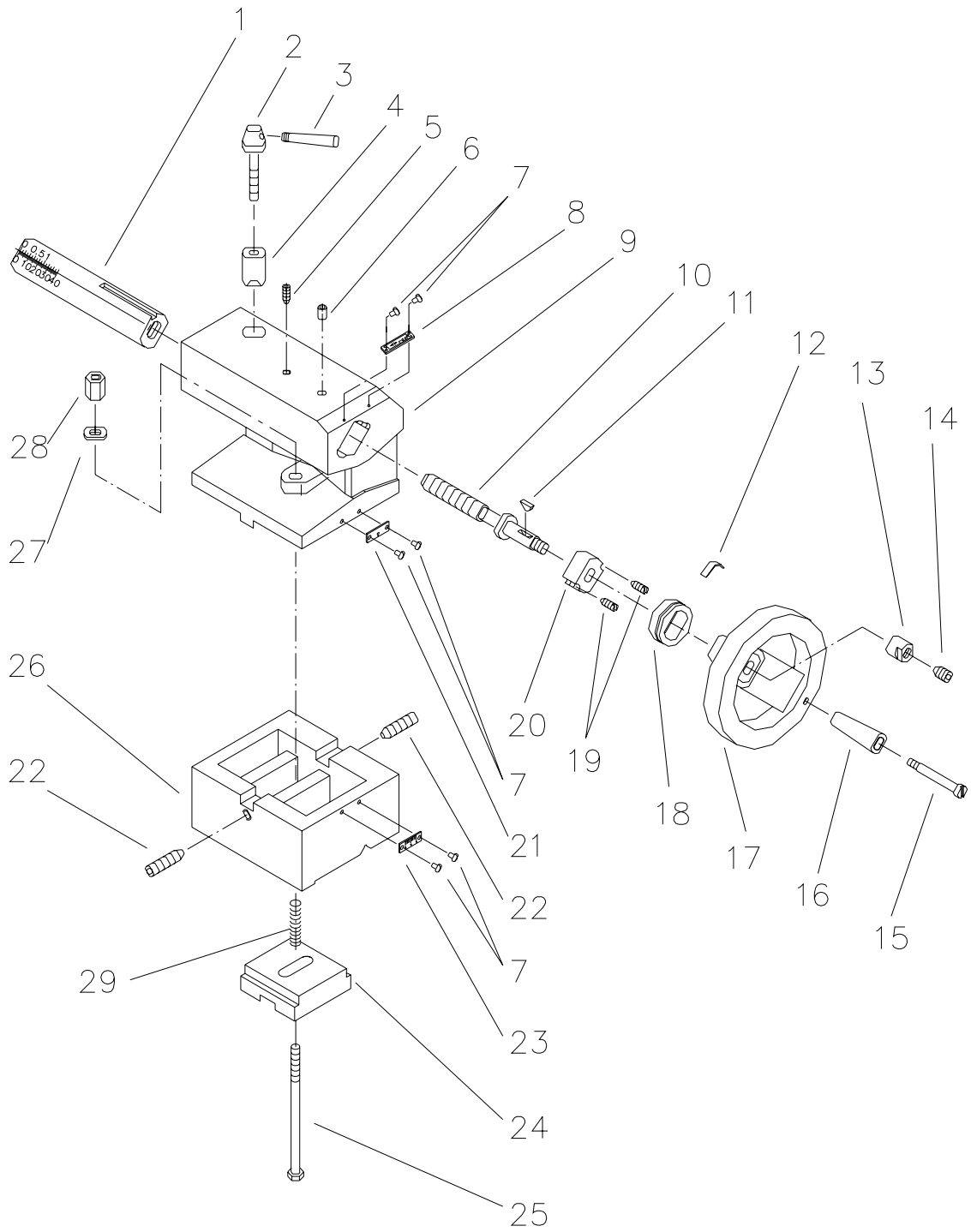
Top Slide Assembly



Top Slide Assembly

Index No.	Part No.	Description	Size	Qty.
	BD920N-TSA	Top Slide Assembly without Tool Post		1
	BD920N-TP	Four Way Tool Post Complete		1
1	5011	Longitudinal Slide		1
2	5010	Swivel Base		1
3	5028	Gib		1
4	5008	Clamping Ring		1
5	5009	Micrometer Pan		1
6	5013	Lead Screw Nut		1
7	5014	Adjusting Screw		1
8	5033	Screw		1
9	5007	T-Screw		2
10	5027	Pin		3
13	TS-1502021	Flat Head Screw	M5x10	2
14	BD920N-TS14	Hex Socket Cap Screw	M6x8	3
15	TS-1521041	Set Screw	M4x10	3
16	TS-1540021	Nut	M4	3
17	TS-1540041	Nut	M6	2
18	BD920N-TS18	Lock Pin	4x12	1
19	BD920N-TS19	Lock Pin	3x12	3
23	5012	Lead Screw		1
24	5043	Lead Screw Mount		1
25	5004	Micrometer Collar		1
26	5031	Handwheel		1
27	5015	Handle		2
28	BD920N-TS28	Key	3x13	1
29	5023	Feed Spring		1
30	5022	Nut		1
31	BD920N-TS31	Set Screw	M8x6	1
32	BD920N-TS32	Lock Pin	3x12	1
35	BD920N-TS35	Bolt	M8x30	8
36	BD920N-HS	Handle Seat		1
37	BD920N-HS	Handle		1
38	BD920N-TS38	Washer		1
39	BD920N-TS39	4 Way Tool Post		1
40	BD920N-TS40	Pin		1
41	BD920N-TS41	Spring		1
(See below : optional for single Tool post assembly)				
11	5032	Nut		1
12	TS-1490051	Hex Cap Bolt	M8x30	1
20	5030	Tool Clamp		1
21	BD920N-TS21	Washer	8	1
22	5034	Spring		1
33	5029	Plate		1
34	5035	Pin		1

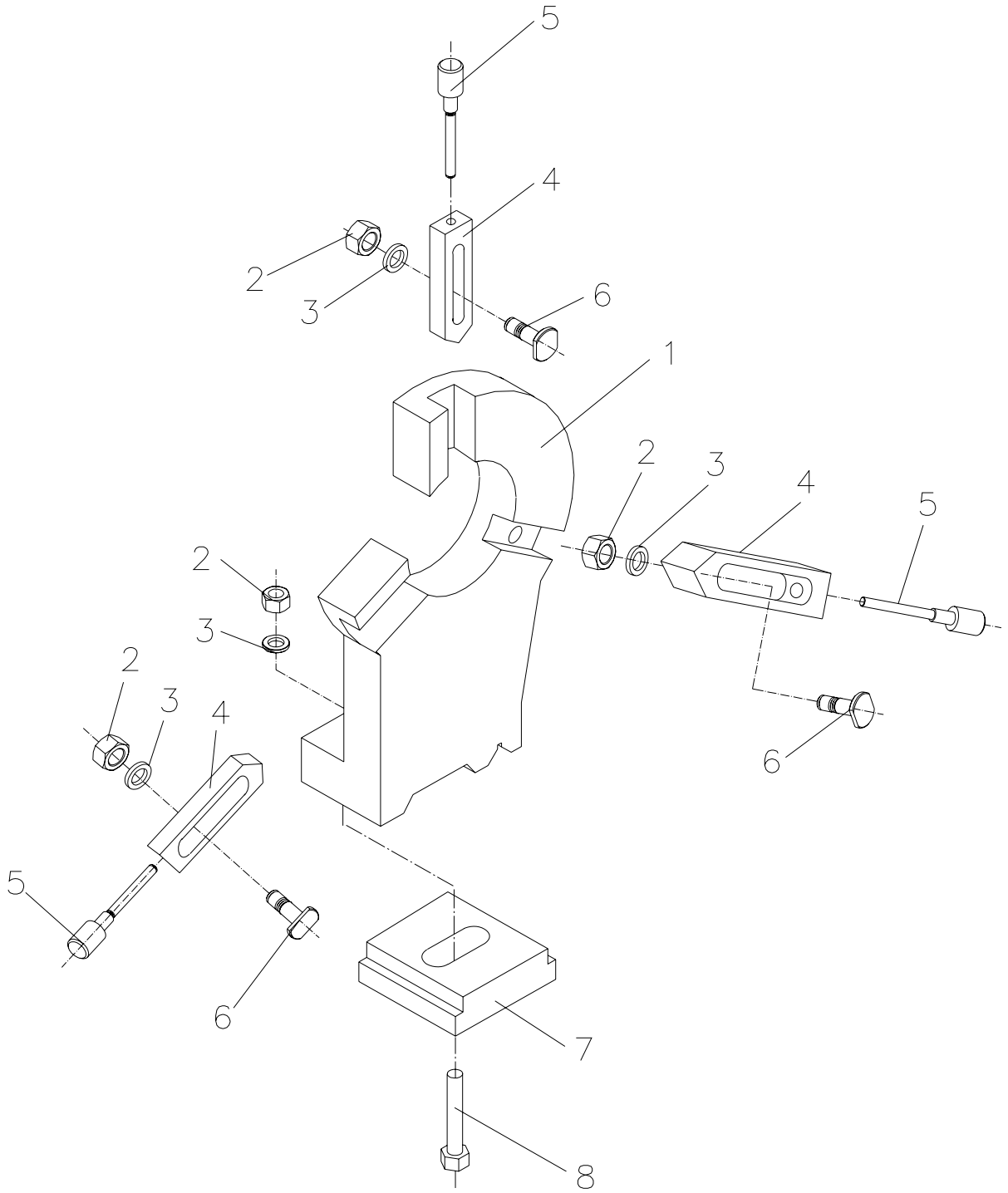
Tailstock Assembly



Tailstock Assembly

Index No.	Part No.	Description	Size	Qty.
1	8009	Tailstock Ram		1
2	8008	Lever		1
3	BD920N-HS	Handle		1
4	8001	Clamp		1
5	BD920N-T08	Guide Pin	M5x10	1
6	BD920N-T20	Oil Port	6	1
7	BD920N-T19	Rivet	1.5x5	6
8	8012E	Label		1
9	8005	Tailstock Body		1
10	8010	Leadscrew		1
11	BD920N-T17	Key	3x10	1
12	5023	Spring		1
13	8014	Nut		1
14	TS-1524011	Set Screw	M8x8	1
15	4002	Screw		1
16	4001	Handle		1
17	8013	Hand Wheel		1
18	8016	Micrometer Collar		1
19	BD920N-T27	Screw	M5x6	2
20	8011	Bushing		1
21	BD920N-T26	Label		1
22	TS-1524061	Set Screw	M8x25	2
23	BD920N-T25	Offset Indicating Plate		1
24	8015	Clamping Plate		1
25	8007	Hex Cap Bolt	M8x100	1
26	8002	Tailstock Base		1
27	TS-1550061	Washer	8	1
28	8006	Nut	M8	1

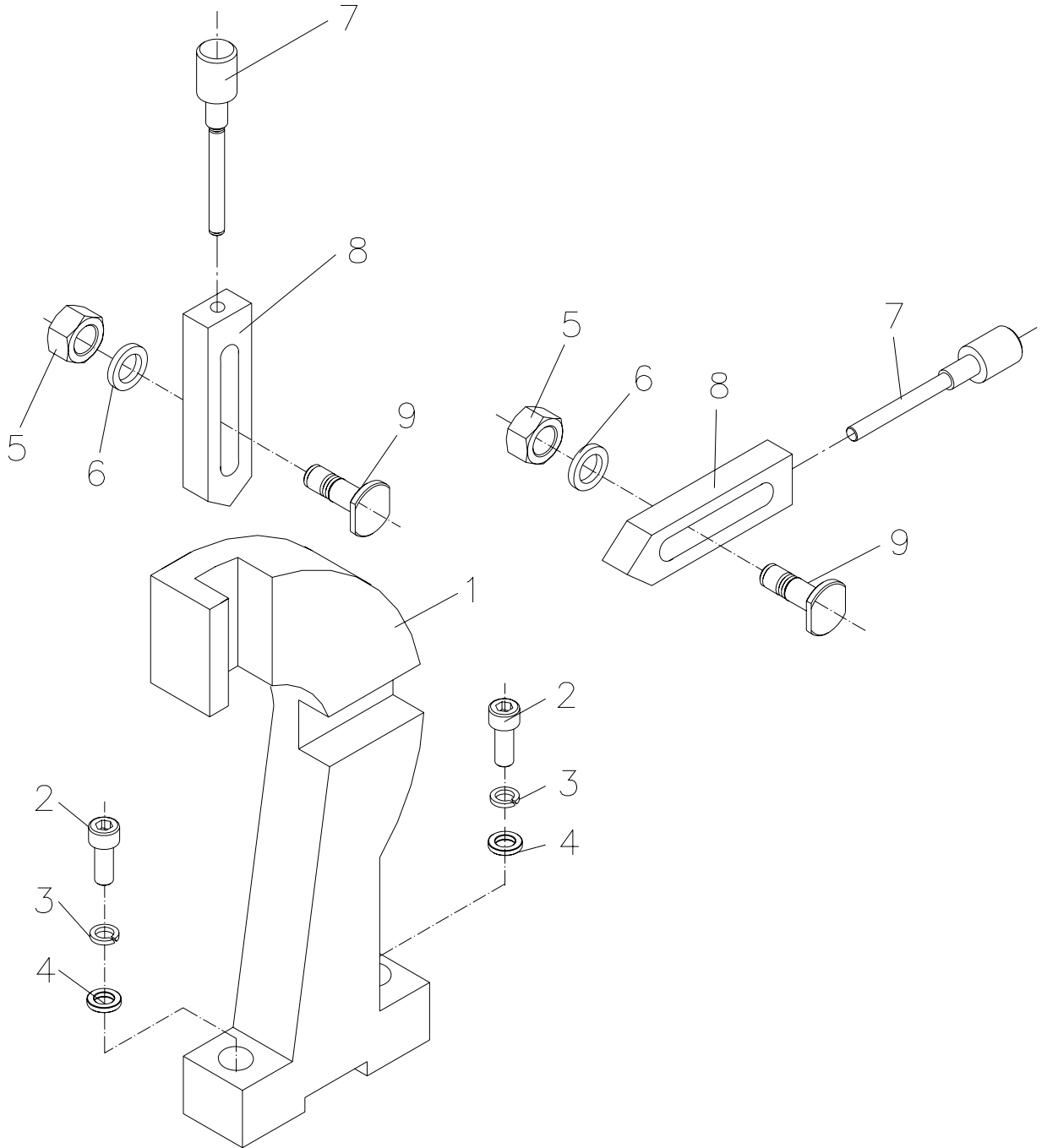
Steady Rest Assembly



Steady Rest Assembly

Index No.	Part No.	Description	Size	Qty.
1	F1001	Rest Casting		1
2	TS-1540061	Nut	M8	4
3	TS-1551081	Lock Washer	8	3
4	F1002	Jaw		3
5	F1004	Adjusting Screw		3
6	F1003	Screw		3
7	F1005	Clamping Plate		1
8	TS-1490091	Hex Cap Bolt	M8x50	1
	BD920N-SR	Steady Rest Complete		

Travel Rest Assembly

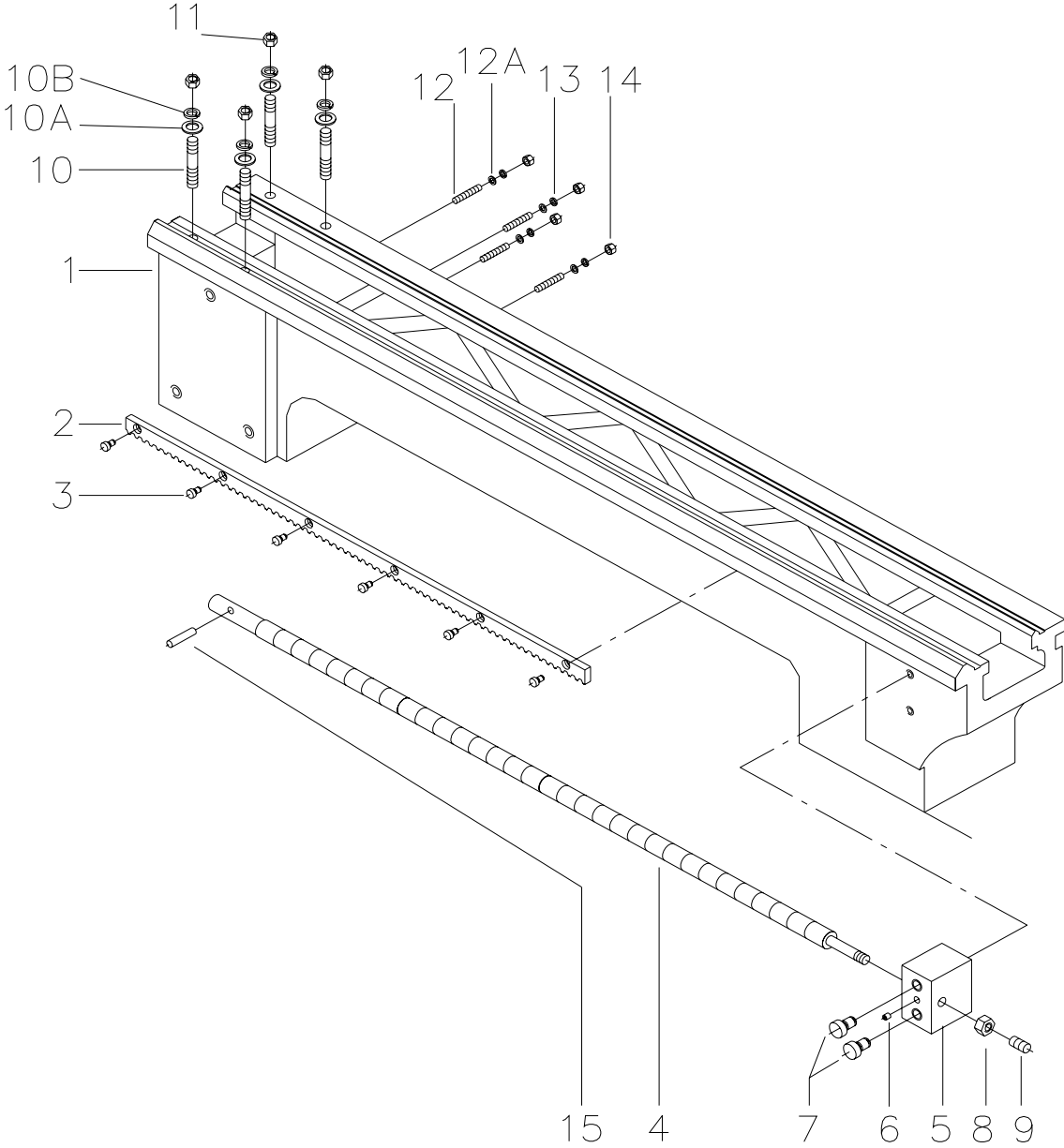


Travel Rest Assembly

Index

No	Part No	Detail	Size	Qty
1	F2001	Rest Casting		1
2	TS-1503061	Hex Socket Cap Screw	M6x25	2
3	TS-1551061	Lock Washer	6	2
4	TS-1550041	Washer	6	2
5	TS-1540061	Hex Nut	M8	2
6	TS-1551081	Lock Washer	8	2
7	F2004	Adjusting Screw		2
8	F2002	Jaw		2
9	F2003	Screw		2
	BD920N-FR	Follow Rest Assembly		1

Lathe Bad Assembly



Lathe Bed Assembly

Index No.	Part No.	Description	Size	Qty.
1	7001	Bed		1
2	7002	Rack		1
3	TS-1501021	Hex Socket Cap Screw	M4x8	6
4	7003E	Leadscrew		1
5	7004	Bracket		1
6	BD920N-B06	Oil Port	6	1
7	TS-1503051	Hex Socket Cap Screw	M6x40	2
8	7006	Nut		1
9	BD920N-B09	Set Screw	M8x8	1
10	7005	Stud	M8x46	4
10A	TS-1550061	Flat Washer	8	4
10B	TS-1551061	Lock Washer	8	4
11	TS-1540061	Hex Nut	M8	4
12	TS-1523081	Set Screw	M6x30	4
12A	TS-1550041	Flat Washer	6	4
13	TS-1551041	Lock Washer	6	4
14	TS-1540041	Hex Nut	M6	4
15	BD920N-B15	Pin	φ4x25	1
16	BD920N-B16	Label		1
17	BD920N-B17	Rivet		4

BD-920W

321373M

	colour of strands	Litzenfarben	couleur des cordons
BK	black	schwarz	noir
WH	white	weiß	blanc
BU	blue	blau	bleu
YE	yellow	gelb	jaune
RD	red	rot	rouge
BN	brown	braun	brun
GY	grey	grau	gris
GNYE	green-yellow	grün-gelb	vert-jaune
OG	orange	orange	orange
VT	violet	violett	violet

	meaning of symbol	Bedeutung der Zeichen	interprétation
M	motor	Motor	moteur
S	switch	Schalter	interrupteur
C	condenser	Kondensator	condensateur
E	electronic unit	Elektronik Einheit	unité électronique
F	fuse	Sicherung	fusible
RS	reversing switch	Drehrichtungsschalter	commu. droite/gauche
CS	centrifugal switch	Fliehkraftschalter	déclencheur centrifuge
OL	overload cut-off	Überlastschutzschalter	déclencheur surcharge
LS	limit switch	Positionsendschalter	micro

230V/50HZ / 1

