

POWERMATIC[®]

WMH | TOOL GROUP

Operating Instructions and Parts Manual Spindle Shaper

Models: 27 and 27Super



27 Super shown

WMH TOOL GROUP

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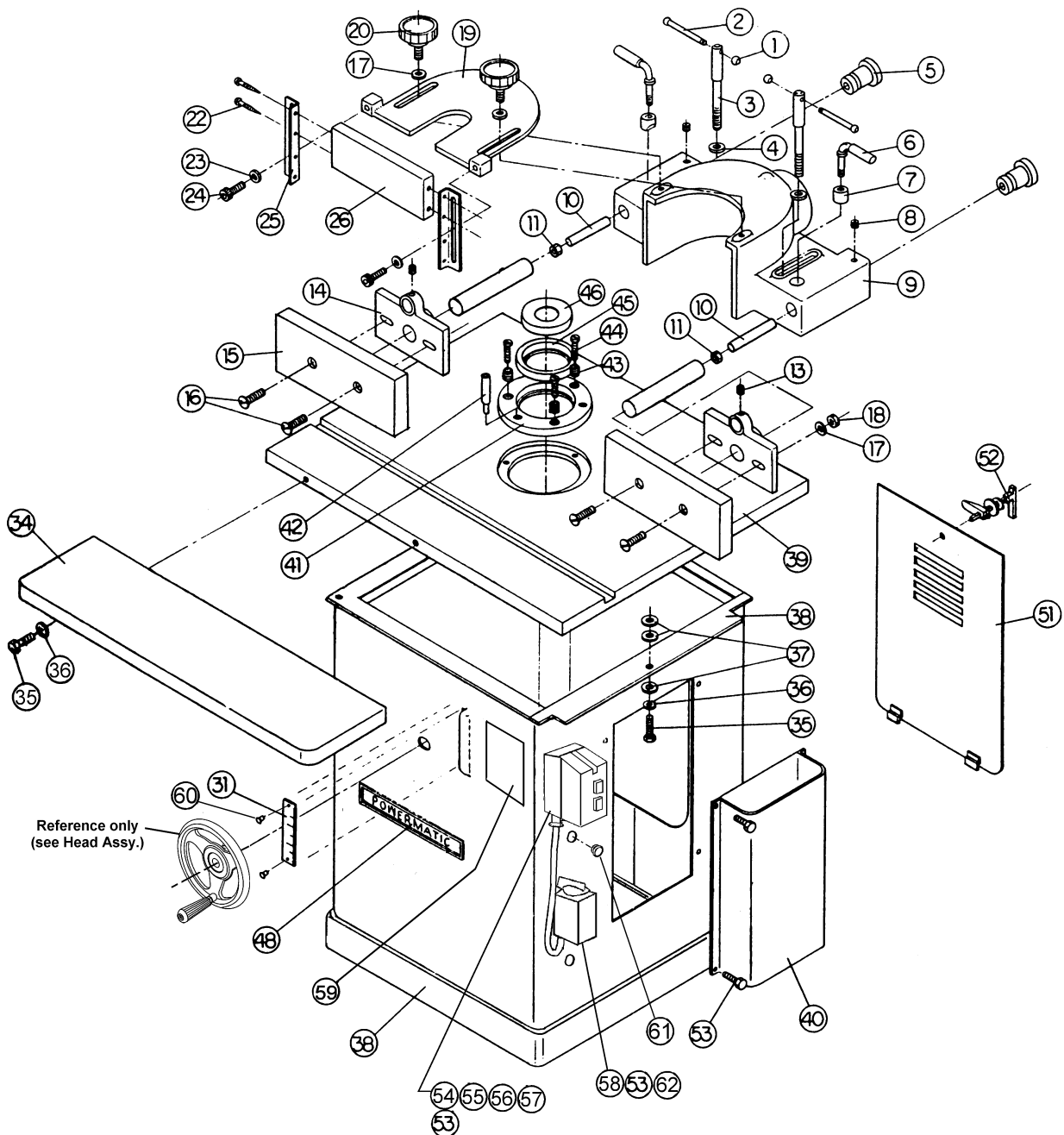
Part No. M-0460232
Revision H 9/04
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PARTS LIST: Table, Stand & Fence (27 & 27S Shapers)

No.	Part No.	Description	Quantity
	2195038	Fence Assembly (Items 1 thru 26)	1
	2195039	Fence Assembly for 30 X 40 Table	1
	2695040	Lock Screw Assembly (Items 1 thru 3)	2
1	3406016	Handle Knob	1
2	3268002	Handle	1
3	3695207	Lock Screw	1
4	3838008	Washer, 1/2	2
5	3406235	Adjustment Knob	2
6	3268001	Handle	2
7	3728005	Quill Lock Sleeve	2
8	6716100	Half Dog Set Screw, 3/8-16 x 3/4 Lg	2
9	3056026	Fence Body	1
10	3773326	Stud	2
11	6516009	Hex Jam Nut, 3/8-16	2
13	6715013	Socket Set Screw, 5/16-18 x 3/8 Lg	2
14	2063173	Rod and Bracket Assembly	2
15	3195025	Wood Fence	2
	3195026	Wood Fence, 30 X 40 Table RH	1
	3195027	Wood Fence, 30 X 40 Table LH	1
16	6715051	Flat Head Screw, 5/16-18 x 1-1/2 Lg	4
17	6861205	Flat Washer (Zinc Plated), 5/16	6
18	6715007	Hex Nut	4
19	3104618	Top Cover	1
20	6430041	Knob	2
22	6749008	Round Head Wood Screw, #10 x 5/8 Lg	4
23	6861200	Med. Lock Washer, 5/16	2
24	6715024	Socket Head Cap Screw, 5/16-18 x 5/8 Lg	2
25	3019071	Fence Angle	2
26	3195024	Guard	1
31	3684203	Plate Scale	1
34	3186008	8" Table Extension (model 27 only)	1
35	6716031	Hex Head Cap Screw, 3/8-16 x 1 Lg	3 [6 on 27S]
36	6861300	Helical Spring Lock Washer, 3/8	3 [6 on 27S]
37	6861301	Flat Washer, 3/8	6
38	2759006	Shaper Stand Assembly (Weldment)	1
39	3797042	Shaper Table, 28 x 21-1/2	1
	3797422	30 X 40 Table less Mitre Slot	1
	3797423	30 X 40 Table with Mitre Slot	1
40	2104003	Motor Cover Assembly (Weldment)	1
41	3595013	Shaper Table Plate	1
42	3585014	Starter Pin	1
43	3696201	Set Screw	3
44	6714037	Fillister Head Machine Screw (Plated), 1/4-20 x 1 Lg	3
45	3328202	Ring Insert	1
46	3078007	Cap	1
	2388035	Shaper Kit Plate (Items 47 thru 54)	1
48	3312341	Powermatic Logo	1
	2136001	Door Assembly (Items 51 & 52)	1
51	2136004	Door Assembly (Weldment)	1
52	6440003	Latch	1
53	6710153	Self Tap Screw, #10-24 x 1 Lg	7
54	6816292	Starter, 3 HP, 1 Ph, 230V	1
55	6816294	Starter, 5 HP, 1 Ph, 230V	1
56	6816295	Starter, 5 HP, 3 Ph, 230V	1

PARTS LIST: Table, Stand & Fence (27 & 27S Shapers)

No.	Part No.	Description	Quantity
57	6816296	Starter, 5 HP, 3 Ph, 460V	1
58	6821499	Reversing Switch	1
59	3408260	Warning Label (Shapers)	1
60	6746001	Pan Head Slot (Self Tap) Screw, #6 x 1/4 Lg	2
61	6095276	Snap Bushing	1
62	6746040	Pan Head Self Tap Screw, #6 x 1/2Lg	2

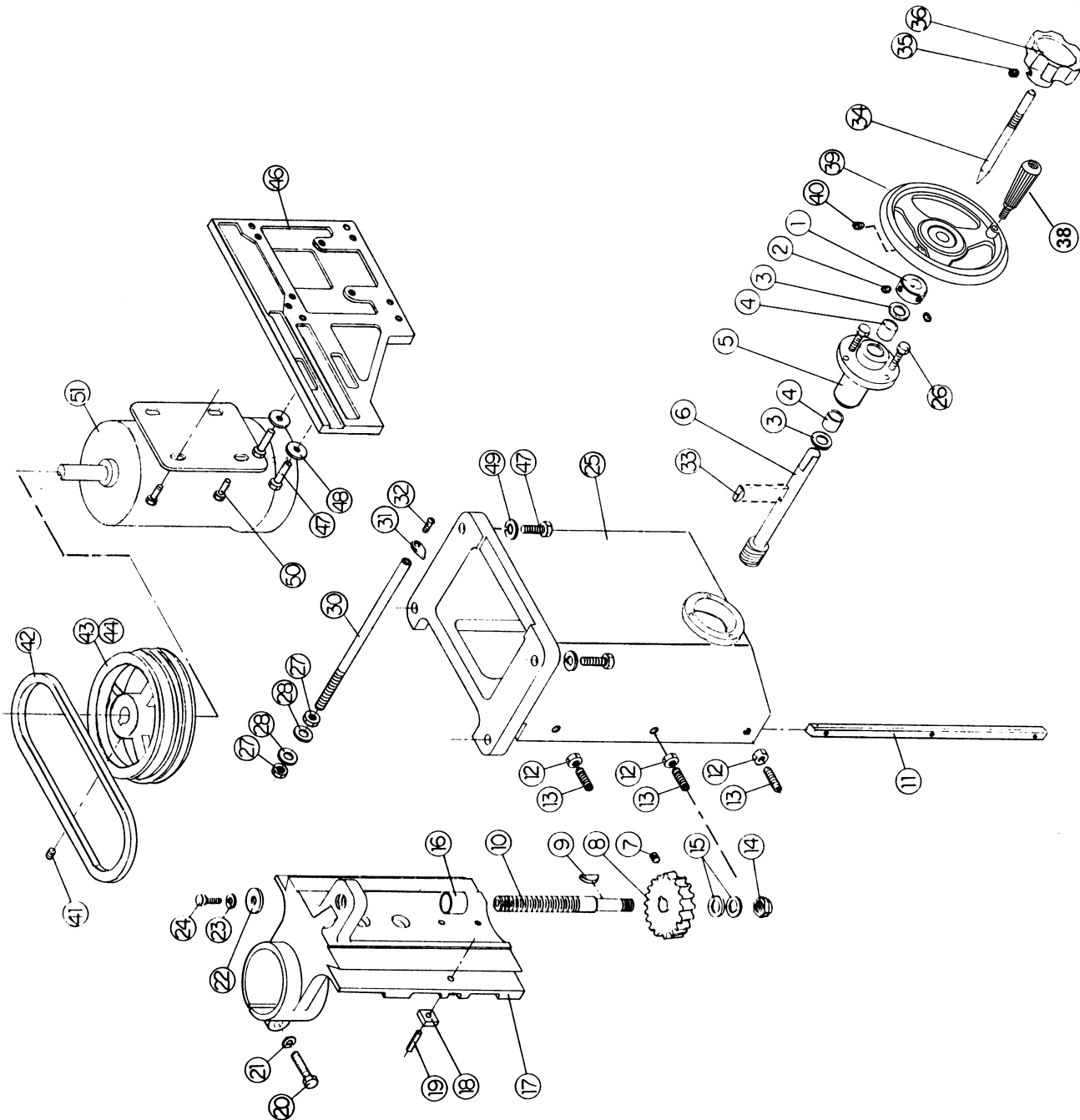


PARTS LIST: Head, Motor & Slide Assembly (27 & 27S Shapers)

No.	Part No.	Description	Quantity
	2277001	Slide Head Assembly (Items 1 thru 26)	1
	2586002	Worm Gear Pinion Assembly (#1-6)	1
1	3096244	Collar	1
2	6715015	Socket Set Screw, 5/16-18 X 1/4 Lg	2
3	6861901	Flat Nylatron Washer, 3/4"E-12	2
4	6095025	Bronze Bushing, 3/4 ID X 7/8 OD X 3/4	2
5	3070006	Adjustable Shaft Bushing	1
6	3586008	Pinion	1
7	6714004	Socket Set Screw, 1/4-20 X 1/4 Lg	1
8	3237003	Head Raising Spiral Gear	1
9	6420001	Woodruff Key No. 606	1
10	3691003	Elevating Screw	1
11	3244039	Head Slide Gib	1
12	6515007	Hex Jam Nut, 5/16	3
13	6715008	Socket Head Set Screw, 5/16-18 X 1 Lg.....	3
14	6520009	Thin Height Hex Nut, 5/8	1
15	6861702	Nylatron Washer, 5/8	2
16	3735006	Elevating Screw Spacer	1
17	3730012	Head Slide	1
18	3387002	Motor Base Key	2
19	6626028	Spring Pin, 3/16 X 1/2	2
20	6716032	Hex Head Screw, 3/8-16 X 1-1/2 Lg	1
21	6861300	Lock Washer, 3/8	1
22	6861251	Elevating Screw Stop Washer	1
23	6861200	Lock Washer, 5/16	1
24	6715042	Hex Head Screw, 5/16-18 X 3/4 Lg	1
25	3057006	Shaper Body	1
26	6715032	Hex Head Screw, 5/16-18 X 1 Lg	3
27	6516009	Hex Jam Nut, 3/8-16	2
28	6861301	Flat Washer, 3/8	2
30	3670009	Pointer Rod	1
31	3604001	Pointer	1
32	6706035	Round Head Machine Screw, 6-32 X 1/4 Lg	1
33	6420002	Woodruff Key 608	1
	2695004	Screw Locking Assembly (Items 34 thru 36)	1
34	3582009	Locking Pin	1
35	6760078	Socket Set Screw, #10-32 X 3/8 Lg	1
36	3406018	Black Phenolic Knob	1
	2271008	Handwheel Assembly (Items 38 thru 40)	1
38	6350032	Handle Assembly	1
39	3271039	Handwheel, 8" Diameter	1
40	6715013	Socket Head Set Screw, 5/16-18 X 3/8 Lg	1
41	6715016	Cup Point Socket Set Screw, 5/16-18 X 5/16 Lg	1
42	6077220	Belt, 3V315 3HP, 3Ph	1
	6077223	Belt, 3V X 300 5HP & 3HP, 1Ph	1
43	3718042	Motor Step Sheave, 1-1/8 BORE	1
44	3718043	Motor Step Sheave, 7/8 BORE	1
46	3042047	Motor Base	1
47	6718010	Hex Head Cap Screw, 1/2-13 X 1-1/2 Lg	4
48	3838008	Bevel Washer	2
49	6861500	Lock Washer, 1/2	4
50	6715007	Hex Washer Head Screw, 5/16-18 X 1/2 Lg	4

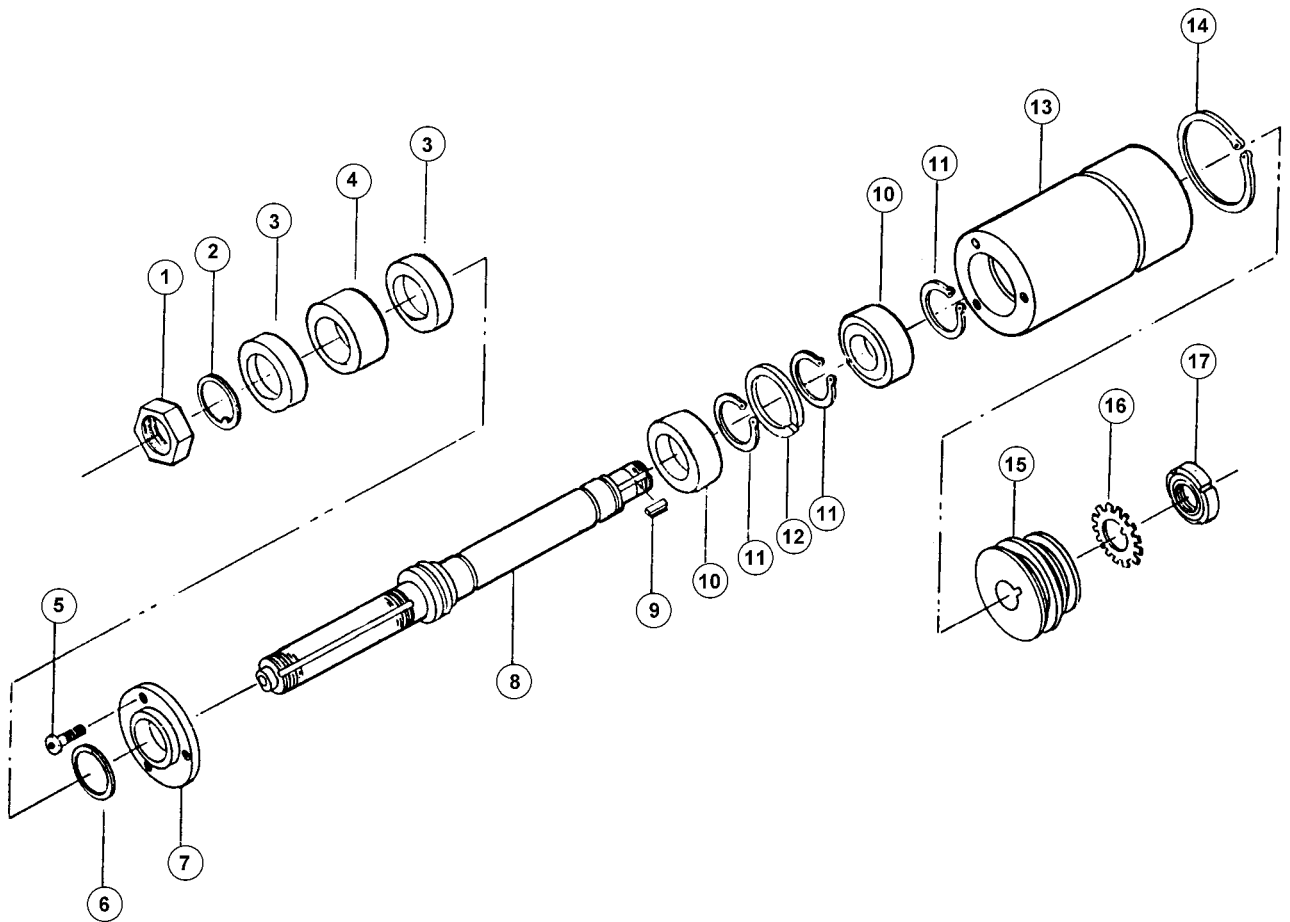
PARTS LIST: Head, Motor & Slide Assembly (27 & 27S Shapers)

No.	Part No.	Description	Quantity
51	6472013	Electric Motor, 3 HP, 1 Ph, 3600 RPM, 230V, 145T FR.	1
	6472026	Electric Motor, 3 HP, 3 PH, 3600 RPM, 230/460V, 145T FR.	1
	6472328	Electric Motor, 5 HP, 1 PH, 3600 RPM 230V, 182TFR.	1
	6472319	Electric Motor, 5 HP, 3 PH, 3600 RPM 230/460V, 182T FR.	1
52	6718017	Hex Head Screw, 1/2-13 x 1-3/4 Lg	2



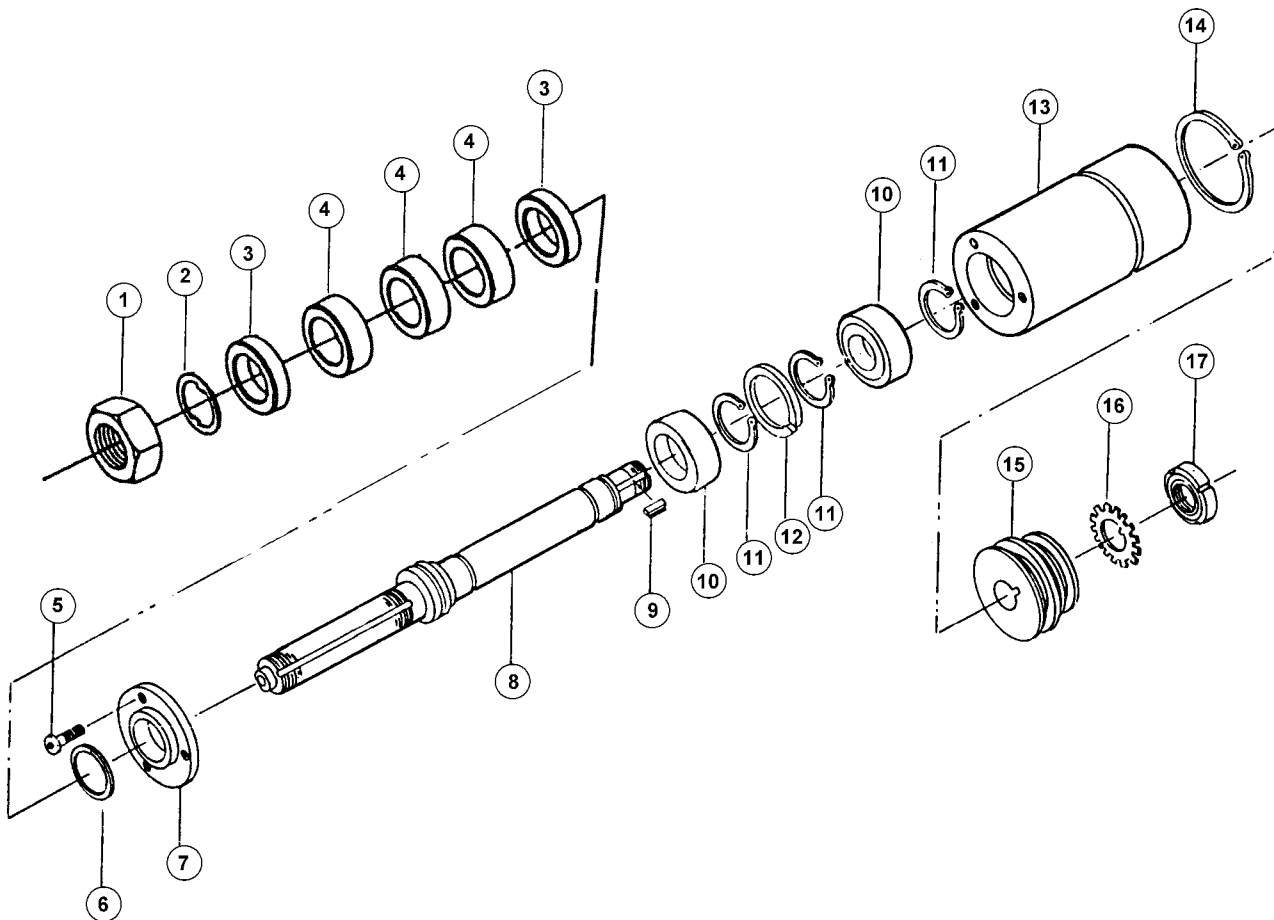
PARTS LIST: 3/4" Spindle Assembly - 2749052 (27 & 27S Shapers)

No.	Part No.	Description	Quantity
1	3526005	Spindle Nut, 3/4	1
2	3840003	Spindle Lockwasher, 3/4	1
3	3742004	Spindle Spacer, 3/4 X 1/2	2
4	3742005	Spindle Spacer, 3/4 X 3/4	1
5	6708067	Button Head Socket Screw, 8-32 X 1/2	3
6	6670129	RSN Retainer Ring - 137	1
7	3659024	Bearing Retainer	1
8	3749115	Solid Spindle, 3/4	1
9	3388062	Square Key	1
10	6060191	Bearing, 6205-2 RSTG	2
11	6670014	5100 98 Truarc External	2
12	6670128	Retainer Ring, IN-206	1
13	3298253	Quill	1
14	6670130	Retainer Ring, 5100-275	1
15	3718044	Spindle Sheave	1
16	6864004	Lockbearing Steel Plain Washer, WD 4	1
17	6549004	Bearing Lock Nut, N-04	1



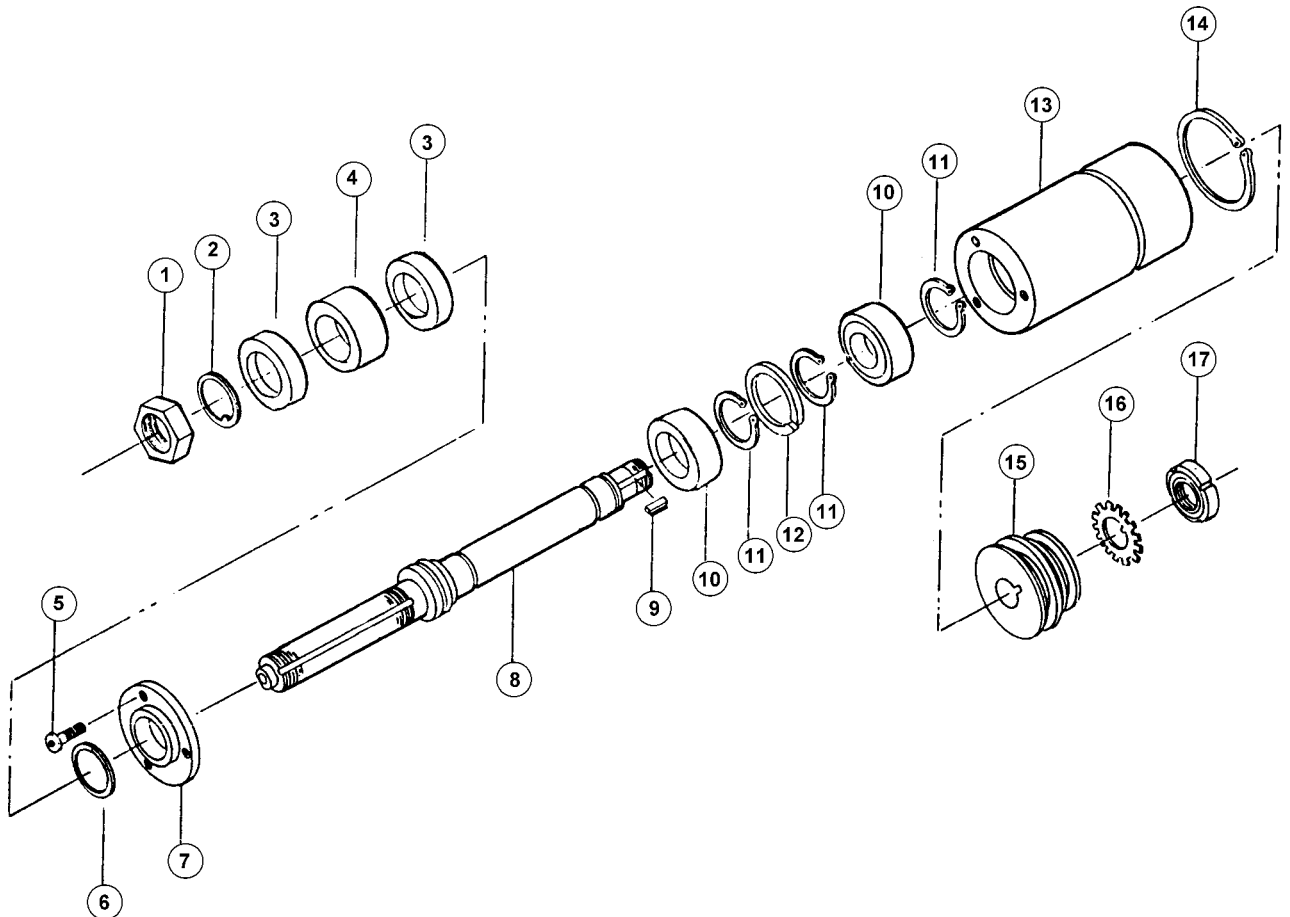
PARTS LIST: 1" Spindle Assembly - 2749053 (27 & 27S Shapers)

No.	Part No.	Description	Quantity
1	3526006	Spindle Nut, 1	1
2	3840004	Spindle Lockwasher, 1	1
3	3742006	Spindle Spacer, 1 X 1/2	2
4	3742007	Spindle Spacer, 1 X 3/4	3
5	6708067	Button Head Socket Screw, 8-32 X 1/2	3
6	6670129	Retainer Ring, RSN-137	1
7	3659024	Bearing Retainer	1
8	3749111	Solid Spindle, 1	1
9	3388062	Square Key	1
10	6060191	Bearing, 6205 - 2RSTG	2
11	6670014	5100 98 Truarc External	3
12	6670128	Retainer Ring, IN-206	1
13	3298253	Quill	1
14	6670130	Retainer Ring, 5100 - 275	1
15	3718044	Spindle Sheave	1
16	6864004	Lockbearing Steel Plain Washer WD4	1
17	6549004	Bearing Lock Nut, N-04	1



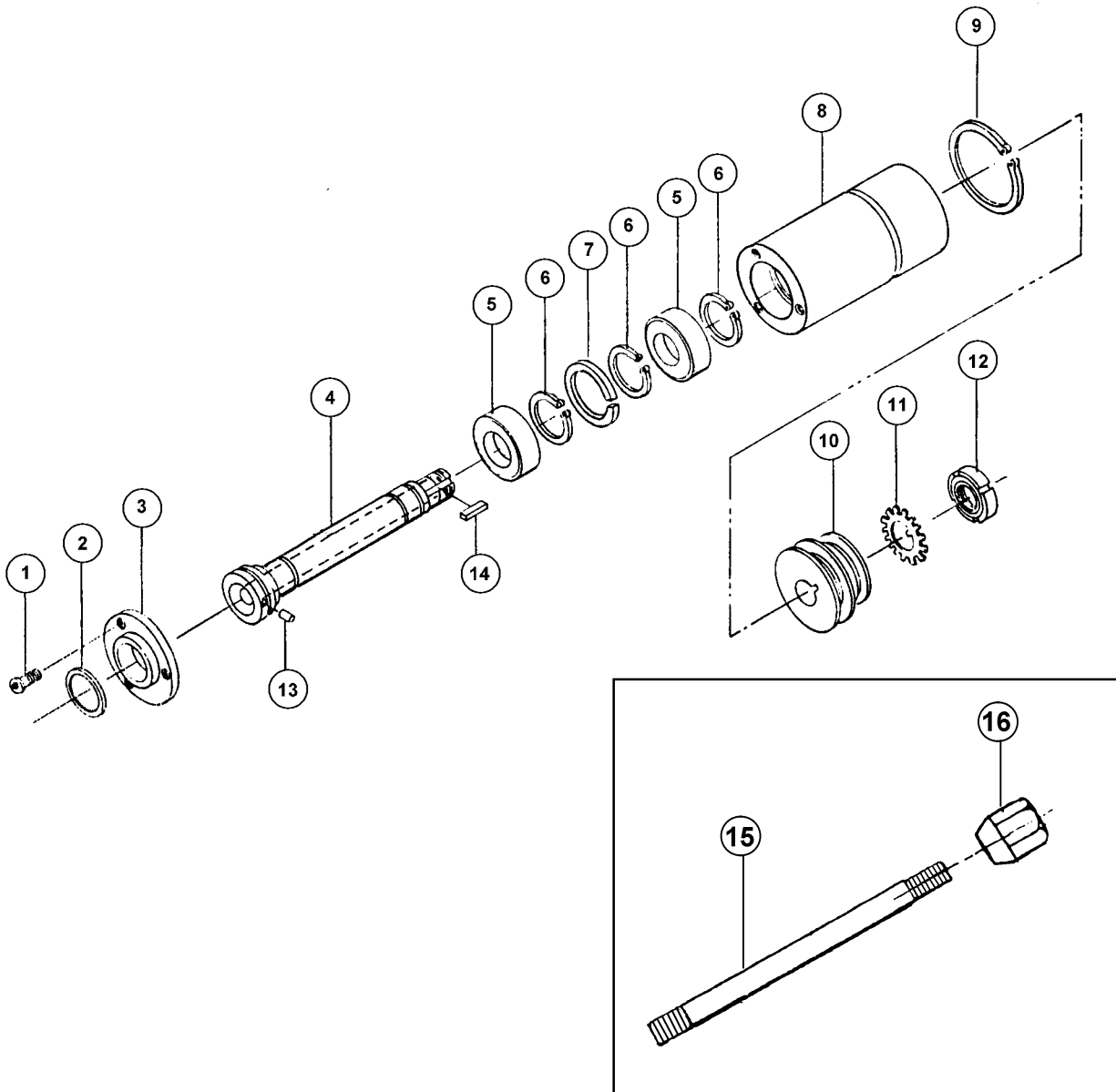
PARTS LIST: 1-1/4" Spindle Assembly - 2749050 (27 & 27S Shapers)

No.	Part No.	Description	Quantity
1	3526235	Spindle Nut, 1-1/4	1
2	3840005	Spindle Lockwasher, 1-1/4	1
3	3745030	Spindle Spacer, 1-1/4 X 1/2	2
4	3745031	Spindle Spacer, 1-1/4 X 3/4	1
5	6708067	Button Head Socket Screw, 8-32 X 1/2	3
6	6670168	Retainer Ring, RSN-162	1
7	3659120	Bearing Retainer	1
8	3749128	Solid Spindle, 1-1/4	1
9	3388062	Square Key	1
10	6060191	Bearing, 6205 - 2 RSTG	2
11	6670014	5100 98 Truarc External	3
12	6670128	Retainer Ring, IN-206	1
13	3298253	Quill	1
14	6670130	Retainer Ring, 5100-275	1
15	3718044	Spindle Sheave	1
16	6864004	Lockbearing Steel Plain Washer, WD 4	1
17	6549004	Bearing Lock Nut, N-04	1



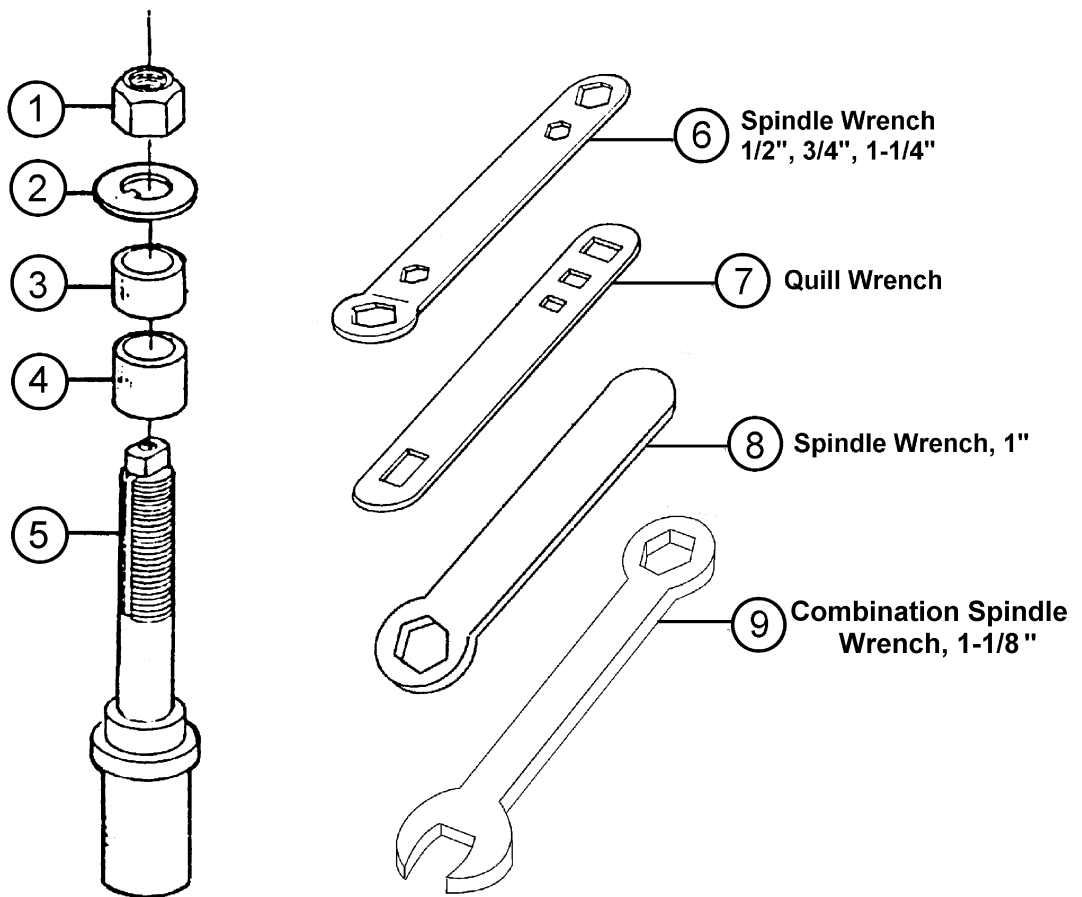
PARTS LIST: Interchangeable Spindle Assembly - 2749051
(Items 1 Thru 14)

No.	Part No.	Description	Quantity
1	6708067	Bottom Head Socket Screw, 8-32 X 1/2	1
2	6670129	Retainer Ring, RSN-137	1
3	3659024	Bearing Retainer	1
4	3749112	Straight Shank Interchangeable Spindle	1
5	6060191	Bearing 6205-2RSTG	2
6	6670014	5100 98 Truarc External.....	3
7	6670128	Retainer Ring, 5100-275	1
8	3298253	Quill	1
9	6670130	Retainer Ring, IN-206	1
10	3718044	Spindle Sheave	1
11	6864004	Bearing Lock Steel Plain Washer, WD 4	1
12	6549004	Bearing Lock Nut, N-04	1
13	3583208	Dowel Pin	1
14	3388062	Square Key	1
15	3140001	Drawbar	1
16	3526202	Drawbar Nut	1



PARTS LIST: Spindle Assemblies: Shank Arbors, Wrenches

No.	Part No.	Description	Quantity
	2749004	Spindle Assembly, 1/2 (Items 1 thru 5)	1
1	3526004	Spindle Nut, 1/2	1
2	3840002	Spindle Lock Washer, 1/2	1
3	3742002	Spindle Spacer, 1/2 X 1/2	4
4	3742003	Spindle Spacer, 1/2 X 3/4	1
5	3749016	Spindle, 1/2	1
	2749003	Spindle Assembly, 3/4 (Items 1 thru 5)	1
1	3526005	Spindle Nut, 3/4	1
2	3840003	Spindle Lock Washer, 3/4	1
3	3742004	Spindle Spacer, 3/4 x 1/2	2
4	3742005	Spindle Spacer, 3/4 x 3/4	1
5	3749017	Spindle, 3/4	1
6	3868004	Spindle Wrench, 1/2, 3/4, 1-1/4	1
7	3868005	Quill Wrench	1
8	3868025	Spindle Wrench, 1	1
9	477435	Combination Spindle Nut Wrench, 1-1/8	1



PARTS LIST: Ring Guard (27 & 27S Shapers)

Ring Guard for Interchangeable Spindle

- 1 3096325 Ring Guard - 3" Diameter, 1/2" Bore
- 2 3096326 Ring Guard - 4" Diameter, 3/4" Bore
- 3 3096328 Ring Guard - 5-1/2" Diameter, 3/4" Bore

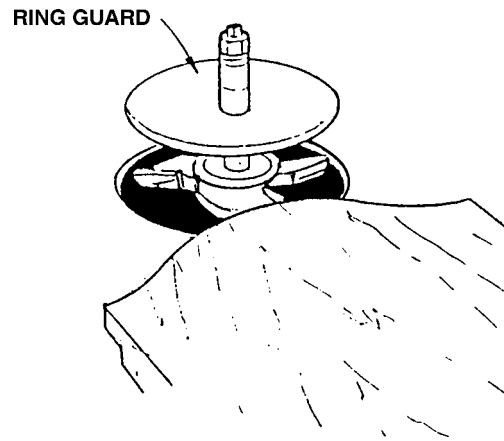
Ring Guard for 1" Spindle

- 1 3096330 Ring Guard - 4-1/2" Diameter, 1" Bore
- 2 3096331 Ring Guard - 6" Diameter, 1" Bore

Ring Guard for 1-1/4" Spindle

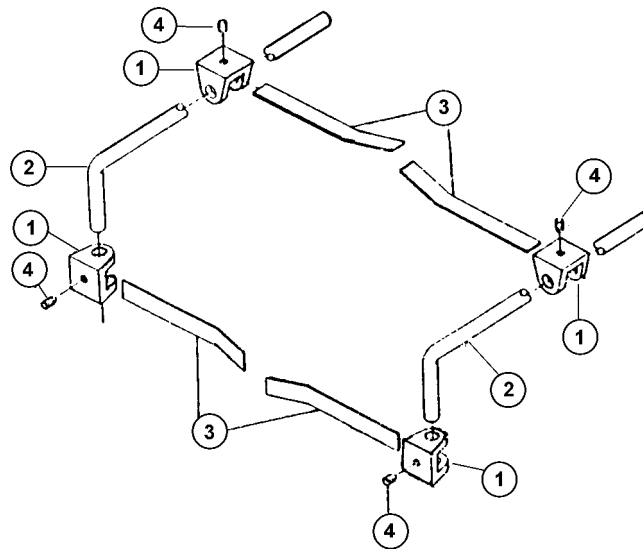
- 1 3096327 Ring Guard - 4-1/2" Diameter, 1-1/4" Bore
- 2 3096329 Ring Guard - 6" Diameter, 1-1/4" Bore

RING GUARDS ARE SHIPPED IN SETS ACCORDING TO SPINDLE SIZE AS STANDARD EQUIPMENT; HOWEVER, THEY MAY ALSO BE PURCHASED AS SINGLE ITEMS.



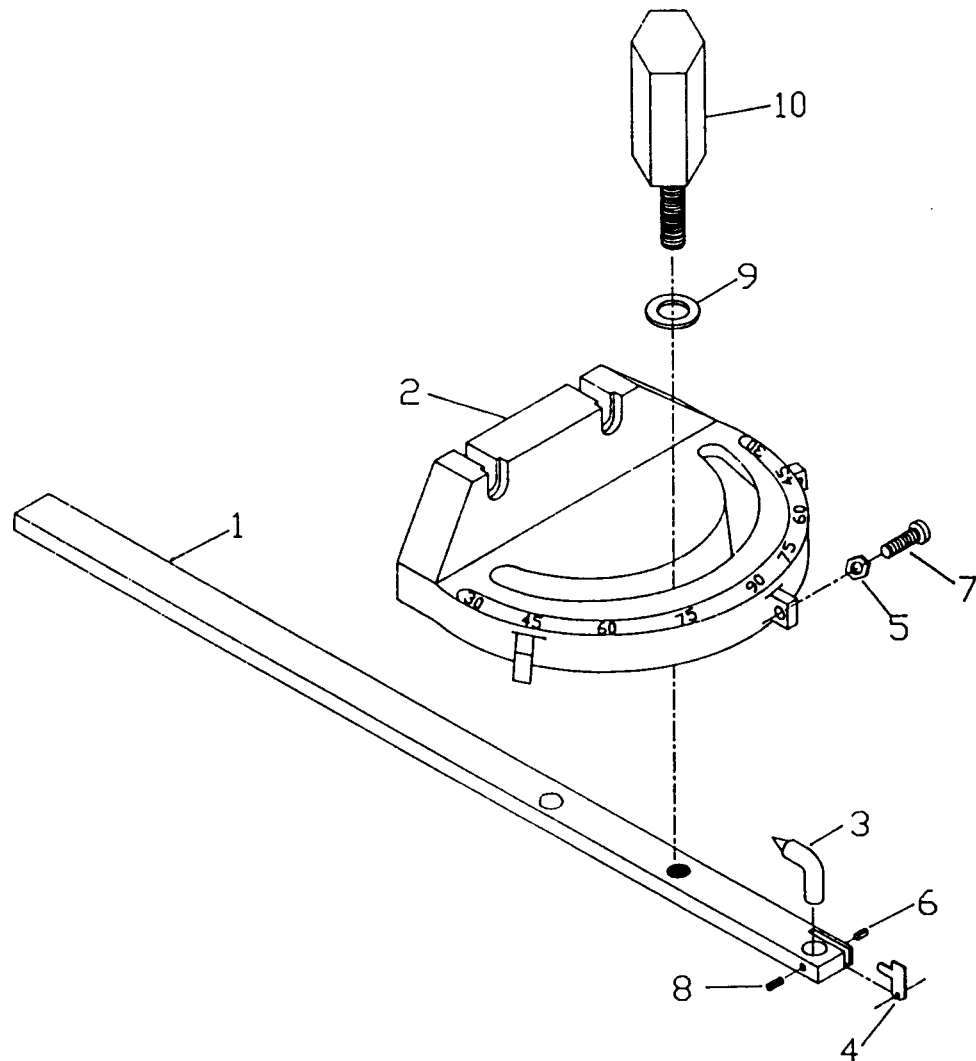
PARTS LIST: Hold-Downs

No.	Part No.	Description	Quantity
1	3289008	Spring Holder	4
2	3670057	Material Hold-down Rod	2
3	3767008	Fence Strap	4
4	6715014	Cup Point Socket Set Screw, 5/16-18 x 1/2	4



PARTS LIST: Mitre Gauge Assembly (Optional) - 27 & 27S Shapers

No.	Part No.	Description	Quantity
	2471010	Mitre Gauge Assembly	1
1	6290553	Mitre Gauge Bar	1
2	6290550	Mitre Gauge Body	1
3	6290555	Mitre Gauge Pointer	1
4	6290554	Mitre Gauge Stop	1
5	6290548	Hex Nut, 5/32	3
6	6290557	Spring Pin	1
7	6290549	Round Head Screw, 5/32-32	3
8	6290556	Socket Set Screw, 1/4-20 X 1/4	1
9	6290546	Washer	1
10	6290547	Mitre Gauge Handle	1



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