



Operating Instructions and Parts Manual Variable Speed Turret Mill

Models JTM-1254VS and JTM-1254RVS

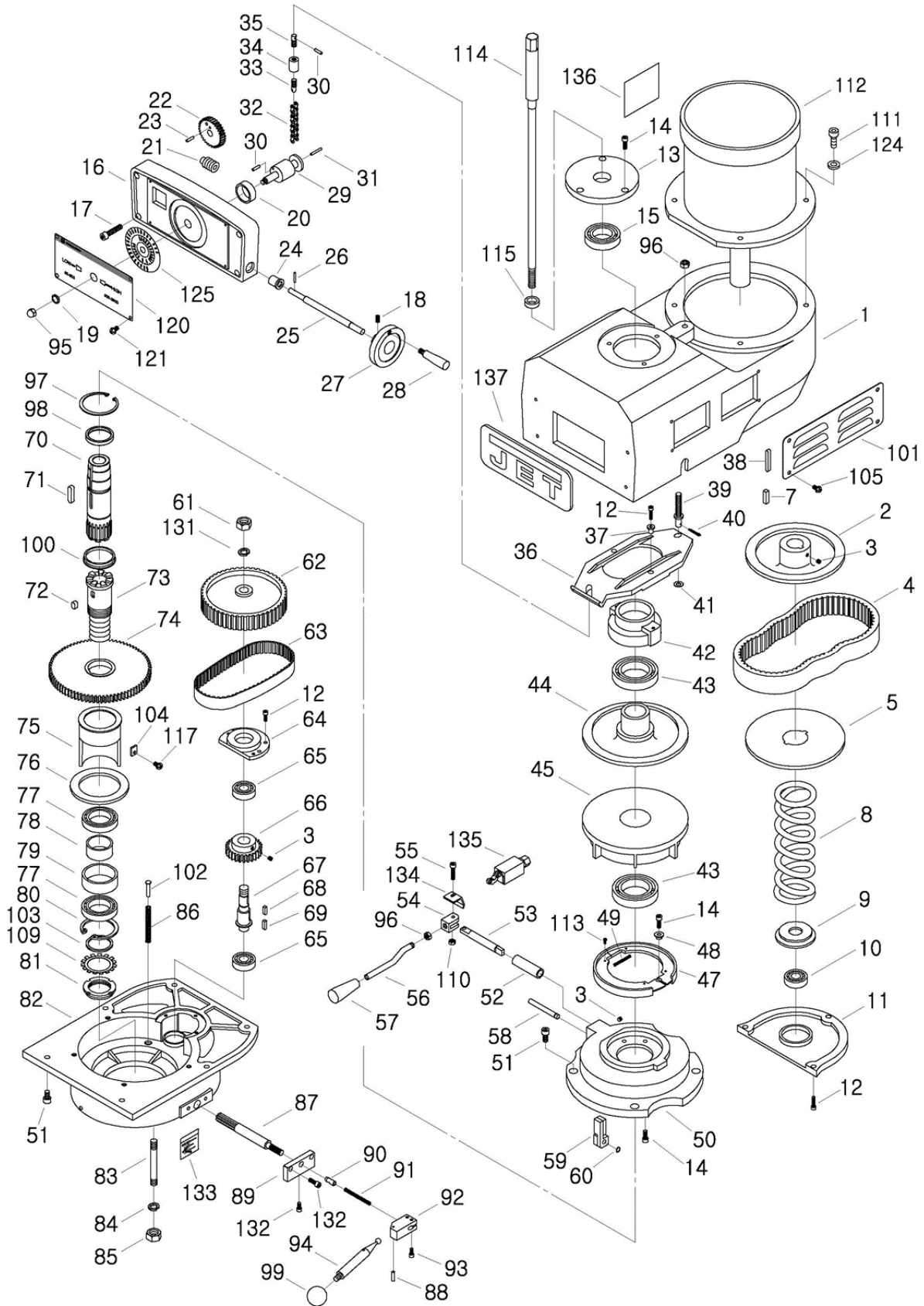


JTM-1254VS shown

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Part No. M-690025
Edition 4 10/2018
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12.2.1 JTM-1254RVS (R8) Upper Head Assembly – Exploded View



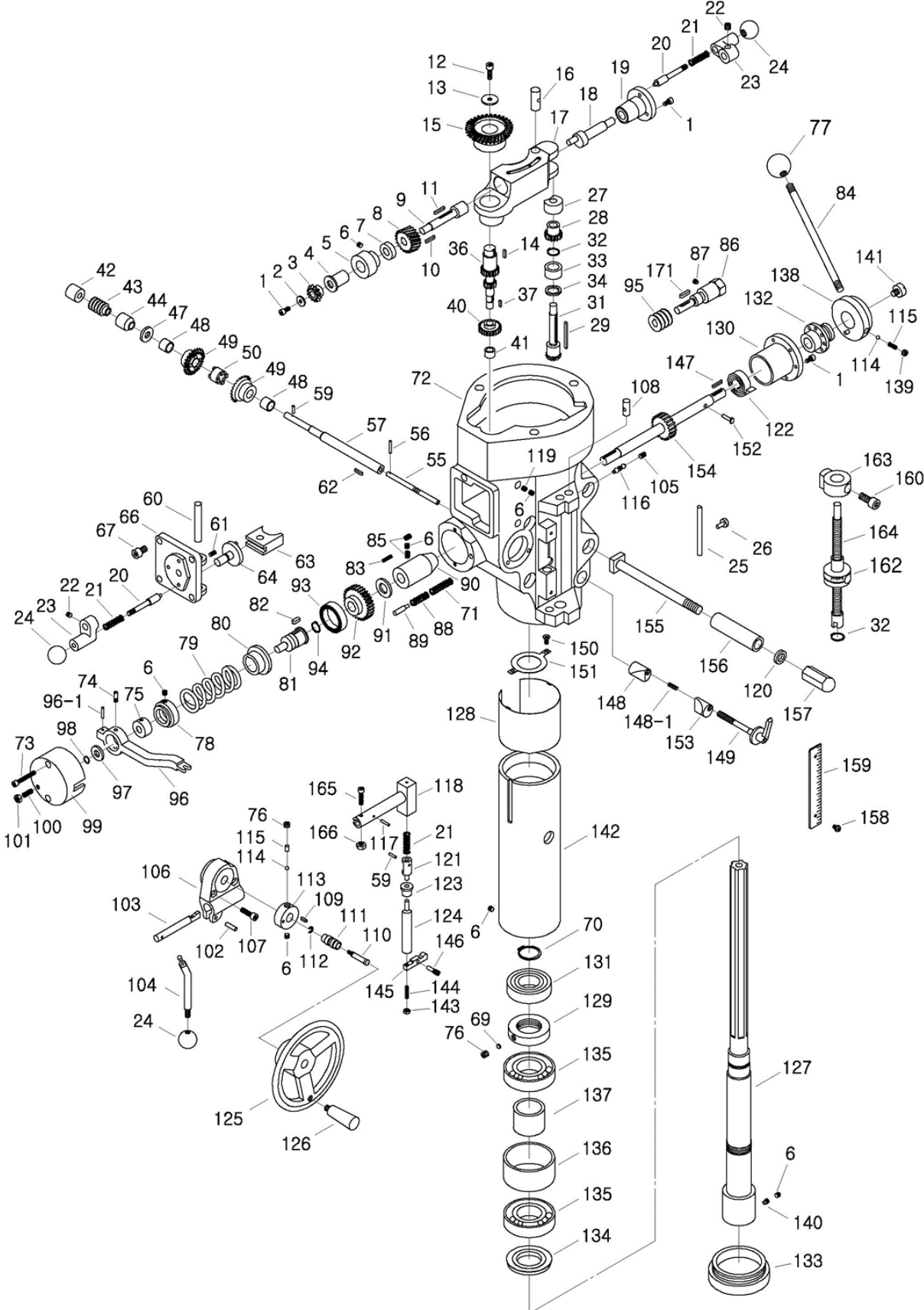
12.2.2 JTM-1254RVS (R8) Upper Head Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	JTM949EVS-A77	Upper Pulley Housing		1
2	JTM1254RVS-A02	Motor Disc - Upper		1
3	TS-1523011	Set Screw	M6x6L	4
4	JTM1254RVS-A04	Belt		1
5	JTM1254RVS-A05	Motor Disc - Lower		1
7	6295247	Key	7x7x25L	1
8	JTM1254RVS-A08	Spring		1
9	JTM1254RVS-A09	Washer		1
10	BB-6204ZZ	Ball Bearing	6204ZZ	1
11	JTM949EVS-A69	Motor Pulley Cover		1
12	TS-1504041	Hex Socket Cap Screw	M8x20	3
13	JTM1254RVS-A13	Upper Cover		1
14	TS-1502041	Hex Socket Cap Screw	M5x16	10
15	BB-6009ZZ	Ball Bearing	6009ZZ	1
16	JTM1254RVS-A16	Dial Housing		1
17	TS-1503071	Hex Socket Cap Screw	M6x30L	4
18	TS-1523051	Set Screw	M6x16L	2
19	JTM1254RVS-A19	Bushing		1
20	JTM1254RVS-A20	Spacer		1
21	JTM1254RVS-A21	Worm Gear Shaft		1
22	JTM1254RVS-A22	Worm Gear		1
23	5301041	Spring Pin	Ø5x10L	2
24	JTM1254RVS-A24	Bushing		2
25	JTM1254RVS-A25	Shaft		1
26	5302611	Spring Pin	Ø3x12L	1
27	JTM1254RVS-A27	Handwheel		1
	JTM1254RVS-A27A	Handwheel Assembly (includes #18,27,28)		1
28	JTM1254RVS-A28	Handle		1
29	JTM1254RVS-A29	Chain axle		1
30	5509313	Spring Pin	Ø4x16L	2
31	GA7X-865	Spring Pin	Ø3x25L	1
32	JTM1254RVS-A32	Chain		1
33	JTM1254RVS-A33	Screw		1
34	JTM1254RVS-A34	Spacer		1
35	JTM1254RVS-A35	Jointer		1
36	JTM1254RVS-A36	Adjustable Plate		1
37	JTM1254RVS-A37	Shift Sleeve		2
38	6294761	Key	6x6x45L	1
39	JTM1254RVS-A39	Bottom Pin		1
40	5307431	Spring Pin	3/32"x3/4"	1
41	JTM1254RVS-A41	Flat Washer	Ø8	1
42	JTM1254RVS-A42	Bearing Housing		1
43	BB-6010ZZ	Ball Bearing	6010ZZ	2
44	JTM1254RVS-A44	Spindle Disc - Upper		1
45	JTM1254RVS-A45	Spindle Disc - Lower		1
47	JTM949EVS-A48	Brake Shoe		1
48	JTM949EVS-A58	Lock Collar		1
49	JTM949EVS-A62	Brake Spring		1
50	JTM949EVS-A43	Brake Base		1
51	TS-1504041	Hex Socket Cap Screw	M8x20L	10
52	JTM949EVS-A53	Brake Sleeve		1
53	JTM949EVS-A54	Spindle Brake Shaft		1
54	JTM949EVS-A56	Spindle Brake Lever Pivot		1
55	TS-1503071	Hex Socket Cap Screw	M6x30	1
56	JTM949EVS-A63	Spindle Brake Lever		1
57	JTM949EVS-A50	Brake Lock Knob	3/8"	1
58	JTM949EVS-A49	Brake Shaft		1
59	JTM949EVS-A47	Brake Finger Stud (set of 2)		1
60	JTM949EVS-A46	Retaining Ring	STW8	1
61	JTM1254RVS-A61	Hex Nut	5/8-18UNF	1

Index No	Part No	Description	Size	Qty
62	JTM949EVS-A34	Timing Pulley		1
63	JTM949EVS-A32	Timing Belt	225L100	1
64	JTM949EVS-A19	Ball Bearing Bracket		1
65	BB-6203ZZ	Ball Bearing	6203ZZ	2
66	JTM949EVS-A18	Gear		1
67	JTM949EVS-A16	Gear Shaft		1
68	KF2R5515	Double Round Key	5x5x15L	1
69	KF2R5518	Double Round Key	5x5x18L	1
70	JTM949EVS-A41	Input Clutch		1
71	5307741	Key	8x7x24L	1
72	KF2R8712	Key	8x7x12L	1
73	JTM949EVS-A38	Output Clutch		1
74	JTM949EVS-A33	Gear		1
75	JTM949EVS-A31	Bearing Sleeve		1
76	JTM949EVS-A30	Washer		1
77	BB-6908ZZ	Ball Bearing	6908ZZ	2
78	JTM949EVS-A29	Gear Bearing Spacer (Small)		1
79	JTM949EVS-A28	Gear Bearing Spacer (Large)		1
79A	JTM949EVS-A28A	Gear Bearing Spacer Assembly (#78,79)		1
80	RTW62	Retaining Ring	RTW62	1
81	AN08	Bearing Nut	AN08	1
82	JTM949EVS-A01	Upper Pulley Housing		1
83	JTM949EVS-A88	Stud	7/16"x4"	3
84	TS-0720101	Spring Washer	7/16"	3
85	TS-0561041	Hex Nut	7/16"	3
86	JTM949EVS-A21	Pressure Spring		3
87	JTM949EVS-A03	Bull Gear Shifter Pinion Shaft		1
88	B-56	Spring Pin	Ø3x20L	1
89	JTM949EVS-A04	Hi-Lo Detent Plate		1
90	JTM949EVS-A05	Sleeve		1
91	JTM949EVS-A06	Spring		1
92	JTM949EVS-A08	Hi-Lo Pinion Block		1
93	TS-1502031	Hex Socket Cap Screw	M5x12L	2
94	JTM949EVS-A09	Hi-Lo Shift Handle		1
95	F004478	Cap Nut	5/16"-18UNC	1
96	TS-0570031	Hex Nut	3/8"-16UNC	2
97	JTM949EVS-A42	Retaining Ring	STW80	1
98	JTM949EVS-A59	Collar		1
99	BH1/4	Black Plastic Ball	1/4"	1
100	JTM949EVS-A39	Clutch Collar		1
101	JTM949EVS-A75	Side Belt Housing Cover		2
102	JTM949EVS-A22	Spring Shaft		3
103	JTM949EVS-A25	Spacer		1
104	JTM1254RVS-A104	Nut		1
105	JTM1254VS-A105	Pan Head Screw	M5x8L	4
109	AW08	Bearing Washer	AW08	1
110	TS-1540041	Nut	M6	1
111	TS-1505031	Hex Socket Cap Screw	M10x25	4
112	JTM1254VS-A112	Motor	5HP (3.75kW)	1
	JTM1254VS-A112-1	Motor Fan (not shown)		1
	JTM1254VS-A112-2	Motor Fan Cover (not shown)		1
	JTM1254VS-A112-3	Junction Box Cover (not shown)		1
113	JTM949EVS-A51	Pan Head Screw	1/8"x1/4"	4
114	JTM949EVS-A87	Draw Bar	7/16"	1
115	JTM949EVS-A86	Spacer		1
117	VS-117	Pan Head Screw	3/16"x1/2"L	1
120	JTM1254VS-A120	Speed Plate		1
121	TS-2284202	Pan Head Screw	M4x20L	4
124	TS-1550071	Flat Washer	Ø10	4
125	JTM1254VS-A125	Speed Dial		1
131	TS-0720131	Spring Washer	5/8"	1
132	TS-1502041	Hex Socket Cap Screw	M5x16	3

Index No	Part No	Description	Size	Qty
133	LM000005	Speed Range Label		1
134	JTM949EVS-A91	Push Plate		1
135	JTM949EVS-A92	Limit Switch		1
136	LM000182	Motor Label		1
137	JET-165	JET Logo	165x68 mm	1

12.4.1 JTM-1254RVS (R8) Lower Head Assembly – Exploded View



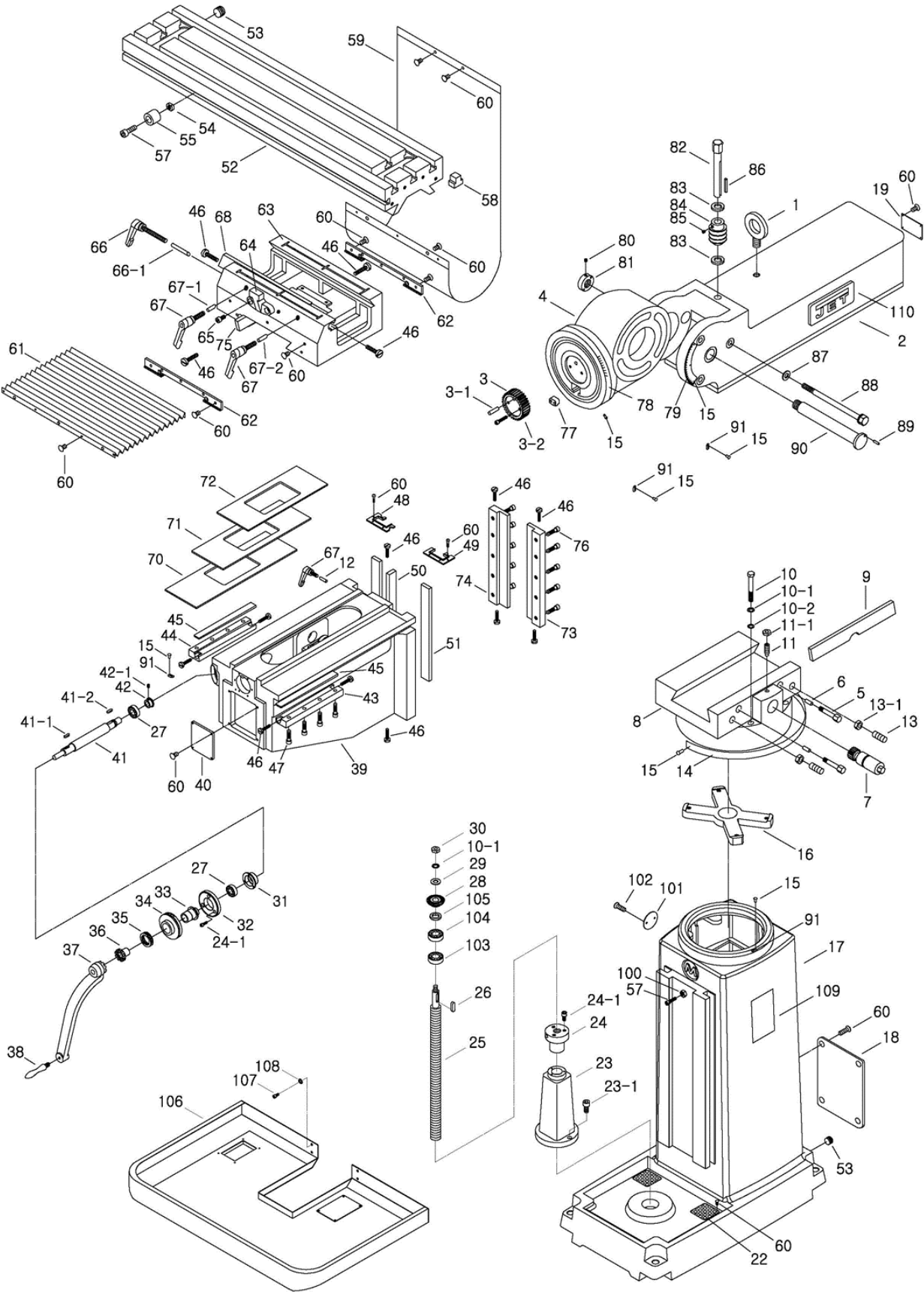
12.4.2 JTM-1254RVS (R8) Lower Head Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	TS-1502031	Hex Socket Cap Screw	M5x12	6
2	JTM949EVS-B02	Flat Washer	Ø5	1
3	JTM949EVS-B03	Feed Gear		1
4	JTM949EVS-B04	Shaft Sleeve		1
5	JTM949EVS-B05	Worm Cradle Bushing		1
6	TS-1523011	Socket Set Screw	M6x6	8
7	JTM949EVS-B07	Worm Gear Spacer		1
8	JTM949EVS-B08	Feed Drive Worm Gear		1
9	JTM949EVS-B09	Worm Gear Shaft		1
10	JTM949EVS-B10	Worm Shaft Key	3x3x8	1
11	KF2R3320	Key	3x3x20	1
12	TS-1503041	Hex Socket Cap Screw	M6x16	1
13	JTM949EVS-B13	Flat Washer	Ø6	1
14	KF2R5508	Key	5x5x8	1
15	JTM949EVS-B15	Feed Reverse Bevel Gear		1
16	JTM949EVS-B16	Feed Engage Pin		1
17	JTM949EVS-B17	Worm Gear Cradle		1
18	JTM949EVS-B18	Cam Rod		1
19	JTM949EVS-B19	Shift Sleeve		1
20	JTM949EVS-B20	Lock Rod		2
21	JTM949EVS-B21	Spring		3
22	5302731	Socket Set Screw	M8x6	2
23	JTM949EVS-B23	Crank		2
24	BH1/4	Black Plastic Ball	1/4"	3
25	JTM949EVS-B25	Indicator Rod		1
26	JTM949EVS-B26	Indicator Rod Screw		1
27	JTM949EVS-B27	Upper Bushing		1
28	JTM949EVS-B28	Cluster Gear		1
29	KF2R4445	Key	4x4x45	1
31	JTM949EVS-B31	Bevel Gear Shaft		1
32	STW16	Retaining Ring	STW16	2
33	JTM949EVS-B33	Bevel Gear Bushing		1
34	JTM949EVS-B34	Spacer		1
36	JTM949EVS-B36	Feed Drive Gear		1
36A	JTM949EVS-B36A	Feed Drive Gear Assembly (#36,37)		1
37	KF2R5512	Key	5x5x12	1
40	JTM949EVS-B40	Feed Drive Gear		1
41	BB-BA66	Needle Bearing	BA66	1
42	JTM949EVS-B42	Bushing		1
43	JTM949EVS-B43	Worm		1
44	JTM949EVS-B44	Feed Worm Shaft Bushing		1
47	JTM949EVS-B47	Bevel Gear Thrust Spacer		1
48	JTM949EVS-B48	Bushing		2
49	JTM949EVS-B49	Feed Reverse Bevel Gear		2
50	JTM949EVS-B50	Feed Reverse Clutch		1
55	JTM949EVS-B55	Reverse Clutch Rod		1
56	TS-209203	Spring Pin	3x20	1
57	JTM949EVS-B57	Feed Worm Shaft		1
59	5302611	Spring Pin	3x12	2
60	JTM949EVS-B60	Feed Shift Rod		1
61	TS-1522031	Socket Set Screw	M5x10	1
62	KF2R3315	Key	3x3x15	1
63	JTM949EVS-B63	Feed Gear Shift Fork		1
64	JTM949EVS-B64	Cluster Gear Shift Crank		1
66	JTM949EVS-B66	Cluster Gear Cover		1
67	TS-1502021	Hex Socket Cap Screw	M5x10	4
69	JTM949EVS-B69	Lock Block		1
70	2210-266	Retaining Ring	STW30	1
71	JTM949EVS-B71	Spring	10x20	1
72	JTM949EVS-B72	Quill Housing	105mm	1

Index No	Part No	Description	Size	Qty
73	TS-1502081	Hex Socket Cap Screw	M5x35	2
74	JTM949EVS-B74	Clutch Ring Pin		2
75	JTM949EVS-B75	Clutch Ring		1
76	5302731	Socket Set Screw	M8x6	2
77	JTM949EVS-B77	Ball Grip		1
78	JTM949EVS-B78	Overload Clutch Lockout		1
79	JTM949EVS-B79	Safety Clutch Spring		1
80	JTM949EVS-B80	Overload Clutch		1
80A	JTM949EVS-B80A	Overload Clutch Assembly (#6,78,80,81)		
81	JTM949EVS-B81	Overload Clutch Sleeve		1
82	KF2R5516	Key	5x5x16	1
83	TS-1532052	Pan Head Machine Screw	M4x16	3
84	JTM949EVS-B84	Handle		1
85	TS-1523031	Socket Set Screw	M6x10	2
86	JTM949EVS-B86	Worm Shaft		1
87	TS-1523011	Set Screw	M6x6	1
88	JTM949EVS-B88	Spring		1
89	JTM949EVS-B89	Spring Plunger		1
90	JTM949EVS-B90	Pinion Shaft		1
91	JTM949EVS-B91	Spacer		1
92	JTM949EVS-B92	Overload Clutch Worm Gear		1
93	JTM949EVS-B93	Overload Clutch Ring		1
94	STW22	Retaining Ring	STW22	1
95	JTM949EVS-B95	Worm Gear		1
96	JTM949EVS-B96	Trip Lever		1
96-1	GA7X-122	Spring Pin	Ø5x20	1
97	JTM949EVS-B97	Washer		1
98	STW10	Retaining Ring	STW10	1
99	JTM949EVS-B99	Clutch Arm Cover		1
100	TS-1523051	Socket Set Screw	M6x16	1
101	TS-2311061	Hex Nut	M6	1
102	5625391	Spring Pin	Ø5x16	1
103	JTM949EVS-B103	Cam Rod		1
104	JTM949EVS-B104	Trip Handle		1
105	5302731	Socket Set Screw	M8x6	1
106	JTM949EVS-B106	Feed Trip Bracket		1
107	TS-1503051	Hex Socket Cap Screw	M6x20	2
108	JTM949EVS-B108	Plunger		1
109	KF2R3312	Key	3x3x12	1
110	JTM949EVS-B110	Feed Reverse Stud Bolt		1
110A	JTM949EVS-B110A	Feed Reverse Stud Assembly (#110,111,112)		
111	JTM949EVS-B111	Feed Reverse Stud		1
112	ETW6	Retaining Ring	ETW6	1
113	JTM949EVS-B113	Handwheel Clutch		1
114	SB-3/16	Steel Ball	3/16"	2
115	JTM949EVS-B115	Spring		2
116	JTM949EVS-B116	Lever		1
117	JTM949EVS-B117	Spring Pin	Ø3x16	1
118	JTM949EVS-B118	Cam Rod Sleeve Assembly		1
119	TS-1523011	Socket Set Screw	M6x6	2
120	JTM949EVS-B120	Flat Washer	Ø13	4
121	JTM949EVS-B121	Trip Plunger		1
122	JTM949EVS-B122	Adjustable Spring		1
123	JTM949EVS-B123	Bushing		1
124	JTM949EVS-B124	Feed Trip Plunger		1
125	JTM1254VS-B77	Cast Handwheel		1
125A	JTM1254VS-B77HA	Handwheel Assembly (#125,126)		
126	JTM1254VS-B78	Handle		1
127	JTM949EVS-B127	Spindle	R8	1
128	JTM949EVS-B128	Quill Skirt		1
129	JTM949EVS-B129	Lock Nut	M35	1
130	JTM949EVS-B130	Spring Cover		1

Index No	Part No	Description	Size	Qty
131	BB-6206ZZ	Ball Bearing	6206ZZ	1
132	JTM949EVS-B132	Hub Sleeve		1
133	JTM949EVS-B133	Nose Piece		1
134	JTM949EVS-B134	Spindle Shield		1
135	BB-7207C	Ball Bearing	7207C	2
136	JTM949EVS-B136	Bearing Spacer (large)		1
136A	JTM949EVS-B136A	Bearing Spacer Assembly (#136,137)		
137	JTM949EVS-B137	Bearing Spacer (small)		1
138	JTM949EVS-B138	Hub		1
139	TS-0270011	Socket Set Screw	5/16"x1/4"	1
140	TS-1523011	Socket Set Screw	M6x6	1
141	JTM949EVS-B141	Pinion Shaft Hub		1
142	JTM949EVS-B142	Quill		1
143	TS-1540021	Hex Nut	M4	1
144	TS-1521071	Socket Set Screw	M4x20	1
145	JTM949EVS-B145	Feed Trip Lever		1
146	JTM949EVS-B146	Trip Lever Pin		1
147	KF2R5525	Key	5x5x25	1
148	JTM949EVS-B148	Quill Lock Sleeve		1
148-1	JTM949EVS-B148-1	Spring		1
149	JTM949EVS-B149	Lock Handle	M8	1
150	TS-1533032	Pan Head Screw	M5x10	2
151	JTM949EVS-B151	Washer		1
152	JTM949EVS-B152	T-type Pin		1
153	JTM949EVS-B153	Quill Lock Sleeve		1
154	JTM949EVS-B154	Quill Pinion Shaft		1
154A	JTM949EVS-B154A	Quill Pinion Shaft Assembly (#152,154)		
155	JTM949EVS-B155	T-Bolt Assembly		4
156	JTM949EVS-B156	Spacer		4
157	JTM949EVS-B157	Lock Nut		4
158	TS-2171012	Pan Head Screw	M4x6	2
159	JTM949EVS-B159	Micrometer Scale		1
160	TS-0209032	Hex Socket Cap Screw	3/8"-24UNFx3/4"	1
162	JTM949EVS-B162	Micrometer Nut	Inch	1
163	JTM949EVS-B163	Quill Stop Knob		1
164	JTM949EVS-B164	Quill Micro-Screw	Inch	1
165	TS-1502051	Hex Socket Cap Screw	M5x20	1
166	TS-1540031	Hex Nut	M5	1
171	KF2R4418	Key	4x4x18	1

12.6.1 JTM-1254RVS (R8) Base Machine – Exploded View



12.6.2 JTM-1254RVS (R8) Base Machine – Parts List

Index No	Part No	Description	Size	Qty
1	JTM1050EVS2-C29A	Lifting Ring	M20	1
2	JTM1050EVS2-30	Ram		1
3	JTM949EVS-C02	Worm Gear		1
3-1	JTM949EVS-C03-1	Spring Pin	Ø6x30L	1
3-2	TS-1504061	Hex Socket Cap Screw	M8x30L	2
4	JTM1050EVS2-C40	Ram Adapter	Ø30	1
5	JTM1254VS-C05	Ram Lock Bolt		2
6	JTM1254VS-C06	Ram Lock Plunger		2
7	JTM1050EVS2-88	Ram Pinion	M2.54x13T	1
8	JTM1254VS-C08	Turret		1
9	JTM1050EVS2-79	Turret Gib	7.6t	1
10	JTM1254RVS-C10	Hex Head Screw	M12x125L	4
10-1	TS-2361121	Spring Washer	Ø12	5
10-2	JTM949EVS-B120	Flat Washer	Ø13	4
11	JWS35X-222	Socket Set Screw	M8x30L	1
11-1	JTM1254VS-C11-1	Hex Nut	M8	1
12	JTM1254RVS-C12	Knee Lock Plunger	Ø10x35L	2
13	JTM1254RVS-C13	Set Screw	M10x60L	2
13-1	TS-2331101	Hex Nut	M10	2
14	JTM949EVS-C81	Turret Scale		1
15	RN2L6	Rivet	Ø2x6L	12
16	JTM949EVS-C27	Spider		1
17	JTM1254VS-C17	Column		1
18	JTM1254VS-C18	Plate		1
19	JTM1254VS-C19	Ram Cover		1
22	JTM949EVS-C87	Strainer Net	90*90	2
23	JTM1254VS-C23	Elevating Screw Housing		1
23-1	JTM1254VS-C23-1	Hex Socket Cap Screw	M10x45L	2
24	JTM1254VS-C24	Elevating Nut (Inch)	Ø32 x 5 Tpi	1
24-1	TS-1503051	Hex Socket Cap Screw	M6x20L	6
25	JTM1254VS-C25	Lead Screw (Inch)	Ø35x5 Tpi (590)	1
26	KF2R5520	Key	5x5x20L	1
27	BB6204ZZ	Bearing	6204ZZ	2
28	JTM1254VS-C28	Bevel Gear	Ø25x36T- 20.6m	1
29	JTM1254VS-C29	Washer	Ø13xØ32x5T	1
30	JTM1254VS-C30	Hex Nut	1/2-20UNF	1
31	JTM1254VS-C31	Bearing Seat		1
32	JTM1254VS-C32	Cover	62mm	1
33	JTM949EVS-C67	Dial Holder	3/4, 51L	1
34	JTM949EVS-C66	Dial (Inch)	100/ 0.001"	1
35	JTM949EVS-C65	Dial Lock Nut		1
36	JTM949EVS-C64	Clutch Insert	3mm, 9T	1
37	JTM1050EVS2-75	Elevating Crank		1
38	JTM949EVS-C62	Handle		1
39	JTM1254VS-C39	Knee		1
40	JTM1254VS-C40	Knee Cover		1
41	JTM1254VS-C41	Elevating Shaft	Ø23.81x354x 538L	1
41-1	JTM1254VS-C41-1	Key	3x3x10L	1
41-2	JTM1254VS-C41-2	Key	4x4x16L	1
42	JTM949EVS-C74	Bevel Gear	18T	1
42-1	TS-1523031	Socket Set Screw	M6x10L	1
43	JTM1254VS-C43	Support Plate-R		1
44	JTM1254VS-C44	Support Plate-L		1
45	JTM1254VS-C45	Gib		2
46	JTM949EVS-C34	Adjustable Screw	M8*37L	14
47	JTM1254VS-C47	Hex Socket Cap Screw	M12x35L	8
48	JTM1254VS-C48	Knee Wiper (Left)		1
49	JTM1254VS-C49	Knee Wiper (Right)		1
50	JTM1254VS-C50	Knee/ Column Gib		1
51	JTM1254VS-C51	Knee/ Column Gib		2

Index No	Part No	Description	Size	Qty
52	JTM1254VS-C52	Table	12"x54"	1
53	JTM1254VS-C53	Oil Plug	1/2"PT	3
54	JTM1254VS-C54	Nut		2
55	JTM1254VS-C55	Bushing		2
57	TS-1505041	Hex Socket Cap Screw	M10x30L	3
58	JTM1254VS-C58	Rubber	23x32x16	6
59	JTM1254VS-C59	Flat Way Cover (rear)	450x850x1.5T	1
60	TS-2245102	Socket Head Button Screw	M5x10L	39
61	JTM1254VS-C61	Pleated Way Cover (front)	450x600L	1
62	JTM1254VS-C62	Wiper		2
63	JTM1254VS-C63	Saddle		1
64	JTM1254VS-C64	Table Stop Bracket		1
65	JTM1254VS-C65	Hex Socket Cap Screw	M10X16L	2
66	JTM949EVS-C21	Lock Handle	M12x25L	1
66-1	JTM1254VS-C66-1	Pluger	Ø10x195L	1
67	JTM949EVS-C21	Lock Handle	M12x25L	4
67-1	JTM1254VS-C67-1	Pluger	Ø10 x L50°	1
67-2	JTM1254VS-C67-2	Pluger	Ø10 x L50°	1
68	JTM1254VS-C68	Gib		1
70	JTM1254VS-C70	Chip Guard (Bottom)	680 mm (129x2.0T)	1
71	JTM1254VS-C71	Chip Guard (Middle)	565 mm (129x2.0T)	2
72	JTM1254VS-C72	Chip Guard (Top)	430 mm (129x2.0T)	1
73	JTM1254VS-C73	Knee Support Plate (Right)		1
74	JTM1254VS-C74	Knee Support Plate (Left)		1
75	JTM1254VS-C75	Gib		1
76	JTM1254VS-C76	Hex Socket Cap Screw	M14x35L	10
77	JTM1254RVS-C77	Lock Stud		1
78	JTM949EVS-C06	Adapter Scale		1
79	JTM949EVS-C12	Angle Scale		1
80	TS-1521021	Set Screw	M4x8L	1
81	JTM1050EVS2-39	Lock Nut	Ø45x13L	1
82	JTM1050EVS2-24	Shaft	19H x162L	1
83	JTM1050EVS2-25	Washer	Ø32*17.6*3.2L	2
84	JTM949EVS-C07	Worm	Ø44.4*17.4*50.7 L	1
85	TS-1523021	Socket Set Screw	M6x8L	1
86	KF2R5549	Key	5x5x50L	1
87	JTM1050EVS2-31	Washer	Ø12	3
88	JTM1050EVS2-32	Adapter Locking Bolt	19H*203L, M14*P2.0	3
89	6293347	Spring Pin	Ø3x16L	1
90	JTM1050EVS2-34	Adapter Shaft	Ø30x200L	1
91	JTM1254RVS-C91	Pointer		4
100	TS-1540071	Hex Nut	M10	1
101	JTM949EVS-C84	Side Cover		1
102	TS-1503031	Socket Head Button Screw	M6x12L	2
103	BA51305	Bearing	51305	1
104	BB6205ZZ	Ball Bearing	6205ZZ	1
105	JTM949EVS-C44	Washer		1
106	JTM1254RVS-C106	Chip Pan	5J	1
107	TS-1504031	Hex Socket Cap Screw	M6x12L	4
108	TS-1550041	Flat Washer	Ø6	4
109	LM000243	ID/Warning Label, JTM-1254RVS		1
110	JET-254	JET Logo	254x105 mm	2
	JTM1254RVS-TB	Tool Box Kit Complete (not shown)		1

12.7.1 JTM-1254VS/RVS Table Assembly – Exploded View



12.7.2 JTM-1254VS/RVS Table Assembly – Parts List

Index No	Part No	Description	Size	Qty
1	TS-0561052	Nut	1/2-20UNF	3
2	JTM949EVS-D02	Handle	3/8"	3
	JTM949EVS-D03A	Ball Crank Assembly (includes #2,3)		1
3	JTM949EVS-D03	Ball Crank		3
4	JTM949EVS-D04	Dial Lock Nut		3
5	JTM949EVS-D05	Dial (Inch)	200/0.001"	3
6	JTM949EVS-D06	Dial Holder	3mm / 56.6L	3
7	TS-1503031	Hex Socket Cap Screw	M6x12	9
8	JTM949EVS-D08	Cover		3
9	BB-6204ZZ	Ball Bearing	6204ZZ	5
10	JTM949EVS-D10	Bearing Bracket	Ø60	2
11	5311251	Spring Pin	Ø5x30	6
12	TS-1505011	Hex Socket Cap Screw	M10x16	16
13	KF2R3325	Key	3x3x25	3
14	JTM1254VS-D14	Lead Screw	Ø32 x 5 tpi (1632)	1
15	TS-1503041	Hex Socket Cap Screw	M6x16	10
16	TS-1550041	Flat Washer	M6	4
17	JTM949EVS-D17	Feed Screw Nut (Inch)	Ø32 x 5 tpi	1
17-1	JTM949EVS-D17-1	Feed Screw Nut (Adjust-I)	Ø32 x 5 tpi	1
18	JTM1254VS-D18	Lead Screw Housing		1
20	JTM949EVS-D20	Cross Bearing Bracket		1
21	JTM1254VS-D21	Cross Feed Screw	Ø32 x 5 tpi (720)	1
22	JTM949EVS-D22	Cross Feed Adjustment Nut (Inch)	Ø32 x 5 TPI	1
22-1	JTM949EVS-D22-1	Cross Feed Nut (Inch)	Ø32 x 5 TPI	1
23	JTM949EVS-D23	Adjusting Washer	Ø45xØ34x0.15t	3

12.8.1 JTM-1254VS/RVS Control Box Assembly – Exploded View



12.8.2 JTM-1254VS/RVS Control Box Assembly – Parts List

Index No	Part No	Description	Size	Qty
.....	JTM1254VS-CBA.....	Control Box Assembly (includes #1-8).....		1
1	JTM949EVS-E01	Control Box		1
2	JTM1254VS-CB	Control Panel.....		1
3	JTM949EVS-E09	Emergency Switch		1
4	JTM949EVS-E07	Spindle Stop Button.....		1
5	JTM949EVS-E06	Coolant Pump Switch		1
6	JTM949EVS-E08	Power Start Button		1
7	JTM949EVS-E04	F/R Select Switch		1
8	TS-2245102	Socket Head Button Screw.....	M5x10L	4
9	TS-1540031	Hex Nut.....	M5	4
10	TS-1550031	Flat Washer	Ø5	4
11	JTM949EVS-E12	Handle		1
12	TS-2245162	Socket Head Button Screw.....	M5x16	4
.....	JTM949EVS-E14	Support Rod Unit Assembly (includes #13, 13-1, 13-2, 16, 20, 23)		1
13	JTM1254VS-E13.....	Rod		1
13-1	JTM1254VS-E13-1....	Rotating Bracket		1
13-2	JTM1254VS-E13-2....	Control Box Bracket.....		1
14	TS-1504041	Hex Socket Cap Screw.....	M8X20L	2
15	TS-1523031	Socket Set Screw	M6x10	3
16	JTM949EVS-E18	Lock Handle.....	M12X35L	1
17	JTM949EVS-E19	Bracket.....		1
18	TS-1523051	Hex Socket Cap Screw.....	M6x16L	3
19	JTM1254VS-E19.....	Spacer		1
20	JTM949EVS-B120	Flat Washer	Ø13xØ20x2T	1
21	TS-0640081	Hex Nylon Lock Nut.....	5/16"-18	1
22	JTM1254VS-E22.....	Rubber gasket		1
23	JTM1254VS-E23.....	Nut.....		1
.....	JTM1254VS-D19.....	Cable (Control Panel to Electrical Box) – not shown.....		1

12.9.1 JTM-1254VS/RVS Electrical Box – Exploded View



12.9.2 JTM-1254VS/RVS Electrical Box – Parts List

Index No	Part No	Description	Size	Qty
1	JTM949EVS-F01	Electrical Cabinet (RE: JTM949EVS-F21)		1
2	JTM949EVS-F02	Electrical Plate (RE: JTM949EVS-F21)		1
3	JTM949EVS-F03	Electrical Cabinet Door (RE: JTM949EVS-F21)		1
	JTM949EVS-F21	Electrical Cabinet Assembly (includes #1-3)		1
4	JTM949EVS-F04	Door Latch		1
6	JTM949EVS-F18	Fan Cover		1
7	JTM949EVS-F19	Electric Receptacle		1
8	JTM949EVS-F16	Aluminum Rail		2
9	JTM949EVS-F14	Wire Casing		5
10	JTM949EVS-F15	Terminal Block		1
11	JTM949EVS-F21	Switch Bracket		1
12	JTM949EVS-F05-1	Switch Interface		1
QS1	JTM949EVS-F05	Door Switch (includes #12)		1
TC1	JTM949EVS-F06	Transformer	400VA	1
KM1	JTM1254VS-FKM1	Magnetic Contactor	TECO / CU-11	1
FR1	JTM1254VS-FFR1	Flicker Relay		1
KM2	JTM1254VS-FKM2	Magnetic Contactor	TECO / CU-11	1
KA1	JTM1254VS-FKA1	Relay	RMIA4524VAC	1
KA2	JTM1254VS-FKA2	Relay	RMIA21024VAC	1
KA3	JTM1254VS-FKA3	Relay	RMIA4524VAC	1
QF1	JTM1254VS-FQF1	Power Circuit Breaker	3P 25A	1
QF2	JTM1254VS-FQF2	Power Circuit Breaker	1P 2A	1
QF3	JTM1254VS-FQF3	Power Circuit Breaker	1P 6A	1
QF4	JTM1254VS-FQF4	Power Circuit Breaker	1P 6A	1

12.10.1 JTM-1254VS/RVS Coolant Pump (Optional) – Exploded View

12.11.1 JTM-1254VS/RVS Work Lamp – Exploded View



12.10.2 JTM-1254VS/RVS Coolant Pump (Optional) – Parts List

Index No	Part No	Description	Size	Qty
.....	JTM949EVS-G00	Coolant Pump Kit (includes #1 thru 12)
1	JTM949EVS-G01	Plastic Nozzle	1
2	JTM949EVS-G02	Valve	PT 3/8" x 1/2"	1
3	TS-1503091	Hex Socket Cap Screw	M6 x 40	2
4	JTM949EVS-G04	Block	1
5	JTM949EVS-G07	Hose Fitting	PT 3/8" x 1/2" (90°)	1
6	JTM949EVS-G06	Hose	1/2"	1
7	JTM949EVS-G07	Hose Fitting	PT 3/8" x 1/2" (90°)	1
8	JTM949EVS-G08	Hose Clamp	5/6" (11 ~ 20)	2
9	JTM949EVS-G09	Coolant Pump	1/8HP	1
10	JTM949EVS-G10	External Coolant Tank	1
11	JTM949EVS-G11	Strainer	1
12	JTM949EVS-G12	Cover with handle	1

12.11.2 JTM-1254VS/RVS Work Lamp – Parts List

13	JTM949EVS-G13	Work Lamp	24V / LED	1
14	TS-1502041	Hex Socket Cap Screw	M5X16	4
15	JTM949EVS-G15	Work Light Bracket	1
16	TS-1503041	Hex Socket Cap Screw	M6X16	6
17	TS-1550041	Flat Washer	Ø6mm	6
18	JTM949EVS-G18	LED Bulb (not shown)	24V	1

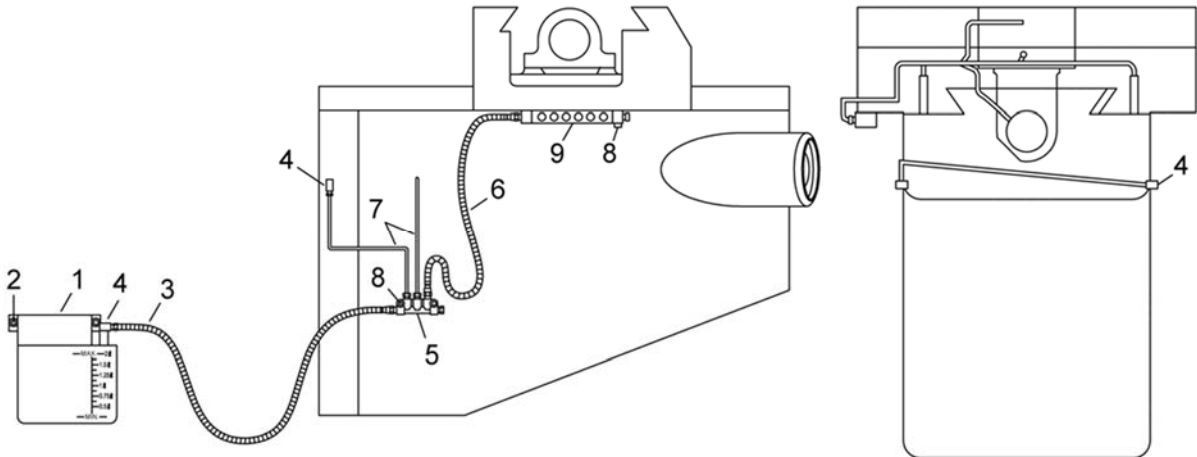
12.12.1 JTM-1254VS/RVS Spindle Guard Assembly – Exploded View



12.12.2 JTM-1254VS/RVS Spindle Guard Assembly – Parts List

Index No	Part No	Description	Size	Qty
	JTM949EVS-SGA	Spindle Guard Assembly (#1 thru 10)		
1	TS-1502101	Hex Socket Cap Screw	M5x45	2
2	JTM949EVS-H02	Support Plate		1
3	TS-2245102	Socket Head Button Screw	M5x10	2
4	JTM949EVS-H04	Bushing Bracket (Re: JTM949EVS-H04A)		1
	JTM949EVS-H04A	Bushing Bracket Assembly (includes #4,5)		1
5	JTM949EVS-H05	Bushing		1
6	JTM949EVS-H06	Support Rod		1
7	TS-1550031	Washer	Ø5	2
8	TS-1502031	Hex Socket Cap Screw	M5x12	2
9	JTM949EVS-H09	Spindle Guard		1
10	TS-1522021	Socket Set Screw	M5x8	1

12.13.1 JTM-1254VS/RVS Lubrication System – Exploded View

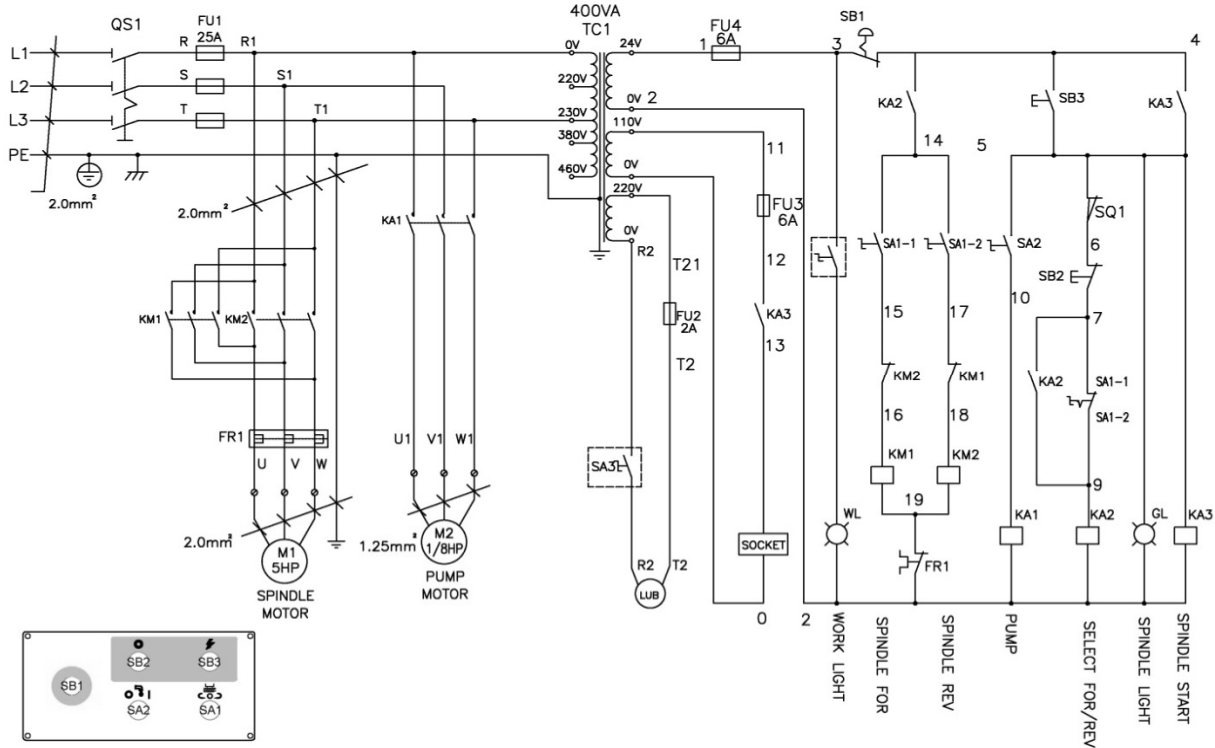


12.13.2 JTM-1254VS/RVS Lubrication System – Parts List

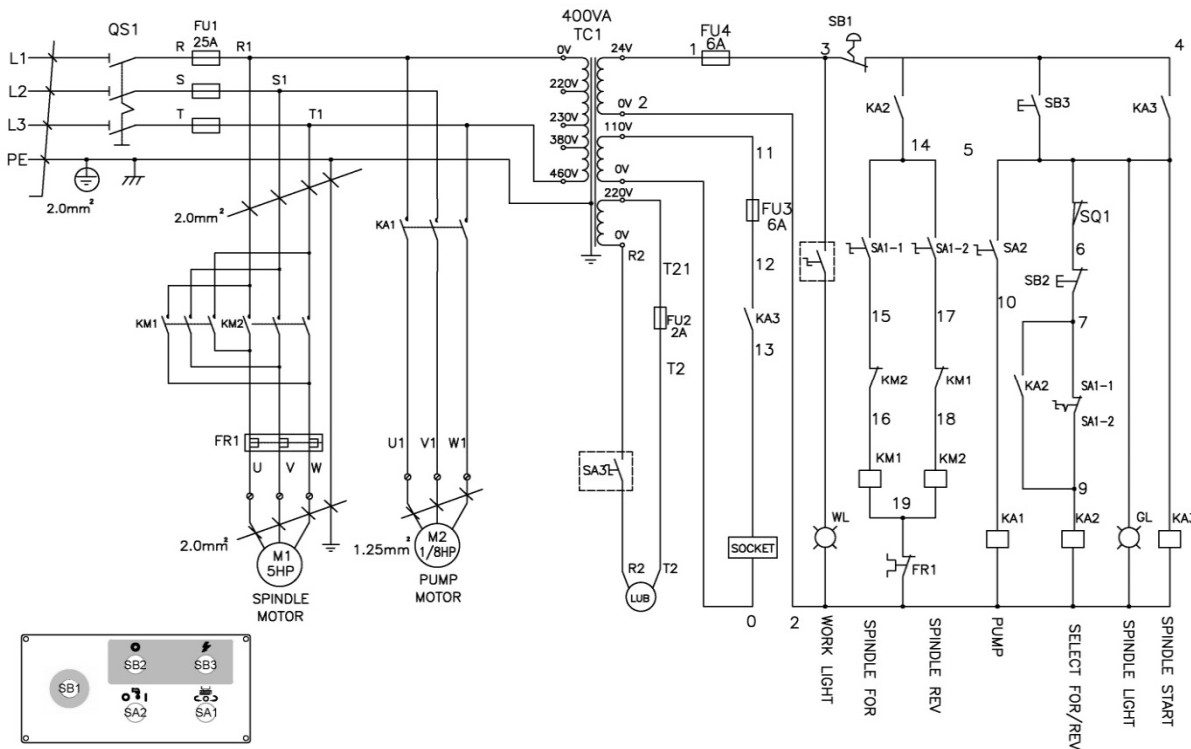
Index No	Part No	Description	Size	Qty
1	JTM949EVS-J01N	Automatic Oiler	2L, 0~180min	1
2	TS-1503061	Hex Socket Cap Screw	M6x25L	2
3	JTM949EVS-J03	Flexible Steel Tube	Ø4	1
4	JTM949EVS-J04	Elbow Adaptor	Ø4	3
5	JTM949EVS-J10	Oil Distributor	Ø4, 6 holes	2
6	JTM949EVS-J06	Flexible Steel Tube		1
7	JTM949EVS-J07	Aluminum Pipe	Ø4	2
8	TS-1502061	Hex Socket Cap Screw	M5x25L	4
9	JTM1254VS-J09	Oil Distributor	Ø4, 8 holes	1
	JTM1254VS-J05A	Oil Distributor Kit (incl. #3,5,6,9)		1

13.0 Electrical Connections – JTM-1254VS/RVS

13.1 230V Wiring Diagram



13.2 460V Wiring Diagram



14.0 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

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