

# Machine Type

#2 Ultramatic Serial 542-2-5601 to 542-2-7575 3/4", 1 1/4" and 1 5/8" Capacity (Early Roller Bearing Machines)

## SPINDLE PARTS

DESCRIPTION	PART NUMBER			QTY
	3/4" Cap	1 1/4" Cap	1 5/8" Cap (early roller)	
Chuck Lever	42-10176-99	42-12397-99	42-12397-99	6
Chuck Lever Fulcrum	42-8108	42-17429	42-19981	1
Clutch Lever	42-9377	42-7168-99	42-7168-99	2
Clutch Lever Fulcrum	(2) 42-17967	(2) 42-17968	(2) 42-17968	2
	(4) 472-199	(4) 472-199	(4) 472-199	
" Lvr Fulcrum Shoe	42-17348-1	42-17430-1	42-19982	2
Clutch Shoe	42-9378	42-7166-99	42-7166-99	2
Spindle Insert	42-9379-1	42-10449-1	42-10449-1	2
Spindle Key	42-17336	42-17419	42-17419	1
Sp Nut Lockwasher	92-2031-45	92-2031-51	92-2031-54	2
Sprocket Bearings	431-14	431-11	431-10	2
Sp Bearing - Front	431-13	431-58 (triplex)	42-17377 (roller)	1
		431-93 (duplex) R/S	431-94 (ball brng) R/S	1
Sp Bearing - Rear	431-15	431-12	431-9	1
Spindle Chain - Front	451-43 high	451-25 high	451-25 high	1
Spindle Chain - Rear	451-22 low	451-26 low	451-26 low	2
Chuck Sleeve Pin	42-20365	42-19956	42-19956	1
Clutch Sleeve Ring	42-17340-1	42-17418	42-17418	
Chuck Fork Slv Comp	42-17349	42-17432	42-19984-99	
Inner Race	42-17350	42-17433	42-19985	
Outer Race	432-1301-1	432-1302-1	432-10	
Fiber Retainer	429-310	429-311	1-432-10	
Ball Set	429-314	429-315	(21) Q10524	

## MACHINE PARTS

DESCRIPTION	PART NUMBER	QTY
Trip Dog - Left (42-15128)	42-21173-1-99	2
Trip Dog - Right (42-15129)	42-21173-1-99	2
Feed Cam Roll	91-215-6	2
Chuck&Feed Roll Stud	42-17545	1
Cam Driving Pin - Back	91-94-12-1	4
Lead Cam Holder Pin	42-17759	1
Clutch Op Screw & Nut	42-16969-1 and	2
	42-16731	
Turret Change Roll	91-215-4	1
Turret Change Roll Stud	42-17599-1	1
Lead Lever Roll	91-215-220	4
Cross Slide Lever Roll	91-215-220	4
Lead Lever Roll Pin	42-17185-1 and	4
	92-5990-632	
Cross Slide Lever Pin	91-90-752 and	4
	92-5990-632	
Turret Locking Pin	42-17232-1	1
Turret Locking Pin Bushing	42-17234	6
Vertical Slide Cam Follower	91-215-220	1
Feed Latch Shear Pin	91-90-782	1
Cam Driving Pin Front	91-94-12-1	1

NOTE: For Ultramatics above s/n 7575 and R/S, please contact us.