

# Machine Type

#2 Ultramatic Serial 542-2-5601  
and up 1 5/8" Capacity

## SPINDLE PARTS

| DESCRIPTION             | PART NUMBER      |             | QTY |
|-------------------------|------------------|-------------|-----|
| Chuck Lever             | 42-12397-99      |             | 6   |
| Chuck Lever Fulcrum     | 42-19981         |             | 1   |
| Chuck Lvr Fulcrum Shoe  | 42-19982         |             | 2   |
| Clutch Lever            | 42-7168-99       |             | 2   |
| Clutch Lever Fulcrum    | (1) 42-17968 and |             | 2   |
|                         | (2) 472-199      |             |     |
| Clutch Shoe             | 42-7166-99       |             | 2   |
| Spindle Insert          | 42-10449-1       |             | 2   |
| Spindle Key             | 42-17419         |             | 1   |
| Sp Nut Lockwasher       | 92-2031-54       |             | 2   |
| Sprocket Bearings       | 431-10           |             | 2   |
| Spindle Bearing - Front | 431-94           |             | 1   |
| Spindle Bearing - Rear  | 431-9            |             |     |
| Spindle Chain - Front   | 451-25-99        |             | 1   |
| Spindle Chain - Rear    | 451-26-99        |             | 1   |
| Chuck Sleeve Pin        | 42-19956         |             | 2   |
| Clutch Sleeve Ring      | 42-17418         |             | 1   |
|                         | Ultra - Early    | Ultra - Ram |     |
| Chuck Fork Slv Comp     | 42-19984-99      | 42-19984-1  |     |
| Inner Race              | 42-19985         | 42-19985-1  |     |
| Outer Race              | 432-10           | 432-11      |     |
| Fiber Retainer          | 1-432-10         | 1-432-11    |     |
| Ball Set                | (21) Q10524      | (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             | 42-16969-1                    | 2   |
| 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<br>92-5990-632 | 4   |
| Cross Slide Lever Pin       | 91-90-752 and<br>92-5990-632  | 4   |
| 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 7747 with R/S, please contact us