

Illustrated Parts Breakdown  
for

**MODEL 766/767 (HJM/HJMD)  
TRIPLEX SLITTER-SCORER**

September 1977



S&S Corrugated Paper Machinery Co., Inc.  
160 North Fourth Street, Brooklyn, New York 11211  
Phone: 212-782-9700 TLX: 223306:232754

Corrugated Paper Machinery Co., Inc.  
Eiko Bldg. 2-2-chome  
Nihonbashi Honcho, Chuo-ku  
Tokyo, Japan  
Phone: (03) 663-9716  
Cable: CORRPAPER TOKYO

S&S Corrugated Machinery Ltd.  
P.O. Box 7, Main Street, Leiston, Suffolk, England  
Phone: Leiston 830811 TLX: 851-99209

S&S Corrugated Paper Machinery  
International (Holland) B.V.  
P.O. Box 993  
Waarderweg 80, Haarlem Holland  
Phone: 23-319007 TLX: 844-41055

Dundalk Engineering Works Ltd.  
Ardee Road, Dundalk, Co. Louth,  
Republic of Ireland  
Phone: Dundalk 34636 TLX: 852-4578

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	VI	12-106		VI	12-40
	VI	12-109		VI	12-47
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1000-208060	VI	16-3		VI	12-77
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1000-209280	VI	03-65		VI	02-52
	VI	02-66	1012-020140	VI	15-24
1000-210230	VI	14-49		VI	12-32
	VI	15-66		VI	12-39
	VI	08-67		VI	12-46
	VI	09-53		VI	15-31
	VI	11-49		VI	09-4
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	VI	12-70		VI	12-26
	VI	12-101	1012-020200	VI	03-57
1000-210300	VI	11-61		VI	02-53
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1000-211230	VI	14-51	1042-300040	VI	17-20
	VI	15-68	1237-197000	VI	08-66
	VI	06-69		VI	09-52
	VI	09-55		VI	11-50
	VI	11-47		VI	11-60
	VI	11-56		VI	11-74
	VI	11-82		VI	12-71
	VI	12-68		VI	12-81
	VI	12-77		VI	12-100
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1000-213000	VI	12-82		VI	17-25
1000-213230	VI	03-62	2-CFR-00069	VI	14-23
	VI	02-63		VI	08-41
1000-216280	VI	16-23		VI	11-24
	VI	17-24		VI	11-32
1000-309230	VI	11-58	1-CFB-00076	VI	14-21
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1000-312010	VI	16-40		VI	08-33
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1000-314010	VI	16-31		VI	11-25
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1002-213230	VI	14-32	2-CFB-00079	VI	08-35
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	VI	14-59	3-CXF-00111	VI	08-32
	VI	15-49	1-CXF-00111	VI	11-31
	VI	15-60	1-CXF-00368	VI	02-6
	VI	15-71	1-CXF-368	VI	02-6
	VI	15-76	1-HJCD-00010	VI	15-59
	VI	11-42	1-HJ D-00001	VI	14-56
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	VI	15-84		VI	14-28
5-HJMD-00003	VI	14-16		VI	15-11
	VI	15-15		VI	15-45
1-HJMD-00005	VI	14-17		VI	11-11
3-HJMD-00005	VI	14-18		VI	11-38
	VI	11-21		VI	12-11
3-HJMD-00006	VI	14-3		VI	12-59
	VI	11-3		VI	13-2
2-HJMD-00008	VI	11-36	1-HJM-00015	VI	03-19
2-HJMD-00009	VI	14-52		VI	02-20
	VI	15-69	1-HJM-00016	VI	14-27
1-HJMD-00010	VI	14-2		VI	15-44
	VI	15-2		VI	11-40
	VI	15-20		VI	12-61
1-HJMD-00016	VI	14-30	1-HJM-00017	VI	14-10
	VI	15-47		VI	15-10
3-HJMD-00017	VI	14-29		VI	11-10
	VI	15-46		VI	12-10
5-HJM-00003	VI	08-25	2-HJM-00018	VI	14-12
5-HJM-00001	VI	16-15		VI	14-13
	VI	17-16		VI	08-11
	VI	03-29		VI	08-16
	VI	02-30		VI	11-13
5-HJM-00004	VI	03-10	1-HJM-00018	VI	13-1
	VI	02-10	2-HJM-00019	VI	14-26
4-HJM-00005	VI	14-64		VI	11-35
	VI	15-81	1-HJM-00023	VI	09-8
	VI	06-71	2-HJM-00020	VI	14-31
	VI	09-57		VI	14-53
1-HJM-00006	VI	14-34		VI	15-48
	VI	14-45		VI	15-70
	VI	15-51		VI	11-64
	VI	15-62		VI	12-85
	VI	08-52	1-HJM-00021	VI	14-9
	VI	08-63		VI	15-9
	VI	09-38		VI	11-9
	VI	09-49		VI	12-9
	VI	10-10	1-HJM-00022	VI	14-5
	VI	10-24		VI	15-5
1-HJM-00007	VI	08-57		VI	08-5
	VI	09-43		VI	09-12
	VI	11-87		VI	11-5
	VI	12-108		VI	11-19
	VI	13-66		VI	12-5
2-HJM-00008	VI	08-68		VI	12-19
	VI	09-54	1-HJM-00023	VI	14-1
	VI	10-29		VI	15-1
2-HJM-00009	VI	08-70		VI	15-18
	VI	09-55		VI	08-2
	VI	10-31		VI	11-1
	VI	11-83		VI	11-22
	VI	12-104		VI	12-1
1-HJM-00010	VI	08-60	3-HJM-00025	VI	03-67
	VI	09-46		VI	02-68
	VI	10-18	3-HJM-00027	VI	08-19
	VI	11-84	1-HJM-00029	VI	08-20
	VI	12-105		VI	09-22
	VI	13-68	1-HJM-00030	VI	16-19
1-HJM-00011	VI	14-65		VI	17-19
	VI	15-82	1-HJM-00031	VI	16-10
	VI	06-72		VI	16-13
	VI	09-58		VI	17-11
	VI	10-36		VI	17-14
	VI	11-98		VI	18-9
	VI	12-119		VI	18-12
1-HJM-00012	VI	14-40	1-HJM-00032	VI	16-42
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1-HJM-00039	VI	08-17		VI	08-62
2-HJM-00040	VI	03-17		VI	09-39
1-HJM-00041	VI	03-24		VI	09-48
1-HJM-00042	VI	03-23		VI	10-11
1-HJM-00043	VI	03-20		VI	10-25
	VI	02-21		VI	11-68
1-HJM-00046	VI	16-65		VI	11-76
	VI	17-66		VI	11-91
1-HJM-00047	VI	16-26		VI	12-89
	VI	17-27		VI	12-98
	VI	18-8		VI	12-112
2-HJM-00048	VI	16-69	1-HJM-00087	VI	08-23
	VI	17-70	1-HJM-00088	VI	16-35
2-HJM-00049	VI	17-35		VI	17-37
2-HJM-00050	VI	17-3	1-HJM-00089	VI	03-56
2-HJM-00051	VI	17-7		VI	02-57
1-HJM-00053	VI	16-8	2-HJM-00091	VI	03-55
	VI	17-10		VI	02-56
2-HJM-00054	VI	16-36	1-HJM-00092	VI	03-22
	VI	17-38	2-HJM-00095	VI	16-34
3-HJM-00055	VI	03-49	1-HJM-00096	VI	16-30
	VI	03-50	2-HJM-00098	VI	16-1
	VI	02-50	1-HJM-00105	VI	03-15
	VI	02-51		VI	02-17
1-HJM-00056	VI	16-43	1-HJM-00106	VI	03-14
	VI	17-45		VI	02-22
1-HJM-00059	VI	14-6	2-HJM-00107	VI	03-13
	VI	11-6		VI	02-23
	VI	12-6	1-HJM-00131	VI	14-66
2-HJM-00061	VI	03-63		VI	15-83
	VI	02-64		VI	08-73
1-HJM-00062	VI	16-39		VI	09-59
	VI	17-41		VI	10-37
3-HJM-00063	VI	17-29		VI	11-99
1-HJM-00064	VI	16-11		VI	12-120
	VI	17-12	3-HJM-00133	VI	17-29
1-HJM-00065	VI	16-66	1-HJM-00134	VI	16-12
	VI	17-67		VI	17-13
2-HJM-00066	VI	17-8	1-HJM-00147	VI	16-14
2-HJM-00067	VI	03-33		VI	17-15
	VI	02-34		VI	18-13
1-HJM-00071	VI	16-41	3-HJM-00148	VI	16-60
	VI	17-43		VI	17-62
1-HJM-00078	VI	03-60	1-HJM-00149	VI	08-14
	VI	02-61	3-HJM-00174	VI	16-28
1-HJM-00079	VI	03-54	1-HJM-00193	VI	08-47
	VI	02-55		VI	09-33
1-HJM-00081	VI	08-21		VI	10-2
1-HJM-00082	VI	14-33	3-HJM-00194	VI	03-26
	VI	14-44		VI	02-27
	VI	14-55	1-HJM-00196	VI	03-25
	VI	14-60		VI	02-26
	VI	15-50	3-HJM-00199	VI	03-1
	VI	15-61		VI	02-1
	VI	15-72	1-HJM-00205	VI	16-52
	VI	15-77		VI	17-54
	VI	08-51	1-HJM-00230	VI	12-22
	VI	08-64	1-HJM-00232	VI	16-63
	VI	09-37		VI	17-65
	VI	09-50	3-HJM-00257	VI	08-1
	VI	11-75		VI	09-10
	VI	11-93	2-HJM-00258	VI	08-46
	VI	12-96		VI	09-32
	VI	12-114		VI	10-1
1-HJM-00083	VI	14-35	2-HJM-00259	VI	08-26
	VI	14-46	1-HJM-00260	VI	08-12
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3-HJM-00263	VI	09-9	4-HJM-00538	VI	12-13
	VI	08-49	1-HJM-00547	VI	09-19
	VI	09-35	3-HJM-00548	VI	08-74
	VI	11-95		VI	09-60
3-HJM-00264	VI	12-116	3-HJM-00549	VI	09-20
	VI	08-44	2-HJM-00550	VI	4A-20
	VI	09-7		VI	4B-15
	VI	11-27		VI	4C-15
2-HJM-00275	VI	12-24		VI	4D-18
	VI	08-9	5-HJM-00554	VI	10-32
	VI	09-16	2-HJM-00559	VI	19-2
	VI	10-39	2-HJM-00567	VI	19-1
	VI	11-16	4-HJM-00568	VI	19-8
1-HJM-00276	VI	12-15	1-HJM-00569	VI	19-4
	VI	13-81	2-HJM-00574	VI	16-27
	VI	08-06		VI	17-28
	VI	09-13	4-HJM-00575	VI	19-8
1-HJM-00277	VI	11-18	2-HJM-103	VI	16-60
	VI	12-18	1-HJM-104	VI	03-42
	VI	08-48		VI	02-43
	VI	09-34	1-HJM-131	VI	13-79
	VI	10-4	2-HJM-50090	VI	03-58
	VI	11-96		VI	02-59
	VI	12-117	1-HJM-50130	VI	14-14
2-HJM-00282	VI	13-80		VI	15-14
	VI	08-11	2-HJM-50137	VI	03-47
	VI	08-16		VI	02-48
2-HJM-00315	VI	11-13	2-HJM-50175	VI	03-59
1-HJM-00322	VI	03-34		VI	02-60
	VI	02-35	2-HJM-50209	VI	03-8
1-HJM-00327	VI	02-29	1-HJM-50209	VI	14-7
	VI	03-28	2-HJM-50209	VI	15-6
3-HJM-00345	VI	02-1		VI	15-7
2-HJM-00350	VI	11-13		VI	02-8
3-HJM-00362	VI	02-1		VI	08-7
1-HJM-00390	VI	03-9		VI	09-14
	VI	02-9		VI	11-7
3-HJM-00409	VI	16-59	1-HJM-50262	VI	12-7
	VI	17-61		VI	08-10
3-HJM-00410	VI	16-25		VI	09-17
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	VI	17-6	2-HJM-50423	VI	13-82
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3-HJM-00472	VI	15-26		VI	02-41
	VI	09-28	3-HJM-50432	VI	03-48
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	VI	12-41	2-HJM-50437	VI	19-3
3-HJM-00479	VI	05-24	2-HJM-50440	VI	19-5
1-HJM-00494	VI	17-48	1-HJM-50443	VI	05-15
2-HJM-00495	VI	16-44	2-HJM-50444	VI	16-53
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2-HJM-00522	VI	09-23	1-765-00004	VI	18-10
3-HJM-00524	VI	14-15	3-765-00006	VI	18-14
	VI	15-16	1-765-00030	VI	18-3
	VI	09-21	1-765-00175	VI	12-126
1-HJM-00525	VI	03-45	3-767-00013	VI	18-14
	VI	02-46	1-767-00014	VI	18-11
1-HJM-00527	VI	03-46	1-767-00140	VI	05-8
	VI	02-47	1-767-00141	VI	05-7
1-HJM-00528	VI	03-37	2-767-00142	VI	05-13
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1-767-00152	VI	05-25		VI	13-69
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1-767-00157	VI	05-12		VI	13-13
2-767-00158	VI	05-11		VI	13-34
2-767-00159	VI	11-37		VI	13-48
5-767-00160	VI	11-17	4-767-00262	VI	13-77
5-767-00161	VI	11-100	2-767-00263	VI	13-18
	VI	12-121	2-767-00264	VI	13-42
2-767-00164	VI	11-41	2-767-00275	VI	13-3
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3-767-00168	VI	15-19	1-767-00277	VI	11-77
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	VI	12-21		VI	12-97
2-767-00174	VI	11-107		VI	12-113
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1-767-00175	VI	11-105		VI	13-74
	VI	11-106	2-767-00278	VI	11-81
	VI	12-128		VI	12-102
	VI	13-85	1-767-00279	VI	11-63
	VI	13-87		VI	12-64
2-767-00207	VI	11-48	2-767-00280	VI	13-19
	VI	12-69	2-767-00283	VI	11-44
2-767-00213	VI	11-55		VI	11-53
2-767-00210	VI	11-46		VI	12-65
	VI	12-67		VI	12-74
3-767-00211	VI	11-12	1-767-00284	VI	11-67
3-767-00213	VI	15-3		VI	12-88
2-767-00213	VI	12-76	2-767-00284	VI	11-71
4-767-00214	VI	10-35		VI	12-92
	VI	11-97	2-767-00293	VI	11-57
	VI	12-118		VI	12-78
3-767-00216	VI	11-12	1-767-00298	VI	11-62
2-767-00217	VI	15-27		VI	12-83
	VI	15-33		VI	13-26
	VI	09-2	2-767-00302	VI	13-22
	VI	09-29	1-767-00308	VI	13-28
	VI	12-28	1-767-00314	VI	13-78
	VI	12-35	2-767-00315	VI	13-59
	VI	12-42	2-767-00316	VI	13-61
	VI	12-48	4-767-00317	VI	19-8
3-767-00218	VI	12-2		VI	19-8
3-767-00229	VI	15-22	4-767-00318	VI	19-8
2-767-00229	VI	09-24	4-767-00319	VI	13-77
	VI	12-30	3-767-50194	VI	05-23
	VI	12-37	3-767-50195	VI	05-4
2-767-00230	VI	15-29	5-767-50196	VI	05-9
	VI	12-44	3-767-50197	VI	05-23
3-767-00235	VI	11-12	2-767-50200	VI	18-1
3-767-00238	VI	11-12	1-767-50207	VI	11-2
2-767-00240	VI	13-41		VI	11-23
2-767-00241	VI	13-39		VI	12-3
5-767-00242	VI	13-88		VI	12-23
2-767-00251	VI	10-19	3-767-50219	VI	13-50
	VI	13-58	1-902-00428	VI	08-61
1-767-00252	VI	10-7	1-912-00428	VI	09-47
	VI	10-21	2-930-00010	VI	03-5
	VI	13-5		VI	03-32
	VI	13-16		VI	02-5
	VI	13-31		VI	02-33
	VI	13-44	2-930-01045-2-0	VI	08-43
	VI	13-56	2-930-01045-2	VI	09-5
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	VI	12-31		VI	13-51
	VI	12-38		VI	13-76
	VI	12-45	1-942-00942-1	VI	08-76
1-930-05668	VI	03-41		VI	09-62
	VI	02-42	1-942-00994	VI	02-7
1-932-00057	VI	03-35	1-942-00994-0-0	VI	02-7
	VI	02-36	1-942-01251	VI	06-4
2-936-50001-2	VI	03-68		VI	07-4
	VI	02-69	1-942-01261	VI	08-28
1-942-00124-2	VI	11-4		VI	08-37
	VI	11-20	1-942-01350	VI	16-43
	VI	12-20		VI	17-45
3-942-00124-3	VI	14-4	1-942-02038	VI	16-70
1-942-00124-3	VI	15-4		VI	17-71
3-942-00124-3	VI	09-11	1-942-02039	VI	16-16
1-942-00124-3	VI	12-4		VI	17-22
3-942-00124-3-0	VI	08-4		VI	18-6
1-942-00358	VI	17-1	1-942-02040	VI	11-39
1-942-00410	VI	14-37		VI	11-102
	VI	15-54		VI	12-60
1-942-00410-0-A	VI	10-4		VI	12-123
	VI	10-13	1-942-02225	VI	19-6
	VI	11-89	1-943-00184	VI	4A-5
	VI	12-110		VI	4B-4
2-942-00410-1-0	VI	08-55		VI	4C-5
	VI	09-41		VI	4D-4
1-942-00428	VI	14-30	1-943-00185	VI	4A-6
	VI	14-47		VI	4B-5
	VI	14-58		VI	4C-6
	VI	14-63		VI	4D-5
	VI	14-68	1-943-00201	VI	03-16
	VI	15-53	1-943-00202	VI	03-18
	VI	15-64	1-943-00303	VI	4A-1
	VI	15-75		VI	4C-1
	VI	15-80	1-943-01816	VI	4A-13
	VI	15-85		VI	4B-11
	VI	11-103		VI	4C-12
	VI	11-104		VI	4D-11
	VI	12-124	1-943-01818	VI	4A-14
	VI	12-125	1-943-01819	VI	4A-15
2-942-00428-0-0	VI	13-84		VI	4D-13
1-942-00428-0-A	VI	10-12	2-945-00068	VI	16-49
	VI	10-26		VI	17-51
	VI	10-33	1-945-00385	VI	17-2
	VI	10-34	2-945-00479	VI	16-49
	VI	11-45		VI	17-51
	VI	11-51	1-946-40150	VI	14-8
	VI	11-69		VI	15-8
	VI	11-70		VI	11-8
	VI	11-78		VI	12-8
	VI	11-90	1-946-40343	VI	08-8
	VI	12-66		VI	09-15
	VI	12-72		VI	10-40
	VI	12-90		VI	11-14
	VI	12-91		VI	12-16
	VI	12-99	1-946-50237	VI	03-64
	VI	12-111		VI	02-65
2-942-00428-1	VI	16-20	1-946-50262	VI	16-29
	VI	16-67		VI	16-37
	VI	17-18		VI	17-39
	VI	17-68	1-947-60162	VI	13-8
	VI	18-2		VI	13-12
2-942-00428-1-0	VI	08-54		VI	13-35
	VI	08-78		VI	13-47
	VI	08-79	1-947-60200	VI	13-52
	VI	09-40		VI	13-75
	VI	09-64	1-947-60256	VI	11-43
				VI	11-52

NUMERICAL INDEX (cont.)

PART NUMBER	SECT	FIG IND	PART NUMBER	SECT	FIG IND
	VI	11-72			
	VI	12-64			
	VI	12-73			
	VI	12-93			
1-948-50212	VI	17-31			
1-948-50267	VI	17-30			
1-948-70575	VI	16-61			
	VI	17-63			
1-949-50212	VI	17-32			

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ILLUSTRATED PARTS BREAKDOWN . . . . .	6-6 thru 6-70
NUMERICAL INDEX . . . . .	6-71 thru 6-77/78 Blank

## LIST OF ILLUSTRATIONS

Figure	Title	Page	Figure	Title	Page
A	Typical Example of an Exploded View . . . . .	6-3	6-11	HJM 8-Bar Swivel Assembly, Without Gang Locking, Operating Side (2 Sheets) . . . . .	6-38
B	Typical Example of Parts Listing . . . . .	6-4	6-12	HJM 8-Bar Swivel Assembly, With Gang Locking, Operating Side (2 Sheets) . . . . .	6-44
C	Typical Example of Numerical Listing . . . . .	6-5	6-13	8-Bar, 109" Only, Operating Side . . . . .	6-48
6-1	Model HJM, HJMD, 6-8-12 Bar Machines, with Manual and Gang Locking . . . . .	6-6	6-14	HJMD 12-Bar Swivel Assembly, Without Gang Locking, Operating Side (2 Sheets) . . . . .	6-52
6-2	Main Assembly, with Gang Locking (3 Sheets) . . . . .	6-9	6-15	HJMD 12-Bar, Swivel Assembly, With Gang Locking, Operating Side (2 Sheets) . . . . .	6-56
6-3	Main Assembly, Manual Locking (3 Sheets) . . . . .	6-13	6-16	Drive Side Stationary Unit Assembly, Automatic (2 Sheets) . . . . .	6-60
6-4	Control Station . . . . .	6-18	6-17	Drive Side Stationary Unit Assembly, Friction Drive (2 Sheets) . . . . .	6-66
6-5	Positive Locking Device Assembly . . . . .	6-21	6-18	Drive Side Stationary Unit Assembly, 12-Bar Only . . . . .	6-68
6-6	Piping Layout for Index Lock . . . . .	6-23	6-19	Shaft Assembly, Air Hose Gang Locking, All Machines . . . . .	6-70
6-7	Piping Layout for Index Lock (L.H. Drive) . . . . .	6-25			
6-8	Swivel Assembly, 6-Bar Without Gang Locking, Operating Side (2 Sheets) . . . . .	6-28			
6-9	Swivel Frame, 6-Bar With Gang Locking, Operating Side (2 Sheets) . . . . .	6-32			
6-10	6-Bar Drive Side Swivel Assembly, 109" Machine Only . . . . .	6-35			

## PREFACE

This manual contains complete disassembly drawings for the entire Model 766/767 (HJM/HJMD) TRIPLEX SLITTER-SCORER. It is not necessary to disassemble the entire machine to repair or replace parts. When a part is to be removed and replaced, the proper procedure is to go to the specific illustration showing that part and to work from that drawing.

This parts breakdown presents the most advanced design of the Model 766/767 TRIPLEX SLITTER-SCORER. Your machine may not be designed exactly as illustrated and allowance for modification in disassembly must be made.

The figures are arranged in order of disassembly of the machine. Each figure is arranged in the order of disassembly of the area shown either in the upper left-hand corner of the drawing or the section drawing. In many cases, a single illustration contains several subassemblies which are shown in disassembly order. If you are working on only one of these subassemblies, do not disassemble the parts which are shown in other sections of the illustration.

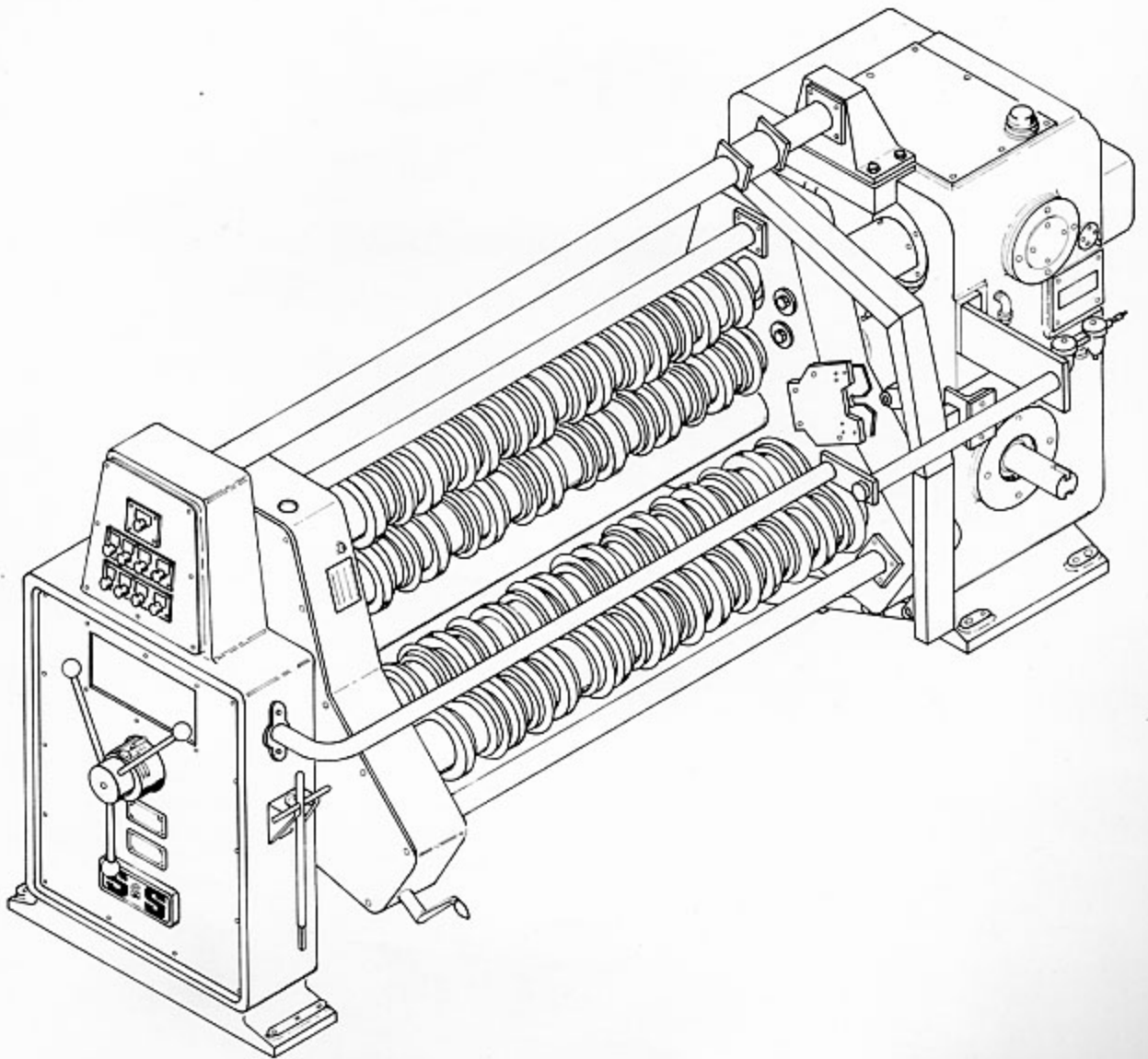
### CAUTION

It is not necessary to disassemble minor subassemblies which work well to replace a part on an assembly which does not function properly. For example, if a subassembly which needs repair is numbered from 7 through 11, do not disassemble the assembly numbered 1 through 6.

When ordering spare parts, the following information must accompany the order:

1. Machine serial number.
2. Part Number.
3. Complete description of the part.
4. Quantity desired.

## SECTION VI





## HOW TO USE THE ILLUSTRATED PARTS BREAKDOWN

### A. INTRODUCTION.

This is an illustrated parts breakdown. It contains complete disassembly drawings for the Model 766/767 (HJM/HJMD) Triplex Slitter-Scorer.

The two-part page number (for example, 6-3 or 6-5) on each sheet is an aid. The number to the left of the dash is the section number and the number to the right of the dash is the sequence number. In other words, page 6-4 is the fourth sheet or page in Section VI and page 6-5 is the fifth sheet or page in Section VI. Illustrations are also designated by a two-part number; for example, Figure 6-7 is the seventh figure in Section VI.

An illustrated parts breakdown is composed of illustrations or exploded views and a parts listing. Illustrations are called exploded views because of the "blown apart" manner in which parts are drawn. In order to coordinate the part in the exploded view and its description, an item or index number is used. The index number is next to its assigned part in the exploded view. In the parts listing, these index numbers appear chronologically or in regular number order sequence, for example, 1, 2, 3, 4, etc. Within the listing, a full description of the part is given in disassembly order. The listing format consists of four columns:

Item No.	The figure number and index number assigned to each part in the exploded view.
Description	Complete title and description of the part. The names of commercial manufacturers are in parenthesis.  A full description of standard hardware is given although not illustrated. Standard hardware hardware, attaching various parts together, is indented in the listing following the part or parts that it attaches.
Part No.	The S & S part number is listed. Part numbers appearing in parenthesis are standard catalog items of the vendors whose names appear in parenthesis in the description column.

Quantity per Assembly	Total number of specific parts used in the assembly.
-----------------------	--

### B. PROCEDURE FOR USING ILLUSTRATED PARTS BREAKDOWN.

#### 1. WHEN PART NUMBER IS NOT KNOWN

- Determine the function and application of the part required.
- Refer to the List of Illustrations (Page iii) and select the most appropriate figure, and note the page number.
- Turn to the indicated page number (Figure A) and locate the desired part on the figure (Figure A).
- Check the index number assigned to the part (Figure A). Refer to the listing for specific information concerning the part (Figure B).

#### 2. WHEN PART NUMBER IS KNOWN

- Refer to the Numerical Index (Figure C). The format is as follows:  

Part Number	- The S & S part number is listed. Part numbers consisting of 10 numbers are listed first. Part numbers with mixed numbers and letters are listed next in alphabetical order for the letters and numerical order for the numbers.
SECT	- The section number is listed.
FIG	- The figure number for each section is listed.
IND	- The index number is given.
- Locate the part number in the index and note the figure (Figure C) and the index numbers (Figure C) assigned to the part number.
- Turn to the corresponding figure number in the book and find the index number in the exploded view.



Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

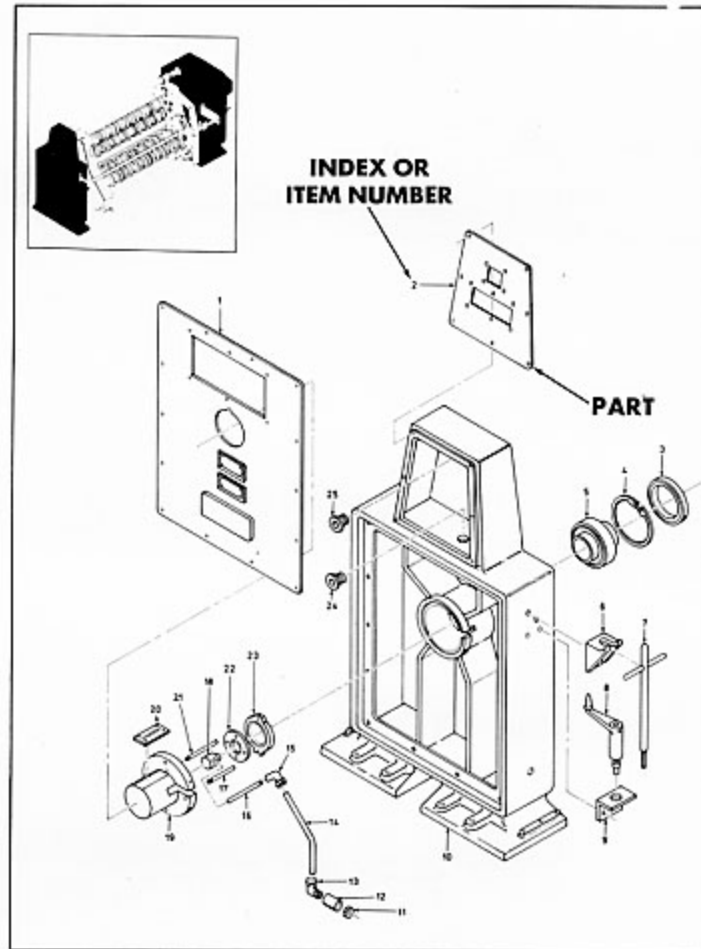


Figure 6-2. Main Assembly, with Gang Locking (Sheet 1 of 3)

SECTION NUMBER

FIGURE NUMBER

SECTION NUMBER

PAGE NUMBER

Figure A. Typical Example of an Exploded View

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-1	MODEL HJM, HJMD, 6-8-12 BAR MACHINES, With manual and gang locking		
-1	MAIN ASSEMBLY TRIPLEX SLITTER-SCORER, 6-8-12 bar, with gang locking (See figure 6-2 for detail breakdown)		
-2	MAIN ASSEMBLY TRIPLEX SLITTER-SCORER, 6-8-12 bar, with manual locking (See figure 6-3 for detail breakdown)		
	SWIVEL ASSEMBLY, 6 bar, with manual locking (See figure 6-8 for detail breakdown)		
	SWIVEL ASSEMBLY, 6 bar, with gang locking (See figure 6-9 for detail breakdown)		
	SWIVEL ASSEMBLY, 6 bar, 109 inch machine only (See figure 6-10 for detail breakdown)		
	SWIVEL ASSEMBLY, 8 bar, with manual locking (See figure 6-11 for detail breakdown)		
	SWIVEL ASSEMBLY, 8 bar, with gang locking (See figure 6-12 for detail breakdown)		
	SWIVEL ASSEMBLY, 8 bar, 109 inch machine only (See figure 6-13 for detail breakdown)		
	SWIVEL ASSEMBLY, 12 bar, with manual locking (See figure 6-14 for detail breakdown)		
	SWIVEL ASSEMBLY, 12 bar, with gang locking (See figure 6-15 for detail breakdown)		
-3	POSITIVE LOCKING DEVICE ASSEMBLY, All machines (See figure 6-5 for detail breakdown)		

Item No.	Description	Part Number	Qty Per Assy
6-2	MAIN ASSEMBLY, With gang locking		
-1	COVER, Main frame, operator side, without "LT"	3-HJM-00159	1
	COVER, Main frame, operator side, with "LT", except JST	3-HJM-00345	1
	COVER, Main frame, operator side, with "LT" to JST only	3-HJM-00362	1
	3/8-16 x 3/4 long button head socket cap screw		(14)
-2	SEE FIG. 6-4 FOR DETAIL BREAKDOWN		
-3	OIL SEAL, C/R	(500516)	1
-4	TRUARC RING	(5000-800)	1
-5	ROLLER BEARING	2-930-00010	1
-6	BRACKET, Wrench	1-CXF-00268	1
-7	WRENCH, Hexagonal-T	1-942-00994	1
-8	WRENCH	2-HJM-30209	1
-9	BRACKET, Wrench	1-HJM-00390	1
-10	FRAME, Operating side	5-HJM-00004	1
-11	JAM NUT, 3/4-10		2
-12	BULK HEAD ADAPTOR 3/4-10 jam nut	1-HJM-00531	1 (2)
-13	ELBOW, 90°, 1/4 MPT to 3/8 O.D. tube		1
-14	TUBING GROUP-1 (4212-650) Samuel Moore, 3/8 O.D. x 0.050 wall, 3 feet long		1
-15	ELBOW, 90°, 1/4 female NPT to 3/8 O.D. tube		1

ITEM NUMBER

PART NUMBER

6-7

Figure B. Typical Example of Parts Listing

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

NUMERICAL INDEX (cont.)

PART NUMBER	SECT	FIG IND	PART NUMBER	SECT	FIG IND
	VI	17-21		VI	15-74
	VI	16-5		VI	15-79
2-HJM-00038	VI	08-18		VI	08-53
1-HJM-00039	VI	08-17		VI	08-62
2-HJM-00040	VI	03-17		VI	09-39
1-HJM-00041	VI	03-24		VI	09-48
1-HJM-00042	VI	03-23		VI	10-11
1-HJM-00043	VI	03-20		VI	10-25
	VI	02-21		VI	11-68
1-HJM-00046	VI	16-65		VI	11-76
	VI	17-56		VI	11-91
1-HJM-00047	VI	16-26		VI	12-89
	VI	17-27		VI	12-98
	VI	18-8		VI	12-112
2-HJM-00048	VI	16-69	1-HJM-00087	VI	08-23
	VI	17-70	1-HJM-00088	VI	16-35
2-HJM-00049	VI	17-35		VI	17-37
2-HJM-00050	VI	17-3	1-HJM-00089	VI	03-56
2-HJM-00051	VI	17-2		VI	02-57
1-HJM-00053	VI	16-8	2-HJM-00091	VI	03-55
	VI	17-10		VI	02-56
2-HJM-00054	VI	16-36	1-HJM-00092	VI	03-22
	VI	17-38	2-HJM-00095	VI	16-34
3-HJM-00055	VI	03-49	1-HJM-00096	VI	16-30
	VI	03-50	1-HJM-00098	VI	16-1
	VI	02-50	1-HJM-00105	VI	03-15
1-HJM-00056	VI	02-51		VI	02-17
	VI	16-43	1-HJM-00106	VI	03-14
1-HJM-00059	VI	17-45		VI	02-22
	VI	14-6		VI	03-13
	VI	11-6		VI	02-21
	VI	12-6	1-HJM-00132	VI	14-66
2-HJM-00061	VI	03-63		VI	15-83
	VI	02-64		VI	08-73
1-HJM-00062	VI	16-39		VI	09-59
	VI	17-41		VI	10-37
3-HJM-00063	VI	17-29		VI	11-99
1-HJM-00064	VI	16-11		VI	12-120
	VI	17-12	3-HJM-00133	VI	17-29
1-HJM-00065	VI	16-66	1-HJM-00134	VI	16-12
	VI	17-67		VI	17-13
2-HJM-00066	VI	17-8	1-HJM-00147	VI	16-14
2-HJM-00067	VI	03-33		VI	17-15
	VI	02-34	3-HJM-00148	VI	18-13
1-HJM-00071	VI	16-41		VI	16-60
	VI	17-43		VI	17-62
1-HJM-00078	VI	03-60	1-HJM-00149	VI	09-14
	VI	02-61	3-HJM-00174	VI	16-28
1-HJM-00079	VI	03-54	1-HJM-00193	VI	08-47
	VI	02-55		VI	09-33
1-HJM-00081	VI	08-21		VI	10-2
1-HJM-00082	VI	14-33	3-HJM-00194	VI	03-26
	VI	14-44		VI	02-27
	VI	14-55	1-HJM-00196	VI	03-25
	VI	14-60		VI	02-26
	VI	15-50	3-HJM-00199	VI	03-1
	VI	15-61		VI	02-1
	VI	15-72	1-HJM-00205	VI	16-52
	VI	15-77		VI	17-54
	VI	08-51	1-HJM-00230	VI	12-22
	VI	08-64	1-HJM-00232	VI	16-63
	VI	09-37		VI	17-65
	VI	09-50	3-HJM-00257	VI	08-1
	VI	11-75		VI	09-10
	VI	11-93	2-HJM-00258	VI	08-46
	VI	12-96		VI	09-32
	VI	12-114		VI	10-1
1-HJM-00083	VI	14-35	2-HJM-00259	VI	08-26
	VI	14-46	1-HJM-00260	VI	08-12
	VI	14-57		VI	08-45
	VI	14-62		VI	09-18
	VI	15-52		VI	09-31
	VI	15-63		VI	11-101

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Figure C. Typical Example of Numerical Listing

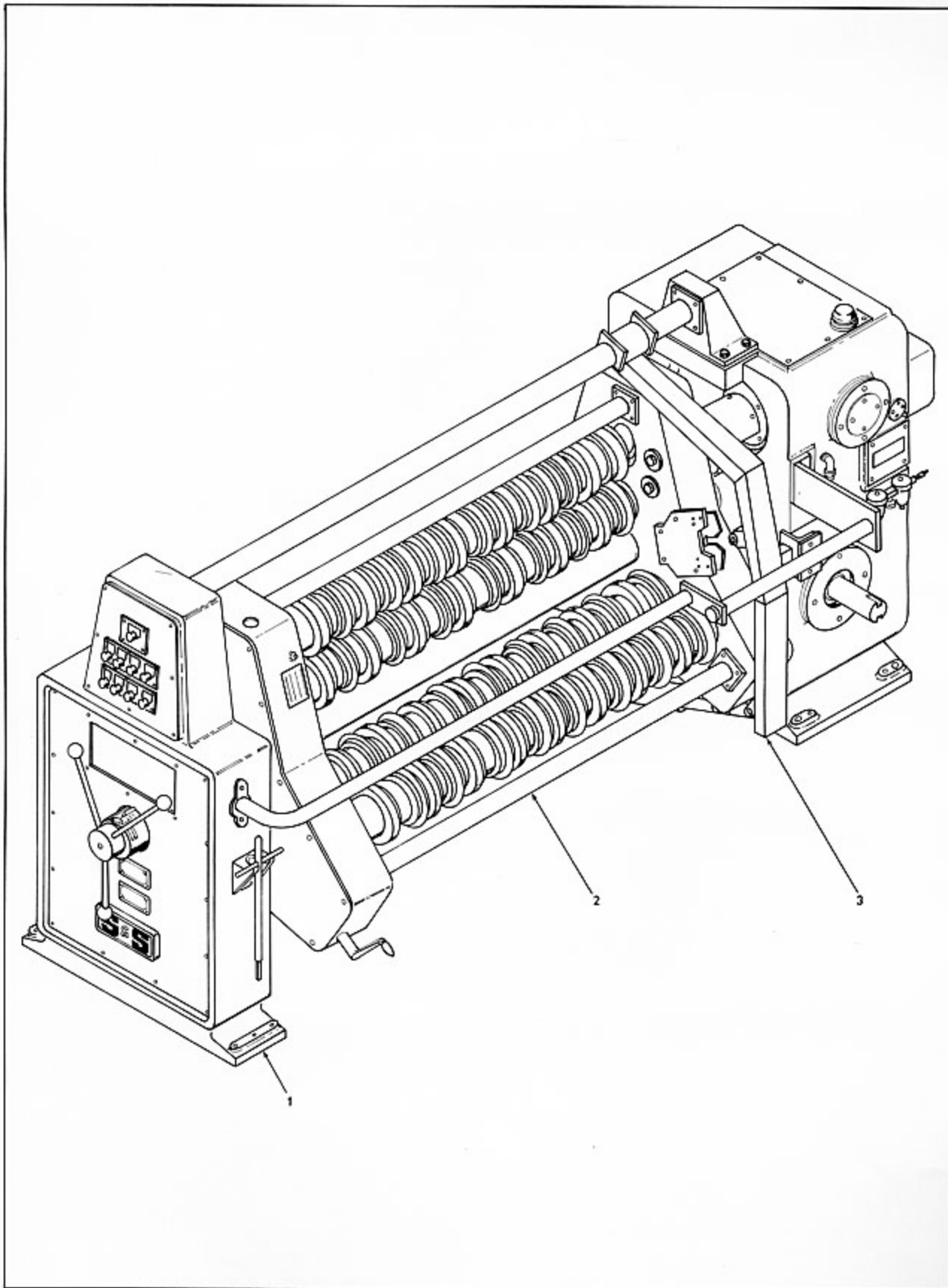


Figure 6-1. Model HJM, HJMD, 6-8-12 Bar Machines, with Manual and Gang Locking

Item No.	Description	Part Number	Qty Per Assy
6-1	MODEL HJM, HJMD, 6-8-12 BAR MACHINES, With manual and gang locking		
-1	MAIN ASSEMBLY TRIPLEX SLITTER-SCORER, 6-8-12 bar, with gang locking (See figure 6-2 for detail breakdown)		
	MAIN ASSEMBLY TRIPLEX SLITTER-SCORER, 6-8-12 bar, with manual locking (See figure 6-3 for detail breakdown)		
-2	SWIVEL ASSEMBLY, 6 bar, with manual locking (See figure 6-8 for detail breakdown)		
	SWIVEL ASSEMBLY, 6 bar, with gang locking (See figure 6-9 for detail breakdown)		
	SWIVEL ASSEMBLY, 6 bar, 109 inch machine only (See figure 6-10 for detail breakdown)		
	SWIVEL ASSEMBLY, 8 bar, with manual locking (See figure 6-11 for detail breakdown)		
	SWIVEL ASSEMBLY, 8 bar, with gang locking (See figure 6-12 for detail breakdown)		
	SWIVEL ASSEMBLY, 8 bar, 109 inch machine only (See figure 6-13 for detail breakdown)		
	SWIVEL ASSEMBLY, 12 bar, with manual locking (See figure 6-14 for detail breakdown)		
	SWIVEL ASSEMBLY, 12 bar, with gang locking (See figure 6-15 for detail breakdown)		
-3	POSITIVE LOCKING DEVICE ASSEMBLY, All machines (See figure 6-5 for detail breakdown)		

Item No.	Description	Part Number	Qty Per Assy
6-2	MAIN ASSEMBLY, With gang locking		
-1	COVER, Main frame, operator side, without "LT"	3-HJM-00199	1
	COVER, Main frame, operator side, with "LT", except JST	3-HJM-00345	1
	COVER, Main frame, operator side, with "LT" to JST only	3-HJM-00362	1
	3/8-16 x 3/4 long button head socket cap screw		(14)
-2	SEE FIG. 6-4 FOR DETAIL BREAKDOWN		
-3	OIL SEAL, C/R	(800616)	1
-4	TRUARC RING	(5000-800)	1
-5	ROLLER BEARING	2-930-00010	1
-6	BRACKET, Wrench	1-CXF-00368	1
-7	WRENCH, Hexagonal-T	1-942-00994	1
-8	WRENCH	2-HJM-50209	1
-9	BRACKET, Wrench	1-HJM-00390	1
-10	FRAME, Operating side	5-HJM-00004	1
-11	JAM NUT, 3/4-10		2
-12	BULK HEAD ADAPTOR 3/4-10 jam nut	1-HJM-00531	1 (2)
-13	ELBOW, 90°, 1/4 MPT to 3/8 O.D. tube		1
-14	TUBING GROUP-1 (4212-650) Samuel Moore, 3/8 O.D. x 0.050 wall, 3 feet long		1
-15	ELBOW, 90°, 1/4 female NPT to 3/8 O.D. tube		1

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-2	MAIN ASSEMBLY, With gang locking (CONT)		
-16	PIPE NIPPLE, 1/4" x 7" long		1
-17	ROD, Guide, indicator ring	1-HJM-00105	1
-18	ROTO COUPLING, 1/4-Wichita (Bulletin 106)	(239-1-1)	1
-19	HOUSING, Roto coupling	3-HJM-00520	1
-20	SCALE	1-HJM-00015	1
-21	INDICATOR, Lateral adjust	1-HJM-00043	1
-22	RETAINER, Indicator ring	1-HJM-00106	1
-23	RING, Indicator	2-HJM-00107	1
	1/4-20 x 3/8 long socket head cap screw		(1)
-24	NIPPLE, Insulated chase, T&B 1/2 inch	(1942)	2
-25	NIPPLE, Chase, 1-1/4 T&B insulated	(1945)	2
-26	BRACE, Upper	1-HJM-00196	1
-27	BRACKET, Upper brace	3-HJM-00194	1
-28	NIPPLE, Insulated chase, 1-1/4 (T&B)	(1945)	1
-29	COVER, Conduit	1-HJM-00327	1
-30	FRAME, Drive side	5-HJM-00001	1
-31	OILSEAL, C/R	(800616)	1
-32	TRUARC RING	(5000-800)	1
-33	ROLLER BEARING	2-930-00010	1
-34	BASE MOTOR	2-HJM-00067	1
	1/2-13 x 1-1/4 long hex. head cap screw		(7)
	1/2-13 x 1-3/4 long hex. head cap screw		(4)
	1/2 L' washers		(11)
	1/2 Plain washers		(4)
-35	COVER, Inspection, Warner clutch	1-HJM-00322	1
	1/4-20 x 1/2 long hex. head cap screw		(4)
	1/4 L' washer		(4)
-36	MOTOR, Master gear, 1-1/2 H. P. (145-CG-21-F)	1-932-00057	1
-37	SUPPORT, Limit switch	2-HJM-00501	1
-38	GUIDE, Hyp. lat. adjust	1-HJM-00528	1
-39	ALLEN BRADLEY LIMIT SWITCH	820T-D	2
-40	ANGLE, Support guide	1-HJM-00529	1
-41	MOUNTING, Hydraulic cylinder lateral adjust	3-HJM-50431	1
	1/2-13 x 1-1/4 long hex. head cap screw		(4)
	1/2 L' washer		(4)
	3/8-16 x 3/4 long hex. head cap screw		(2)
	3/8 L' washer		(2)
	1/2 diameter x 1-1/4 long dowel pin		(2)
-42	HYDRO-LINE CYLINDER, R-2F, rod end style	1-930-05668	1
	1X 1-3/8 diameter rod, 6" bore, 3" stroke		
-43	SPACER, Adjust shaft mounting	1-HJM-10400	2
-44	JAM NUT, 1-1/4"-12		1
-45	COTTER PIN, 1/8 x 1-1/2" long		2
-46	PIN, Clevis	1-HJM-00525	1
-47	CLEVIS, Hydraulic lat. adjust	1-HJM-00527	1
-48	COVER, Lower main drive frame	2-HJM-50137	1
	1/2-13 x 1-1/4 long hex. head cap screw		(9)
	1/2 L' washer		(9)
-49	HOUSING, Lat. adjust	3-HJM-50432	1
-50	HOUSING, Adjust, swivel plate	3-HJM-00055	1
	1/2-13 x 3-1/2 long hex. head cap screw		(4)
	1/2 L' washer		(4)
-51	HOUSING, Adjust, swivel plate	3-HJM-00055	1
-52	LOCK NUT, MRC (AN-20)	1012-010200	1
-53	LOCK WASHER, MRC (W20)	1012-020200	1
-54	BEARING, MRC (120-KSFF)	1000-120230	1
-55	RETAINER, Lateral adjust bearing	1-HJM-00079	1

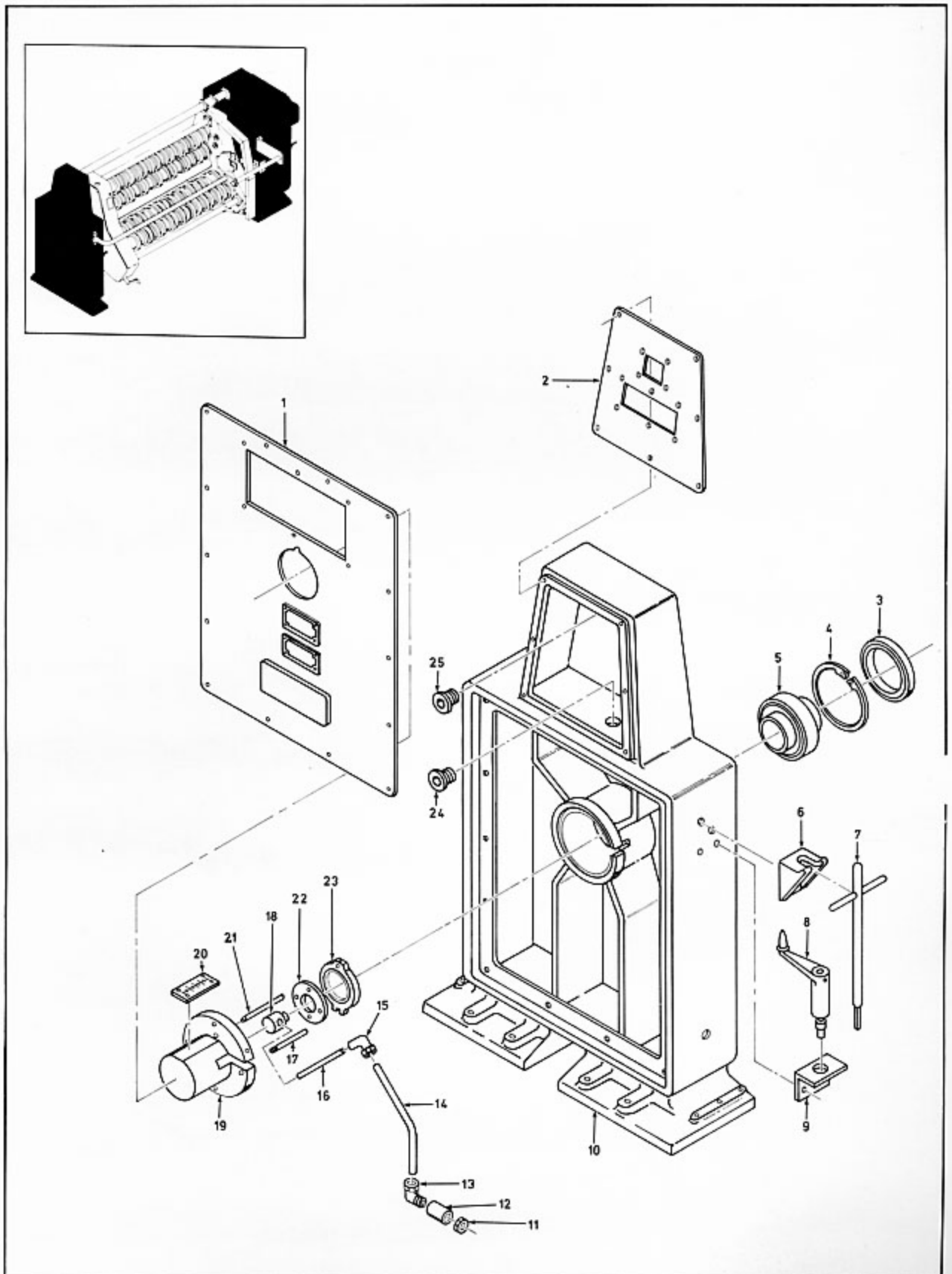


Figure 6-2. Main Assembly, with Gang Locking (Sheet 1 of 3)

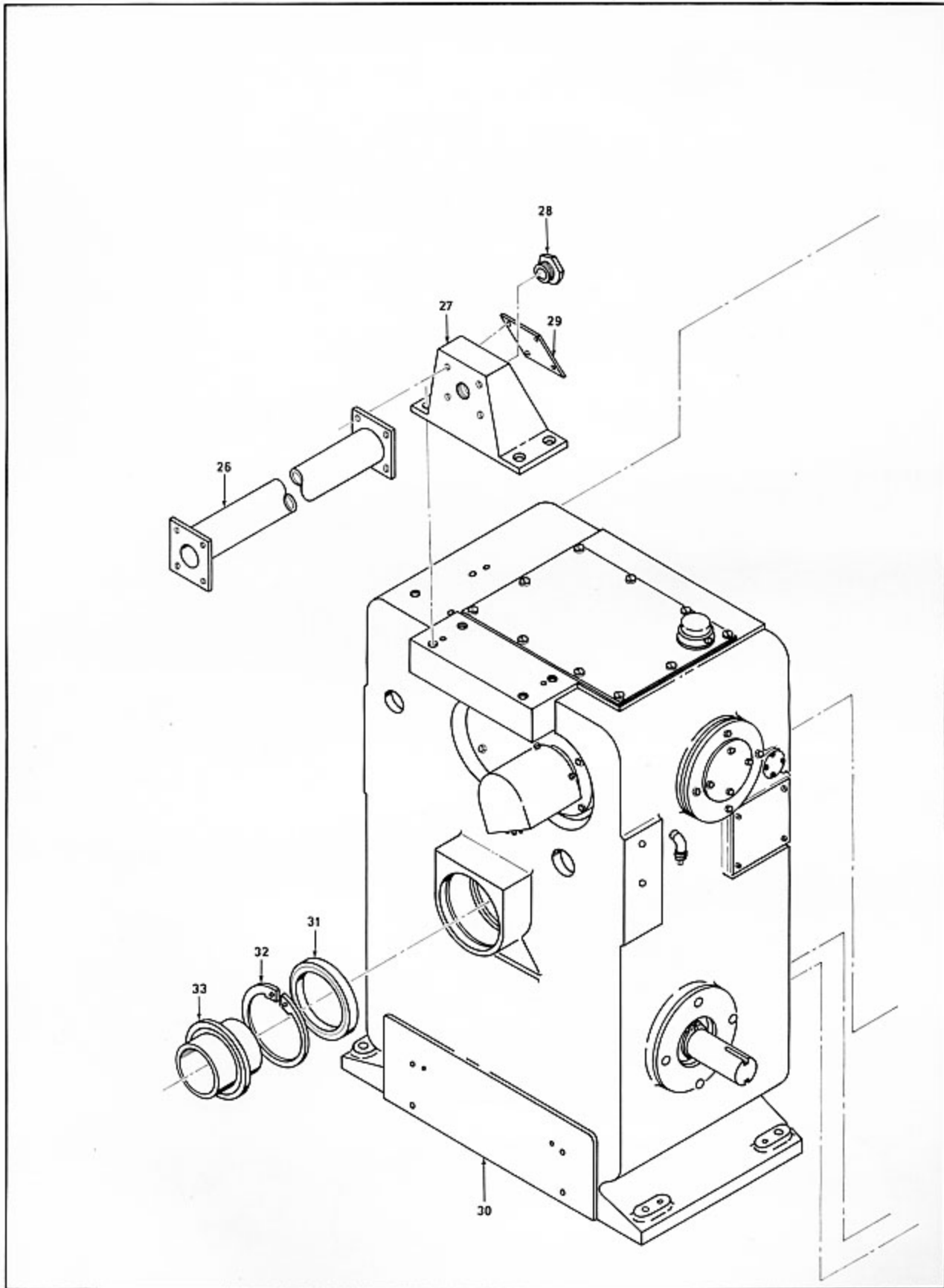


Figure 6-2. Main Assembly, with Gang Locking (Sheet 2 of 3)



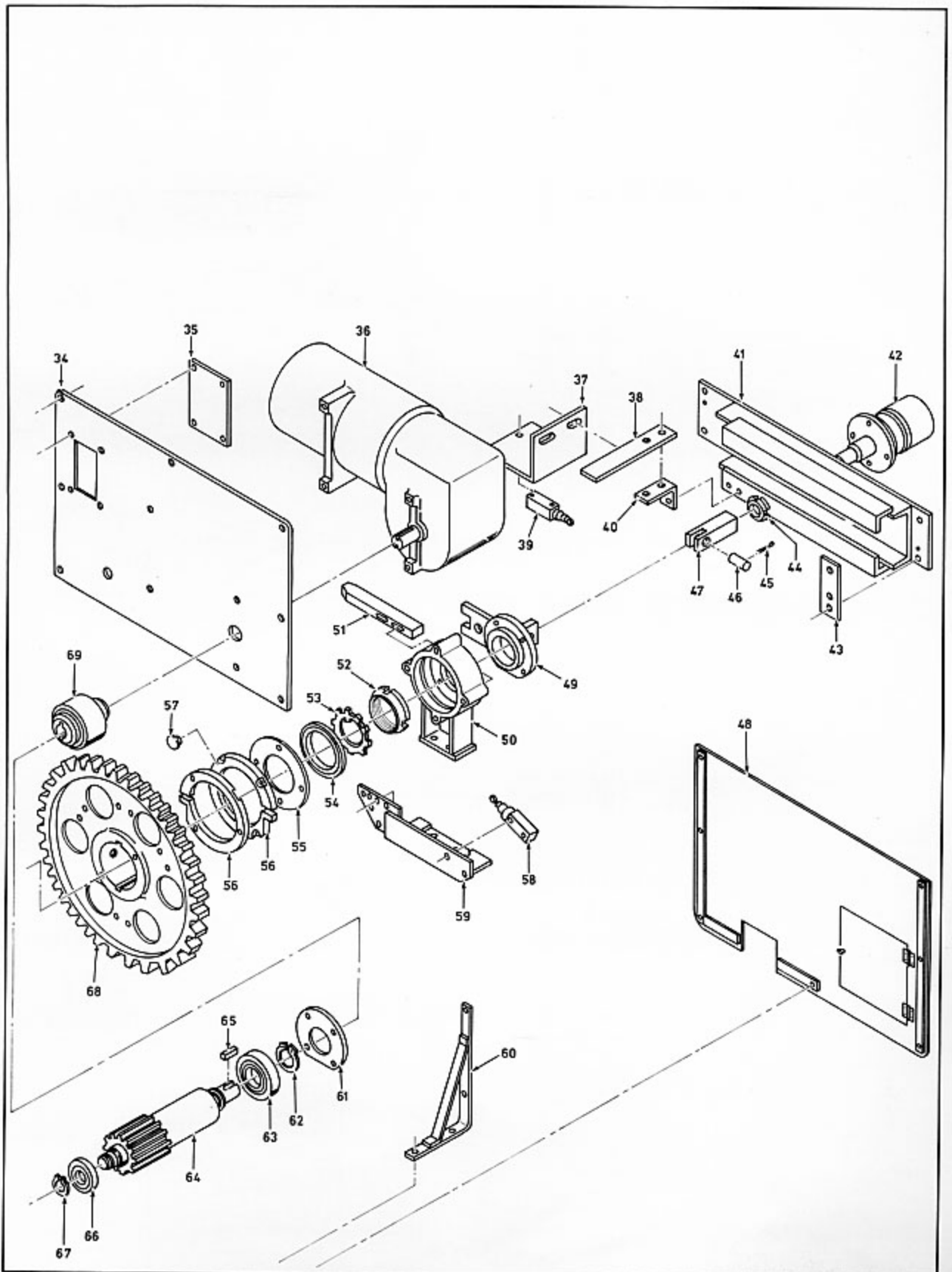


Figure 6-2. Main Assembly, with Gang Locking (Sheet 3 of 3)

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-2	MAIN ASSEMBLY, With gang locking (CONT)		
-56	CAM, Limit switch actuator 3/8-16 x 2 long socket head cap screw	2-HJM-00091	2 (2)
-57	ROLLER CAM	1-HJM-00089	1
-58	LIMIT SWITCH, Allen Bradley	(802T-D)	2
-59	BRACKET, Limit switch support 1/2-13 x 1 long hex. head cap screw 1/2 L' washers #10-32 x 1-7/8 long round head machine screw #10 L' washers ALLEN-BRADLEY LIMIT SWITCHES, Type 802TD	2-HJM-50090	1 (2) (2) (4) (4) (2)
-60	BRACKET, Pull box mounting 1/2-13 x 7/8 long socket set screw	2-HJM-50175	2 (2)
-61	RETAINER, Indexing pinion bearing 3/8-16 x 1-1/4 long hex. head cap screw 3/8 L' washers	1-HJM-00078	1 (4) (4)
-62	TRUARC RING	(5100-255)	1
-63	BEARING, MRC (213-SFF)	1000-213230	1
-64	PINION, Indexing	2-HJM-00061	1
-65	KEY	1-946-50237	2
-66	BEARING, MRC (209-SZZ)	1000-209280	1
-67	TRUARC RING	(5100-177)	1
-68	GEAR, Index 5/8-11 x 7/8 long socket set screw	3-HJM-00025	1 (3)
-69	SIER-BATH COUPLING 5/8-16 x 1/2 long 1/2-13 x 1/2 long socket set screw	2-936-50001-2	1 (3) (3)

Item No.	Description	Part Number	Qty Per Assy
6-3	MAIN ASSEMBLY, MANUAL LOCKING		
-1	COVER, Main frame, operating side, with "LT" except JST 3-HJM-00345 shown COVER, Main frame, operating side, without "LT" COVER, Main frame, operating side, with "LT" to JST only 3-HJM-00362 3/8-16 x 3/4 long button head socket cap screw	3-HJM-00199	1     (14)
-2	SEE FIGURE 6-4 FOR DETAIL BREAKDOWN		
-3	OIL SEAL, C/R	(800616)	1
-4	TRUARC RING	(5000-800)	1
-5	BEARING, Roller	2-930-00010	1
-6	BRACKET, For wrench 1/4-20 x 3/4 long hex. head cap screw	1-CXF-368	1 (2)
-7	T-WRENCH	1-942-00994-0-0	1
-8	WRENCH	2-HJM-50209	1
-9	BRACKET, Wrench	1-HJM-00390	1

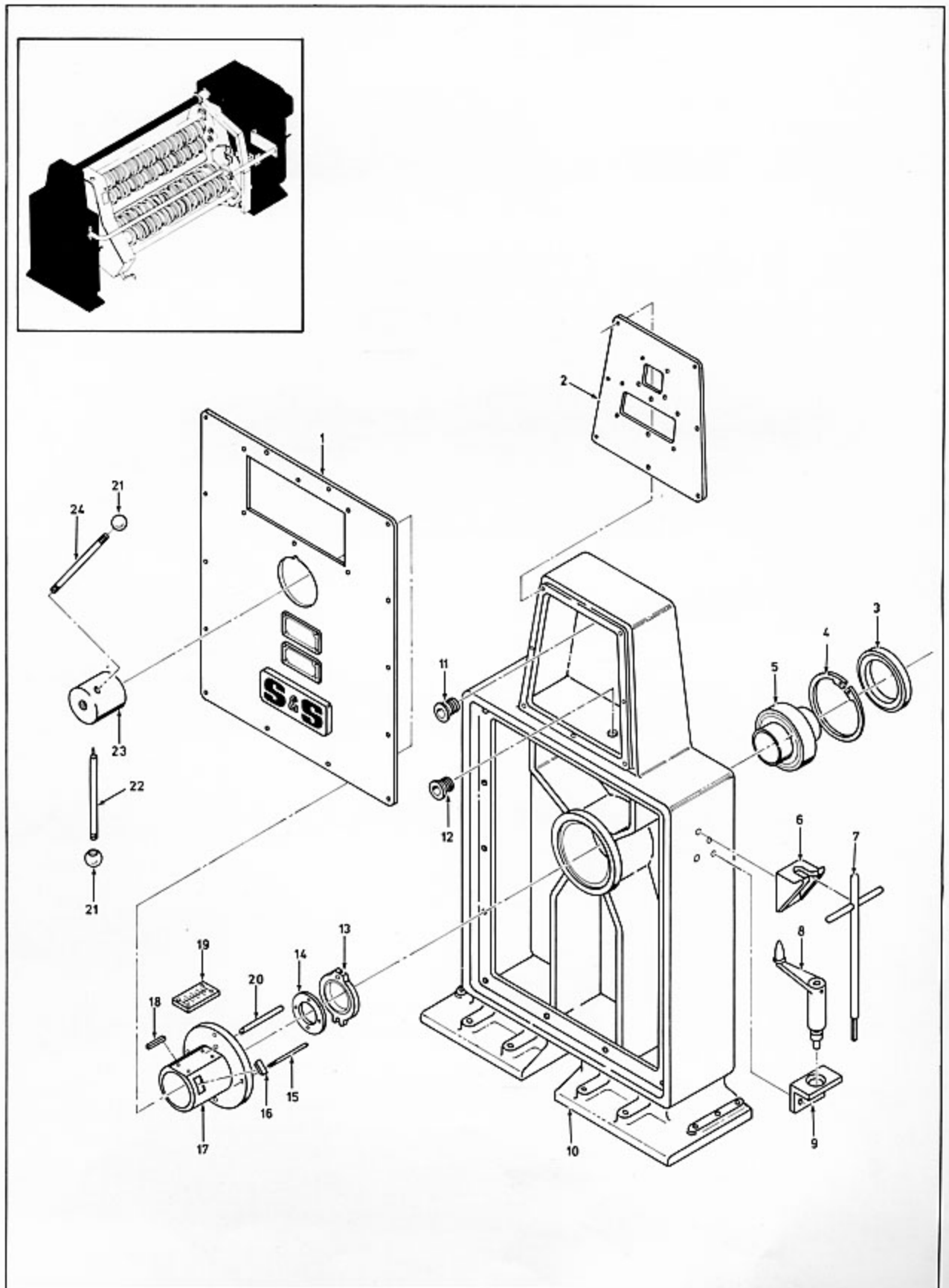


Figure 6-3. Main Assembly, Manual Locking (Sheet 1 of 3)

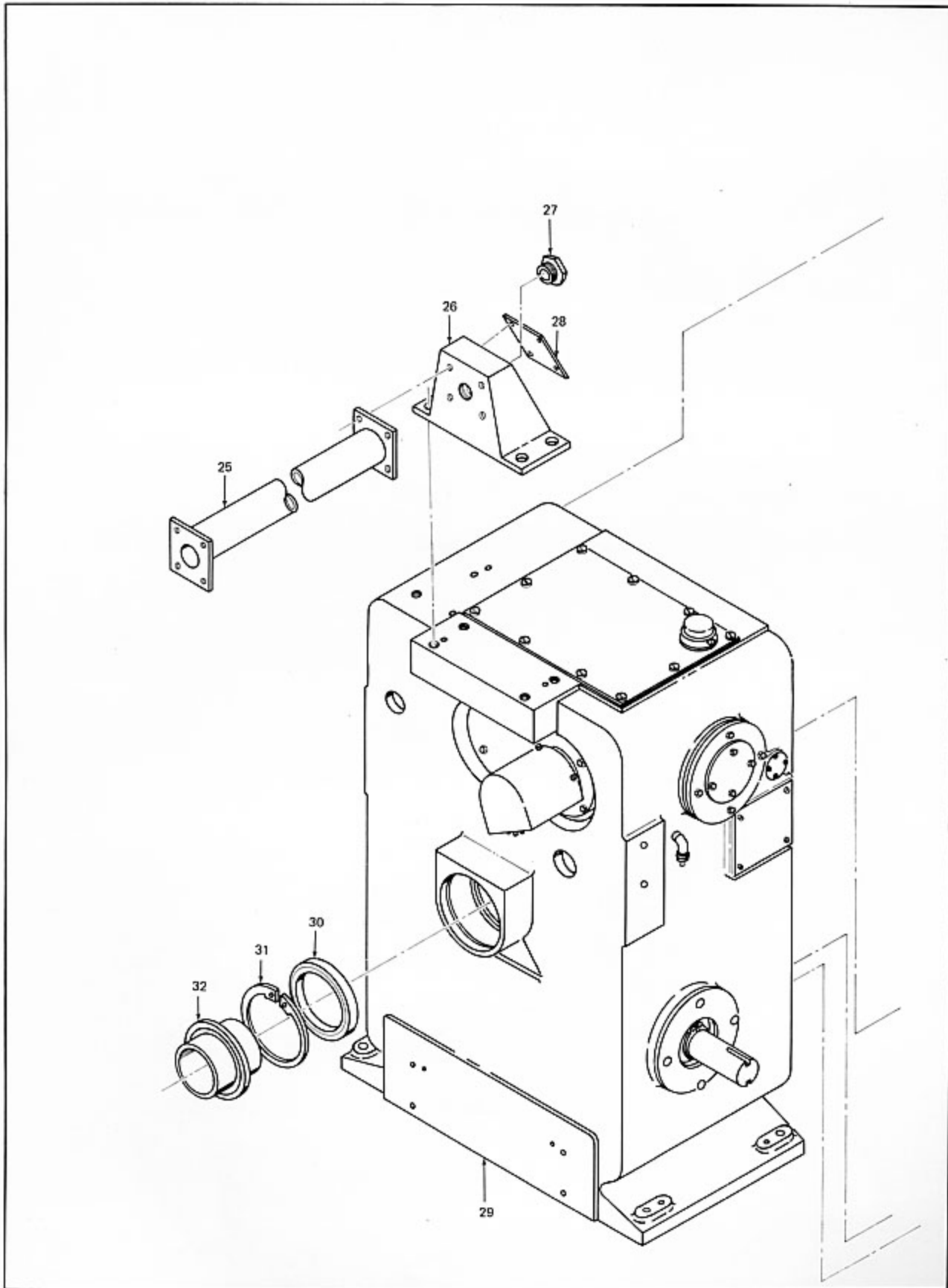


Figure 6-3. Main Assembly, Manual Locking (Sheet 2 of 3)

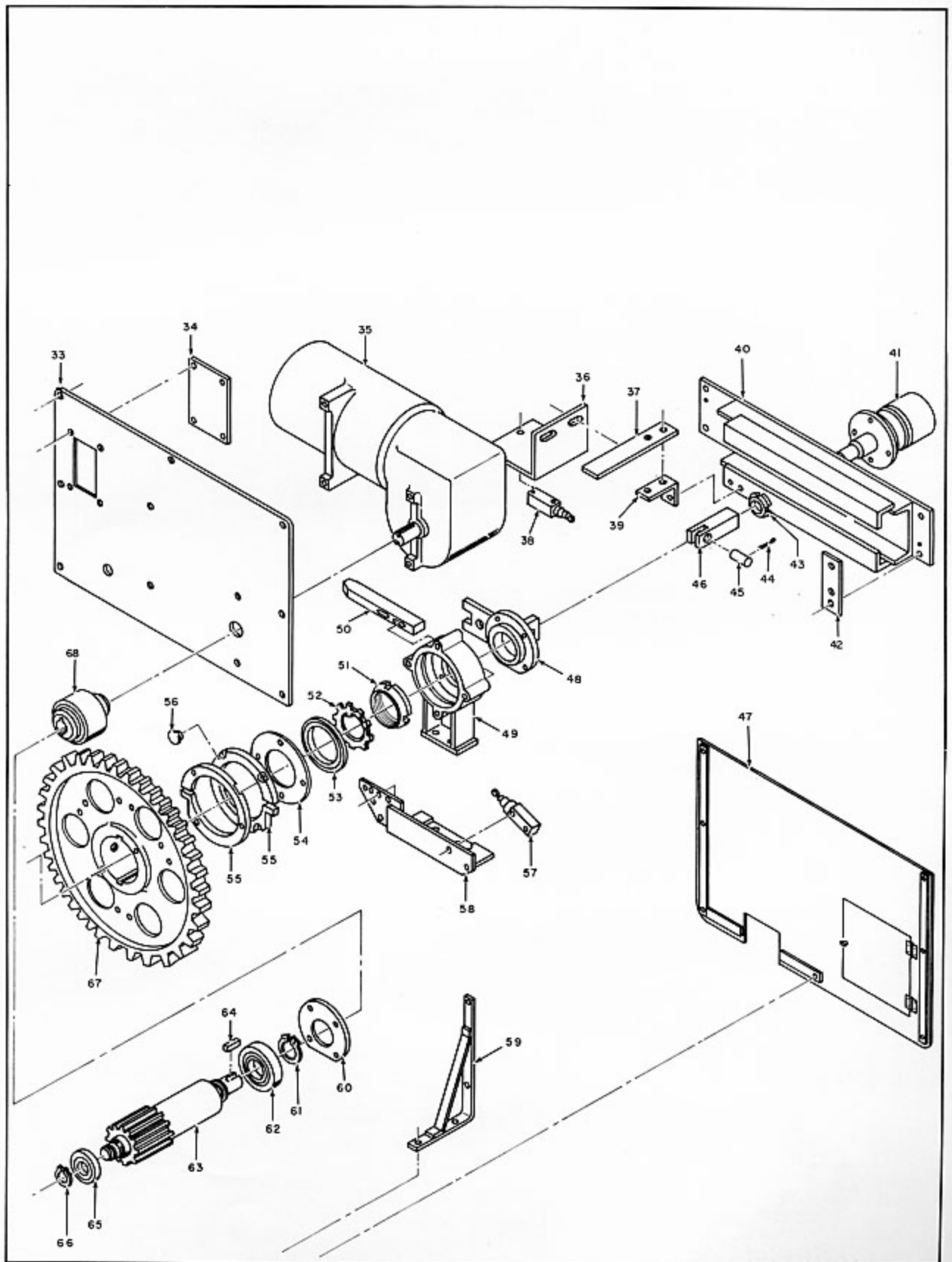


Figure 6-3. Main Assembly, Manual Locking (Sheet 3 of 3)

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item Item No.	Description	Part Number	Qty Per Assy
6-3	MAIN ASSEMBLY, MANUAL LOCKING (CONT)		
-10	FRAME, Operating side ALEMITE FITTING #1610 5/8-11 x 4" long square head set screw 5/8-11 hex. nut T&B 1-1/4 insulated chase nipple #1945 T&B 1/2 insulated chase nipple #1942	5-HJM-00004	1 (1) (4) (4) (1) (1)
-11	NIPPLE, Insulated chase, T&B, 1-1/4 inch	(1945)	2
-12	NIPPLE, Insulated chase, T&B, 1/2 inch	(1942)	2
-13	RING, Indicator 1/4-20 x 3/8 long socket head cap screw	2-HJM-00107	1 (1)
-14	RETAINER, Indicator ring 1/4-20 x 5/8 long socket head cap screw 1/4 L' washer	1-HJM-00106	1 (4) (4)
-15	ROD, Guide, indicator ring	1-HJM-00105	1
-16	NAMEPLATE	1-943-00201	1
-17	SUPPORT, Hand wheel 1/2-13 x 1-1/4 long hex. head cap 1/2 L' washer	2-HJM-00040	1 (4) (4)
-18	NAMEPLATE	1-943-00202	1
-19	SCALE	1-HJM-00015	1
-20	INDICATOR, Lateral adjust	1-HJM-00043	1
-21	KNOB, Dimco gray	(111)	3
-22	SPOKE, Hand wheel	1-HJM-00092	1
-23	HUB, Hand wheel	1-HJM-00042	1
-24	SPOKE, Hand wheel	1-HJM-00041	2
-25	BRACE, Upper	1-HJM-00196	1
-26	BRACKET, Upper brace	3-HJM-00194	1
-27	NIPPLE, Insulated chase, 1-1/4 (T&B)	(1945)	1
-28	COVER, Conduit	1-HJM-00327	1
-29	FRAME, Drive Side	5-HJM-00001	1
-30	OILSEAL, C/R	(800616)	1
-31	TRUARC RING	(5000-800)	1
-32	ROLLER BEARING	2-930-00010	1
-33	BASE MOTOR 1/2-13 x 1-1/4 long hex. head cap screw 1/2-13 x 1-3/4 long hex. head cap screw 1/2 L' washers 1/2 Plain washers	2-HJM-00067	1 (7) (4) (11) (4)
-34	COVER, Inspection, Warner clutch 1/4-20 x 1/2 long hex. head cap screw 1/4 L' washer	1-HJM-00322	1 (4) (4)
-35	MOTOR, Master gear, 1-1/2 H.P. (145-CG-21-F)	1-932-00057	1
-36	SUPPORT, Limit switch	2-HJM-00501	1
-37	GUIDE, Hyp. lat. adjust	1-HJM-00528	1
-38	ALLEN BRADLEY LIMIT SWITCH	820T-D	2
-39	ANGLE, Support guide	1-HJM-00529	1
-40	MOUNTING, Hydraulic cylinder lateral adjust 1/2-13 x 1-1/4 long hex. head cap screw 1/2 L' washer 3/8-16 x 3/4 long hex. head cap screw 3/8 L' washer 1/2 diameter x 1-1/4 long dowel pin	3-HJM-50431	1 (4) (4) (2) (2) (2)
-41	HYDRO-LINE CYLINDER, R-2F, rod end style 1X 1-3/8 diameter rod, 6" bore, 3" stroke	1-930-05668	1
-42	SPACER, Adjust shaft mounting	1-HJM-10400	2
-43	JAM NUT, 1-1/4"-12		1
-44	COTTER PIN, 1/8 x 1-1/2" long		2
-45	PIN, Clevis	1-HJM-00525	1

Item No.	Description	Part Number	Qty Per Assy
6-3	MAIN ASSEMBLY, MANUAL LOCKING (CONT)		
-46	CLEVIS, Hydraulic lat. adjust	1-HJM-00527	1
-47	COVER, Lower main drive frame	2-HJM-50137	1
	1/2-13 x 1-1/4 long hex. head cap screw		(9)
	1/2 L' washer		(9)
-48	HOUSING, Lat. adjust	3-HJM-50432	1
-49	HOUSING, Adjust, swivel plate	3-HJM-00055	1
	1/2-13 x 3-1/2 long hex. head cap screw		(4)
	1/2 L' washer		(4)
-50	HOUSING, Adjust, swivel plate	3-HJM-00055	1
-51	LOCK NUT, MRC (AN-20)	1012-010200	1
-52	LOCK WASHER, MRC (W20)	1012-020200	1
-53	BEARING, MRC (120-KSFF)	1000-120230	1
-54	RETAINER, Lateral adjust bearing	1-HJM-00079	1
-55	CAM, Limit switch actuator	2-HJM-00091	2
	3/8-16 x 2 long socket head cap screw		(2)
-56	ROLLER CAM	1-HJM-00089	1
-57	LIMIT SWITCH, Allen Bradley	(802T-D)	2
-58	BRACKET, Limit switch support	2-HJM-50090	1
	1/2-13 x 1 long hex. head cap screw		(2)
	1/2 L' washer		(2)
	#10-32 x 1-7/8 long round head machine screw		(4)
	#10 L' washer		(4)
	ALLEN-BRADLEY LIMIT SWITCHES, Type 802TD		(2)
-59	BRACKET, Pull box mounting	2-HJM-50175	2
	1/2-13 x 7/8 long socket set screw		(2)
-60	RETAINER, Indexing pinion bearing	1-HJM-00078	1
	3/8-16 x 1-1/4 long hex. head cap screw		(4)
	3/8 L' washers		(4)
-61	TRUARC RING	(5100-255)	1
-62	BEARING, MRC (213-SFF)	1000-213230	1
-63	PINION, Indexing	2-HJM-00061	1
-64	KEY	1-946-50237	2
-65	BEARING, MRC (209-SZZ)	1000-209280	1
-66	TRUARC RING	(5100-177)	1
-67	GEAR, Index	3-HJM-00025	1
	5/8-11 x 7/8 long socket set screw		(3)
-68	SIER-BATH COUPLING	2-936-50001-2	1
	5/8-16 x 1/2 long		(3)
	1/2-13 x 1/2 long socket set screw		(3)



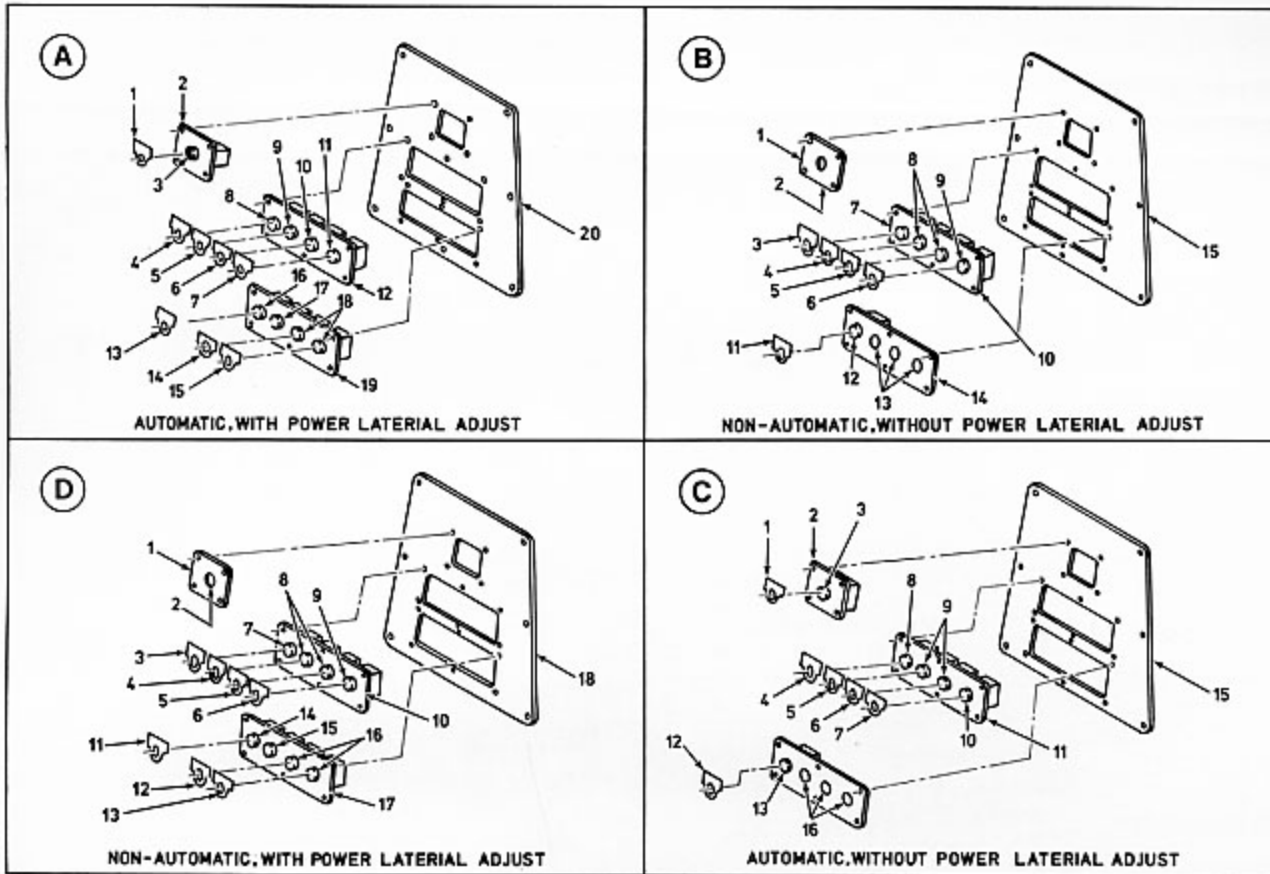


Figure 6-4. Control Station

Item No.	Description	Part Number	Qty Per Assy
6-4A	CONTROL STATION, AUTOMATIC WITH POWER LATERAL ADJUST		
-1	NAMEPLATE	1-943-00303	1
-2	PUSH BUTTON STATION	(A-B800T-12T)	1
-3	2 POSITION SELECTOR SWITCH	(A-B800T-HG2H)	1
-4	NAMEPLATE, "RUN-JOG"	(A-B800T-X41)	1
-5	NAMEPLATE	1-943-00184	1
-6	NAMEPLATE	1-943-00185	1
-7	NAMEPLATE, "STOP"	(A-B800T-X50)	1
-8	2 POSITION SELECTOR SWITCH	(A-B800T-HG2H)	1
-9	PUSHBUTTON	115V A-B800T-PB16G	1
-10	PUSHBUTTON	220V A-B800T-PB26G	1
-11	PUSHBUTTON (EXTENDED HEAD) LOCKING ATTACHMENT	115V A-B800T-PB16G	1
-12	PUSHBUTTON STATION	120V A-B 800T-PB26G	1
-13	NAMEPLATE	(A-B800T-B6B)	1
-14	NAMEPLATE	(A-B800T-N2)	1
-15	NAMEPLATE	(A-B800T-4ZT)	1
-16	SELECTOR SWITCH	1-943-01816	1
-17	CLOSING BUTTON	1-943-01818	1
-18	PUSHBUTTON	1-943-01819	1
-19	PUSHBUTTON STATION	(A-B800T-H2B)	1
-20	COVER, Upper main frame, operating side	(A-B800T-N1)	1
		(A-B800T-A7B)	2
		(A-B800T-42T)	1
		2-HJM-00550	1



Item No.	Description	Part Number	Qty Per Assy
6-4B	CONTROL STATION, NON-AUTOMATIC, WITHOUT POWER LATERAL ADJUST		
-1	PUSHBUTTON STATION	(A-B 800T-12T)	1
-2	CLOSING BUTTON	(A-B 800T-N1)	1
-3	NAMEPLATE, "RUN-JOG"	(A-B 800T-X41)	1
-4	NAMEPLATE	1-943-00184	1
-5	NAMEPLATE	1-943-00185	1
-6	NAMEPLATE, "STOP"	(A-B 800T-X50)	1
-7	2 POSITION SELECTOR SWITCH	(A-B 800T-HG2H)	1
-8	PUSHBUTTON	115V A-B 800T-PB16G 120V A-B 800T-PB26G	2
-9	PUSHBUTTON (EXTENDED HEAD) LOCKING ATTACHMENT	(A-B 800T-B6B) (A-B 800T-N2)	1 1
-10	PUSHBUTTON STATION	(A-B 800T-42T)	1
-11	NAMEPLATE	1-943-01816	1
-12	SELECTOR SWITCH	(A-B 800T-H2B)	1
-13	CLOSING BUTTON	(A-B 800T-N1)	3
-14	PUSHBUTTON STATION	(A-B 800T-42T)	1
-15	COVER, Upper main frame, operating side	2-HJM-00550	1

Item No.	Description	Part Number	Qty Per Assy
6-4C	CONTROL STATION, AUTOMATIC, WITHOUT POWER LATERAL ADJUST		
-1	NAMEPLATE	1-943-00303	1
-2	PUSHBUTTON STATION	(A-B 800T-12T)	1
-3	2 POSITION SELECTOR SWITCH	(A-B 800T-HG2H)	1
-4	NAMEPLATE, "RUN-JOG"	(A-B 800T-X41)	1
-5	NAMEPLATE	1-943-00184	1
-6	NAMEPLATE	1-943-00185	1
-7	NAMEPLATE, "STOP"	(A-B 800T-X50)	1
-8	2 POSITION SELECTOR SWITCH	(A-B 800T-HG2H)	1
-9	PUSHBUTTON	115V 800T-PB16G 220V 800T-PB26G	2
-10	PUSHBUTTON (EXTENDED HEAD) LOCKING ATTACHMENT	(A-B 800T-B6B) (A-B 800T-N2)	1 1
-11	PUSHBUTTON STATION	(A-B 800T-AZT)	1
-12	NAMEPLATE	1-943-01816	1
-13	SELECTOR SWITCH	(A-B 800T-H2B)	1
-14	PUSHBUTTON STATION	(A-B 800T-42T)	1
-15	COVER, Upper main frame, operating side	2-HJM-00550	1
-16	CLOSING BUTTON	(A-B 800T-N1)	3

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Item No.	Description	Part Number	Qty Per Assy
6-4D	CONTROL STATION, NON-AUTOMATIC, WITH POWER LATERAL ADJUST		
-1	PUSHBUTTON STATION	(A-B 800T-1ZT)	1
-2	CLOSING BUTTON	(A-B 800T-N1)	1
-3	NAMEPLATE, "RUN-JOG"	(A-B 800T-X41)	1
-4	NAMEPLATE	1-943-00184	1
-5	NAMEPLATE	1-943-00185	1
-6	NAMEPLATE, "STOP"	(A-B 800T-X50)	1
-7	2 POSITION SELECTOR SWITCH	(A-B 800T-HG2H)	1
-8	PUSHBUTTON	115V A-B 800T-PB16G 220V A-B 800T-PB26G	2
-9	PUSHBUTTON (EXTENDED HEAD) LOCKING ATTACHMENT	(A-B 800T-B6B) (A-B 800T-N2)	1 1
-10	PUSHBUTTON STATION	(A-B 800T-42T)	1
-11	NAMEPLATE	1-943-01816	1
-12	NAMEPLATE	1-943-01818	1
-13	NAMEPLATE	1-943-01819	1
-14	SELECTOR SWITCH	(A-B 800T-H2B)	1
-15	CLOSING BUTTON	(A-B 800T-N1)	1
-16	PUSHBUTTON	(A-B 800T-A7B)	2
-17	PUSHBUTTON STATION	(A-B 800T-4ZT)	1
-18	COVER, Upper main frame, operating side	2-HJM-00550	1

Item No.	Description	Part Number	Qty Per Assy
6-5	POSITIVE LOCKING DEVICE ASSEMBLY		
-1	BLOCK, Locking device	3-767-00146	1
	1/2-13 x 3-1/2 long hex. head cap screw		(6)
	1/2 L' washer		(6)
-2	FITTING, Alemite (1610-B)		1
-3	COLLAR, Block	2-767-00145	2
	1/2-13 x 2 long hex. head cap screw		(2)
	1/2 L' washer		(2)
-4	PAPER SUPPORT	3-767-50195	1
-5	ANGLE, Support-switch, right-hand drive	2-767-00147	1
	5/16-18 x 1" long hex. head cap screw		(2)
	#10-24 x 1/2 long pan head machine screw		(2)
	5/16-18 hex. nut		(2)
	5/16 plain washer		(2)
	5/16 L' washer		(2)
	#10 L' washer		(2)
-6	SWITCH, Square "D" limit with lever arm CA-1	(9007-B62B2)	1
-7	BRACKET, Switch actuator	1-767-00141	1
	5/16-18 x 1 long hex. head cap screw		(2)
	5/16 L' washer		(2)
-8	SPACER, Bracket	1-767-00140	1

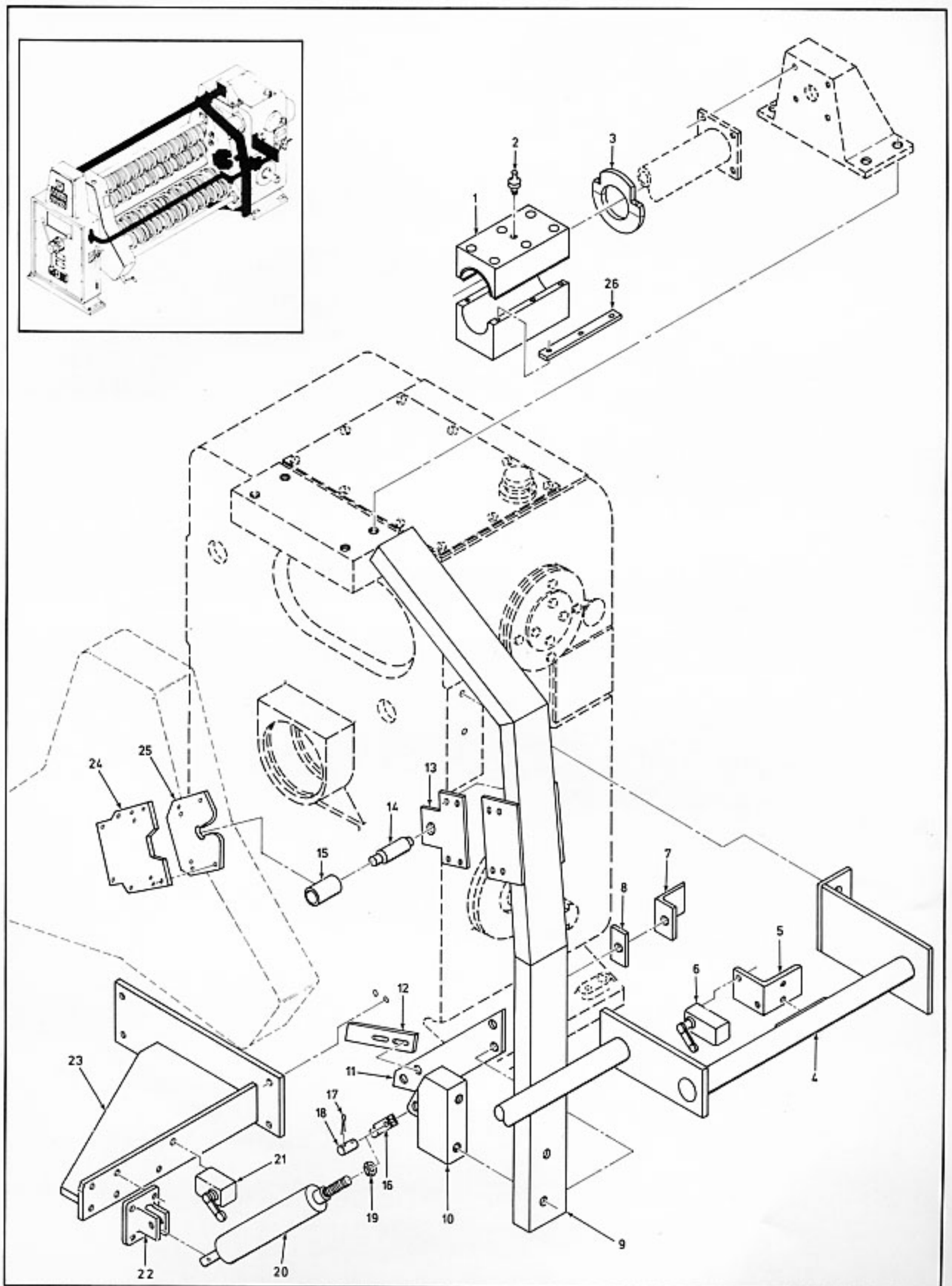


Figure 6-5. Positive Locking Device Assembly

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-5	POSITIVE LOCKING DEVICE ASSEMBLY (CONT)		
-9	ARM, Pivoting	5-767-50196	1
	1/2-13 x 1-1/4 long hex. head cap screw		(8)
	1/2-13 x 1/2 long hex. head cap screw		(4)
	5/8-11 x 1-1/2 long hex. head cap screw		(2)
	3/8 diameter dowel pin x 1" long		(4)
	1/2 L' washer		(12)
	5/8 L' washer		(2)
-10	BRACKET, Cylinder mounting	2-767-00148	1
-11	BRACKET, Switch actuator	2-767-00158	1
	1/2-13 x 3/4 long hex. head cap screw		(2)
	1/2 L' washer		(2)
	1/4 diameter roll pin x 1/2 long		(2)
-12	SWITCH, Actuator	1-767-00157	1
	3/8-16 x 1-1/2 long hex. head cap screw		(2)
	3/8 L' washer		(2)
	3/8 plain washer		(2)
-13	BRACKET, Roller, lock device	2-767-00142	2
	5/16-8 x 1/2 long socket set screw		(1)
-14	SHAFT, Roller	2-767-00144	1
-15	ROLLER-LOCKING ARM	1-HJM-50443	1
-16	TOP CLEVIS (ALLEN AIR)	(345)	1
-17	COTTER PIN, 1/8"		2
-18	PIN	1-767-00149	1
-19	NUT (ALLEN AIR)	(345)	1
-20	AIR CYLINDER, Allenair, 3" diameter bore x 8" stroke (A - 3x8-BC) both ends cushioned		1
-21	LIMIT SWITCH, Square "D", with lever arm MA-1	(9007-B52B2)	1
-22	BRACKET, Allenair swivel	(339)	1
-23	BRACKET, Cylinder support, right-hand drive	3-767-50197	1
	Allenair swivel bracket #339		(1)
	3/8-16 x 1" long hex. head cap screw		(4)
	3/4-10 x 1-3/4 long hex. head cap screw		(4)
	3/8 lock washers		(4)
	3/4 L' washer		(4)
-23	BRACKET, Cylinder support, left-hand drive	3-767-50194	1
	Allenair swivel bracket #339		(1)
	3/8-16 x 1" long hex. head cap screw		(4)
	3/4-10 x 1-3/4 long hex. head cap screw		(4)
	3/8 lock washer		(4)
	3/4 L' washer		(4)
-24	SUPPORT, Block, roller lock	3-HJM-00479	3
	1/2-13 x 1-1/2 long hex. head cap screw		(4)
	1/2-13 x 1-3/4 long hex. head cap screw		(4)
	1/2 L' washer		(8)
-24	SUPPORT, Block, roller lock, 8-bar, 12-bar machine	2-767-00143	3
	1/2-13 x 1-1/2 long hex. head cap screw		(6)
	1/2-13 x 1-1/4 long hex head cap screw		(3)
	1/2 L' washer		(9)
	1/2-13 jam nut		(6)
	Bunting bush #C372 (1" I.D. x 1-1/8 O.D. x 1-3/8 long)		(1)
-25	BLOCK, Roller locking	2-767-00206	3
-26	SHIMS	1-767-00151	2
-26	SHIMS	1-767-00152	4

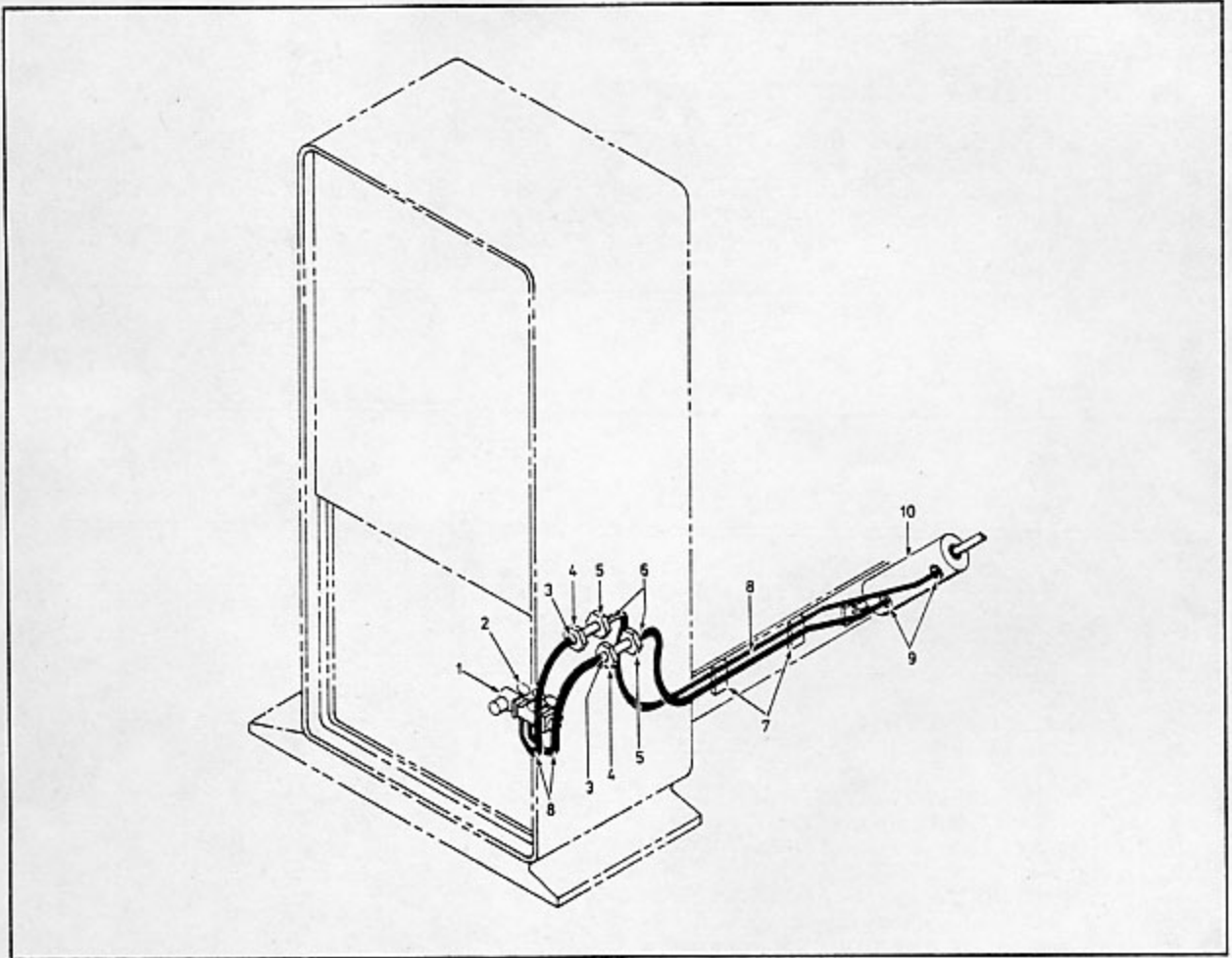


Figure 6-6. Piping Layout for Index Lock (R. H. Drive)

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-6	PIPING LAYOUT FOR INDEX LOCK (R.H. DRIVE)		
-1	AVALCO SOLENOID VALVE (409-B-33-2EA-1C)		1
-2	AVALCO EXHAUST PORT CONTROL (2666-3)		2
-3	3/8" TUBE TO 1/8" PIPE, Synflex fitting #4400-1162 or equivalent		2
-4	NUT	1-942-01251	2
-5	HEX NUT, 5/8-11		2
-6	3/8" TUBE TO 1/8" PIPE, Synflex fitting #4400-1362 or equivalent		2
-7	IMPERIAL-EASTMAN POLY TUBE, Rack #16-P (10 grooves) 1 makes 2)		1
-8	SYNFLEX P-1 POLYETHYLENE TUBING #4201-6622, Red (3/8" O.D. x 0.062 wall)		8 ft.
-9	3/8" TUBE TO 3/8" PIPE SYNFLEX FITTING #4400-1366 or equivalent		4
-10	ALLEN AIR CYLINDER, 3" bore, 8" stroke, double action, single ended (A-3 8-BC) both ends cushioned		1
-	SWIVEL BRACKET, #339 rod clevis #345 and nuts		

Item No.	Description	Part Number	Qty Per Assy
6-7	PIPING LAYOUT FOR INDEX LOCK (L.H. DRIVE)		
-1	AVALCO SOLENOID VALVE, #409-B-33-2EA-1C		1
-2	AVALCO EXHAUST PORT CONTROL #2666-3		2
-3	3/8" TUBE TO 1/8" PIPE SYNFLEX FITTING, #4400-1162 or equivalent		2
-4	NUT	1-942-01251	2
-5	HEX NUT, 5/8"-11		2
-6	3/8" TUBE TO 1/8" SYNFLEX FITTING, #4400-1362 or equivalent		2
-7	3/8" TUBE TO 3/8" PIPE SYNFLEX FITTING, #4400-1366 or equivalent		4
-8	SYNFLEX P-1 POLYETHYLENE TUBING, #4201-6622, red (3/8" O.D. x 0.062 wall)		14 ft.
-9	IMPERIAL-EASTMAN POLY TUBE RACK, #16-P (10 grooves) (1 makes 2)		2
-10	ALLEN AIR CYLINDER, 3" bore, 8" stroke, double action, single ended (A-3 8-BC) both ends cushioned		1
	SWIVEL BRACKET #339 ROD CLEVIS #345 and nuts		



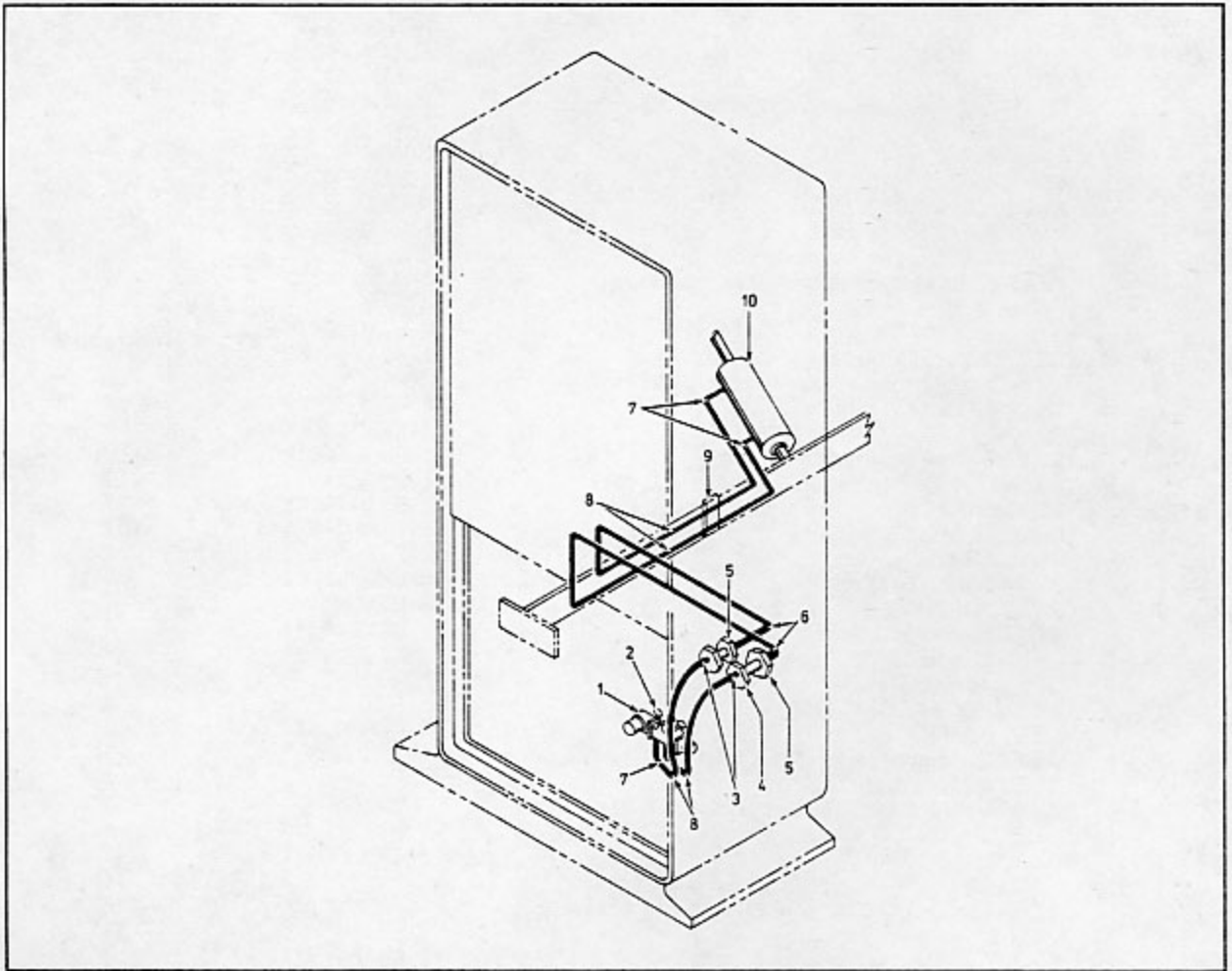


Figure 6-7. Piping Layout for Index Lock (L.H. Drive)

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-8	SWIVEL ASSEMBLY, 6-BAR WITHOUT GANG LOCKING		
-1	BRACKET, Worm	3-HJM-00257	3
-2	WORM, Adjust	1-HJM-00023	3
-3	WORM ADJ. STUD	1-HJM-00261	3
-4	STEEL COLLAR	3-942-00124-3-0	3
-5	WORM GEAR 3/8-16 x 1/4 long socket set screw	1-HJM-00022	3 (2)
-6	PINION	1-HJM-00276	3
-7	HANDLE	2-HJM-50209	1
-8	KEY, Standard key	1-946-40343	3
-9	UPPER SHAFT, Pinion	2-HJM-00275	3
-10	TIE BRACE	1-HJM-50262	3
-11	SHAFT, Upper creaser and slitter with chrome plate 6" Standard 6"	2-HJM-00282 2-HJM-00018	3 3
-12	SEGMENT, Retainer	1-HJM-00260	3
-13	ADJUSTING BOLT (Vlier)	(S-58)	3
-14	PIN, Worm adjustment	1-HJM-00149	3
-15	FITTING, Grease (Alemite) (1610)		3
-16	SHAFT, Lower creaser slitter with chrome plate 6" Standard 6"	2-HJM-00282 2-HJM-00018	3 3
-17	KEY, Lateral adjustment shaft #8-32 x 1/2 long socket head cap screw	1-HJM-00039	1 (2)
-18	SHAFT, Lateral adjustment	2-HJM-00038	1
-19	SHAFT, Swivel	3-HJM-00027	1
-20	KEY, Swivel shaft 3/8-16 x 1-1/4 long socket head cap screw	1-HJM-00029	2 (2)
-21	BEARING, Center lateral adjustment shaft	1-HJM-00081	1
-22	DOWEL, Pin, 3/8 dia. x 7/8 long		1
-23	COLLAR	1-HJM-00087	1
-24	RETAINER, Truarc	(5100-200)	1
-25	SWIVEL FRAME (Operating drive)	5-HJM-00003	1
-26	COVER, Swivel frame #10-32 x 3/8 long, type F, self-tapping round head screw	2-HJM-00259	3 (8)
-27	ALEMITE FITTING (1613-B)		3
-28	LUB, Screw	1-942-01261	3
-29	UNION, Compression (701), 1/8 MPT to 1/4 tubing		3
-30	TUBING, 1/4 inch		3
-31	ELBOW, 90°, Conklin compression (801) 1/8 MPT to 1/4 tubing		3
-32	BEARING BOX 1/2-13 x 1-1/4 long hex. head cap screw 1/2-13 x 3-1/2 long socket head cap screw 1/2 L' washer	3-CXF-00111	3 (4) (3) (4)
-33	WASHER, Bearing retainer 5/8-11 x 1-1/4 long socket head screw 3/16 diameter x 5/8 long crs pin	1-CEB-00078	3 (1) (1)
-34	BEARING, Timken roller, two-row, double cup, single cone	2-930-01045-20	3
-35	RETAINER, Bearing	2-CEB-00079	3
-36	ALEMITE FITTING (1613-B)		3
-37	LUB, Screw	1-942-01261	3
-38	UNION, Compression (701), 1/8 MPT to 1/4 tube		3
-39	FLEXIBLE TUBING with 1/4 copper tubing		3
-40	ELBOW, 90°, Conklin compression (801), 1/8 MPT to 1/4 tubing		3



Item No.	Description	Part Number	Qty Per Assy
6-8	SWIVEL ASSEMBLY, 6-BAR WITHOUT GANG LOCKING, (CONT)		
-41	COVER, Upper bearing box 1/2-13 x 1-1/4 long socket head cap screw	2-CEB-00069	1 (3)
-42	WASHER, Bearing retainer 5/8-11 x 1-1/4 long socket head screw 3/16 diameter x 5/8 long crs. pin	1-CEB-00078	1 (1) (1)
-43	BEARING, Timken roller, two row, double cup, single cone	2-930-01-045-2-0	3
-44	BEARING BOX 1/2-13 x 3-1/2 long socket head cap screw 1/2 L' washer	3-HJM-00264	1 (2) (2)
-45	SEGMENT, Bearing box, creaser and slitter shaft	1-HJM-00260	3
-46	COVER, Swivel frame #10-32 x 3/8 long, Type F, self-tapping round head screw	2-HJM-00258	3 (6)
-47	COVER, Small lube access #8-32 x 1/4 long flat head socket flat head socket cap screw	1-HJM-00193	3 (4)
-48	PINION, Upper shaft, drive side Taper pin #7 x 2-3/4 long 3/8-16 x 5/8 long socket set screw	1-HJM-00277	3 (1) (1)
-49	BEARING BOX, Upper creaser and slitter shaft 1/2-13 x 3-1/2 long socket head cap screw 1/2 L' washer	3-HJM-00263	3 (2) (2)
-50	BEARING, New departure, double row, ball bearing, double shield (55513)	1002-421320	3
-51	SPACER, Creaser and slitter gear	1-HJM-00082	3
-52	GEAR, Creaser and slitter (5P-36T)	1-HJM-00006	3
-53	KEY, Creaser and slitter 5/16-18 x 3/4 long socket head cap screw	1-HJM-00083	3 (12)
-54	PINNED WASHER 5/8 L' washer 5/8-11 x 1-1/2 long hex. head cap screw	2-942-00428-1-0	3 (12) (12)
-55	WASHER 3/8 L'washer 3/8-16 x 1" long hex. head cap screw	2-942-00410-1-0	3 (12) (12)
-56	BEARING, MRC single row ball bearing, snap ring, double shield (206SFFG)	1000-206260	3
-57	GEAR, Idler (5P-22T)	1-HJM-00007	3
-58	SPACER, Idler gear	1-HJM-00012	3
-59	BEARING, MRC single row ball bearing, snap ring, double shield (206SFFG)	1000-206260	3
-60	STUD, Idler gear 5/8-11 x 1-1/4 long hex. head cap screw 5/8 L'washer	1-HJM-00010	3 (1) (1)
-61	WASHER	1-902-00-428	3
-62	KEY, Creaser and slitter	1-HJM-00083	3
-63	GEAR, Creaser and slitter (5P-36T)	1-HJM-00006	3
-64	SPACER, Creaser and slitter gear	1-HJM-00082	3
-65	BEARING, New departure, double row, ball bearing, double shield (55513)	1002-421320	3
-66	TRUARC EXTERNAL SNAP RING (5100-196)	1237-197000	3
-67	BEARING, MRC single row ball bearing, double shield (210-SFF)	1000-210230	3
-68	GEAR, Compound, swivel frame	2-HJM-00008	3
-69	BEARING, MRC single row ball bearing, double shield (211-SFF)	1000-211230	3

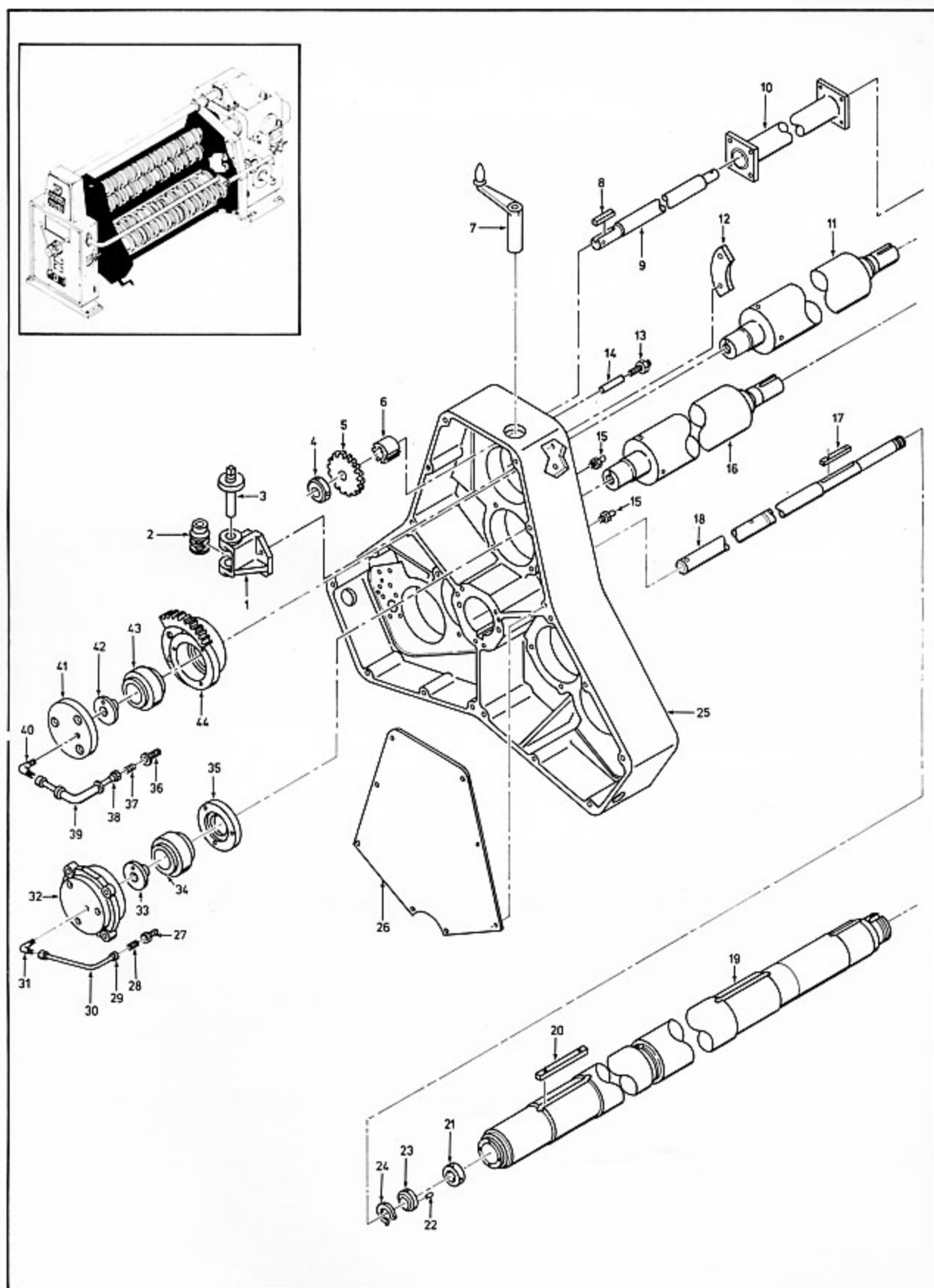


Figure 6-8. Swivel Assembly, 6-Bar Without Gang Locking, Operating Side (Sheet 1 of 2)

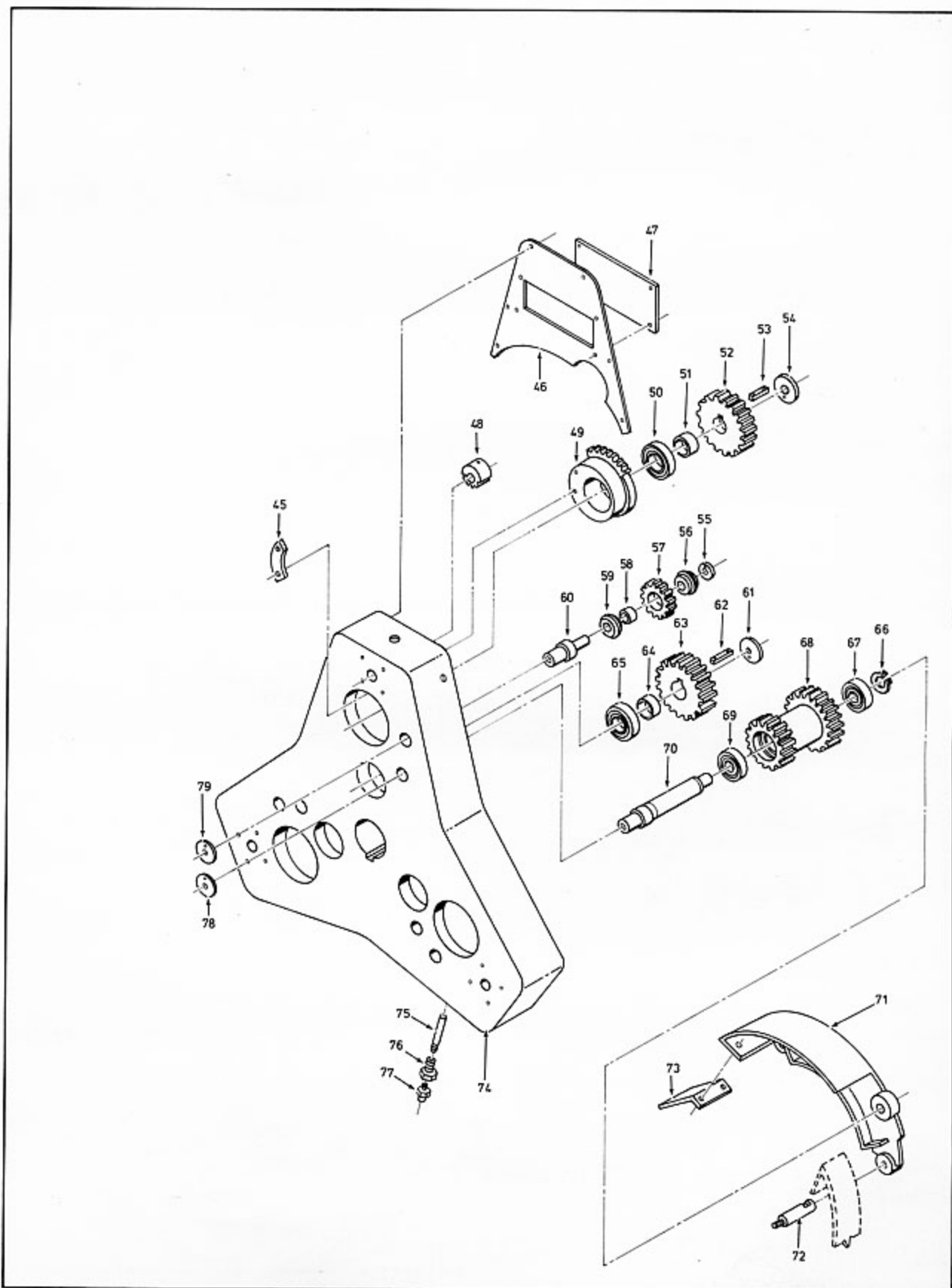


Figure 6-8. Swivel Assembly, 6-Bar Without Gang Locking, Drive Side (Sheet 2 of 2)

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-8	SWIVEL ASSEMBLY, 6-BAR WITHOUT GANG LOCKING, (CONT)		
-70	STUD, Compound gear	2-HJM-00009	3
-71	GUARD, Drive side	4-HJM-00005	3
-72	POST, Guard	1-HJM-00011	3
-73	GUARD, Compound gear	1-HJM-00131	3
-74	FRAME	3-HJM-00548	1
-75	TUBING	1-HJLD-00068	3
-76	LUBRICATING SCREW	1-942-00942-1	3
-77	FITTING, Grease (Alemite)	(1610)	3
-78	PINNED WASHER	2-942-00428-1-0	3
-79	PINNED WASHER	2-942-00428-1-0	3

Item No.	Description	Part Number	Qty Per Assy
6-9	SWIVEL FRAME, 6-BAR WITH GANG LOCKING		
-1	ROTO COUPLING, Wichita, 1/4		3
-2	COVER, Upper and lower bearing box	2-767-00217	3
	1/2-13 x 4 long socket head cap screw		(3)
	1/2 B&H hi-collar L'washer		(3)
	1/2-13 x 1-1/2 long socket head cap screw		(3)
-3	MRC LOCKNUT (N-14)	1012-010140	3
-4	MRC LOCKWASHER (W-14)	1012-020140	3
-5	ROLLER BEARING, Timken, two row, double cup, single cone	2-930-01045-2	3
-6	BEARING, Spacer	1-HJM-00467	3
-7	BEARING BOX, Upper creaser and slotter shaft	3-HJM-00264	3
	1/2-13 x 3-1/2 long socket head cap screw		(2)
	1/2 L'washer		(2)
-8	WORM, Adjustment	1-HJM-00023	3
	#2 taper pin x 1-1/4" long		(1)
	#10-32 x 3/16 long socket set screw		(1)
-9	WORM ADJUSTMENT STUD	1-HJM-00261	3
-10	BRACKET, Worm	3-HJM-00257	3
-11	COLLAR	3-942-00124-3	3
-12	WORM GEAR, Adjustment	1-HJM-00022	3
	3/8-16 x 1/4 long socket set screw		(2)
-13	PINION, Upper shaft	1-HJM-00276	3
-14	HANDLE	2-HJM-50209	1
-15	KEY	1-946-40343	3
-16	UPPER SHAFT, Pinion	2-HJM-00275	3
-17	TIE BRACE, Swivel frame	1-HJM-50262	3
-18	SEGMENT, Bearing box, creaser and slitter shaft	1-HJM-00260	3
-19	BRACKET, Tape hook-up	1-HJM-00547	6
	1/4-20 x 1-3/4 long socket head cap screw		(2)
	1/4 L'washer		(2)
-20	SWIVEL FRAME	3-HJM-00549	1

Item No.	Description	Part Number	Qty Per Assy
6-9	SWIVEL FRAME, 6-BAR WITH GANG LOCKING, (CONT)		
-21	SHAFT, Swivel 1/2-13 x 1-1/2 long socket head set screw	3-HJM-00524	1 (4)
-22	KEY, Swivel shaft 3/8-16 x 1-1/4 socket head cap screw	1-HJM-00029	2 (2)
-23	COVER, Swivel frame	2-HJM-00522	3
-24	RETAINER, Bearing	2-767-00229	3
-25	ROLLER BEARING, Timken, two row, double cup, single cone 3/16 diameter x 5/8 cres pin	2-930-01045-2	3 (1)
-26	MRC L'WASHER (W-14)	1012-020140	3
-27	MRC L'NUT (N-14)	1012-010-140	3
-28	BEARING BOX, Lower creaser shaft 1/2-13 x 1-1/4 long hex. head cap screw 1/2 L'washer	3-HJM-00472	3 (4) (4)
-29	COVER, Upper and lower bearing box 1/2-13 x 1-1/4 long hex head cap screw 1/2 B&H Hi-collar L'washer	2-767-00217	3 (4) (3)
-30	ROTO COUPLING, Wichita, 1/4		3
-31	SEGMENT, Bearing box, creaser and slitter shaft	1-HJM-00260	3
-32	COVER, Swivel frame #10-32 x 3/8 long, Type F self-tapping round head screw	2-HJM-00258	3 (6)
-33	COVER, Small lube access #8-32 x 1/4 long flat head socket flat head socket cap screw	1-HJM-00193	3 (4)
-34	PINION, Upper shaft, drive side Taper pin #7 x 2-3/4 long 3/8-16 x 5/8 long socket set screw	1-HJM-00277	3 (1) (1)
-35	BEARING BOX, Upper creaser and slitter shaft 1/2-13 x 3-1/2 long socket head cap screw 1/2 L'washer	3-HJM-00263	3 (2) (2)
-36	BEARING, New departure double row, ball bearing, double shield (55513)	1002-42132	3
-37	SPACER, Creaser and slitter gear	1-HJM-00082	3
-38	GEAR, Creaser and slitter (5P-36T)	1-HJM-00006	3
-39	KEY, Creaser and slitter 5/16-18 x 3/4 long socket head cap screw	1-HJM-00083	3 (12)
-40	PINNED WASHER 5/8 L'washer	2-942-00428-1-0	3 (12)
-41	WASHER 5/8-11 x 1-1/2 long hex. head cap screw 3/8 L'washer	2-942-00410-1-0	3 (12) (12)
-42	BEARING, MRC single row ball bearing, snap ring, double shield (206SFFG)	1000-20626-0	3
-43	GEAR, Idler (5P-22T)	1-HJM-00007	3
-44	SPACER, Idler gear	1-HJM-00012	3
-45	BEARING, MRC single row ball bearing, snap ring, double shield (206SFFG)	1000-206260	3
-46	STUD, Idler gear MRC bearing #206-SFFG 5/8-11 x 1-1/4 long hex. head cap screw 5/8 L'washer	1-HJM-00010	3 (2) (1) (1)

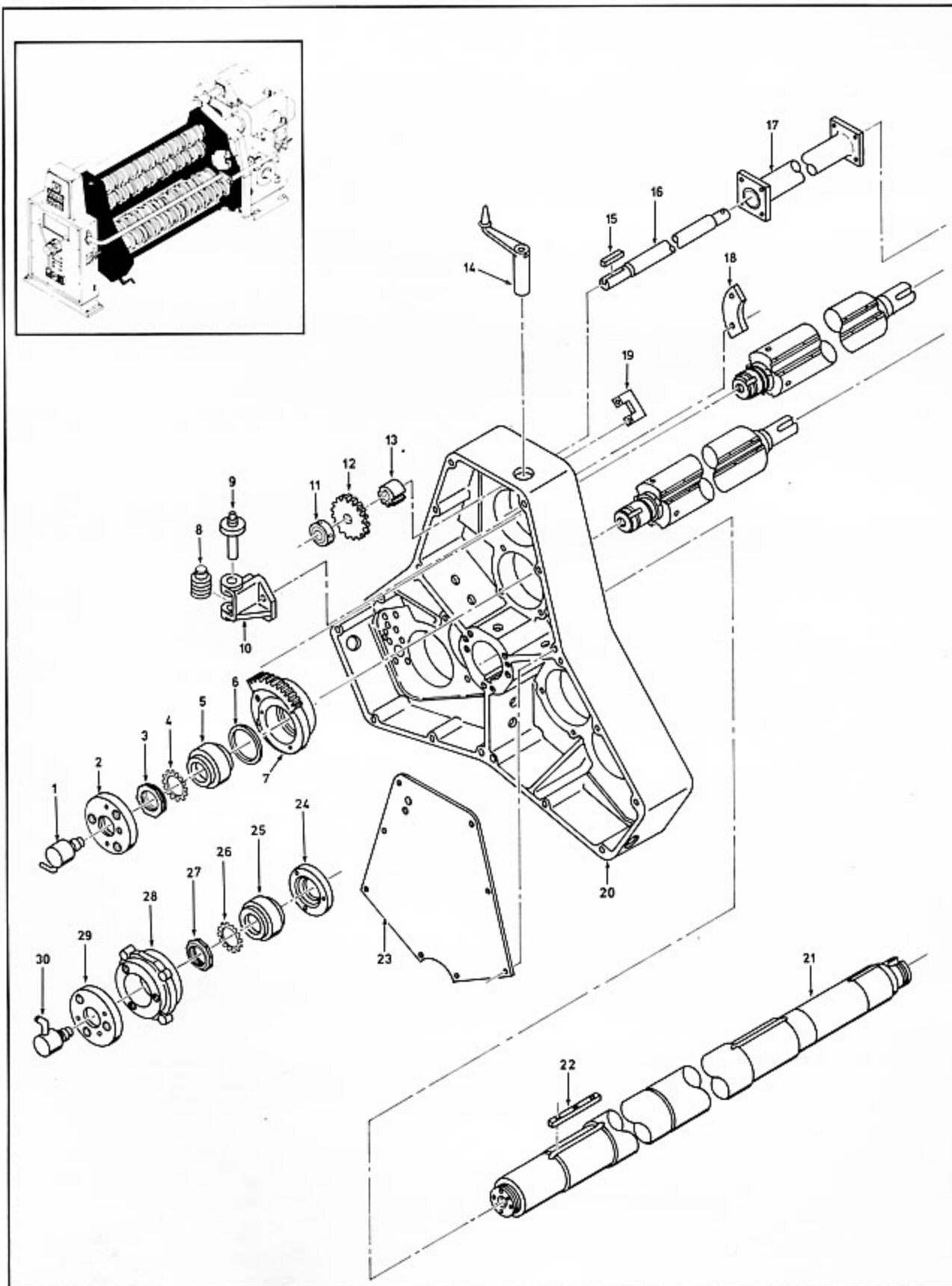


Figure 6-9. Swivel Frame, 6-Bar With Gang Locking, Operating Side (Sheet 1 of 2)

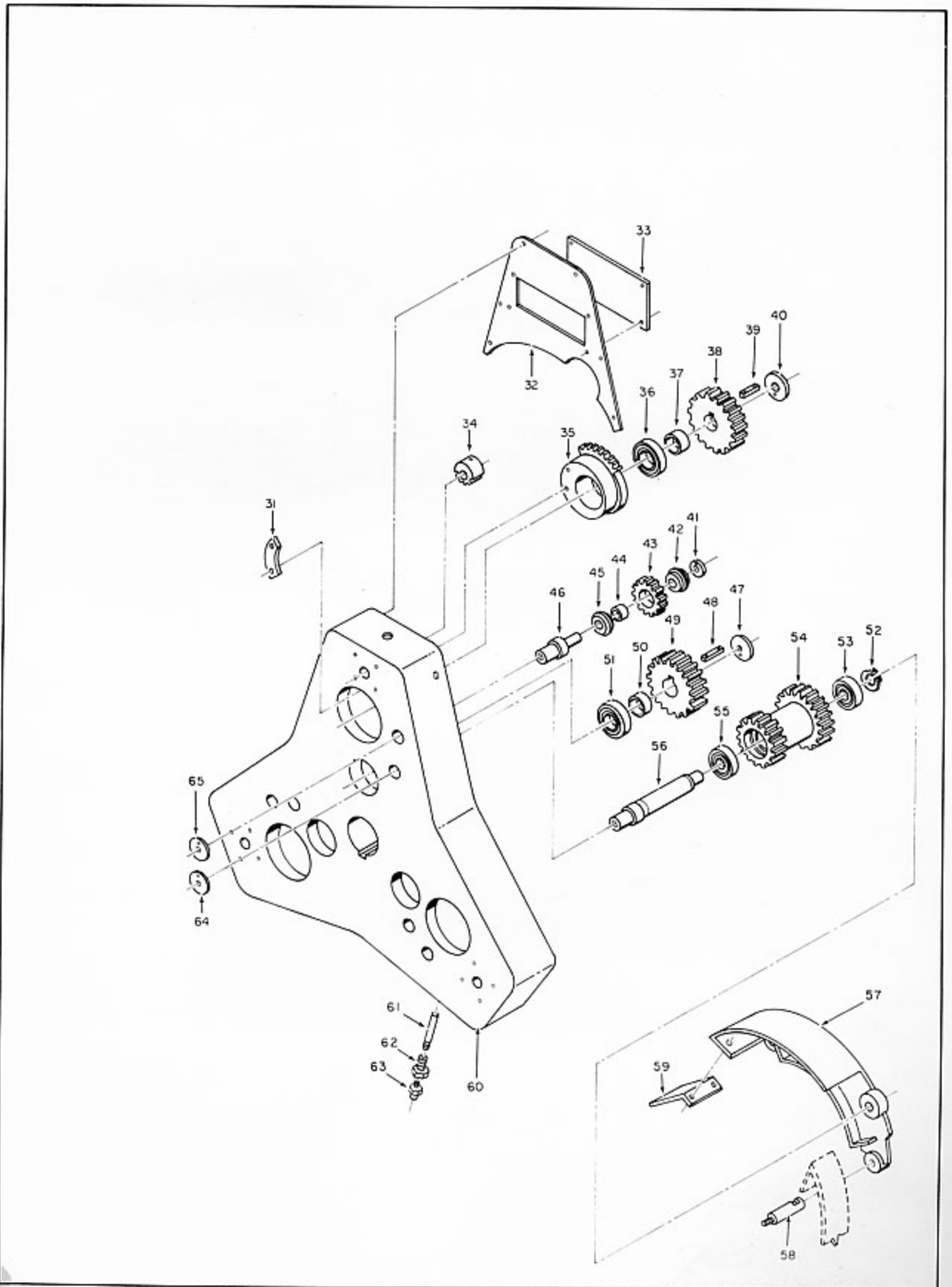


Figure 6-9. Swivel Frame, 6-Bar With Gang Locking, Drive Side (Sheet 2 of 2)



Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-9	SWIVEL FRAME, 6-BAR WITH GANG LOCKING, (CONT)		
-47	WASHER	1-912-00428	3
-48	KEY, Creaser and slitter	1-HJM-00083	3
-49	GEAR, Creaser and slitter (5P-36T)	1-HJM-00006	3
-50	SPACER, Creaser and slitter gear	1-HJM-00082	3
-51	BEARING, New departure, double row ball bearing, double shield (55513)	1002-421320	3
-52	TRUARC EXTERNAL SNAP RING (5100-196)	1237-197000	3
-53	BEARING, MRC single row ball bearing, double shield (210-SFF)	1000-210230	3
-54	GEAR, Compound, swivel frame	2-HJM-00008	3
-55	BEARING, MRC single row ball bearing, double shield (211-SFF)	1000-211230	3
-56	STUD, Compound gear	2-HJM-00009	3
-57	GUARD, Drive side	4-HJM-00005	3
-58	POST, Guard	1-HJM-00011	3
-59	GUARD, Compound gear	1-HJM-00131	3
-60	FRAME	3-HJM-00548	1
-61	TUBING	1-HJLD-00068	3
-62	LUBRICATING SCREW	1-942-00942-1	3
-63	FITTING, Grease (Alemite)	(1610)	3
-64	PINNED WASHER	2-942-00428-1-0	3
-65	PINNED WASHER	2-942-00428-1-0	3

Item No.	Description	Part Number	Qty Per Assy
6-10	6-BAR DRIVE SIDE SWIVEL ASSEMBLY, 109" MACHINE ONLY		
-1	COVER, Swivel frame, drive side	2-HJM-00258	3
-2	COVER, Small lub. access	1-HJM-00193	3
-3	TAPER PIN, #7 x 2-3/4" long		3
-4	PINION, Upper shaft	1-HJM-00277	3
	Pinned washer	1-942-00410-0-A	3
-5	BEARING BOX, Upper 2 bar station	2-767-00255	3
-6	BEARING, MRC (213-SZZ)		3
-7	SPACER, Creaser slitter	1-767-00252	3
-8	BEARING, MRC (213-SZZ)		3
-9	SPACER, Creaser slitter	1-767-00253	3
-10	GEAR, Creaser and slitter	1-HJM-00006	3
-11	KEY, Creaser and slitter shaft	1-HJM-00083	3
	5/16-18 x 3/4 long socket head cap screw		(6)
-12	PINNED WASHER	1-942-00428-0-A	3
	5/8-11 x 1-1/4 long hex. head cap screw		(3)
	L'washer, 5/8		(3)
-13	PINNED WASHER	1-942-00410-0-A	3
	3/8-16 x 1" long hex. head cap screw		(3)
	L'washer, 3/8		(3)
-14	BEARING, MRC (206-SFFG)		3
-15	GEAR, Idler (22T)		3
-16	SPACER, Idler gear stud	1-HJM-00012	3

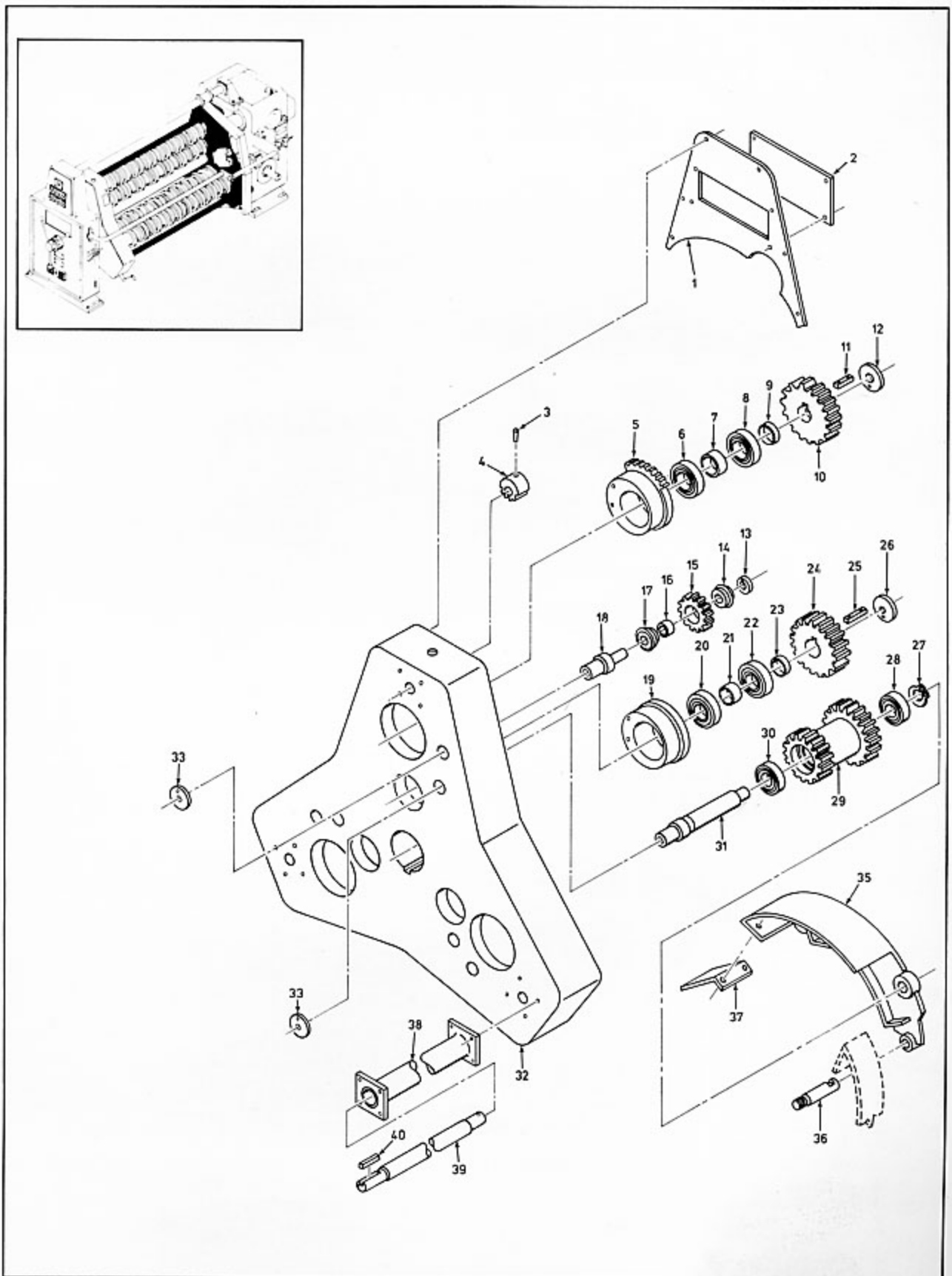


Figure 6-10. 6-Bar Drive Side Swivel Assembly, 109" Machine Only

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-10	6-BAR DRIVE SIDE SWIVEL ASSEMBLY, 109" MACHINE ONLY (CONT)		
-17	BEARING, MRC (206-SFFG)		3
-18	STUD, Idler gear	1-HJM-00010	3
-19	BEARING BOX, Lower 2-bar station	2-767-00251	3
-20	BEARING, MRC (213-SZZ)		3
-21	SPACER, Creaser slitter	1-767-00252	3
-22	BEARING, MRC (213-SZZ)		3
-23	SPACER, Creaser slitter	1-767-00253	3
-24	GEAR, Creaser and slitter	1-HJM-00006	3
-25	KEY, Creaser and slitter shaft	1-HJM-00083	3
	5/16 x 18-3/4 long socket head cap screw		(6)
-26	PINNED WASHER	1-942-00428-0-A	3
	5/8-11 x 1-1/4 long hex. head cap screw		(3)
	L'washer, 5/8		(3)
-27	TRUARC RING (5100-196)		3
-28	BEARING, MRC (210-SFF)		3
-29	GEAR, Compound	2-HJM-00008	3
-30	BEARING, MRC (211-SFF)		3
-31	STUD, Compound gear	2-HJM-00009	3
-32	SWIVEL FRAME, Drive side	5-HJM-00554	1
-33	PINNED WASHER	1-942-00428-0-A	3
	5/8-11 x 1-1/4 long hex. head cap screw		(3)
	L'washer, 5/8		(3)
-34	PINNED WASHER	1-942-00428-0-A	3
	5/8-11 x 1-1/4 long hex. head cap screw		(3)
	5/8 L'washer		(3)
-35	GUARD	4-767-00214	1
-36	POST, Guard	1-HJM-00011	1
-37	GUARD, Compound gear	1-HJM-00131	1
-38	TIE BRACE, Swivel frame	1-HJM-50262	3
-39	PINION, Upper shaft	2-HJM-00275	3
-40	KEY	1-946-40343	3

Item No.	Description	Part Number	Qty Per Assy
6-11	HJM 8-BAR SWIVEL ASSEMBLY, WITHOUT GANG LOCKING		
-1	WORM, Adjustment	1-HJM-00023	2
-2	STUD, Worm adjustment	1-767-50207	2
-3	BRACKET, Worm adjustment	3-HJMD-00006	1
	3/8-16 x 1 long hex. head cap screw		(2)
	3/8-16 x 4-1/2 long hex. head cap screw		(1)
	3/8 L'washer		(3)
	3/8 diameter x 1" long dowel pin		(2)
-4	COLLAR	1-942-00124-2	2
-5	WORM GEAR, Adjustment (8P-40T)	1-HJM-00022	2
-6	SPACER, Worm wheel	1-HJM-00059	2
-7	HANDLE	2-HJM-50209	1

Item No.	Description	Part Number	Qty Per Assy
6-11	HJM 8-BAR SWIVEL ASSEMBLY, WITHOUT GANG LOCKING, (CONT)		
-8	KEY	1-946-40150	2
-9	PINION	1-HJM-00021	2
	#5 x 2-1/2 long taper pin		(1)
-10	TORQUE TUBE	1-HJM-00017	2
	#7 taper pin x 2-1/2" long		(2)
	1/4-20 x 1/4 long socket set screw		(2)
-11	SEGMENT	1-HJM-00014	2
	1/2-13 x 1" long socket head cap screw		(2)
	3/8 diameter x 3/8 long dowel pin		(1)
-12	SHAFT, Slitter and creaser (with chrome), 6" diameter shafts	3-767-00216	2
-12	SHAFT, Slitter and creaser (without chrome), 6" diameter shafts	3-767-00238	2
-12	SHAFT, Slitter and creaser (with chrome), 6-1/2" diameter shafts	3-767-00211	2
-12	SHAFT, Slitter and creaser (without chrome), 6-1/2" diameter shafts	3-767-00235	2
-13	SHAFT, Slitter and creaser (with chrome), 6" diameter shafts	2-HJM-00282	6
-13	SHAFT, Slitter and creaser (without chrome), 6" diameter shafts	2-HJM-00018	6
-13	SHAFT, Slitter and creaser (with chrome), 6-1/2" diameter shafts	2-HJM-00350	6
-13	SHAFT, Slitter and creaser (without chrome), 6-1/2" diameter shafts	2-HJM-00315	6
-14	KEY	1-946-40343	2
-15	TIE BRACE, Swivel frame	1-HJM-50262	2
	1/2-13 x 1-1/2 long hex. head cap screw		(8)
	1/2 L'washer		(8)
-16	PINION, Upper shaft	2-HJM-00275	2
-17	SWIVEL FRAME, Operating side	5-767-00160	1
	1/8 to 1/4 tube compression fitting, #701 brs		(8)
	Alemite fitting #1613-B		(8)
	Vlier Plunger No. S-58 (3/8-16 thd.)		(4)
	3/8-16 hex. nuts		(4)
-18	PINION	1-HJM-00276	2
-19	WORM GEAR, Adjustment (8P-40T)	1-HJM-00022	2
-20	COLLAR	1-942-00124-2	2
-21	BRACKET, Worm adjustment	3-HJMD-00005	3
	3/8-16 x 1" long hex. head cap screw		(2)
	3/8-16 x 4-1/2 long hex. head cap screw		(1)
	3/8 L'washer		(3)
	3/8 diameter x 1" long dowel pin		(2)
-22	WORM, Adjustment	1-HJM-00023	2
-23	STUD, Worm adjustment	1-767-50207	2
-24	COVER, Bearing box	2-CEB-00069	4
	Alemite #1684		(1)
	1/2-13 x 1-1/4 long socket head cap screw		(3)
-25	WASHER, Bearing retainer	1-CEB-00078	4
	5/8-11 x 1-1/4 long socket head screw		(1)
	3/16 diameter x 5/8 long crs pin		(1)
-26	TIMKEN BEARING (TDo-484-472-D)	2-930-01049-2	2
-27	BEARING BOX	3-HJM-00264	2
-28	RETAINER, BEARING	2-CEB-00079	4
-29	TIMKEN BEARING (TD0-484-472-D)	2-930-01049-2	4

Note (A). For Swivel Shaft Assembly, (not shown), see Figure 6-8, parts 17 thru 24.

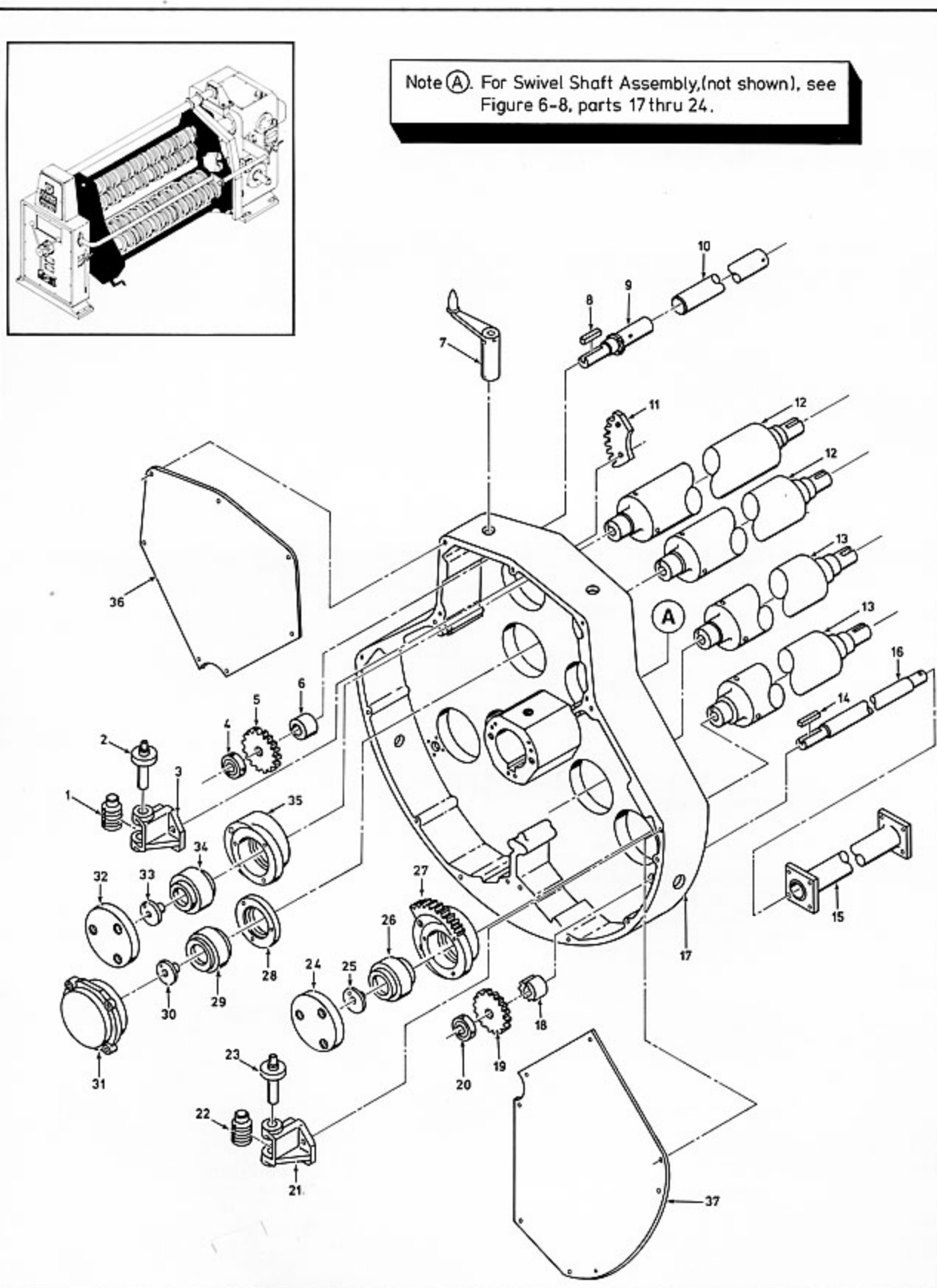


Figure 6-11. HJM 8-Bar Swivel Assembly, Without Gang Locking, Operating Side (Sheet 1 of 2)

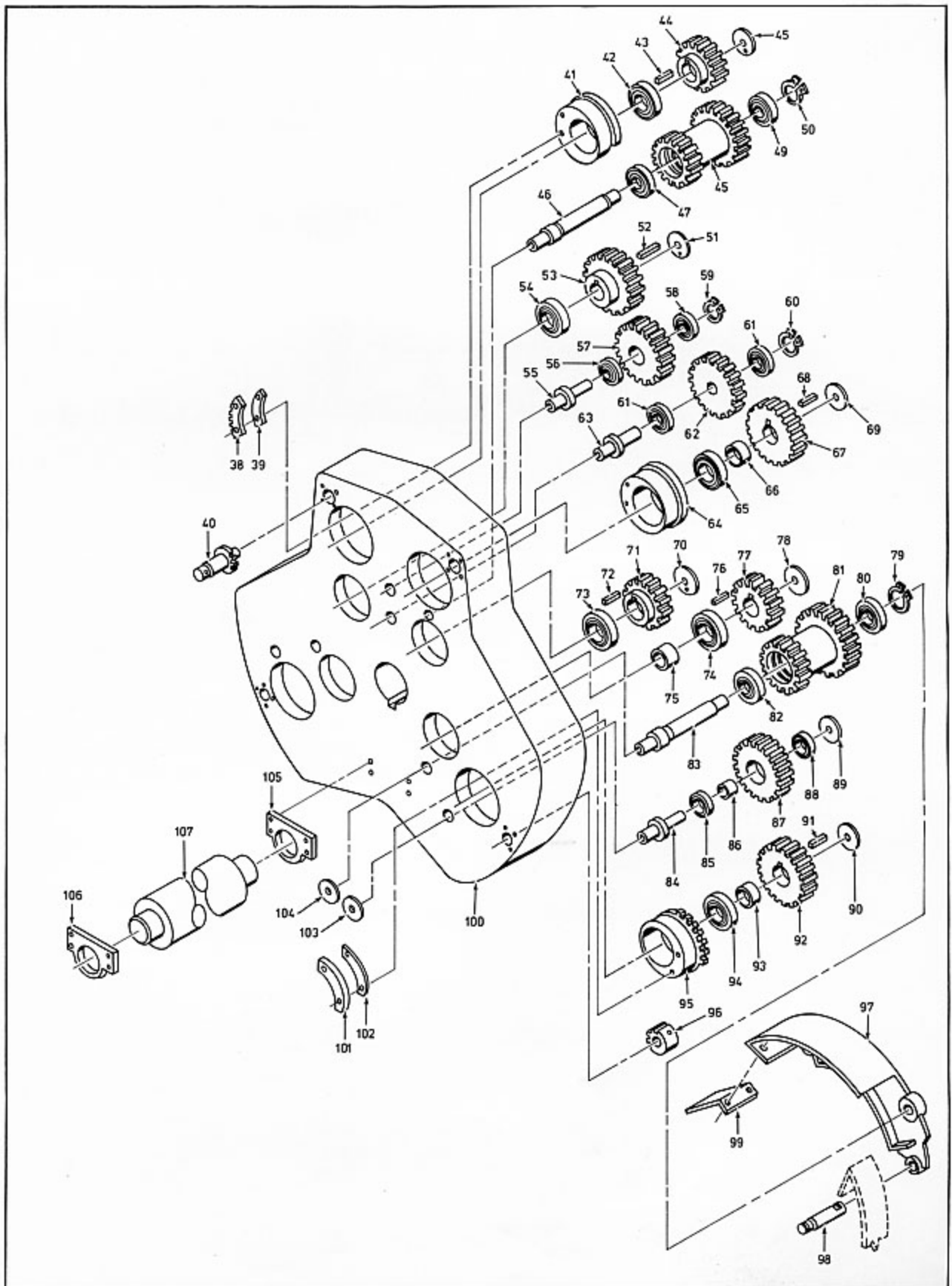


Figure 6-11. HJM 8-Bar Swivel Assembly, Without Gang Locking, Drive Side (Sheet 2 of 2)

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-11	HJM 8-BAR SWIVEL ASSEMBLY, WITHOUT GANG LOCKING, (CONT)		
-30	WASHER, Bearing retainer 5/8-11 x 1-1/4 long socket head screw 3/16 diameter x 5/8 long crs pin	1-CEB-00078	4 (1) (1)
-31	BEARING BOX	1-CXF-00111	4
-32	COVER, Bearing box Alemite #1684 1/2-13 x 1-1/4 long socket head cap screw	2-CEB-00069	4 (1) (3)
-33	WASHER, Bearing retainer 5/8-11 x 1/4 long socket head cap screw 5/8-11 x 1-1/4 long socket head screw 3/16 diameter x 5/8 long crs pin	1-CEB-00078	4 (8) (1) (1)
-34	TIMKEN BEARING (TD0-484-472-D)	2-930-01049-2	2
-35	BEARING BOX	2-HJM-00019	2
-36	COVER, Swivel frame #10-32 x 3/8 long, Type F, self-tapping round head screw	2-HJMD-00008	1 (7)
-37	COVER, Swivel frame #10-32 x 3/8 long, Type F, pan head tapping screw	2-767-00159	2 (8)
-38	SEGMENT, Bearing box, creaser and slitter shaft	1-HJM-00014	2
-39	SHIM	1-942-02040	1
-40	PINION, Upper shaft adjustment	1-HJM-00016	2
-41	BEARING BOX	2-767-00164	1
-42	BEARING, New departure (55513)	1002-213230	2
-43	KEY	1-947-60256	1
-44	GEAR, Creaser and slitter (25T-5P)	2-767-00283	1
-45	PINNED WASHER 5/8-11 x 1-1/2 long hex. head cap screw 5/8 L'washer	1-942-00428-0-A	1 1 1
-46	STUD, Compound gear	2-767-00210	1
-47	BEARING, MRC (211-SFF)	1000-211230	1
-48	GEAR, Compound (5P-36T, 5P-25T)	2-767-00207	1
-49	BEARING, MRC (210-SFF)	1000-210230	1
-50	RETAINING RING, Truarc (5100-196)	1237-197000	1
-51	PINNED WASHER 5/8-11 x 1-1/2 long hex. head cap screw 5/8 L'washer	1-942-00428-0-A	1 1 (1)
-52	KEY	1-947-60256	1
-53	GEAR, Creaser and slitter (25T-5P)	2-767-00283	1
-54	BEARING, New departure (55513)	1002-213230	1
-55	STUD	2-767-00213	1
-56	BEARING, MRC (211-SFF)	1000-211230	1
-57	GEAR, Compound	2-767-00293	1
-58	BEARING, MRC (309-SFF)	1000-309230	1
-59	RETAINING RING, Truarc (5100-177)		1
-60	RETAINING RING, Truarc (5100-196)	1237-197000	1
-61	BEARING, MRC (210-SZZG)	1000-210300	2
-62	GEAR, Idler	1-767-00298	1
-63	STUD, Idler	1-767-00279	1
-64	BEARING BOX	2-HJM-00020	1
-65	BEARING, New departure (55513)	1002-213230	1
-66	SPACER		1
-67	GEAR, Creaser and slitter shaft (5P-25T)	1-767-00284	1
-68	KEY	1-HJM-00083	1
-69	PINNED WASHER	1-942-00428-0-A	1
-70	PINNED WASHER	1-942-00428-0-A	1

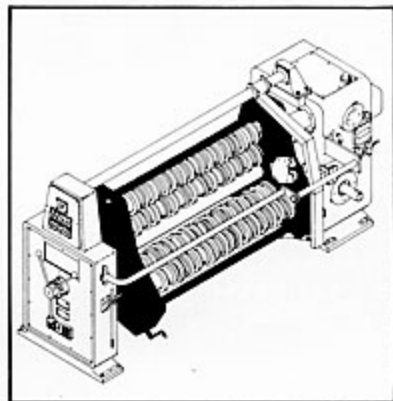


Item No.	Description	Part Number	Qty Per Assy
6-11	HJM 8-BAR SWIVEL ASSEMBLY, WITHOUT GANG LOCKING, (CONT)		
-71	GEAR, Creaser and slitter (25T-5P)	2-767-00284	1
-72	KEY	1-947-60256	1
-73	BEARING, New departure (55513)	1002-213230	1
-74	BEARING, New departure (55513)	1002-213230	1
-75	SPACER	1-HJM-00082	1
-76	KEY	1-HJM-00083	1
-77	GEAR, Creaser and slitter (33T-5P)	1-767-00277	1
-78	PINNED WASHER 5/8-11 x 1-1/2 long hex. head cap screw 5/8 L'washer	1-942-00428-0-A	1 (1) (1)
-79	RETAINING RING, Truarc (5100-196)	1237-197000	1
-80	BEARING, MRC (210-SFF)	1000-210230	1
-81	GEAR, Compound (5P-36T, 5P-33T)	2-767-00278	1
-82	BEARING, MRC (211-SFF)	1000-211230	1
-83	STUD, Compound gear	2-HJM-00009	1
-84	STUD, Idler gear 5/8-11 x 1-1/4 long hex. head cap screw 5/8 L'washer	1-HJM-00010	1 (1) (1)
-85	BEARING, MRC (206-SFFG)	1000-206260	2
-86	SPACER	1-HJM-00012	1
-87	GEAR, Idler (22T-5P)	1-HJM-00007	1
-88	BEARING, MRC (206-SFFG)	1000-206260	1
-89	PINNED WASHER 3/8-16 x 1" long hex. head cap screw 3/8 L'washer	1-942-00410-0-A	1 1 1
-90	PINNED WASHER 5/8-11 x 1-1/2 long hex. head cap screw 5/8 L'washer	1-942-00428-0-A	1 (1) (1)
-91	KEY 5/16-18 x 3/4 long socket head cap screw	1-HJM-00083	1 (4)
-92	GEAR, Creaser and slitter (33T-5P)	1-767-00277	1
-93	SPACER	1-HJM-00082	1
-94	BEARING, New departure (55513)	1002-213230	1
-95	BEARING BOX 1/2-13 x 3-1/2 long socket head cap screw 1/2 L'washer	3-HJM-00263	1 (2) (2)
-96	PINION #7 x 2-3/4" long taper pin 3/8-16 x 5/8 long socket set screw	1-HJM-00277	1 (1) (1)
-97	GUARD	4-767-00214	1
-98	POST, Guard	1-HJM-00011	1
-99	GUARD, Compound gear	1-HJM-00131	1
-100	SWIVEL FRAME	5-767-00161	1
-101	SEGMENT	1-HJM-00260	2
-102	SHIM	1-942-02040	A/R
-103	WASHER	1-942-00428	1
-104	WASHER	1-942-00428	1
-105	PLATE, Mounting, balance shaft	1-767-00175	1
-106	PLATE, Mounting, balance shaft	1-767-00175	1
-107	SHAFT, Balancing	2-767-00174	1

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-12	HJM 8-BAR, SWIVEL ASSEMBLY, WITH GANG LOCKING		
-1	WORM, Adjustment	1-HJM-00023	2
-2	BRACKET, Worm adjustment	3-767-00218	1
	3/8-16 x 1" long hex. head cap screw		(2)
	3/8-16 x 4-1/2 long hex. head cap screw		(1)
	3/8 L'washer		(3)
-3	STUD, Worm adjustment	1-767-50207	2
-4	COLLAR	1-942-00124-3	2
-5	WORM GEAR, Adjustment (8P-40T)	1-HJM-00022	2
-6	SPACER, Worm wheel	1-HJM-00059	2
-7	HANDLE	2-HJM-50209	1
	1/4-20 x 1/4 long socket head set screw		(2)
-8	KEY	1-946-40150	2
-9	PINION	1-HJM-00021	2
-10	TORQUE TUBE	1-HJM-00017	2
	#7 taper pin x 2-1/2 long		(2)
	1/4-20 x 1/4 long socket set screw		(2)
-11	SEGMENT	1-HJM-00014	2
-12	SHAFT, Creaser and slitter (See figure 6-19 for detail breakdown)	4-HJM-00537	2
-13	SHAFT, Slitter and creaser (See figure 6-19 for detail breakdown)	4-HJM-00538	6
-14	TIE BRACE, Swivel frame	1-HJM-50262	2
-15	PINION, Upper shaft	2-HJM-00275	2
-16	KEY	1-946-40343	2
-17	SWIVEL FRAME, Operating side	3-REW-00100	1
-18	PINION	1-HJM-00276	2
	1/2-13 x 1-1/2 long hex. head cap screw		(8)
	1/2 L'washer		(8)
-19	WORM GEAR, Adjustment (8P-40T)	1-HJM-00022	2
-20	COLLAR	1-942-00124-2	2
-21	BRACKET, Worm adjustment	3-767-00168	3
-22	WORM, Adjustment	1-HJM-0023	2
-23	STUD, Worm adjustment	1-767-50207	2
-24	BEARING BOX	3-HJM-00264	2
-25	TIMKEN BEARING (TD0-484-472-D)	2-930-01049-2	2
-26	MRC LOCK WASHER (W-14)	1012-020140	2
-27	MRC LOCK NUT (N-14)	1012-010140	2
-28	COVER, Upper and lower bearing box	2-767-00217	2
-29	ROTO COUPLING (1/4)		2
	3/8-16 x 1" long hex. head cap screw		(2)
	3/8-16 x 4-1/2 long hex. head cap screw		(1)
	3/8 L'washer		(3)
-30	RETAINER, Bearing	2-767-00229	2
-31	TIMKEN BEARING (TD0-484-472-D)	2-930-01049-2	2
-32	MRC LOCK WASHER (W-14)	1012-02014	2
	1/2-13 x 3-1/2 long socket head cap screw		(2)
	1/2 L'washer		(2)
-33	MRC LOCK NUT (N-14)	1012-01014	2
-34	BEARING BOX	3-HJM-00472	2
-35	COVER, Upper and lower bearing box	2-767-00217	2
-36	ROTO COUPLING (1/4)		2
	1/2-13 x 4 long socket head cap screw		(3)
	1/2 B&H Hi-collar L'washer		(3)
	1/2-13 x 1-1/2 long socket head cap screw		(3)
-37	RETAINER, Bearing	2-767-00229	2
-38	TIMKEN BEARING (TD0-484-472-D)	2-930-01049-2	2

Item No.	Description	Part Number	Qty Per Assy
6-12	HJM 8-BAR, SWIVEL ASSEMBLY, WITH GANG LOCKING, (CONT)		
-39	MRC LOCK WASHER (W-14)	1012-02014	2
-40	MRC LOCK NUT (N-14)	1012-01014	2
-41	BEARING BOX	3-HJM-00472	2
-42	COVER, Upper and lower bearing box	2-767-00217	2
	1/2-13 x 1-1/4 long hex. head cap screw		(4)
	1/2 L'washer		(4)
-43	ROTO COUPLING (1/4)		2
	1/2-13 x 4 long socket head cap screw		(3)
	1/2 B&H Hi-collar L'washer		(3)
	1/2-13 x 1-1/2 long socket head cap screw		(3)
-44	BEARING BOX, Upper creaser and slitter	2-767-00230	2
-45	TIMKEN BEARING (TD0-484-472-D)	2-930-01049-2	2
-46	MRC LOCK WASHER (W-14)	1012-02014	2
-47	MRC LOCK NUT (N-14)	1012-01014	2
-48	COVER, Upper and lower bearing box	2-767-00217	2
-49	ROTO COUPLING (1/4)		2
	1/2-13 x 1-1/4 long hex. head cap screw		(4)
	1/2 L'washer		(4)
-50	1/4 WICHITA ROTO-COUPLING		8
	1/2-13 x 4 long socket head cap screw		(3)
	1/2 B&H Hi-collar L'washer		(3)
	1/2-13 x 1-1/2 long socket head cap screw		(3)
-51	1/8 P. T. TO 3/8 O. D. TUBE, Male conn.		7
-52	1/8 CROSS		2
-53	1/8 NIPPLE x 3" LONG		1
-54	1/4 P. T. TO 3/8 O. D. TUBE, Male conn.		8
-55	UNION TEE 3/8 x 3/8 x 3/8 (for plastic tube)		3
-56	SAMUEL MOORE 3/8 O. D. x 050, Wall group I tubing		20
	1/2-13 x 4 long socket head cap screw		(3)
	1/2 B&H Hi-collar L'washer		(3)
	1/2-13 x 1-1/2 long socket head cap screw		(3)
-57	1/4-20 "U" BOLT, Lafayette Cat. 18E02024 Cat. 740-PG. 301		1
-58	HOSE CLIP, 3/8 O. D.		3
-59	SEGMENT, Bearing box, creaser and slitter shaft	1-HJM-00014	2
-60	SHIM	1-942-02040	
-61	PINION, Upper shaft adjustment	1-HJM-00016	2
-62	BEARING BOX	2-767-00164	1
-63	BEARING, New departure (55513)	1002-213230	2
-64	KEY	1-947-60256	1
-65	GEAR, Creaser and slitter (25T-5P)	2-767-00283	1
-66	PINNED WASHER	1-942-00428-0-A	1
	5/8-11 x 1-1/2 long hex. head cap screw		(1)
	5/8 L'washer		(1)
-67	STUD, Compound gear	2-767-00210	1
-68	BEARING, MRC (211-SFF)	1000-211230	1
-69	GEAR, Compound (5P-36T, 5P-25T)	2-767-00207	1
-70	BEARING, MRC (210-SFF)	1000-210230	1
-71	RETAINING RING, Truarc (5100-196)	1237-197000	1
-72	PINNED WASHER	1-942-00428-0-A	1
	5/8-11 x 1-1/2 long hex. head cap screw		(1)
	5/8 L'washer		(1)
-73	KEY	1-947-60256	1
-74	GEAR, Creaser and slitter (25T-5P)	2-767-00283	1
-75	BEARING, New Departure (55513)	1002-213230	1
-76	STUD	2-767-00213	1



Note (A). For Swivel Shaft Assembly, (not shown), see Figure 6-9, parts 21 and 22.

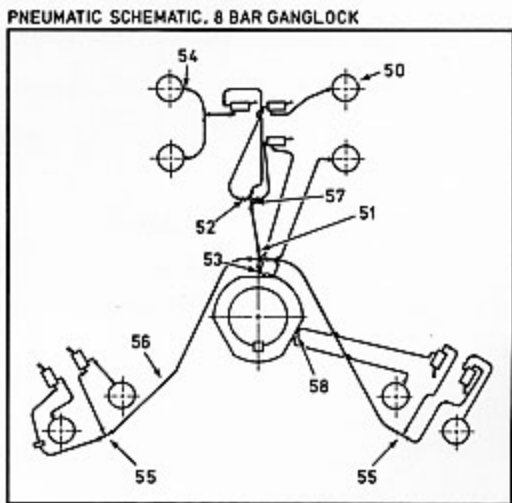
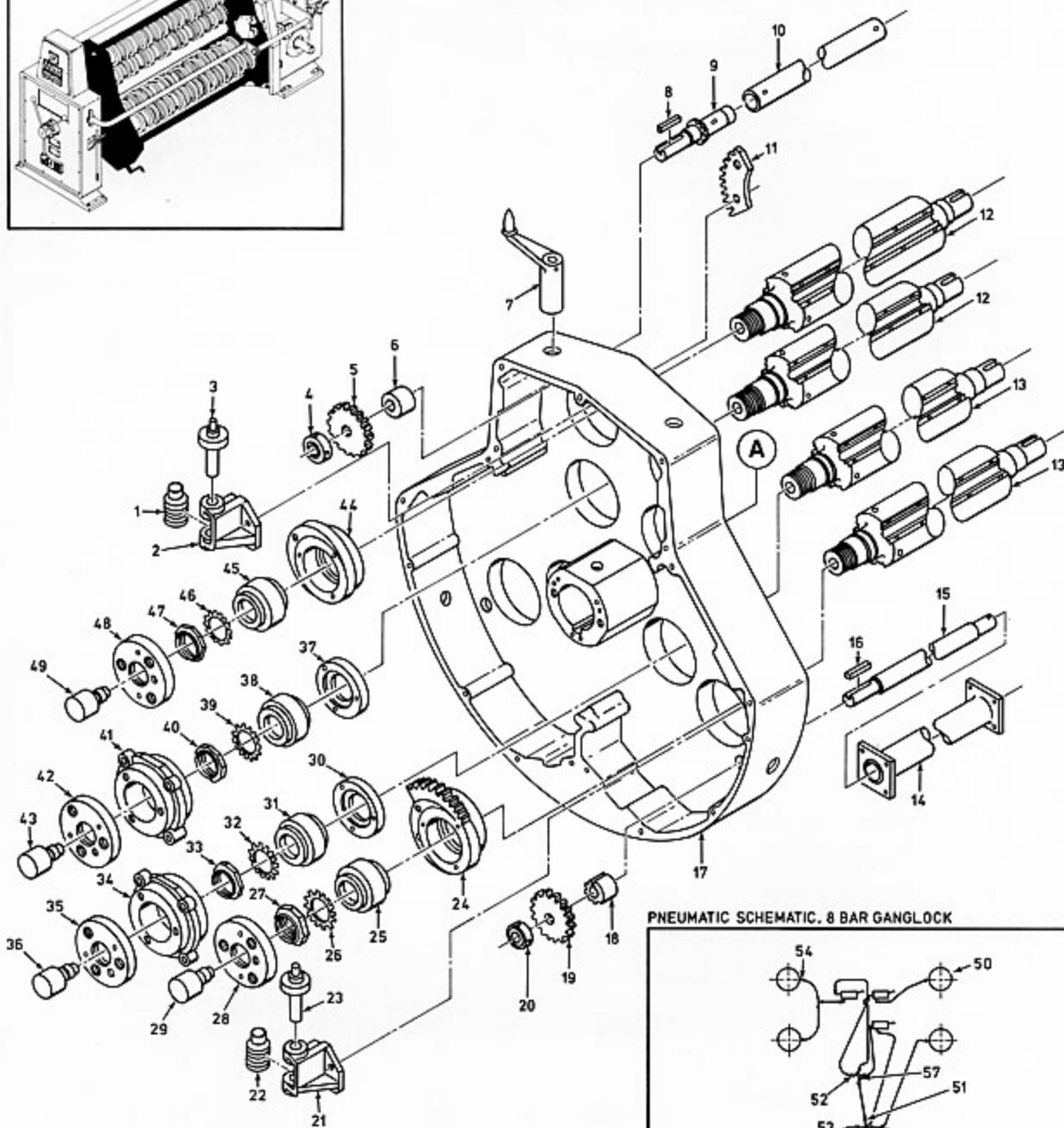


Figure 6-12. HJM 8-Bar, Swivel Assembly, with Gang Locking, Operating Side (Sheet 1 of 2)

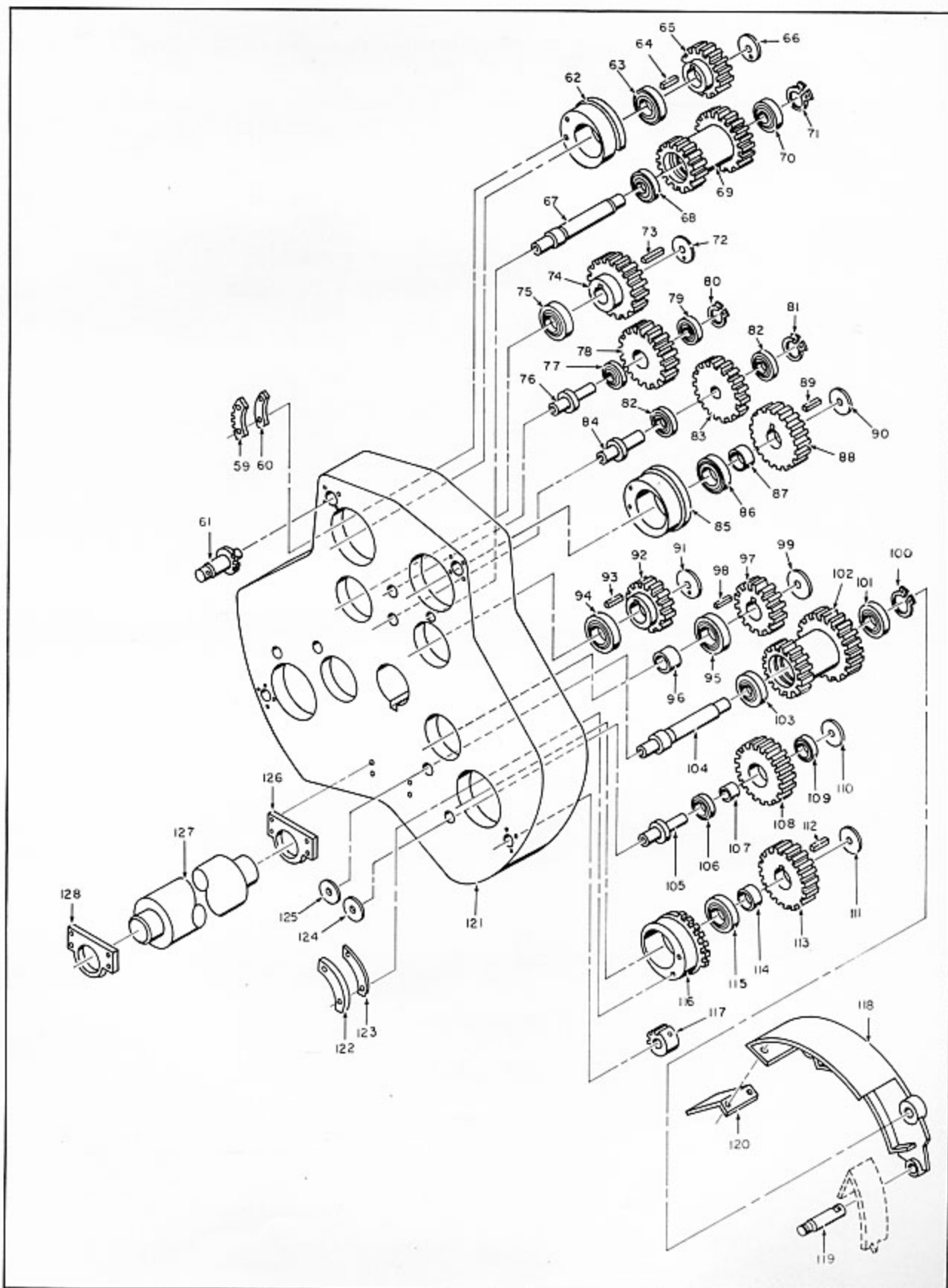


Figure 6-12. HJM 8-Bar, Swivel Assembly, with Gang Locking, Drive Side (Sheet 2 of 2)

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-12	HJM 8-BAR, SWIVEL ASSEMBLY, WITH GANG LOCKING, (CONT)		
-77	BEARING, MRC (211-SFF)	1000-211230	1
-78	GEAR, Compound	2-767-00293	1
-79	BEARING, MRC (309-SFF)	1000-309230	1
-80	RETAINING RING, Truarc (5100-177)		1
-81	RETAINING RING, Truarc (5100-196)	1237-197000	1
-82	BEARING, MRC (210-SZZG)	1000-21300	2
-83	GEAR, Idler	1-767-00298	1
-84	STUD, Idler	1-767-00279	1
-85	BEARING BOX	2-HJM-00020	1
-86	BEARING, New departure (55513)	1002-213230	1
-87	SPACER		
-88	GEAR, Creaser and slitter shaft (5P-25T)	1-767-00284	1
-89	KEY	1-HJM-00083	1
-90	PINNED WASHER	1-942-00428-0-A	1
-91	PINNED WASHER	1-942-00428-0-A	1
-92	GEAR, Creaser and slitter (25T-5P)	2-767-00284	1
-93	KEY	1-947-60256	1
-94	BEARING, New departure (55513)	1002-213230	1
-95	BEARING, New departure (55513)	1002-213237	1
-96	SPACER	1-HJM-00082	1
-97	GEAR, Creaser and slitter (33T-5P)	1-767-00277	1
	Taper pin #7 x 2-3/4 long		(1)
	3/8-16 x 5/8 long socket set screw		(1)
-98	KEY	1-HJM-00083	1
-99	PINNED WASHER	1-942-00428-0-A	1
-100	RETAINING RING, Truarc (5100-196)	1237-197000	1
-101	BEARING, MRC (210-SFF)	1000-210230	1
-102	GEAR, Compound (5P-36T, 5P-33T)	2-767-00278	1
-103	BEARING, MRC (211-SFF)	1000-211230	1
-104	STUD, Compound gear	2-HJM-00009	1
-105	STUD, Idler gear	1-HJM-00010	1
	5/8-11 x 1-1/2 long hex. head cap screw		(1)
	5/8 L'washer		(1)
-106	BEARING, MRC (206-SFFG)	1000-206260	2
-107	SPACER	1-HJM-00012	1
-108	GEAR, Idler (22T-5P)	1-HJM-00007	1
-109	BEARING, MRC (206-SFFG)	1000-206260	1
-110	PINNED WASHER	1-942-00410-0-A	1
	3/8-16 x 1" long hex. head cap screw		(1)
	3/8 L'washer		(1)
-111	PINNED WASHER	1-942-00428-0-A	1
	5/8-11 x 1-1/2 long hex. head cap screw		(1)
	5/8 L'washer		(1)
-112	KEY	1-HJM-00083	1
	5/16-18 x 3/4 long socket head cap screw		(4)
-113	GEAR, Creaser and slitter (33T-5P)	1-767-00277	1
-114	SPACER	1-HJM-00082	1
-115	BEARING, New departure (55513)	1002-213230	1
-116	BEARING BOX	3-HJM-00263	1
	1/2-13 x 3-1/2 long socket head cap screw		(2)
	1/2 L'washer		(2)
-117	PINION	1-HJM-00277	1
	#7 x 2-3/4" long taper pin		2
-118	GUARD	4-767-00214	1
-119	POST, Guard	1-HJM-00011	1
-120	GUARD, Compound gear	1-HJM-00131	1
-121	SWIVEL FRAME	5-767-00161	1
-122	SEGMENT	1-HJM-00260	2



Item No.	Description	Part Number	Qty Per Assy
6-12	HJM 8-BAR, SWIVEL ASSEMBLY WITH GANG LOCKING, (CONT)		
-123	SHIM	1-942-02040	A/R
-124	WASHER	1-942-00428	1
-125	WASHER	1-942-00428	1
-126	PLATE, Mounting, balance shaft	1-767-00175	1
-127	SHAFT, Balancing	2-767-00174	1
-128	Plate, Mounting, balance shaft	1-767-00175	1

Item No.	Description	Part Number	Qty Per Assy
6-13	8-BAR, 109" ONLY, DRIVE SIDE		
-1	PINION, Upper shaft adjust.	1-HJM-00018	2
-2	GEAR SEGMENT	1-HJM-00014	2
	Socket head cap screw, 1/2-13 x 1" long		(2)
-3	BEARING BOX, Upper shaft	2-767-00275	1
-4	BEARING, MRC (213-SZZ)		1
-5	SPACER, Creaser and slitter	1-767-00252	1
-6	BEARING, MRC (213-SZZ)		1
-7	SPACER, Creaser and slitter	1-767-00253	1
-8	KEY	1-947-60162	1
	Socket head cap screw, 5/16-18 x 3/4 long		(1)
-9	GEAR, Creaser and slitter (25T-5P)	2-767-00257	1
-10	PINNED WASHER	2-942-00428-1-0	1
	Hex head cap screw, 5/8-11 x 1-1/2 long		(1)
	L'washer, 5/8		(1)
-11	PINNED WASHER	2-942-00428-1-0	1
	Hex head cap screw, 5/8-11 x 1-1/2 long		(1)
	L'washer, 5/8		(1)
-12	KEY	1-947-60162	1
	Socket head cap screw, 5/16-18 x 3/4 long		(1)
-13	GEAR, Creaser and slitter (25T-5P)	2-767-00257	1
-14	SPACER, Creaser and slitter	1-767-00253	1
-15	BEARING, MRC (213-SZZ)		1
-16	SPACER, Creaser and slitter	1-767-00252	1
-17	BEARING, MRC (213-SZZ)		1
-18	BEARING BOX	2-767-00263	1
-19	STUD, Compound gear	2-767-00280	1
-20	BEARING, MRC (210-SZZG)		1
-21	BEARING, MRC (210-SZZG)	1000-210300	1
-22	GEAR, Compound (36T-5P)	2-767-00302	1
-23	RETAINING RING, Truarc (5100-196)		1
-24	RETAINING RING, Truarc (5100-196)		1
-25	BEARING, MRC (210-SZZG)		1
-26	GEAR, Idler (30T-5P)	1-767-00298	1
-27	BEARING, MRC (210-SZZG)		1
-28	STUD, Idler gear	1-767-00308	1
-29	BEARING BOX, Upper shaft	2-767-00275	1
-30	BEARING, MRC (213-SZZ)		1



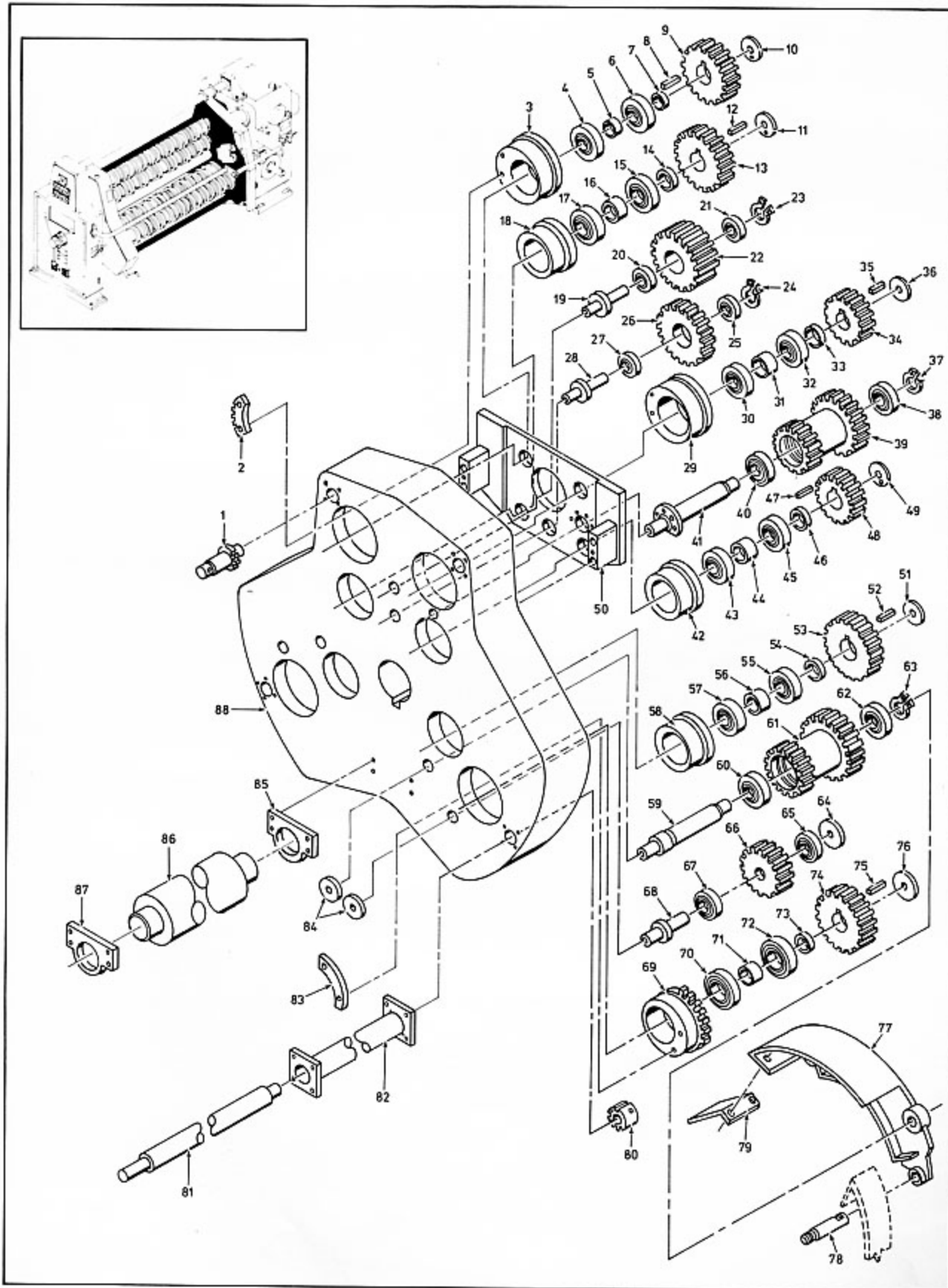


Figure 6-13. 8-Bar, 109' Only, Drive Side

Item No.	Description	Part Number	Qty Per Assy
6-13	8-BAR, 109" ONLY, DRIVE SIDE (CONT)		
-31	SPACER, Creaser and slitter	1-767-00252	1
-32	BEARING, MRC (213-SZZ)		1
-33	SPACER, Creaser and slitter	1-767-00253	1
-34	GEAR, Creaser and slitter (25T-5P)	2-767-00257	1
-35	KEY	1-947-60162	1
	Socket head cap screw, 5/16-18 x 3/4 long		(1)
-36	PINNED WASHER	2-942-00428-1-0	1
	Hex head cap screw, 5/8-11 x 1-1/2 long		(1)
	L'washer, 5/8		(1)
-37	RETAINING RING, Truarc (5100-196)		1
-38	BEARING, MRC (210-SFF)		1
-39	GEAR, Compound	2-767-00241	1
-40	BEARING, MRC (211-SFF)		1
-41	STUD, Compound gear	2-767-00240	1
-42	BEARING BOX, Lower shaft	2-767-00264	1
-43	BEARING, MRC (213-SZZ)		1
-44	SPACER, Creaser and slitter	1-767-00252	1
-45	BEARING, MRC (213-SZZ)		1
-46	SPACER, Creaser and slitter	1-767-00253	1
-47	KEY	1-947-60162	1
	Socket head cap screw, 5/16-18 x 3/4 long		(1)
-48	GEAR, Creaser and slitter (25T-5P)	2-767-00257	1
-49	PINNED WASHER	2-942-00428-1-0	1
	Hex head cap screw, 5/8-11 x 1-1/2 long		(2)
	L'washer, 5/8		(1)
-50	SUPPORT, Compound gear	3-767-50219	1
-51	PINNED WASHER	2-942-00428-1-0	2
	Hex head cap screw, 5/8-11 x 1-1/2 long		(2)
	L'washer, 5/8		(2)
-52	KEY	1-947-60200	2
	Socket head cap screw, 5/16-18 x 3/4 long		(2)
-53	GEAR, Creaser and slitter (33T-5P)	1-767-00277	2
-54	SPACER, Creaser and slitter	1-767-00253	2
-55	BEARING, MRC (213-SZZ)		2
-56	SPACER, Creaser and slitter	1-767-00252	2
-57	BEARING, MRC (213-SZZ)		2
-58	BEARING BOX, Lower 2-bar station	2-767-00251	2
-59	STUD, Compound gear	2-767-00315	2
-60	BEARING, MRC (211-SFF)		2
-61	GEAR, Compound (33T-5P, 36T-5P)	2-767-00316	2
-62	BEARING, MRC (210-SFF)		2
-63	RETAINING RING, Truarc (5100-196)		2
-64	PINNED WASHER		2
	Pin, crs, 5/32 diameter x 1/2 long		(2)
	L'washer, 3/8		(2)
	Hex head cap screw, 3/8-16 x 1" long		(2)
-65	BEARING, MRC (206-SFFG)		2
-66	GEAR, Idler (22T-5P)	1-HJM-00007	2
-67	BEARING, MRC (206-SFFG)		2
-68	STUD, Idler gear	1-HJM-00010	2
-69	BEARING BOX, Upper shaft	2-767-00255	2
-70	BEARING, MRC (213-SZZ)		2
-71	SPACER, Creaser and slitter	1-767-00252	2
-72	BEARING, MRC (213-SZZ)		2
-73	SPACER, Creaser and slitter	1-767-00253	2
-74	GEAR, Creaser and slitter (33T-5P)	1-767-00277	2
-75	KEY	1-947-60200	2
	Socket head cap screw, 5/16-18 x 3/4 long		(2)

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-13	8-BAR, 109" ONLY, DRIVE SIDE (CONT)		
-76	PINNED WASHER Hex head cap screw, 5/8-11 x 1-1/8 long L'washer, 5/8	2-942-00428-1-0	2 (1) (1)
-77	GUARD, Drive side	4-767-00262	1
-78	POST, Guard	4-767-00319	2
-79	GUARD	1-767-00314	3
-80	PINION	1-HJM-131	6
-81	PINION, Upper shaft	1-HJM-00277	2
-82	TIE BRACE, Swivel frame	2-HJM-00275	2
-83	SEGMENT	1-HJM-50262	2
-84	WASHER Hex head cap screw, 5/8-11 x 1-1/2 long L'washer, 5/8	2-942-00428-0-0	5 (5) (5)
-85	MOUNTING PLATE, Balance shaft	1-767-00175	1
-86	SHAFT, Balancing	1-767-00254	1
-87	MOUNTING PLATE, Balance shaft	1-767-00175	1
-88	SWIVEL FRAME, Drive side	5-767-00242	1

Item No.	Description	Part Number	Qty Per Assy
6-14	HJMD 12-BAR, SWIVEL ASSEMBLY, WITHOUT GANG LOCKING		
-1	WORM, Adjustment	1-HJM-00023	6
-2	STUD, Worm adjustment	1-HJMD-00010	6
-3	BRACKET, Worm adjustment 3/8-16 x 1" long hex. head cap screw 3/8-16 x 4-1/2 long hex. head cap screw 3/8 L'washer 3/8 diameter x 1" long dowel pin	3-HJMD-00006	3 (2) (1) (3) (2)
-4	COLLAR	3-942-00124-3	6
-5	WORM GEAR, Adjustment	1-HJM-00022	6
-6	SPACER, Worm wheel	1-HJM-00059	6
-7	HANDLE	2-HJM-50209	1
-8	KEY	1-946-40150	6
-9	PINION #5 x 2-1/2 long taper pin	1-HJM-00021	6 (1)
-10	TORQUE TUBE, Upper shaft adjustment #7 taper pin x 2-1/2" long 1/4-20 x 1/4 long socket set screw	1-HJM-00017	6 (2) (2)
-11	SEGMENT 1/2-13 x 1" long socket head cap screw 3/8 diameter x 3/4 long dowel pin	1-HJM-00014	6 (2) (1)
-12	SHAFT, Creaser and slitter	2-HJM-00018	6
-13	SHAFT, Creaser and slitter	2-HJM-00018	6
-14	TIE BRACE, Swivel frame	1-HJM-50130	3
-15	See Fig. 6-8, parts 17 through 24	3-HJM-00524	1
-16	SWIVEL FRAME	5-HJMD-00003	1

Item No.	Description	Part Number	Qty Per Assy
6-14	HJMD 12-BAR, SWIVEL ASSEMBLY, WITHOUT GANG LOCKING, (CONT)		
-17	COVER, Operator side swivel frame	HJMD-00005	3
-18	BRACKET, Worm adjustment	3-HJMD-00005	3
-19	COVER, Upper bearing box	CEB-79	6
-20	BEARING, Timken (TD0-484-472-D)	2-930-01049-2	6
-21	WASHER, Bearing retainer	1-CEB-00078	6
	5/8-11 x 1-1/4 long socket head screw		(1)
	3/16 diameter x 5/8 long crs pin		(1)
-22	BEARING BOX, Lower creaser	3-CXF-00111	6
	1/2-13 x 1-1/4 long hex. head cap screw		(4)
	1/2-13 x 3-1/2 long socket head cap screw		(3)
	1/2 L'washer		(4)
	Alemite #1684		(1)
-23	COVER, Upper bearing box	2-CEB-00069	6
	Alemite #1684		(1)
	1/2-13 x 1-1/4 long socket head cap screw		(3)
-24	WASHER, Bearing retainer	1-CEB-00078	6
	5/8-11 x 1-1/4 long socket head screw		(1)
	3/16 diameter x 5/8 long crs pin		(1)
-25	BEARING, Timken (TD0-484-472-D)	2-930-01049-2	6
-26	BEARING BOX, Upper creaser and slitter shaft	2-HJM-00019	6
-27	PINION, Upper shaft adjustment	1-HJM-00016	6
-28	SEGMENT	1-HJM-00014	6
-29	COVER, Swivel frame, drive side	3-HJMD-00017	3
	5/16-18 x 5/8 long hex. head cap screw		(8)
	5/16 L'washer		(8)
	1/4 diameter x 3/4 long dowel		(2)
-30	COVER, Small lubrication access	1-HJMD-00016	3
	#8-32 x 3/8 long flat head socket cap screw		(6)
-31	BEARING BOX, Upper creaser and slitter shaft	2-HJM-00020	3
-32	BEARING, New departure (55513)	1002-213230	3
-33	SPACER, Creaser and slitter gear	1-HJM-00082	3
-34	GEAR, Creaser and slitter (3P-36T)	1-HJM-00006	3
-35	KEY, Creaser and slitter shaft	1-HJM-00083	3
	5/16-18 x 3/4 long socket head cap screw		(12)
-36	WASHER	1-942-00428	3
	5/8-11 x 1-1/2 long hex. head cap screw		(6)
	5/8 L'washer		(6)
-37	WASHER	1-942-00410	3
	3/8-16 x 1" long hex. head cap screw		(3)
	3/8 L'washer		(3)
-38	BEARING, MRC (206-SFFG)	1000-206260	6
-39	GEAR, Idler	1-HJLD-00007	3
-40	SPACER, Idler gear stud	1-HJM-00012	3
-41	BEARING, MRC (206-SFFG)	1000-206260	6
-42	STUD, Idler gear	1-HJLD-00010	3
	5/8-11 x 1-1/4 long hex. head cap screw		(1)
	5/8 L'washer		(1)
-43	BEARING, New departure (55513)	1002-213230	3
-44	SPACER, Creaser and slitter gear	1-HJM-00082	3
-45	GEAR, Creaser and slitter (3P-36T)	1-HJM-00006	3
-46	KEY, Creaser and slitter shaft	1-HJM-00083	3
	5/16-8 x 3/4 long socket head cap screw		(1)
-47	WASHER	1-942-00428	3
	5/8-11 x 1-1/2 long hex. head cap screw		(6)
	5/8 L'washer		(6)
-48	RETAINING RING, Truarc (5100-196)		3

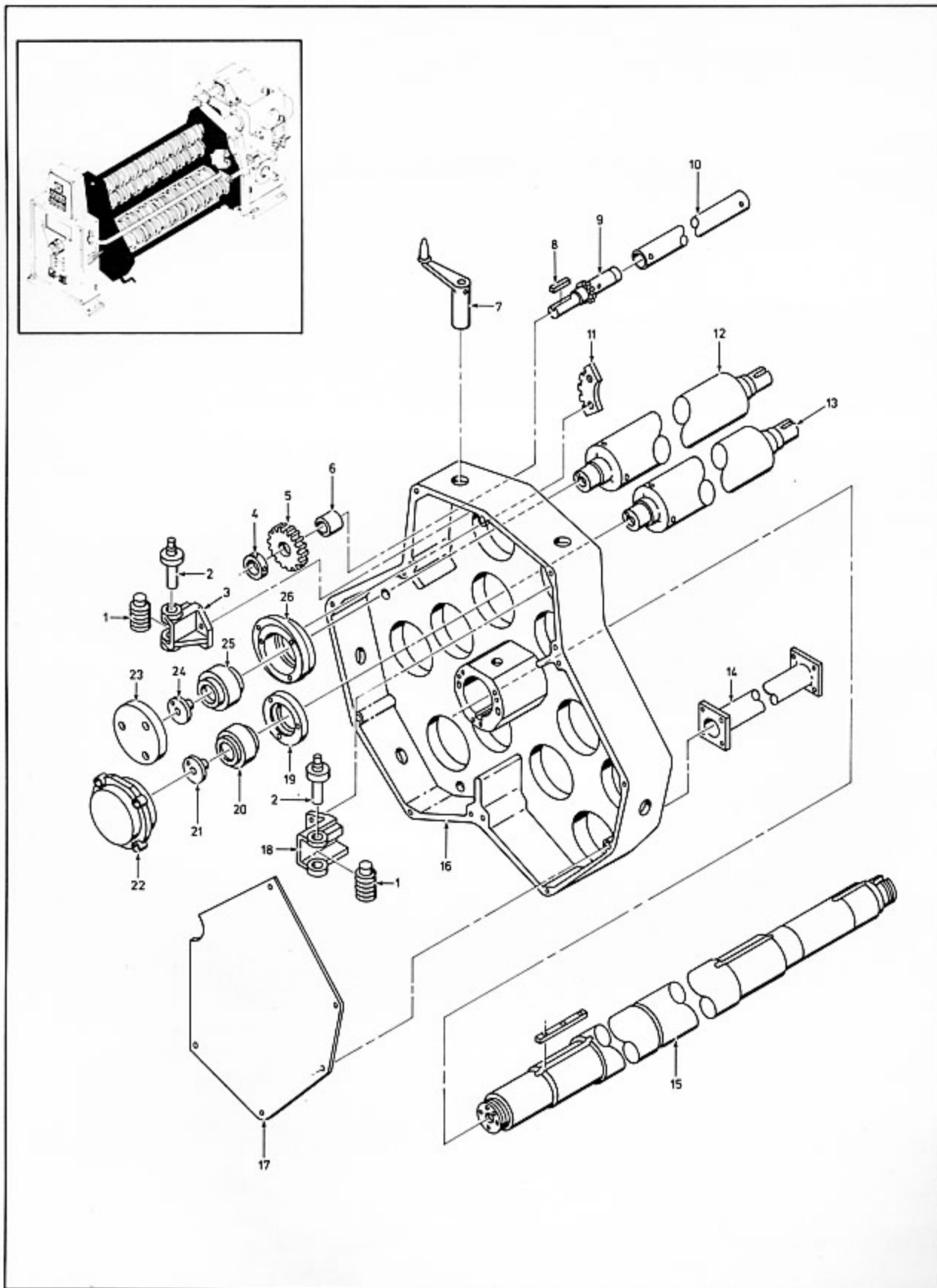


Figure 6-14. HJMD 12-Bar, Swivel Assembly, Without Gang Locking, Operating Side (Sheet 1 of 2)

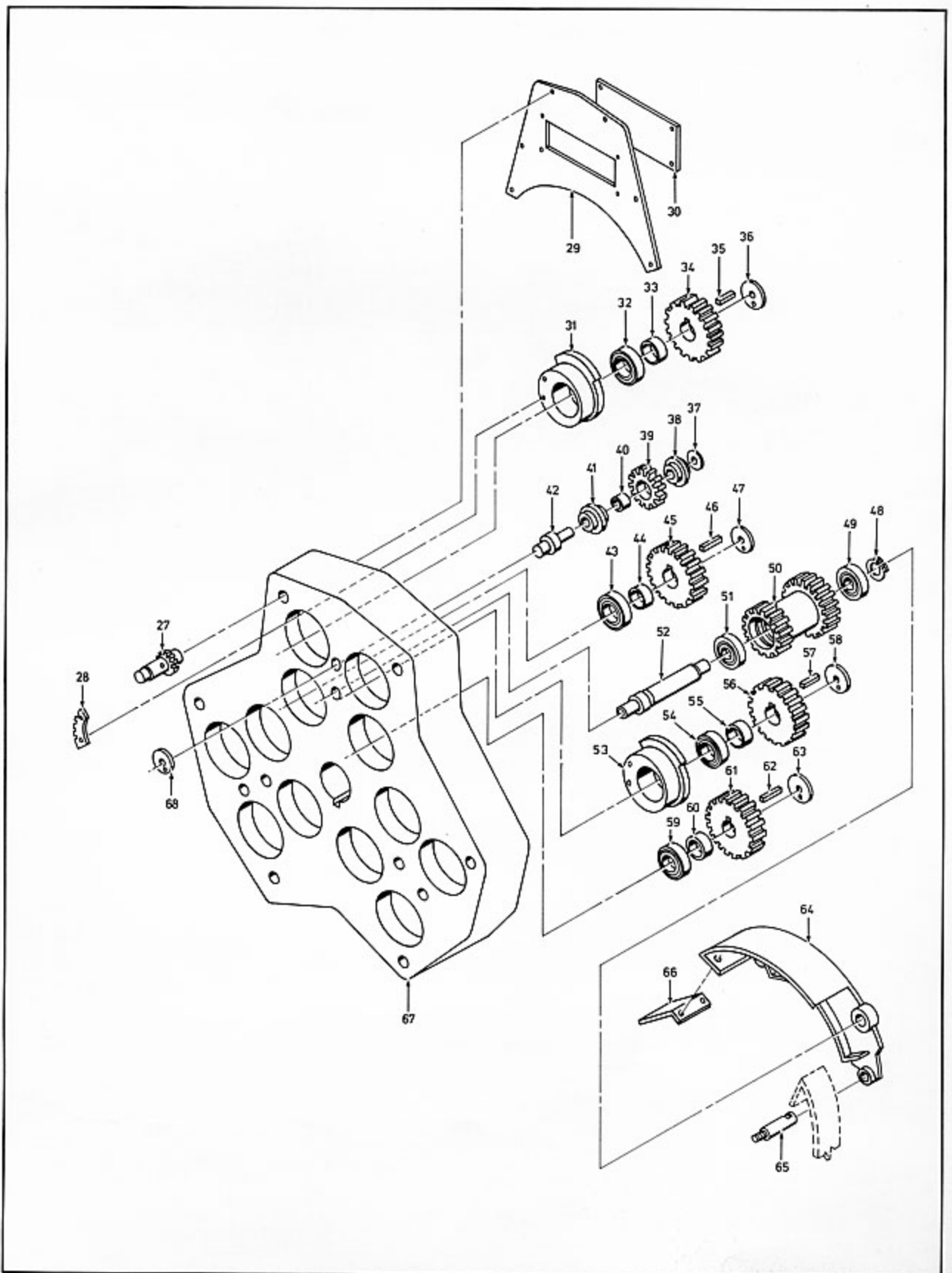


Figure 6-14. HJMD 12-Bar, Swivel Assembly, Without Gang Locking, Drive Side (Sheet 2 of 2)

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-14	HJMD 12-BAR, SWIVEL ASSEMBLY, WITHOUT GANG LOCKING, (CONT)		
-49	BEARING, MRC (210-SFF)	1000-210230	3
-50	GEAR, Compound	2-HJLD-00008	3
-51	BEARING, MRC (211-SFF)	1000-211230	3
-52	STUD, Compound gear	2-HJMD-00009	3
-53	BEARING BOX, Upper creaser and slitter shaft	2-HJM-00020	3
-54	BEARING, New departure (55513)	1002-213230	3
-55	SPACER, Creaser and slitter gear	1-HJM-00082	3
-56	GEAR, Creaser and slitter (3P-32T)	1-HJLD-00001	3
-57	KEY, Creaser and slitter shaft	1-HJM-00083	3
-58	WASHER	1-942-00428	3
-59	BEARING, New departure (55513)	1002-213230	3
-60	SPACER, Creaser and slitter gear	1-HJM-00082	3
-61	GEAR, Creaser and slitter (3P-32T)	1-HJLD-00001	3
-62	KEY, Creaser and slitter shaft	1-HJM-00083	3
-63	WASHER	1-942-00428	3
-64	GUARD, Drive side swivel frame	4-HJM-00005	3
-65	POST, Guard	1-HJM-00011	3
-66	GUARD, Compound gear	1-HJM-00131	3
-67	SWIVEL FRAME, Drive side	5-HJMD-00002	1
-68	WASHER	1-942-00428	3
	5/8-11 x 1-1/2 long hex. head cap screw		(3)
	5/8 L'washer		(3)

Item No.	Description	Part Number	Qty Per Assy
6-15	HJMD 12-BAR, SWIVEL ASSEMBLY, WITH GANG LOCKING		
-1	WORM, Adjustment	1-HJM-00023	3
-2	STUD, Idler gear	1-HJMD-00010	3
-3	BRACKET, Worm adjustment	3-767-00213	3
	3/8-16 x 1" long hex. head cap screw		(2)
	3/8-16 x 4-1/2 long hex. head cap screw		(1)
	3/8 L'washer		(3)
	3/8 diameter x 1" long dowel pin		(2)
-4	COLLAR	1-942-00124-3	6
-5	WORM GEAR, Adjustment	1-HJM-00022	6
-6	SPACER, Worm wheel	1-HJM-50209	1
-7	HANDLE	2-HJM-50209	1
	1/4-20 x 1/4 long socket head set screw		(2)
-8	KEY	1-946-40150	6
-9	PINION	1-HJM-00021	6
	#5 x 2-1/2 long taper pin		(1)
-10	TORQUE TUBE, Upper shaft adjustment	1-HJM-00017	6
	#7 taper pin x 2-1/2" long		(2)
	1/4-20 x 1/4 long socket set screw		(2)



Item No.	Description	Part Number	Qty Per Assy
6-15	HJMD 12-BAR, SWIVEL ASSEMBLY WITH GANG LOCKING, (CONT)		
-11	SEGMENT 1/2-13 x 1" long socket head cap screw 3/8 diameter x 3/4 long dowel pin	1-HJM-00014	6 (2) (1)
-12	See figure 6-19 for detail breakdown		
-13	PINION, Upper shaft	2-HJM-00275	2
-14	TIE BRACE, Swivel frame 1/2-13 x 1-1/4 long hex. head cap screw 3/8 diameter x 3/4 long dowel pin	1-HJM-50130	3 (4) (1)
-15	SWIVEL FRAME Vlier plungers No. S-58 3/8-16th 3/8-16 nuts	5-HJMD-00003	1 (6) (6)
-16	SHAFT	3-HJM-00524	1
-17	KEY		
-18	WORM ADJUSTMENT	1-HJM-00023	3
-19	BRACKET, Worm adjustment	3-767-00168	3
-20	STUD, Idler gear	1-HJMD-00010	
-21	COVER	3-767-00168	3
-22	RETAINER, Bearing	3-767-00229	6
-23	BEARING, Timken (TD0-484-472-D)	2-930-01049-2	6
-24	LOCK WASHER, MRC (W-14)	1012-02014	6
-25	LOCK NUT, MRC (N-14)	1012-01014	6
-26	BEARING BOX 1/2-13 x 1-1/4 long hex head cap screw 1/2 L'washer	3-HJM-00472	6 (4) (4)
-27	COVER, Upper and lower bearing box 1/2-13 x 4 long socket head cap screw 1/2 B&H Hi-collar L'washer 1/2-13 x 1-1/2 long socket head cap screw	2-767-00217	6 (3) (3) (3)
-28	ROTO COUPLING (1/4)		6
-29	BEARING BOX, Upper creaser and slitter shaft	2-767-00230	6
-30	BEARING, Timken (TD0-484-472-D)	2-930-01049-2	6
-31	LOCK WASHER, MRC (W-14)	1012-02014	6
-32	LOCK NUT, MRC (N-14)	1012-01014	6
-33	COVER, Upper and lower bearing box 1/2-13 x 4 long socket head cap screw 1/2 B&H Hi-collar L'washer 1/2-13 x 1-1/2 long socket head cap screw	2-767-00217	6 (3) (3) (3)
-34	ROTO COUPLING (1/4)		6
-35	TOGGLE VALVE, Clippard (MJTV-3)		12
-36	ELBOW, 1/8 pt to 3/8 O.D. tube, 90° male		24
-37	MALE CONNECTOR, 1/8 pt. to 3/8 O.D. tube		15
-38	CROSS, 1/8-NPT		4
-39	NIPPLE, 1/8 x 5" long		1
-40	MALE CONNECTOR, 1/4 pt. to 3/8 O.D. tube		12
-41	UNION TEE, 3/8 x 3/8 x 3/8 (for plastic tube)		3
-42	SAMUAL MOORE, 3/8 O.D. x 0.050 wall thk		26 ft.
-43	"U" BOLT, 1/4-20, Lafayette (18E02024)		2
-44	PINION, Upper shaft adjustment	1-HJM-00016	6
-45	SEGMENT	1-HJM-00014	6
-46	COVER, Swivel frame, drive side 5/16-18 x 5/8 long hex. head cap screw 5/16 L'washer	3-HJMD-00017	3 (8) (8)
-47	COVER, Small lubrication access #8-32 x 3/8 long flat head socket cap screw	1-HJMD-00016	3 (6)
-48	BEARING BOX, Upper creaser and slitter shaft	2-HJM-00020	3
-49	BEARING, New departure (55513)	1002-213230	3

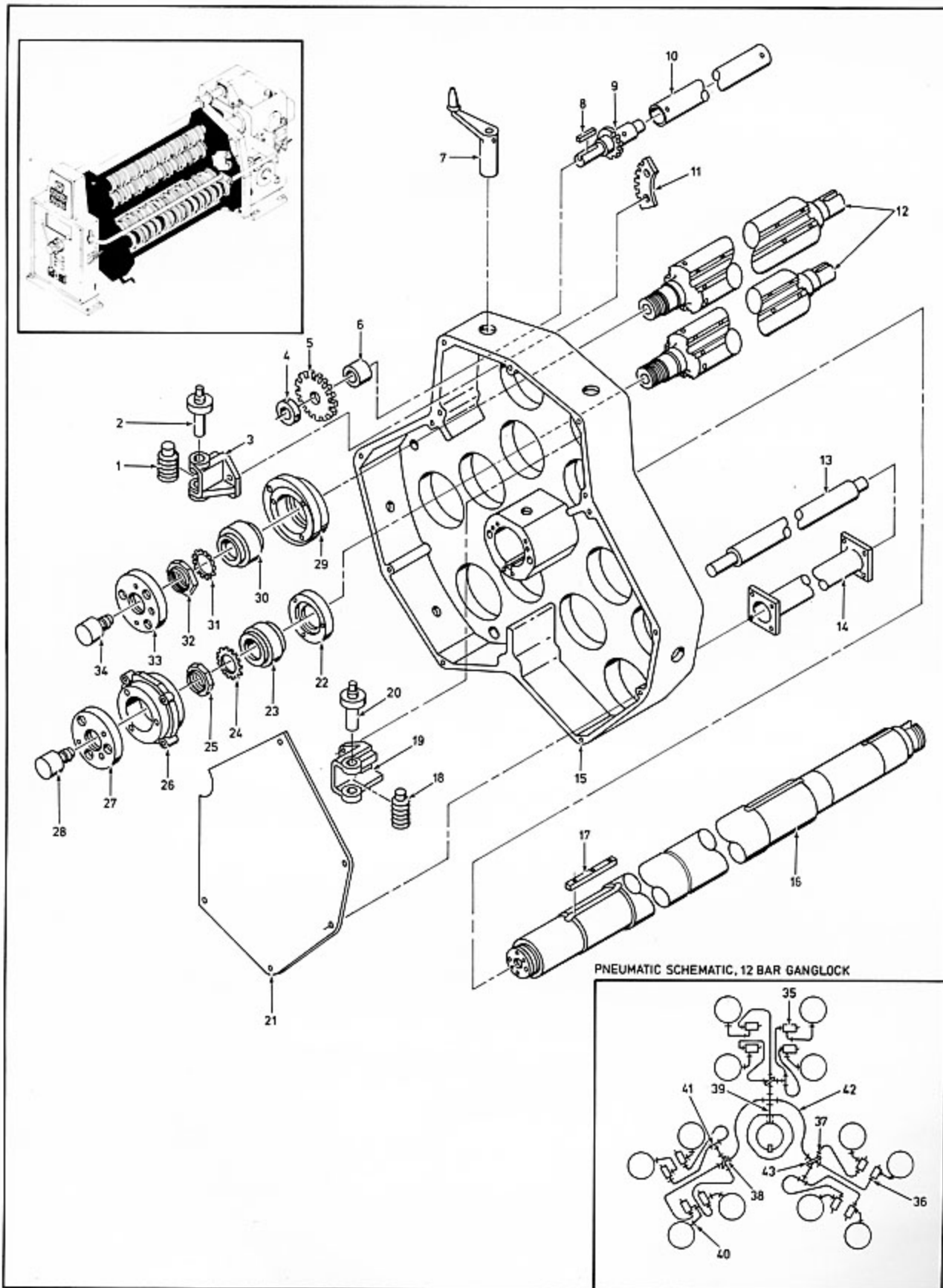


Figure 6-15. HJMD 12-Bar, Swivel Assembly, With Gang Locking, Operating Side (Sheet 1 of 2)

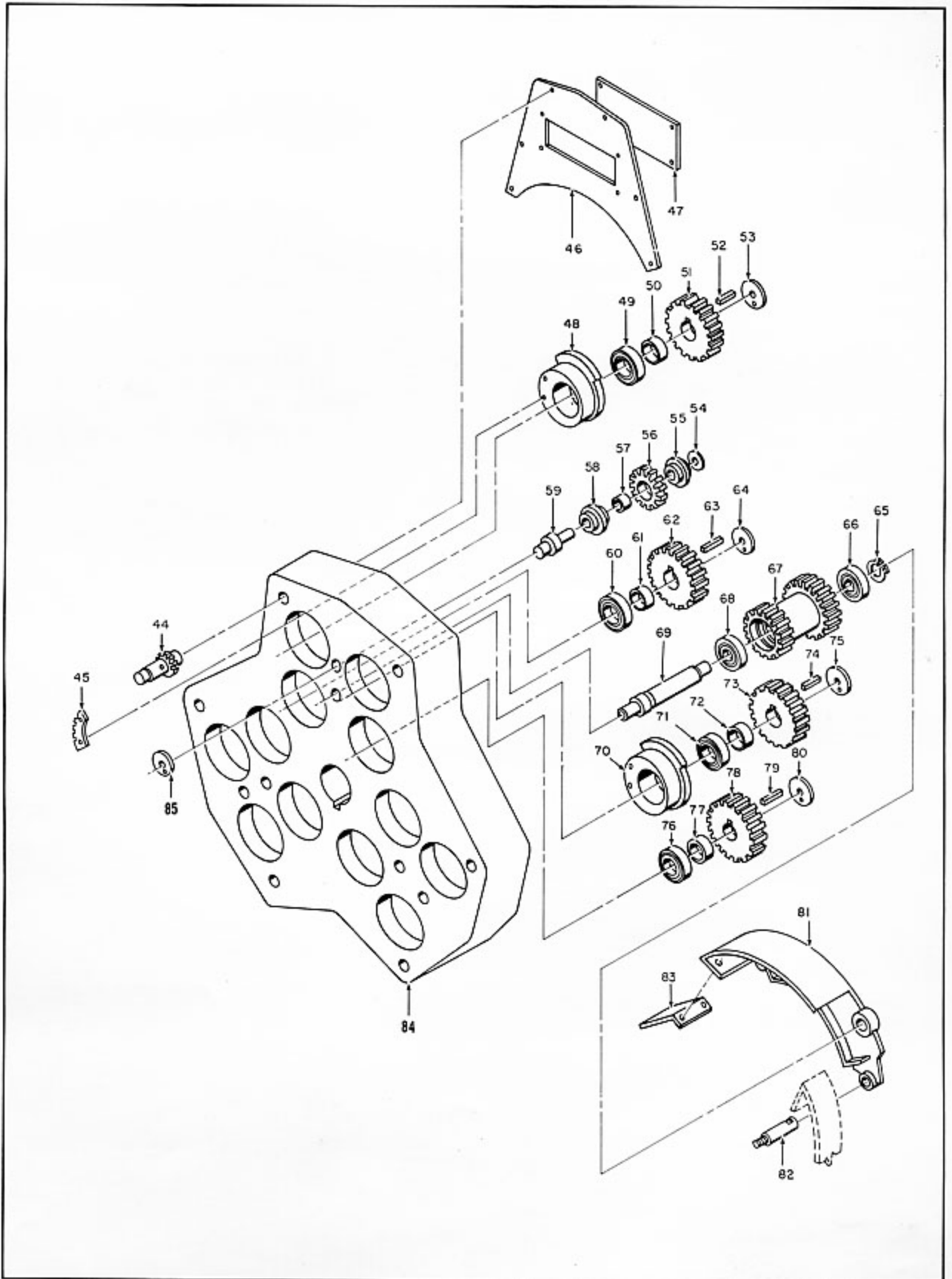


Figure 6-15. HJMD 12-Bar, Swivel Assembly, With Gang Locking, Drive Side (Sheet 2 of 2)

Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-15	HJMD 12-BAR, SWIVEL ASSEMBLY WITH GANG LOCKING, (CONT)		
-50	SPACER, Creaser and slitter gear	1-HJM-00082	3
-51	GEAR, Creaser and slitter (3P-36T)	1-HJM-00006	3
-52	KEY, Creaser and slitter shaft 5/16-8 x 3/4 long socket head cap screw	1-HJM-00083	3 (1)
-53	WASHER 5/8-11 x 1-1/2 long hex. head cap screw 5/8 L'washer	1-942-00428	3 (12) (12)
-54	WASHER 3/8-16 x 1" long hex. head cap screw 3/8 L'washer	1-942-00410	3 (3) (3)
-55	BEARING, MRC (206-SFFG)	1000-206260	6
-56	GEAR, Idler	1-HJLD-00007	3
-57	SPACER, Idler gear stud	1-HJM-00012	3
-58	BEARING, MRC (206-SFFG)	1000-206260	6
-59	STUD, Idler gear 5/8-11 x 1-1/4 long hex. head cap screw 5/8 L'washer	1-HJCD-00010	3 (1) (1)
-60	BEARING, New departure (55513)	1002-213230	3
-61	SPACER, Creaser and slitter gear	1-HJM-00082	3
-62	GEAR, Creaser and slitter (3P-36T)	1-HJM-00006	6
-63	KEY, Creaser and slitter shaft 5/16-8 x 3/4 long socket head cap screw	1-HJM-00083	3
-64	WASHER 5/8-11 x 1-1/2 long hex. head cap screw 5/8 L'washer	1-942-00428	3 (12) (12)
-65	RETAINING RING, Truarc (5100-196)		3
-66	BEARING, MRC (210-SFF)	1000-210230	3
-67	GEAR COMPOUND	2-HJLD-00008	3
-68	BEARING, MRC (211-SFF)	1000-211230	3
-69	STUD, Compound gear	2-HJMD-00009	3
-70	BEARING BOX, Upper creaser and slitter shaft	2-HJM-00020	3
-71	BEARING, Nre departure (55513)	1002-213230	3
-72	SPACER, Creaser and slitter shaft	1-HJM-00082	3
-73	GEAR, Creaser and slitter (3P-32T)	1-HJLD-00001	3
-74	KEY, Creaser and slitter shaft	1-HJM-00083	3
-75	WASHER	1-942-00428	3
-76	BEARING, New Departure (55513)	1002-213230	3
-77	SPACER, Creaser and slitter gear	1-HJM-00082	3
-78	GEAR, Creaser and slitter (3P-32T)	1-HJLD-00001	3
-79	KEY, Creaser and slitter shaft	1-HJM-00083	3
-80	WASHER	1-942-00428	3
-81	GUARD, Drive side swivel frame	4-HJM-00005	3
-82	POST, Guard	1-HJM-00011	3
-83	GUARD, Compound gear	1-HJM-00131	3
-84	SWIVEL FRAME, Drive side	5-HJMD-00002	3
-85	WASHER 5/8-11 x 1-1/2 long hex. head cap screw 5/8 L'washer	1-942-00428	3 (3) (3)

Item No.	Description	Part Number	Qty Per Assy
6-16	DRIVE SIDE STATIONARY UNIT ASSEMBLY, AUTOMATIC		
-1	COVER, Electric drive 3/8-16 x 3/4 long hex. head cap screw 3/8 L'washer	2-HJM-00098	1 (6) (6)
-2	RETAINING RING, Truarc (5100-156)		1
-3	BEARING, New Departure (477208)	1000-208060	1
-4	PULLEY, Electric clutch	Specify Mach. Serial #	1
-5	DODGE DYNA V-BELTS	Specify Mach. Serial # HJM- HJMD 8 & 12 BAR	3 4
-6	BEARING, New Departure (4T7208)	1000-208060	1
-7	CLUTCH, Warner Electric (SF-1000)		1
-8	COVER, Top, main drive frame 3/8-16 x 1" long hex. head cap screw 3/8 L'washer	1-HJM-00053	1 (10) (10)
-9	BREATHER, Lenz, filter (BF-12)		1
-10	PINION, Gear box (25T-4P) (for cw rotation) 1/2-13 x 7/8 long socket set screw	1-HJM-00031	1 (2)
-11	SPACER (for cw rotation)	1-HJM-00064	1
-12	SPACER (for ccw rotation)	1-HJM-00134	1
-13	PINION, Gear box (25T-4P) (for ccw rotation) 1/2-13 x 7/8 long socket set screw	1-HJM-00031	1 (2)
-14	SPACER (for ccw rotation)	1-HJM-00147	1
-15	FRAME, Drive side 5/8-11 x 4" long square head set screw 5/8-11 hex. nut 1/2 pipe plug 1/2 90° elbow 1/4-20 x 3/4 long hex. head cap screw 1/4 plain washer 3/8-16 x 1-1/4 long hex. head cap screw 3/8 L'washer 3/4 knockout plug	5-HJM-00001	1 (4) (4) (1) (1) (2) (2) (4) (4) (1)
-16	SHIM	1-942-02039	1 set
-17	HOUSING, Bearing output shaft 1/2-13 x 1-1/4 long hex. head cap screw 1/2 L'washer	2-HJM-00035	1 (1) (4)
-18	OIL SEAL, C/R (4993)		1
-19	GEAR, Main drive (30T-5P)	1-HJM-00030	1
-20	PINNED WASHER 3/16 diameter x 5/8 long crs pin	2-942-00428-1	1 (1)
-21	GUARD, Main drive gear	2-HJM-50423	1
-22	RETAINING RING, Truarc (5100-315)		4
-23	BEARING, MRC (216-SZZ)	1000-216280	1
-24	RETAINING RING, Truarc (5100-315)		4
-25	HOUSING, Bearing, input shaft 1/2-13 x 1-1/2 long hex. head cap screw 1/2 L'washer 5/8 diameter x 1-1/2 long dowel	3-HJM-00410	1 (6) (6) (2)
-26	COVER, Main frame	1-HJM-00047	1
-27	PIVOT, Idler arm	2-HJM-00574	1
-28	SHAFT, Electric clutch (cw rotation HJM)	3-HJM-00094	1
-28	SHAFT, Electric clutch (ccw rotation, HJM)	3-HJM-00174 ✓	1
-29	KEY	1-946-50262	1
-30	KEY, Electric clutch 1/4-20 x 1/2 long socket head cap screw	1-HJM-00096	1 (2)

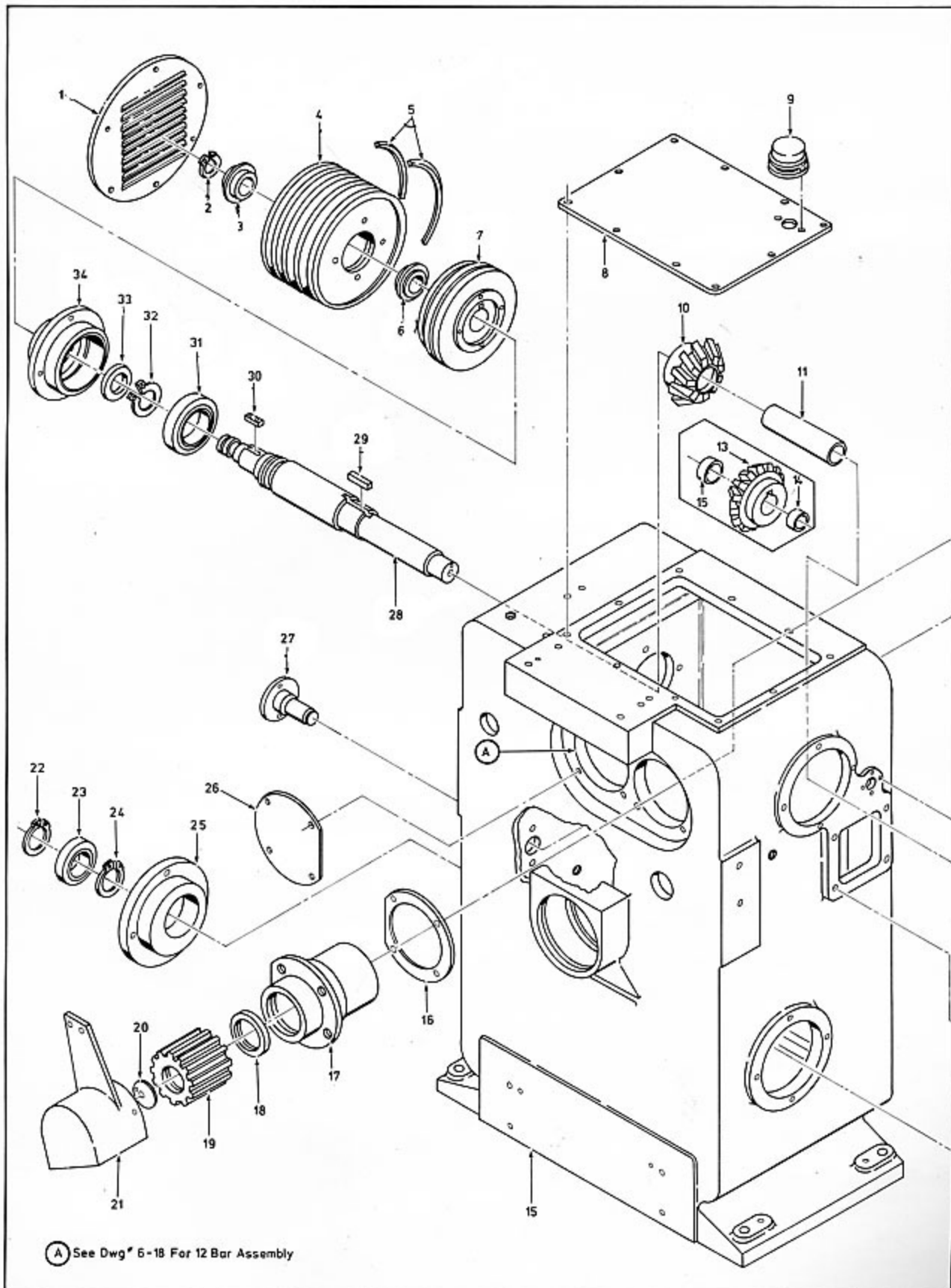


Figure 6-16. Drive Side Stationary Unit Assembly, Automatic (Sheet 1 of 2)

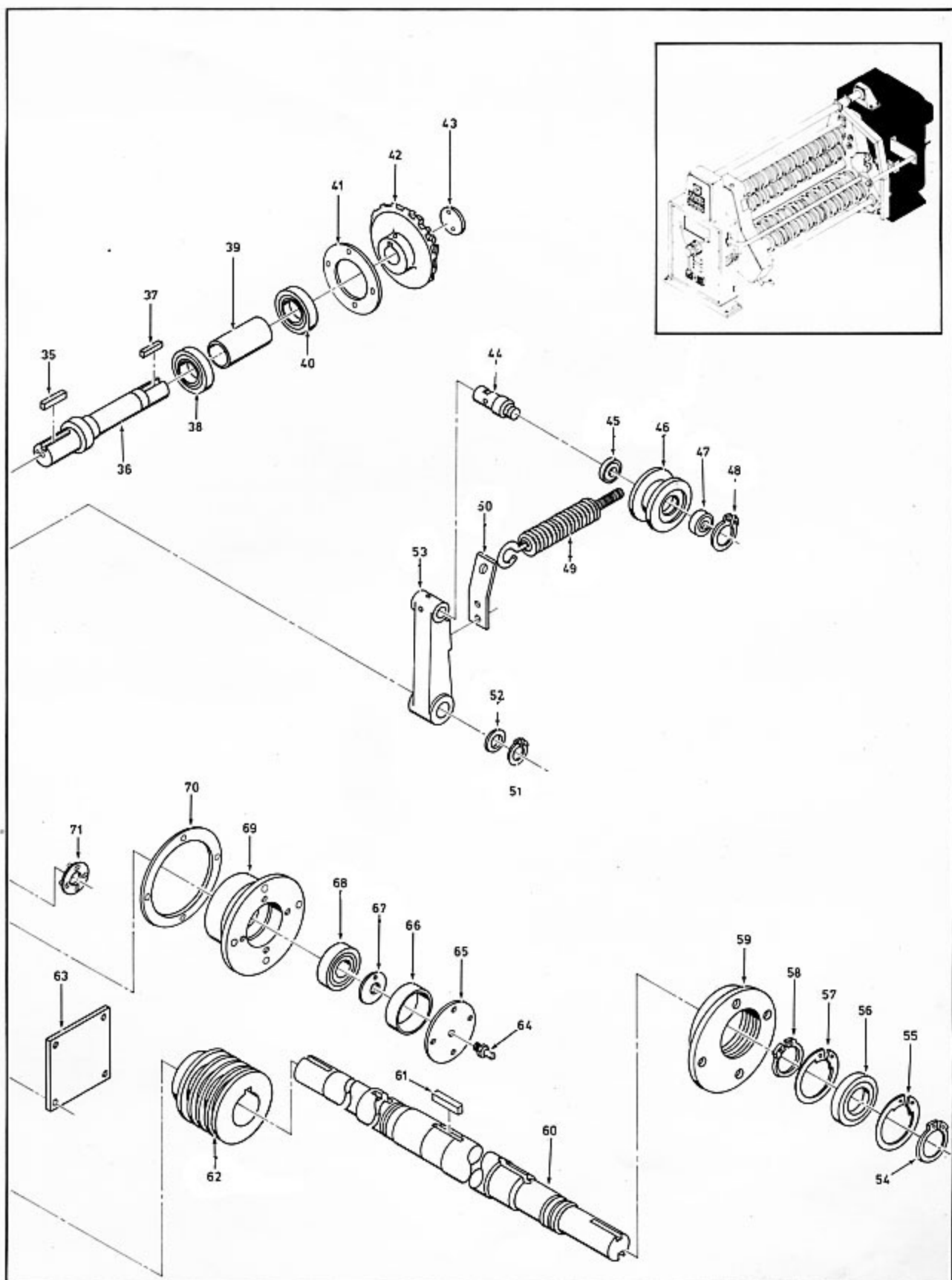


Figure 6-16. Drive Side Stationary Unit Assembly, Automatic (Sheet 2 of 2)



Model 766/767 (HJM/HJMD)  
Triplex Slitter-Scorer

Item No.	Description	Part Number	Qty Per Assy
6-16	DRIVE SIDE STATIONARY UNIT ASSEMBLY, AUTOMATIC (CONT)		
-31	BEARING, MRC (314-M)	1000-314010	1
-32	RING, Truarc (5100-275)		1
-33	OIL SEAL, JM (16047)		1
-34	HOUSING, Bearing, electric clutch shaft 1/2-13 x 1-1/2 long hex. head cap screw 1/2 L'washer	2-HJM-00095	1 (4) (4)
-35	KEY, Output drive shaft 5/16-18 x 3/4 long socket head cap screw	1-HJM-00088	1 (2)
-36	SHAFT, Output drive	2-HJM-00054	1
-37	KEY	1-946-50262	1
-38	BEARING, MRC (5213-KF)	1002-213020	1
-39	SPACER, Output shaft	1-HJM-00062	1
-40	BEARING, MRC (312-M)	1000-312010	1
-41	RETAINER, Output shaft bearing	1-HJM-00071	1
-42	BEVEL GEAR (36T-4P) 1/2-13 x 5/8 long socket set screw	1-HJM-00032	1 (2)
-43	WASHER, Output shaft Drilled hex. head cap screw W&M 16 GA (0.063) spring wire x 5" long	1-HJM-00056 1-942-01350	1 (2) (1)
-44	STUD, Idler pulley	2-HJM-00495 2-HJM-00421	1 1
-45	BEARING, MRC (206-SZZG)	1000-206300	1
-46	PULLEY, Belt take up	Specify Mach. Serial #	1
-47	BEARING, MRC (206-SZZG)	1000-206300	1
-48	RETAINING RING, Truarc (5100-118)		1
-49	SPRING, cw rotation ccw rotation	2-945-00068 2-945-00479	1 1
-50	BRACKET, Spring 1/2-13 x 1-1/4 long hex. head cap screw 1/2 L'washer	1-HJM-00458	1 (2) (2)
-51	RETAINING RING, Truarc (5100-150)		1
-52	WASHER	1-HJM-00205	1
-53	ARM, Idler 1/2-13 x 5/8 long socket set screw 3/8 diameter x 2-1/4 long dowel pin	2-HJM-50444	1 (1) (1)
-54	RETAINING RING, Truarc (5100-315)		1
-55	RETAINING RING, Truarc (5000-550)		1
-56	BEARING, MRC (216-SZZ)	1000-1216H	1
-57	RETAINING RING, Truarc (5000-550)		1
-58	RETAINING RING, Truarc (5100-315)		1
-59	HOUSING, Bearing input shaft 1/2-13 x 1-1/2 long hex. head cap screw 1/2 L'washer 5/8 diameter x 1-1/2 long dowel	3-HJM-00409	1 (6) (6) (2)
-60	SHAFT, Input, with HC double backing with HE double backing	2-HJM-00103 3-HJM-00148	1 1
-61	KEY	1-948-70575	1
-62	PULLEY, Driver	Specify Mach. Serial #	1
-63	COVER, Coupling 1/4-20 x 1/2 long button socket head screw	1-HJM-00232	1 (4)
-64	ALEMITE (1610)		1
-65	COVER, Main frame 3/8-16 x 1" long hex head cap screw 5/8 L'washer	1-HJM-00046	1 (4) (4)
-66	SPACER	1-HJM-00065	1

Item No.	Description	Part Number	Qty Per Assy
6-16	DRIVE SIDE STATIONARY UNIT ASSEMBLY, AUTOMATIC (CONT)		
-67	PINNED WASHER 3/16 diameter x 5/8 long crs pin	2-942-00428-1	1 (1)
-68	5/8-11 x 1-1/2 long hex. head cap screw		(1)
-68	BEARING, MRC (5311-F)	1002-311020	1
-69	HOUSING, Bearing	2-HJM-00048	1
	1/2-13 x 1-1/2 long hex head cap screw		(4)
	1/2 L'washer		(4)
-70	SHIM	1-942-02038	1 set
-71	OIL LEVEL GAUGE	1-ZA-02808	1

Item No.	Description	Part Number	Qty Per Assy
6-17	DRIVE SIDE STATIONARY UNIT ASSEMBLY, FRICTION DRIVE		
-1	COLLAR 3/8-16 x 1/2 long headless setscrew	1-942-00358	1 (1)
-2	SPRING, Friction drive	1-945-00385	1
-3	DISC, Friction drive	2-HJM-00050	1
-4	DISC, Clutch (leather)	1-HJM-00457	1
-5	PULLEY, Friction drive		
-6	DISC, Clutch (leather)	1-HJM-00457	1
-7	DISC, Friction drive	2-HJM-00051	1
-8	COVER, Friction drive spring 3/8-16 x 1" long hex. head cap screw	2-HJM-00066	1 (6)
	3/8 L'washer		(6)
-9	BREATHER CAP, Lenz-filter (BF-12) 1/4-20 x 3/8 long socket head cap screw		1 (2)
-10	COVER, Top, main drive frame 3/8-16 x 1" long hex. head cap screw	1-HJM-00053	1 (10)
	3/8 L'washer		(10)
-11	PINION, Gear box (cw rotation) 1/2-13 x 7/8 long socket set screw	1-HJM-00031	1 2
-12	SPACER (cw rotation)	1-HJM-00064	1
-13	SPACER (ccw rotation)	1-HJM-00134	1
-14	PINION, Gear box (ccw rotation)	1-HJM-00031	1
-15	SPACER (ccw rotation)	1-HJM-00147	1
-16	FRAME, Drive side 3/8-16 x 1-1/4 long hex head cap screw	5-HJM-00001	1 (4)
	3/8 L'washer		(4)
	3/4 knockout plug		(1)
	5/8-11 x 4" long square head set screw		(4)
	5/8-11 hex. nut		(4)
	Alemite fitting #1610		(1)
	1/2 pipe plug		(1)
	1/2 90° elbow		(1)
	1/4-20 x 3/4 long hex. head cap screw		(2)
	1/4 L'washer		(2)
	1/4 plain washer		(2)

Model 766/767 (HJM/HJMD)  
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Item No.	Description	Part Number	Qty Per Assy
6-17	DRIVE SIDE STATIONARY UNIT ASSEMBLY, FRICTION DRIVE (CONT)		
-17	GUARD, Main drive gear 3/8-16 x 3/4 long hex. head cap screw 3/8 L'washer	2-HJM-50423	1 (2) (2)
-18	PINNED WASHER 3/16 diameter x 5/8 long crs pin	2-942-00428-1	1 (1)
-19	GEAR, Main drive (30T-5P)	1-HJM-00030	1
-20	OIL SEAL, C/R (4993)	1042-30004	1
-21	HOUSING, Bearing output shaft	2-HJM-00035	1
-22	SHIM	1-942-02039	1 set
-23	RETAINING RING, Truarc (5100-315)	1237-31600	1
-24	BEARING, MRC (216-SZZ)	1000-216280	1
-25	RETAINING RING, Truarc (5100-315)	1237-31600	1
-26	HOUSING, Bearing, input shaft 1/2-13 x 1-1/2 long hex. head cap screw 1/2 L'washer 5/8 diameter x 1-1/2 long dowel	3-HJM-00410	1 (6) (6) (2)
-27	COVER, Main frame 1/2-13 x 1" long hex. head cap screw 1/2 L'washer	1-HJM-00047	1 (4) (4)
-28	PIVOT, Idler arm	2-HJM-00574	1
-29	SHAFT, Friction drive (ccw) (cw)	3-HJM-00133 3-HJM-00063	1 1
-30	KEY	1-948-50262	1
-31	KEY	1-948-50212	1
-32	KEY	1-949-50212	1
-33	BEARING, MRC (314-M)		1
-34	TRUARC #5100-275		1
-35	HOUSING, Bearing, Friction drive shaft 1/2-13 x 1-1/2 long hex. head cap screw 1/2 L'washer	2-HJM-00049	1 (4) (4)
-36	OIL SEAL, JM (16047)	1042-23807	1
-37	KEY, Output drive shaft 5/16-18 x 3/4 long socket head cap screw	1-HJM-00088	1 (2)
-38	SHAFT, Output drive	2-HJM-00054	1
-39	KEY	1-946-50262	1
-40	BEARING, MRC (5213-KF)	1002-213020	1
-41	SPACER, Output shaft	1-HJM-00062	1
-42	BEARING, MRC (312-M)	1000-312010	1
-43	RETAINER, Output shaft bearing	1-HJM-00071	1
-44	BEVEL GEAR (36T-4P) 1/2-13 x 5/8 long socket set screw	1-HJM-00032	1 (2)
-45	WASHER, Output shaft Drilled hex. head cap screw W&M 16 GA (0.063) spring wire x 5' long	1-HJM-00056 1-942-01350	1 (2) (1)
-46	STUD, Idler pulley	2-HJM-00495	1
-47	BEARING, MRC (206-SZZG)		1
-48	PULLEY, Idler	1-HJM-00494	1
-49	BEARING, MRC (206-SZZG)		1
-50	RETAINING RING, Truarc (5100-118)		1
-51	SPRING (cw) (ccw)	2-945-00068 2-945-00479	1 1
-52	BRACKET, Spring 1/2-13 x 1-1/4 long hex. head cap screw 1/2 L'washer	1-HJM-00458	1 (2) (2)
-53	RETAINING RING, Truarc (5100-150)		1
-54	WASHER	1-HJM-00205	1

Item No.	Description	Part Number	Qty Per Assy
6-17	DRIVE SIDE STATIONARY UNIT ASSEMBLY, FRICTION DRIVE (CONT)		
-55	ARM, Idler 1/2-13 x 5/8 long socket set screw 3/8 diameter x 2-1/4 long dowel pin	2-HJM-50444	1 (1) (1)
-56	RETAINING RING, Truarc (5100-315)		1
-57	RETAINING RING, Truarc (5000-550)		1
-58	BEARING, MRC (216-SZZ)		1
-59	RETAINING RING, Truarc (5000-550)		1
-60	RETAINING RING, Truarc (5100-315)		1
-61	HOUSING, Bearing, Input shaft 1/2-13 x 1-1/2 long hex. head cap screw 1/2 L'washer 5/8 diameter x 1-1/2 long dowell	3-HJM-00409	1 (6) (6) (2)
-62	SHAFT, Input	3-HJM-00148	1
-63	KEY	1-948-70575	1
-64	PULLEY, Driver	Specify Mach. Serial #	1
-65	COVER, Coupling 1/4-20 x 1/2 long button socket head screw	1-HJM-00232	1 (4)
-66	COVER, Main frame 3/8-16 x 1" long hex. head cap screw 3/8 L'washer Alemite #1610, B1	1-HJM-00046	1 (4) (4) (1)
-67	SPACER	1-HJM-00065	1
-68	PINNED WASHER 3/16 diameter x 5/8 long crs pin 5/8-11 x 1-1/2 long hex. head cap screw	2-942-00428-1	1 (2) (1)
-69	BEARING, MRC (5311-F)		1
-70	HOUSING, Bearing	2-HJM-00048	1
-71	SHIM	1-942-02038	1 set
-72	OIL LEVEL GAUGE	1-ZA-02808	1

Item No.	Description	Part Number	Qty Per Assy
6-18	DRIVE SIDE STATIONARY UNIT ASSEMBLY, 12-BAR ONLY		
-1	GUARD, Main drive gear 3/8-16 x 3/4 long hex. head cap screw 3/8 L'washer	2-767-50200	1 (2) (2)
-2	PINNED WASHER 3/16 diameter x 5/8 long crs pin	2-942-00428-1	1 (1)
-3	GEAR, Main drive (25T-5P)	1-765-00030	1
-4	OIL SEAL, C/R (4993)		1
-5	HOUSING, Bearing output shaft	2-HJM-00035	1
-6	SHIM	1-942-02039	1 set
-7			
-8	COVER, Main frame 1/2-13 x 1" long hex. head cap screw 1/2 L'washer	1-HJM-00047	1 (4) (4)

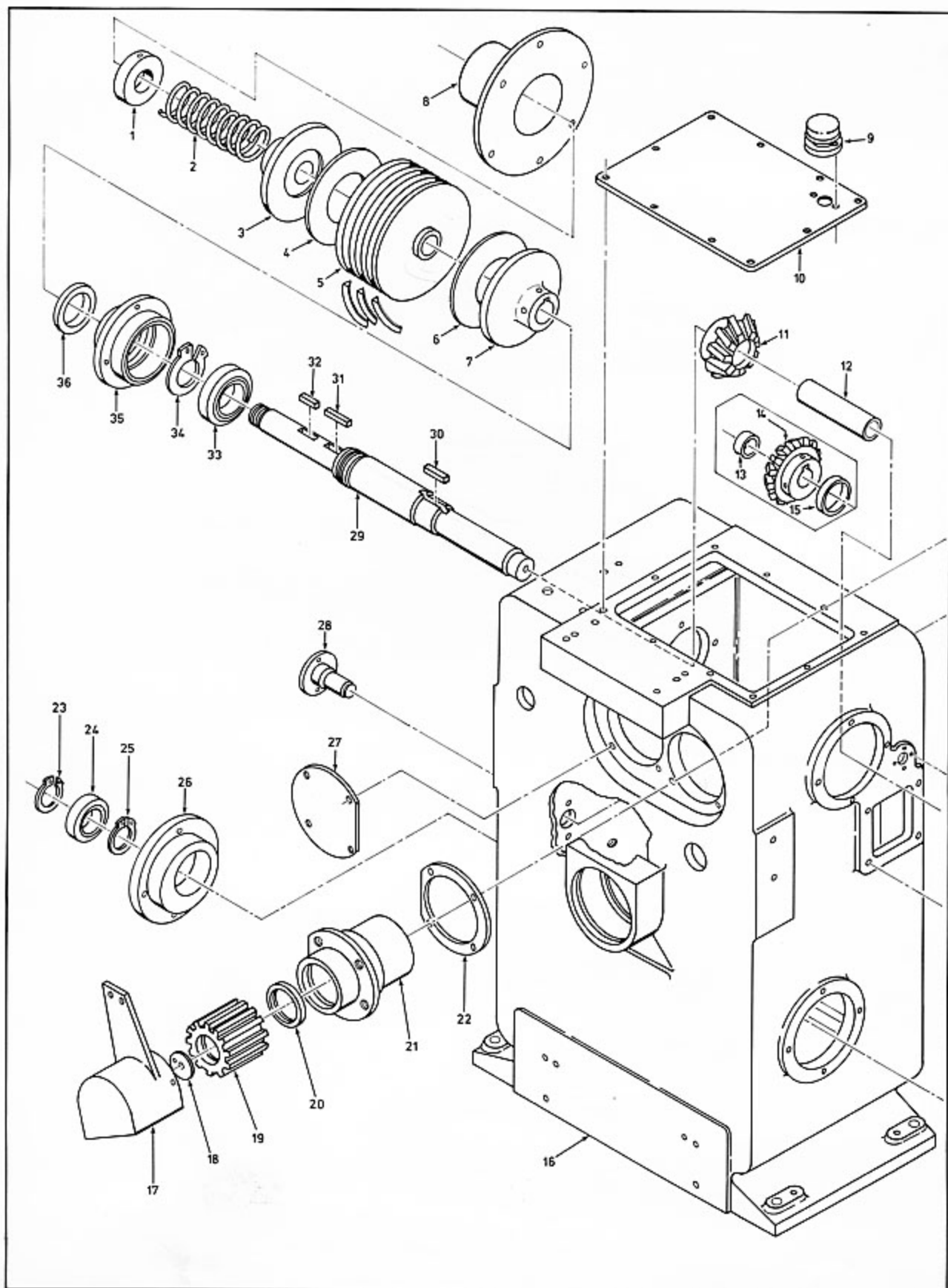


Figure 6-17. Drive Side Stationary Unit Assembly, Friction Drive (Sheet 1 of 2)

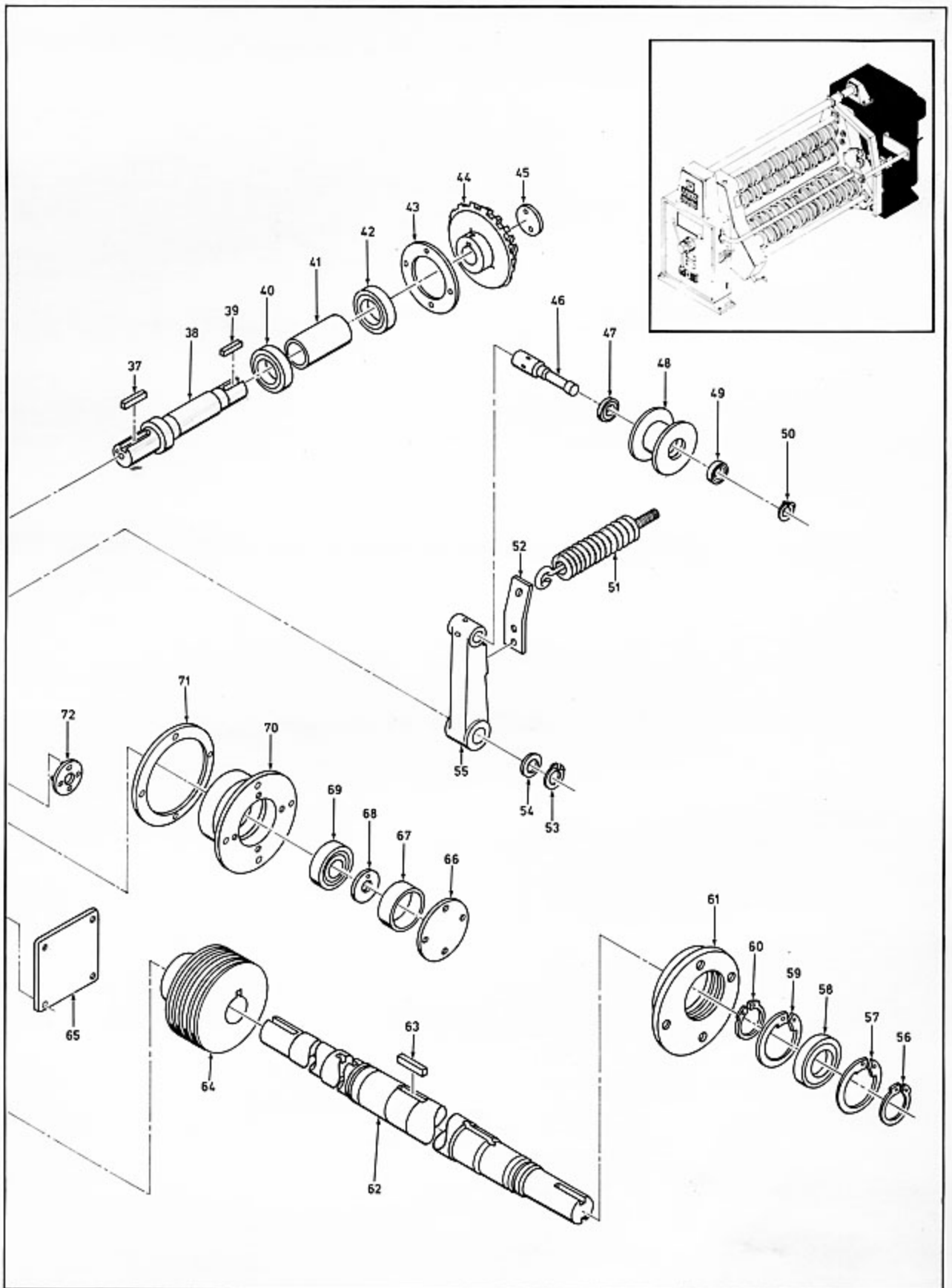


Figure 6-17. Drive Side Stationary Unit Assembly, Friction Drive (Sheet 2 of 2)

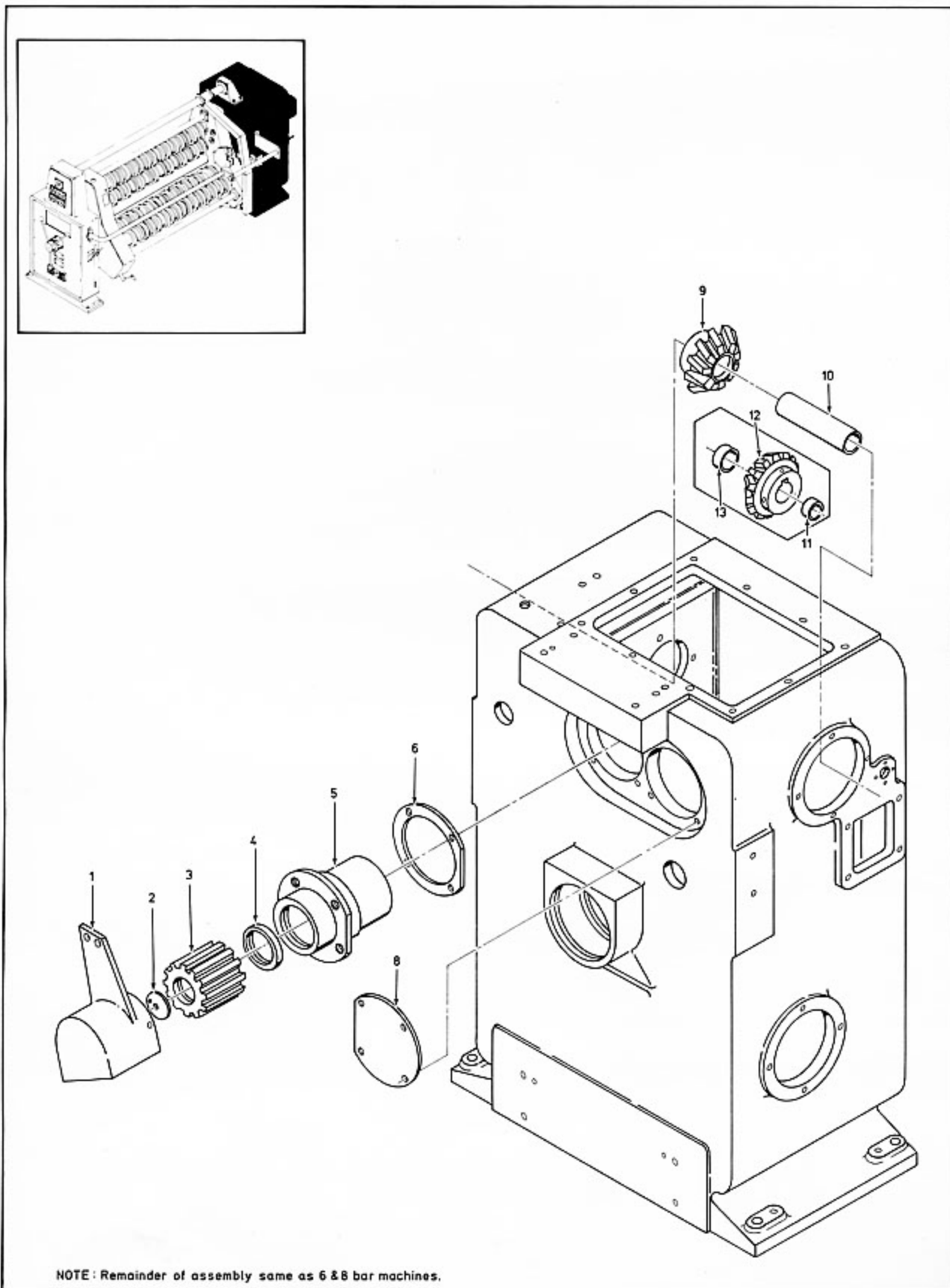


Figure 6-18. Drive Side Stationary Unit Assembly, 12-Bar Only



Item No.	Description	Part Number	Qty Per Assy
6-18	DRIVESIDE STATIONARY UNIT ASSEMBLY, 12-BAR ONLY (CONT)		
-9	PINION, Gear box (25T-4P) 1/2-13 x 7/8 long socket set screw	1-HJM-00031	1 (2)
-10	SPACER (for cw rotation)	1-765-00004	1
-11	SPACER (for ccw rotation)	1-767-00014	1
-12	PINION, Gear box (for ccw rotation)	1-HJM-00031	1
-13	SPACER, Bevel gear (for ccw rotation)	1-HJM-00147	1
-14	SHAFT, Friction drive (cw) (ccw)	3-765-00056 3-767-00013	1 1

Item No.	Description	Part Number	Qty Per Assy
6-19	SHAFT ASSEMBLY, AIR HOSE GANG LOCKING, ALL MACHINES		
-1	GIB, Key 1/4 L'washer 1/4-20 x 5/8 long pan head machine screw	2-HJM-00567	2 (A/R) (A/R)
-2	SPRING, Key	2-HJM-00559	2
-3	KEY	2-HJM-50437	1
-4	SPACER - 1/4-20 x 1-3/4 long socket head cap screw	1-HJM-00569	2 (4)
-5	HOSE ASSEMBLY	2-HJM-50440	1
-6	SHIM, Air hose	1-942-02225	A/R
-7	O'RING, 3/8 O. D. x 1/4 I. D.		1
-8	SHAFT, Air hose For HJM 87" and 97" For HJMD 87" and 97" For HJMD 8-Bar 87" and 97" For HJMD 8-bar, 109"  For HJM 109"	4-HJM-00568 4-HJM-00568 4-HJM-00568 4-HJM-00575 4-767-00317 4-767-00318 4-767-00317	6 12 6 2 4 4 6

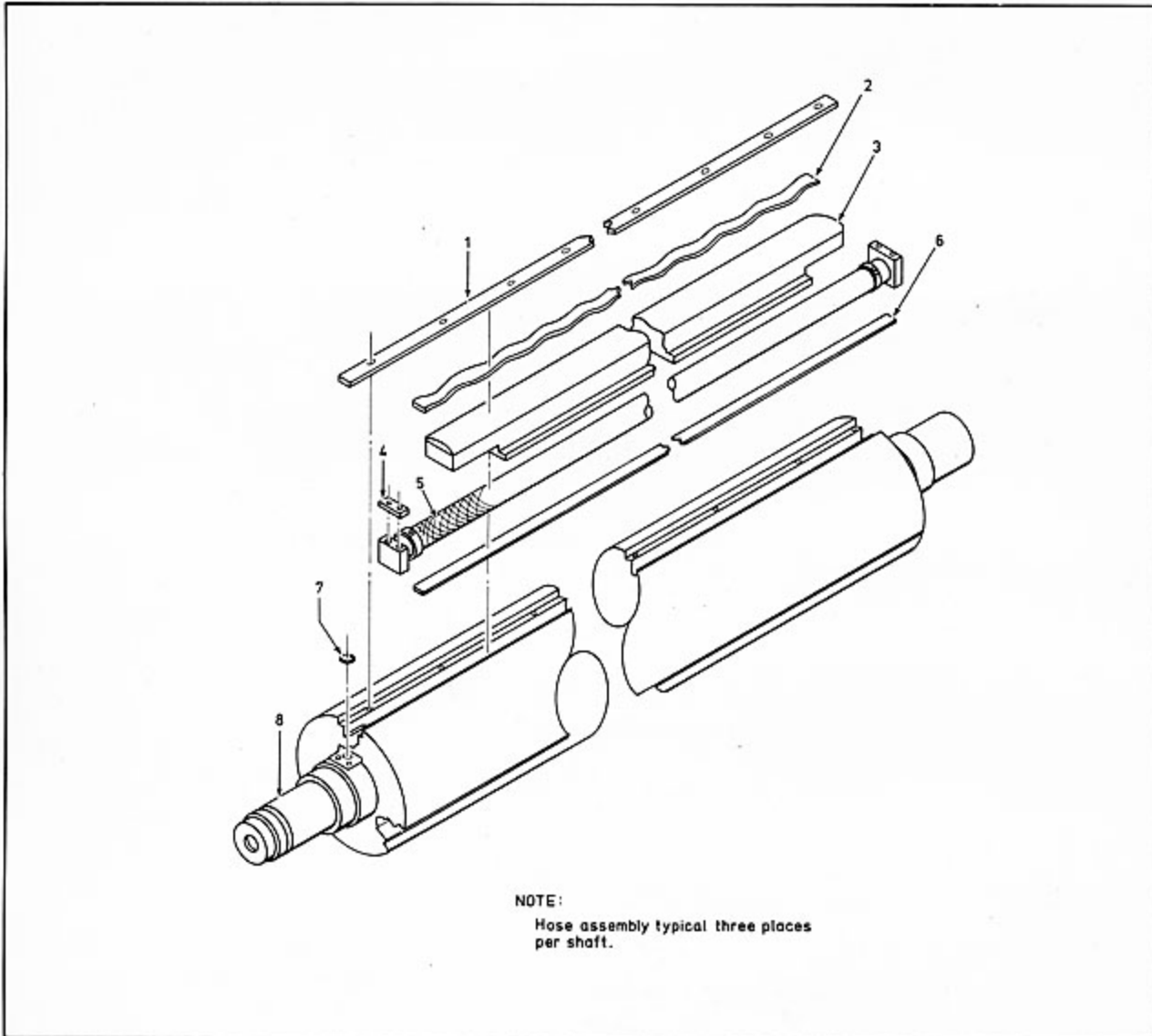


Figure 6-19. Shaft Assembly, Air Hose Gang Locking, All Machines