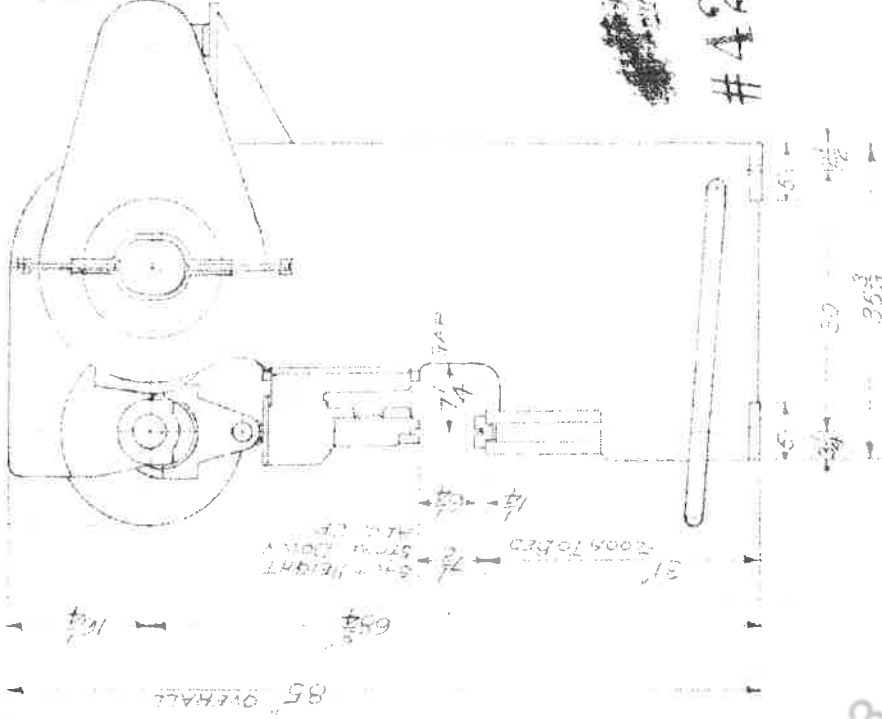
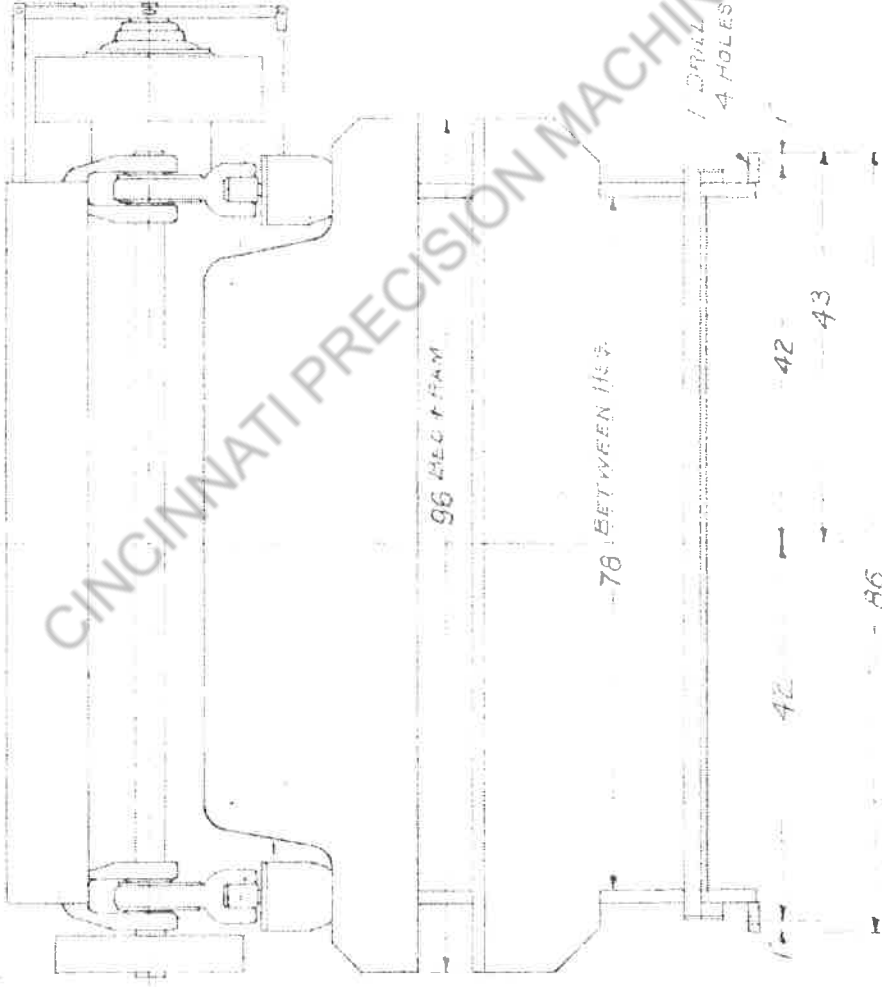


M-  
DRAWING

50 61 50 61



#42

210 COPY

SE. 9

TOWNAGE 45 TONS  
 STROKE OF FRAME 2 1/2'  
 STROKES PER MIN. 40  
 ADJUSTMENT OF FRAME 3"  
 DRIVE MOTOR 3 H.P. 1500 R.P.M.

DRAWING NO. 2776

M-1-A

REVISED

TRADE MARK

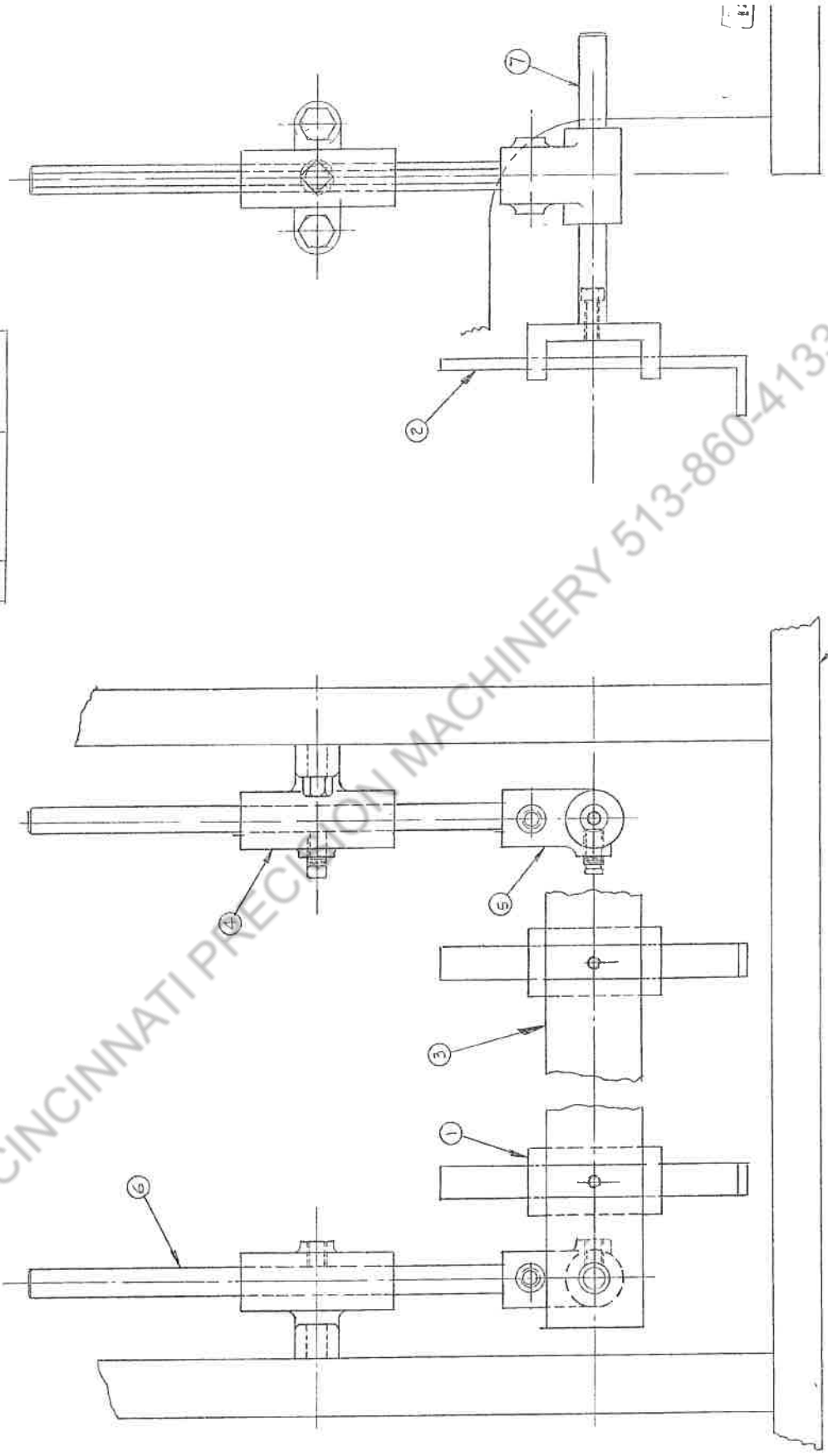
**Version**  
**VERSON ALL-STEEL PRESS CO.**  
 CHICAGO, ILL.

MACHINE #2078 JIF PRESS BRAKE

PART GENERAL ASSEMBLY

TOLERANCE ± .010" FOR ALL MACHINE DIMENSIONS UNLESS OTHERWISE SPECIFIED. INK TO DIMENSIONS. DO NOT SCALE DRAWINGS

PART NO	PART	DWG NO
1	GAGE HOLDER	174-3091-0
2	" FINGER BAR	" " " " " "
3	" " BAR	" " " " " "
4	" HOLDER	1400-3093-0
5	" FINGER	" " " " " "
6	HOLDE BAR	" " " " " "
7	GAGE LOCK BAR	" " " " " "



REPLACES WOOD DWG # 2449-3090

ASSEMBLY NO	4601	DRAWING NO	17400 - 3090	REV NO	
DATE	11-20-63	SCALE	1/2" = 1"	DRAWN BY	PEL
CHECKED BY	PEL	DATE	11-20-63	DESIGNED BY	PEL
TRADE NAME <b>VERSON</b>		COMPANY <b>VERSON ALL-STEEL PRESS CO</b> CHICAGO, ILL.		MACHINE C-10 & C-20 JR PR BR	
PART GAGE		CHECKED BY PEL			

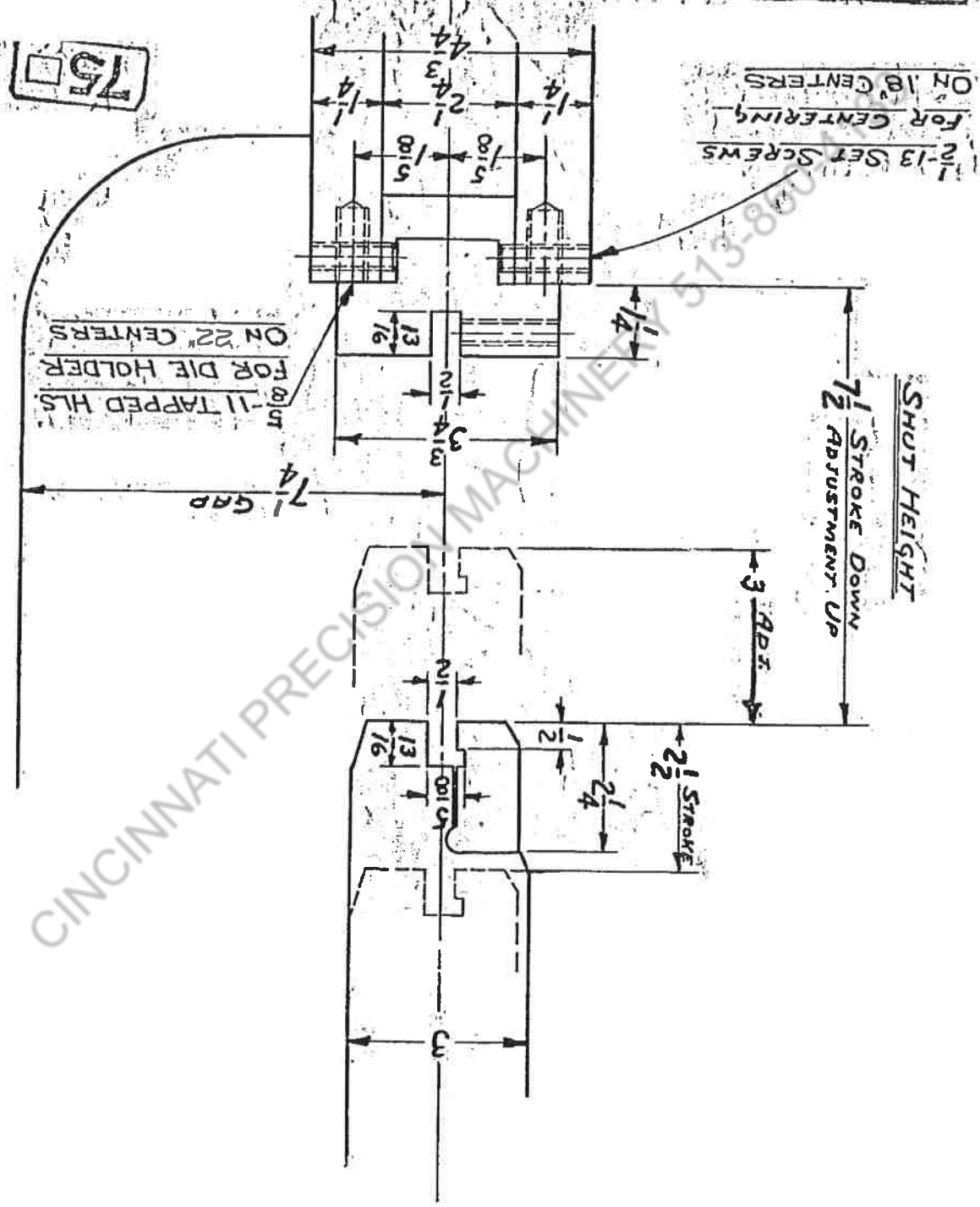
CINCINNATI PRECISION MACHINERY 513-860-4133

ASSEMBLY NO. 80  
 DRAWING NO. 2373-1005

DRAWING NO. 2373  
 REVISED 7-5

**VERSON** TRADE MARK  
 VERSON ALLSTEEL PRESS CO.  
 CHICAGO, ILL.  
 MACHINE 20 SERIES PRESS BRAKE  
 PART DIE SPACE

DATE 8-5-60  
 SCALE 3/8" = 1"  
 DR. O.L.  
 CH.



WORK TO DIMENSIONS, DO NOT SCALE DRAWINGS.  
 REPORT ANY ERRORS OR INCONSISTENCIES TO ENGINEERING DEPT.

CINCINNATI PRECISION MACHINERY 513-800-1000

151-SW  
"N" stamped

S.C.	
L.D.	
DR.	
DR.	
MILL	
SD.	
SLOT	
KEY	
GR.	
F.C.	
T.W.	
A.W.	
PLN.	
HOR. MILL	
T.C.	
LINE	
ANV.	
HORN	
ROLL	
HEAT TREAT	

Index No.	Name of Part
JB-5	Str. Key
JB-6	Elev. Shaft Coupling
JB-7	Cotter Pin
JB-8	Sq. Hd. Set Scr.
JB-9	Elev. Crank Handle
JB-10	Elev. Shaft Collar
JB-11	Soc. Set Scr.
JB-12	Reducer Coupling
JB-13	Sq. Hd. Set Scr.
JB-14	Pitman
JB-15	Pitman Cap
JB-16	Hex. Hd. Cap Scr.
JB-17	Alem. Hyd. Fitting
JB-18	Adj. Scr.
JB-19	Soc. Set Scr.
JB-20	Wrist Pin Bush.
JB-21	Pitman Bushing
JB-22	Fl. Hd. Brass Scr.
JB-23	Bs. Dowel Pin
JB-24	Wrist Pin
JB-25	Alem. Hyd. Fitt.
JB-26	Adj. Nut
JB-27	Worm Gear
JB-28	Worm
JB-29	Ram Gib R. H.
JB-30	Ram Gib L. H.
JB-31	Sq. Hd. Set Scr.
JB-32	Soc. Set Scr.
JB-33	Jam Nut
JB-34	Ram Gib Cover Plate
JB-35	Alem. Hyd. Fitt.
JB-36	Rnd. Hd. Cap Scr.
JB-37	Gib Plate-Inner
JB-38	Gib Plate-Outer
JB-39	Hex. Hd. Cap Scr.
JB-40	Cut Washer
JB-41	Elev. Flange Bracket
JB-42	Hex. Hd. Cap Scr.
JB-43	Pitman Shim
JB-44	Main Bearing
JB-45	Alem. Hyd. Fitt.
JB-46	Main Brg. & Drive Hsg.
JB-47	Pipe Plug
JB-48	Main Brg. Cap

Index No.	Name of Part
JB-49	Hex. Hd. Cap Scr.
JB-50	Main Brg. Bush.
JB-51	Fl. Hd. Brass Scr.
JB-52	Drive Hsg. Cover
JB-53	Hex. Hd. Cap Scr.
JB-54	Pipe Plug
JB-55	Drive Hsg. End Plate
JB-56	Vellum Gasket
JB-57	Hex. Hd. Cap Scr.
JB-58	Body Gib - R. H.
JB-59	Body Gib - L. H.
JB-60	Hex. Hd. Cap Scr.
JB-61	Motor Support
JB-62	Hex. Hd. Cap Scr.
JB-63	Std. Hex. Nut
JB-64	Std. Washer
JB-65	Main Brg. Shim
JB-66	Eccentric
JB-67	Bull Gear
JB-68	Bull Gear Guard
JB-69	Int. Shaft Bush. - L. H.
JB-70	Int. Shaft Bush. - R. H.
JB-71	Bull Pinion
JB-72	Interm. Gear
JB-73	Clutch Shaft
JB-74	Gib Key
JB-75	Feather Key
JB-76	Flywheel
JB-77	Clutch Driving Ring
JB-78	Twin Disc Clutch
JB-79	Alem. Hyd. Fitt.
JB-80	Hex. Hd. Cap Scr.
JB-81	Bell Brg.
JB-82	Snap Ring
JB-83	Short Pipe Nipple
JB-84	Pipe Coupling
JB-85	Soc. Hd. Cap Scr.
JB-86	Flywheel Guard
JB-87	Brake Drum
JB-88	Roller Brg. Hsg.
JB-89	Hex. Hd. Cap Scr.
JB-90	Alem. Hyd. Fitt.
JB-91	Oil Seal
JB-92	Roller Brg.
JB-93	Seal Retainer

Index No.	Name of Part
JB-94	Snap Ring
JB-95	Ball Brg. Hsg.
JB-96	Snap Ring
JB-97	Hex. Hd. Cap Scr.
JB-98	Ball Brg.
JB-99	Inter. Pinion
JB-100	Gib Key
JB-101	Foot Treadle
JB-102	Treadle Spring
JB-103	Anchor Bolt
JB-104	Std. Hex. Nut
JB-105	Spring Anchor
JB-106	Bell Crank
JB-107	Treadle Shaft Lever
JB-108	Soc. Set Scr.
JB-109	Treadle Reach Rod
JB-110	Foot Treadle Hings
JB-111	Treadle Shaft Supp.
JB-112	Hex. Hd. Cap Scr.
JB-113	Upper Treadle Rod
JB-114	Lower Treadle Rod
JB-115	Turbuokle
JB-116	Jam Nut
JB-117	Clutch Reach Rod
JB-118	Shifting Lever Yoke
JB-119	Shifting Bar
JB-120	Hex. Hd. Cap Scr.
JB-121	Hex. Nut
JB-122	Clutch Shifter Supp.
JB-123	Std. Hex. Nut
JB-124	Brake End Swivel
JB-125	Brake Lever
JB-126	Hex. Hd. Cap Scr.
JB-127	Lever Bracket
JB-128	Hex. Hd. Cap Scr.
JB-129	Sq. Hd. Set Scr.
JB-130	Brake End Supp.
JB-131	Brake End
JB-132	Semi Fin. Hex. Nut
JB-133	Brake Band
JB-134	Brake Lining
JB-135	Brake Band End
JB-136	Brake End Swivel Rod
JB-137	Hex. Nut
JB-138	Std. Washer
JB-139	Spring

Index No.	Name of Part
JB-140	Lever Bracket Pin
JB-141	Cotter Pin
JB-142	Brake Lever Pin
JB-143	Cotter Pin
JB-144	Brake Lever Pin
JB-145	Cotter Pin
JB-146	Brake Band Pin
JB-147	Clutch Shifter Sup. Pin
JB-148	Drive Motor
JB-149	Motor Sheave
JB-150	V-Belt
JB-151	Alem. Hyd. Gun
JB-152	Soc. Scr. Wrench
JB-153	Motor Starter
JB-154	Motorized Speed Reducer
JB-155	Reversing Switch
JB-156	Manzel Lubricator
JB-157	Cap Scr. Wrench
JB-158	Ram
JB-159	Soc. Hd. Cap Scr.
JB-160	L. H. Elev. Shaft
JB-161	Str. Key
JB-162	Bushing
JB-163	Ecc. Shaft
JB-164	Str. Key
JB-165	Gib Key
JB-166	Interm. Shaft
JB-167	Gib Key
JB-168	Foot Treadle Shaft
JB-169	Str. Key
JB-170	Ram Clamp
JB-171	Ram Nut
JB-172	Ram Clamp Spring
JB-173	Die Holder
JB-174	Hex. Hd. Cap Scr.
JB-175	Bevel Washer
JB-176	Soc. Set Scr.
JB-177	Die Holder Tongue
JB-178	Soc. Hd. Cap Scr.
JB-179	Hand Bar Supp.
JB-180	Soc. Set Scr.
JB-181	Hex. Hd. Cap Scr.
JB-182	Hand Bar

**VERSON** TRADE MARK  
**VERSON ALLSTEEL PRESS CO.**  
CHICAGO, ILL.

MACHINE C-10, C-20, & C-200  
SERIES PRESS BRAKES

PART REPAIR PARTS LIST

Drawing No. **MS-151** DATE **4-29-53**

REVISED **A** 1-18-53

SCALE **C**

DR. **CZ**

CH

UNLESS OTHERWISE SPECIFIED  
TOLERANCE FOR ALL FINISHED  
DIMENSIONS ± .005.  
TOLERANCE FOR UNFINISHED  
DIMENSIONS ± .1/8.  
WORK TO DIMENSIONS, DO NOT SCALE DRAWINGS.

RETYPED FR. MS-151, DATED 9-5-40



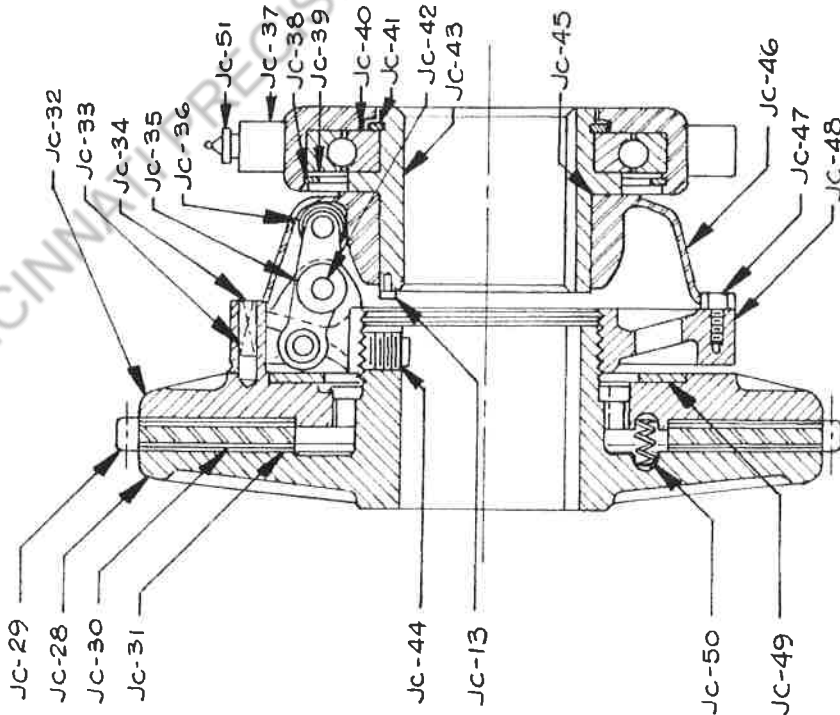
DIMENSIONS - TOLERANCES UNLESS OTHERWISE SPECIFIED  
 FINISHED - FRACTIONAL ± 1/64 DECIMAL ± .005  
 UNFINISHED - WELDS ± 1/8

REPAIR PARTS LIST FOR SINGLE PLATE MODEL 'CL' CLUTCH

**TO ADJUST CLUTCH!**  
 FULL ADJUSTING PIN "A" OUT AND TURN ADJUSTING YOKE OR RING TO RIGHT OR CLOCKWISE UNTIL OPERATING LEVER REQUIRES A DISTINCT PRESSURE TO ENGAGE. CLUTCH MUST NEVER BE SO LOOSE THAT TOGGLE WILL LOCK PAST CENTER. (SMALL SCREWS ON SLIDING MEMBER "B" ARE PROVIDED TO PREVENT LOCKING OF CLUTCH AND REPEATING OF PRESS BRAKE) CLUTCH SHOULD BE ADJUSTED FAIRLY TIGHT SO THAT VERY LITTLE SLIP WILL OCCUR UNDER FULL LOAD AND WHEN IN RELEASE POSITION. CLUTCH PLATES MUST HAVE JUST ENOUGH CLEARANCE TO PREVENT DRAGGING & HEATING.



REFER TO THIS NUMBER WHEN ORDERING PARTS



INDEX	NAME OF PART
JC-13	SO.C.HD. CAP SCREW
JC-28	HUB & BACK PLATE
JC-29	DRIVING PLATE
JC-30	CLUTCH LINING
JC-31	F-GATING RIVETS
JC-32	F-GATING PLATE
JC-33	ADJ. LOCK PIN SPRING
JC-34	ADJ. LOCK PIN
JC-35	LEVERS
JC-36	ROLLERS
JC-37	CONE COLLAR
JC-38	SNAP RING
JC-39	WASHER
JC-40	BALL BEARING
JC-41	SNAP RING
JC-42	LEVER RING
JC-43	CONE SLEEVE
JC-44	DOG POINT SET SCR.
JC-45	CONE RING
JC-46	COVER
JC-47	HEX HD. CAD SCR.
JC-48	ADJ. YOKE
JC-49	ROLLER DISC.
JC-50	RELEASE SPRING
JC-51	GREASE FITTING

NOTE! IT IS RECOMMENDED THAT PARTS INDICATED WITH AN ASTERISK BE CARRIED IN THE CUSTOMER'S STOCK FOR EMERGENCY REPLACEMENT.

REDRAWN - NO CHANGE - 4-23-70 CR # 7-13-98 FG REDRAWN S-N 9-13-51

DATE	REVISION	ASSEMBLY NO.	1.03	DRAWING NO.	20-00151	REV. NO.
1	1					
2	2					
3	3					
4	4					

DATE	12-9-42
SCALE	
DRAWN BY	BW
CHECKED BY	

TRADE MARK	VERSON
VERSOR ALLSTEEL PRESS CO	Chicago, Ill

MACHINE	PRESS BRAKES
PART	SINGLE PLATE MODEL 'CL' CLUTCH

PATT. #