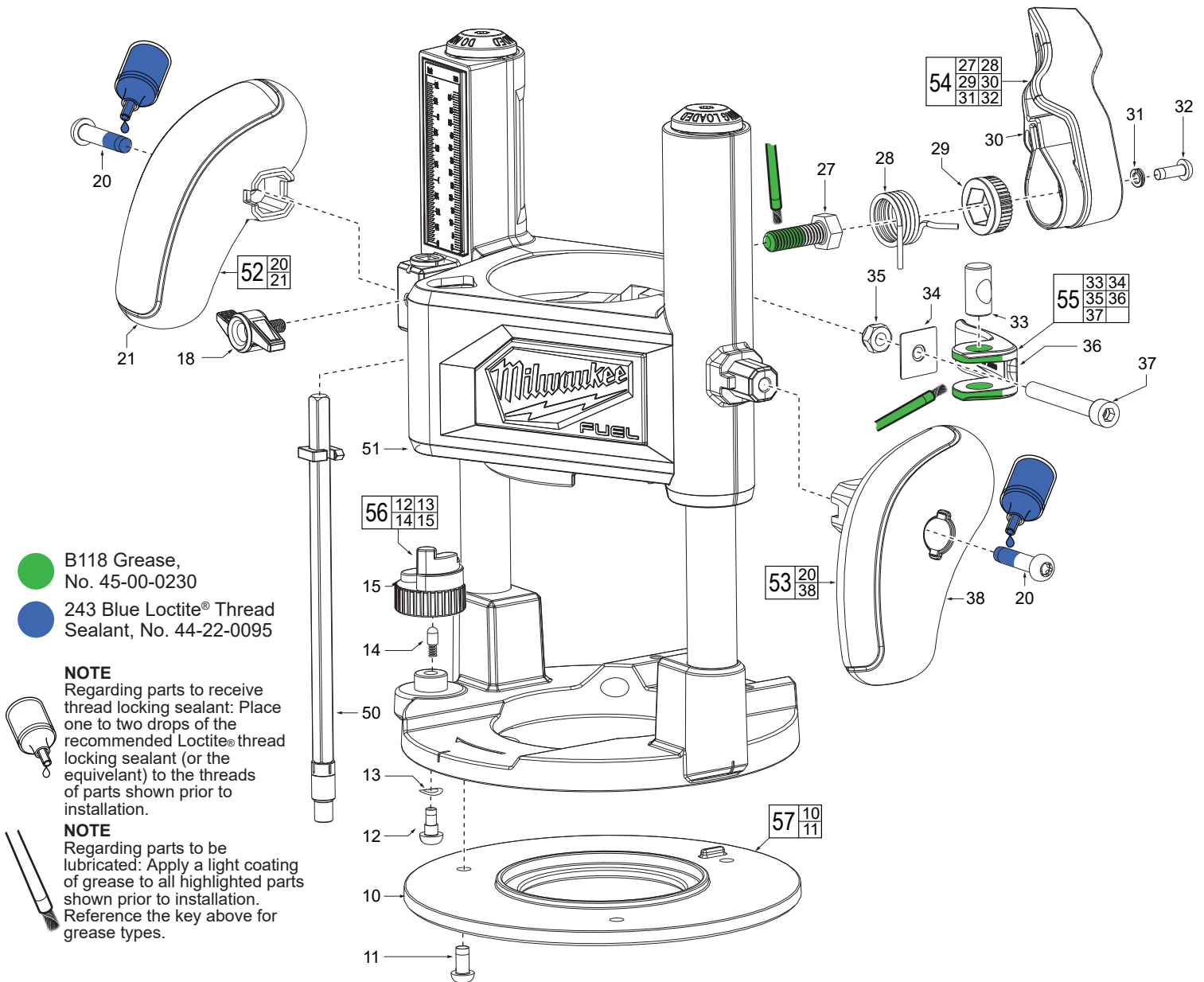


# PLUNGE BASE ASSEMBLY. 48-10-2838



- B118 Grease, No. 45-00-0230
- 243 Blue Loctite® Thread Sealant, No. 44-22-0095

## NOTE

Regarding parts to receive thread locking sealant: Place one to two drops of the recommended Loctite® thread locking sealant (or the equivalent) to the threads of parts shown prior to installation.

## NOTE

Regarding parts to be lubricated: Apply a light coating of grease to all highlighted parts shown prior to installation. Reference the key above for grease types.

|    |            |                             |     |
|----|------------|-----------------------------|-----|
| 10 | -----      | Sub Base                    | (1) |
| 11 | -----      | M5 x .8 PH T-25 Screw       | (3) |
| 12 | -----      | M4 x 10mm PH T-25 Screw     | (1) |
| 13 | -----      | Curved Washer               | (1) |
| 14 | -----      | Spring & Cover Assy.        | (1) |
| 15 | -----      | Depth Turret                | (1) |
| 16 | -----      | Fine Adjustment Knob        | (1) |
| 17 | -----      | Rubber O-Ring               | (1) |
| 18 | 43-98-0101 | 2 Nub Knob                  | (1) |
| 19 | -----      | Depth Stop Rod              | (1) |
| 20 | -----      | M6 x 1 CH T30 Screw         | (2) |
| 21 | -----      | Left Handle                 | (1) |
| 24 | -----      | Scale Pointer               | (1) |
| 27 | -----      | M8 x 23mm Brass Screw       | (1) |
| 28 | -----      | Plunge Lock Spring          | (1) |
| 29 | -----      | Screw Cap                   | (1) |
| 30 | -----      | Plunge Lock Lever           | (1) |
| 31 | -----      | Spring Washer               | (1) |
| 32 | -----      | #8-32 PH T-20 Screw w/Nylok | (1) |
| 33 | -----      | Cam Lock Pin                | (1) |
| 34 | -----      | Wear Plate                  | (1) |
| 35 | -----      | M6 Nylon Insert Nut         | (1) |
| 36 | -----      | Cam Lock Handle             | (1) |
| 37 | -----      | M6 x 45mm Hex Screw w/Nylok | (1) |
| 38 | -----      | Right Handle                | (1) |

| FIG. | PART NO.   | DESCRIPTION OF PART                  | QTY. |
|------|------------|--------------------------------------|------|
| 39   | -----      | Nameplate (Not Shown)                | (1)  |
| 50   | 31-17-0198 | Depth Rod Service Assembly           | (1)  |
| 51   | 14-46-0350 | Plunge Base Casting Service Assembly | (1)  |
| 52   | 31-44-0467 | Left Handle Service Kit              | (1)  |
| 53   | 31-44-0468 | Right Handle Service Kit             | (1)  |
| 54   | 44-10-0111 | Lock Lever Service Kit               | (1)  |
| 55   | 44-10-0112 | Cam Lock Lever Service Kit           | (1)  |
| 56   | 42-46-0266 | Turret Service Kit                   | (1)  |
| 57   | 43-76-0082 | Sub Base Service Kit                 | (1)  |
| 58   | 12-25-0579 | Warning Label (Not Shown)            | (1)  |

## SCREW TORQUE SPECIFICATIONS

| FIG. | PART NO. | WHERE USED     | SEAT TORQUE |         |
|------|----------|----------------|-------------|---------|
|      |          |                | (kgf-cm)    | (lb-in) |
| 11   | -----    | Sub Base Assy  | 12-16       | 10-14   |
| 12   | -----    | Turret         | 5-7         | 4-6     |
| 20   | -----    | Handles        | 35-45       | 30-39   |
| 27   | -----    | Lock Lever     | 8-12        | 7-10    |
| 32   | -----    | Lock Lever     | 16-20       | 14-17   |
| 37   | -----    | Cam Lock Lever | 35-43       | 30-37   |