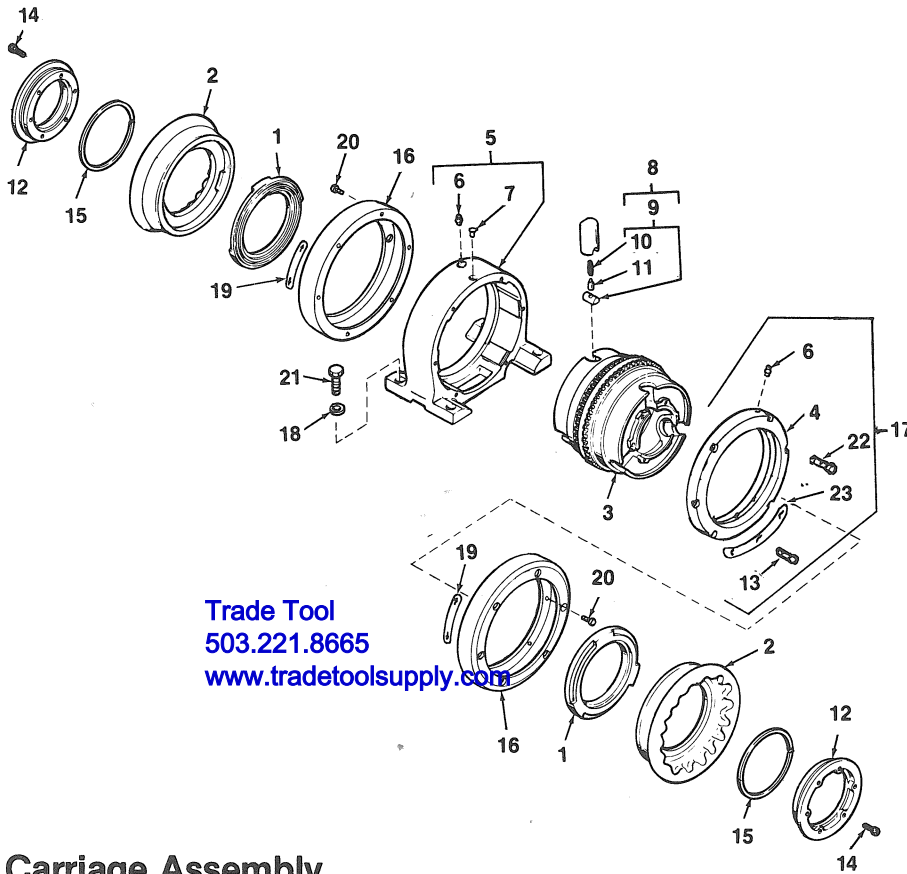




Workholder Assembly



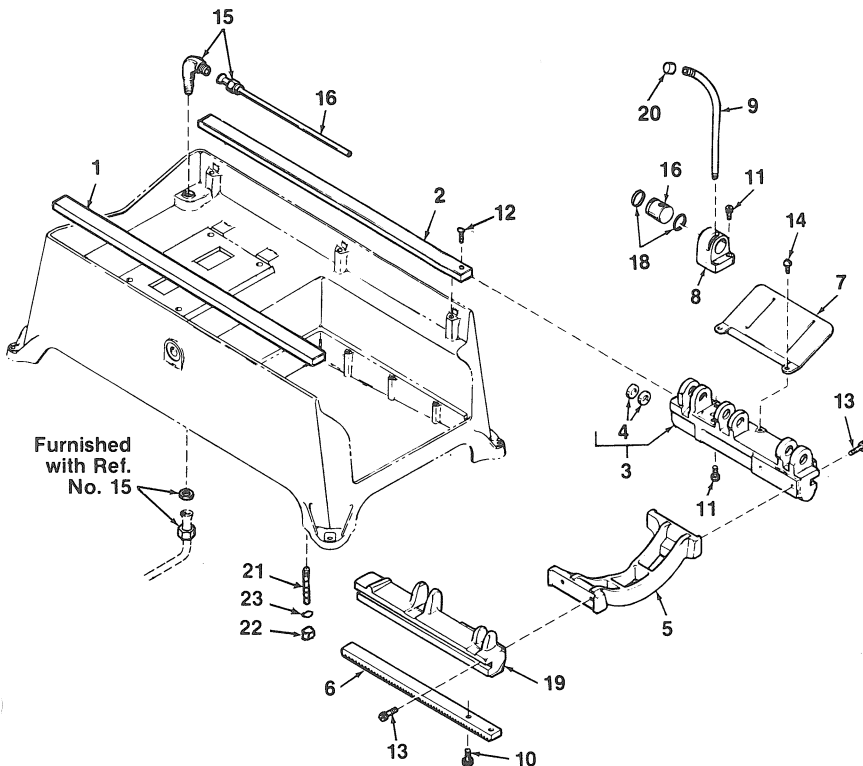
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**NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.**

Ref. No.	Catalog No.	Description
1	76045	B-205 Scroll (2)
2	76050	B-206 Handwheel (2)
3	84225	B-409 Workholder
4	84230	B-410 Bearing Cap
5	84235	B-411-X Workholder Housing
6	46860	E-912 Grease Fitting (2)
7	84180	E-3319 Oil Cup
8	76085	C-326-X Chuck Jaw Sets
9	76090	D-492-X Jaw Insert Sets
10	44700	E-1664 Spring (6)
11	44705	E-1665 Insert Pin (6)
12	76055	C-315 Retaining Ring (2)
13	44590	E-1503 Screw (6)
14	79685	E-1555 Screw (12)
15	76070	D-858 Thrust Ring (2)
16	84240	C-668 Workholder Guard (2)
17	84230	B-410 Bearing Cap Assembly
18	84150	E-3264 Lock Washer (4)
19	85985	E-3316 Open/Close Decal (2)
20	46795	E-901 Screw (12)
21	84215	E-10005 Screw (4)
22	44590	E-1503 Screw (6)
23	96340	E-10739 Retainer Plate (3)

Specify Machine Model and Serial Numbers When Ordering Parts.

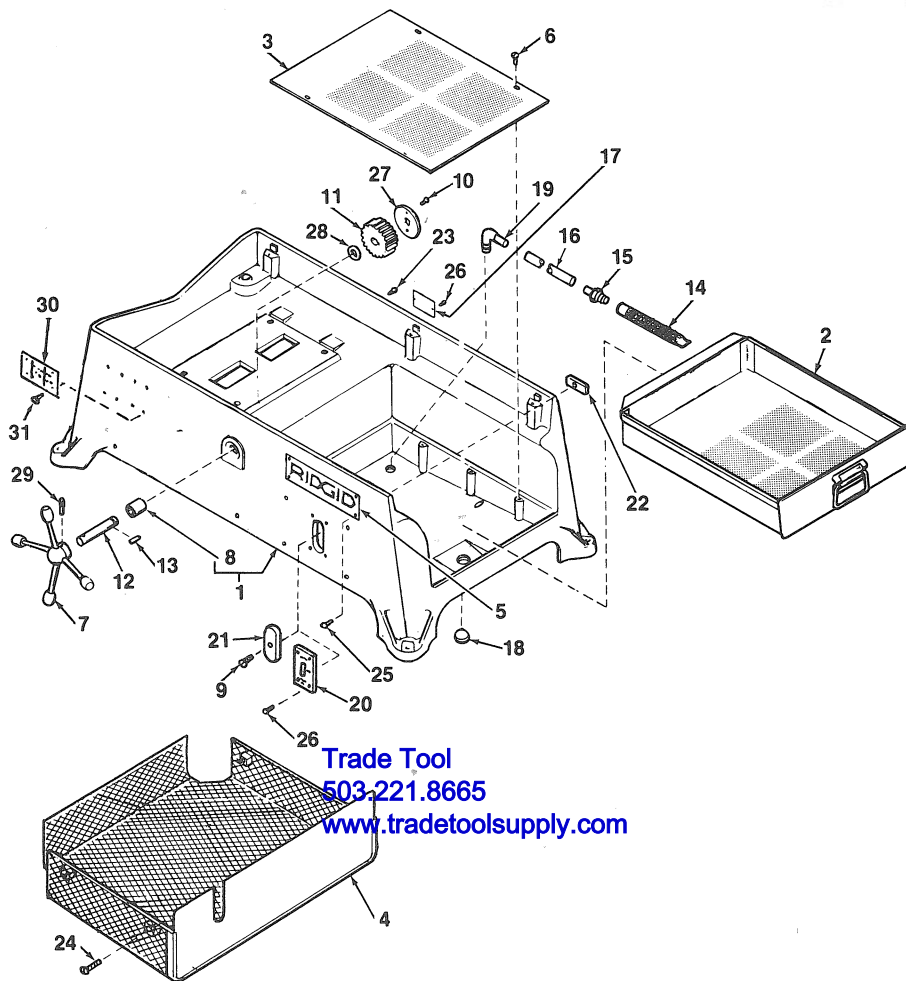
Carriage Assembly



Ref. No.	Catalog No.	Description
1	75735	B-263 Carriage Support Bar (Front)
2	75740	B-264 Carriage Support Bar (Rear)
3	76030	B-271-X Rear Support
4	76015	E-2584 Oil Seal (2)
5	75980	B-273 Carriage
6	75990	C-461 Carriage Rack
7	75995	C-462 Drip Guard
8	76000	D-857 Oil Spout Support
9	84210	D-1290 Oil Spout
10	46760	E-894 Screw (2)
11	32270	E-1027 Screw (3)
12	32205	E-1406 Screw
13	79685	E-1555 Screw (4)
14	79970	E-1668 Screw (2)
15	75765	E-2536 Elbow with Nuts and Ferrel
16	75770	E-2537 Telescopic Oil Line
17	76005	E-2578 Shut-off Plug
18	76010	E-2583 "O" Ring (2)
19	75985	B-272 Front Support
20	76025	E-2628 Oil Spout Cap
21	96735	E-10748 Stud (6)
22	96730	E-1634 Nut (6)
23	96740	E-10759 Washer (6)



Base, Carriage Handwheel and Oil Filter



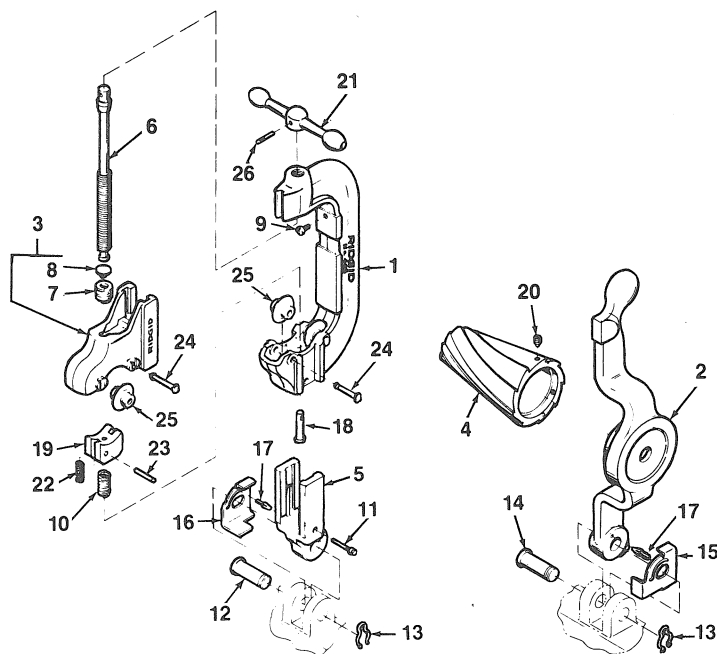
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NOTE: Order parts by Catalog Number only. DO NOT order by Reference Number.

Ref. No.	Catalog No.	Description
1	84005 A-75-X	Base (Incl. Ref. No. 9)
2	84015 B-400	Chip Tray
3	84020 B-402	Splash Tray
4	84045 B-429	Guard
5	85975 D-1288	RIDGID Logo Plate (850 only)
	85980 D-1289	RIDGID Logo Plate (852 only)
6	45275 E-313	Screw (4)
7	46510 E-632	Carriage Handwheel
8	45540 E-666	Bushing
9	86010 E-475	Screw (850 only) (12)
10	46785 E-899	Screw (2)
11	75750 E-2525	Pinion
12	75745 E-2617	Handwheel Shaft
13	75800 E-2667	Key
14	83920 E-2956	Filter
15	83925 E-2957	Fitting (2)
16	83930 E-2958	Oil Return Hose
17	— E-3122	Name Plate (115V)
	90065 E-3314	Name Plate (230V)
18	84075 E-3168	Plug
19	84170 E-3279	Elbow
20	85990 E-3317	Switch Cover (852 only)
21	84185 E-3324	Plug (850 only)
22	84190 E-3325	Nut (850 only)
23	45420 E-3467	Screw
24	E-10687	Screw (4)
25	46470 E-6270	Screw (4)
26	85920 E-10006	Pop Rivet (6) (852) (2)
27	47120 F-639	Pinion Lock Ring
28	47145 F-677	Washer
29	47165 F-744	Pin
30	88690 E-1238	Warning Plate
31	85920 E-10006	Pop Rivet (8)

Specify Machine Model and Serial Numbers when ordering parts.

No. 425 Cutter and 458 Reamer



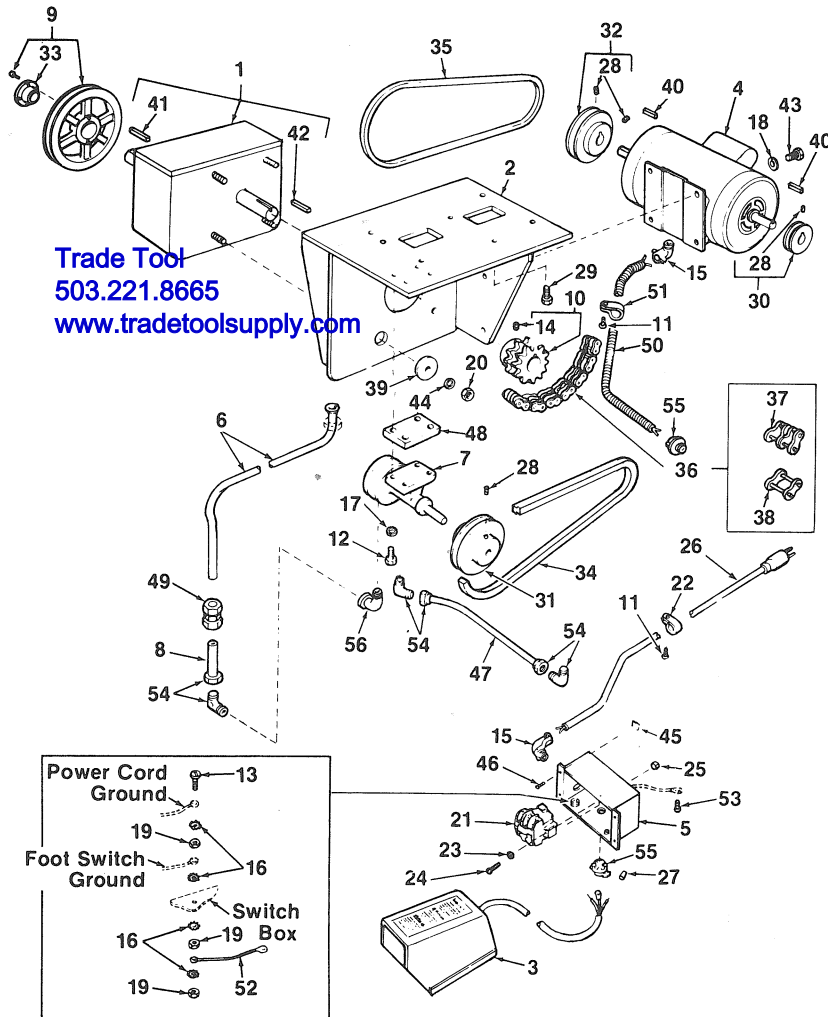
Ref. No.	Catalog No.	Description
—	85580 B-243	Cutter Complete (425)
—	76250 B-397	Reamer Complete (458)
1	76210 B-274	Cutter Frame
2	85605 B-275	Reamer Arm
3	33345 C-508-X	Wheel Housing (Incl. Ref. No. 7 and 8)
4	35135 C-965	Reamer Cone
5	85585 D-845	Cutter Arm
6	76220 D-846	Cutter Screw
7	34315 E-1793	Wear Plug Spring
8	34320 E-1794	Wear Plug
9	34425 E-2479	Stop Screw
10	76240 E-2588	Spring
11	76230 E-2591	Stop Pin
12	85590 E-2592	Stop Pin
13	85610 E-2593	Hairpin Clip (2)
14	76260 E-2594	Hinge Pin
15	75785 E-2613	Retaining Plate
16	75790 E-2614	Retaining Plate
17	76270 E-2708	Spring Pin (2)
18	83960 E-2898	Pin
19	83955 E-2899	Guide Block
20	35140 E-4334	Set Screw (3)
21	45765 E-4428	Feed Screw Crank
22	75610 E-4465	Spring (4)
23	41545 E-5397	Roll Pin
24	34790 F-14	Pin & Clip (4)
25	33125 F-229	Cutter Wheel (4)
26	47160 F-743	Feed Screw Pin

Specify Machine Model and Serial Numbers when ordering parts.

850 Machine Electrical Components (115V, 60 Hz) (230V, 60 Hz) (230V, 50 Hz)

**NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.**

ECN-2429

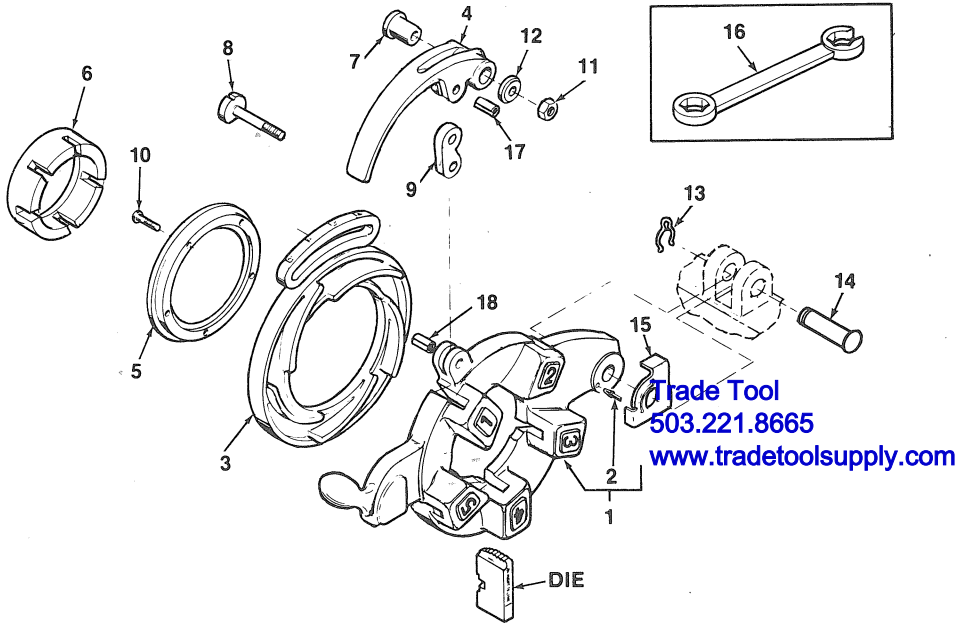


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Ref. No.	Catalog No.	Description
1	84010	B-394 Gear Reducer
2	84025	B-412 Support Bracket
3	83555	B-436 Foot Switch Assembly
3	76095	E-2497 Foot Switch Assembly
4	85965	C-653 Motor (115/230V)
4	86000	C-1241 Motor (230, 50 Hz)
5	84040	C-656 Switch Box
6	84050	C-703 Outlet Tube
7	87820	C-1245 Oil Pump
8	84055	E-3280 Oil Outlet Tube
9	84030	D-1246 Pulley
10	84035	D-1247 Sprocket
11	45275	E-313 Screw (2)
12	75350	E-396 Screw (4)
13	92455	E-10412 Screw
14	46800	E-902 Set Screw
15	46900	E-923 90° Connector (2)
16	46985	E-945 Lock Washer (4)
17	40930	E-1095 Lock Washer (4)
18	—	E-1649 Lock Washer (4)
19	44695	E-1663 Nut (3)
20	44745	E-1732 Nut (4)
21	85560	E-2499 Contactor (115V)
21	85675	E-2698 Contactor (230V)
22	76150	E-2664 Clamp
23	85945	E-2686 Washer (2)
24	85570	E-2696 Screw (2)
25	76190	E-2697 Nut (2)
26	76390	E-2700 Cord (230V)
26	89735	E-10378 Cord (115V)
27	85930	E-2859 Wire Nut (2)
28	77905	E-2896 Set Screw (5)
29	85915	E-3113 Screw (3)
30	84080	E-3208 Pulley
31	84085	E-3209 Pulley
32	84090	E-3210 Pulley
33	84095	E-3211 Bushing
34	84100	E-3212 Belt
35	84105	E-3213 Belt
36	84110	E-3214 Roller Chain
37	84115	E-3216 Offset Link
38	84120	E-3217 Link
39	84125	E-3257 Washer (4)
40	84130	E-3260 Key (2)
41	84135	E-3261 Key
42	84140	E-3262 Key
43	84145	E-3263 Screw (4)
44	84150	E-3264 Lock Washer (4)
45	84155	E-3265 Speed Nut (4)
46	84160	E-3266 Screw (4)
47	84060	E-3281 Intake Line
48	84175	E-3290 Spacer
49	84065	E-3330 Union
50	84195	E-3333 Flexible Conduit
51	84200	E-3336 Clamp
52	85925	E-3359 Jumper Wire
53	45420	E-3467 Screw
54	75960	E-4284 Elbow (3)
55	45990	E-4484 Connector (2)
56	84220	E-10067 Elbow

No. 424 Die Head (R.H. Only)

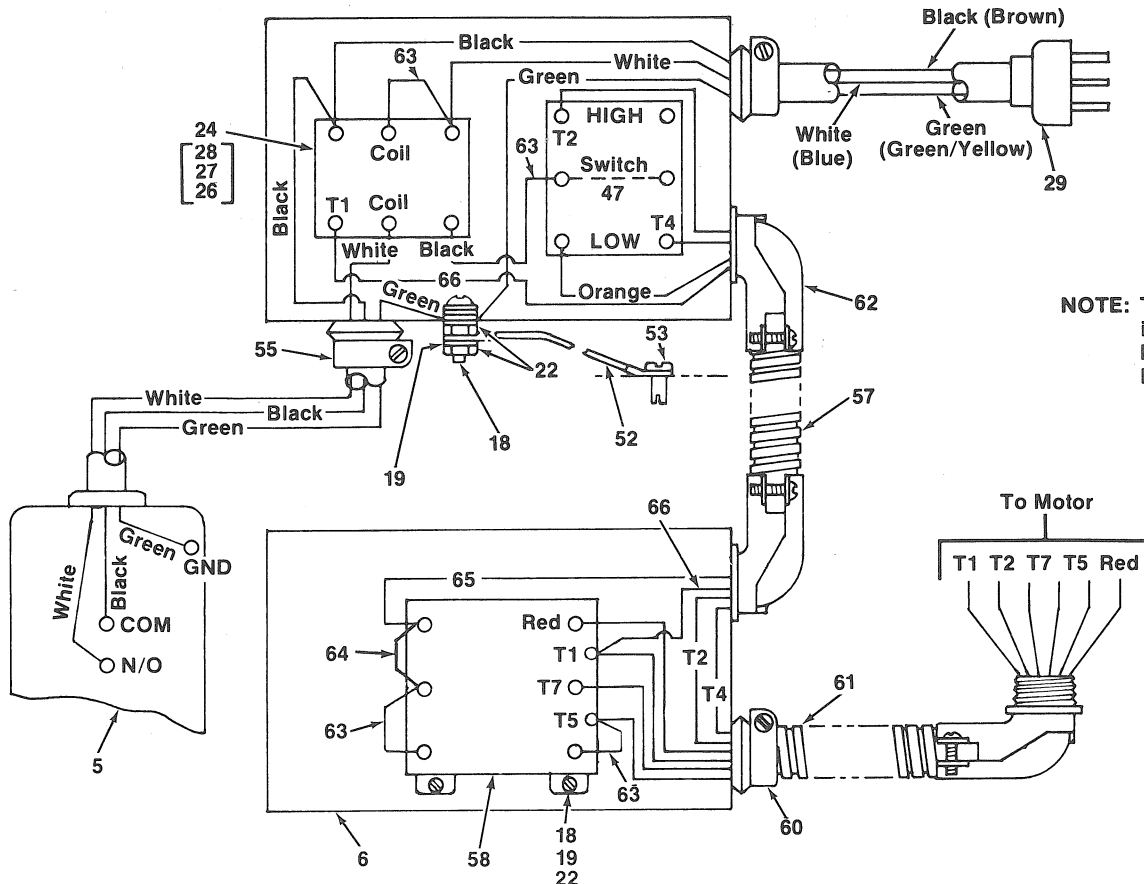
NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.



Ref. No.	Catalog No.	Description
1	83980	A-79-X Die Head
2	76270	E-2708 Spring Pin
3	85615	B-276 Cam Plate
	76375	B-276-B Cam Plate (British only)
4	76370	C-473-X Throwout Lever
5	83970	C-716 Retaining Ring
6	85665	C-1227 Die Head Bushing (for 2-1/2" pipe)
7	76300	D-854 Pivot Bushing
8	85630	D-855 Adjusting Screw
9	76310	D-856 Link
10	85910	E-1638 Screw (5)
11	80000	E-1694 Nut
12	85655	E-2518 Washer
13	85610	E-2593 Hairpin Clip
14	76260	E-2594 Hinge Pin
15	75785	E-2613 Retaining Plate
16	83975	E-2923 Combination Wrench (3/4")
17	76360	E-3288 Roll Pin (2)

Specify Machine Model and Serial Numbers When Ordering Parts.

**No. 852 Machine Wiring Diagram (115V, 60 Hz)
(230V, 60 Hz) (230V, 50 Hz)**

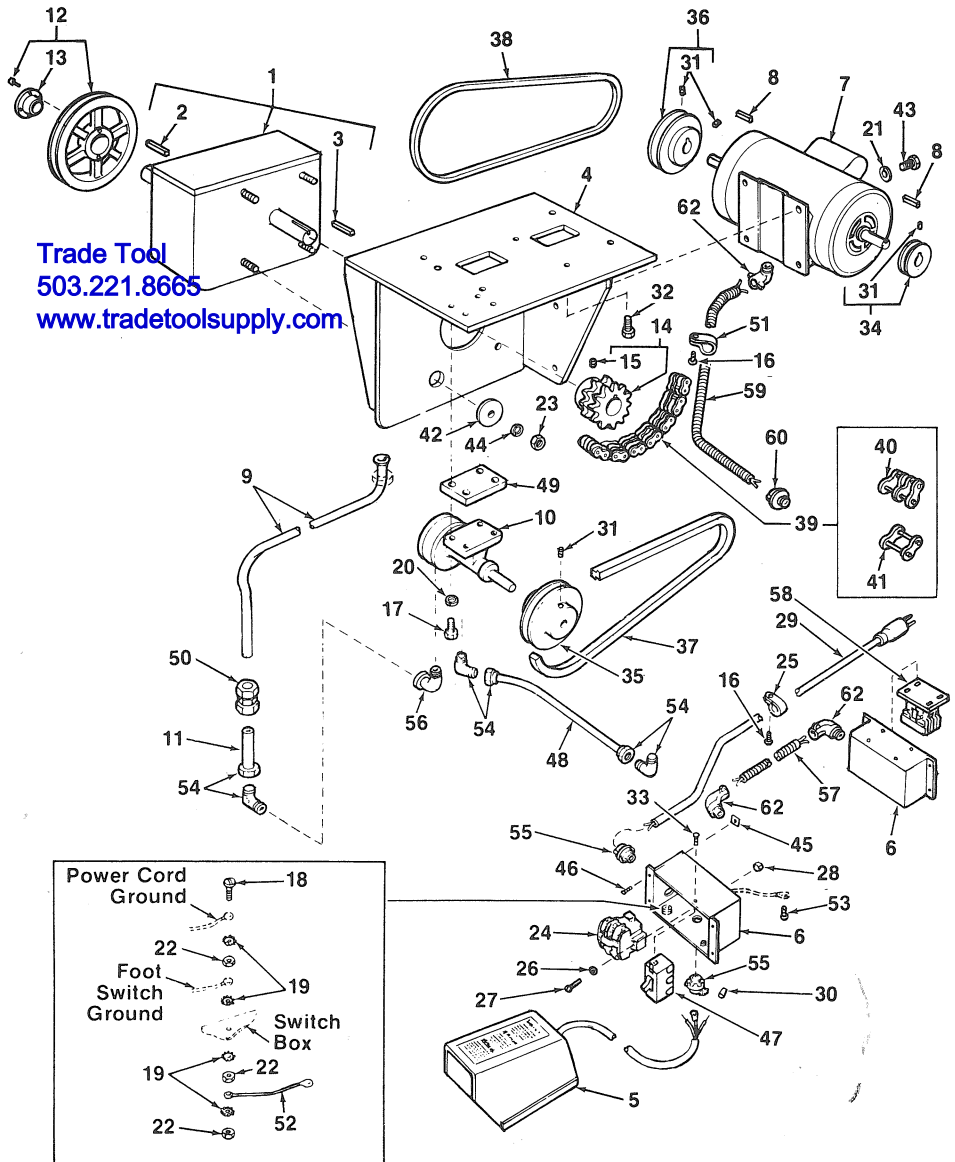


NOTE: These Reference Numbers are included in the 852 Machine Electrical Components Parts List

852 Machine Electrical Components (115V, 60 Hz) (230V, 60 Hz) (230V, 50 Hz)

NOTE: Order parts by Catalog Number only. DO NOT order by Reference Number.

Ref. No.	Catalog No.	Description
1	84010	B-394 Gear Reducer
2	84135	E-3261 Key
3	84140	E-3262 Key
4	84025	B-412 Support Bracket
5	83555	B-436 Foot Switch Assembly
6	76095	E-2497 Foot Switch Assembly
7	84040	C-656 Switch Box (2)
8	85970	C-657 Motor (115V, 60 Hz)
9	86005	C-1242 Motor (230V, 50 Hz)
10	84130	E-3260 Key (2)
11	84050	C-703 Oil Outlet Tube
12	87820	C-1245 Oil Pump
13	84055	E-3280 Oil Outlet Tube
14	84035	D-1247 Sprocket
15	46800	E-902 Set Screw
16	45275	E-313 Screw (2)
17	75350	E-396 Screw (4)
18	92455	E-10412 Screw (5)
19	46985	E-945 Lock Washer (8)
20	40930	E-1095 Lock Washer (4)
21	92255	E-1649 Lock Washer (4)
22	44695	E-1663 Nut (7)
23	44745	E-1732 Nut (4)
24	85675	E-2698 Contactor (230V)
25	85560	E-2499 Contactor (115V)
26	76150	E-2664 Clamp
27	85945	E-2686 Washer (2)
28	85570	E-2696 Screws (2)
29	76190	E-2697 Nut (2)
30	76390	E-2700 Power Cord (230V)
31	89735	E-10378 Power Cord (115V)
32	85930	E-2859 Wire Terminal (2)
33	77905	E-2896 Set Screw (5)
34	85915	E-3113 Screw (3)
35	45280	E-3144 Screw (2)
36	84080	E-3208 Pulley
37	84085	E-3209 Pulley
38	84090	E-3210 Pulley
39	84100	E-3212 Drive Belt
40	84105	E-3213 Drive Belt
41	84110	E-3214 Roller Chain
42	84115	E-3216 Offset Link
43	84120	E-3217 Connecting Link
44	84125	E-3257 Washer (4)
45	84145	E-3263 Screw (4)
46	84150	E-3264 Lock Washer (4)
47	84155	E-3265 Speed Nut (8)
48	84160	E-3266 Screw (8)
49	84165	E-3271 Switch
50	84060	E-3281 Oil Intake Line
51	84175	E-3290 Spacer
52	84065	E-3330 Union with Insert
53	84200	E-3336 Clamp
54	85925	E-3359 Jumper Wire (Ground)
55	45420	E-3467 Screw
56	75960	E-4284 Elbow (3)
57	45990	E-4484 Straight Connector (2)
58	84220	E-10067 Elbow
59	89500	E-10221 Flexible Conduit
60	89505	E-10222 Motor Relay (115V)
61	92425	E-10571 Motor Relay (230V)
62	88275	E-10224 Flexible Conduit
63	88280	E-10225 Straight Connector



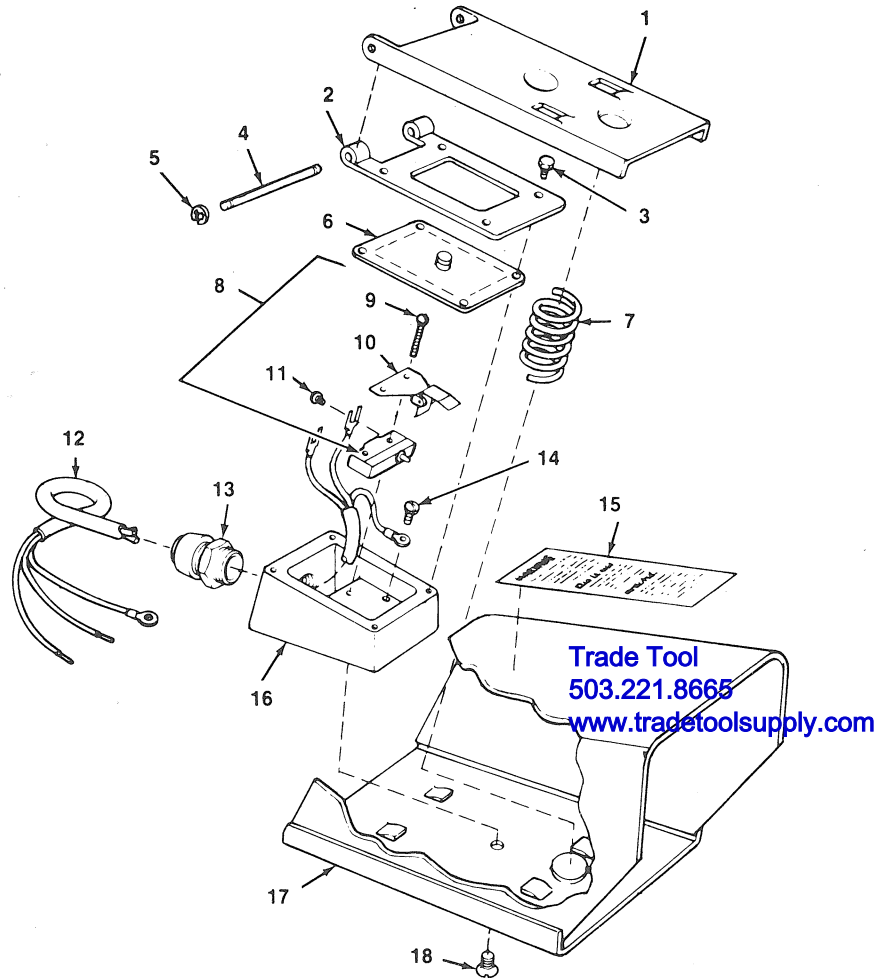
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Ref. No.	Catalog No.	Description
61	—	E-10296 Wire Terminal (2)
62	88285	E-10324 90 Degree Connector (3)
63	76130	E-2544 Jumper Wire (Black) (4)
64	76130	E-2544 Jumper Wire (Black)
65	89490	E-10219 Jumper Wire (Orange)
66	89495	E-10220 Jumper Wire (Black)

Jumper Wires (852 Machine)
(Refer to previous wiring diagram for location)



NOTE: Order parts by Catalog Number only.
DO NOT order by Reference Number.



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Ref. No.	Catalog No.	Description	Ref. No.	Catalog No.	Description
	83550	B-293 Foot Switch Assembly	10	83575	E-3031 Actuator Assembly
	83555	B-436 Foot Switch Assembly	11	78805	E-5367 Screw (2)
1	83565	C-546 Foot Pedal	12	68880	D-620 Cord (B-293)
2	89105	D-2000 Plate		83605	D-1297 Cord (B-436)
3	83625	E-3084 Screw (4)		83600	D-1221 Cord w/Plug (301)
4	83580	E-3058 Pin	13	68885	E-1511 Cord Connector (B-293)
5	78780	E-3562 Retaining Ring (2)		85565	E-2668 Cord Connector (B-436) (301)
6	83590	E-3050 Diaphragm w/Gasket	14	74542	E-3467 Screw
7	83615	E-3051 Spring	15	85940	E-2220 Warning Label (B-293)
8	83585	E-2988-X Micro Switch (Incl. Ref. Nos. 9, 10 & 11)			E-3173 Warning Label (B-436) (301)
9	83595	E-3060 Screw (2)	16	85935	C-532 Housing
			17	83560	B-345 Housing Cover
			18	83610	E-3095 Screw