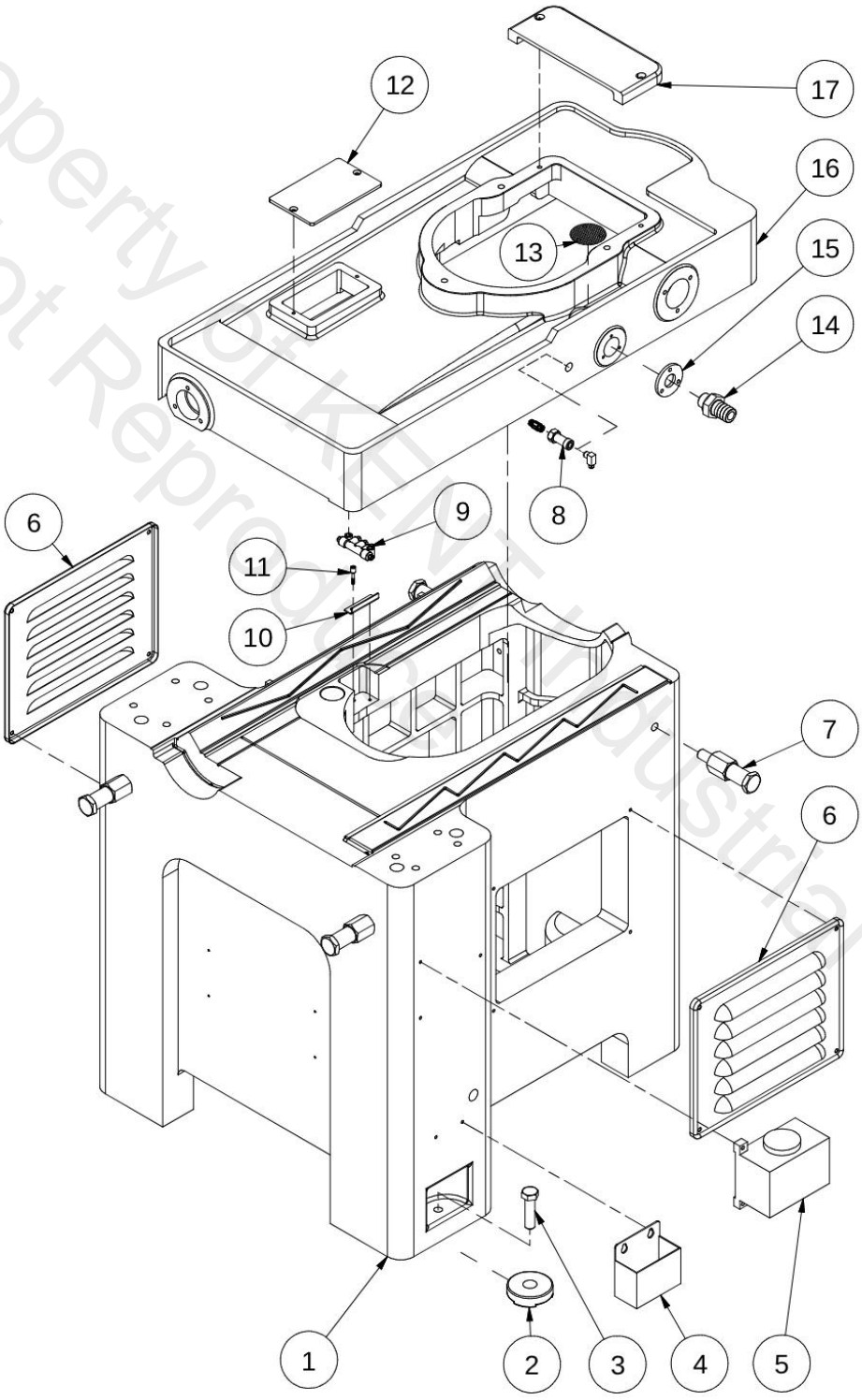
4. Exploded Diagram and Parts List

4.1 Bed and Saddle



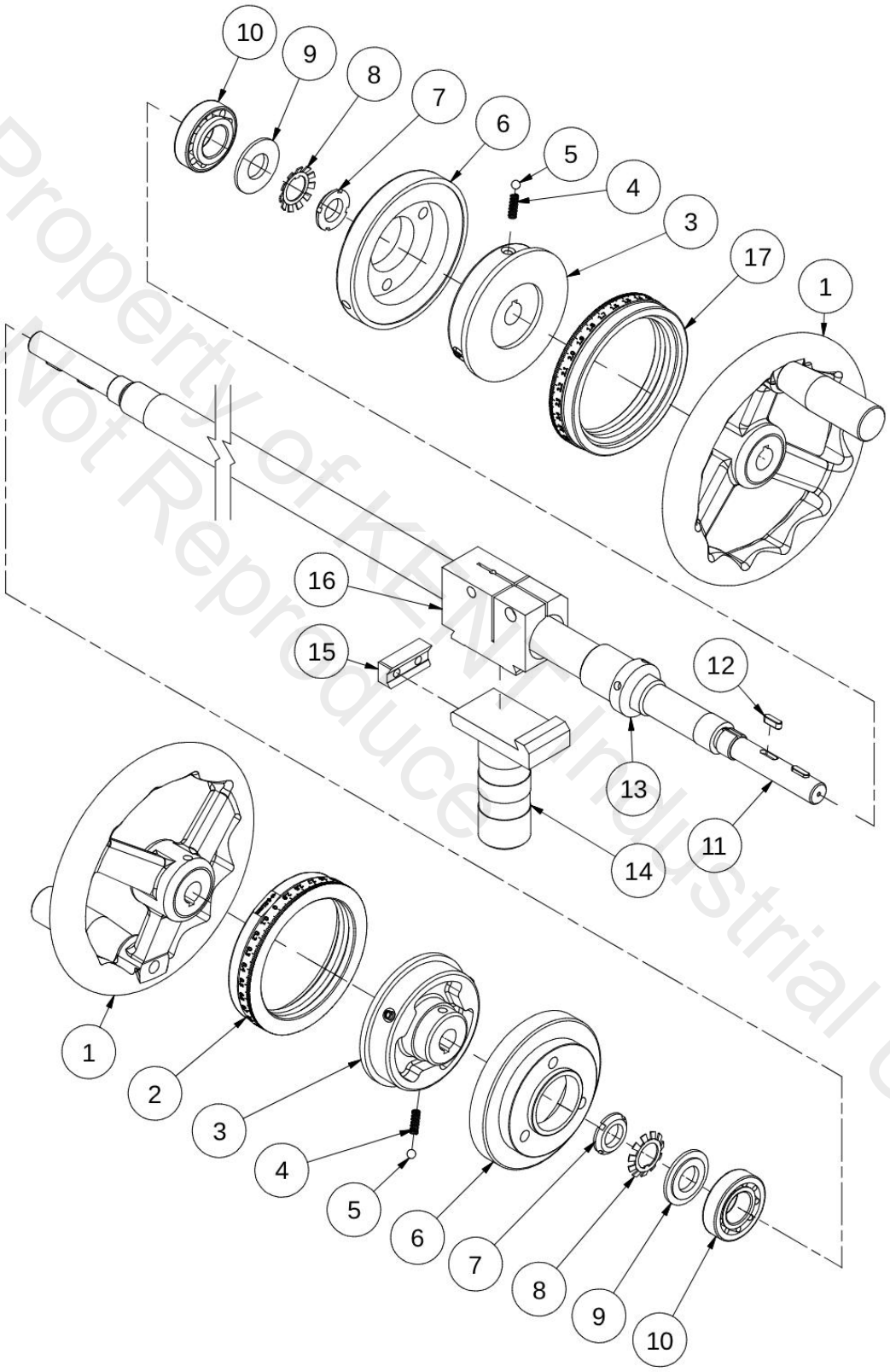
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Part List of Bed and Saddle

No.	Part Number	Description	Specification	Q'ty
1	3M41001921	Machine bed	L795*W755*H700(8 hole)	1
2	3M46035000	Leveling Blocks	D74*L20	3
3	5GF017192	Hex screw	M16*60L(Full thread)	3
4	3M41224001	Oil Catch Pan	L100*W100*H50	1
5	4GN050296	Resistance Type Oil Manual Lubricator	CTA-8	1
6	3M41003008	Machine bed protection cover	L339*W271*H16	2
7	3C21026128	Lifting rod	D36.95*L120	4
8	3M41002429	Connector	D22*D4*L42	1
9	4GN050403	A Type Distributor (A5) + Thimble nut PA-4 + Thimble PB-4	Inlet Φ4 Outlet Φ4*4	1
10	3M41217029	Oil plate	L60*W18*H13	1
11	3M41215201	Oil pipe connector	D8*D2*L33	5
12	3M41004001	Cover of saddle's screw	L160*W100*H5	1
13	3U21969119	Filter	D57*L1.5~2	1
14	4GM010159	Male Hose-Barb connector	3/4PT*1"	1
15	3M41006201	Rounded lid	D57*D24.5*H5 (For splash guard)	1
16	3M41002380	Saddle	L981*W460*H130	1
17	3M41005017	Dustproof cover of saddle	L259*W103.5*H22	1

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4.2 Saddle Feed



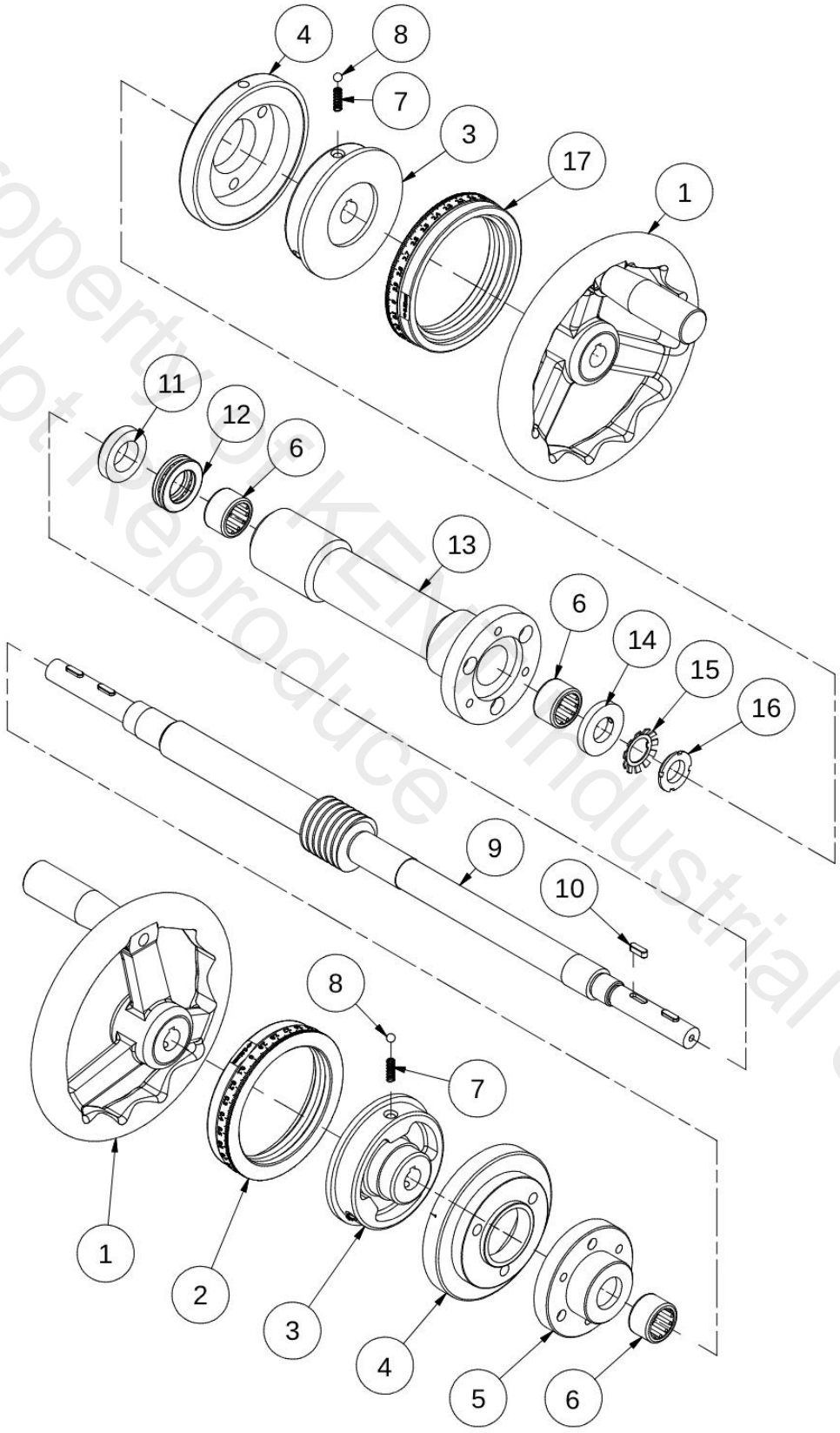
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Part List of Saddle Feed

No.	Part Number	Description	Specification	Q'ty
1	5GD020389	Handwheel	KPS 200 + FG 90/M10	2
2	3M43011223	Scale ring (Left /Metric)	D120*D95*L23	1
3	3M43009013	Scale ring seat	D104*D17*L38	2
4	3M43010000	Spring	D6*D4.4*L18 (Wire core: Φ0.8)	6
5	5GB050076	Steel Ball	Φ1/4"	6
6	3M43008010	Scale ring indicating seat	D120*D44*L30	2
7	3M43007004	Hard lock nut	D32*D18.5*L5(M20*1.5)	2
8	5GE010269	TAIYO Washer	AW04(20)	2
9	3M43006001	Spacer	D43*D20.3*L4	2
10	5GB020017	Tapered Roller Bearing	30205	2
11	3M43005804	Saddle feed screw	D28*L1121	1
12	5GC010188	Woodruff key	5*5*16L	4
13	3M43003811	Insert screw	D42*D25*L45	1
14	3M43001051	Saddle feed slide	L111*W80*H42	1
15	3M43004005	Dovetail block	L42*W19*H13.6	1
16	3M43002821	Saddle feed slide	L85*W58*H43.5	1
17	3M43011126	Scale ring (Right/Metric)	D120*D95*L23	1

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4.3 Vertical Feed Shaft for Grinding Wheel Head



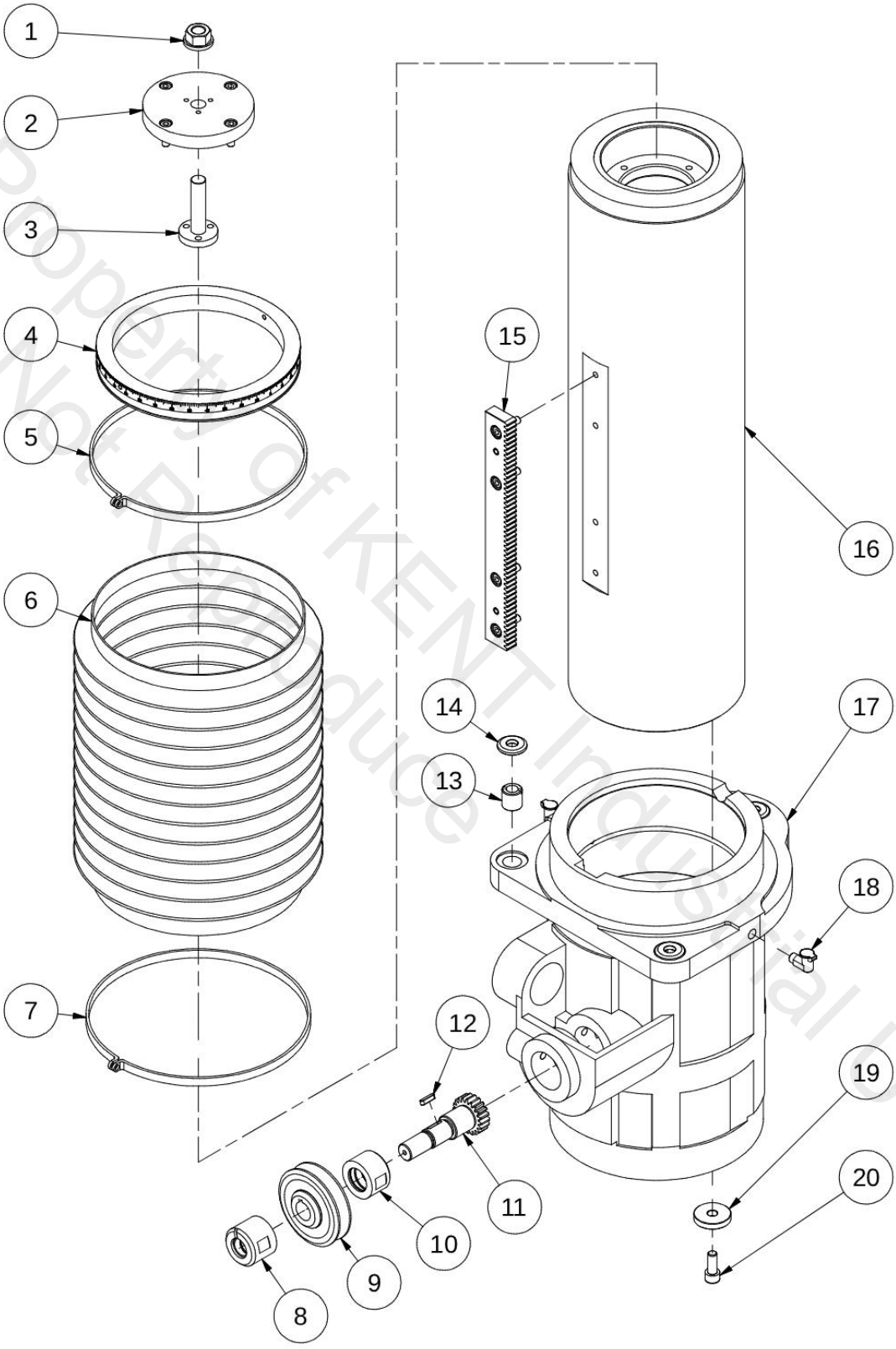
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Part List of Vertical Feed Shaft for Grinding Wheel Head

No.	Part Number	Description	Specification	Q'ty
1	5GD020389	Hand wheel	KPS 200 + FG 90/M10	2
2	3M43011223	Scale ring (Left/Metric)	D120*D95*L23	1
3	3M43009013	Scale ring seat	D104*D17*L38	2
4	3M43008010	Scale ring indicating seat	D120*D44*L30	2
5	3M43105027	Vertical bearing seat	D90*D26*L33.6	1
6	5GB020431	Needle roller bearing	HK2520	3
7	3M43010000	Spring	D6*D4.4*L18 (Wire core:Φ0.8)	6
8	5GB050076	Steel ball	Φ1/4"	6
9	3M43103827	Vertical feed screw	D44*L664	1
10	5GC010188	Woodruff key	5*5*16L	4
11	3M43104008	Bearing Washer	D42*D25*L11	1
12	5GB030124	Thrust Ball Bearing	51105	1
13	3M43102028	Vertical worm sleeve	D90*D30*L237	1
14	3M43101009	Vertical worm spacer	D42*D20.5*L6	1
15	5GE010269	TAIYO Washer	AW04(20)	1
16	3M43007004	Hard lock nut	D32*D18.5*L5(M20*1.5)	1
17	3M43011126	Scale ring (Right/Metric)	D120*D95*L23	1

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4.4 Elevating Column



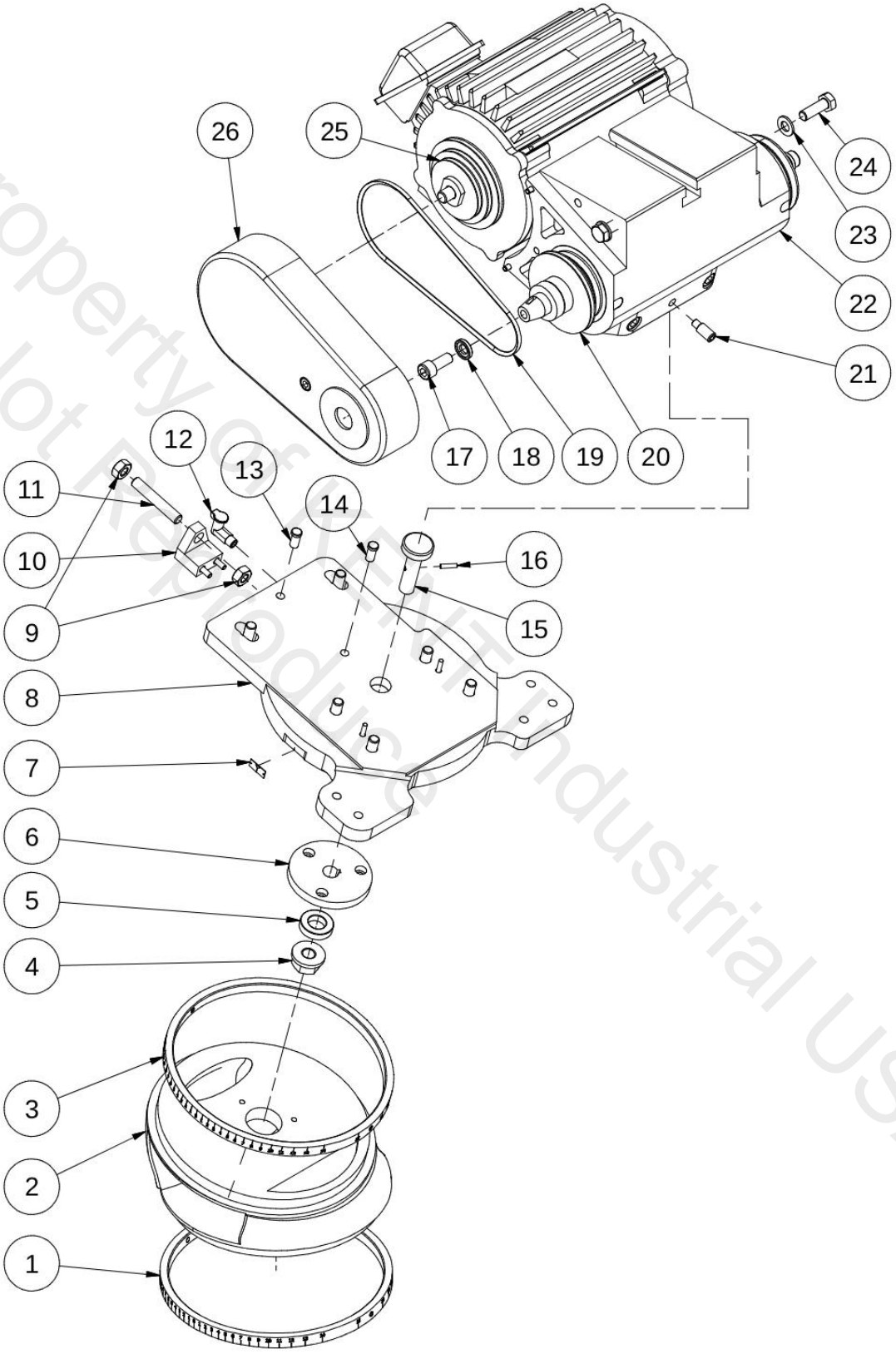
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Part list of Elevating Column

No.	Part Number	Description	Specification	Q'ty
1	3M43216004	Elevating Flange nut (Right-hand thread)	D32*D14*L16	1
2	3M43208003	Elevating lid	D120*D16.2*L16	1
3	3M43209019	Elevating Flange screw	D42*L75	1
4	3M43214024	Elevating scale ring	D220*D185*L24	1
5	4GM071109	Stainless Steel Hose Clamp	9"	1
6	5GA010078	Dust guard bellows		1
7	4GM071112	Stainless Steel Hose Clamp	9.5"	1
8	3M43204001	Rear oil groove bushing	D45*D20*L35	1
9	3M43206803	Elevating worm	D91*D22*L30(M2*42T)	1
10	3M43207000	Front oil groove bushing	D45*D28*L30	1
11	3M43205004	Elevating pinion	D44*L108.5	1
12	5GC010450	Woodruff key	5*5*20L	1
13	3M43215001	Adjusting screw	D22*D13*L22	3
14	3M49010002	Spacer	D32*D12.5*L4.7	3
15	3M43203053	Elevating rack	L300*W34.1*H14.5	1
16	3M43202034	Elevating column	D190*D80*L690	1
17	3M43201031	Elevating column base	L380*W297*H291	1
18	4GN010243	Oil cup	1/4PT	2
19	3M43210019	Stopper	D40*D10.5*L7.5	1
20	5GF014944	Hex screw	M10*25L	1

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4.5 Grinding Wheel head



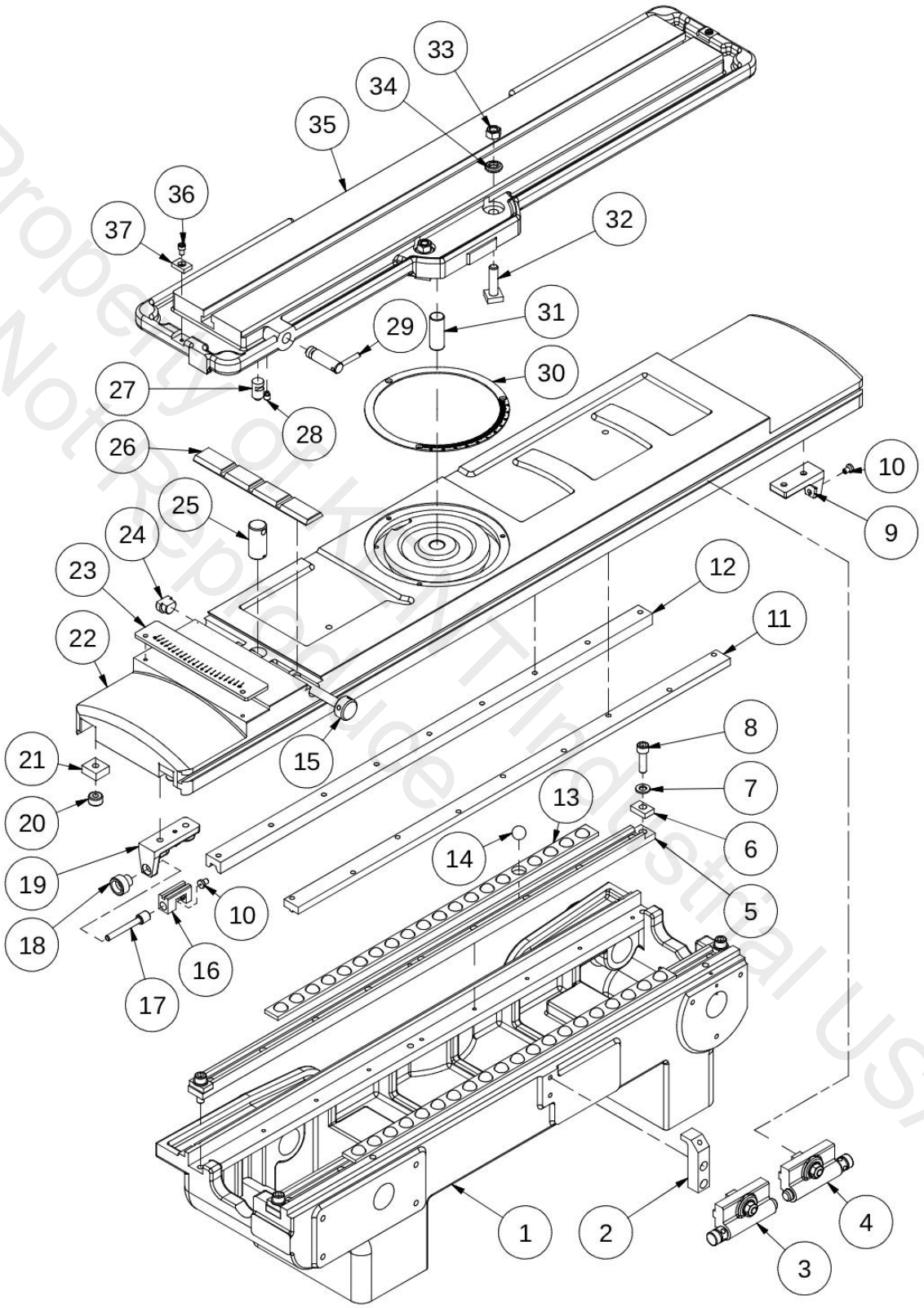
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Part list of grinding wheel head

No.	Part Number	Description	Specification	Q'ty
1	3M44003119	Scale ring (Lower)	D220*D204*L12	1
2	3M44001045	15° tilting base	L238.77*W220*H123.2	1
3	3M44002103	Scale ring (Upper)	D220*D204*L12	1
4	3M44007001	Screw nut	D32*D12*L15.8(M14*2, left hand thread/ used with 3M440060**)	1
5	3M44016005	Spacer	D32*D17.44*L8	1
6	3M44004015	Tilting swivel base	D80*D15*L21	1
7	3M47012101	Sticker of zero point	L20*W9*H0.5	2
8	3M44005089	Motor swiveling base	L300*W280*H24.8	1
9	5GF030357	Screw nut	M10*P1.5	2
10	3M44011013	Adjusting block	L36.5*W32*H30	1
11	3M44012003	Adjusting bolt	D10*L61	1
12	4GN010214	1/8 oil cup	Iron	1
13	3M44009117	Pin	D10*L19.5	1
14	3M44009007	Pin	D10*L19.5	1
15	3M44006008	Fixing bolt	D30*L64 (M14x, left hand thread /used with 3M440070**)	1
16	5GB050199	Needle	4*16	1
17	5GF014944	Hex screw	M10*25L	6
18	3M44110000	Spacer	D20*D10*L3.7	2
19	5GD030069	Belt	5M-530	1
20	3M44112006	Spindle (with pulley)	10°30' / 5M / 3 grooves with different speeds	Choose one
	3M44113009	Spindle (with pulley)	9°27' / 5M / 3 grooves with different speeds	
21	3M44017011	Fixing screw	D10*L25	1
22	3M44008059	Motor base	L235*W163*H151	1
23	5GE011055	Flat spacer	M10	4
24	5GF016759	Hex screw	M10*30L	4
25	3M44014122	Motor pulley	D92*D13.45*L25(5M/3 grooves with different speeds)	1
26	3M44013022	Belt cover	L260*W129*H50	1

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4.6 Workbench and Bridge Base



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Part list of Workbench and Bridge Base

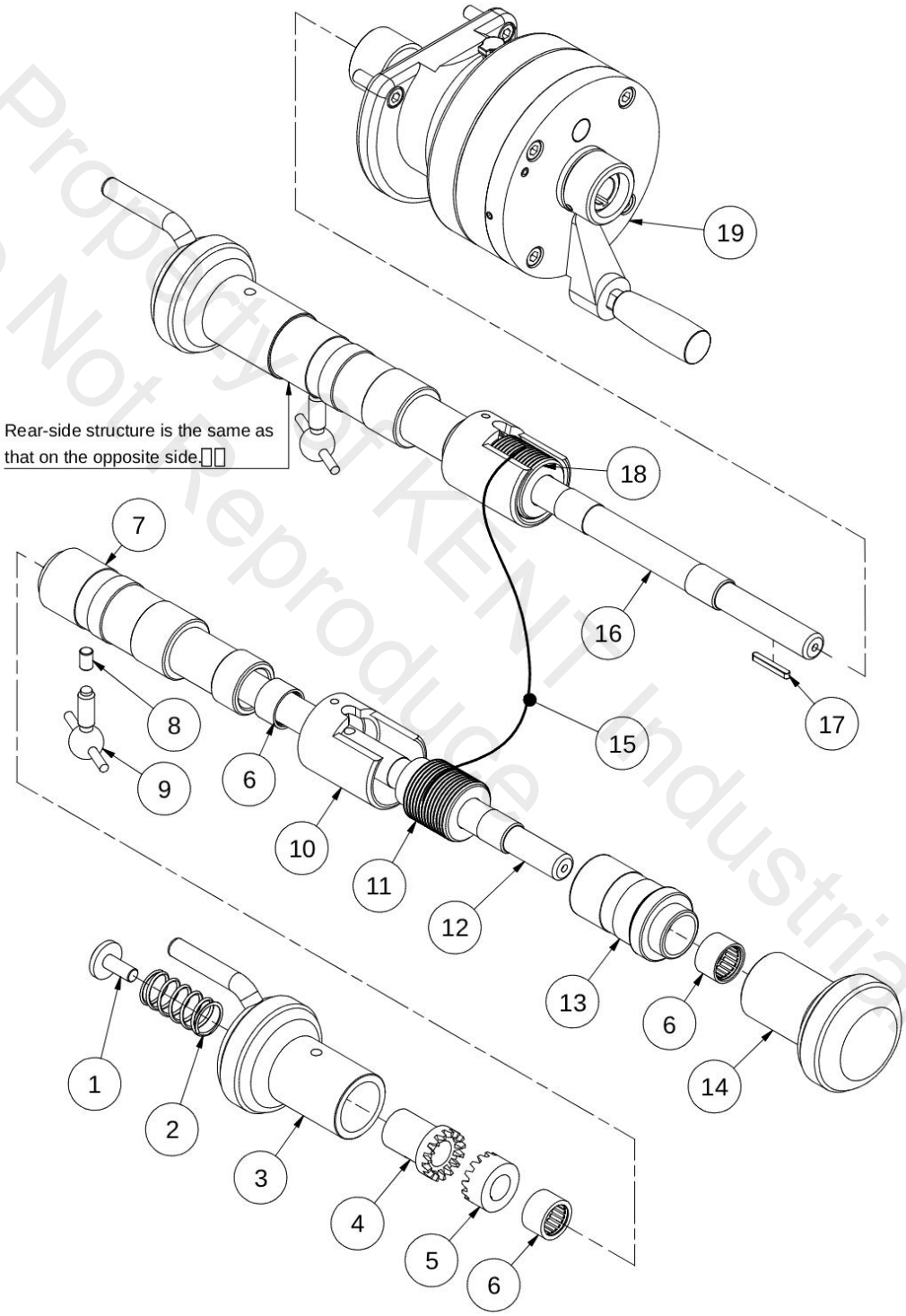
No.	Part Number	Description	Specification	Q'ty
1	3M42001669	Bridge base	L888*W280*H226(8 holes)	1
2	3M42005001	Stopper	L82*W34*H22	1
3	2AM4040004	Dog (Left)		1
4	2AM4030001	Dog (Right)		1
5	3M42002015	Ball race (Lower)	L884*W28*H18.8(Travel: 400)	2
6	3M42004011	Groove stopper	L28*W18*H8	4
7	5GE011055	Flat spacer	M10	4
8	5GF011644	Hex screw	M10*35L	4
9	3M42022022	Adjusting block (Right)	L75*W44*H31	1
10	3M42118013	Plug block	D12*D1.9*L13	2
11	3M42015011	Ball race (Left)	L844*W28*H13.55(Travel 400)	1
12	3M42014018	Ball race (Right)	L844*W28*H18.8(Travel 400)	1
13	3M42003005	Ball retainer	L626.5*W25.5*H6	2
14	5GB050034	Steel Ball	Φ3/4"	40
15	3M42023012	Taper adjusting screw	D31*L222	1
16	3M42119016	Wire tension adjusting block	L46*W25*H18	1
17	3M42120003	Wire tension adjusting screw	D14*L78.5	1
18	3M42121006	Wire adjusting wheel	D26.5*D6.8*L25	1
19	3M42021003	Adjusting block (Left)	L91*W46*H31	1
20	3M42016001	Stopper washer	D19.5*D8*L11.5	4
21	3M42017017	Stopper	L28*W26*H12	4
22	3M42013073	Sliding worktable	L1332*W221*H72	1
23	3M42019000	Swivel scale plate	L220*W45*H5	1
24	3M42028017	Plug block	D25*L17.5	1
25	3M42024002	Taper adjusting nut	D25*L50.5	1
26	3M42025047	Taper adjusting plate	L220*W32.5*H8	1

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27	3M42026008	Taper adjusting pin	D16*L30	1
28	3M42039017	Fixing screw	D8*L12	1
29	3M42027014	Taper adjusting eccentric shaft	D16*L63	1
30	3M42018010	Angle scale	D200*D175*L2	1
31	3M42020000	Swivel center pin	D20*L51.5	1
32	3M45008014	T blot	L54*W22*H22	2
33	5GF030360	Hex screw	M12*1.75	2
34	3M49010303	Spacer	D24*D12.7*L4.5	2
35	3M42029081	Swivel worktable	L1049*W228*H44	1
36	5GF011343	Hex screw	M6*10L	2
37	3M42030007	Plug block	L24*W16*H6	2

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4.7 Workbench Supply



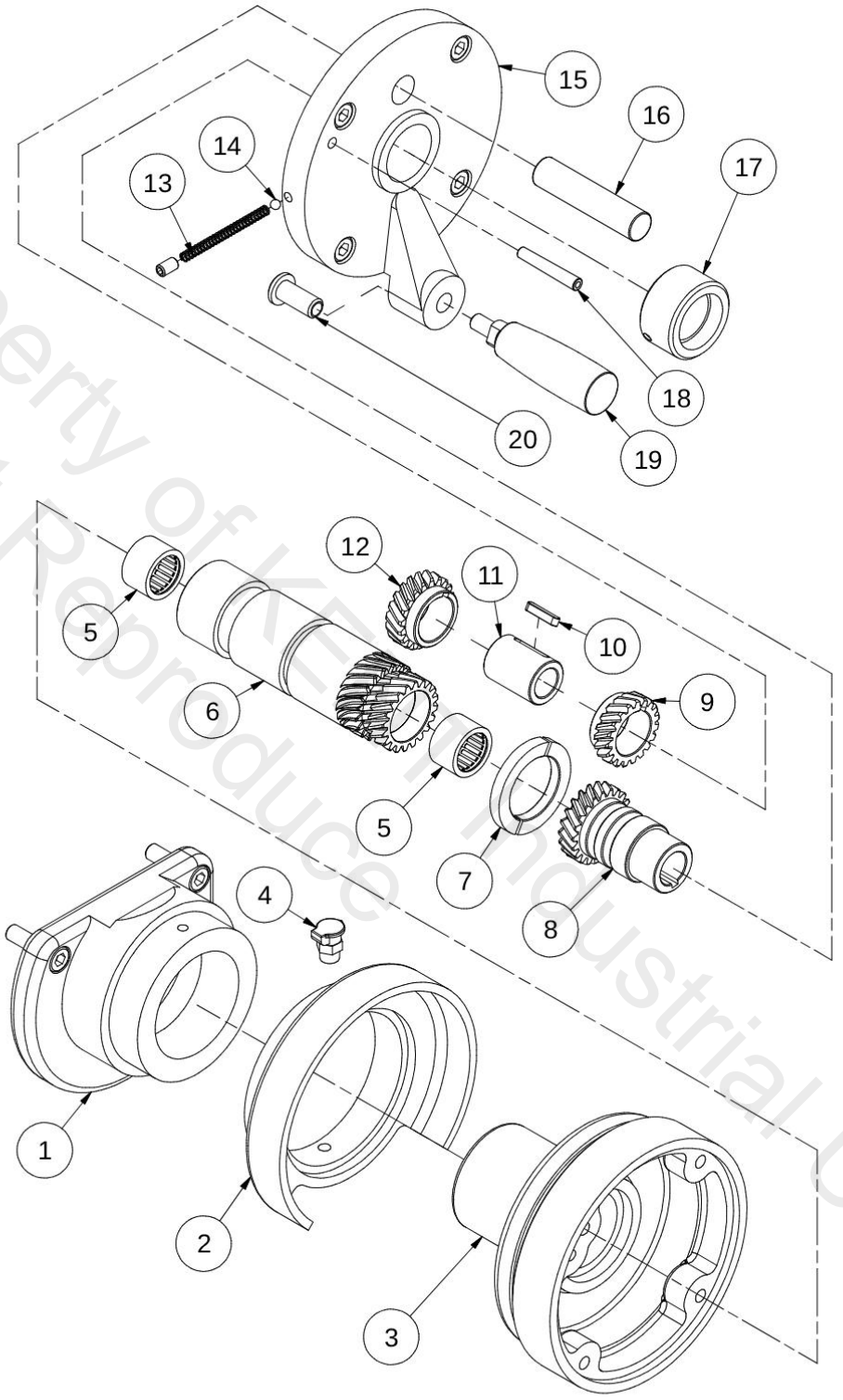
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Part list of Workbench Supply

No.	Part Number	Description	Specification	Q'ty
1	3M42114008	Spring adjusting screw	D24*L29.5	2
2	3M42113005	Spring	D23*D19*L47	2
3	3M42111009	Feed shaft handle	D72*D25*L92.5	2
4	3M42110035	Clutch (Front)	D32*D17*L42	2
5	3M42107026	Clutch (Rear)	D32*D17*L16.5	2
6	5GB010453	Needle bearing	HK2016 / TLA2016 (IKO)	5
7	3M42101015	Feel shaft sleeve	D40*D21*L167	2
8	3M42102005	Thin rod	D8*L12	2
9	3M42103011	Feed shaft lock bolt	L60*W50.5*H21	2
10	3M42104014	Reel sleeve	D50*D35*L60	2
11	3M42108003	Worktable adjusting reel (Left)	D39.7*D20*L47	1
12	3M42106036	Worktable feed shaft (Left)	D20*L435	1
13	3M42115001	Worktable feed sleeve	D45*D21*L74	1
14	3M42116017	Feed handle	D72*L87.5	1
15	3M42117010	Wire (M-40)	D1.8*L2221	1
16	3M42105033	Worktable feed shaft (Right)	D20*L525	1
17	6GC010311	Woodruff key	4*4*30L	1
18	3M42109006	Reel (Right)	D39.7*D20*L47	1
19	2AM4160052	Fine feed handle	Slow speed	1

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4.8 Fine Feed Handle Assembly



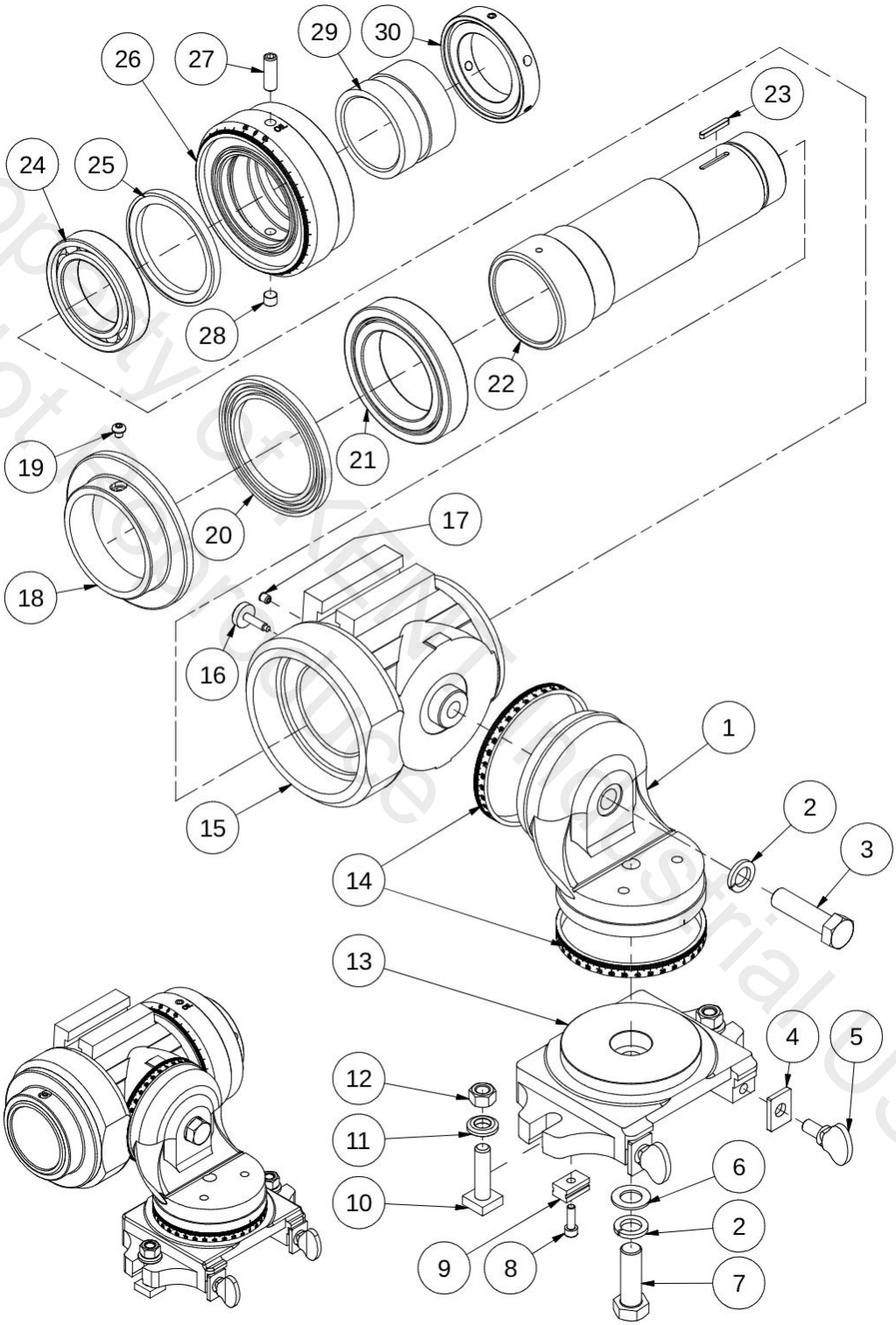
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Part list of Fine Feed Handle Assembly

No.	Part Number	Description	Specification	Q'ty
1	3M42201063	Fine feed bracket	L125*W112.5*H60	1
2	3M42203056	Feed fine adjusting base	D132*D80*L42	1
3	3M42202011	Fine feed base	D132*D40*L105	1
4	4GN010489	Oil cup	1/8PT (OC-118)	1
5	5GB010453	Needle Bearing	HK2016 / TLA2016 (IKO)	2
6	3M42204004	Helical gear sleeve	D40*D22*L137	1
7	3M42205104	Fine gear moving ring	D48*D33*L6	1
8	3M42210041	Fine helical gear	D39.37*D17*L58	1
9	3M42209025	Fine feed helical gear	D35.91*D23*L15	1
10	5GC010162	Woodruff key	4*4*20L	1
11	3M42208022	Bushing	D23*D15*L31	1
12	3M42207029	Fine feed helical gear	D37.64*D23*L16	1
13	3M42218003	Spring	D4.8*D3.6*L55 (Wire core: ø0.6)	1
14	5GB050555	Steel ball	Φ3/16"	1
15	3M42212018	Fine feed cover	L155*W132*H45.5	1
16	3M42206013	Fine gear arbor	D15*L65	1
17	3M42213008	Fine ger ring	D40.5*D26*L22	1
18	5GC031606	Inner thread taper pin	1/48-4#1-1/2L=38, Big end: 6.35	1
19	5GD020554	Swiveling handle	1011-23-M8	1
20	3M42212102	Fixing screw	D16*D6.8*L25.5	1

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4.9 Standard Accessory
Workhead



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Part list of Workhead

No.	Part Number	Description	Specification	Q'ty
1	3M45005073	Workhead swivel base	L146*W127.4*H115	1
2	5GE010065	Spring washer	16(Black Oxide)(16.4*26*3.5)	2
3	5GF014232	Hex screw	M16*60L	1
4	3M45006005	Clamping block	L30*W22*H4	2
5	3M45007008	Wing screw	L48*W35*H16	2
6	5GE011806	Flat washer	5/8=17*30*2.0(Galvanized)	1
7	5GF016092	Hex screw	M16*50L	1
8	5GF012003	Hex screw	M6*20L	2
9	3M45003019	Key	L25*W15*H11	2
10	3M45008014	T-shaped bolt	L54*W22*H22	2
11	3M49010303	Washer	D24*D12.7*L4.5	2
12	5GF030360	Hex nut	M12*1.75(Black Oxide)	2
13	3M45001071	Work spindle base	L206*W127.8*H47.5	1
14	3M45002016	Rotating seat scale ring	D115*D108*L11	2
15	3M45009075	Work spindle house	L160*W150*H136	1
16	3M45017005	Spindle fixing screw	D19.5*L30	1
17	5GB050131	Oil ball	Φ1/4	1
18	3M45016015	Front inner dustproof cover	D130*D82*L28	1
19	5GF010696	Hex socket head cap screws	M6*6L	1
20	3M45015012	Front inner dustproof ring	D115*D83*L7	1
21	5GB011725	Angular contact ball bearings	7015A TYXP5(NSK)	1
22	3M45010130	Work spindle	D82*D38.43*L255(NT50*MT5 taper hole (standard)	1
23	6GC010311	Parallel Keys	4*4*30L	1
24	5GB011563	Angular contact ball bearings	7012A5 TYN SU M P5	1

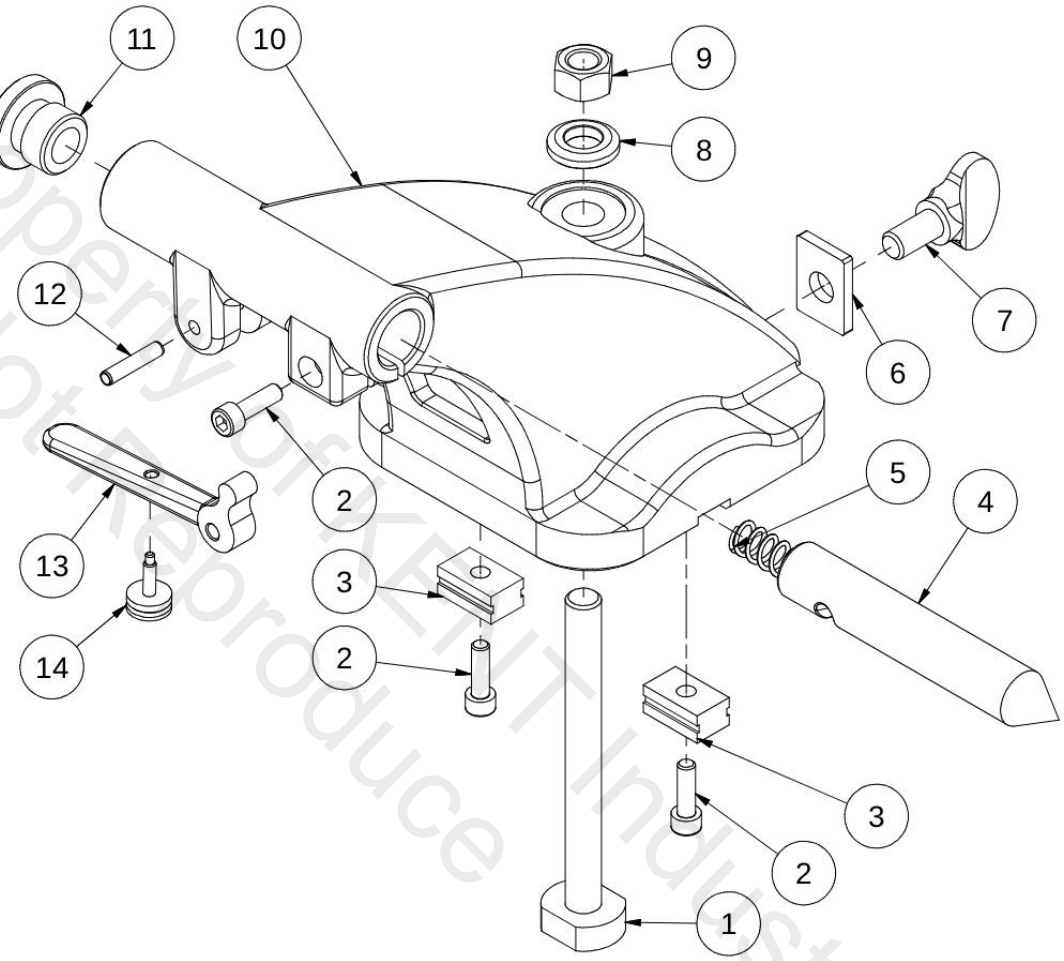
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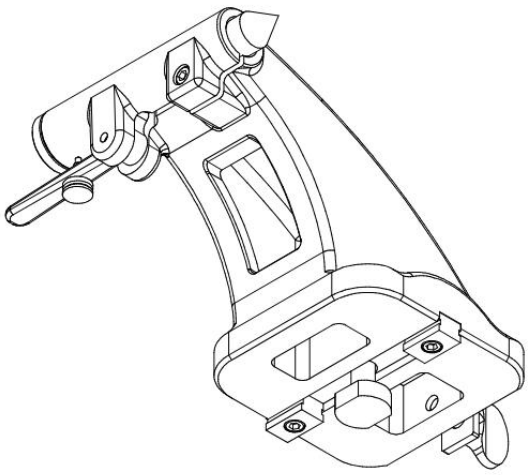
25	3M45012000	Front inner dustproof ring	D95*D76*L7	1
26	3M45013016	Rear inner dustproof cover	D130*D75*L52	1
27	5GF012692	Hex socket head cap screws	M10*30L	1
28	4GM011178	Plug	PT1/8-28 thread	1
29	3M45011007	Inner spacer	D75*D60*L55	1

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4.9 Standard Accessory

Right tailstock





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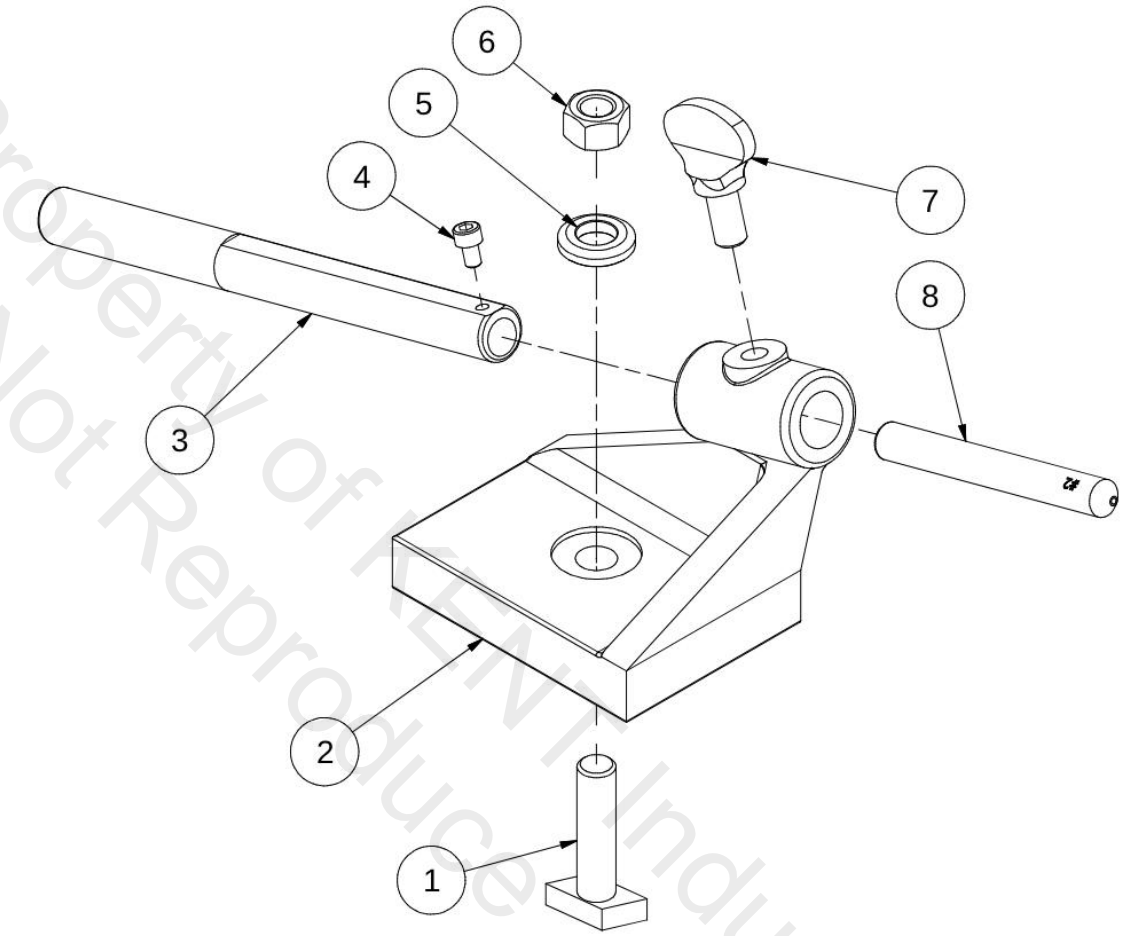
Part list of right tailstock

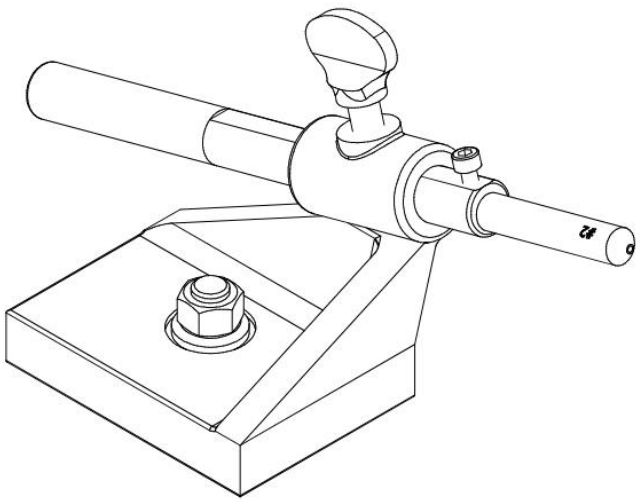
No.	Part Number	Description	Specification	Q'ty
1	3M45107001	T-shaped bolt	D28*L133	1
2	5GF012003	Hex socket screw	M6*20L	3
3	3M45003019	Key	L25*W15*H11	2
4	3M45102022	Center	D20*L122	1
5	3M45104002	Spring	D12*D9*L56	1
6	3M45006005	Clamping block	L30*W22*H4	1
7	3M45007008	Wing screw	L48*W35*H16	1
8	3M49010303	Spacer	D24*D12.7*L4.5	1
9	5GF030360	Hex nut	M12*1.75	1
10	3M45101032	Right tailstock	L211.25*W147*H140.25	1
11	3M45105005	Screw nut	D32*L22	1
12	5GC030056	Spring pin	5*25	1
13	3M45103012	Lever	L91.5*W29*H14	1
14	3M45106008	Fixing screw of lever	D15*L22	1

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4.9 Standard Accessory

Diamond Dresser Holder





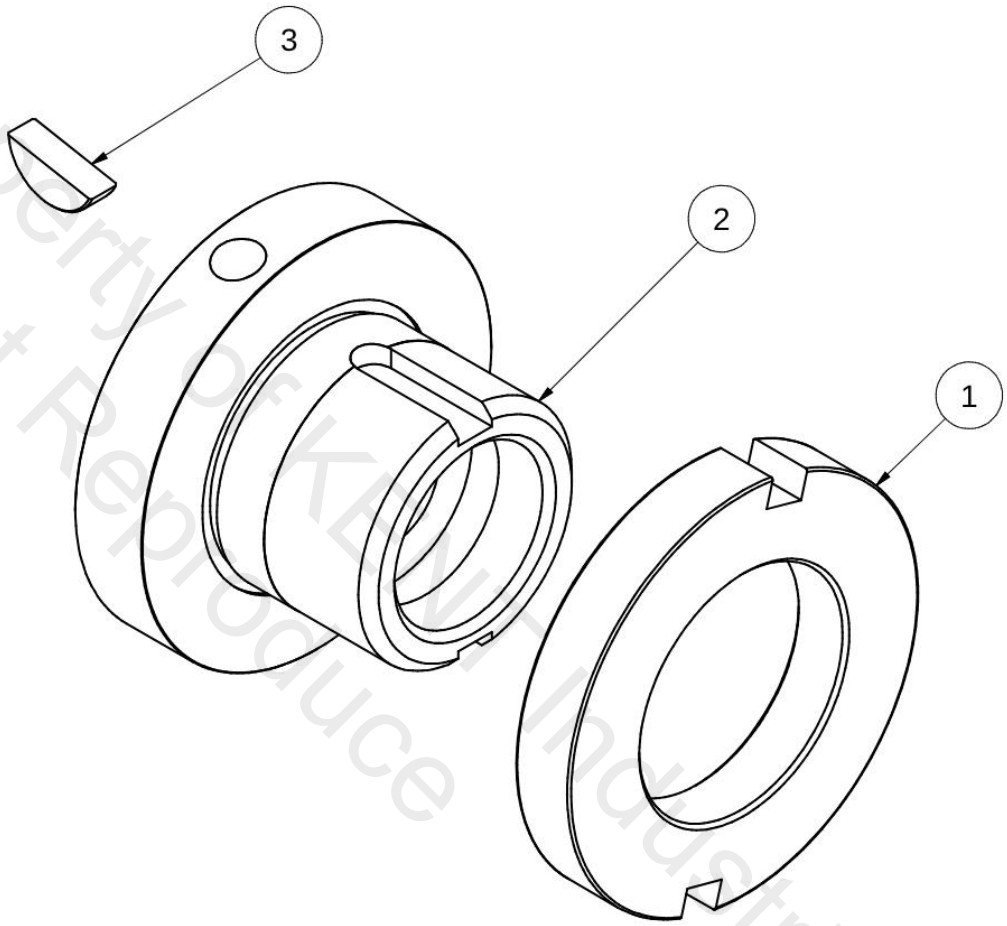
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Part list of Diamond Dresser Holder

No.	Part Number	Description	Specification	Q'ty
1	3M46004006	Taper T-shaped bolt	L56*W29.51*H13	1
2	3M46001007	Dressing holder support seat	L153*W133.69*H76	1
3	3M46002000	Dressing rod	D18*L200	1
4	5GF014562	Hex socket screw	M5*8L	1
5	3M49010303	Spacer	D24*D12.7*L4.5	1
6	5GF030360	Hex nut	M12*1.75	1
7	3M45007008	Wing screw	L48*W35*H16	1
8	4GP070850	Dressing pen	2#	1

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4.9 Standard Accessory
Grinding Wheel Flange (10°30' & 9°27'/ø31.75)



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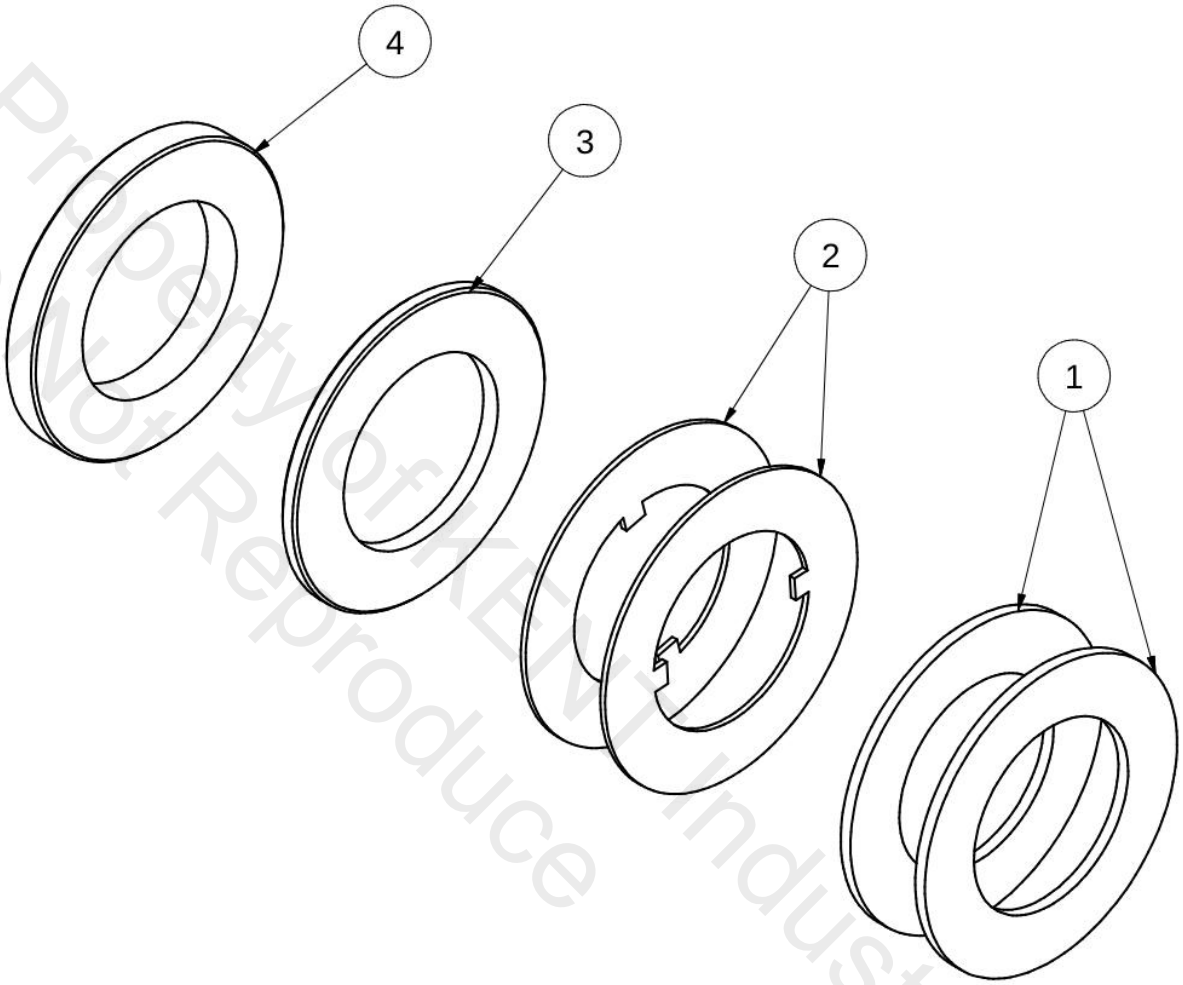
Part list of Grinding Wheel Flange

No.	Part Number	Description	Specification	Q'ty
1	3M46042202	Flange nut	D52*D30.2*L8	1
2	3M46098001	Grinding wheel flange (10°30'/Φ31.75)	D52*D14.22*L33.5	Choose one
	3M46098108	Grinding wheel flange (9°27'/Φ31.75)	D52*D15.01*L33.5	
3	5GC010243	Woodruff key	4*13	1

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4.9 Standard Accessory

Set of Grinding Wheel Washer (Φ31.75)



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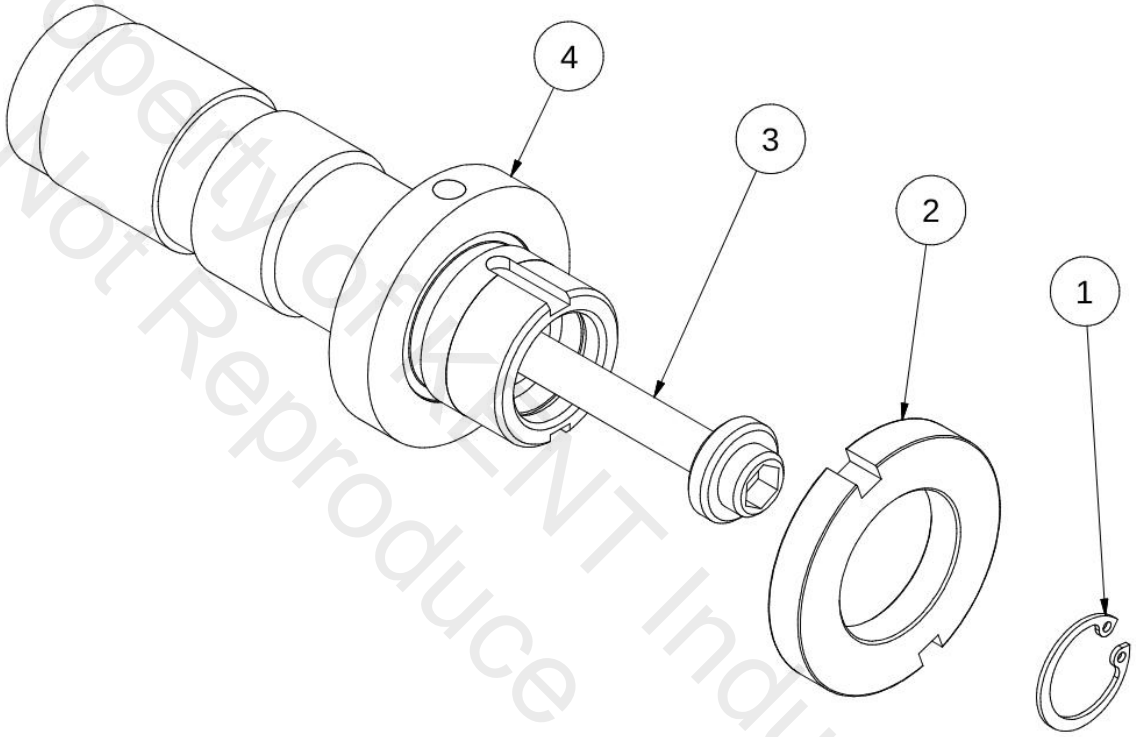
Part list of Set of Grinding Wheel Washer (Φ31.75)

No.	Part Number	Description	Specification	Q'ty
1	3M46051002	Washer (NBR)	D52*D31.8*L2	2
2	3M46052500	Washer (Metal shim)	D52*D32*L1	2
3	3M46054001	Washer	D52*D31.8*L3	1
4	3M46053008	Washer	D52*D31.8*L6	1

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4.9 Standard Accessory

4'' Grinding Wheel Extension (10°30' & (9°27' x Φ31.75)



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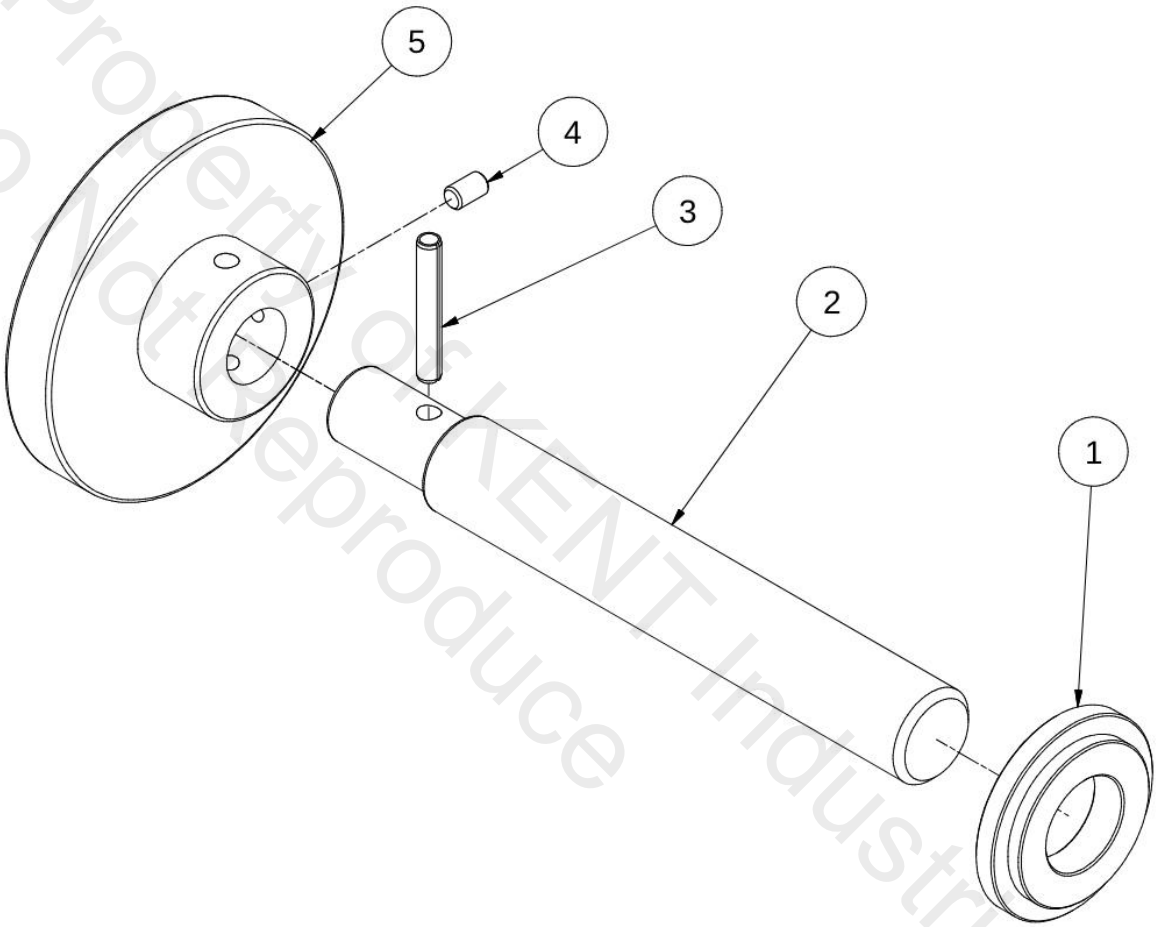
Part list of 4” Grinding Wheel Extension (10°30' & (9°27' x Φ31.75)

No.	Part Number	Description	Specification	Q’ty
1	5GC020172	C-clip	R-22	1
2	3M46042202	Wheel flange nut	D52*D30.2*L8	1
3	3M46057000	Screw bolt	D20*L125.5(115.5mm)	1
4	3M46055114	4" Grinding Wheel Extension	D52*D16*L126.5 (**10˚30'**/Φ31.75)	Choose one
	3M46055224	4" Grinding Wheel Extension	D52*D16*L126.5 (**9˚27'**/Φ31.75)	

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4.9 Standard Accessory

Draw-in Bolt for Workhead and Spacer (Inch thread)



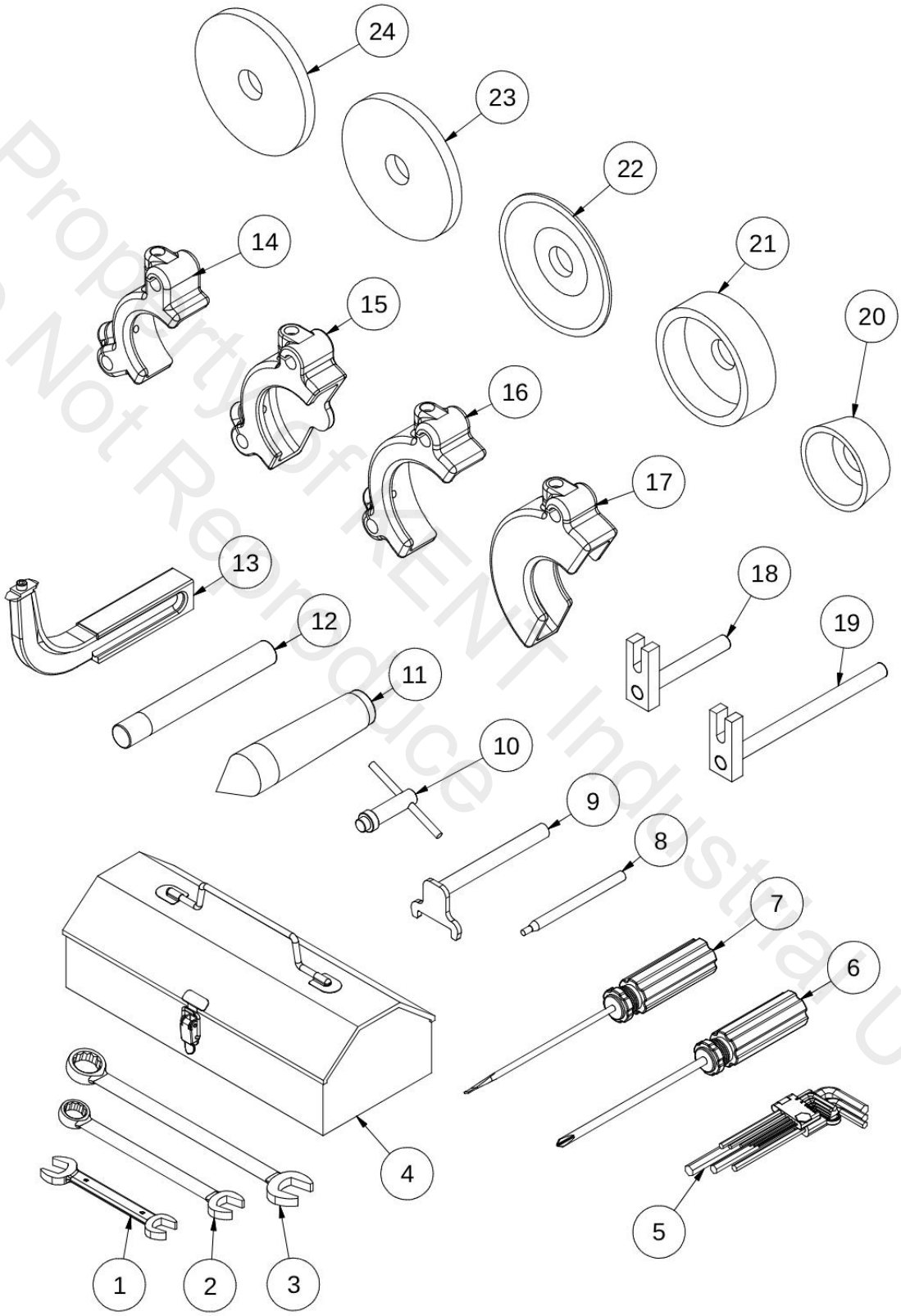
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Part list of Draw-in Bolt for Workhead and Spacer (Inch thread)

No.	Part Number	Description	Specification	Q'ty
1	3M46064008	Draw-in bolt spacer (MT5)	D54.4*D25.5*L10	1
2	3M46062028	Draw-in bolt (1"-8 thread)	D25.4*L196	1
3	5GC030690	Sprin pin	6*40	1
4	5GF015219	Hex nut screw	M6*10L	1
5	3M46063021	Draw-in bolt handle	D100*D20*L35	1

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4.9 Other Standard Accessories



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4.9 Other Standard Accessories

No.	Part Number	Description	Specification	Q'ty
1	4GP010285	**A26:** Open End Wrench	17*19	1
2	4GP010188	**A27**: Combination Wrench	19	1
3	4GP010201	**A28**: Combination Wrench	24	1
4	4GP070847	**A29**: Tool Box & Adjusting Tools	350*148*107	1
5	4GP013103	**A29**: Allen Wrench	1.5、2、2.5、3、4、5、6、8、10	1
6	4GP012252	**A29:** Screw Driver (+)	#2*200mm	1
7	4GP012249	**A29**: Screw Driver (-)	1.2*6.5*200mm	1
8	3M46025003	**A25**: Fixture Rod	D10*L135	1
9	3M46019105	**A24**: Collet Wrench	L149*W63.5*H52	1
10	3M46024000	**A23:** Wheel Spanner	L100*W70*H20.5	1
11	4GQ030328	**A06**: Center for Workhead Spindle	MT5	1
12	3M46022004	**A05**: Ejector Rod	D25*L200	1
13	2AM4320016	**A04**: Center Gauge		1
14	2AM4281007	**A09**: Wheel Guard	The Max. O.D of G.W: ø90	1
15	2AM4271004	**A10**: Wheel Guard	The Max. O.D of G.W: ø110	1
16	2AM4261001	**A11**: Wheel Guard	The Max. O.D of G.W: ø125	1
17	2AM4251008	**A12**: Wheel Guard	The Max. O.D of G.W: ø150	1
18	2AM4300003	**A13**: Wheel Guard Holder (Short)		1
19	2AM4290003	**A14**: Wheel Guard Holder (Long)		1
20	4GP020664	**A17**: Grinding Wheel	90D*38T*31.75H(PA60J8V11A)	1
21	4GP020680	**A18**: Grinding Wheel	125D*38T*31.75H(GC100IJMV6A)	1
22	4GP020635	**A21**: Grinding Wheel	150D*19T*31.75H(WA60JMV12A)	1
23	4GP020648	**A19**: Grinding Wheel	150D*13T*31.75H(WA60K8V1A)	1
24	4GP020651	**A20**: Grinding Wheel	150D*13T*31.75H(GC100IJMV1A)	1

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