



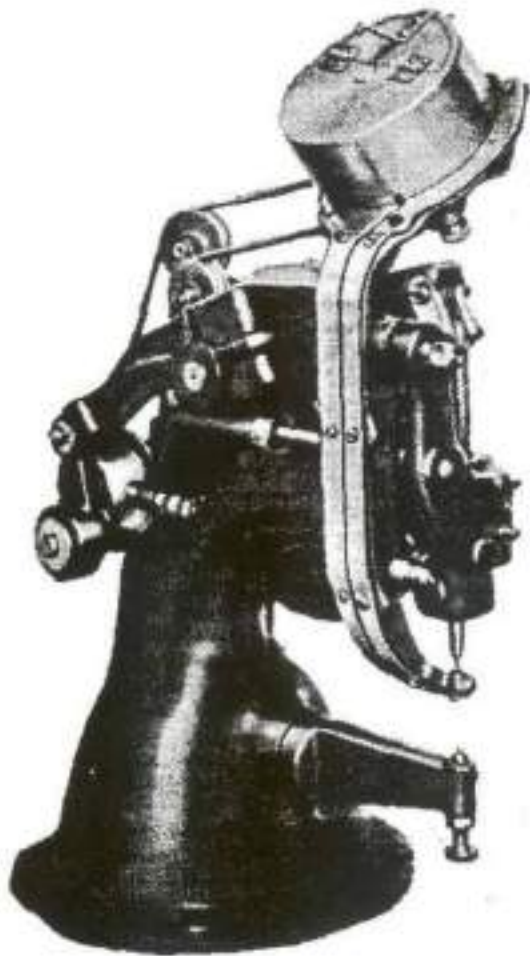
8 Rosol Lane Ext  
P.O. Box 921  
Saddle Brook, NJ 07663  
800-393-5381

*Serving Industry for Over 50 Years*

**EYELETS - RIVETS - GROMMETS & WASHERS  
SETTING DIES - NEW AND REBUILT MACHINES**

**CALL 1-800-EYELET 1**

## MODEL "B" EYELET MACHINE



The Model "B" machine is a versatile eyeletter capable of auto feeding and setting very small electronic size eyelets up to an A500 size eyelet (5/16 inch hole). Raceways and setting tools are easily interchangeable to accomidate different size eyelets. All machines come mounted to a table with a 110 volt motor. A safety enclosure and an electronic ring guard safety device are also available. The Model "B" is a single stroke machine and is best suited for prepunched work or can be used with a spear point bottom die.

### DIMENSIONS:

Height: 22 inches  
Width: 15 inches  
Depth: 18 inches  
Weight: 75 pounds  
Throat Depth: 7 inches  
Stroke: 2 1/4 inches



# **CAUTION**

**We recommend reading the entire instructions before installing or operating this machine. Mishandling can result in injury to personnel or damage to the machine.**

**It is mandatory to shut off electric power before adjusting or handling moving parts, cleaning machine or removing any guard.**

**Because of vibration imposed during transportation, it is possible that loosening of components and adjustments can occur.**

**Before installation or operating the machine, the entire machine should be carefully inspected for loose fasteners and adjustments. If any are found, they should be tightened and corrected before operating the machine.**



# **OPERATOR SAFETY PRECAUTIONS**

Handout for Anyone Operating This Machine

**Before You Operate This Machine  
You Must Read and Understand  
These Safety Precautions**

**! DANGER**



**NEVER**  
**Place Your Hands**  
**or Any Part of**  
**Your Body in This**  
**Machine**

See Reverse Side for Other Safety Precautions.

**OVER** 



# Do Not Operate This Machine Until You Read and Understand the Following Safety Precautions.

- 1 **Never** operate this machine until you understand that this machine is dangerous and if you place your hands or any part of your body in this machine it could result in the loss of fingers, limbs or even death.
- 2 **Never** operate this machine without the use of a guard or safety device that will always protect you from bodily injury.
- 3 **Never** use a foot switch to operate this machine unless a point of operation guard or device is provided and properly maintained.
- 4 **Never** "ride" the foot pedal or foot switch. Never rest your foot on top of the foot pedal or inside the foot switch. Always remove your foot completely from the foot pedal or foot switch after each cycle and any time you are not intending to trip the machine.
- 5 **Always** use hand tools for feeding or retrieving material from the point of operation or any other hazardous part of the machine. Never reach through or into die area for any reason.
- 6 **Never** operate this machine unless you feel you have been fully trained and have received and understand all operating instructions. Make sure you know how the machine works and how it is controlled.
- 7 **Never** operate this machine until you test the machine with its guard or safety device before you start or re-start production. Do not begin operating the machine unless you are sure the safeguarding is adjusted properly and working correctly. If you are not sure call your supervisor.
- 8 **Never** operate this machine if it is not working properly or if you notice any unusual noise or change in the performance of the machine. Stop operating the machine immediately and advise your supervisor.
- 9 **Never** operate this machine with pullbacks unless they are adjusted properly for you. Have your supervisor show you manually that when the ram descends the pullbacks will pull your fingers clear of any pinch points. Always wear your wristlets properly and securely.
- 10 **Never** operate this machine with pullbacks without reading and understanding the instructions. Instructions must be kept with the pullback device at all times and made available to you. Obtain, read and follow these instructions.
- 11 **Never** operate this machine unless two-hand trip, two-hand control or presence sensing device are installed correctly and at the proper safety distance. Consult your supervisor should you have any questions regarding the proper safety distance.
- 12 **Never** tamper with, rewire or bypass any control, component or safeguard on this machine.
- 13 **Always** wear safety glasses, ear protection and any other personal protection equipment needed when operating this machine.
- 14 **Be sure** all persons are clear of the machine before it is cycled, especially when multiple operators are present. Do not operate machine unless you and every operator and/or helper are protected from injury by a guard or safety device.
- 15 **Always** stay alert (don't daydream) and never operate this machine while under the influence of alcohol or any other drug including prescription medications.
- 16 **Maintenance and Die Set-Up Personnel:** **Never** work on this machine unless power is off, flywheel is at rest, safety blocks are used between dies, ram and bolster plate and all energy (electrical, air, hydraulic, etc.) are in a zero state.

**NOTICE TO EMPLOYER:** A copy of this "Operator Safety Precautions" must be given to all operators (including set-up people, maintenance personnel and supervisors) of this machine. A copy should also be hung on the machine readily accessible and visible to the operator. Additional copies of this precaution are available upon request. Just call or write.

**IMPORTANT:** Where a language barrier or insufficient schooling would prevent a person from reading and understanding the contents of this Operator Safety Precaution, you should either translate this information or have it read or interpreted to the person, with assurance that it is understood.

THIS PRECAUTION MUST BE REVIEWED DAILY.

## HOW TO CHANGE THE RACEWAY AND DIES

\*\* Before doing the following steps, make sure the machine is in the off position.

1) Pull off the Raceway Belt.

2) Take the cotter pin off the back of the bottom link pin and pull pin out.

3) While holding the raceway with your left hand, loosen the square head bolt, securing the upper link pin, and pull out pin.

4) Loosen the allen set screw on the bottom arm and pull out die.

5) Next, hit the pedal and turn the wheel towards you by hand so that the driving arm comes down all the way. On the right side, loosen the allen set screw - the top die and spindle will pop out. There is also a spring that will come out. This spring is going to be used with the other dies.

6) Insert the new top die and spindle, with the spring, and lock the screw. Then turn the machine by hand until the starting pin locks in place. If necessary, turn the knob to lock the pin.

7) Insert the bottom die and lock the screw.

Note: On the raceways, the top eccentric is set for both, so you shouldn't have to adjust that at all.

8) Install the new raceway with the upper link first, inserting it through the eccentric sleeve. Then lock the square head bolt. Now, push the raceway in until the swinging link (on the right side) goes in between the raceway links. Insert bottom link pin when holes line up. Install new cotter pin on the back of this link.

9) Adjust the raceway (to pick-off correctly). Make adjustments front or back and left or right until the spindle lines up with the hole of the eyelet.

10) To adjust the front or back pick-off, loosen the square head bolt which is 2 inches below the upper link pin square bolt) so the raceway can move freely. Also, loosen the set screw (holding the eccentric in the raceway upper link). Now position the raceway so the top spindle is in line with the hole of the eyelet. You may have to tap the raceway lightly to get it to move over. Lock the set screw first. While the square head bolt is still unlocked, adjust the raceway left or right until the spindle lines up with the hole of the eyelet. Then hold the raceway firmly in place and lock the square head bolt.

11) Make sure the eyelet picks out of the raceway correctly - turn the machine over by hand, to check eyelet pick-off. The top die shouldn't hit the tip of the raceway at all. If it does, you will have to make the proper adjustments again until correct.

12) When properly adjusted, make sure the raceway is fastened securely and all screws are tight.

13) When hooking up the raceway feed belt, make sure the pulley turns counter clockwise (when looking at the raceway from the front). If it doesn't go in the right direction, just twist it and install it back on the pulley. It will then turn in the opposite direction.

14) Before running the machine, make sure again that eyelet pick-off is correct. To double check your work, turn the machine over by hand a few times until confident.

\*\* To adjust bottom die pressure, loosen the locknut below the bottom arm and loosen the allen set screw. Turn the big screw left or right to raise or lower the bottom die. Then lock the allen set screw and locknut when proper pressure is achieved.



## OPERATIONAL /MAINTENANCE

### WARNING - IMPORTANT

Read and understand thoroughly all of the information and instructions contained in this manual prior to setting up, operating, or adjusting this machine. Contact Siska, Inc. at once if there are any questions as to safety or operation.

This machine is built to give many years of trouble free service if maintained and operated as instructed. Your machine has been adjusted for the sample work or blueprint submitted with your order; performance tested and is ready for operation. Tools and pockets are made to order. To avoid any unnecessary downtime, it is suggested you keep a spare set of tools and pockets on hand at all times.

**CAUTION:** USE CARE IN REMOVING THE MACHINE FROM ITS CRATE AND PACKING. DO NOT MOVE OR LIFT THE MACHINE BY ITS HOPPER BOX, ROADWAY OR GUARDS.

Power to the machine must be off while lubricating, cleaning, loading, adjusting or repairing the machine.

#### LUBRICATION:

WARNING: NEVER ATTEMPT TO LUBRICATE MACHINE WHILE IT IS IN OPERATION. AVOID PINCH POINTS.

Lubricate periodically in accordance with instructions listed below. Most maintenance problems begin with indifferent attention to lubrication. All oil holes, oiling areas, and grease fittings have been *painted red* for convenience in locating lubricating points.

Lubricate as follows:

- a. Grease fittings weekly with an NLGI #2 multi-purpose lithium based grease.
- b. Oil holes and oil areas weekly with SAE-40, extreme pressure treated oil.
- c. Cam weekly with Lubricate - extreme pressure lubricant or equivalent.

**DO NOT OVER LUBRICATE:** Excess oil, if not wiped clean, will only lead to an accumulation of dust and other abrasive particles causing premature wear and improper functioning of the machine.

**NEVER LUBRICATE:** Box carrier roadway and box, these parts must be absolutely free of oil and grease. All points requiring lubrication are provided with oil cups or access holes, except the plunger and pivot points where pins are installed. A drop or two of oil in these areas is sufficient.

#### V BELTS

V belt grooves in motor pulley and flywheel should be in line for proper running of machine. Proper tension of V belt will be maintained if deflection is between 1/4" and 3/4".

#### FLYWHEEL

To tighten the flywheel and motor belts, locate belt hook on the belt. Remove belt hook. Cut off 1/2" from one end of the belt. Punch a hole 14" from the end and in the center of the belt. Connect the two ends back together with the belt hook and close hook. Repeat process if necessary.

#### RACEWAY BELT

To tighten the raceway belt, locate where the belt is locked together. Pull apart, cut 1/2" off the belt. Press it back onto the interlocking pin until the two ends meet. If the belt is still loose, repeat process.

### **BOTTOM DIE ADJUSTMENT**

To adjust bottom die pressure, loosen the bottom die adjusting locknut directly under the die on the bottom of the arm. Then loosen the allen set screw which is located on the side of the bottom arm, parallel to the die. Turn the bottom die adjusting screw on the bottom of the arm a 1/4 of a turn (Clockwise to raise the die and Counter clockwise to lower the die). Lock the bottom die adjusting locknut and allen set screw. Cycle machine once by hand. If the setting thickness is still not correct, repeat process.

### **DO'S AND DON'TS**

1. *DO lubricate regularly as recommended below.*
2. *DO clean machine regularly. If compressed air is available, blow out dirt, dust, lint, chips, etc.*
3. *DO check all springs periodically. These parts are inexpensive and should be considered expendable. The springs used in this machine are designed for long wear and hard use, but springs in constant use will sometimes take a set. Most efficient operation will be maintained by replacing springs regularly.*
4. *DO NOT lift by or pull on raceway when moving machine.*
5. *DO NOT operate machine at higher speeds than indicated.*
6. *DO NOT change the eyelets for which your raceway and tools have been built without checking dimensions. Eyelets of different dimensions will usually require completely new raceway and tools.*
7. *DO NOT force eyelets in hoppers and raceways. If eyelets do not move easily, check dimensions. Constant prying with hard objects will distort the hopper opening and tracks necessitating expensive replacement.*
8. *DO NOT fill hopper box more than 1/3 to 1/2 full.*
9. *DO NOT use an oily lubricant on eyelets.*
10. *DO NOT operate machine without approved safety device and all guarding in place. Check frequently that safety devices are in proper working order and adjustment.*



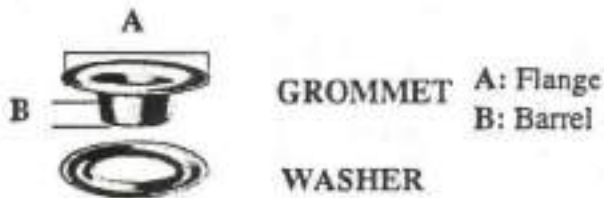
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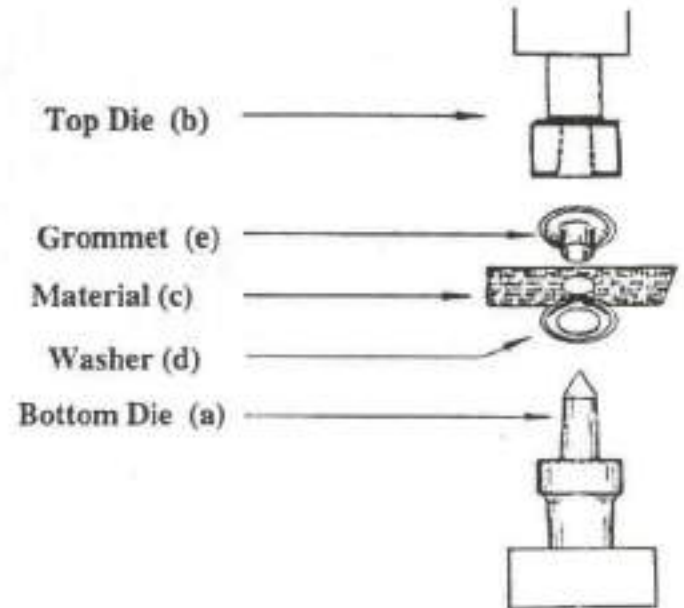
## PIERCE POINT / SETTING DIE PROCEDURE



Roll set



Scored set



The following procedure is for setting grommets and washers with a pierce point / setting die combination. Eyelets may be substituted for grommets in this procedure. If the material is stiff enough to hold with a roll setting, or a scored setting is being used, the washer does not have to be used and may be eliminated from the procedure. The bottom die (part "a") will be identified as being the male part and the top die (part "b") will be identified as the female part.

The washer (part "d") will be placed on the bottom die (a) with the concave or dish side facing upward. The material being used (part "c") will be pulled down over the pointed male part of the bottom die (a). The grommet (part "e") should then be placed on the bottom die with the barrel pointing downward. **Be sure that your hands are kept clear of the dies and all moving parts to prevent injury.** At this point the machine should be cycled, having the top die (b) force the grommet (e) by its flange down the bottom die stud. In its travel downward, the grommet (e) will pass down through the material (c), through the washer (d) engaging the bottom die seat (a) and rolling over on the back side of the washer (d) completing the setting.

USMC EYELETING MACHINE - MODEL B  
(SYMBOL UEB)

THE USMC EYELETING MACHINE - MODEL B IS FITTED WITH A 9-1/8" GROOVED CLUTCH PULLEY. THIS PULLEY SHOULD BE SPEEDED 225 REVOLUTIONS PER MINUTE.

TABLE OF PULLEYS FOR DRIVING MACHINE

REVOLUTIONS OF MAIN SHAFT	NUMBER OF PULLEY FOR DRIVING MACHINE
350	PE-568+5-3/4"
400	PE-568+5"
450	PE-568+4-1/2"
500	PE-568+4"
550	PE-568+3-1/2"
600	PE-568+3-1/2"
650	PE-568+3"

5/16" ROUND BELTING REQUIRED

LUBRICATION

CAREFUL ATTENTION SHOULD BE GIVEN TO THE PROPER LUBRICATION OF THIS MACHINE. WE RECOMMEND THE USE OF USMC 15GA OIL FOR ALL PURPOSES.

READ THESE SPECIAL INSTRUCTIONS BEFORE  
ORDERING PARTS

ALL LETTERS THAT APPEAR IN CONNECTION WITH A NUMBER IN THIS CATALOG, WHETHER BEFORE OR AFTER IT, SHOULD ALWAYS BE GIVEN IN ORDERING PARTS, AS "NL-89K" AND NOT "89K" OR "89", AND "NLN-48" AND NOT "48".

AS IT IS NOT PRACTICABLE, OWING TO THE SMALL SIZE OF SOME OF THE PARTS, TO MARK THE INITIAL LETTERS ON THEM, IT IS BEST TO ALWAYS CONSULT YOUR CATALOG AND OBTAIN THE FULL NUMBER BEFORE ORDERING DUPLICATE PARTS--THE NUMBER MARKED UPON THE BROKEN PART SERVING TO IDENTIFY IT IN THE CATALOG. COIL SPRINGS HAVE NO NUMBERS STAMPED ON THEM.

IN ORDERING PARTS CATALOGED WITHOUT INITIAL LETTERS BEFORE THE NUMBER, ALWAYS PREFIX THE SYMBOL OF THIS MACHINE.

IN ORDERING BY MAIL, IT IS BEST TO GIVE THE NAME OF THE PART, AS GIVEN IN THIS CATALOG, AS WELL AS THE WHOLE NUMBER, BUT IF ORDERING BY TELEGRAM, THE NAME OF THE PART MAY BE OMITTED EXCEPT WHEN IT CAN BE GIVEN WITHOUT EXTRA CHARGE.

SPECIAL INFORMATION

NOTE QUANTITY OF PARTS USED IS ONE (1) UNLESS OTHERWISE NOTED BY THE NUMBER IN PARENTHESIS AFTER THE NAME OF PART.

USMC EYELETTERING MACHINE - MODEL B  
(SYMBOL UEB)

CLASSIFIED LIST OF PARTS

FRAME PARTS

PLATE

1A+ FRAME - ASSEMBLED WITH 1-PL-1763P, 1-PL-64P, 1-PL-1223P  
 PL-1763P PIN, THROWOUT LEVER SPRING  
 PL-64P PIN, THROWOUT LEVER STOP  
 PL-1223P PIN, SET DIE HORN DOWEL  
 SL-1511V SCREW, FRAME LAG (4)

DRIVING PARTS

101 SHAFT, MAIN 1  
 FL-153M FELT, MAIN SHAFT OIL 1  
 4DA WHEEL, MAIN SHAFT HAND 1  
 PL-1190P PIN, HAND WHEEL  
 106+ PULLEY, DRIVING - ASSEMBLED  
 WITH 4-37A  
 37A PIN, DRIVING PULLEY CLUTCH (4) 1  
 4 BUSHING, DRIVING PULLEY 1  
 70A HUB, CLUTCH 1  
 71+ PIN, CLUTCH STOP - ASSEMBLED 1  
 WITH 1-PL-3868P  
 PL-3868P PIN, STOP PIN LOCATING  
 SL-4544V SCREW, STOP PIN RETAINING  
 SPGL-2062S SPRING, CLUTCH STOP PIN  
 (COMPRESSION 11/32" X 1-1/8",  
 .024" DIA. WIRE)  
 PL-925P PIN, CLUTCH HUB TAPER 1  
 39 PIN, CLUTCH HUB LOCK  
 SPGL-1676S SPRING, LOCK PIN (COMPRESSION  
 21/64" X 1-3/16", .026" DIA. WIRE)



USMC EYELETTERING MACHINE - MODEL B  
(SYMBOL UEB)

DRIVING PARTS - CONT'D

PLATE

SL-5134V HANDLE, LOCK PIN  
 DOG, CLUTCH  
 PL-1419P PIN, DOG TAPER  
 SPGL-3665 SPRING, CLUTCH DOG (COMPRESSION  
 17/64" X 1-9/16", .032" DIA.  
 WIRE)  
 PIN, CLUTCH DOG - ASSEMBLED WITH  
 1-PL-6891P  
 PIN, DOG PIN SPRING  
 PL-6891P ROD, STARTING  
 10 COLLAR, STARTING ROD  
 CL-106J SCREW, COLLAR SET  
 SL-3194V SPRINGS, STARTING ROD (COMPRESSION  
 SPGL-3325 35/64" X 2-3/4", .0625" DIA.  
 WIRE)

SET CAP OPERATING PARTS

4BA PLUNGER, SET CAP (REGULAR)  
 165A PLUNGER, SET CAP  
 166 END, PLUNGER  
 PL-585P PIN, PLUNGER END  
 190 SPRING, PLUNGER  
 \*167A PLUNGER, SET CAP (WITH SPRING  
 YIELD) - COMPLETE, VIZ:  
 1-165A, 1-166, 1-PL-585P,  
 1-190  
 \*64A PLUNGER, SET CAP (FOR TWIN  
 EYELETS, USE WITH NO. 63)  
 SL-1296 SCREW, SET CAP BINDING (HEX.  
 SOCKET SET SCREW - FLAT 1/4"-  
 28NF X 1/4")  
 SPGL-1192S SPRINGS, SET SPINDLE (REGULAR)  
 (COMPRESSION .290" X 2-7/8",  
 .029" DIA. WIRE)  
 \*SPGL-6719S SPRING, SET SPINDLE (COMPRESSION  
 3/8" X 2-3/8", .042" DIA. WIRE)  
 13 LINK, SET CAP PLUNGER (2)

SET CAP OPERATING PARTS - CONT'D

PLATE

SL-3021V SCREW, PLUNGER LINK (2)  
 NL-475K NUT, LINK SCREW (2)  
 NL-304K CHECKNUT, SCREW NUT (2)  
 WL-955T WASHER, LINK SCREW (2)  
 73A LEVER, SET CAP PLUNGER  
 FL-15M FELT, LEVER OIL (2)  
 #164 LEVER, SET CAP PLUNGER  
 PL-3086P PIN, LEVER FULCRUM  
 SL-3250V SCREW, FULCRUM PIN SET  
 134 ARM, PLUNGER CRANK  
 PL-1757P PIN, CRANK ARM CONNECTING  
 PL-705P PIN, CONNECTING PIN COTTER  
 WL-331T WASHER, CRANK ARM BINDING THRUST  
 SL-1995V SCREW, THRUST WASHER

HORN PARTS

183A+ HORN, SET DIE (REGULAR) -  
 ASSEMBLED WITH 1-SL-3647V,  
 1-NL-51K, 1-SL-1296  
 SL-3647V SCREW, SET DIE ADJUSTING  
 NL-51K NUT, ADJUSTING SCREW  
 SL-1296 SCREW, SET DIE BINDING (HEX.  
 SOCKET SET SCREW - FLAT  
 1/4"-28NF X 1/4")  
 \*41A+ HORN, SET DIE (FOR FLASHLIGHTS) -  
 ASSEMBLED WITH 1-SL-1296  
 SL-1296 SCREW, SET DIE BINDING (HEX.  
 SOCKET HEAD CAP SCREW 1/4"-28NF  
 X 5/8")  
 \*SL-1180V SCREW, SET DIE HORN BINDING  
 \*184+ HORN, NUM (FOR RADIO WORK) -  
 ASSEMBLED WITH 1-SL-561V,  
 SL-561V 2-SL-1296  
 SCREW, SET DIE ADJUSTING

\* NOT SENT UNLESS ORDERED.  
 ### USED ONLY WITH EYELET BRUSH OSCILLATING  
 DEVICE.

## EYELET SETS - CONT'D

PLATE

HORN PARTS - CONT'D

PLATE

SL-12S10	SCREW, ADJUSTING SCREW SET (HEX. SOCKET SET SCREW - FLAT 1/4"-28NF X 3/8")		**EL-7 * **88	DIE, SET SET - COMPLETE (FOR FLASHLIGHT WORK OR CYLINDER WORK, REQUIRES HORN No. 41A+), VIZ: 1-EL-101, 1-EL-201, 1-EL-7	4
SL-12S10	SCREW, SET DIE BINDING (HEX. SOCKET SET SCREW - FLAT 1/4"-28NF X 3/8")		**EL-102 63+	CAP, SET (2) HOLDER, SET CAP - ASSEMBLED WITH 2-SL-2282V	4
*148A+	HORN, SET DIE (FOR HEAVY WORK) - ASSEMBLED WITH 1-PE-274, 2-SL-12S10, 1-WL-8993T		SL-2282V * **EL-237 * **EL-2 97+	SCREW, SET CAP SET (2) SPINDLE, SET DIE, SET (2) HOLDER, SET DIE - ASSEMBLED WITH 2-SL-2282V	4 4 4
PE-274 SL-12S10	SCREW, SET DIE ADJUSTING SCREW, ADJUSTING SCREW SET (HEX. SOCKET SET SCREW - FLAT 1/4"-28NF X 3/8") (2)	2	SL-2282V * **89	SET - COMPLETE (FOR TWIN EYELETS CENTER DISTANCE UP TO 3/8", SET CAP HOLDER HAS 7/16" SHANK AND REQUIRES PLUNGER No. 64A), VIZ: 2-EL-102, 1-63+, 1-EL-237, 2-EL-2, 1-97+	
WL-8993T *168	ROD, HORN TIE				4
*NL-46K	NUT, HORN TIE ROD (2)	USED WITH NO. 148A+			4
*NL-51K	NUT, HORN TIE ROD (2)				4
*SL-509V	SCREW, HORN SUPPORTING SCREW, SCREW SET	USED WITH NO. 184+			4
*SL-1075V	BUTTON, SET SCREW		**EL-101 **EL-201 ø **NL-1034K **EL-23 * **92	CAP, SET SPINDLE, SET NUT, SET SPINDLE (2) DIE, SET SET, COMPLETE (FOR RADIO WORK, REQUIRES HORN No. 184+), VIZ: 1-EL-101, 1-EL-201, 1-EL-23	4 4 4
*SL-1089V	SCREW, HORN RETAINING WASHER, RETAINING SCREW	USED WITH NO. 184+ & NO. 148A+			
*WL-386T	SCREW, HORN BINDING				
SL-3748V	SCREW, HORN BINDING				
<u>EYELET SETS</u>					
**EL-101	CAP, SET	REGULAR.	**EL-20	DIE, SET	4
**EL-201	SPINDLE, SET	USE WITH	**EL-101	CAP, SET	4
ø **NL-1034K	NUT, SET SPINDLE (2)	HORN	**EL-201	SPINDLE, SET	4
**EL-20	DIE, SET	No. 183A+	ø **NL-1034K * **123	NUT, SET SPINDLE (2) SET - COMPLETE (FOR RUBBER BOOT WORK USE HORN No. 183A+), VIZ: 1-EL-20, 1-EL-101, 1-EL-201	4 4 4
* **EL-101	CAP, SET				
* **EL-201	SPINDLE, SET				
ø **NL-1034K	NUT, SET SPINDLE (2)				

\* NOT SENT UNLESS ORDERED.  
 \*\* WHEN ORDERING, SPECIFY MAKE AND SIZE OF EYELET.  
 ø FOR LARGE SIZE SPINDLES.

USMC -6- UEB

-7-

UEB

RACEWAY  
(FOR EYELETS UP TO AND INCLUDING 11/32" DIA. HEAD) PLATE

#135 24A	RACEWAY BUSHING, RACEWAY SCREW, BUSHING SET	3
SL-1159V	BLOCK, RACEWAY GUIDE	
#UEC-144 #175	GUIDE, RACEWAY (RIGHT HAND) - COMPLETE, VIZ: 4-UEC-144	
#174	GUIDE, RACEWAY (LEFT HAND) - COMPLETE, VIZ: 4-UEC-144	
SL-903V	SCREW, RACEWAY GUIDE BINDING (8)	
#UEC-144 #190	BLOCK, EYELET BOX GUIDE RAIL (2) BLOCK AND RAIL, RAIL - COMPLETE, VIZ: 2-UEC-144	
SL-903V	SCREW, EYELET BOX GUIDE BINDING (2)	4
#473	LEVER, EYELET STOP	
SL-4888V	SCREW, EYELET STOP LEVER	
NL-315K	NUT, STOP LEVER SCREW	
SPGL-129S	SPRING, EYELET STOP LEVER (COMPRESSION .130" X 9/16", .020" DIA. WIRE)	
#PE-104D	BOX, EYELET (2" DEEP)	
#PE-1041	COVER, EYELET BOX	
PE-511E	LATCH, COVER SPRING	4
PL-2499P	RIVET, LATCH (2)	
PE-511D	HINGE, EYELET BOX COVER (2)	
PL-2547P	RIVET, COVER HINGE (8)	
PE-1020	LUG, EYELET BOX (2)	4
PL-4075P	RIVET, LUG (4)	
PE-511C	BUTTON, EYELET BOX (1" TOP)	4
#PE-511JPA	BOX, EYELET, 2" DEEP, WITHOUT GUIDE, WITH SINGLE PORT - COMPLETE, VIZ: 1-PE-104D, 1-PE-1041, 1-PE-511E, 2-PL-2499P, 2-PE-511D, 8-PL-2547P, 2-PE-1020, 4-PL-4075P, 1-PE-511C	

RACEWAY - CONT'D  
(FOR EYELETS UP TO AND INCLUDING 11/32" DIA. HEAD - CONT'D) PLATE

PE-511F	BUSHING, EYELET BOX GUIDE THREADED (2)	4
NL-506K	NUT, EYELET BOX THUMB (2)	
#PE-521	GUIDE, EYELET BOX	
SL-858V	SCREW, GUIDE BINDING (2)	
#PE-511JXA	BOX, EYELET (2" DEEP, WITH GUIDE) - COMPLETE, VIZ: 1-PE-511JPA, 2-PE-511F, 2-NL-506K, 1-PE-521, 2-SL-858V	
PE-600+	BRUSH, EYELET BOX - ASSEMBLED WITH 1-PE-600B+	3
#PE-600B+	HUB, EYELET BOX BRUSH - ASSEMBLED WITH 1-PE-528A	
#PE-528A	RING, BRUSH ALUMINUM	
16	SHAFT, EYELET BOX BRUSH	4
SL-3693V	SCREW, BRUSH SHAFT BINDING	
PE-531	WASHER, BINDING SCREW	4
17	KNIB, BRUSH SHAFT	
PL-1543P	PIN, SHAFT KNIB	4
18	PULLEY, BRUSH SHAFT	
SL-7138V	SCREW, PULLEY SET	3
*147	PULLEY, BRUSH SHAFT	
*SL-2811V	SCREW, PULLEY SET	3
*A140A	RACEWAY, (REGULAR, FOR EYELETS UP TO AND INCLUDING 11/32") - COMPLETE, VIZ: 1-135, 1-24A, 1-SL-1159V, 1-173, 1-174, 8- SL-903V, 1-180, 2-SL-903V, 1- 33, 1-SL-4888V, 1-NL-315K, 1- SPGL-129S, 1-PE-511JXA,	

# NOT FURNISHED SEPARATE.

# MUST BE FITTED TO CUSTOMER'S RACEWAY.  
# FURNISHED SEPARATE FOR DOMESTIC USE ONLY ON  
SPECIFIC INSTRUCTIONS OF EYELET DEPARTMENT.

\* NOT SENT UNLESS ORDERED.  
# NOT FURNISHED SEPARATE.

\*\* WHEN ORDERING, SPECIFY MAKE AND SIZE OF EYELET.  
# FURNISHED SEPARATE FOR DOMESTIC USE ONLY ON  
SPECIFIC INSTRUCTIONS OF EYELET DEPARTMENT.



RACEWAY - CONT'D ★  
(FOR EYELETS ABOVE 11/32" DIA. HEAD - CONT'D)

#PE-1041 COVER, EYELET BOX  
 PE-511E LATCH, COVER SPRING  
 PL-2499P RIVET, SPRING LATCH (2)  
 PE-511D HINGE, BOX COVER (2)  
 PL-2547P RIVET, COVER HINGE (8)  
 PE-1020 LUG, EYELET BOX (2)  
 PL-4075P RIVET, BOX LUG (4)  
 PE-511C BUTTON, EYELET BOX (IN TOP)  
 #PE-511JPA BOX, EYELET (2" DEEP, WITHOUT GUIDE WITH SINGLE PORT) - COMPLETE, VIZ: 1-PE-1040, 1-PE-1041, 1-PE-511E, 2-PL-2499P, 2-PE-511D, 8-PL-2547P, 2-PE-1020, 4-PL-4075P, 1-PE-511C

PE-511F BUSHING, EYELET BOX GUIDE THREADED (2)  
 NL-506K NUT, EYELET BOX THUMB (2)  
 #PE-521 GUIDE, EYELET BOX  
 SL-858V SCREW, EYELET BOX GUIDING BINDING (2)

#PE-511JXA BOX, EYELET (2" DEEP, WITH GUIDE, MULTIPLE PARTS) - COMPLETE, VIZ: 1-PE-511JPA, 2-PE-511F, 2-NL-506K, 1-PE-521, 2-SL-858V

PE-600+ BRUSH, EYELET BOX - ASSEMBLED WITH 1-PE-600B+  
 #PE-600B+ HUB, BRUSH - ASSEMBLED WITH 1-PE-528A  
 #PE-528A RING, BRUSH ALUMINUM 16  
 SL-3693V SHAFT, BRUSH SCREW, SHAFT BINDING

★ NOT SENT UNLESS ORDERED.  
 # NOT FURNISHED SEPARATE.  
 ## FURNISHED SEPARATE FOR DOMESTIC USE ONLY ON SPECIFIC INSTRUCTIONS OF EYELET DEPARTMENT.

RACEWAY - CONT'D  
(FOR EYELETS UP TO AND INCLUDING 11/32" DIA. HEAD - CONT'D)

1-PE-600+, 1-16, 1-SL-3693V,  
 1-PE-531, 1-17, 1-PL-1543P,  
 1-18, 1-SL-7138V

RACEWAY ★  
(FOR EYELETS ABOVE 11/32" DIA. HEAD)

#135 RACEWAY (FOR LARGE EYELETS)  
 #139 RACEWAY (FOR EXTRA LARGE EYELETS)

24A BUSHING, RACEWAY  
 SL-1159V SCREW, BUSHING SET  
 #UEC-144 BLOCK, RACEWAY GUIDE  
 #173 GUIDE, RACEWAY - COMPLETE, VIZ: 4-UEC-144

#174 GUIDE, RACEWAY - COMPLETE, VIZ: 4-UEC-144  
 SL-903V SCREW, GUIDE BINDING (8)  
 #UEC-144 BLOCK, RACEWAY BOX GUIDE RAIL (2)

#180 RAIL AND BLOCK, EYELET BOX GUIDE - COMPLETE, VIZ: 2-UEC-144

SL-903V SCREW, EYELET BOX GUIDE BINDING (2)  
 #120 LEVER, EYELET STOP  
 SL-4888V SCREW, STOP LEVER  
 NL-315K NUT, LEVER SCREW  
 SPGL-2141S SPRING, STOP LEVER (COMPRESSION 3/16" X 3/4", .022" DIA. WIRE)  
 #PE-104D BOX, EYELET (2" DEEP)

★ NOT SENT UNLESS ORDERED.  
 # NOT FURNISHED SEPARATE.  
 ## FURNISHED SEPARATE FOR DOMESTIC USE ONLY ON SPECIFIC INSTRUCTIONS OF EYELET DEPARTMENT.  
 Ⓞ MUST BE FITTED TO CUSTOMER'S RACEWAY.

PLATE

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PLATE

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RACEWAY - CONT'D \*  
 (FOR EYELETS ABOVE 11/32" DIA. HEAD - CONT'D)

PE-531	WASHER, BINDING SCREW	4
17	KNOB, BRUSH SHAFT	4
PL-1543P	PIN, BRUSH SHAFT KNOB	
18	PULLEY, BRUSH SHAFT	3
SL-7138V	SCREW, PULLEY SET	
*147	PULLEY, BRUSH SHAFT	3
*SL-2811V	SCREW, PULLEY SET	
** *142A	RACEWAY (FOR EYELETS ABOVE 11/32") - COMPLETE, VIZ:	

1-135 or 139, 1-24A, 1-SL-1159V, 1-173, 1-174, 8-SL-903V, 1-180, 2-SL-903V, 1-120, 1-SL-488V, 1-NL-315K, 1-SPGL-21415, 1-PE-511JXA, 1-PE-600+, 1-16, 1-SL-3693V, 1-PE-531, 1-17, 1-PL-1543P, 1-18, 1-SL-7138V

RACEWAY \*  
 (FOR TWIN EYELETS)

#175	RACEWAY	3
24A	BUSHING, RACEWAY	
SL-1159V	SCREW, BUSHING SET	
#UEC-144	BLOCK, RACEWAY GUIDE	
#173	GUIDE, RACEWAY - COMPLETE,	
	VIZ: 4-UEC-144	
#174	GUIDE, RACEWAY - COMPLETE,	
	VIZ: 4-UEC-144	
SL-903V	SCREW, RACEWAY GUIDE BINDING (8)	
#UEC-144	BLOCK, EYELET BOX GUIDE RAIL (2)	
#180	RAIL AND BLOCK, EYELET BOX GUIDE - COMPLETE, VIZ: 2-UEC-144	

PLATE

RACEWAY - CONT'D \*  
 (FOR TWIN EYELETS - CONT'D)

SL-903V	SCREW, EYELET BOX GUIDE BINDING (2)	4
0033	LEVER, EYELET STOP	
SL-4888V	SCREW, LEVER	
NL-315K	NUT, LEVER SCREW	
SPGL-129S	SPRING, STOP LEVER (COMPRESSION .180" X 9/16", .020" DIA. WIRE)	
#PE-1040	BOX, EYELET (2" DEEP)	
#PE-1041	COVER, EYELET BOX	
PE-511E	LATCH, COVER SPRING	4
PL-2499P	RIVET, LATCH (2)	
PE-511D	HINGE, COVER (2)	
PL-2547P	RIVET, COVER HINGE (8)	
PE-1020	LUG, EYELET BOX (2)	4
PL-4075P	RIVET, LUG (4)	
PE-511C	BUTTON, EYELET BOX (IN TOP)	
#PE-511JPA	BOX, EYELET (2" DEEP, WITHOUT GUIDE, WITH SINGLE PORT) - COMPLETE, VIZ: 1-PE-1040, 1-PE-1041, 1-PE-511E, 2-PL-2499P, 2-PE-511D, 8-PL-2547P, 2-PE-1020, 4-PL-4075P, 1-PE-511C	4

PLATE

NL-506K	NUT, EYELET BOX THUMB	
PE-600+	BRUSH, EYELET BOX - ASSEMBLED WITH 1-PE-6008+	3
#PE-600B+	HUB, BRUSH - ASSEMBLED WITH 1-PE-528A	
#PE-528A	RING, ALUMINUM BRUSH	4
16	SHAFT, BRUSH	
SL-3693V	SCREW, SHAFT BINDING	4
PE-531	WASHER, BINDING SCREW	4
17	KNOB, BRUSH SHAFT	4

\* NOT SENT UNLESS ORDERED.  
 # NOT FURNISHED SEPARATE.  
 \*\* WHEN ORDERING, SPECIFY MAKE AND SIZE OF EYELET.  
 \*\*\* FURNISHED SEPARATE FOR DOMESTIC USE ONLY ON SPECIFIC INSTRUCTIONS OF EYELET DEPARTMENT.

\* NOT SENT UNLESS ORDERED.  
 # NOT FURNISHED SEPARATE.  
 \*\* MUST BE FITTED TO CUSTOMER'S RACEWAY.  
 \*\*\* FURNISHED SEPARATE FOR DOMESTIC USE ONLY ON SPECIFIC INSTRUCTIONS OF EYELET DEPARTMENT.

RACEWAY - CONT'D \*  
(FOR TWIN EYELETS - CONT'D)

PL-1543P PIN, KNOB  
18 PULLEY, BRUSH SHAFT  
SL-7138V SCREW, PULLEY SET  
\*147 PULLEY, BRUSH SHAFT  
\*SL-2811V SCREW, PULLEY SET  
\*\*141A RACEWAY, (FOR TWIN EYELETS) -  
COMPLETE, VIZ: 1-135, 1-24A,  
1-SL-1159V, 1-173, 1-174, 8-  
SL-903V, 1-180, 2-SL-903V,  
1-33, 1-SL-4886V, 1-NL-315K,  
1-SPGL-129S, 1-PE-511JPA, 2-  
NL-506K, 1-PE-600+, 1-16, 1-  
SL-3693V, 1-PE-531, 1-17,  
1-PL-1543P, 1-18, 1-SL-7138V

PLATE

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PLATE

25 PIN, RACEWAY FULCRUM  
26A PLUNGER, FULCRUM PIN  
SPGL-1593S SPRING, PLUNGER (COMPRESSION  
1/4" X 3/16", .020" DIA. WIRE)  
SL-5272V SCREW, PLUNGER SPRING  
27 LEVER, RACEWAY ROCKING  
SL-2186V SCREW, LEVER CLAMP  
175 LINK, RACEWAY  
PL-3220P PIN, LINK CONNECTING  
WL-177T WASHER, CONNECTING PIN  
PL-1055P PIN, CONNECTING PIN COTTER  
47 PIN, RACEWAY LINK RELEASE  
26A PLUNGER, RELEASE PIN  
SPGL-1593S SPRING, PLUNGER (COMPRESSION  
1/4" X 3/16", .020" DIA. WIRE)  
SL-5272V SCREW, PLUNGER SPRING  
176 SHAFT, RACEWAY ROCKING LEVER  
CL-156J COLLAR, LEVER SHAFT  
SL-1073V SCREW, COLLAR SET  
133 CAM, RACEWAY  
PL-925P PIN, RACEWAY CAM TAPER  
-RL-573G ROLL, RACEWAY CAM  
45 STUD, CAM ROLL  
NL-263K NUT, ROLL STUD  
PE-255 BUSHING, ROLL STUD  
NL-226K NUT, STUD BUSHING  
32 LEVER, RACEWAY CAM  
PL-3743P PIN, CAM LEVER TAPER  
SL-2186V SCREW, LEVER CLAMP  
TEM-13 ROD, RACEWAY SPRING  
SPGL-1354S SPRING, RACEWAY (COMPRESSION  
31/64" X 3-11/16", .072" DIA.  
WIRE)

BRUSH CONTINUOUS FEED PARTS \*

104 BRACKET, IDLER PULLEY  
UEC-106 STAND, PULLEY BRACKET  
SL-5416V SCREW, BRACKET STAND SET  
PL-6882P STUD, IDLER PULLEY (2)  
SL-5286V SCREW, PULLEY STUD SET (2)  
NL-532K CHECKNUT, SET SCREW (2)  
35 PULLEY, IDLER (4)  
PL-6882P STUD, IDLER PULLEY (VERTICAL) (2)  
SL-5286V SCREW, STUD SET (2)  
NL-532K CHECKNUT, SET SCREW (2)  
105 PULLEY, BRUSH DRIVE  
SL-5286V SCREW, PULLEY SET (2)  
107 BELT, (3/16" NO. BELTING, 4'4-3/8"  
LONG)  
191 FEED, BRUSH CONTINUOUS - COMPLETE,  
VIZ.: 4-35, 1-104, 1-105, 1-107,  
1-UEC-106, 4-NL-532K, 4-PL-6882P,  
6-SL-5286V, 1-SL-5416V  
PULLEY, DRIVING (SEE 106+)

\* NOT SENT UNLESS ORDERED.

\*\* WHEN ORDERING, SPECIFY MAKE AND SIZE OF EYELET.

USMC

-14-

UEB

USMC

-15-

1 B

WL-177T WASHER, SPRING ROD (IN FRAME) -  
WL-177T WASHER, SPRING ROD (3) -  
NL-263K NUT, SPRING ROD  
NL-263K CHECKNUT, SPRING ROD  
WL-1413T WASHER, SPRING ROD ←

SPEED REDUCER PARTS \*PLATE

185	PULLEY, SPEED REDUCER	2
186	SHAFT, REDUCER PULLEY	2
187	SCREW, REDUCER PULLEY	2
SL-5L3	SCREW, PULLEY SHAFT SET (SQ. NO. SET SCREW 5/16" - 18NC X 1/2")	

188	RESERVOIR, PULLEY SHAFT OIL WICKING, SHAFT OIL (18")	2
#XHF-01993	SCREW, RESERVOIR SET (FILLISTER HD. MACH. SCREW NO. 10-32NF X 3/4")	
SL-12A18		

189	STAND, SPEED REDUCER	2
SL-15P19	SCREW, REDUCER STAND (NO. 16 FLAT HD. WOOD SCREW 1-1/2" LONG)	

* Ø108	REDUCER, SPEED - COMPLETE, VIZ: 1-185, 1-186, 1-187, 1-188, 1-189, 1-SL-5L3, 1-SL-12A18, 3-SL-15P19, 1-XHF-01993	
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WRENCHES

WRHL-150H	ALLEN SET SCREW (3/16" HEX)
WRHL-221H	DOUBLE END (3/4" X 7/8")
WRHL-467H	ALLEN SET SCREW (1/4" HEX.)
WRHL-219H	DOUBLE END (5/16" X 1/2")

MISCELLANEOUS

ORL-757	DRIVER, USMC SCREW (3")
DE-K583	BELT, MACHINE DRIVING (3/8" ROUND BELTING, 9' LONG)
	SCRAPER, RACEWAY

\* NOT SENT UNLESS ORDERED.  
Ø USE WHEN MACHINE IS DRIVEN WITH A MOTOR.  
## APPLIED FOR REPLACEMENT PURPOSES BY TOTAL LENGTH DESIRED IN FEET.

PE-399	CHAIN, SCRAPER (#14 SINGLE IRON JACK CHAIN 35-7/8" LONG)
SL-2469V	HOOK, CHAIN
CZR13A	CAN, OIL (5" SPOUT, CAP. 5 OZ.) LAYOUT, BENCH

COLLECTIVE NUMBERS

65	PARTS NECESSARY TO APPLY RACEWAY THROWOUT TO MACHINES (B.B. No. A17, JUNE 21, 1924)
136	COLLECTIVE NUMBER COVERING NECESSARY PARTS TO APPLY 5/8" MORE MOTION TO TOP SET ON MACHINES WHICH HAVE CLOSED CAM UEB-30 (B.B. No. A51, AUGUST 24, 1929)
179	COLLECTIVE NUMBER COVERING NECESSARY PARTS TO APPLY REDESIGNED EYELET BRUSH OSCILLATING DEVICE TO OUTSTANDING MACHINES (B.B. No. A62, OCTOBER 30, 1930)

RACEWAY THROWOUT PAHIO \*

PLATE

177+ LEVER, RACEWAY THROWOUT -  
 ASSEMBLED WITH 1-PL-1763P  
 PL-1763P PIN, LEVER SPRING 3  
 178 STOP, THROWOUT 3  
 NL-320K NUT, THROWOUT STOP  
 WL-177T WASHER, THROWOUT STOP  
 SPGL-1239S SPRING, THROWOUT LEVER (TENSION  
 3/16" X 1-1/16", .026" DIA.  
 WIRE)  
 SL-6422V SCREW, THROWOUT LEVER FULCRUM  
 SL-292V SCREW, FULCRUM SCREW SET  
 WL-553T FRICTION, SET SCREW

EYELET BRUSH OSCILLATING DEVICE \*

157 LEVER, SET CAP PLUNGER (SEE 164)  
 158 SHAFT, OSCILLATING BRUSH 1  
 PL-1518P PINION, BRUSH SHAFT 1  
 159 PIN, PINION TAPER 1  
 160+ RACK, PINION 1  
 BRACKET, BRUSH SHAFT PINION -  
 ASSEMBLED WITH 2-PL-6771P 1  
 PL-6771P PIN, BRACKET DOWEL (2)  
 SL-1474V SCREW, BRACKET (SHORT)  
 SCREW, BRACKET (LONG) (SEE  
 SL-4849V)  
 161 GUIDE, RACK 1  
 GUC-390+ SOCKET, RACK BALL JOINT -  
 ASSEMBLED WITH 1-UMS-116,  
 1-UMS-118, 2-SL-7289V (2) 1  
 #UMS-116 JOINT, RACK BALL  
 #UMS-118 CAP, RACK BALL SOCKET  
 SL-7289V SCREW, SOCKET CAP (2)  
 WL-1247T WASHER, SOCKET OSCILLATING CRANK  
 NL-368K NUT, RACK BALL JOINT SOCKET (2)  
 SOL-1054Y CONNECTION, BALL JOINT  
 NL-368K NUT, CONNECTION (2)

\* NOT SENT UNLESS ORDERED.

# NOT FURNISHED SEPARATE.

USMC

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UEB

EYELET BRUSH OSCILLATING

PLATE

DEVICE - CONT'D \*

162+ CRANK, OSCILLATING -  
 ASSEMBLED WITH 2-PL-1332P  
 PL-1332P PIN, CRANK DOWEL (2) 1  
 SL-2763V SCREW, CRANK (3) 1  
 163 GUARD, BRUSH RACK  
 SL-4849V SCREW, RACK GUARD  
IDLER PULLEY PARTS  
 34+ BRACKET, IDLER PULLEY -  
 ASSEMBLED WITH 2-PL-3085P 3  
 PL-3085P STUD, IDLER PULLEY (2)  
 SL-1438V SCREW, PULLEY BRACKET BINDING (2)  
 35 PULLEY, IDLER (2) 1  
 WL-264T WASHER, PULLEY STUD (2)  
 PL-1047P PIN, STUD COTTER (2)  
 38 BELT, IDLER PULLEY (3/16" RO.  
 BELTING, 37-3/4" LONG)

TREADLE PARTS

RF-686 TREADLE 3  
 RF-460 STAND, TREADLE 3  
 PL-2581P PIN, TREADLE FULCRUM  
 PL-243P PIN, FULCRUM PIN COTTER (2)  
 SL-11P15 SCREW, TREADLE STAND (NO. 12  
 FLAT HD. WOOD SCREW 1" LONG) (2)  
 SL-4191V SCREW, TREADLE ROD 3  
 DE-K783 ROD, TREADLE (UPPER)  
 PL-1055P PIN, ROD COTTER 3  
 DE-K786 ROD, TREADLE (LOWER)  
 DE-K787 BLOCK, ROD CONNECTION 3  
 SL-332V SCREW, BLOCK SET  
 DE-K788 ROD, TREADLE - COMPLETE, VIZ:  
 1-DE-K783, 1-PL-1055P, 1-DE-  
 K786, 1-DE-K787, 1-SL-332V

\* NOT SENT UNLESS ORDERED.

USMC

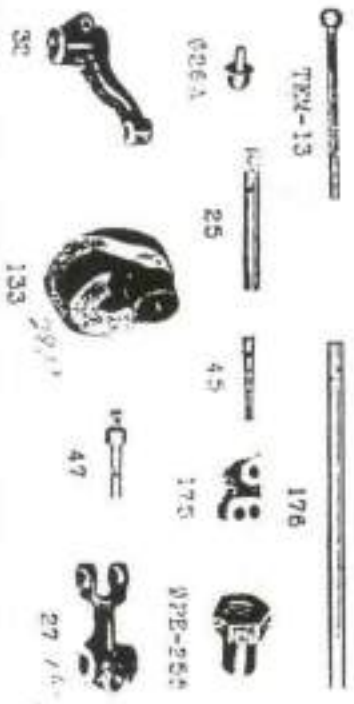
-17-

UEB

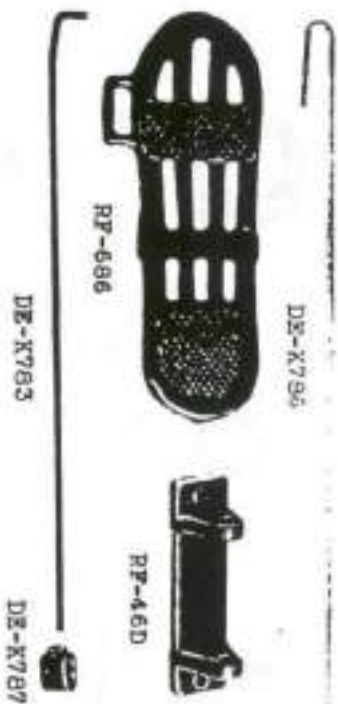


PLATE 3

RACEWAY ROCKING PARTS



THRADLY PARTS



RACEWAY THROWOUT PARTS



EDLER PULLEY PART

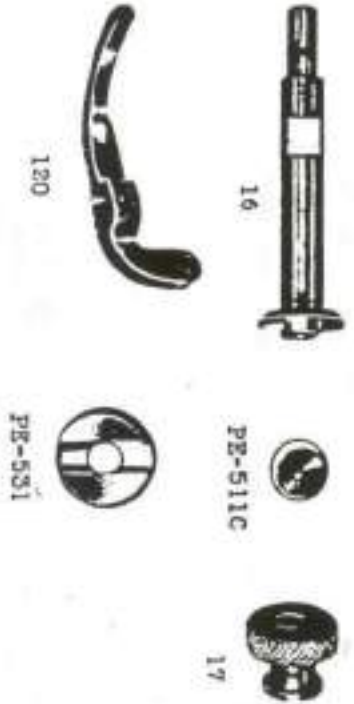


RACEWAY PARTS



PLATE 4

RACEWAY PARTS - CONT'D.



PE-1020



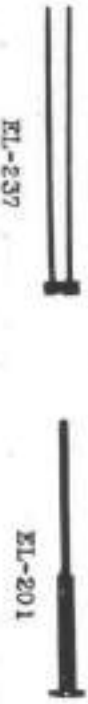
PE-511F



PE-511R

33

EYELET SETS



EL-7



EL-101



EL-102



EL-23



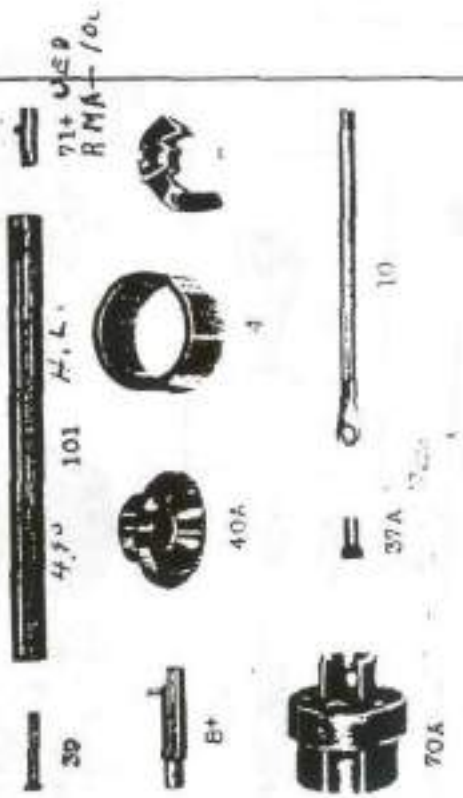
EL-25



EL-2



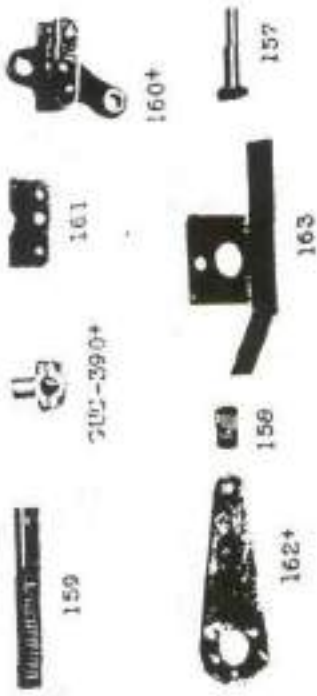
DRIVING PARTS



BRUSH CONTINUOUS FEED PARTS



EYELET BRUSH OSCILLATING DEVICE



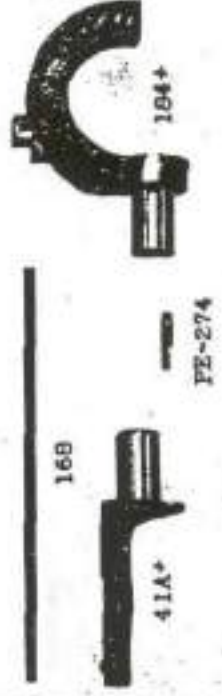
SET CAP OPERATING PARTS



SPEED REDUCER PARTS



HORN PARTS



1 2 3  
INCHES

USMC

1 2 3  
INCHES

USMC

USCB