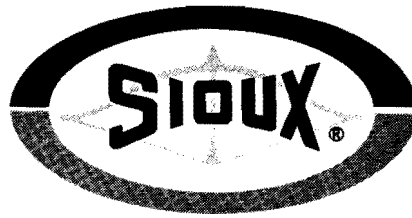




**NOTE: Parts are no longer available for this tool.**

**The manual will continue on the next page.**



## **Parts List For 1640 and 1650 CYLINDER HEAD WORK CENTER**

### **ASSEMBLY INSTRUCTIONS**

#### **Overhead Rail**

The Overhead Rail assembly is a simple 5 piece assembly as shown in the parts list. To install:

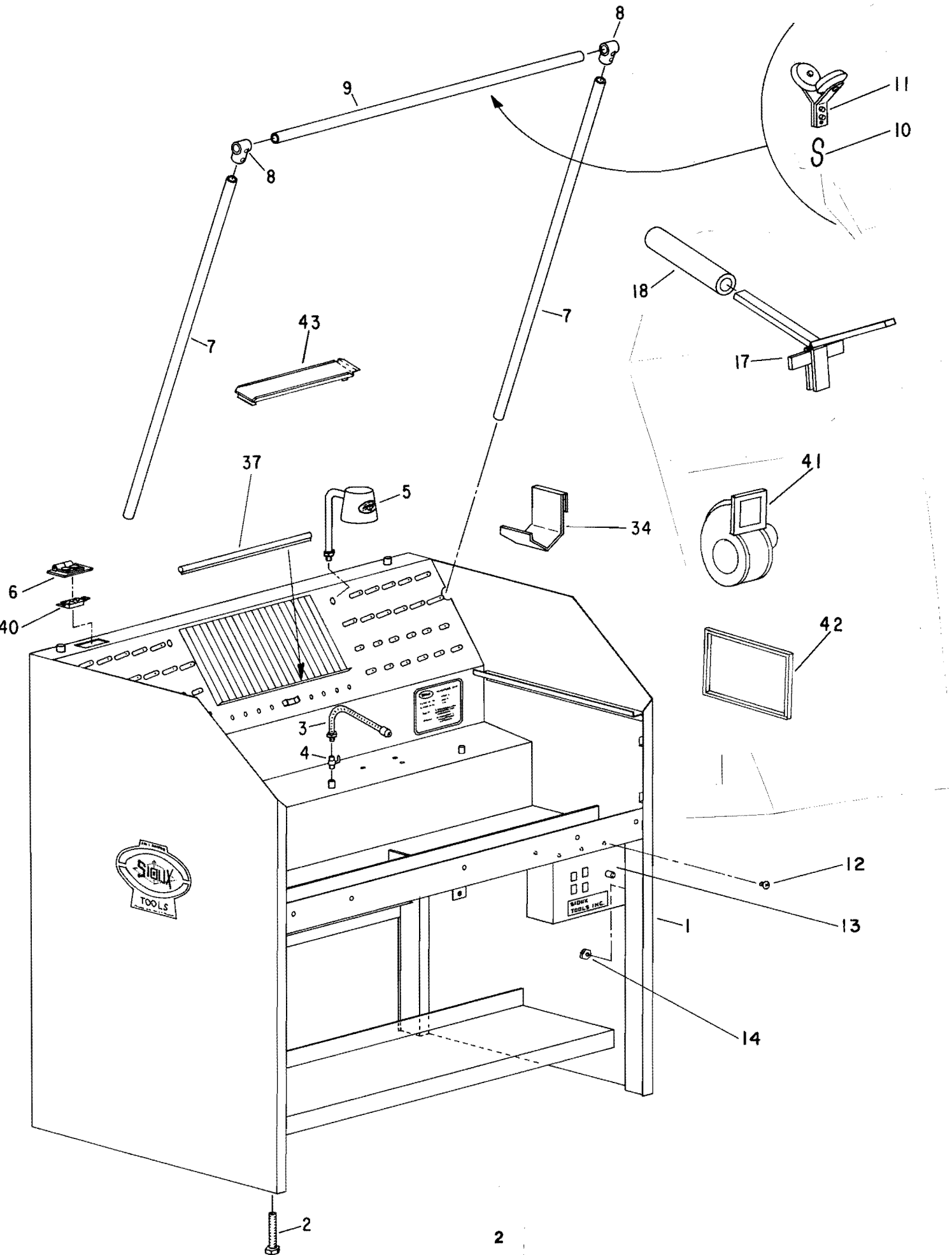
1. Install the two legs (Figure 7) through the back panel opening and clamps which are welded to the back channel. The bottom of the legs should rest against the back channel.
2. Sight across the two legs and adjust up or down to assure they are parallel to each other.
3. Tighten clamp which is welded to back channel.
4. Install and tighten "U" bolts (Figure 39).
5. Assemble trolley (Figure 11), overhead track (Figure 9), and elbows (Figure 8).
6. Assemble the trolley and track as outlined in step 5 to the previously installed legs and secure with set screws.

#### **Air Supply**

Sioux has provided two (2) 1/4" pipe couplings permanently welded in this assembly. They are only intended to provide convenient termination for air lines if the user so desires.

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## Parts List For 1650 Wet Cylinder Head Work Center

Fig- ure	Part No.	Name
1		Cabinet (not available)
2	09355	1/2''-13 Leg Leveler (4)*
3	54983	Ass'y-Coolant Tube (3)*
4	30731	Valve-Coolant (3)*
5	28153	Ass'y-Flexible Light (2)*
6	18691	Cover-Outlet
7	40120	Leg-Overhead Track (2)*
8	40137	Tee-3/4'' Pipe (Slip On) (2)*
9	40121	Track-Overhead
10	40134	''S'' Hook
11	63275	Ass'y.-Trolley
12	07226	Screw-10-24 Self-Tapping (3)*
13	35685	Cover-Switch & Receptacle
	18221	Switch (115V)
	18221J	Switch (230V)
	18663	Receptacle (115V) (2)*
	18877	Receptacle (230V) (2)*
14	09545	Nut-5/16''-18
16	09500	Hex Nut 1/4''-20 (4)*
17	63270	Support-Head Stand [Includes (2) Fig. 18] (3)*
18	40132	Hose-Head Stand (6)*
30	40126	Rod-Curtain
31	40129	Curtain-Splash
33	09464	Hex. Nut #10-24 (5)*
34	35719	Hanger-Tool
35	54912	Rod-Curtain Guide
37		''U'' Channel - Rubber
38	07200	Screw-Phil. Rd. Hd. #10-24 x 3/8'' (5)*
40	18669	Receptacle

ITEMS NOT SHOWN:

04311 Mat-Reservoir (2)\*

## Parts List For 1640 Vacuum Cylinder Head Work Center

Fig- ure	Part No.	Name
1		Cabinet (not available)
2	09355	1/2''-13 Leg Leveler (4)*
5	28153	Ass'y-Flexible Light (2)*
6	18691	Cover-Outlet
7	40120	Leg-Overhead Track (2)*
8	40137	Tee-3/4'' Pipe (Slip On) (2)*
9	40121	Track-Overhead
10	40134	''S'' Hook
11	63275	Ass'y.-Trolley
12	07226	Screw-10-24 Self-Tapping (3)*
13	35685	Cover-Switch & Receptacle
	18221	Switch (115V)
	18221J	Switch (230V)
	18663	Receptacle (115V) (2)*
	18877	Receptacle (230V) (2)*
14	09545	Nut-5/16''-18
16	09500	Hex Nut 1/4''-20 (4)*
17	63270	Support-Head Stand [Includes (2) Fig. 18] (3)*
18	40132	Hose-Head Stand (6)*
30	40126	Rod-Curtain
31	40129	Curtain-Splash
33	09464	Hex. Nut #10-24 (5)*
34	35719	Hanger-Tool
35	54912	Rod-Curtain Guide
37		''U'' Channel - Rubber
38	07200	Screw-Phil. Rd. Hd. #10-24 x 3/8'' (5)*
40	18669	Receptacle
41	65290	Blower
42	65291	Filter (2) [Sold in boxes of 6]
43	65303	Lid

ITEMS NOT SHOWN:

04311 Mat-Reservoir (2)\*

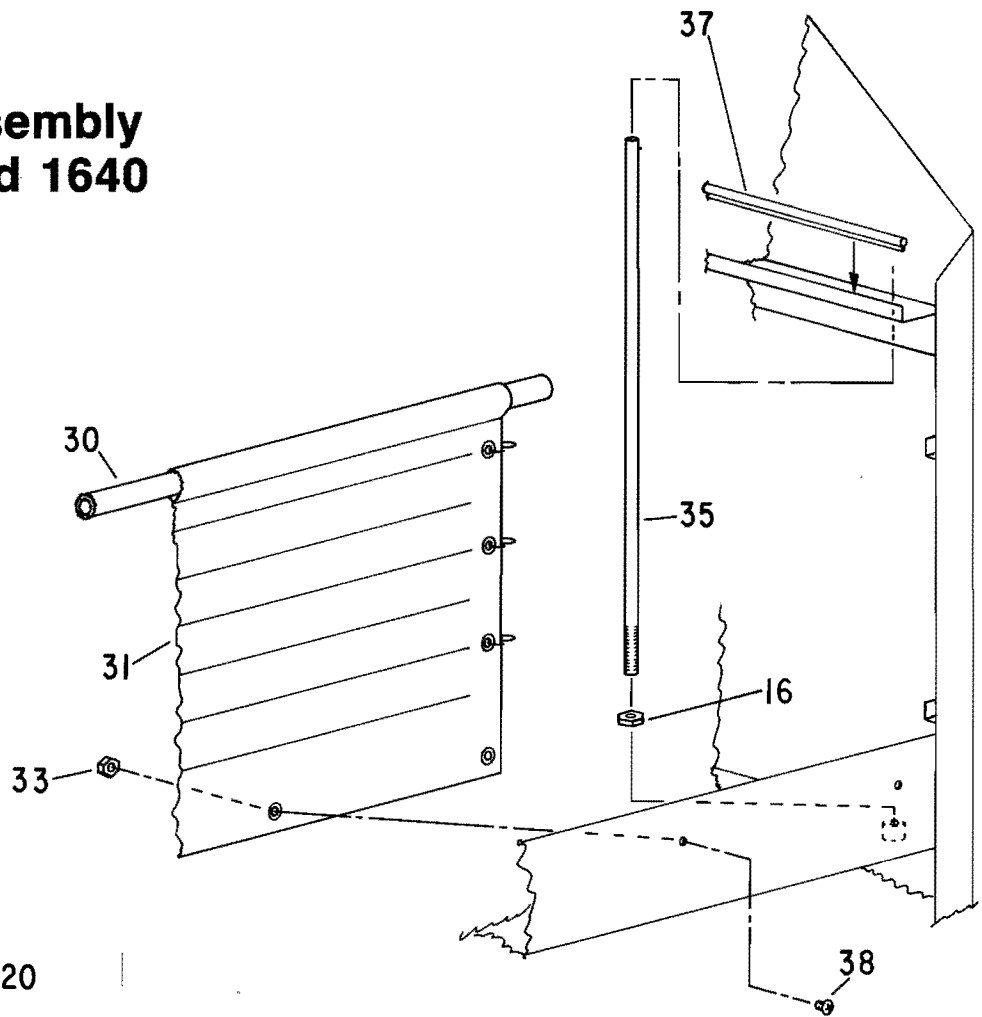
65282 Door-Dressing Tool

## Dressing Tool Mounting Hardware

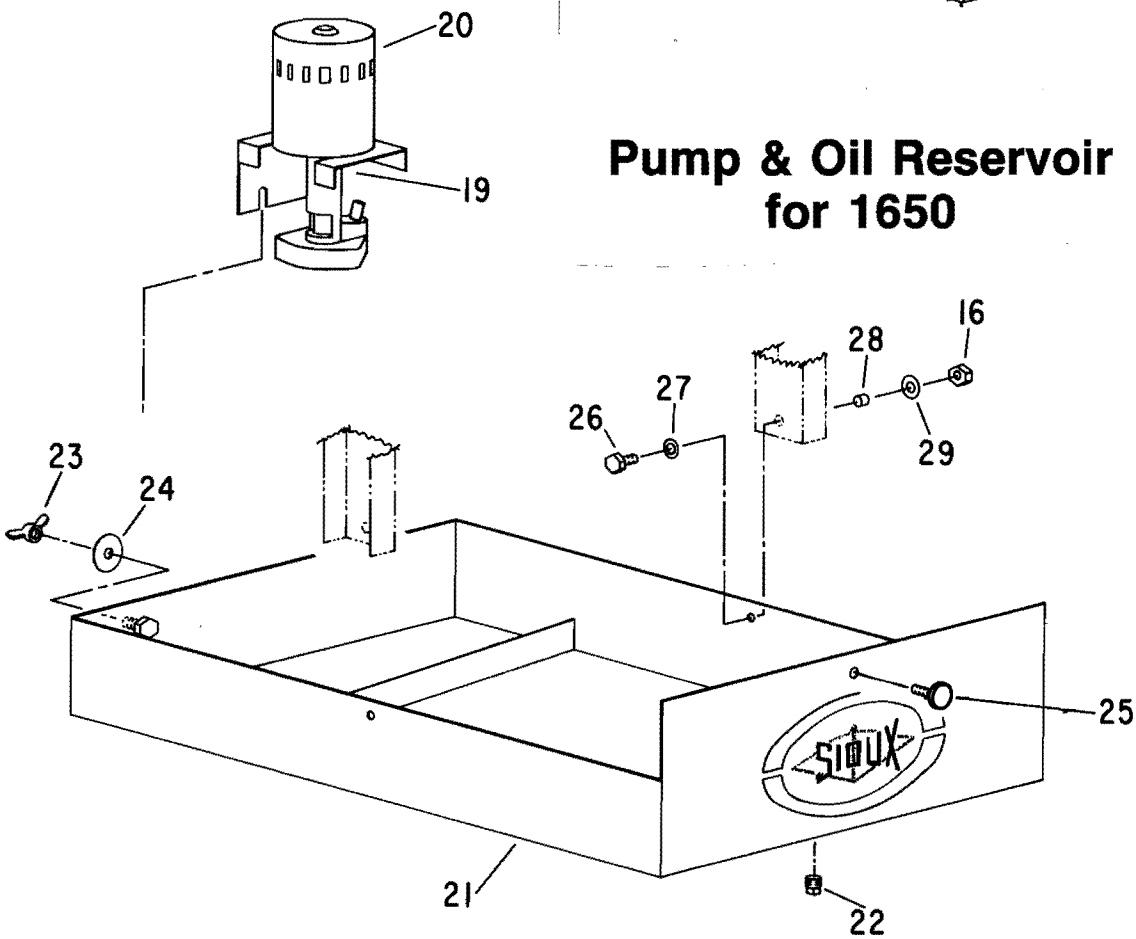
08246	Screen-Hex Hd Cap (Grade 5) 1/4-20x5/8 (3)*
09748	Washer-Lock 1/4 (3)*
09500	Nut-1/4-20 (3)*
40125	Washer-Sealing 1/4 (3)*

\*Order Quantity As Needed

# Curtain Assembly for 1650 and 1640



# Pump & Oil Reservoir for 1650

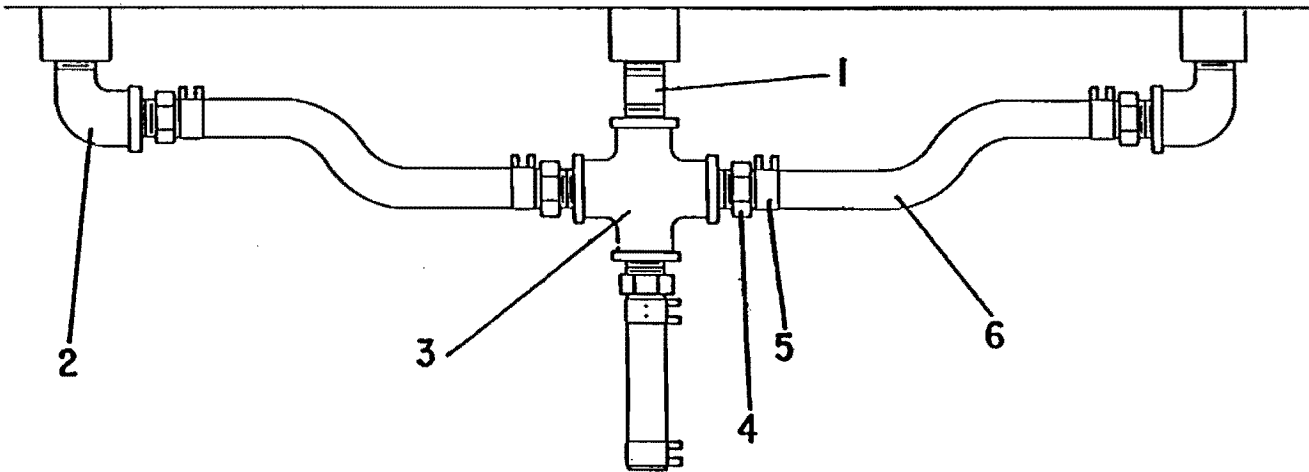




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## Plumbing Diagram For 1650



### Parts List For 1650 Plumbing Diagram

Fig- ure	Part Number	Name
1	30638	Nipple 1/4" x 2 1/2"
2	40122	Street ELL 1/4" (2)*
3	40123	Fitting—Cross 1/4"
4	70190	Fitting Nylon 1/4" x 3/8" (5)*
5	30744	Hose Clamp (6)*
6		Hose 3/8" I.D. x 1/16" Wall

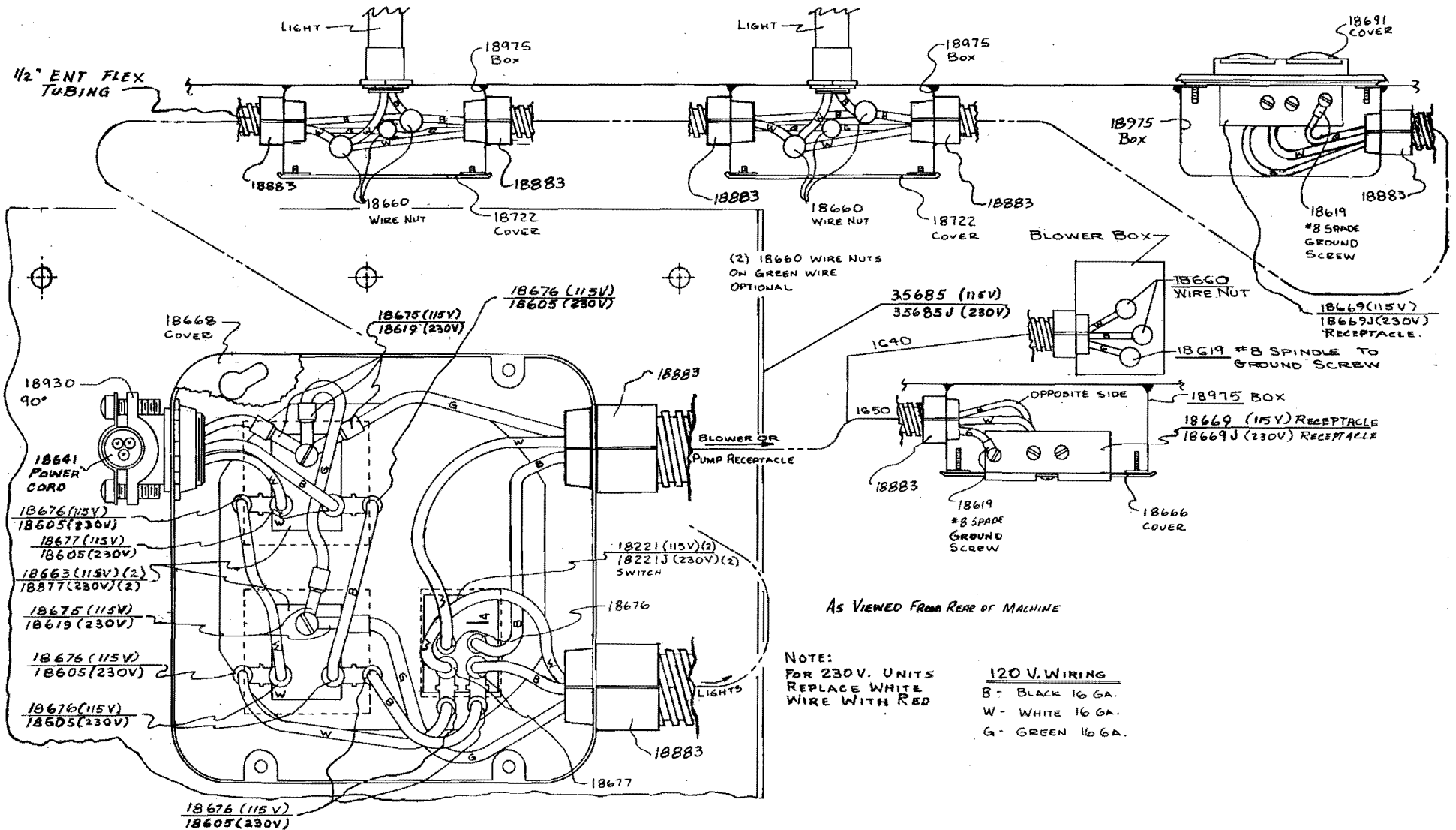
\*Order Quantity As Needed



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## Wiring Diagram for 1650 and 1640



This pdf incorporates the following model numbers:

1640, 1650