

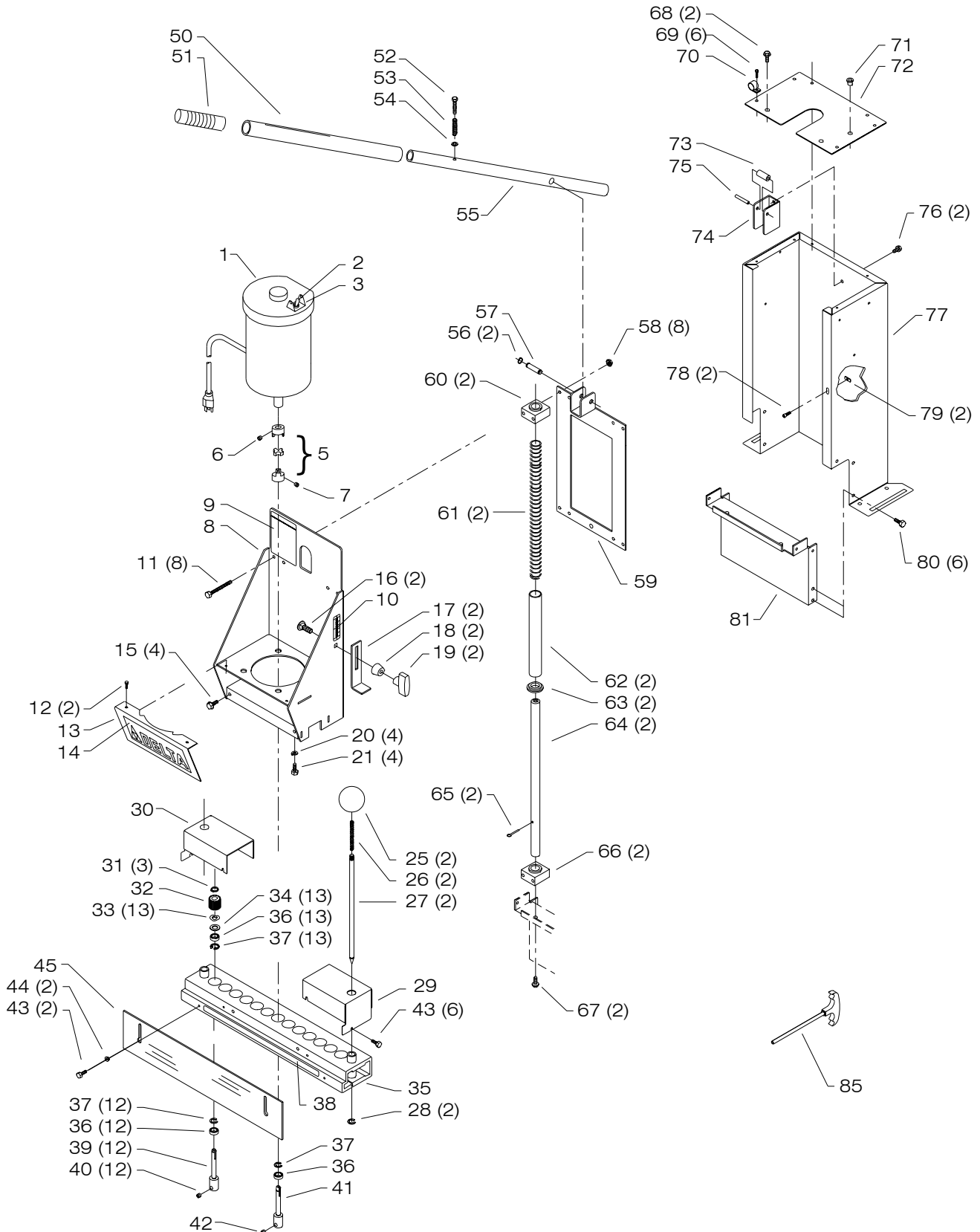


# 32-325 LINE BORING MACHINE & 32-326 PNEUMATIC LINE BORING MACHINE

**DP-22**

PART NO. 449-01-651-0006

Revised: 10-07-04



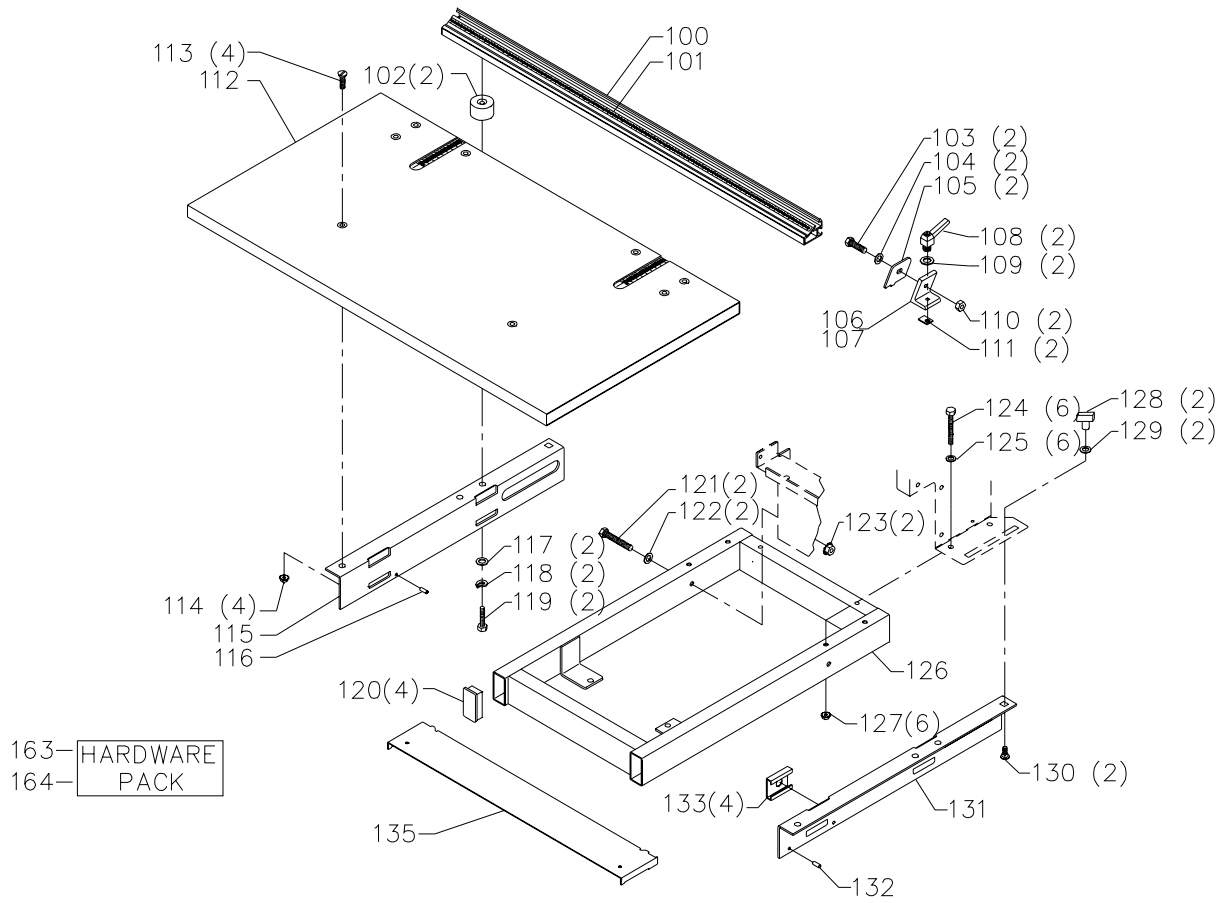
# REPLACEMENT PARTS

Ref.	No.	Part No.	Description	Ref.	No.	Part No.	Description
1	n	438-02-314-6208	MOTOR - WEG	42		901-04-151-9209	5/16-24 X 1/4" HEX SOC SET SCREW
		62-095	MOTOR, MARATHON	43		901-06-443-1806	10-24 X 1/2" HEX HD SCREW
2		438-01-017-0200	SWITCH	44		449-01-104-0001	SPACER
3		434-08-054-0001	SWITCH GUARD	45		449-01-054-0001	GUARD
5		449-01-301-0001	COUPLING - 1/2 TO 5/8", INCL:	50		449-01-367-0002	SLIDING LEVER, INCL:
6		901-04-150-0236	10-24 X 1/4" HEX SOC SET SCREW	51		422-39-105-0001	GRIP
7		901-04-150-1185	1/4-20 X 5/16" HEX SOC SET SCREW	52		901-01-060-3124	1/4-20 X 1 1/2" HEX HD SCREW
8		449-01-384-0005	SLIDE, INCL: ( NOTE A)	53		422-25-122-0004	SPRING
		449-01-384-0002	SLIDE, INCL: ( NOTE B)	54		904-01-031-2934	1/4" FLAT WASHER
9		449-01-754-0007	UNIT WARNING DECAL ( NOTE A)	55		449-01-067-0001	STATIONARY LEVER
		449-01-754-0001	UNIT WARNING DECAL ( NOTE B)	56		904-15-062-0137	EXT RET RING
10		449-01-132-0002	HEAD SCALE	57		449-01-071-0005	PIVOT LEVER PIN
11		901-01-060-5768	1/4-20 X 2 1/2" HEX HD SCREW	58		902-01-212-2409	1/4-20 LOCKNUT
12		901-06-443-1806	10-24 X 1/2" HEX HD SCREW	59		449-01-072-0005	BACKING PLATE
13		449-01-331-0002	FRONT SLIDE COVER, INCL: ( NOTE A)	60		449-01-010-0001	BEARING BLOCK
		449-01-331-0001	FRONT SLIDE COVER, INCL: ( NOTE B)	61		449-01-122-0003	SPRING
14		449-01-754-0008	NAMEPLATE ( NOTE A)	62		449-01-105-0004	GUIDE ROD SLEEVE
		449-01-754-0002	NAMEPLATE ( NOTE B)	63		449-01-017-0001	SPRING GUIDE BUSHING
15		901-02-763-1709	5/16-18 X 5/8" HEX FLANGE SCREW	64		449-01-408-0001	GUIDE ROD
16		901-11-020-0830	5/16-18 X 1 1/4" CAR HD SCREW ( NOTE C)	65		905-05-040-2106	1/8" X 1 1/4" COTTER PIN
17		449-01-014-0007	STOP BRACKET ( NOTE C)	66		449-01-010-0001	BEARING BLOCK
18		449-01-104-0004	SPACER ( NOTE C)	67		901-02-763-1709	5/16-18 X 5/8" HEX FLANGE SCREW
19		424-12-060-0005	KNOB ( NOTE C)	68		901-02-763-1709	5/16-18 X 5/8" HEX FLANGE SCREW
20		904-02-020-1704	3/8" LOCK WASHER	69		901-06-443-1806	10-24 X 1/2" HEX HD SCREW
21		901-01-060-0640	3/8-16 X 3/4" HEX HD SCREW	70		438-01-004-0015	CLAMP
25		931-01-021-4099	KNOB - SCREW ON	71		961-03-010-2859	GROMMET
26		449-01-122-0002	INDEX SPRING	72		449-01-031-0007	TOWER COVER ( NOTE A)
27		449-01-371-0002	INDEX PIN, INCL:			449-01-031-0002	TOWER COVER ( NOTE B)
28		904-15-062-0137	EXT RET RING	73		1087842	SPACER
29		449-01-031-0009	GEAR COVER - RIGHT ( NOTE A)	74		449-01-014-0011	LEVER BRACKET ( NOTE A)
		449-01-031-0005	GEAR COVER - RIGHT ( NOTE B)			449-01-014-0009	LEVER BRACKET ( NOTE B)
30		449-01-031-0008	GEAR COVER - LEFT ( NOTE A)	75		905-01-010-5070	1/4" X 1 1/2" SPRING PIN
		449-01-031-0003	GEAR COVER - LEFT ( NOTE B)	76		901-06-413-1169	1/4-28 X 1/2" HEX WASHER HD SCREW
*		449-01-312-0002	HEAD ASSY, INCL.:	77		449-01-089-0012	TOWER HOUSING ( NOTE A)
31		904-15-010-7018	EXT RET RING			449-01-089-0001	TOWER HOUSING ( NOTE B)
32		449-01-351-0002	SET OF 13 GEARS	78		901-03-010-0229	1/4-20 X 1/2" HEX HD SCREW ( NOTE C)
33		928-06-013-1696	1/2" WAVE WASHER	79		902-05-000-2919	WELD NUT ( NOTE C)
34		904-01-031-2905	FLAT WASHER	80		901-06-413-1169	1/4-28 X 1/2" HEX WASHER HD SCREW
35		449-01-312-0003	HEAD W/BUSHINGS, INCL:	81		449-01-056-0002	TOWER WEB ( NOTE A)
36		920-04-022-4017	BEARING			449-01-056-0001	TOWER WEB ( NOTE B)
37		904-15-103-1701	RET RING	85		955-03-023-1739	5/32" "T" HEX WRENCH
38		449-01-754-0009	GUARD WARNING DECAL ( NOTE A)				
		449-01-754-0004	GUARD WARNING DECAL ( NOTE B)	*		NOT SHOWN ASSEMBLED	
39		449-01-385-0002	SPINDLE - DRIVEN, INCL:				
40		901-04-151-9209	5/16-24 X 1/4" HEX SOC SET SCREW				
41		449-01-385-0001	SPINDLE - DRIVER, INCL:				

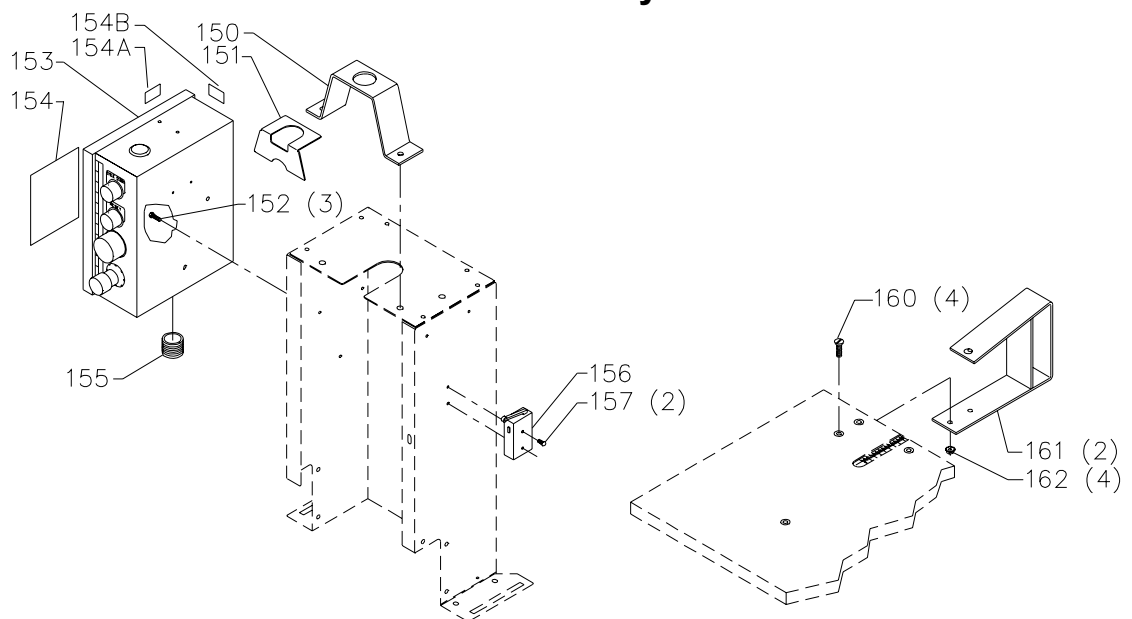
## SERVICE NOTE:

- A - S/N'S BEGINNING WITH 01K AND ABOVE
- B - S/N'S BEGINNING WITH 01J AND BELOW

*C – Early models 32-325's employed only one stop while current units are produced with one on each side. It is recommended that references 16, 17, 18, 19, 78, & 79 be added to older 32-325's with only one stop.*



**32-326 Only**



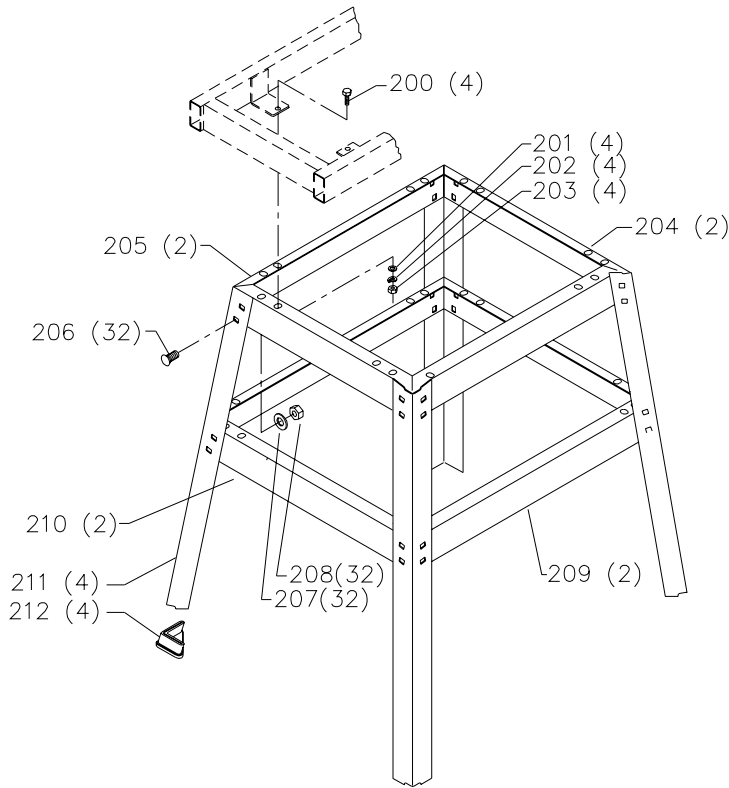
# REPLACEMENT PARTS

Ref.			Ref.		
No.	Part No.	Description	No.	Part No.	Description
100	449-01-343-0001	FENCE W/INSERT, INCL:	150	449-01-089-0011	WORK CYL. SUPPORT ( NOTE A)
101	449-01-132-0005	FENCE SCALE		449-01-089-0010	WORK CYL. SUPPORT ( NOTES B & D)
102	449-01-104-0005	FENCE SPACER	151	449-01-054-0004	GUARD ( NOTE A)
*	32-334	ADJUSTABLE FENCE STOP, INCL.:		449-01-054-0003	GUARD ( NOTES B & D)
103	901-01-060-0612	1/4-20 X 5/8" HEX HD SCREW	152	901-06-423-1170	10-32 X 5/8" HEX HD SCREW
104	904-01-031-7712	FLAT WASHER	153	449-01-313-0001	CONTROL BOX, INCL:
105	449-01-088-0002	FENCE STOP	154	449-01-752-0001	SCHEMATIC - PNEUMATIC
106	449-01-084-0003	FENCE STOP SLIDE - LEFT	154A	449-01-754-0010	PNEUMATIC WARNING DECAL ( NOTE A)
107	449-01-084-0004	FENCE STOP SLIDE - RIGHT		449-01-754-0005	PNEUMATIC WARNING DECAL ( NOTE B)
108	449-01-367-0003	RATCHET LEVER	154B	449-01-754-0011	RECEPTACLE WARNING DECAL ( NOTE A)
109	904-01-010-1614	FLAT WASHER		449-01-754-0006	RECEPTACLE WARNING DECAL ( NOTE B)
110	902-01-120-1034	1/4-20 HEX NUT	155	438-01-004-0094	HEYCO BUSHING
111	902-05-000-2919	WELD NUT	156	906-50-013-1728	LIMIT SWITCH
112	449-01-391-0002	TABLE W/SCALES	157	901-05-163-1743	8-32 X 1" PAN HD SCREW
113	901-02-031-7612	1/4-20 X 1 1/4" FLAT HD SCREW	160	901-02-031-7612	1/4-20 X 1 1/4" FLAT HD SCREW
114	902-01-293-1240	1/4-20 KEPS NUT	161	449-01-409-0002	CYLINDER CLAMP ARM
115	449-01-389-0008	TABLE/FENCE SUPPORT - LEFT, INCL: ( NOTE A)	162	902-01-293-1240	1/4-20 KEPS NUT
	449-01-389-0005	TABLE/FENCE SUPPORT - LEFT, INCL: ( NOTE B)	163	449-01-628-0010	HARDWARE PACK, INCL.: 102, 128, 133
116	905-01-010-2729	3/16" X 1/2" SPRING PIN	164	449-01-628-0009	HARDWARE PACK, INCL.: 40, 42, 113, 117, 118, 119, 127, 129, 130
117	904-01-010-1614	FLAT WASHER			
118	904-02-020-1702	1/4" LOCK WASHER			
119	901-01-060-3124	1/4-20 X 1 1/2" HEX HD SCREW			
120	436-02-020-0001	CAP 1" X 2"			
121	901-01-060-3124	1/4-20 X 1 1/2" HEX HD SCREW			
122	904-01-031-2934	1/4" FLAT WASHER			
123	902-01-293-1240	1/4-20 KEPS NUT			
124	901-01-060-5768	1/4-20 X 2 1/2" HEX HD SCREW			
125	904-01-031-2934	1/4" FLAT WASHER			
126	449-01-305-0003	BASE ASSY			
	449-01-305-0002	BASE ASSY			
127	902-01-293-1240	1/4-20 KEPS NUT			
128	424-12-060-0005	KNOB			
129	904-01-010-1620	FLAT WASHER			
130	901-11-020-0834	5/16-18 X 3/4" CARRIAGE HD SCREW			
131	449-01-389-0007	TABLE/FENCE SUPPORT, INCL: ( NOTE A)			
	449-01-389-0004	TABLE/FENCE SUPPORT, INCL: ( NOTE B)			
132	905-01-010-2729	3/16" X 1/2" SPRING PIN			
133	422-27-084-0006	NYLON SLIDE			
135	449-01-050-0003	SET-UP GAGE			

## SERVICE NOTE:

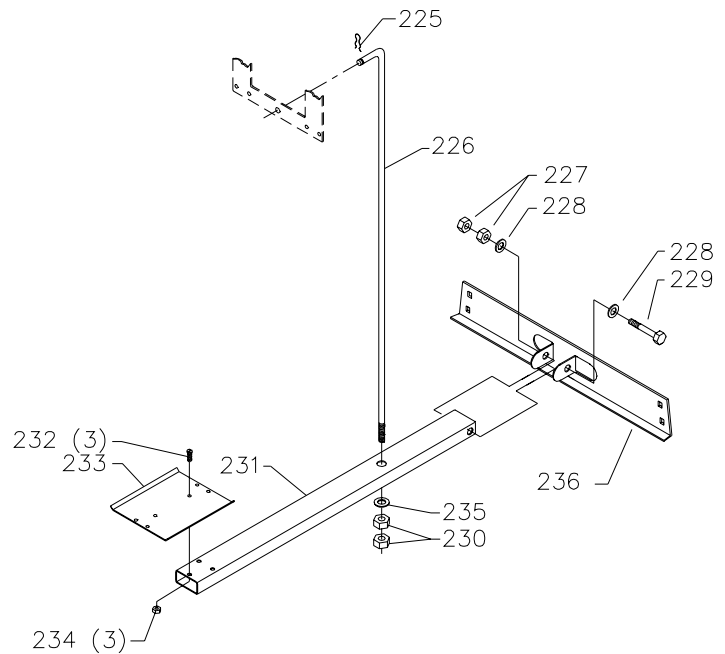
*D - Early models had work cylinder with 2.10" O.D. barrel.*

*Current models have work cylinders with 2.55" O.D. barrel.*

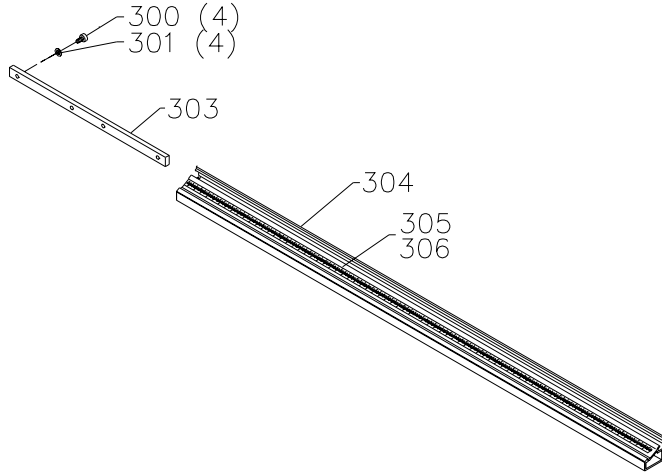


<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>
*	32-331	STAND, INCL.:
200	901-01-060-0607	5/16-18 X 3/4" HEX HD SCREW
201	904-01-013-1855	FLAT WASHER ( NOTE A)
	904-01-010-1620	FLAT WASHER ( NOTE B)
202	904-02-010-1703	5/16" LOCK WASHER
203	902-01-010-1300	5/16-18 HEX NUT
204	427-99-014-0096	BRACKET - 13.66"
205	427-99-014-0097	BRACKET - 16.56"
206	901-11-023-1476	5/16-18 X 5/8" CARRIAGE HD SCREW
207	904-01-013-1855	FLAT WASHER ( NOTE A)
	904-01-010-1620	FLAT WASHER ( NOTE B)
208	902-01-013-1859	5/16-18 HEX NUT
	902-01-010-1300	5/16-18 HEX NUT
209	427-99-014-0099	BRACKET - 22.57" ( NOTE A)
	427-99-014-0089	BRACKET - 22.57" ( NOTE B)
210	427-99-014-0098	BRACKET - 19.67"
211	427-99-066-0045	LEG
212	427-99-048-0001	FOOT
*	NOT SHOWN ASSEMBLED	

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>
*	32-335	FOOT PEDAL, INCL.;; CF
225	422-04-079-5001	SPRING CLIP
226	449-01-108-0003	LINK ROD
227	902-01-020-1266	1/2-13 JAM NUT
228	904-01-010-1636	FLAT WASHER
229	901-01-060-0643	1/2-13 X 4" HEX HD SCREW
230	902-01-020-5433	3/8-16 JAM NUT
231	449-01-066-0001	FOOT PEDAL LEG
232	901-03-040-8015	1/4-20 X 1/2" BUTTON HD SCREW
233	432-10-048-0001	FOOT TREADLE
234	902-05-000-2919	WELD NUT
235	904-01-010-1615	FLAT WASHER
236	427-99-014-0100	BRACKET W/EARS - 19.67" ( NOTE A)
	427-99-014-0090	BRACKET W/EARS - 19.67" ( NOTE B)
*	NOT SHOWN ASSEMBLED	

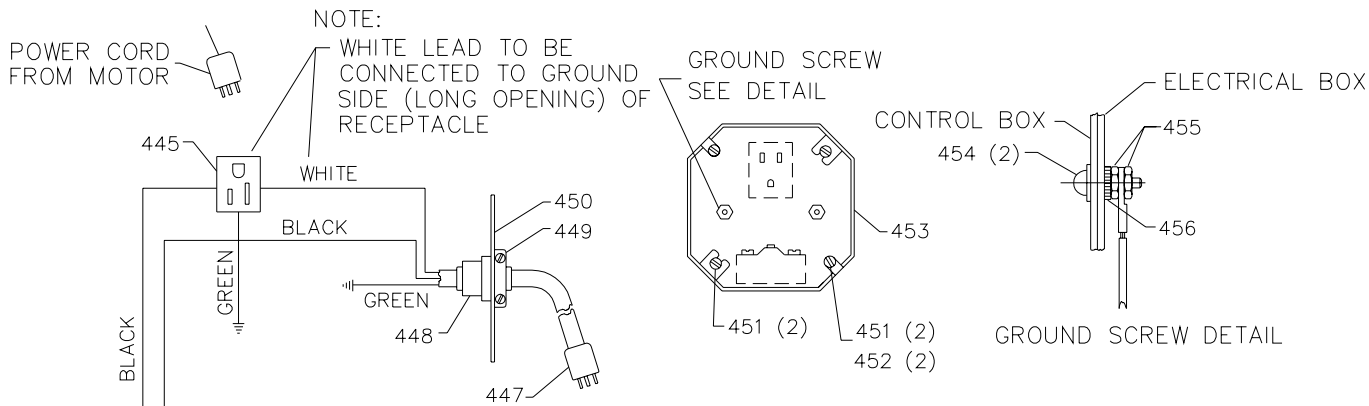


# REPLACEMENT PARTS AVAILABLE AS ACCESSORIES



<b>Ref. No.</b>	<b>Part No.</b>	<b>Description</b>
*	32-333	FENCE EXTENSION, INCL.:
300	901-03-010-0763	1/4-20 X 3/8" HEX SOC HD SCREW
301	904-01-031-2934	1/4" FLAT WASHER
303	449-01-004-0003	FENCE EXTENSION BAR
304	449-01-043-0003	FENCE EXTENSION
305	449-01-132-0003	SCALE - LEFT
306	449-01-132-0004	SCALE - RIGHT
*	NOT SHOWN ASSEMBLED	

# ELECTRICAL WIRING SCHEMATIC

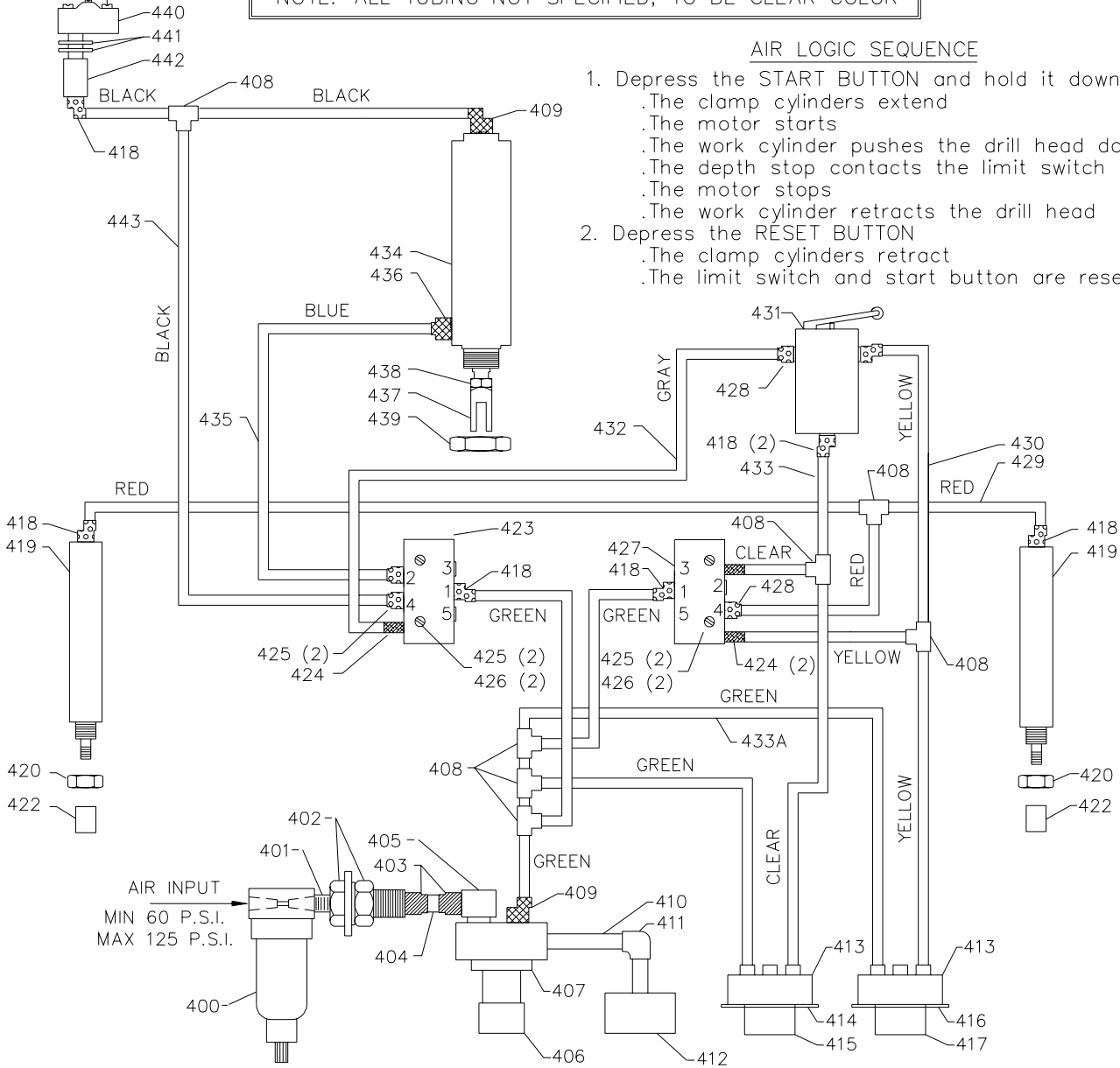


## AIR LINE SCHEMATIC

NOTE: ALL TUBING NOT SPECIFIED, TO BE CLEAR COLOR

### AIR LOGIC SEQUENCE

1. Depress the START BUTTON and hold it down
  - .The clamp cylinders extend
  - .The motor starts
  - .The work cylinder pushes the drill head down
  - .The depth stop contacts the limit switch
  - .The motor stops
  - .The work cylinder retracts the drill head
2. Depress the RESET BUTTON
  - .The clamp cylinders retract
  - .The limit switch and start button are reset



# REPLACEMENT PARTS

Ref.			Ref.		
No.	Part No.	Description	No.	Part No.	Description
400	449-01-046-0001	AIR FILTER	429	906-99-223-1733	5/32" X 36" TUBING - RED ( NOTE C)
401	906-10-013-1719	NIPPLE	430	906-99-223-1737	5/32" X 36" TUBING - YELLOW ( NOTE C)
402	906-11-163-1722	BULK HEAD FITTING	431	906-50-013-1728	LIMIT SWITCH
403	906-11-163-1721	1/4 X 1/4 MALE CONNECTOR	432	906-99-223-1736	5/32" X 36" TUBING - GRAY ( NOTE C)
404	906-99-223-1731	1/4" X 5" TUBING - CLEAR	433	906-99-223-1732	5/32" X 36" TUBING - CLEAR ( NOTE C)
405	906-03-123-1745	1/4" STREET ELL	433A	906-99-223-1755	5/32" X 36" TUBING - GREEN ( NOTE C)
406	909-03-013-1729	AIR REGULATOR, INCL:	434	449-01-035-0003	WORK CYLINDER
407	449-01-079-0004	RETAINING NUT	435	906-99-223-1735	5/32" X 36" TUBING - BLUE ( NOTE C)
408	906-09-013-1717	5/32" TEE	436	906-11-163-1740	1/4 X 5/32" MALE CONNECTOR
409	906-03-123-1714	1/4 X 5/32 MALE ELBOW	437	449-01-082-0002	ROD CLEVIS, INCL:
410	906-10-013-1718	PIPE NIPPLE	438	902-01-020-1227	1/2-20 JAM NUT
411	906-03-123-1716	1/8" UNION ELBOW	439	902-01-043-1758	1 3/8" HEX NUT
412	909-03-013-1746	AIR PRESSURE GAGE	440	438-01-017-0208	AIR ELECTRIC SWITCH
413	906-50-013-1726	ACTUATOR VALVE	441	904-01-010-1607	1/2" FLAT WASHER
414	960-03-043-1747	RESET DECAL PLATE	442	438-01-017-0210	PILOT SWITCH
415	438-01-017-0211	PUSH BUTTON SWITCH - BLACK	443	906-99-223-1734	5/32" X 36" TUBING - BLACK ( NOTE C)
416	960-03-043-1723	START DECAL PLATE	445	438-01-007-0068	OUTLET (120V)
417	438-01-017-0209	PUSH BUTTON SWITCH - GREEN	447	438-01-302-0677	POWER CORD, INCL:
418	906-03-123-1715	1/8" MALE ELBOW	448	438-01-011-0054	INSULATOR SLEEVE
419	449-01-035-0002	CLAMP CYLINDER, INCL:	449	438-01-004-0007	CORD CLAMP
420	902-01-020-1227	1/2-20 JAM NUT	450	438-01-001-0062	ELECTRICAL BOX COVER
422	449-01-016-0002	RUBBER BUMPER	451	901-02-010-0554	08-32 X 1/2" ROUND HD SCREW
423	906-50-013-1724	SINGLE ACT PILOT VALVE	452	902-01-120-1204	08-32 HEX NUT
424	906-11-163-1741	10-32 X 5/32" MALE CONNECTOR	453	438-01-001-0061	ELECTRICAL BOX
425	901-02-013-1742	4-40 X 1" ROUND HD SCREW	454	901-02-010-0559	10-32 X 1/2" ROUND HD SCREW
426	902-01-120-5432	04-40 HEX NUT	455	904-03-030-1757	1/4" EXT TOOTH WASHER
427	906-50-013-1725	DOUBLE ACT PILOT VALVE	456	902-01-120-1203	10-32 HEX NUT
428	906-11-163-1720	1/8" MALE CONNECTOR			

## SERVICE NOTE:

*C - Tubing is sold at one length and must be cut to meet specific needs.*

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## STANDARD SAFETY EQUIPMENT

In order to promote tool safety, Delta Machinery strictly enforces the policy of repairing or replacing any damaged or missing standard safety equipment on machines presented to Delta Authorized Service Centers for service/repairs. Any product that is presented to a Delta Authorized Service Center for repair with damaged or missing standard safety equipment will have that equipment repaired or replaced and the customer will be charged for any such service/repairs. Customers can avoid such charges only if the missing safety component is supplied to the service center at the time of repair.

This parts list is provided to aid in obtaining service parts. Copies of the instruction and maintenance literature can be obtained through the Delta Technical Publications Department, your service outlet, or by visiting the Delta Website @ [www.deltamachinery.com](http://www.deltamachinery.com).