**TECHNICAL MANUAL**

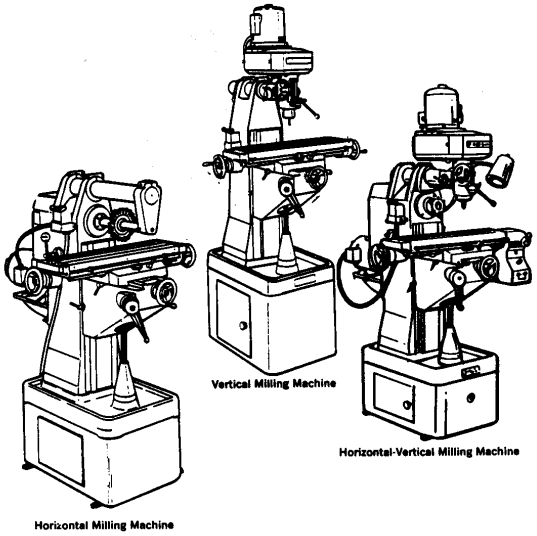
# OPERATOR'S, ORGANIZATIONAL, DIRECT SUPPORT AND GENERAL SUPPORT MAINTENANCE MANUAL INCLUDING REPAIR PARTS LIST

**FOR**

**MILLING MACHINE**
**MODELS 21-122-W/49-697 & 52-020**
**(NSN 3417-00-494-9573)**
**(ROCKWELL INTERNATIONAL CORP.)**

**H E A D Q U A R T E R S , D E P A R T M E N T O F T H E A R M Y**

**OCTOBER 1981**




**WARNING**

**1. IF YOU ARE NOT thoroughly familiar with the operation of Milling Machines, obtain advice from your supervisor, instructor or other authorized person.**

**2. MAKE SURE wiring codes and recommended electrical connections are followed and that machine is properly grounded.**

**3. HAVE the power off when making any adjustment.**

**4. REMOVE tie, rings, watch and other jewelry and roll up sleeves.**

**5. ALWAYS wear safety glasses or a face shield.**

**6. BE SURE work is properly clamped in place before making a cut.**

**7. BEFORE STARTING a cut , set the proper feed, speed and depth of cut. Failure to follow this rule can break a cutter, bend an arbor, throw a work piece out of the machine, or cause some other dangerous condition.**

**8. YOU will have a broken cutter, etc. If you start cutting with the feed set for rapid traverse.**

**9. KEEP machine clean and free of chips. Shut off power and wait for machine to stop before removing chips. Do not clean machine with a rag or a brush while machine is running.**

**10. MAKE SURE cutters are sharp. Handle them with care to avoid cutting yourself.**

**11. BE SURE cutter is turning in the right direction. A broken cutter, etc. can occur if cutter is turning backwards.**

**12. GUARDS should be used at all times.**

**13. IF A COOLANT is used, wash your hands and arms thoroughly to prevent danger of dermatitis or infection from the coolant.**

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Technical Manual
No. 9-3417-211-14&P

HEADQUARTERS
DEPARTMENT OF THE ARMY
Washington, DC, *27 October 1981*

# OPERATOR'S, ORGANIZATIONAL, DIRECT SUPPORT AND GENERAL SUPPORT MAINTENANCE MANUAL INCLUDING REPAIR PARTS LIST FOR MILLING MACHINE MODELS 21-122 W/49-697 & 52-020 NSN 3417-00-494-9573

**REPORTING OF ERRORS**

**You can help improve this manual. If you find any mistakes or if you know of a way to improve the procedures, please let us know. Mail your letter, DA Form 2028 (Recommended Changes to Publications and Blank Forms), or DA Form 2028-2, located in the back of this manual direct to: Commander, US Army Armament Materiel Readiness Command, ATTN: DRSAR-MAS, Rock Island, IL 61299.**
**A reply will be furnished directly to you.**

**NOTE**

**This manual is published for the purpose of identifying an authorized commercial manual for the use of the personnel to whom this equipment is issued.**

Manufactured by: Rockwell International Corp.
131 Park Street, NE
Vienna, Virginia 22180

Procured under Contract No. DAAA09-77-C-6003

This technical manual is an authentication of the manufacturers' commercial literature and does not conform with the format and content specified in AR 310-3, Military Publications. This technical manual does, however, contain available information that is essential to the operation and maintenance of the equipment.

## INSTRUCTIONS FOR REQUISITIONING PARTS NOT IDENTIFIED BY NSN

When requisitioning parts not identified by National Stock Number, it is mandatory that the following information be furnished the supply officer.

1 - Manufacturer's Federal Supply Code Number - 80318

2 - Manufacturer's Part Number exactly as listed herein.

3 - Nomenclature exactly as listed herein, including dimensions, if necessary.

4 - Manufacturer's Model Number - Model 21-122 W/49-697 & 52-020

5 - Manufacturer's Serial Number (End Item)

6 - Any other information such as Type, Frame Number, and Electrical Characteristics, if applicable.

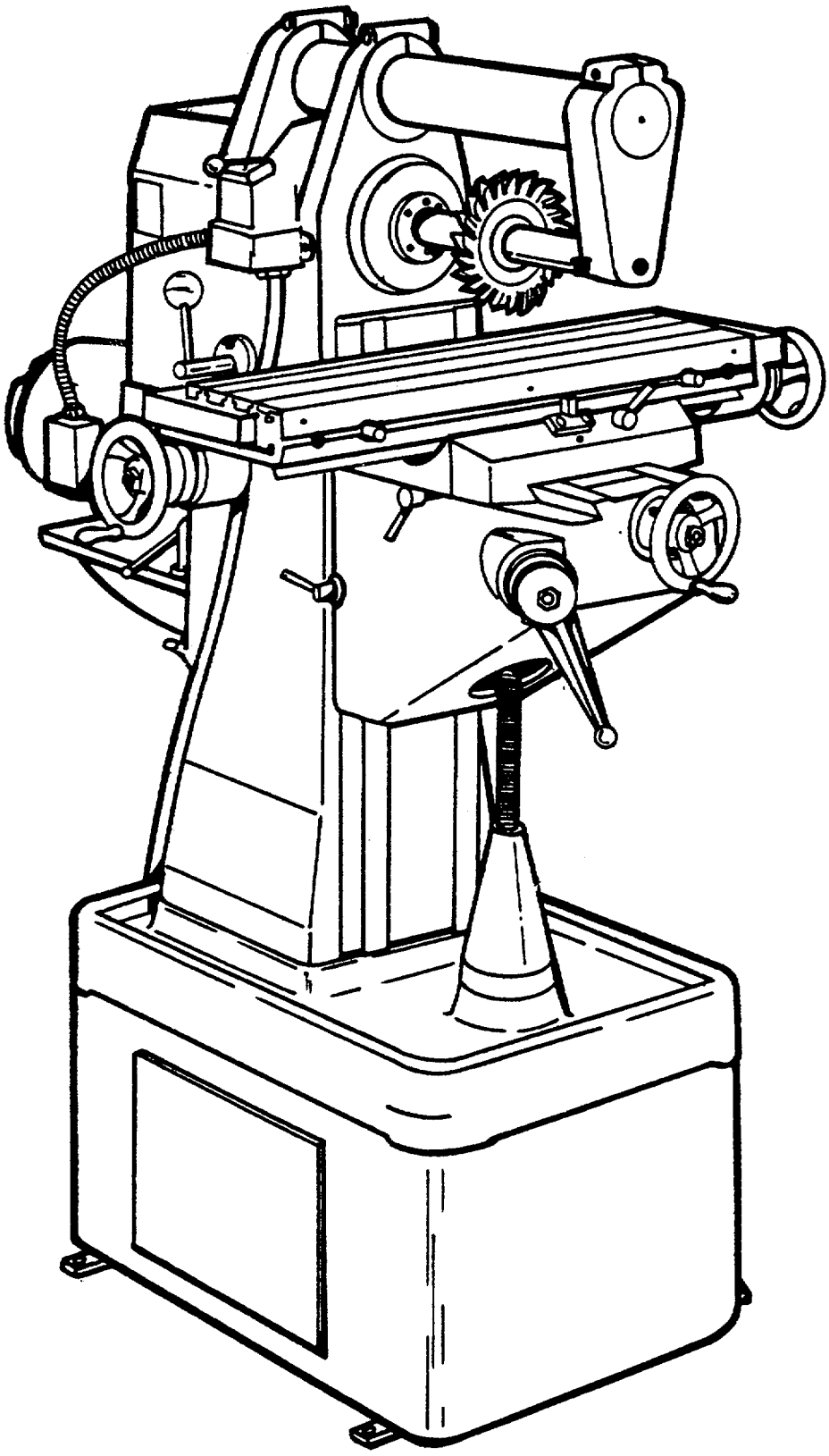
7 - If DD Form 1348 is used, fill in all blocks except 4, 5, 6, and Remarks field in accordance with AR 725-50.

Complete Form as Follows:

(a) In blocks 4, 5, 6, list manufacturer's Federal Supply Code Number — 80318 followed by a colon and manufacturer's Part Number for the repair part.

(b) Complete Remarks field as follows:
Noun: (nomenclature of repair part)
For: NSN: 3417-00-494-9573
Manufacturer: Rockwell International Corp.

Model: 21-122 W/49-697 & 52-020
Serial: (of end item)

Any other pertinent information such as Frame Number, Type, Dimensions, etc.

**HORIZONTAL**
**MILLING MACHINE**