



**INSTRUCTION MANUAL  
AND PARTS LIST  
FOR McLAREN  
MILLING HEAD**



**WELLS-INDEX®**

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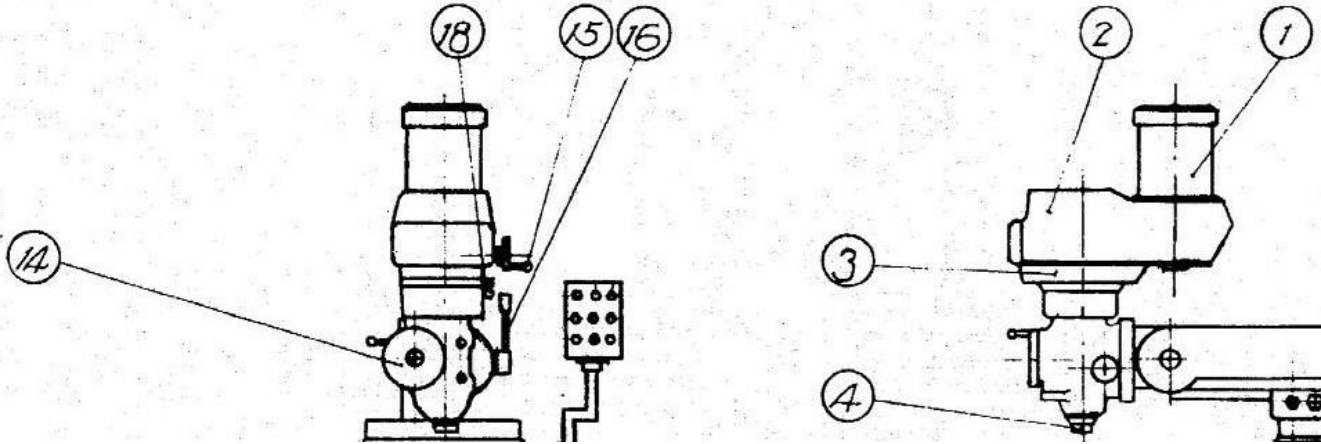
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**McLAREN MILLING HEAD  
INSTRUCTION MANUAL & PARTS LIST**

**INSTRUCTION MANUAL**

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## I. LOCATION OF CONTROLS AND ADJUSTMENTS FOR INDEX MILLING MACHINES



- No. 1 – Motor
- No. 2 – Belt Housing
- No. 3 – Gear Housing
- No. 4 – Spindle

- No. 14 – Automatic Feed Hand Wheel
- No. 15 – Speed Change Hand Wheel
- No. 16 – Pinion Shaft Hub Handle

- No. 18 – Hi-Low Speed Change Handle

## II. Operation

### A. Head stock

#### 1. Reversing Switch

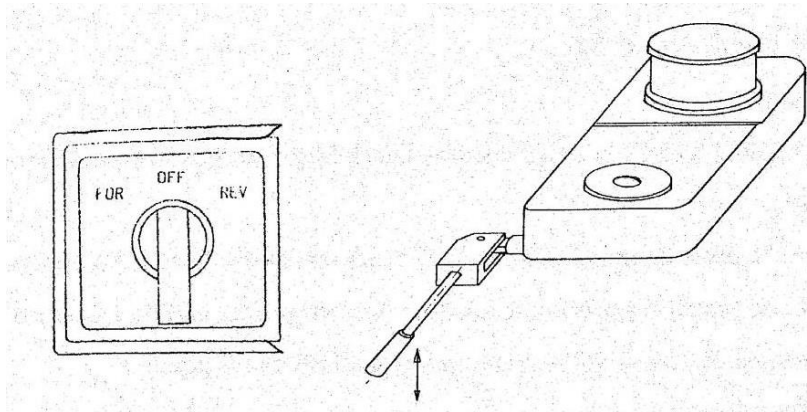
The rotation of the motor is controlled by the reversing switch. When the high low speed lever is placed at the high gear position (forward), and the switch is on the "FOR", then the motor turns clockwise. When the switch is on "REV", the motor turns counterclockwise. When the switch is on "OFF", then the power source is cut off. When high low speed lever is placed at the "LOW" position (backward), the directions are reversed.

#### 2. Spindle Brake

Power must be shut off before braking. When the spindle speed is lower than 200 RPM, operator can pull down or up the brake lever 1 to stop the spindle.

#### 3. Chucking of Tooling Shank and Dismantling

- A. Firstly, the screw of the draw bar is right turn when the spindle is at the highest point. When the screw is turned clockwise, it is for locking of tooling shank, and vice versa. To take out the tooling shank, the draw bar must be turned from three to five rounds. Then, use a soft mallet to hit slightly on the draw bar to allow the tooling shank to separate from the spindle. Turn the draw bar until the tooling shank comes off totally.
- B. When there is a slot in the shank and the spindle taper is R8, it is necessary to turn the tooling shank, in the process of chucking, so that the tooling shank key way will slide into the key grooves.



### III. Spindle Feed

#### A. Manual Feed

The manual feed lever is installed on the right side of head stock. The spindle will travel vertically when the lever is turned. There are 12 positions to be chosen. An operator can freely take out the lever and install it again at the position deemed proper and fit. In manual feed, the feed control handle 4 must be placed at the position "A" as shown.

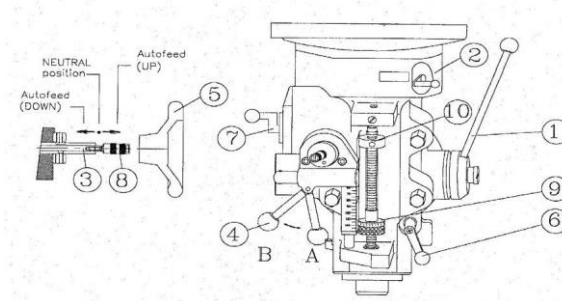
#### B. Manual Micro-Feeding

To use the manual micro-motion feed, the power feeding transmission engagement crank 2 shall be placed at "OUT" position, and feed reverse knob 3, at neutral position. Feed control lever 4 must be pulled from "A" to "B". This is to engage the overload clutch. Turn the feed hand wheel 5 clockwise for quill downward feed, and vice-versa.

#### C. Automatic Feed

- (1) Loosen the quill lock 6.
- (2) Turn the power feed transmission engagement crank 2 from "OUT" to "IN" position. Make certain to engage the worm gear cradle with the spindle gear hub so that the driving will be directed from the spindle worm and worm gear before it is passed to the speed change gears.
- (3) Feed speed is in three stages. H, L, and M. Selection may be made by quill feed selector 7.
- (4) Pull the feed control lever 4 from "A" to "B" position to engage the overload clutch for automatic feed mechanism.

- (5) When the feed reverse knob 8 presses inward, it is for downward feed, and vice-versa. The middle position is neutral.
- (6) The working depth may be set by micrometer adjustment nuts 9 (each graduation is 0.02mm or (0.001"). When the quill stop-block 10 contacts the micrometer adjustment nut 9, the feed control lever 4 may simply jump from "B" to "A"-position owing to the connecting motion between the feed trip lever and feed trip plunger. This will disengage the overload clutch and stop the spindle feed.
- (7) Do not move the power feed transmission engagement crank when the spindle is in revolution.



#### IV. SPEED CHANGE

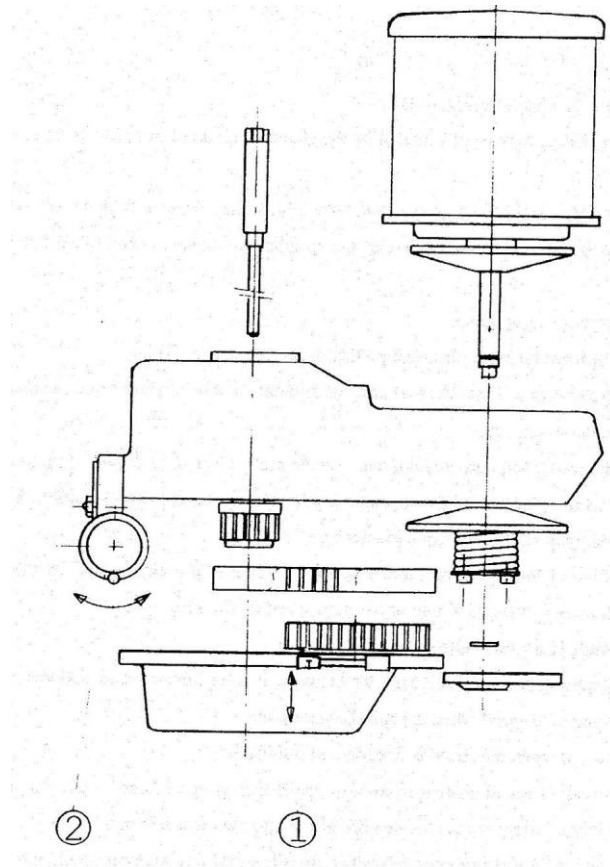
##### A. Speed Change of Spindle

The speed change may be changed by the chosen high and low speed lever 1. When 1 is engaged in the right front, it is for the high speed and the spindle may rotate as high as 500 to 3000RPM. When 1 is positioned at the right rear, the spindle may have a speed of 60-580RPM. The neutral lever position is in the right down.

- (1) The spindle must be motionless completely during the speed change.
- (2) To shift the high speed into the low one, the spindle must be slightly turned to make it easier for the back row gear to engage.
- (3) To shift the low speed into the high one, use the brake lever so as to put a stop to the spindle clutch. Then turn the spindle slightly so that the clutch may be engaged feasibly. A "click" sound of engagement may be sensed at this moment.
- (4) The direction of low speed rotation is opposite to that of the high speed. By the reversing switch, the direction may be changed to that of the high speed revolution.

##### B. Speed Change Hand Wheel

- (1) When the turning hand wheel is turned clockwise, it is for higher speed, and vice versa.
- (2) Do not change the speed when the spindle stands still.
- (3) Avoid using it when the speed is in excess of 3000RPM.
- (4) In the process of speed change from high speed to low speed, and vice versa, do not change the speed rapidly to safeguard the service life of the internal mechanism.

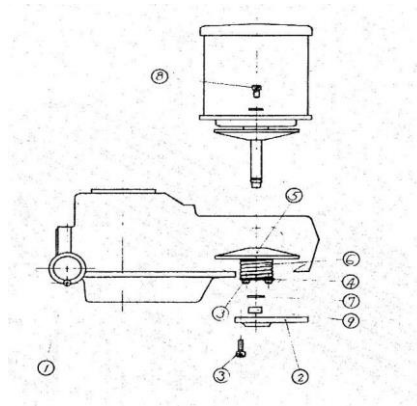


## V. TROUBLE SHOOTING

### A. REMOVING THE MOTOR

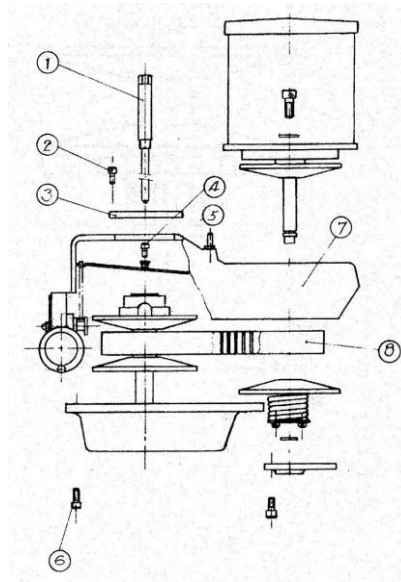
1. Start the motor and turn the speed switch 1 to the center position of 60-4200 RPM
2. Cut off the motor power source and take off wire press board and reversing switch.
3. Take out the three concave hexagonal bolts under the motor pulley cover.
  - a. Using two screwdrivers to insert into the two holes between the motor pulley cover and the belt housing. Then push down to loosen the motor pulley cover 2.
  - b. Place a screwdriver in the speed change spring piece 4 to loosen the motor pulley cover when the above mentioned method failed.

4. Lock two hexagonal bolts (M6 x 45) into the motor vari-disc 5 to compress the speed change spring so as to separate the retainer ring 7.
5. Take off the two hexagonal bolts 8 that locked the motor. The motor may be lifted up. Motor vari-disc and speed change belt are still kept inside the belt housing.
6. Change the speed to 4200 RPM and pull back the belt. Install the motor's wheel and the retainer ring to the shaft. Take out the two screwdrivers from the belt housing.
7. To install, reverse the order of the above steps.



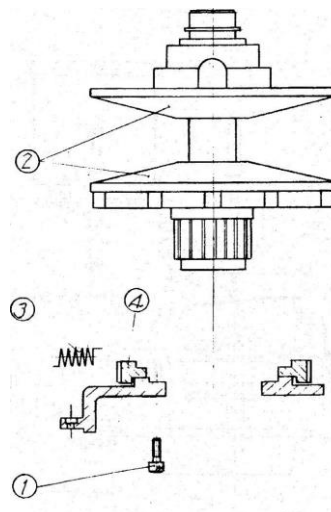
#### B. REPLACEMENT OF SPEED CHANGE BELT

1. Refer to V-A for removing the motor.
2. Take off the draw bar 1.
3. Remove the four hexagonal concave bolts 2 and use them to lift the bearing housing 3.
4. Remove from atop the two hexagonal concave bolts 4 and take off the bolt sleeves 5.
5. Remove six hexagonal concave bolts 6 under the gear housing to remove the upper belt housing 7.
6. When the speed change belt 8 is replaced accordingly, reverse the above steps to reassemble.



C. REPLACEMENT OF BRAKE BLOCK

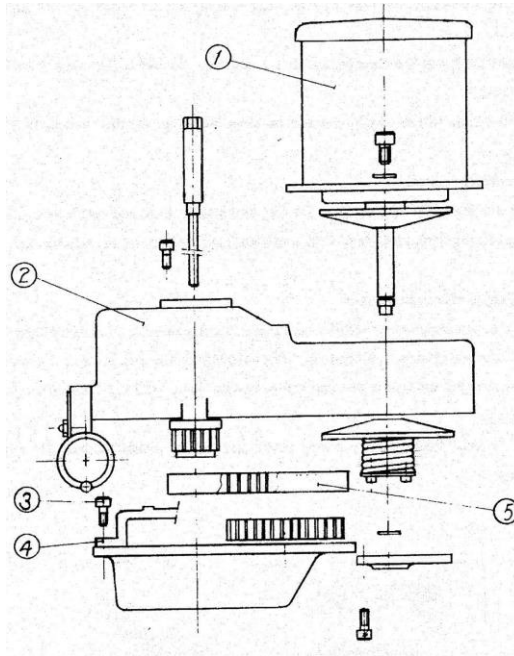
1. Refer to V-A for removing the motor.
2. Refer to V-B on replacement of speed change belt to dismantle the upper belt housing.
3. Remove the gear housing 1 and four hexagonal bolts 2.
4. Remove the hexagonal concave bolt 1 of the two setting bearing housing and remove the front vari-disc assembly set 2. Brake block 3 can be replaced then.
5. Remove six hexagonal concave bolts 6 under the gear housing to remove the upper belt housing 7.
6. Reverse the above steps to reassemble.





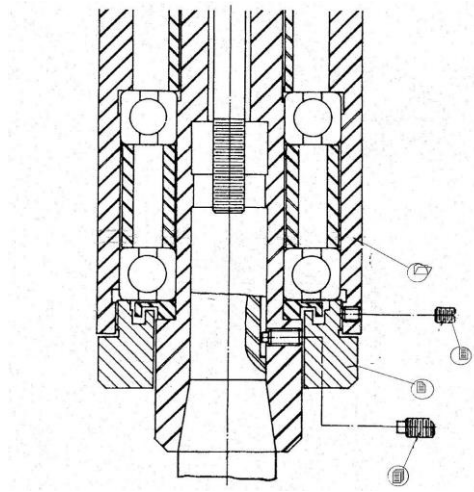
## D. REPLACEMENT OF THE TIMING BELT

1. Refer to V-A for removing the motor.
2. Refer to V-B on replacement of speed change belt to dismantle the upper belt housing. Then the timing belt can be replaced.
3. Reverse the above steps to reassemble.



## E. REPLACEMENT OF COLLET ALIGNING SCREW

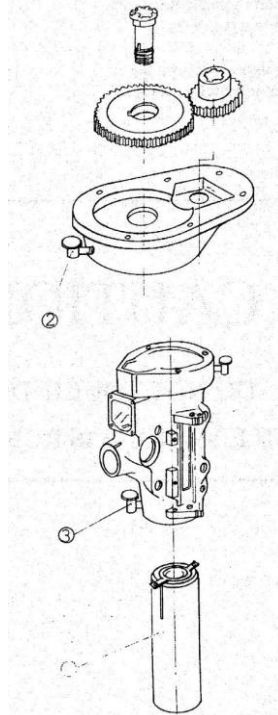
1. Prior to replacement, use a marking pencil to draw a line on quill 1 and its nose piece 2.
2. Loosen the setting screw 3 nose piece. Use a hook spanner to take off the nose piece 2. NOTE: This is a left hand thread!
3. Use a hexagonal spanner of approximate length to take off the collet aligning screw 4 for replacement.
4. When the collet aligning screw is replaced, set the nose piece 2 tightly until it is positioned on the marked line.
5. Set the screw 3 of the nose piece tightly.
6. Note: To replace the collect aligning screw, the collet must be placed inside the quill. Set the collet aligning screw 4 tightly so that it will contact the bottom of the screw key way. Then turn it backward by approximately  $\frac{1}{4}$  of a turn to keep a 0.25mm (0.01") play for easy installation and removal of the shank.

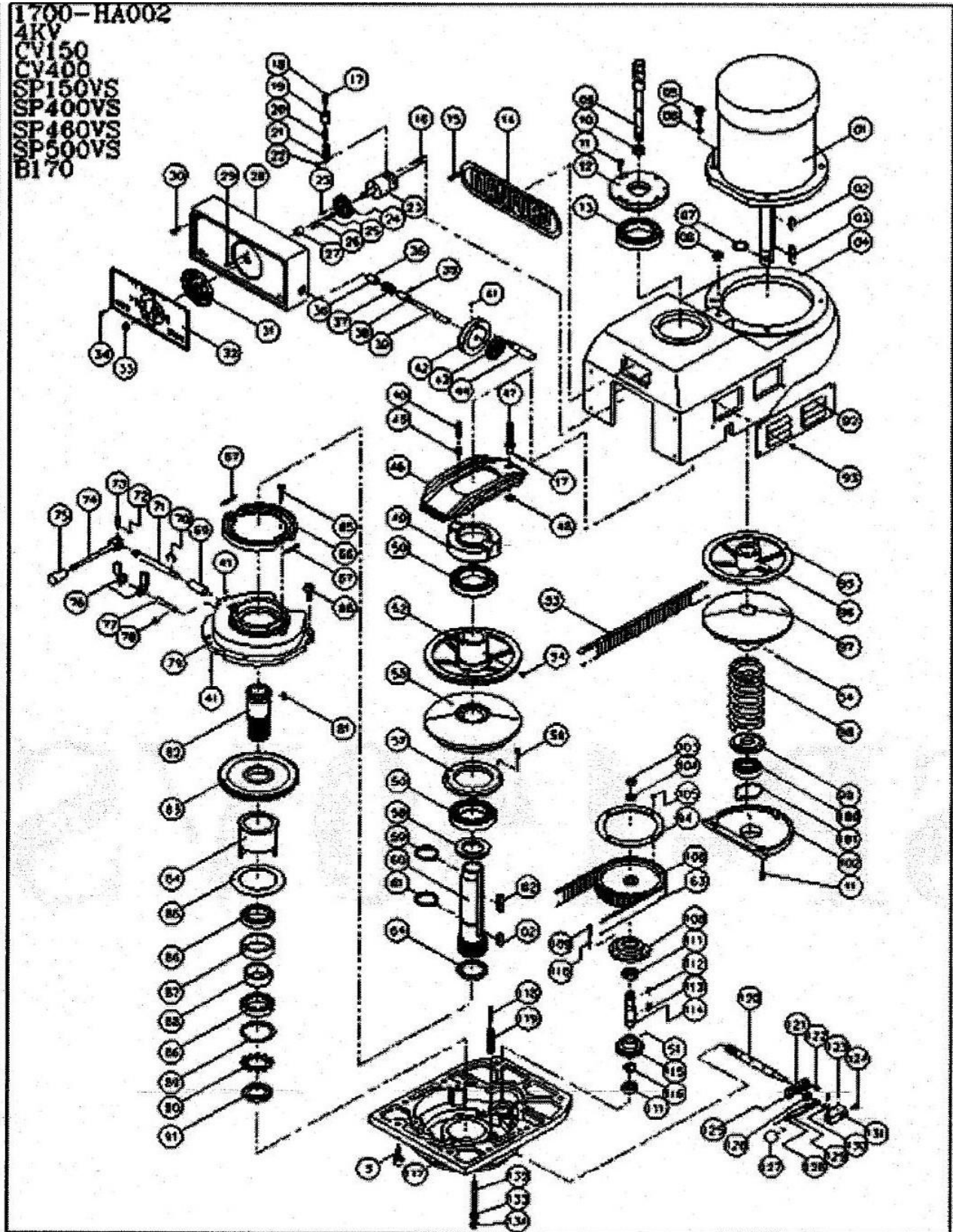


**VI. LUBRICATION**

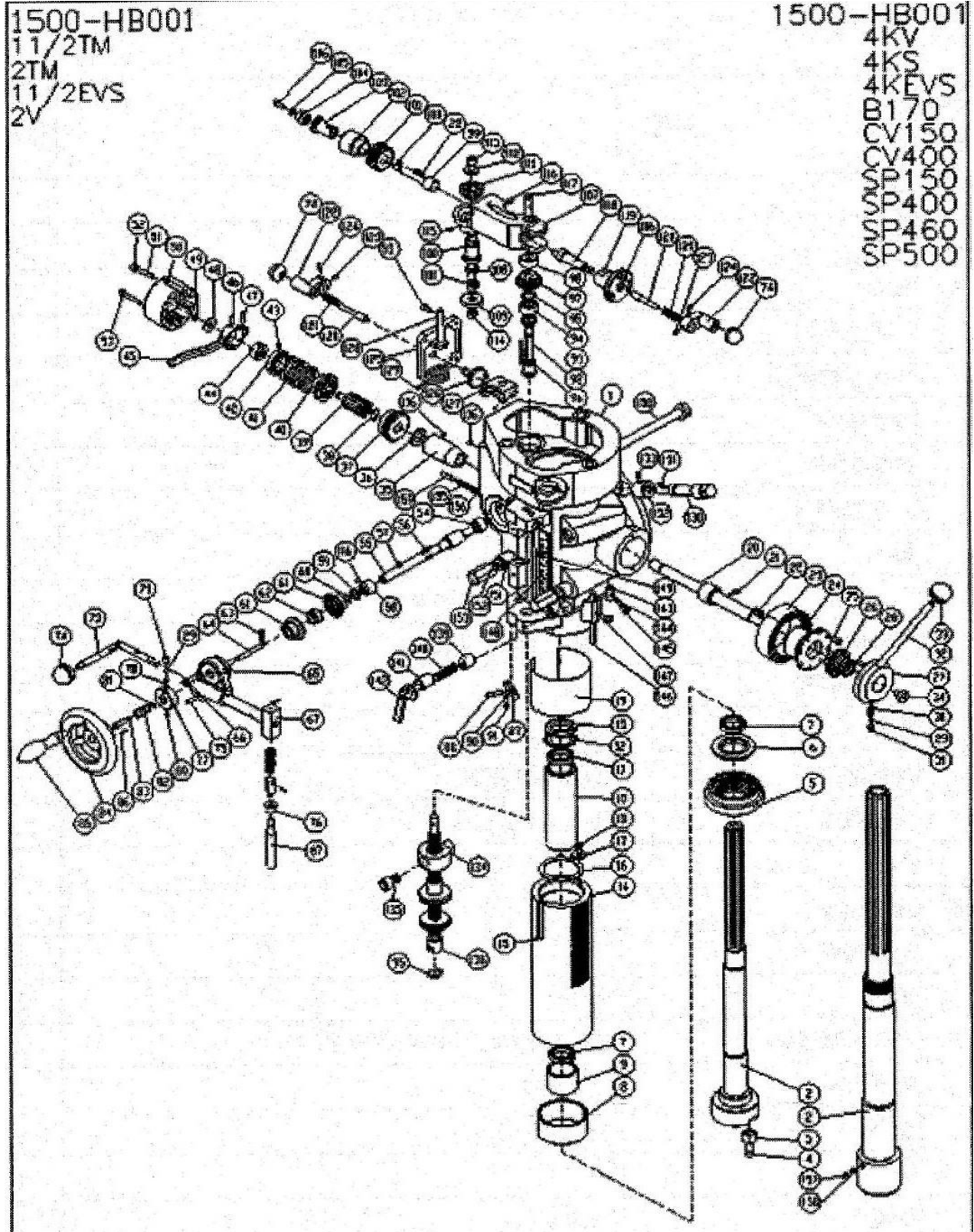
A. Recommended Oil and Locations:

Recommended Lube	Qty.	Time	Position
Vactra Oil #2	Full	Twice Daily	1- Head Stock Quill Holes
Vactra Oil #2	Full	Once Daily	2
Vactra Oil #2	Full	Three times a day	3 - Quill and Head Stock Internal Holes





VARIABLE SPEED DRIVE ASSEMBLY							
SYM.	Qty.	Part Number	Description	SYM.	Qty.	Part Number	Description
	1	M1514	3HP Motor 220V/440V 60Hz	71	1	1710-G074	Brake Lock Shaft
	2	HKE-2R-0810	Key	72	1	HETW-E4	Snap Ring E-Type
	3	1510-G049	Key	73	1	1500-A035	Brake Lock Pin, S45C
	4	1710-T012	Upper Pulley Box	74	1	1510-G070	Brake Lock & Handle
	5	HCAP-W03100	Screw	75	1	1510-G069	Black Plastic Ball Handle
	6	HWS-3/8	Spring Washer	76	1	1710-G067	Brake Finger Pivot Stud
	7	HSTW-S30	Snap Ring C-Type	77	2	1510-G068	Brake Operation Finger
	8	HBBE-W030-16	Nut	78	1	HETW-E6	Snap Ring E-Type
	9	1510-G087	Draw Bar R8 (Inch)	79	1	1710-G053	Brake Base
	10	1500-A039	Washer R8 (Inch) S45C/cm				
	11	HCAP-M06020	Hex-Socket Head Screw	81	1	HKE-1R-08012	Key
	12	1550-A004	Top Bearing Bracket	82	1	1510-T039	Spindle Pulley Hub
	13	BR-6007	Ball Bearing	83	1	1510-T040	Spindle Bull Gear Assembly
	14	N1500-A100	Logo	84	1	1510-T057	Bull Gear Bearing Sleeve
	15	HAEC-W10005	Hex-Socket Head Screw	85	1	1510-T048	Bull Gear Bearing Sleeve Washer
	16	HPB-0340	Hi-Low Detent Plunger	86	2	BR-6908	Ball Bearing
	17	HPB-0420	Hi-Low Detent Plunger	87	1	1510-T043	Bull Gear Bearing Spacer
	18	1510-T088	Speed Change Chain Stud	88	1	1510-T044	Bull Gear Bearing Spacer
	19	1510-T091	Speed Change Chain Stud	89	1	HSTW-R62	Snap Ring C-Type
	20	1510-T011	Speed Change Chain Stud	90	1	AW08-40MM	Spacer
	21	1510-T010	Chain	91	1	1510-T056	Bearing Lock Nut
	22	1510-T092	Chain Washer	92	2	1710-T097	Side Belt Housing Cover
	23	1710-T035	Speed Change Chain Drum	93	8	HAEC-M06008	Cross-Recessed Head Screw
	24	1510-T033	Feed Drive Worm Gear	94	1	15001-A024	Timing Belt Pulley Flange
	25	HPB-0510	Hi-Low Detent Plunger	95	1	1510-G040	Stationary Motor Vari-Disc
	26	HPB-0530	Hi-Low Detent Plunger	96	1	HSET-M06008	Set Screw
	27	1510-T003	Bushing	97	1	1510-G043	Adjustable Motor Vari-Disc
	28	1710-T005	Speed Change Housing	98	1	1510-G044	Spring
	29	1510-T004	Lock Screw	99	1	1510-G045	Spring Washer
	30	HCAP-M06035	Hex-Socket Head Screw	100	1	BR-6204	Ball Bearing
	31	N1710-T002	Variable Speed Dial 60Hz	101	1	BR-6204	Washer
	32	N1710-T094	Speed Indicator Plate	102	1	1710-G054	Motor Pulley Cover
	33	HBBA-W025	Nut	103	1	HBBE-W05	Nut
	34	HAEB-M04006	Screw	104	1	HWS-5/8	Washer
	35	HSET-M05006	Set Screw	105	4	HAAF-M05008	Screw
	36	1500-B088	Compression Spring	106	1	UH151-B016	Pulley Set
	37	1710-T030	Worm	2			Timing Belt Pulley Flange
	38	1710-T027	Worm Cradle Bushing	108	1	1510-T084	Cover
	39	1710-T029	Speed Control Shaft	109	3	HCAP-M05016	Hex-Socket Head Cap Screw
	40	HCAP-M05020	Hex-Socket Head Cap Screw	110	3	HWD-M5	Washer
	41	HSET-M06006	Set Screw	111	2	BR-6203	Ball Bearing
	42	1510-T017	Handle	112	1	HKE-2R-0515	Key
	43	N1510-T020	Speed Change Waring Plate	113	1	HKE-2R-0518	Key
	44	1510-T019	Handle	114	1	1510-T080	Bull Gear Pinion Counter Shaft
	45	2 1510-G019	Pivot Sleeve	115	1	1510-T083	Bull Gear Pinion Counter Gear
	46	1510-G013	Speed Change Plate	116	1	1510-T095	Spacer
	47	1510-G016	Speed Change Plate Pivot Stud	117	1	1510-T049	Gear Housing
	48	HWD-M10	Clutch Washer	118	3	1510-T093	Spring Supported Pin
	49	1510-G022	Sliding Housing	119	3	1510-T055	Spring
	50	2 BR-6010	Ball Bearing	120	1	1510-T059	Bull Gear Shifter Pinion Shaft
	51	HSET-M08006	Set Screw	121	1	1510-T060	Hi-Low Detent Plate
	52	1510-G025	Adjustable Driven Vari-Disc Assembly	122	2	HCAP-M06035	Hex-Socket Head Cap Screw
	53	1510-G027	Belt 38x890	123	2	HPB-0320	Hi-Low Detent Plunger
	54	HSET-M05008	Screw	124	1	HCAP-M06016	Hex-Socket Head Cap Screw
	55	1510-G028	Stationary Driven Vari-Disc	125	1	HSET-M04016	Set Screw
	56	4 HCAP-M06035	Hex-Socket Head Cap Screw	126	1	1510-T065	Adjustment Plate
	57	1510-G0259	Brake Bearing Cap	127	1	1500-A046	Black Plastic Ball 1/4" Diameter
	58	1510-G033	Spindle Pulley Spacer	128	1	1510-T070	Hi-Low Shift Crank
	59	HSTW-S35	Snap Ring C-Type	129	1	1510-T066	Hi-Low Detent Plunger
	60	1510-G034	Spindle Clutch Device	130	1	1510-T067	Spring
	61	HSTW-S40	Snap Ring C-Type	131	1	1510-T071	Hi-Low Pinion Block
	62	1510-G039	Sliding Key	132	3	1510-G090	Studs
	63	1500-A023	Timing Belt 225L	133	3	1500-A077	Washer
	64	1510-T038	Timing Pulley Clutch Sleeve	134	3	HBBE-W35	Nut
	65	1510-G035	Brake Ring Screw				
	66	1510-G032	Brake Shoe				
	67	2 1510-G031	Brake Spring				
	68	3 HCAP-M08020	Hex-Socket Head Cap Screw				
	69	1510-G073	Sleeve for Brake				
	70	HSTW-S12	Snap Ring C-Type				



LOWER HEAD ASSEMBLY, PAGE 1							
SYM.	Qty.	Part Number	Description	SYM.	Qty.	Part Number	Description
1	1	1500-B192	Milling Head	41	1	1800-B079	Safety Clutch Spring
2	1	1500-B127+129	Spindle	42	1		Overload Clutch Locknut
	1	1500-B193+129	Spindle	43	1	HSET-M05005	Set Screw
3	2	1500-B026	Stop Block	44	1	1500-B075	Clutch Ring
4	2	5/16" x 5/8"	Hex-Socket Head Cap Screw	45	1	1500-B096	Overload Clutch Trip Lever
5	1	1500-B194	Nut				
	1	1500-B133	Nut	46	2	1500-B074	Clutch Ring Pin
				47	1	HPB-0518	Overload Clutch Lever Spring Washer
6	1	1500-B134	Spindle Dirt Shield	48	1	1500-B097	Overload Clutch Washer
7	2	BR-7207	NSK Bearing (P4)	49	1	HSTW-S10	Snap Ring C-Type
8	1	1500-B137	Bearing Spacer (Large)	50	1	1500-B099	Clutch Arm Cover
9	1	1500-B136	Bearing Spacer (Large)				
10	1	1500-B132	Sleeve	51	1	HSET-W020060	Set Screw
				52	1	HBBA-W020	Nut
11	1	BR-6206	Bearing	53	2	HCAP-M05035	Hex-Socket Head Cap Screw
12	1	AW06-30MM	Lock Washer	54	1	1500-B042	Bushing
13	1	1500-B129	Locknut Washer	55	1	1500-B057	Feed Worm Shaft
14	1	1500-B142	Quill				
15	1	HSET-M05005	Set Screw	56	1	HKE-2R-3315	Flat Key
				57	1	HKE-2R-3310	Flat Key
16	1			58	1	1500-B044	Feed Worm Shaft Bushing
17	2	HWA-M5	Washer	59	1	1500-B047	Feed Worm Shaft Thrust Washer
18	2	HCAP-M05010	Hex-Socket Head Cap Screw	60	1	HSTW-S12	Snap Ring C-Type
19	1	1500-B128	Quill Skirt				
20	1	1500-B166	Quill Pinion Shaft	61	2	1500-B049	Feed Reverse Bevel Gear
				62	1	1500-B050	Feed Reverse Clutch
21	1	1500-B168	Pin	63	1	HPB-0312	Overload Clutch Lever Spring Plunger
22	1	HKE-2R-3318	Flat Key	64	1	1500-B055	Reverse Clutch Rod
23	1	1500-B178	Clock Spring	65	1	1500-B106	Feed Trip Bracket
24	1	1500-B177	Spring Cover				
25	2	HCAP-M05012	Hex-Socket Head Cap Screw	66	2	HCAP-M06020	Hex-Socket Head Cap Screw
				67	1	1500-B118	Cam Rod Sleeve Assembly
26	1	1500-B176A	Pinion Shaft Hub Sleeve		1		Spring
27	1	1500-B175	Back Feed Handle Hub (Quill Feed Lever)		1		Trip Plunger
28	1	HPB-0516	Overload Clutch Lever Spring Plunger		1	HPB-0312	Overload Clutch Lever Spring Plunger
29	1	HETC-W015	Steel Ball		1	HPB-0314	Overload Clutch Lever Spring Plunger
30	1	1500-B174	Compression Spring				
					1		Cam Rod
31	1	HSET-W025030	Set Screw	73	1	1500-B104	Trip Handle
32	1	1500-B190	Pinion Shaft Hub Handle	74	3	1500-A046	Black Plastic Ball " Diameter
33	1	1500-B191	Black Plastic Ball	75	1	HPB-0520	Overload Clutch Lever Spring Plunger
34	1	1500-B172	Pinion Shaft Hub Screw				
35	1	1500-B090	Quill Pinion Shaft Bushing	76	1	1500-B123	Trip Plunger Bushing
				77	1	1500-B113	Handwheel Clutch
36	1	1500-B091	Quill Pinion Shaft Worm Gear Spacer	78	1	1500-B115	Compression Spring
37	1	1500-B092+B093	Overload Clutch Worm Gear	79	1	1500-B116	Handwheel Clutch Spring Screw
38	1	HSTW-S15	Snap Ring C-Type	80	1	HSET-W020020	Set Screw
39	1	1500-B081+807E	Overload Clutch				
40	1		Overload Clutch				



LOWER HEAD ASSEMBLY, PAGE 2							
SYM.	Qty.	Part Number	Description	SYM.	Qty.	Part Number	Description
81	1	HSTW-E5	Snap Ring E-Type	121	1	1500-B021	Compression Spring
82	1	1500-B110+111	Feed Reverse Knob Stud	122	1	1500-B023	Shift
83	1		Feed Reverse Knob Stud Bolt	123	2	HSET-W020020	Set Screw
84	1	15001-B125+126	Handwheel & Handwheel Handle	124	1	HPB-0320	Overload Clutch Lever Spring Plunger
85	1		Handle	125	1	1500-B066	Cluster Gear Cover
86	1	HPB-0316	Overload Clutch Lever Spring Plunger	126	1	1500-B064	Cluster Gear Shift Crank
87	1	1500-B124	Feed Trip Plunger	127	1	1500-B063	Feed Gear Shift Fork
88	1	1500-B146	Trip Lever Pin	128	1	1500-B060	Feed Shift Rod
89	1	1500-B145	Feed Trip Lever	129	1	HPB-0318	Overload Clutch Lever Spring Plunger
90	1	HSET-M04020	Set Screw	130	1	1500-B189	Adjustable Worm Shaft
91	1	HBBE-M04	Nut	131	1	HKE-2R-4418	Flat Key
92	1	1500-B031	Cluster Gear Shaft	132	1	1500-B186	Worm Gear
93	1	1500-B034	Bevel Gear Thrust Spacer	133	1	1500-B140	Set Screw
94	1	1500-B033	Bevel Gear Bushing	134	1	1500-B163	Quill Stop Knob
95	1	HSTW-S16	Snap Ring C-Type	135	1	HCAP-W030050	Hex-Socket Head Cap Screw
96	1	HKE-2R-3345	Flat Key	136	1	1500-B164	Quill Stop Micro-Screw (Metre)
97	1	1500-B028	Cluster Gear		1		Quill Stop Micro-Screw (Inch)
98	1	1500-B027	Cluster Gear Shaft Upper Bushing		1		Micro Meter Nut (Metre)
99	1	1500-B009	Feed Drive Worm Gear Shaft	139	1	1500-B148	Quill Lock Sleeve
100	1	HKE-2R-3308	Flat Key	140	1	1500-B200	Spring
101	1	1500-B008	Feed Drive Worm Gear Shaft	141	1	1500-B153	Quill Lock Sleeve Tapped
102	1	1500-B005	Worm Cradle Bushing	142	1	1500-B149	Quill Lock Bolt & Spring
103	1	1500-B004	Feed Worm Gear Shaft Sleeve	143	1	1500-B184A	Feed Reverse Trip Plunger
104	1	1500-B003	Feed Bevel Pinion	144	1	1500-B183	Reverse Trip Ball Lever
105	1	1500-B002	Washer	145	1	1500-B185	Reverse Trip Ball Lever Screw
106	1	HCAP-M05012	Hex-Socket Head Cap Screw	146	1	1500-B147	Indicator Rod
107	1	1500-B017	Worm Gear Cradle	147	1	1500-B154	Indicator Rod Screw
108	1	1500-B036+38	Feed Driving Gear	148	1	N1500-B159	Micro-Screw Gauge (Metric)
109	1	1500-B040	Feed Drive Gear		1	N1500-B195	Micrometer Scale (Inch)
110	1	HKE-2R-3310	Flat Key	149	1	HAEC-W100015	Cross-Recessed Head Screw
				150	4	1500-B155	1/2" x 12 NC T-Bolt
111	1	1500-B015	Feed Reverse Bevel Gear				
112	1	1500-B013	Washer	151	2	1500-B156	Lower Clamping Bolt Spacer
113	1	HCAP-M08016	Hex-Socket Head Cap Screw	152	4	HWA-N4	Washer
114	1	BR-BA060	Bearing	153	4	1500-B157	1/2" x 12 NC Adapter Nut
115	1	1500-B054	Set Screw M6 x 25	154	4	HBBE-W040-13	Nut
				155	1	1500-B082	M4 x 15 Hex-Socket Head Cap Screw
116	1	HSET-M06006	Set Screw				
117	1	1500-B016	Feed Engage Pin	156	1	1500-B088	Compression Spring
118	1	1500-B018	Worm Gear Cradle Throw-Out	157	1	1500-B140	Special Socket Set Screw
119	1	1500-B019	Shift Sleeve	158	1	HSET-M06005	Set Screw
120	1	1500-B020	Gear Shift Plunger	159	1	1500-B089	Overload Clutch Lever Spring Plunger