

# Saddle Machines

- Every model works on a range of pipe sizes
- Works with all standard torches, including plasma
- Light and compact, perfect for shop or field applications
- Mount and begin cutting in as little as 5 minutes
- Depended on by professionals for over 70 years
- Pipe is ready to weld up to five times quicker than hand cutting and grinding



## ALL SADDLE MACHINES INCLUDE

- Base Machine
- Torch Arm
- Torch Carrier Assembly
- Spacers to allow the machine to cut pipe sizes not listed above (within range specified), are available at an additional cost
- Boomer Assembly (fastens the machine to the pipe)
- Cutting Torch Not Included
- Parts and Operating Manual
- 6SA and 8SA include extension plate and spacers

## MANUAL (W/SPACER BOLTS) FOR OXY-FUEL

Machine Model	Cutting Range (Pipe O.D.)		Includes Spacers to fit pipe sizes (in)	Part No.	Shipping Weight		Shipping Dimensions	
	in	mm			lbs	kg	in	mm
MSA	1.5 - 4	38 - 102	2,3,4	03.0100.000	12	5.4	12x12x10	305x305x229
1SA	3 - 8	76 - 203	3,4,6,8	03.0101.000	24	10.8	18x18x11.5	457x457x292
2SA	6 - 12	152 - 305	6,8,10,12	03.0102.000	34	15.3	23x23x12.5	584x584x318
3SA	12 - 20	305 - 508	12,14,16,18,20	03.0103.000	73	32.9	34x32x12	864x813x305
4SA	20 - 26	508 - 660	20,22,24,26	03.0104.000	150	67.5	40.5x41x19	1029x1041x483
5SA	24 - 30	610 - 762	24,26,28,30	03.0105.000	185	83.3	40.5x41x19	1029x1041x483
6SA	28 - 36	711 - 914	28,30,36	03.0106.000	295	132.8	57x43x19	1448x1092x483
8SA	36-48	914-1219	36,38,40,42,48	03.0108.000	537	241.7	69x60x21	1753x1524x533

## MANUAL (W/STEP SPACERS) FOR OXY-FUEL

Machine Model	Cutting Range (Pipe O.D.)		Includes Spacers to fit pipe sizes (in)	Part No.	Shipping Weight		Shipping Dimensions	
	in	mm			lbs	kg	in	mm
1SA	3 - 8	75 - 203	3,4,6,8	03.01S1.000	24	10.8	18x18x11.5	457x457x292
2SA	6 - 12	152 - 305	6,8,10,12	03.01S2.000	34	15.3	23x23x12.5	584x584x318
3SA	12 - 20	305 - 508	12,14,16,18,20	03.01S3.000	73	32.9	34x32x12	864x813x305



## MOTORIZED SADDLE MACHINES ALSO INCLUDE

- 110/230 VAC Motorized Saddle Machine
- Right-angle precision stepper motor
- Motor Control Box



## PLASMASPEED SADDLE MACHINE

Machine Model	Cutting Range (Pipe O.D.)		Includes Spacers to fit pipe sizes (in)	Part No.	Shipping Weight		Shipping Dimensions	
	in	mm			115 vdc	lbs	kg	in
MSA	1.5 - 4	38 - 102	2,3,4	03.0100.S01	19	8.6	12x12x15	305x305x361
1SA	3 - 8	75 - 203	3,4,6,8	03.0101.S01	31	14.0	18x18x17	457x457x432
2SA	6 - 12	152 - 305	6,8,10,12	03.0102.S01	42	18.9	23x23x19	584x584x476
3SA	12 - 20	305 - 508	12,14,16,18,20	03.0103.S01	85	38.3	34x32x18	864x813x457
4SA	20 - 26	508 - 660	20,22,24,26	03.0104.S01	160	72.0	40.5x41x19	1029x1041x483
5SA	24 - 30	610 - 762	24,26,28,30	03.0105.S01	210	94.5	40.5x41x19	1029x1041x483
6SA	28 - 36	711 - 914	28,30,36	03.0106.S01	300	135.0	57x43x19	1448x1092x483
8SA	36-48	914-1219	36,38,40,42,48	03.0108.S01	537	241.7	69x60x21	1753x1524x533

## SADDLE MACHINE PLASMASPEED RETROFIT KITS

Machine Model	Cutting Range (Pipe O.D.)		Part No.	Shipping Weight		Shipping Dimensions	
	in	mm		115 vdc	lbs	kg	in
MSA	1.5 - 4	38 - 102	03.0100.SA1	7.0	3.2	12x10x6	305x254x152
1SA	3 - 8	76 - 203	03.0101.SA1	7.0	3.2	12x10x6	305x254x152
2SA	6 - 12	152 - 305	03.0101.SA1	8.0	3.6	12x10x6	305x254x152
3SA	12 - 20	305 - 508	03.0103.SA1	9.0	4.1	20x6x6	508x152x152
4SA	20 - 26	508 - 660	03.0103.SA1	9.0	4.1	23x10x9	584x254x229
5SA	24 - 30	610 - 762	03.0105.SA1	11.0	5.0	23x10x9	584x254x229
6SA	28 - 36	711 - 914	03.0105.SA1	11.0	5.0	23x10x9	584x254x229
8SA	40 - 48	1016 - 1219	03.0105.SA1	11.0	5.0	23x10x9	584x254x229



# Saddle Machine Spacers & Step Spacers



## SPACERS AND SPACER BOLTS

Machine Model	Part Description (Nominal Pipe Size)	Part No.	Qty Required	Shipping Weight (Each)	
				lbs	kg
MSA	1 1/2 in (38mm) Spacer	03.0109.001	2	0.25	0.11
MSA	2 in (51mm) Spacer	03.0109.002	2	0.20	0.09
MSA	2 1/2 in (64mm) Spacer	03.0109.003	2	0.20	0.09
MSA	3 in (78mm) Spacer	03.0109.004	2	0.20	0.09
MSA	3 1/2 in (89mm) Spacer	03.0109.005	2	0.10	0.05
1SA	3 in (78mm) Spacer Bolt	03.0110.034	4	0.40	0.18
1SA	4 in (102mm) Spacer Bolt	03.0110.003	4	0.30	0.14
1SA	5 in (127mm) Spacer Bolt	03.0110.031	4	0.30	0.14
1SA	5 1/2 in (140mm) Spacer Bolt	03.0110.027	4	0.30	0.14
1SA	6 in (152mm) Spacer Bolt	03.0110.002	4	0.20	0.09
1SA	7 in (178mm) Spacer Bolt	03.0110.025	4	0.15	0.07
1SA	8 in (203mm) Spacer Bolt	03.0110.001	4	0.10	0.05
2SA	6 in (152mm) Spacer Bolt	03.0110.022	4	0.45	0.20
2SA	8 in (203mm) Spacer Bolt	03.0110.003	4	0.30	0.14
2SA	9 in (244mm) Spacer Bolt	03.0110.026	4	0.30	0.14
2SA	10 in (254mm) Spacer Bolt	03.0110.002	4	0.20	0.09
2SA	11 in (279mm) Spacer Bolt	03.0110.029	4	0.20	0.09
2SA	12 in (305mm) Spacer Bolt	03.0110.001	4	0.10	0.05
3SA	Spacer Bolt	03.0110.010	4	0.30	0.14
3SA	1 in (25mm) Spacer	04.0106.018	4	0.15	0.07
3SA	2 in (51mm) Spacer	04.0106.019	4	0.35	0.16
3SA	12 in (305mm) Spacer Bolt	03.0110.035	4	1.20	0.54
4SA	Spacer Bolt	03.0110.011	4	0.30	0.14
4SA	1 in (25mm) Spacer	04.0106.018	8	0.15	0.07
4SA	20 in (508mm) Spacer Bolt	03.0110.008	4	1.80	0.81
5SA	Spacer Bolt	03.0110.011	4	0.30	0.14
5SA	1 in (25mm) Spacer	04.0106.018	8	0.15	0.07
5SA	20 in (508mm) Spacer Bolt	03.0110.008	4	1.80	0.81
6SA	Spacer Bolt	03.0110.004	4	0.30	0.14
6SA	Spacer Bolt	03.0110.008	4	1.80	0.81
6SA	Spacer Bolt	03.0110.009	4	2.25	1.01
6SA	31 in (787mm) Spacer Bolt	03.0110.007	4	1.50	0.68
6SA	32 in (813mm) Spacer Bolt	03.0110.006	4	1.30	0.59
6SA	34 in (864mm) Spacer Bolt	03.0110.005	4	0.80	0.36
8SA	Spacer Bolt	03.0110.004	4	0.30	0.14
8SA	Spacer Bolt	03.0110.008	4	1.80	0.81
8SA	Spacer Bolt	03.0110.009	4	2.25	1.01
8SA	44 in (1118mm) Spacer Bolt	03.0110.006	4	1.30	0.59

## SPACER BOLT KITS (SIZING CHART INCLUDED)

Machine Model	Includes Spacers for Pipe Sizes		Part No.	Shipping Weight (KIT)		Shipping Dimensions	
	in	mm		lbs	kg	in	mm
	MSA	2,3		51,76	03.0MSA.KIT	1.0	45.9
1SA	3,4,6,8	76,102,152,203	03.01SA.KIT	4.0	51.6	8x6x6	203x152x152
2SA	6,8,10,12	152,203,254,305	03.02SA.KIT	5.0	55.9	8x6x6	203x152x152
3SA	12,14,16,18,20	305,356,406,457,508	03.03SA.KIT	9.0	75.1	8x6x6	203x152x152
4SA	20,22,24,26	508,559,510,660	03.04SA.KIT	10.0	149.9	12x6x6	305x152x152
5SA	24,26,28,30	610,660,711,762	03.05SA.KIT	10.0	153.0	12x6x6	305x152x152
6SA	28,30,36	711,762,914	03.06SA.KIT	20.0	160.5	12x6x6	305x152x152
8SA	36,38,40,42,48	914,952,1016,1067,1219	03.08SA.KIT	20.0	164.2	12x6x6	305x152x152



1SA STEP SPACER



2SA STEP SPACER



## STEP SPACERS

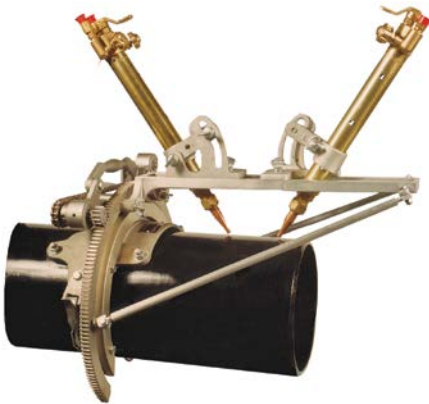
Machine Model	Part Description (Nominal Pipe Size)	Part No.	Quantity Required	Shipping Weight (KIT)		Shipping Dimensions	
				lbs	kg	in	mm
				1SA	3,4,6,8 in / 76,102,152,203 mm	03.0110.1SA	4
2SA	6,8,10,12 in / 152,203,254,305	03.0110.2SA	4	0.40	0.18	0.40	0.18
3SA	12,14,16,18,20 / 305,356,406,457,508	03.0110.3SA	4	0.40	0.18	0.40	0.18

## STEP SPACER KITS

Machine Model	Part Description (Nominal Pipe Size)	Part No.	Shipping Weight (KIT)		Shipping Dimensions	
			lbs	kg	in	mm
			1SA	3,4,6,8 in / 76,102,152,203 mm	03.0110.1SAKIT	3.60
2SA	6,8,10,12 in / 152,203,254,305	03.0110.2SAKIT	3.60	1.62	12x6x6	305x152x152
3SA	12,14,16,18,20 / 305,356,406,457,508	03.0110.3SAKIT	3.60	1.62	12x6x6	305x152x152



# Saddle Machine Contour Cutting Attachments



## CONTOUR CUTTING ATTACHMENT

Machine Model	Pipe Size		Part No.	Shipping Weight		Shipping Dimensions	
	in	mm		lbs	kg	in	mm
MSA	1.5 - 4	38 - 102	03.0116.MSA	7.0	3.2	23x10x9	584x254x229
1-2 SA	3 - 12	76 - 305	03.0116.1SA	7.0	3.2	36x12x12	914x305x305
3SA	12 - 20	305 - 508	03.0116.3SA	9.0	4.1	36x12x12	914x305x305
4SA	20 - 26	508 - 660	03.0116.4SA	9.0	4.1	36x12x12	914x305x305
5SA	24 - 30	610 - 762	03.0116.5SA	11.0	5.0		
6SA	28 - 36	711 - 914	03.0116.6SA	13.0	5.9		
8SA	36 - 48	914 - 1219	03.0116.8SA	16.0	7.2		

## CONTOUR CUTTING SHAPE TEMPLATES

NOTE: Template Form is required prior to order - Template cannot be returned

Machine Model	Includes Spacers for Pipe Sizes		Part No.	Shipping Weight		Shipping Dimensions	
	in	mm		lbs	kg	in	mm
MSA	1.5 - 4	38 - 102	03.0115.M . .	3.5-5.0	1.6-2.3	12x12x9	305x305x229
1SA	3 - 8	76 - 203	03.0115.1 . .	4.5-6.0	2.0-2.7	18x18x11	457x457x279
2SA	8 - 12	152 - 305	03.0115.2 . .	6.0-8.0	2.7-3.6	23x23x13	584x584x330
3SA	12 - 20	305 - 508	03.0115.3 . .	11.0-15.0	5.0-7.0	36x12x12	914x305x305
4SA	20 - 26	508 - 660	03.0115.4 . .	18.0-27.0	8.0-12.0		
5SA	24 - 30	610 - 762	03.0115.5 . .	22.0-31.0	10.0-14.0		
6SA	28 - 36	711 - 914	03.0115.6 . .	27.0-35.0	12.0-16.0		
8SA	36 - 48	914 - 1219	03.0115.8 . .	31.0-40.0	14.0-18.0		

## DOUBLE TORCH ARM

Machine Model	Pipe Size		Part No.	Shipping Weight		Shipping Dimensions	
	in	mm		lbs	kg	in	mm
1SA	3 - 8	76 - 203	03.0101.030	5.0	2.3	20x6x6	508x152x152
2SA	8 - 12	152 - 305	03.0102.015	5.0	2.3	20x6x6	508x152x152
3SA	12 - 20	305 - 508	03.0103.030	5.0	2.3	23x10x9	584x254x229
4SA	20 - 26	508 - 660	03.0104.021	5.0	2.3	23x10x9	584x254x229
5SA	24 - 30	610 - 762	03.0105.025	5.0	2.3	23x10x9	584x254x229
6SA	28 - 36	711 - 914	03.0106.018	5.5	2.5		
8SA	36 - 48	914 - 1219	03.0108.014	5.5	2.5		

## REPLACEMENT PARTS FOR MOTORIZED UNITS

Description	Part No.	Shipping Weight		Shipping Dimensions	
		lbs	kg	in	mm
Plasma Speed Motor Control Box	03.0203.008	2.1	0.9	6x6x4	152x152x102
Motor Drive Cable 50' Stepper Motor	03.0203.020	1.2	0.5	6x6x4	152x152x102
Motor Mounting Bracket (MSA)	03.0100.064				
Motor Mounting Bracket (1SA)	03.0103.031				
Motor Mounting Bracket (2SA)	03.0102.013				
Motor Coupling 1SA,2SA, 5SA-8SA	03.0105.032				
Stepper Motor 1SA-4SA	03.0201.058	7.8	3.5	12x6x6	305x152x152
Stepper Motor 5SA-8SA	03.0201.059	6.7	3.0	12x610x8	305x254x203

## SADDLE MACHINE STORAGE BOX

Machine Model	Pipe Size		Part No.	Shipping Weight		Shipping Dimensions	
	in	mm		lbs	kg	in	mm
MSA	1.5 - 4	38 - 102	03.0100.BOX	23.0	10.4	18x18x10	457x457x254
1SA	3 - 8	76 - 203	03.0101.BOX	33.0	14.9	23x23x13	584x584x330
2SA	8 - 12	152 - 305	03.0102.BOX	41.0	18.5	34x32x12	635x559x457
3SA	12 - 20	305 - 508	03.0103.BOX	60.0	27.0	34x34x14	864x864x356
4SA	20 - 26	508 - 660	03.0104.BOX	79.0	35.6	40x38x14	1016x965x356
5SA	24 - 30	610 - 762	03.0105.BOX	84.0	37.8	42x40x14	1067x1016x356
6SA	28 - 36	711 - 914	03.0106.BOX	100.0	45.0	56x48x16	1422x1219x406
8SA	36 - 48	914 - 1219	03.0108.BOX	125.0	56.3	70x56x19	1778x1422x483

**PRO MODEL TORCH ARM**

Description	Part No.	Shipping Weight		Shipping Dimensions	
		lbs	kg	in	mm
PRO Model With Out of Round	03.0209.000	9.5	4.3	16x8x8	406x203x203
PRO Model Basic Assembly	03.0209.001	7.0	3.2	16x8x8	406x203x203
Out of Round Kit	03.0209.003	2.5	1.1	12x6x6	305x152x152
Tracer Point	03.0209.012	1.6	0.7	12x6x6	305x152x152

**CAM ADJUSTABLE TORCH HOLDER  
(FITS ALL SADDLE MACHINES)**

Part Number	Description
03.0100.052	Cam Adjustable Torch Holder

**MSA SADDLE MACHINE PARTS**

Description	Part No.	Qty Reqd	Ship Weight	
			lbs	kg
Torch Arm	03.0101.001	1	1.50	0.68
Torch Carrier Assembly	03.0100.002	1	1.40	0.63
Torch Clamp Base	03.0100.003	1	0.70	0.32
Clamp	03.0100.004	1	0.35	0.16
Torch Clamp	03.0100.005	1	0.60	0.27
Screw Kit-Torch Carrier Assy	03.0100.029	1	0.50	0.23
Boomer Assembly	03.0100.024	1	0.45	0.20
Strap	03.0100.025	1	0.26	0.12
Thumbscrew	03.0100.026	1	0.10	0.05
Eye	03.0100.027	1	0.05	0.02
Handle	03.0100.023	1	0.25	0.11
Threaded Studs	01.0194.003	2	0.05	0.02
Drive Chain	03.0100.022	1	0.35	0.16
Double Bearing Bracket Assy	03.0100.014	1	2.00	0.90
Bracket	03.0100.015	1	0.20	0.09
Crank Handle Assy	03.0100.018	1	0.45	0.20
Axle	03.0100.013	1	0.10	0.05
Crank Pinion	03.0100.017	1	0.10	0.05
Pinion Gear	03.0100.012	1	0.10	0.05
Crank Gear/Sprocket Assy	03.0100.016	1	1.00	0.45
Bronze Bushing	01.0210.004	4	0.01	0.00
Single Bearing Bracket Assy	03.0100.009	1	0.02	0.01
Bracket	03.0100.010	1	0.15	0.07
Axle	03.0100.013	1	0.10	0.05
Pinion Gear	03.0100.012	1	0.10	0.05
Sprocket	03.0100.011	1	0.30	0.14
Bronze Bushing	01.0210.004	2	0.10	0.05

**1SA SADDLE MACHINE PARTS**

Description	Part No.	Qty Reqd	Ship Weight	
			lbs	kg
Torch Arm	03.0101.001	1	1.50	0.68
Torch Carrier Assembly	03.0100.002	1	1.40	0.63
Torch Clamp Base	03.0100.003	1	0.70	0.32
Clamp	03.0100.004	1	0.35	0.16
Torch Clamp	03.0100.005	1	0.60	0.27
Screw Kit-Torch Carrier Assy	03.0100.029	1	0.50	0.23
Boomer Assembly	03.0101.018	1	0.85	0.38
Spring	01.0184.002	1	0.40	0.18
Boomer	01.0258.001	1	0.40	0.18
Spring Snap	01.0258.003	1	0.05	0.02
Chain	01.0577.002	1	0.25	0.11
Handle	03.0101.016	1	0.30	0.14
Threaded Studs	01.0194.003	2	0.05	0.02
Drive Chain	03.0101.015	1	0.45	0.20
Boomer Eye	03.0101.017	2	0.05	0.02
Double Bearing Bracket Assy	03.0101.010	1	2.85	1.28
Bracket	03.0101.011	1	0.60	0.27
Crank Handle Assy	03.0101.014	1	0.45	0.20
Axle	03.0101.009	1	0.10	0.05
Crank Pinion	03.0101.013	1	0.10	0.05
Pinion Gear	03.0101.007	1	0.10	0.05
Crank Gear/Sprocket Assy	03.0101.012	1	1.00	0.45
Bearings	01.0196.012	4	0.05	0.02
Spacer	04.0106.010	1	0.05	0.02
Spacer	04.0106.056	1	0.05	0.02
Single Bearing Bracket Assy	03.0101.005	1	1.10	0.50
Bracket	03.0101.006	1	0.50	0.23
Axle	03.0101.009	1	0.10	0.05
Pinion Gear	03.0101.007	1	0.10	0.05
Bearing	01.0196.012	2	0.05	0.02
Spacer	04.0106.010	1	0.05	0.02
Sprocket	03.0101.008	1	0.05	0.02

**2SA SADDLE MACHINE PARTS**

Description	Part No.	Qty Reqd	Ship Weight	
			lbs	kg
Torch Arm	03.0101.001	1	1.50	0.68
Torch Carrier Assembly	03.0100.002	1	1.40	0.63
Torch Clamp Base	03.0100.003	1	0.70	0.32
Clamp	03.0100.004	1	0.35	0.16
Torch Clamp	03.0100.005	1	0.60	0.27
Screw Kit-Torch Carrier Assy	03.0100.029	1	0.50	0.23
Boomer Assembly	03.0102.011	1	1.10	0.50
Spring	01.0184.002	1	0.10	0.05
Boomer	01.0258.001	1	0.40	0.18
Snap Hook	01.0258.003	1	0.05	0.02
Chain	01.0577.003	1	0.45	0.20
Handle	03.0102.010	1	0.70	0.32
Threaded Studs	01.0194.003	2	0.05	0.02
Drive Chain	03.0102.009	1	0.60	0.27
Boomer Eye	03.0101.017	2	0.05	0.02
Double Bearing Bracket Assy	03.0102.007	1	3.40	1.53
Bracket	03.0102.008	1	0.60	0.27
Crank Handle Assy	03.0101.014	1	0.45	0.20
Axle	03.0101.009	1	0.10	0.05
Crank Pinion	03.0101.013	1	0.10	0.05
Pinion Gear	03.0102.006	1	0.45	0.20
Crank Gear/Sprocket Assy	03.0101.012	1	1.00	0.45
Bearings	01.0196.012	4	0.05	0.02
Spacer	04.0106.010	1	0.05	0.02
Spacer	04.0106.056	1	0.05	0.02
Single Bearing Bracket Assy	03.0102.004	1	1.40	0.63
Bracket	03.0102.005	1	0.45	0.20
Axle	03.0101.009	1	0.10	0.05
Pinion Gear	03.0102.006	1	0.45	0.20
Sprocket	03.0101.008	1	0.20	0.09
Bearings	01.0196.012	2	0.05	0.02
Spacer	04.0106.010	1	0.05	0.02

**3SA SADDLE MACHINE PARTS**

Description	Part No.	Qty Reqd	Ship Weight	
			lbs	kg
Torch Arm	03.0101.001	1	1.50	0.68
Torch Carrier Assembly	03.0100.002	1	1.40	0.63
Torch Clamp Base	03.0100.003	1	0.70	0.32
Clamp	03.0100.004	1	0.35	0.16
Torch Clamp	03.0100.005	1	0.60	0.27
Screw Kit-Torch Carrier Assy	03.0100.029	1	0.50	0.23
Boomer Assembly	03.0103.020	1	1.55	0.70
Spring	01.0184.003	1	0.30	0.14
Boomer	01.0258.001	1	0.40	0.18
Snap Hook	01.0258.003	1	0.05	0.02
Chain	01.0577.004	1	0.80	0.36
Handle Tie Rod	03.0103.019	2	0.55	0.25
Threaded Studs	01.0194.003	2	0.05	0.02
Drive Chain	03.0103.021	2	0.60	0.27
Boomer Eye	03.0101.017	2	0.05	0.02
Double Bearing Bracket Assy	03.0103.011	1	5.00	2.25
Bracket	03.0103.017	1	1.10	0.50
Crank Handle Assy	03.0103.012	1	0.60	0.27
Axle	03.0103.015	1	0.15	0.07
Crank Pinion	03.0103.014	1	0.15	0.07
Double Sprocket	03.0103.018	1	1.05	0.47
Crank Gear	03.0103.016	1	1.45	0.65
Bearings	01.0196.012	4	0.05	0.02
Spacer	04.0106.011	2	0.05	0.02
Spacer	04.0106.056	1	0.05	0.02
Lt Single Bearing Brkt. Assy.	03.0103.004	1	2.55	1.15
Rt Single Bearing Brkt. Assy.	03.0103.009	1	2.55	1.15
Left Bracket	03.0103.005	1	0.90	0.41
Right Bracket	03.0103.010	1	0.90	0.41
Axle	03.0103.008	1	0.20	0.09
Pinion Gear	03.0102.006	1	0.45	0.20
Sprocket	03.0103.007	1	0.70	0.32
Bearings	01.0196.012	2	0.05	0.02
Spacer	04.0106.013	1	0.15	0.07

4SA SADDLE MACHINE PARTS				
Description	Part No.	Qty Reqd	Ship Weight	
			lbs	kg
Torch Arm	03.0101.001	1	1.50	0.68
Torch Carrier Assembly	03.0100.002	1	1.40	0.63
Torch Clamp Base	03.0100.003	1	0.70	0.32
Clamp	03.0100.004	1	0.35	0.16
Torch Clamp	03.0100.005	1	0.60	0.27
Screw Kit-Torch Carrier Assy	03.0100.029	1	0.50	0.23
Boomer Assembly	03.0104.011	1	1.70	0.77
Spring	01.0184.003	1	0.30	0.14
Boomer	01.0258.001	1	0.40	0.18
Snap Hook	01.0258.003	1	0.05	0.02
Chain	01.0577.005	1	0.95	0.43
Handle Tie Rod	03.0104.010	2	0.80	0.36
Threaded Studs	01.0194.003	2	0.05	0.02
Drive Chain	03.0104.009	2	0.75	0.34
Boomer Eye	03.0101.017	2	0.05	0.02
Double Bearing Bracket Assy	03.0104.007	1	4.75	2.14
Bracket	03.0104.008	1	1.00	0.45
Crank Handle Assy	03.0103.012	1	0.60	0.27
Axle	03.0103.015	1	0.15	0.07
Crank Pinion	03.0103.014	1	0.15	0.07
Double Sprocket	03.0103.018	1	1.05	0.47
Crank Gear/Sprocket Assy	03.0103.016	1	1.45	0.65
Bearings	01.0196.012	4	0.05	0.02
Spacer	04.0106.011	1	0.05	0.02
Spacer	04.0106.056	1	0.05	0.02
Lt. Single Bearing Brkt. Assy.	03.0104.004	1	2.40	1.08
Rt. Single Bearing Brkt. Assy.	03.0104.005	1	2.40	1.08
Bracket	03.0104.006	1	0.70	0.32
Axle	03.0103.008	1	0.20	0.09
Pinion Gear	03.0102.006	1	0.45	0.20
Sprocket	03.0103.007	1	0.70	0.32
Bearings	01.0196.012	2	0.05	0.02
Spacer	04.0106.013	1	0.15	0.07

5SA SADDLE MACHINE PARTS				
Description	Part No.	Qty Reqd	Ship Weight	
			lbs	kg
Torch Arm	03.0101.001	1	1.50	0.68
Torch Carrier Assembly	03.0100.002	1	1.40	0.63
Torch Clamp Base	03.0100.003	1	0.70	0.32
Clamp	03.0100.004	1	0.35	0.16
Torch Clamp	03.0100.005	1	0.60	0.27
Screw Kit-Torch Carrier Assy	03.0100.029	1	0.50	0.23
Boomer Assembly	03.0105.017	1	1.95	0.88
Spring	01.0184.003	1	0.30	0.14
Boomer	01.0258.001	1	0.40	0.18
Snap Hook	01.0258.003	1	0.05	0.02
Chain	01.0577.006	1	1.20	0.54
Handle Tie Rod	03.0105.016	2	1.15	0.52
Threaded Studs	01.0194.003	2	0.05	0.02
Drive Chain	03.0105.015	2	0.85	0.38
Boomer Eye	03.0101.017	2	0.05	0.02
Double Bearing Bracket Assy	03.0105.010	1	4.35	1.96
Bracket	03.0105.011	1	1.35	0.61
Crank Handle Assy	03.0103.012	1	0.60	0.27
Axle	03.0105.013	1	0.20	0.09
Crank Pinion	03.0105.012	1	0.20	0.09
Crank Gear/Sprocket Assy	03.0105.014	1	1.55	0.70
Bearings	01.0196.012	4	0.05	0.02
Set Collar	01.0185.005	1	0.05	0.02
Spacer	04.0106.056	1	0.05	0.02
Spacer	04.0106.013	1	0.15	0.07
Lt Single Bearing Brkt. Assy.	03.0105.004	1	2.65	1.19
Rt Single Bearing Brkt. Assy.	03.0105.005	1	2.65	1.19
Bracket	03.0105.006	1	1.05	0.47
Axle	03.0105.009	1	0.20	0.09
Pinion Gear	03.0105.007	1	0.75	0.34
Sprocket	03.0105.008	1	0.75	0.34
Bearings	01.0196.012	2	0.05	0.02
Spacer	04.0106.013	1	0.15	0.07

6SA SADDLE MACHINE PARTS				
Description	Part No.	Qty Reqd	Ship Weight	
			lbs	kg
Torch Arm	03.0101.001	1	1.50	0.68
Torch Carrier Assembly	03.0100.002	1	1.40	0.63
Torch Clamp Base	03.0100.003	1	0.70	0.32
Clamp	03.0100.004	1	0.35	0.16
Torch Clamp	03.0100.005	1	0.60	0.27
Screw Kit-Torch Carrier Assy	03.0100.029	1	0.50	0.23
Boomer Assembly	03.0106.010	1	2.20	0.99
Spring	01.0184.003	1	0.30	0.14
Boomer	01.0258.001	1	0.40	0.18
Snap Hook	01.0258.003	1	0.05	0.02
Chain	01.0577.007	1	1.45	0.65
Tie Rod - Top	03.0106.007	1	1.55	0.70
Tie Rod - Side	03.0106.006	2	1.35	0.61
Threaded Studs	01.0194.003	4	0.05	0.02
Drive Chain - Top	03.0106.004	1	0.85	0.38
Drive Chain - Side	03.0106.005	2	0.95	0.43
Boomer Eye	03.0101.017	2	0.05	0.02
Lifting Eye	03.0106.011	1	0.80	0.36
Double Bearing Bracket Assy	03.0105.010	2	4.35	1.96
Bracket	03.0105.011	1	1.35	0.61
Crank Handle Assy	03.0103.012	1	0.60	0.27
Axle	03.0105.013	1	0.20	0.09
Crank Pinion	03.0105.012	1	0.20	0.09
Crank Gear/Sprocket Assy	03.0105.014	1	1.55	0.70
Bearings	01.0196.012	4	0.05	0.02
Set Collar	01.0185.005	1	0.05	0.02
Spacer	04.0106.056	1	0.05	0.02
Spacer	04.0106.013	1	0.15	0.07
Single Bearing Bracket, Right	03.0105.005	1	2.65	1.19
Single Bearing Bracket, Left	03.0105.004	1	2.65	1.19
Bracket	03.0105.006	1	1.05	0.47
Axle	03.0105.009	1	0.20	0.09
Pinion Gear	03.0105.007	1	0.45	0.20
Sprocket	03.0105.008	1	0.75	0.34
Bearings	01.0196.012	2	0.05	0.02
Spacer	04.0106.013	1	0.15	0.07

8SA SADDLE MACHINE PARTS				
Description	Part No.	Qty Reqd	Ship Weight	
			lbs	kg
Torch Arm	03.0101.001	1	1.50	0.68
Torch Carrier Assembly	03.0100.002	1	1.40	0.63
Torch Clamp Base	03.0100.003	1	0.70	0.32
Clamp	03.0100.004	1	0.35	0.16
Torch Clamp	03.0100.005	1	0.60	0.27
Screw Kit-Torch Carrier Assy	03.0100.029	1	0.50	0.23
Boomer Assembly	03.0108.006	1	2.55	1.15
Spring	01.0184.003	1	0.30	0.14
Boomer	01.0258.001	1	0.40	0.18
Snap Hook	01.0258.003	1	0.05	0.02
Chain	01.0577.009	1	1.80	0.81
Tie Rod - Top and Side	03.0108.005	3	1.80	0.81
Threaded Studs	01.0194.003	4	0.05	0.02
Drive Chain - Top and Side	03.0108.004	3	1.25	0.56
Boomer Eye	03.0101.017	2	0.05	0.02
Lifting Eye	03.0106.011	1	0.80	0.36
Double Bearing Bracket Assy	03.0108.013	2	4.75	2.14
Bracket	03.0105.011	1	1.35	0.61
Crank Handle Assy	03.0103.012	1	0.60	0.27
Axle	03.0108.011	1	0.25	0.11
Crank Pinion	03.0105.012	1	0.20	0.09
Crank Gear/Sprocket Assy	03.0105.014	1	1.55	0.70
Bearings	01.0196.012	4	0.05	0.02
Pinion Gear	03.0105.007	1	0.45	0.20
Spacer	04.0106.056	1	0.05	0.02
Spacer	04.0106.013	1	0.15	0.07
Single Bearing Bracket	03.0108.012	2	2.65	1.19
Bracket	03.0105.006	1	1.05	0.47
Axle	03..0108.011	1	0.25	0.11
Pinion Gear	03.0105.007	1	0.45	0.20
Sprocket	03.0105.008	1	0.75	0.34
Bearings	01.0196.012	2	0.05	0.02
Spacer	04.0106.013	1	0.15	0.07