

# INSTRUCTION MANUAL

## H-460HA-NC

Automatic Hitch Feed Double Column Metal  
Cutting Band Saw (415V)  
480 x 460mm (W x H) Rectangle



**B122**

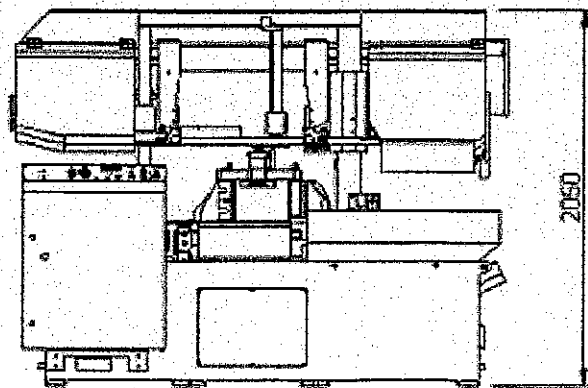
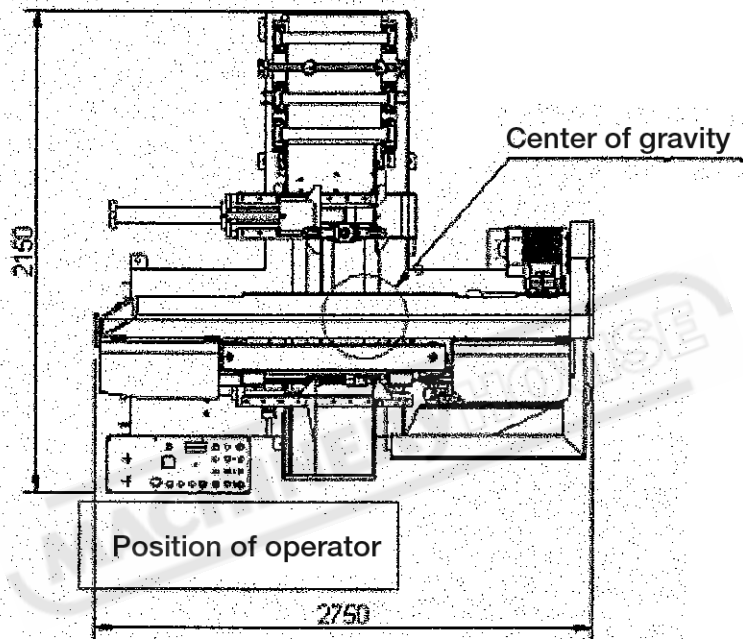
**SPECIFICATION:**

MODEL NO.		<b>H-460HA</b>
CAPACITY		○ 460mm
		□ 480x460mm
BUNDLE CUTTING		210x130 ~ 360x230mm (W*H)
BLADE TENSION		HYDRAULIC
BLADE SIZE		SW5450*41W*1.3T
MOTOR	BLADE	5.7KW 7.5HP
	HYDRAULIC	1.5KW 2HP
	COOLANT	0.09KW 1/4HP
TABLE HEIGHT		808mm
CLAMP VISE TYPE		HYDRAULIC
MACHINE WEIGHT ( N.W. )		2800kgs
HYDRAULIC OIL CAPACITY		88L
CUTTING OIL CAPACITY		117L
MATERILA LENGTH OF SINGLE FEED		510mm
PACKING DIMENSION		2940 x 2270 x 2270mm (L*W*H)

## 二 : MACHINE INSTALLATION

### 1. Machine Installation

Please figure out enough space for working, inspection and maintenance afterward.  
Refer to the machine floor space drawing below:

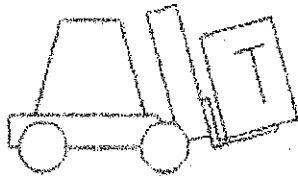


## 2. Machine Transportation

Be careful to take apart the outer package and fixing screw. Please make use of forklift truck or overhead crane to transit the machine. During the process, please keep the machine balance in the forklift truck and avoid to have any impact or tremble happened when machine was transported by the overhead crane.

( Note: please lift the machine from the hook exactly. )

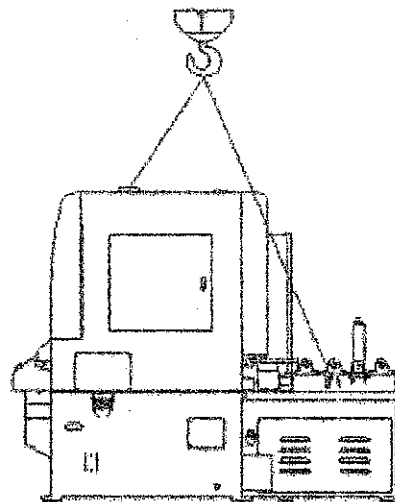
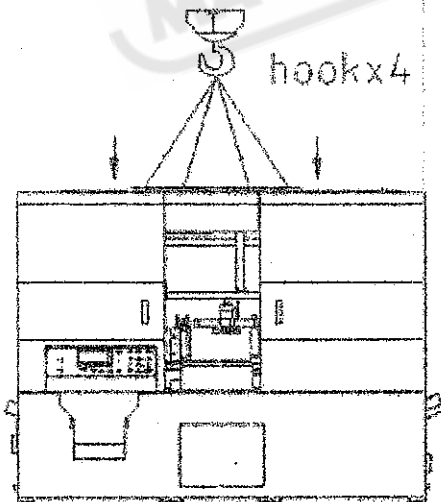
( Machine Weight: 2800kgs )



T = 3 t



T = 3 t



### **3. Clean**

After positioning the machine, clean up the anticorrosive from the machine, then lay on a coat of thin oil.

**( Please removes the fixing iron plate between saw frame and table before machine operation. )**

### **4. Adjust Level And Fixing**

To calibrate the machine level for the correct flow direction of cooling water and accurate saw cutting.

There are ten adjusting screws at the base for adjusting the machine level.

### **5. Hydraulic Oil Level**

Check the oil drain port screw was tighten or not then look over the level of hydraulic oil in the oil tank from the oil gauge. If the oil level is too low, please open the oil tank cover and pour into the standard capacity. Before the machine delivery, the oil tank was loaded with enough capacity previously.

### **6. Cooling Water**

Before the machine delivery, the cooling water should be drained out completely.

Please infuse the enough cooling water into the machine before operation.

Check the drain water port screw was tighten or not and then implant the suitable water volume.

The aperture of filling is under the meshed hole of steel blade brush.

### **7. Power Supply**

1. Before connect the power please make sure the wire is long enough to connect between the power supply and machine.
2. Switch OFF the power supply and connect the machine wire. Please confirm the power voltage is matched with machine. Connect the power wire and ground wire precisely.
3. Before switch ON the power supply, please check the wire connection is correct or not.
4. Draw up the emergency switch and turn on the power, at this time the lamp will be lighted up to show the power was connected completely.
5. Press the hydraulic button on the control panel.  
( Note: Please removes all of the transport fixing screw before this procedure. )
6. Press the UP button of saw frame.

7. Press the emergency switch to cut off the power supply.
8. Turn off the power supply switch.
9. Exchange the two wires of the power supply.
10. Repeat the step of 3 and 6.

### **8. Inspection Before Operation**

After the complete machine installation, please do the final inspection properly.

The item is listed as below:

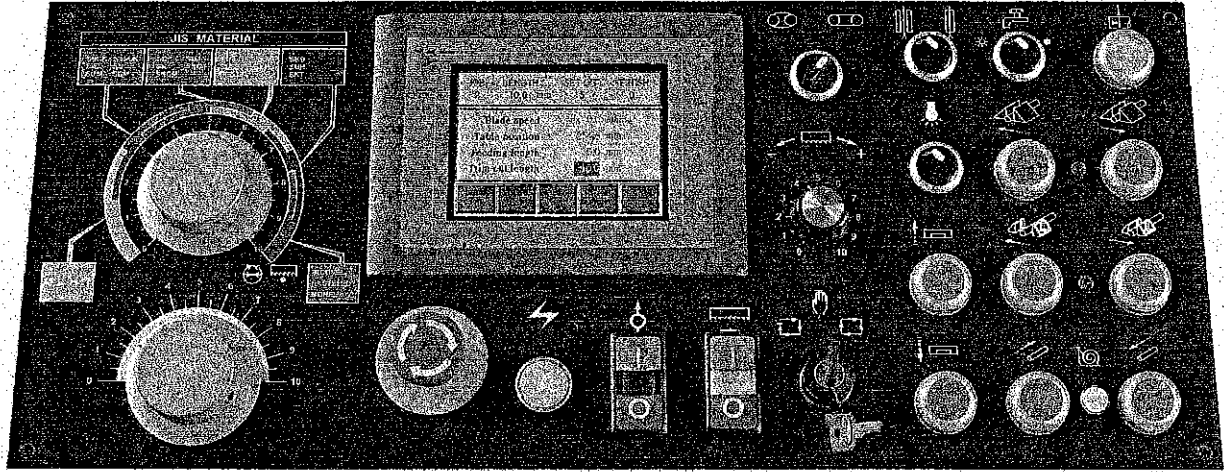
1. Take all of the fixing plate for transporting purpose off.
2. Check screws and fixing items.
3. Check water pipe and wire guide tube.
4. Make sure the cooling water is enough and hydraulic pressure is normal.
5. Tools or other materials should not be left on the machine.

MACHINERYHOUSE

# ≡ : OPERATION METHOD

## 1. The Description Of Operation Panel

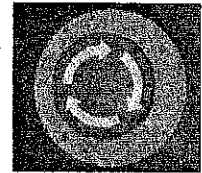
### MODEL: H-460HA



#### (1) Emergency Stop Button

Press the button to stop all of the machine function.  
( picture 1 )

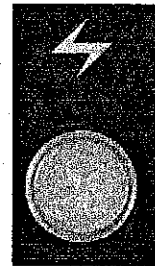
( picture 1 )



#### (2) Power Light

When the emergency stop switch was drew up, the power lamp will be lighted up to show the normal connection of electric power.  
( picture 2 )

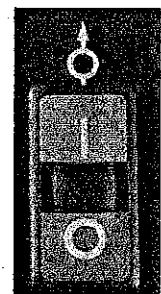
( picture 2 )



#### (3) Hydraulic Button

Press this button to start the hydraulic motor.  
( picture 3 )

( picture 3 )



**(4) Blade Start Button**

Press this button to start the saw blade motor and coolant pump at the same time. The saw frame will descend according to the speed of flow control valve.

( picture 4 )

( picture 4 )

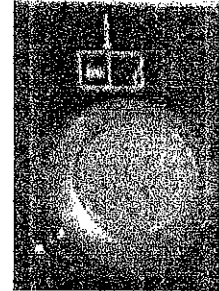


**(5) The Button For Material Zero Point Search Of Automatic Feed**

Under the clamping situation of feed clamp ( and manual mode ), the materials will be clamped to move ahead by feed table to the zero point automatically. (the material original cutting point) The button lamp will be lighted up after the finish of this process. Afterward, please choose circulation by repeat or single circulation as the requirement, and press the start button of blade. The material will be cut as the previous setting.

( picture 5 )

( picture 5 )

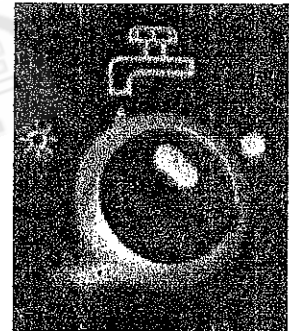


**(6) The Switch For Choosing Cooling Water**

\* Turn to the position of ☀  
to start the coolant pump and make the cooling water flow.  
The switch could be turned on independently without the start of blade motor.

\* Turn to the position of ●  
to stop the coolant pump.  
( picture 6 )

( picture 6 )



**(7) The Adjusting Switch For Hydraulic Carbide Fixture**

\* Turn the position to →  
the carbide fixture will be clipped tight.



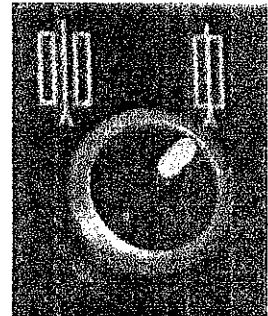
\* Turn the position to →  
the carbide fixture will be loosen.



( Carbide fixture is under the situation of being clipped, when the blade was started )

( picture 7 )

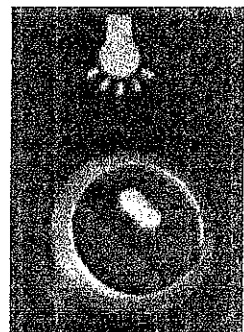
( picture 7 )



**(8) The Switch For Work Light**


For work light use only.


( picture 8 )

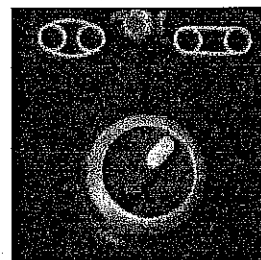




**(9) The Adjusting Switch For Blade Tension**

\* Turn the position to   
The blade tension will be tighten.

\* Turn the position to   
The blade tension will be loosen  
( picture 9 )

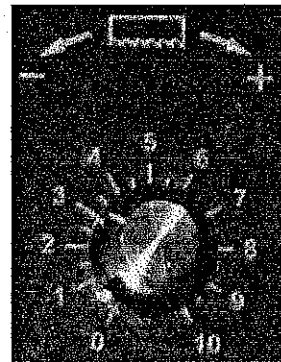


( picture 9 )


**(10) The Switch For Blade Cutting Speed**


To control the rotational speed of blade cutting.  
Clockwise turn for acceleration,  
counterclockwise one for deceleration. ( picture 10 )


( Picture 10 )

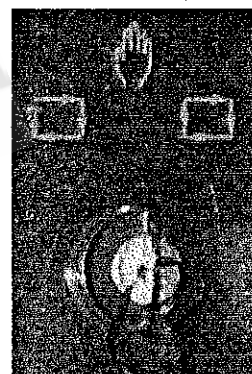


**(11) The Switch For Circulation And Manual Mode Changeover**

\* Turn the position to   
Materials will be cut under the mode of circulation by repeat.



\* Turn the position to   
For manual operation.


\* Turn the position to   
For single circulation work.  
( picture 11 )



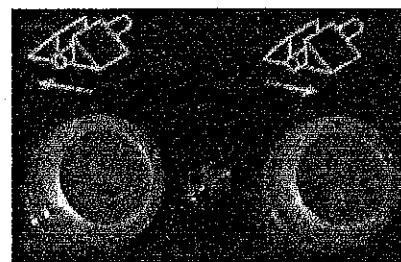
( picture 11 )

**(12) The Adjusting Button For Movable Clamp Of Feeding Table**

Press this button   
the work piece will be clipped tight by the clamp.  
When the lamp  was lighted on, the clipping process  
was finished completely.

Press this button   
The work piece will be loosen.  
( picture 12 )

If the guide wheel base is not higher 20mm than  
the movable clamp, the moving measure of the clamp  
will be 1 inch for one step.




( picture 12 )

**(13) The Adjusting Button For Movable Clamp Of Feeding Table**

Press this button



the work piece will be clipped tight by the clamp.

When the lamp  was lighted on, the clipping process was finished completely.

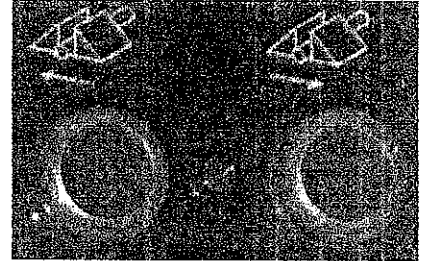
Press this button



The work piece will be loosen.

( picture 13 )

If the guide wheel base is not higher 20mm than the movable clamp, the moving measure of the clamp will be 1 inch for one step.



( picture 13 )

**(14) The Button For The Movement Of Feed Table**

Press this button



To make the feed table move ahead.

Press this button



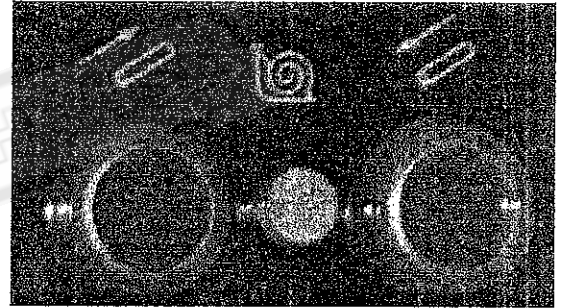
To make the feed table move slowly to the requirement.

Press this button



To make the feed table move back.

( picture 14 )



( picture 14 )

**(15) The Button For Saw Frame UP And Down**

Press this button



to make the saw frame UP

Press this button



to make the saw frame DOWN

( picture 15 )

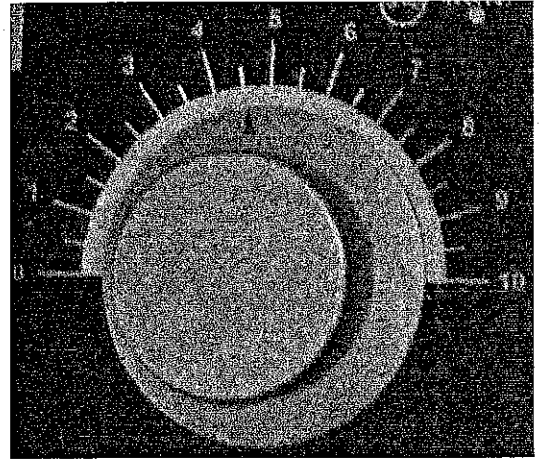


( picture 15 )

**(16) The Switch Of Hydraulic Oil Control Valve**

To control the cutting speed.

The more large number to indicate,  
the more cutting speed to obtain.



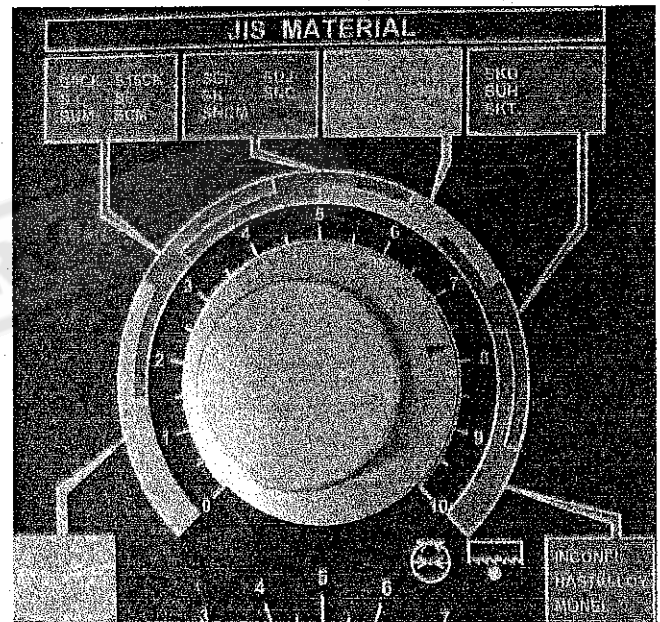
( picture 16 )

**(17) The Switch Of Pressure Control****For Blade Cutting**

To control the pressure given to the blade  
during the process for different materials.

The more large number to indicate,  
the more great pressure to offer.

( picture 17 )



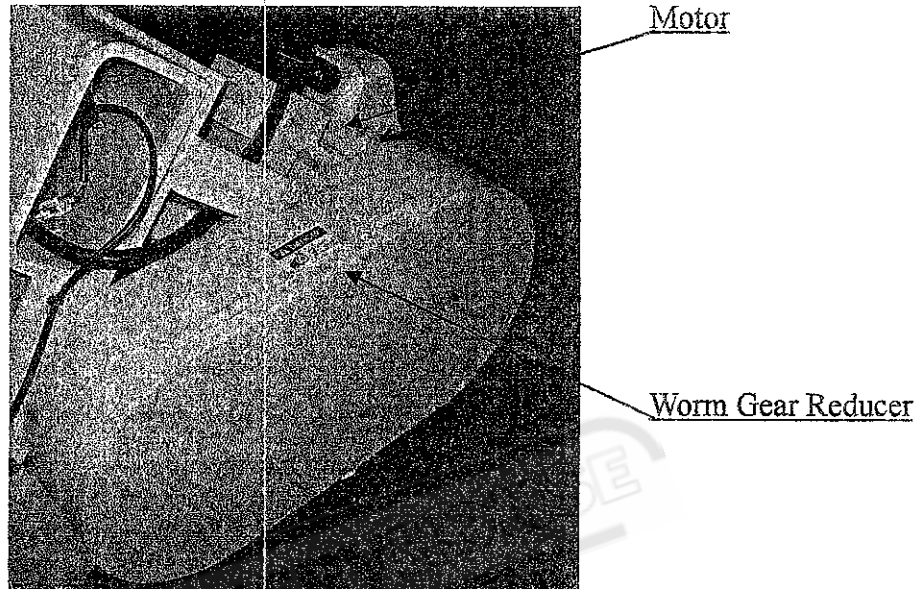
( picture 17 )

## 1. OPERATION PANEL DESCRIPTION

### (1) Motor

The motor of driving pulley is 5.7 KW ( 7.5HP )

The rotation rate was adjusted by reducer and transmitted to driving pulley.

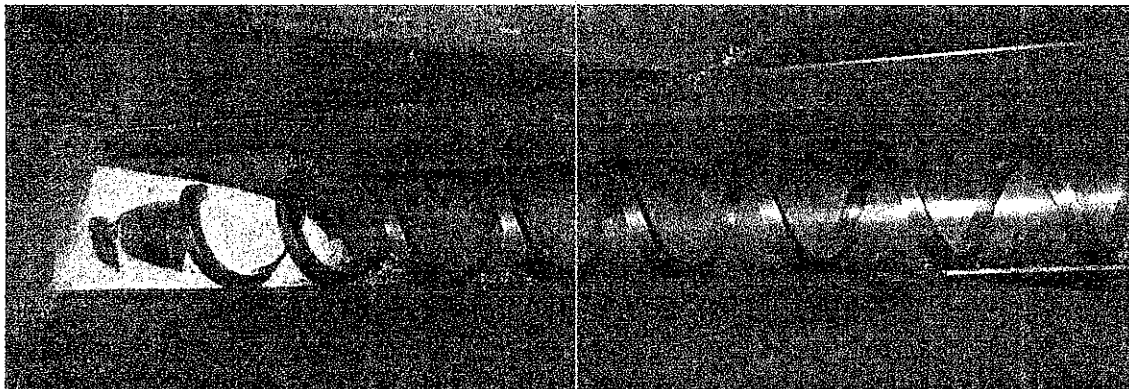


( picture 18 )

### (2) Chipping Discharge Device

Power Source: hydraulic motor

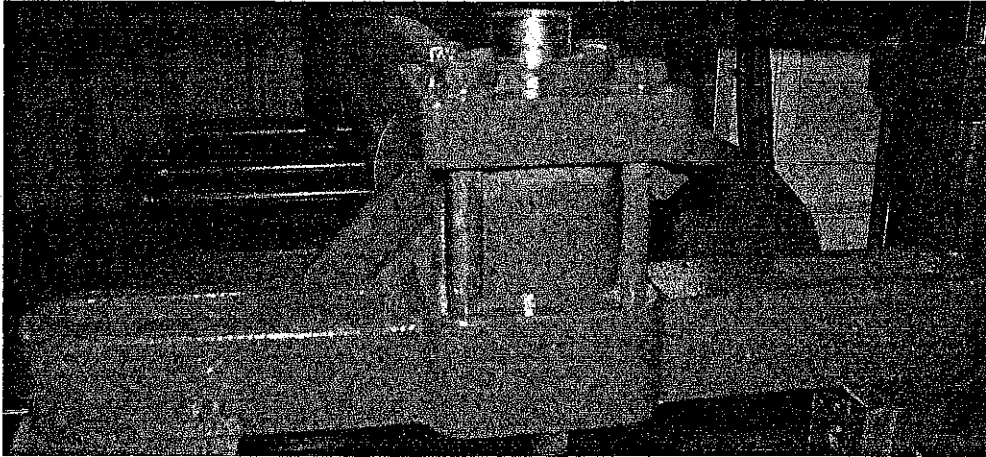
Banish the iron chipping from the machine.



( picture 19 )

### **(3) Upper Impaction Device For Bundle Cutting**

It is mobile and for the purpose of prevention the material slip out of looseness during the process. ( picture 20 )



( picture 20 )

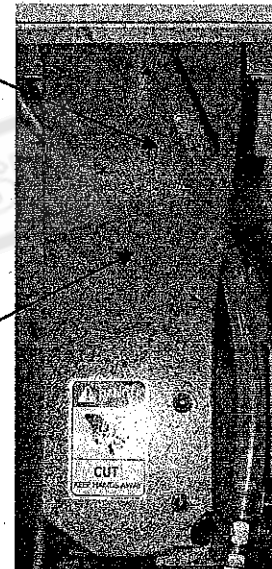
### **(4) The Adjustment Of Movable Guide Arm**

The left guide arm should be adjusted properly to close to the work piece.

- Step 1: loose carbide fixture
  - Step 2: loose locking handle
  - Step 3: move the guide arm to the work piece
  - Step 4: lock the handle
- ( picture 21 )

Locking Handle

Guide Arm



( picture 21 )

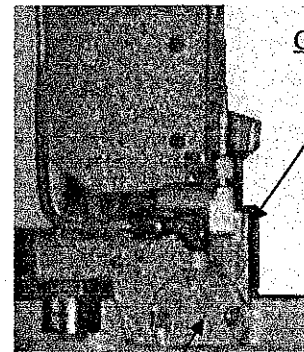
### **(5) The Guide Wheel Base Of Hydraulic Clipping Carbide Fixture**

Hydraulic clamp system make the blade cutting more stable.

Carbide material is more wear-resisting.

( picture 22 )

Carbide Fixture

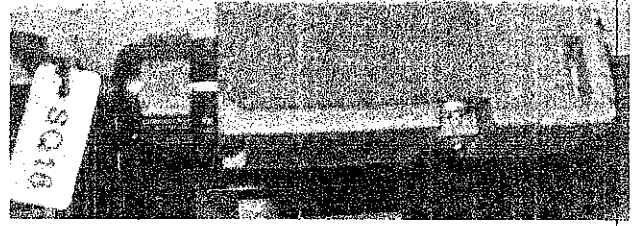


( picture 22 )

Hydraulic Tank

**(6) Splash Guard**

When the guard cover be opened, the blade cutting will be stopped automatically.  
( picture 23 )



( picture 23 )

**(7) Micro Clamp Device Of Table**

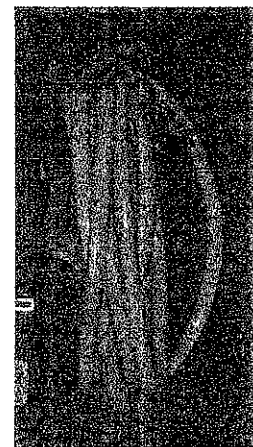
To avoid the material scrape out of the direct contact, this clamp will step back by small extent during the working.



( picture 24 )

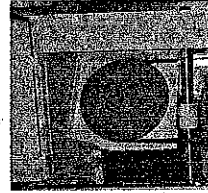
**(8) Washing Gun**

Flush the machine table surface or wash iron chipping away.  
( picture 25 )

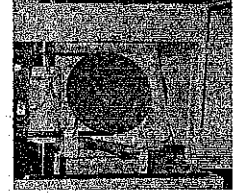


( picture 25 )

## 2. THE INSTALLATION OF SAW BLADE




( picture 27 )




( picture 28 )

Step 1: Make the saw frame ascend to the position higher than the clamp.

Step 2: Open the right and left front door of the splash guard. ( picture 27 and 28 above )

Step 3: Turn the adjusting switch of hydraulic carbide fixture to the position to  ( picture 7 of Page 8 )


Step 4: Turn the adjusting switch of blade tension to the position of  ( picture 9 of Page 9 )

Step 5: Clean up the iron chipping from the carbide fixture.

Step 6: Install the blade on the main driving pulley.  
( Note: Please wear the glove to take the blade )

Step 7: The teeth of blade was faced down and turned to the right.

Step 8: The back of saw blade was touched the edge of main driving and driven pulley.

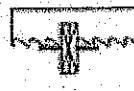
Step 9: Turn the adjusting switch of blade tension to the position of  ( picture 9 of Page 9 )

Step 10: Turn the adjusting switch of carbide fixture to the position of  ( picture 7 of Page 8 )

Step 11: Adjust the position of blade brush.



Correct



Wrong





Step 12: Close the splash guard and lock the safe knob.

### 3. OPERATION DIRECTION

There are three operation mode of H-460HA:

1. **Circulation By Repeat**
2. **Manual Way (manual operation for every function of machine)**
3. **Single Circulation Work**

Step as below:


- (a.) Start the hydraulic pump  , and choose the mode of manual 
- (b.) By the basis of appearance , material and size of work piece to choose the proper blade cutting pressure and blade rotation rate setting.
- (c.) Confirm that the saw blade was installed well.
- (d.) Make the movable guide arm close to the work piece.
- (e.) Move the materials to the clamp.
  - \* Make the saw frame ascend and the position is higher than clamp.
  - \* Make the clamp open and large than the material in width.
  - \* Move the material carefully to the position of front clamp.
  - \* Press the button of front & back clamp  
- (f.) Choose the proper blade speed according to the material of work piece.

**Note: Process of above should only be fulfilled when the blade was stopped.**


Then make the following choice:

Circulation By Repeat  or Single Circulation 

\* Take the Circulation By Repeat for example:

- (a.) Turn the switch of circulation by repeat and manual mode to the position of 
- (b.) Press the start button of blade to deliver on the previous setting.
- (c.) After repeat of cutting, blade will be stopped when the setting was carried out.
- (d.) Take off the remainder.

\* Take the Single Circulation for example:

- (a.) Turn the switch of circulation by repeat and manual mode to the position of 
- (b.) Press the start button of blade to deliver on the previous setting.
- (c.) After the completion of one circulation cutting, blade will be stopped directly.
- (d.) Take off the remainder.



## 四 : MAINTENANCE

### After Every Day Work:

1. Clean up the iron chipping on the machine.
2. Clean up the iron chipping of the carbide fixture.
3. Turn off all of the machine switch.

### 1. Every Day

Before operate the machine, please check the following procedure:

- (1). Check the hydraulic oil level and refill the capacity if it is not enough.
- (2). Check the cutting oil level and refill the capacity if it is not enough.
- (3). Check the saw blade if it was installed on the saw frame or not.
- (4). Check the blade steel brush contact the saw blade exactly or not.

### 2. One Week

Refill the lubrication for: drived & driving pulley.

### 3. Every Six Months

Replace the gear box oil of hollow shaft reduce.

**Note: please replace the gear oil of gear box after the period of 3 months or 600 hours, and the gear oil of hollow shaft reducer for 6 months or 1,200 hours.**

The variety of gear oil:

STORK, HIGH CLASS THUBAN 140

### 4. Every Year

Please leak out the used one and refill the capacity in enough.

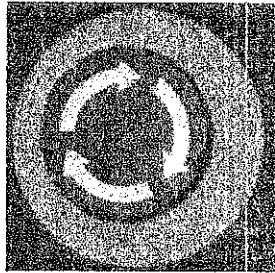
The variety of hydraulic oil:

ISO-VG grade NO.68

DATKYO,PIOLUBE ALLPUR A315

## 五 : SAFE MATTERS

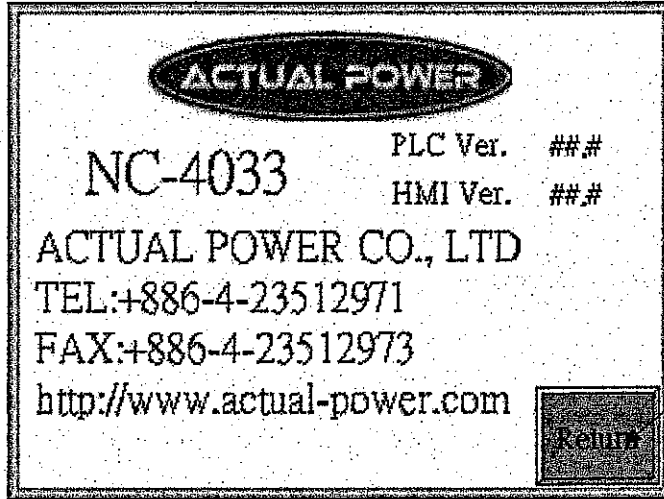
1. Please don't approach the machine inside when the saw blade is on working.
2. Any maintenance will be forbidden during the machine operation.
3. Please offer the proper material measurement for machine cutting.
4. During the machine operation, please don't play pranks around.
5. Please don't smoke in the factory or put any flammable article nearby.
6. Please press the emergency button to stop the operation if any accident happened.



7. The guidance of qualified professional was required for the first operation of the beginner.
8. Please wear the glove for the saw blade installation to avoid the blade wound.

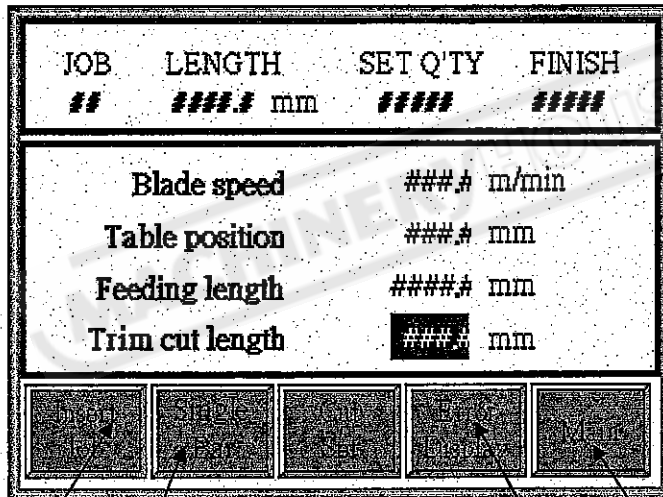
MACHINERY

# 六 : NC CONTROL PANEL DESCRIPTION



Return to the operating and setting page

( picture 29 )



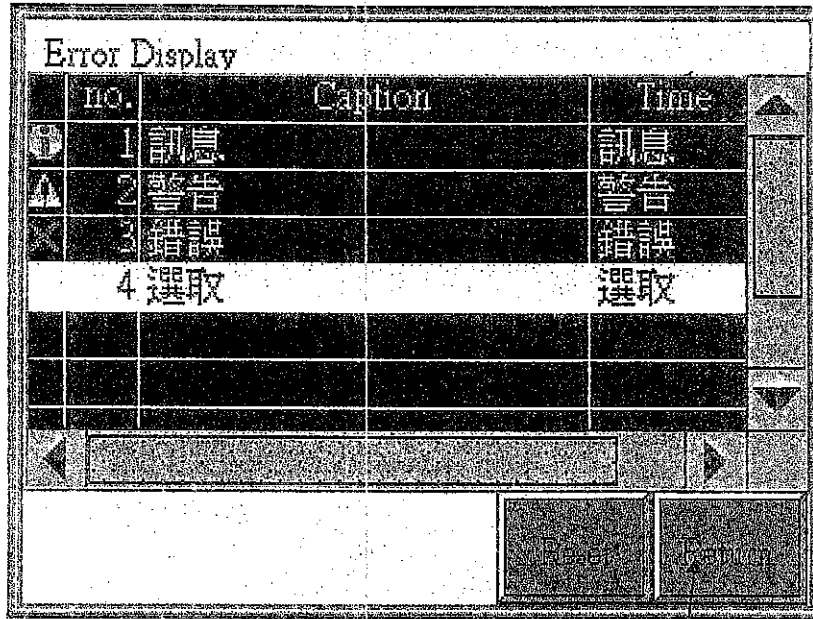
( picture 30 )

Setting of inserted job

Bundle or single cutting setting

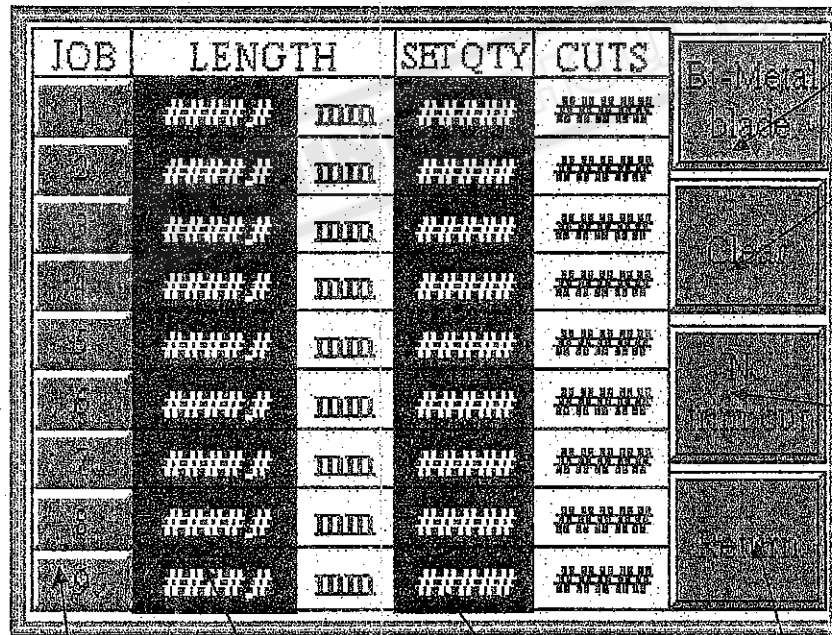
Error display

Return to the first page



( picture 31 )

Return to the operating and setting page



( picture 32 )

Bi-material blade

Clear the finished record

Trim setting

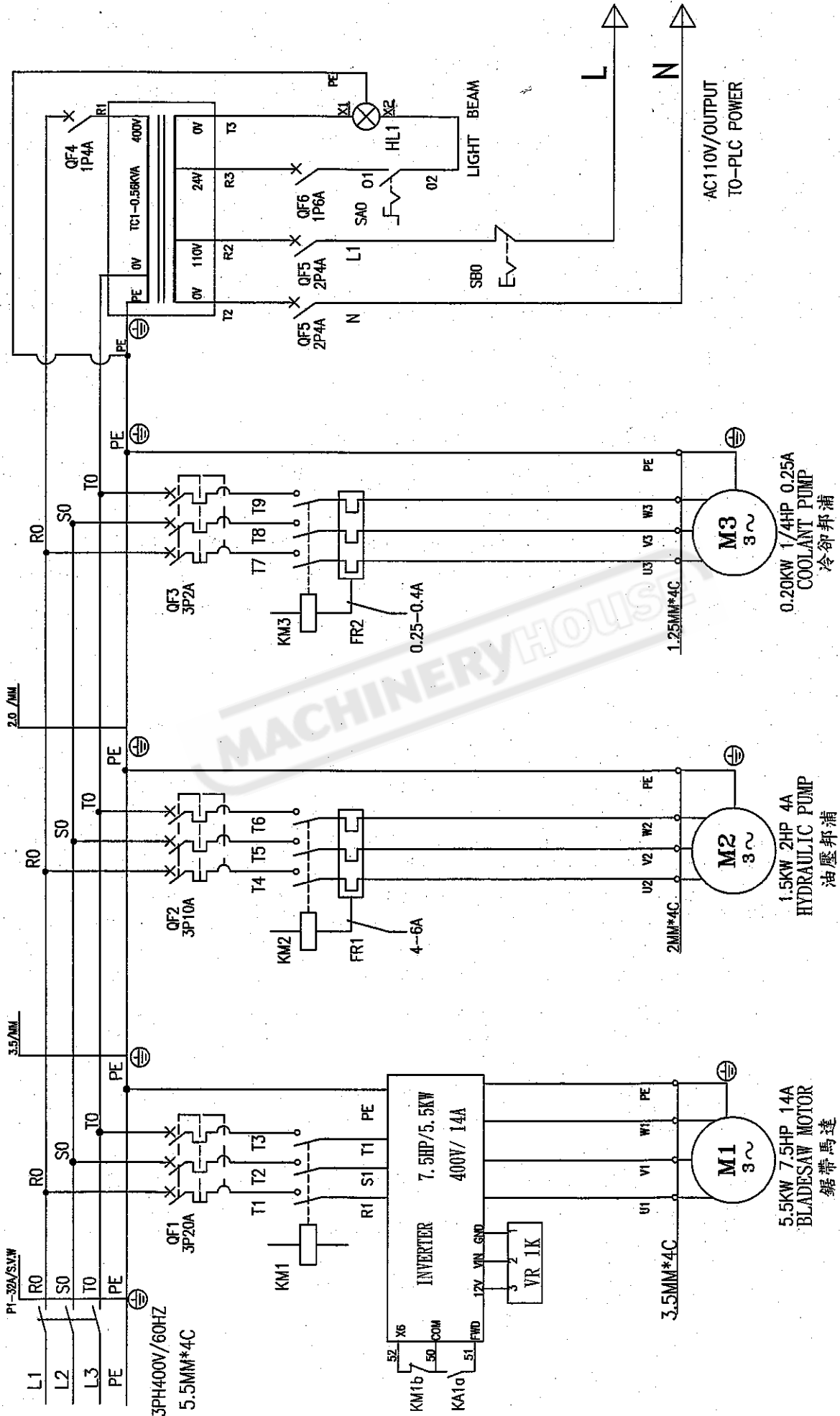
Job setting

Length setting

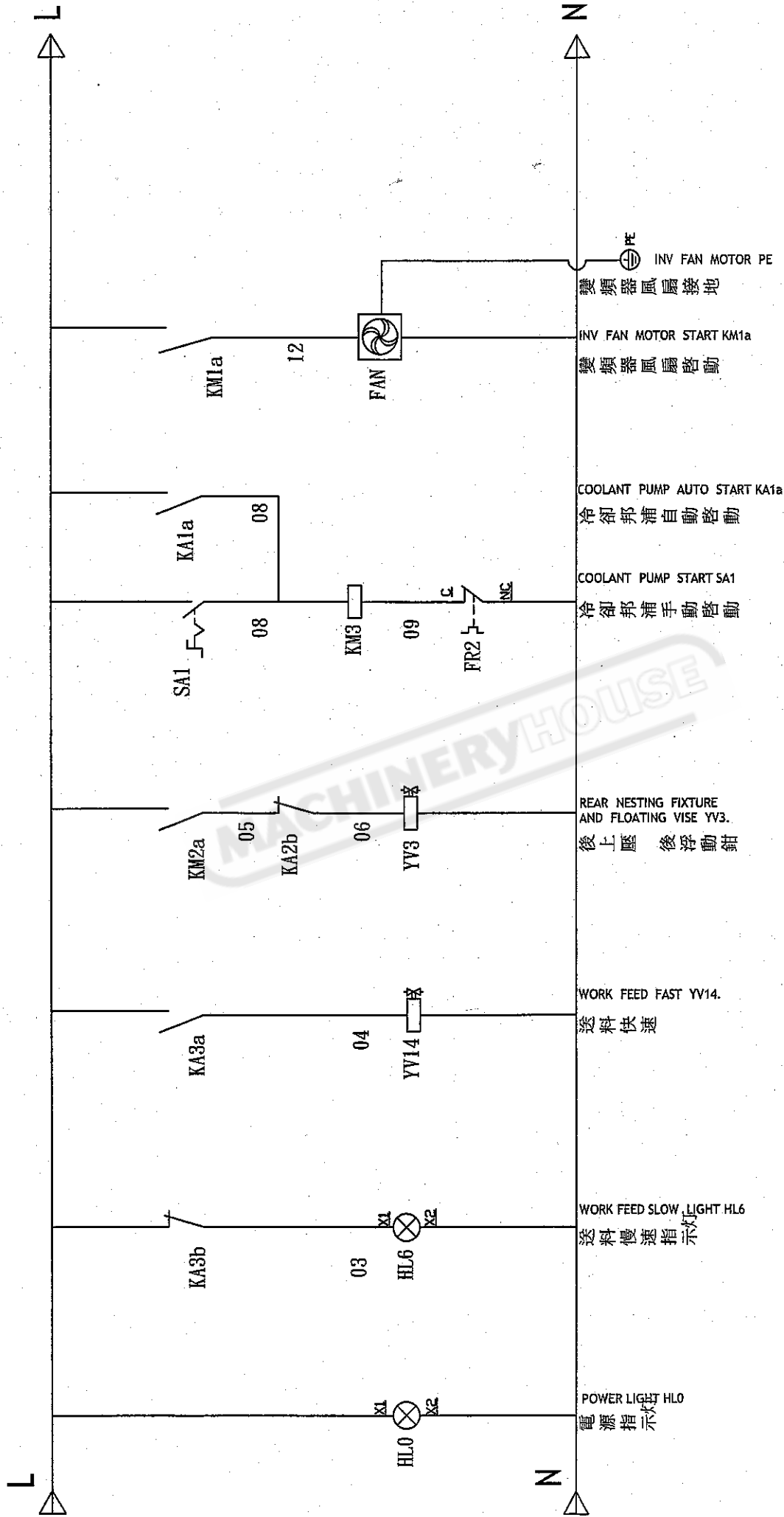
Quantity setting

Return to the operating and setting page





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CE/7.8kW / 400V / 21A  
HA-460NC

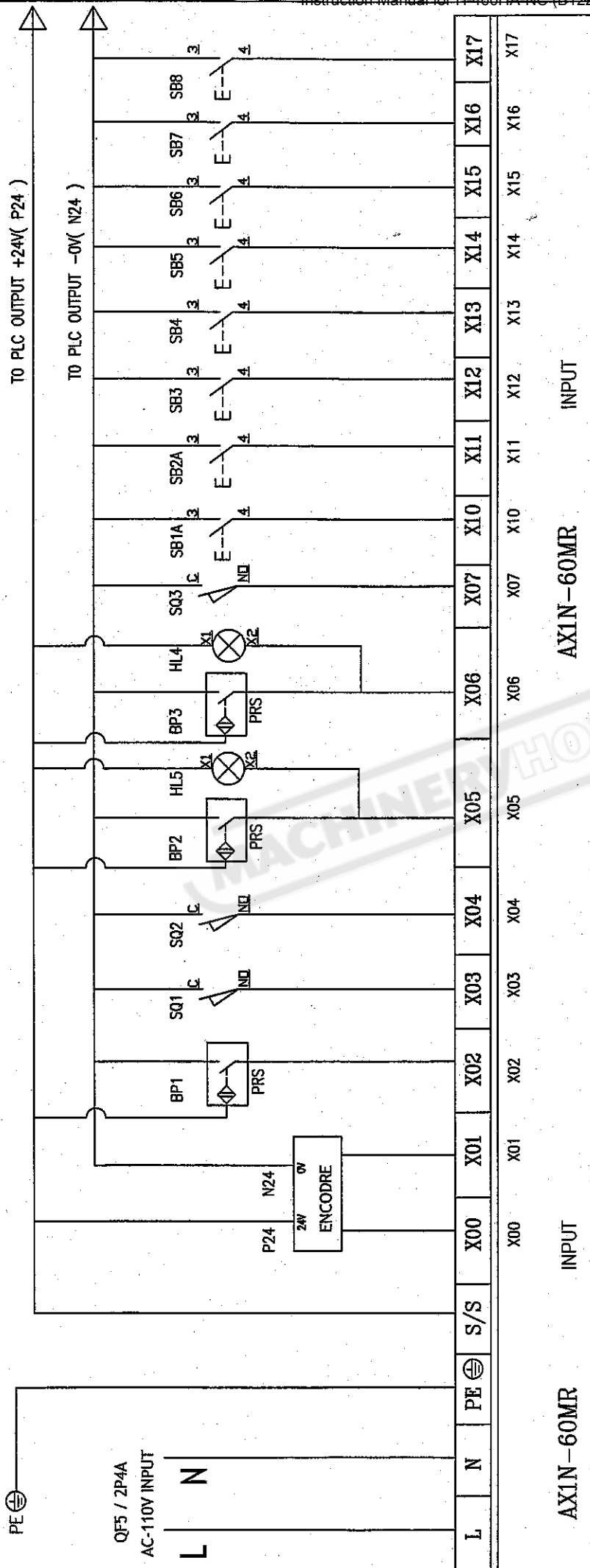
NC Type :  
Machine :

AC110V

ACTUAL POWER

Edt: Chun Nan Lin  
Check: Nick Huang  
Date: 2008/10/17

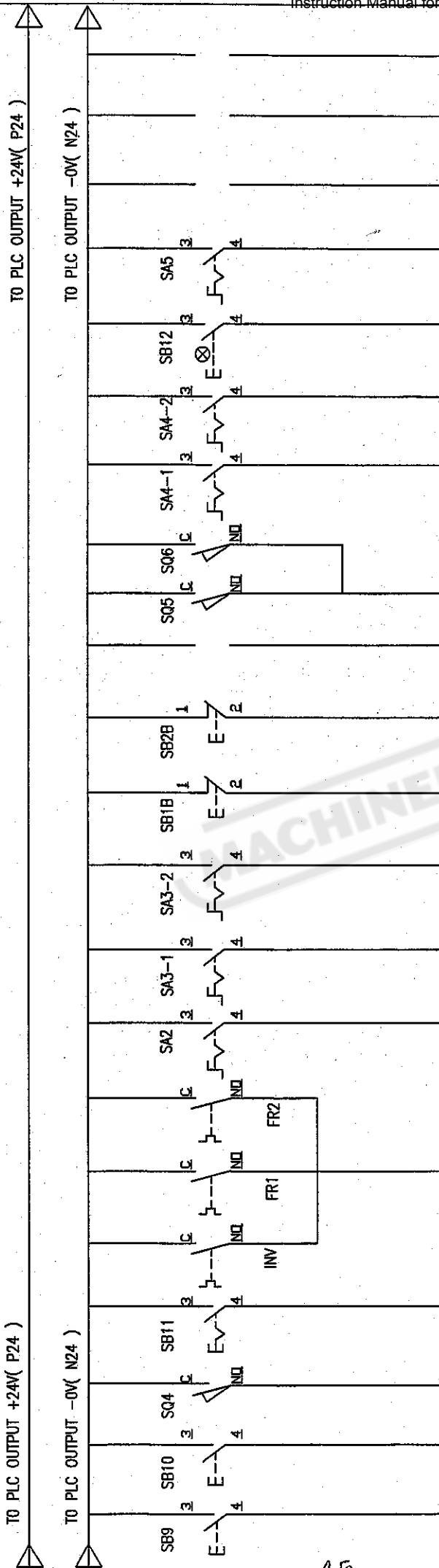
23



**AX1N-60MR** INPUT

- X00 24V AC ENCODRE A 譯碼器 A 相
- X01 24V AC ENCODRE B 譯碼器 B 相
- X02 PRS BP1 鋸帶偵測 P R S
- X03 SQ1 鋸框下極限
- X04 SQ2 送料台前極限
- X05 PRS BP2 後夾鉗夾緊檢測 P R S
- X06 PRS BP3 前夾鉗夾緊檢測 P R S
- X07 SQ3 快降桿
- X08 SB1A HYDRAULIC PUMP START SB1A. 油壓邦浦啓動
- X09 SB2A BLADE MOTOR START SB2A. 鋸帶馬達啓動
- X10 SB3 WORK FEED FORWARD SB3. 送料台前進
- X11 SB4 WORK FEED BACKWARD SB4. 送料台後退
- X12 SB5 FRAME RAISE SB5. 鋸框抬升
- X13 SB6 FRAME DOWN SB6. 鋸框下降
- X14 SB7 FRONT VISE OPEN SB7. 前夾開啓
- X15 SB8 FRONT VISE CLAMP SB8. 前夾夾緊
- X16 HL4 FRONT VISE CLAMP LIGHT HL4 前夾鉗夾緊指示
- X17 HL5 REAR VISE CLAMP LIGHT HL5 後夾鉗夾緊指示

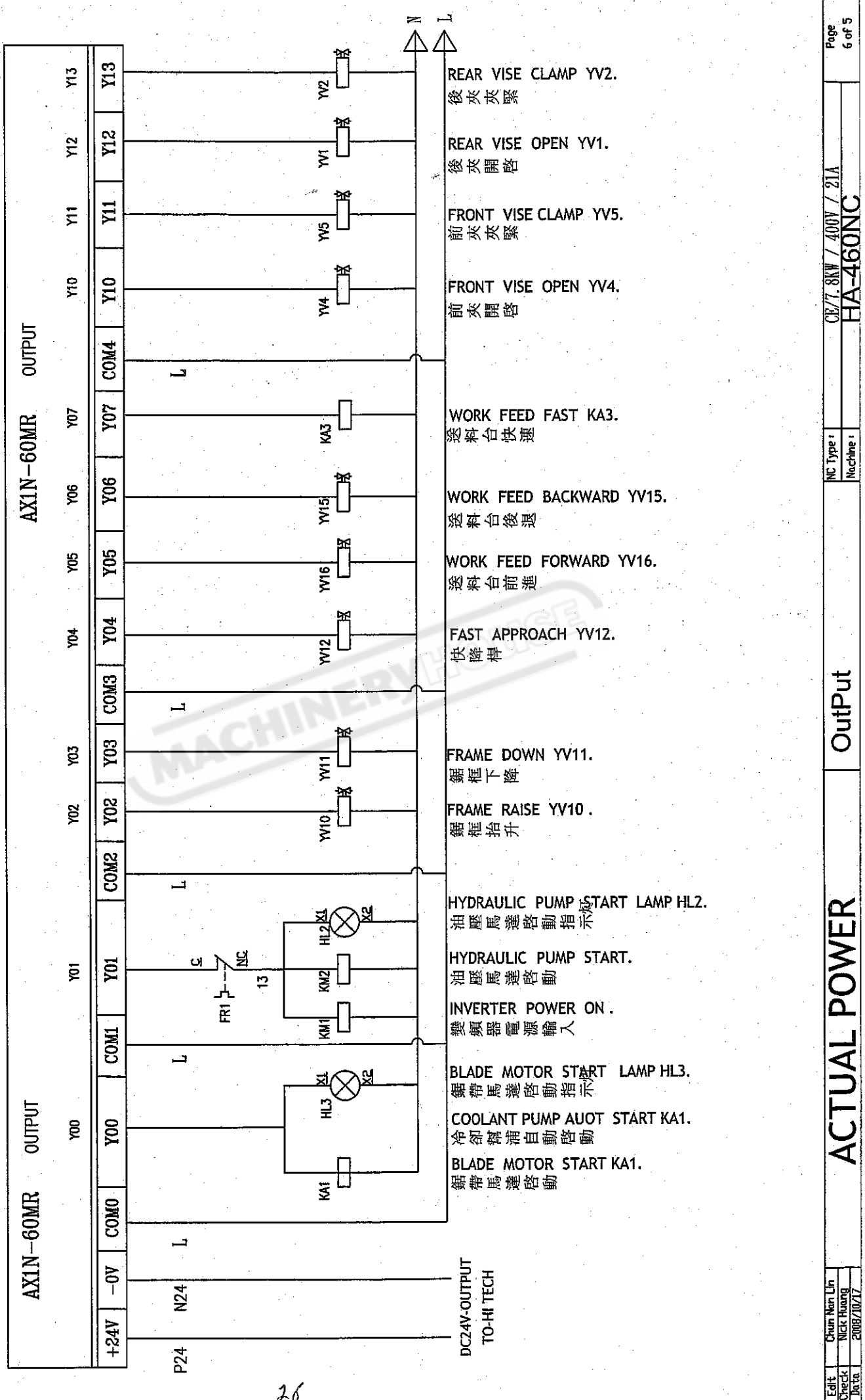




Terminal	Terminal	Component / Description
X20	X21	REAR VISE OPEN SB9.
X21	X22	後夾開啓
X22	X23	REAR VISE CLAMP SB10.
X23	X24	後夾夾緊
X24	X25	INV FR ALM.
X25	X26	變頻器異常
X26	X27	HYDRAULIC PUMP FR ALM.
X27	X28	油壓邦浦異常
X28	X29	COOLANT PUMP FR ALM.
X29	X30	冷卻邦浦異常
X30	X31	CARBIDE INSERT SA2.
X31	X32	鏤鋼夾緊
X32	X33	SINGLE CYCLE MODE SA3-1.
X33	X34	單回合模式
X34	X35	AUTOMATIC MODE SA3-2.
X35	X36	全自動模式
X36	X37	HYDRAULIC PUMP STOP SB1B.
X37	X38	油壓邦浦停止
X38	X39	BLADE MOTOR STOP SB2B.
X39	X40	鏤帶馬達停止
X40	X41	COVER SAFETY SQ5.
X41	X42	左大蓋停機
X42	X43	COVER SAFETY SQ6.
X43	X44	右大蓋停機
X44	X45	REAR NESTING FIXTURE SA4-1.
X45	X46	鏤帶張力拉緊
X46	X47	FRONT NESTING FIXTURE SA4-2.
X47	X48	鏤帶張力放鬆
X48	X49	GIVE THE MATERIAL SB12.
X49	X50	原點偵測
X50	X51	5TIME RBED FEED VISE OPEN SA5.
X51	X52	五次開關夾
X52	X53	S/P.
X53	X54	預留
X54	X55	S/P.
X55	X56	預留
X56	X57	S/P.
X57	X58	預留

25

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26

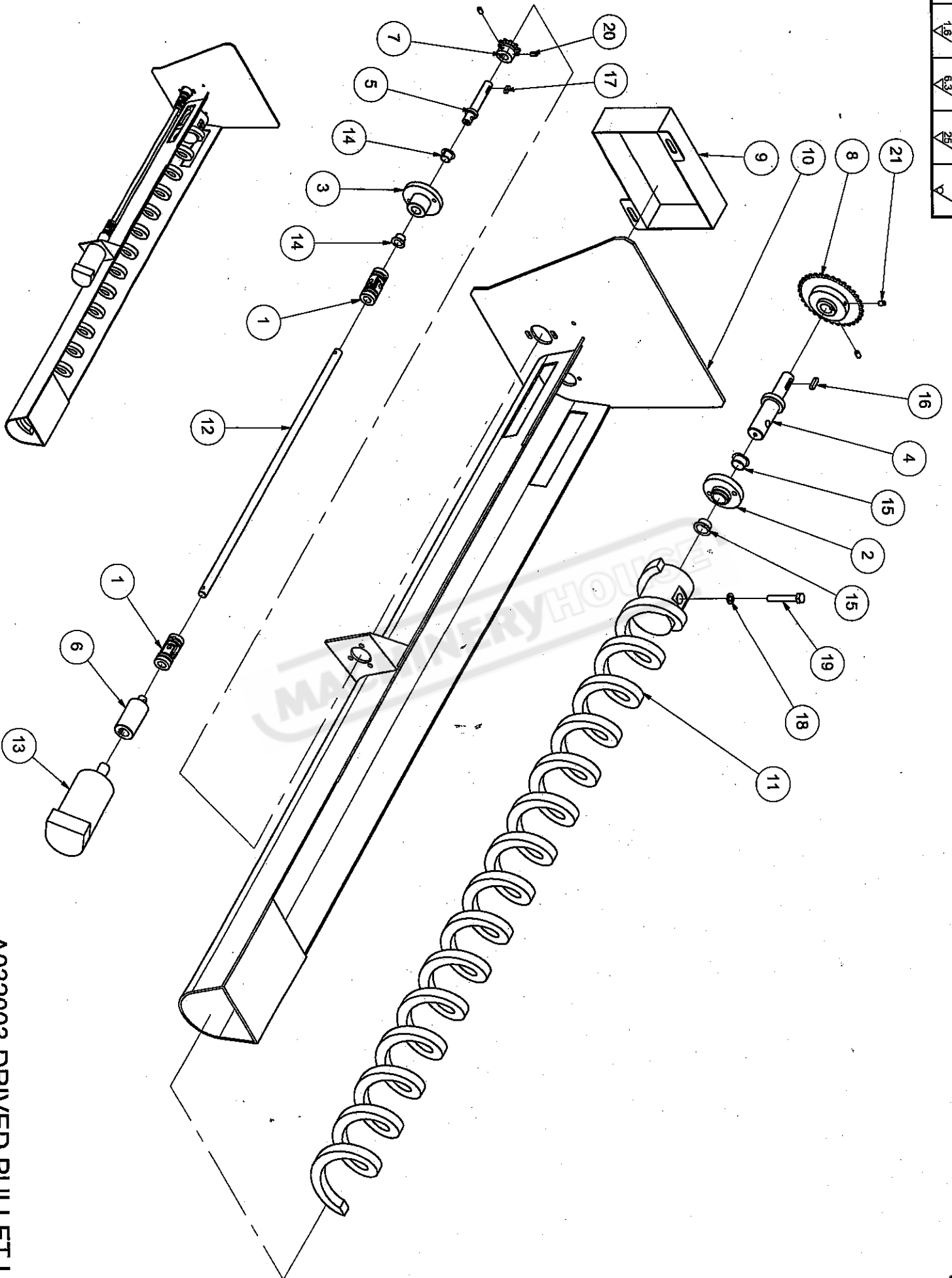




NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	H03220600	WORM GEAR				
2	1	B02020700	UNDER COVER				
3	1	B02020800	OIL SEAL COVER				
4	1	B02020900	BEARING COVER				
5	1	B02021000	BEARING SLEEVE				
6	1	B02021100	BACK COVER				
7	1	H03220500	OUTPUT SHAFT ( WORM SHAFT )				
8	1	H03220700	BEARING SLEEVE				
9	1	H03220800	GEAR BOX				
10	1	H03220900	DRIVING PULLEY SHAFT				
11	1	H03221100	UPPER COVER				
12	1	H03221200	BEARING COVER				
13	1	H03221500	NUT				
14	2	6007	CYLINDRICAL ROLLER BEARING				
15	2	30210J3	CYLINDRICAL ROLLER BEARING				
16	1	22212	SPHERICAL ROLLER BEARING				
17	1	AW12	GASKET				
18	2	AN12	BEARING NUT				
19	1	4TC65-85-10	OIL SEA				
20	1	65x2.5	C TYPE RETAINING RING				
21	1	35x1.6	C TYPE RETAINING RING				
22	1	G105	O RING				
23	1	16x16x60	DOUBLE ROUND KEY				
24	1	22215	SPHERICAL ROLLER BEARING				
25	1	4TC85-110-13	TC OIL SEAL				

A032002 GEAR BOX UNIT

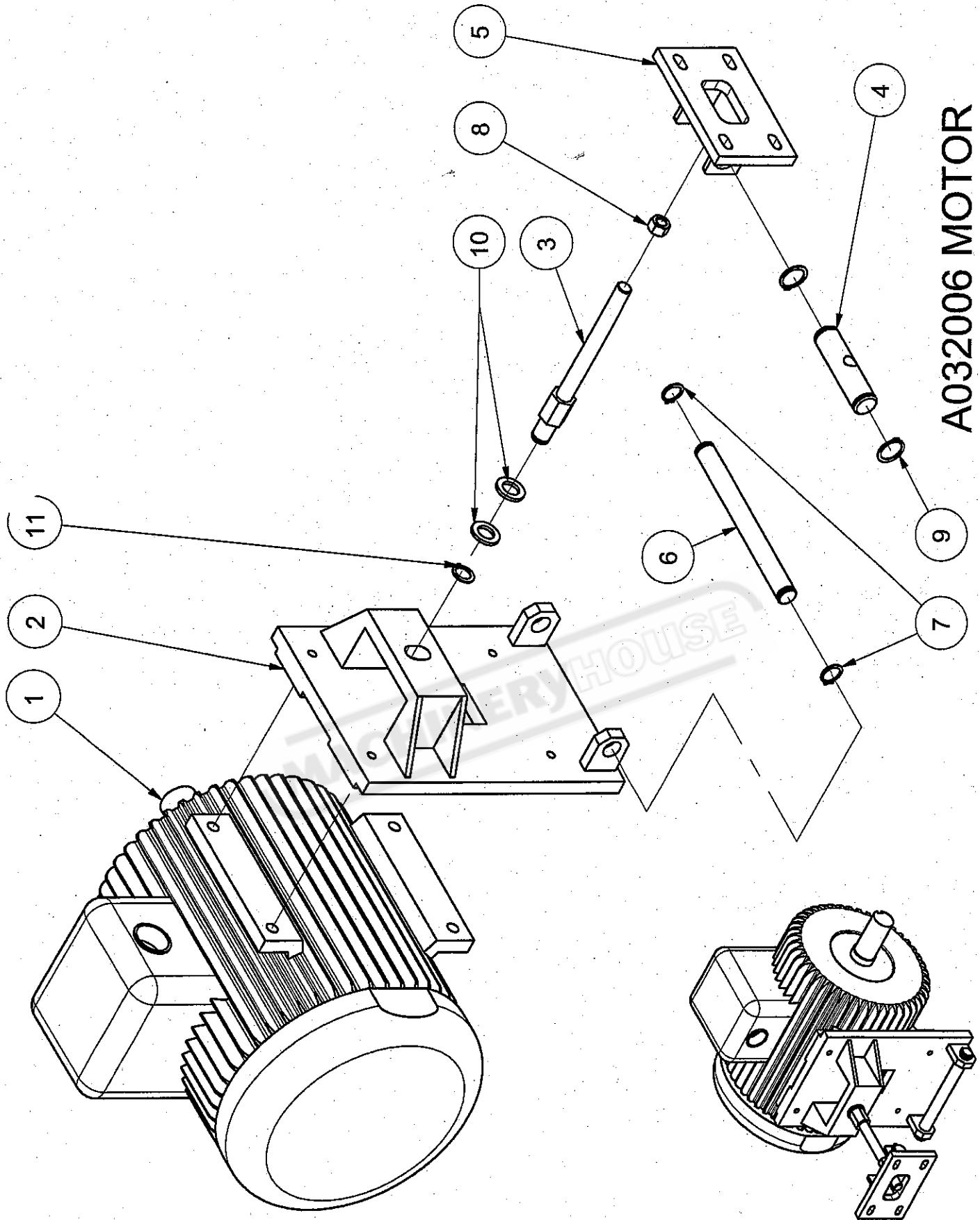
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AN32003 DRIVEN PULLER UNIT

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	2	5UJ-NI12	COUPLING				
2	1	B02031500	FLANGE BASE				
3	1	B02031600	ADJUSTING BASE				
4	1	B02031700	SHAFT				
5	1	B02031800	CHAIN WHEEL SHAFT				
6	1	B02031900	MOTOR COUPLING				
7	1	B02032900	DRIVING CHAIN WHEEL				
8	1	B02033000	DRIVED CHAIN WHEEL				
9	1	B02013401	PROTECTING COVER				
10	1	H03210300	CHIPPING DISCHARGE CHASE				
11	1	H03231900	DISCHARGE SCREW				
12	1	H03232700	CLEAN SCREW				
13	1	3HM-OMM32	HYDRAULIC MOTOR				
14	2	2DUF1210-20	LUBRICATING BEARING				
15	2	2DUF1810-26	LUBRICATING BEARING				
16	1	6x6x20	ROUND KEY				
17	1	5x5x15	ROUND KEY				
18	1	M8	SPRING WASHER				
19	1	M8X55L	HEXAGON FIXING SCREW				
20	2	M5x10	HEX BOLT				
21	2	M6x10	HEX BOLT				
22							
23							
24							
25							

**A032003 CHIPPING CONVEYER UNIT**



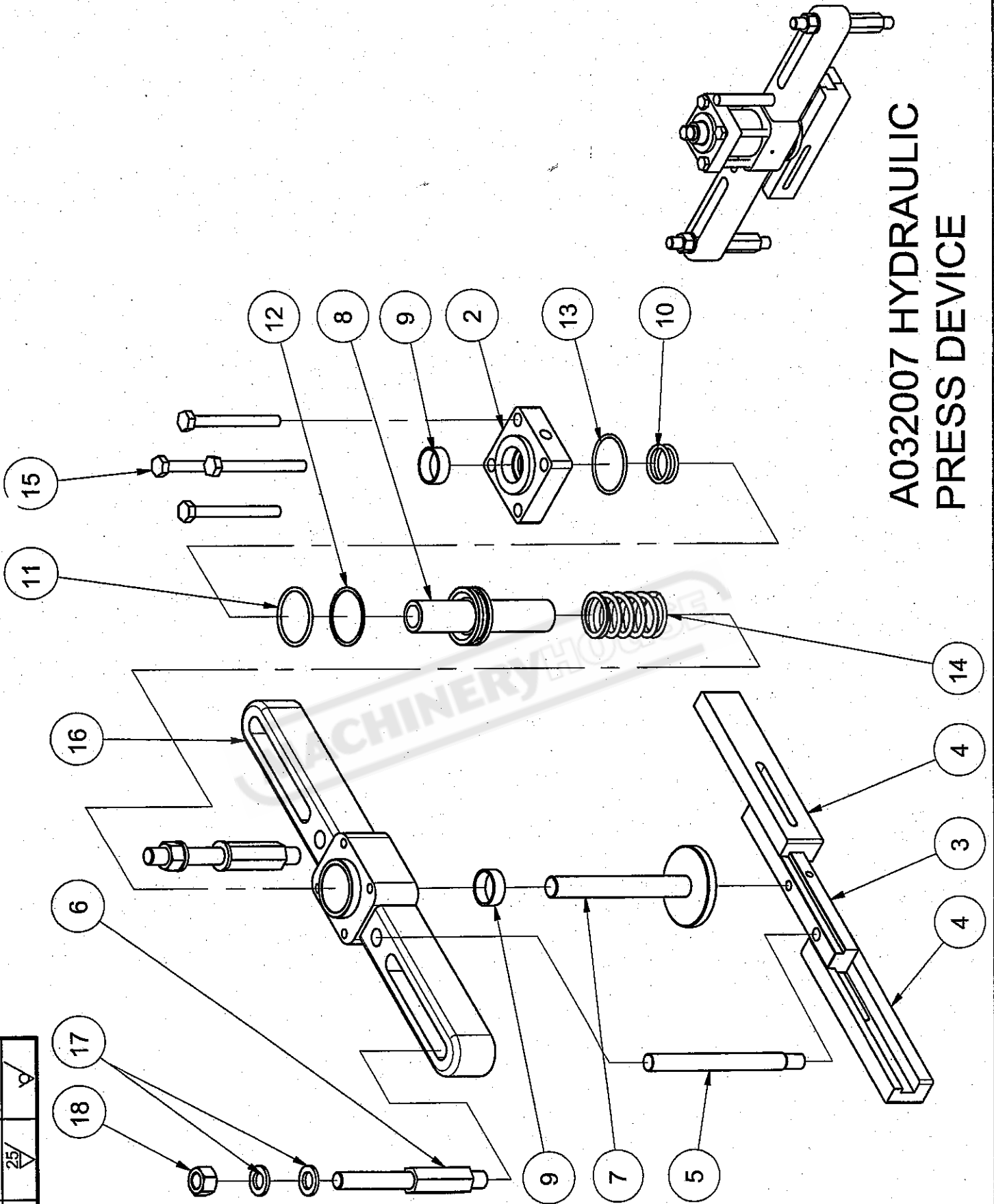
A032006 MOTOR  
STAND UNIT



NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	7.5HP-132S	MOTOR				
2	1	H03220200	MOTOR STAND				
3	1	H03221600	ADJUSTING SCREW				
4	1	H03221400	PIN				
5	1	H03220100	BASE				
6	1	H03221000	SHAFT				
7	2	20x1.2	C TYPE RETAINING RING				
8	1	M12	HEX NUT				
9	2	25x1.2	C TYPE RETAINING RING				
10	2	M18	GASKET				
11	1	18x1.2	C TYPE RETAINING RING				
12							
13							
14							
15							
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A032006 MOTOR STAND UNIT

# A032007 HYDRAULIC PRESS DEVICE

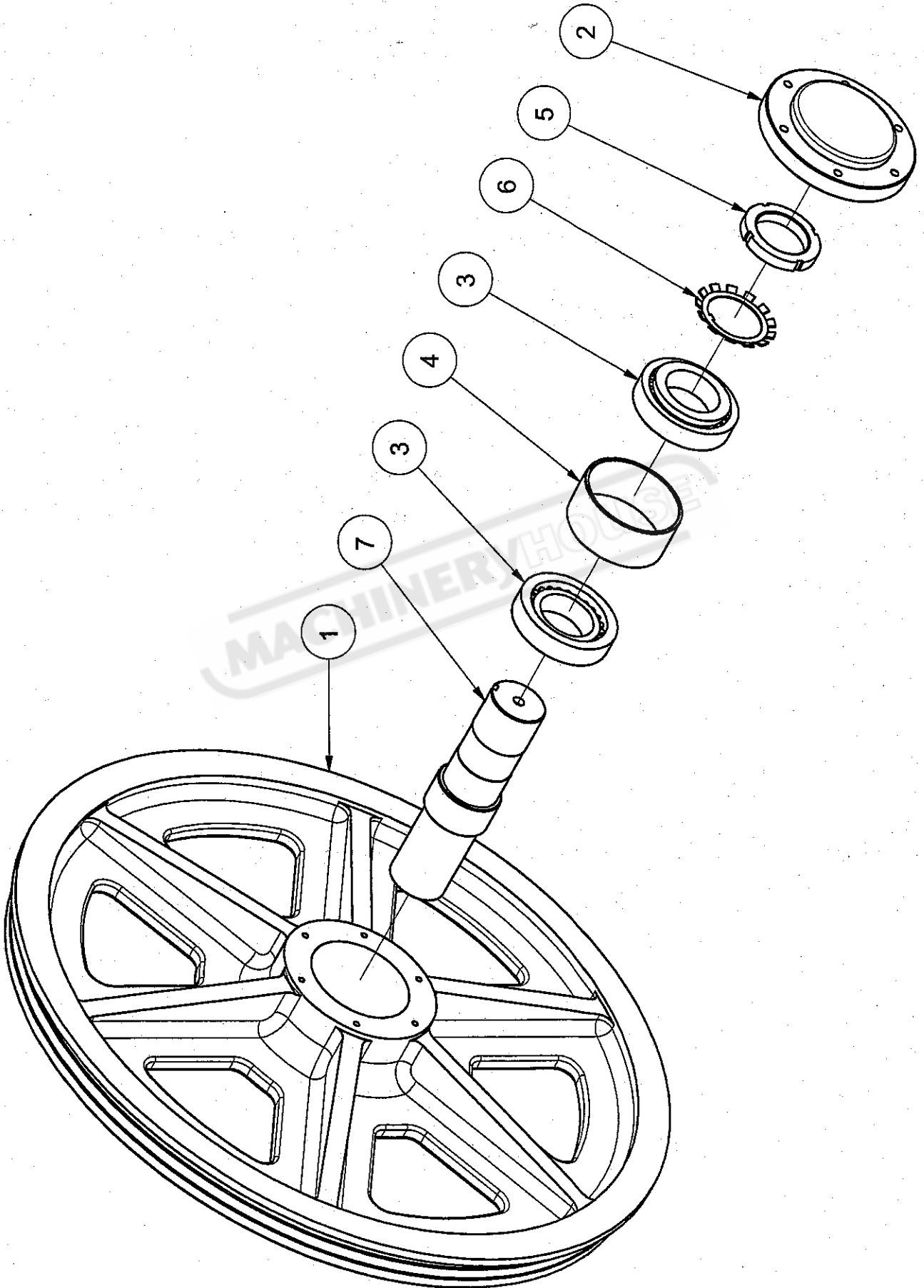


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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B02161400	CYLINDER				
2	1	B02161500	BACK COVER				
3	1	H03241300	PRESSING BLOCK				
4	2	H03241400	PLATE				
5	1	H03241700	GUIDE BAR				
6	2	H03241800	GUIDE SCREW				
7	1	H03341900	ADJUSTING DISK				
8	1	H03261500	PISTON BAR				
9	2	2DU3012	LUBRICATING BEARING				
10	2	P30	O RING				
11	1	P49	O RING				
12	1	TP49	BACKING UP RING				
13	1	G50	O RING				
14	1	DIAMETER 33	COMPRESS SPRING				
15	4	M10xP1.5x100	HEX HEAD CAP SCREW				
16	1	H03241200	BASE				
17	4	M16	GASKET				
18	2	M16	NUT				

A032007 HYDRAULIC PRESS DEVICE

A032008 DRIVEN PULLEY UNIT

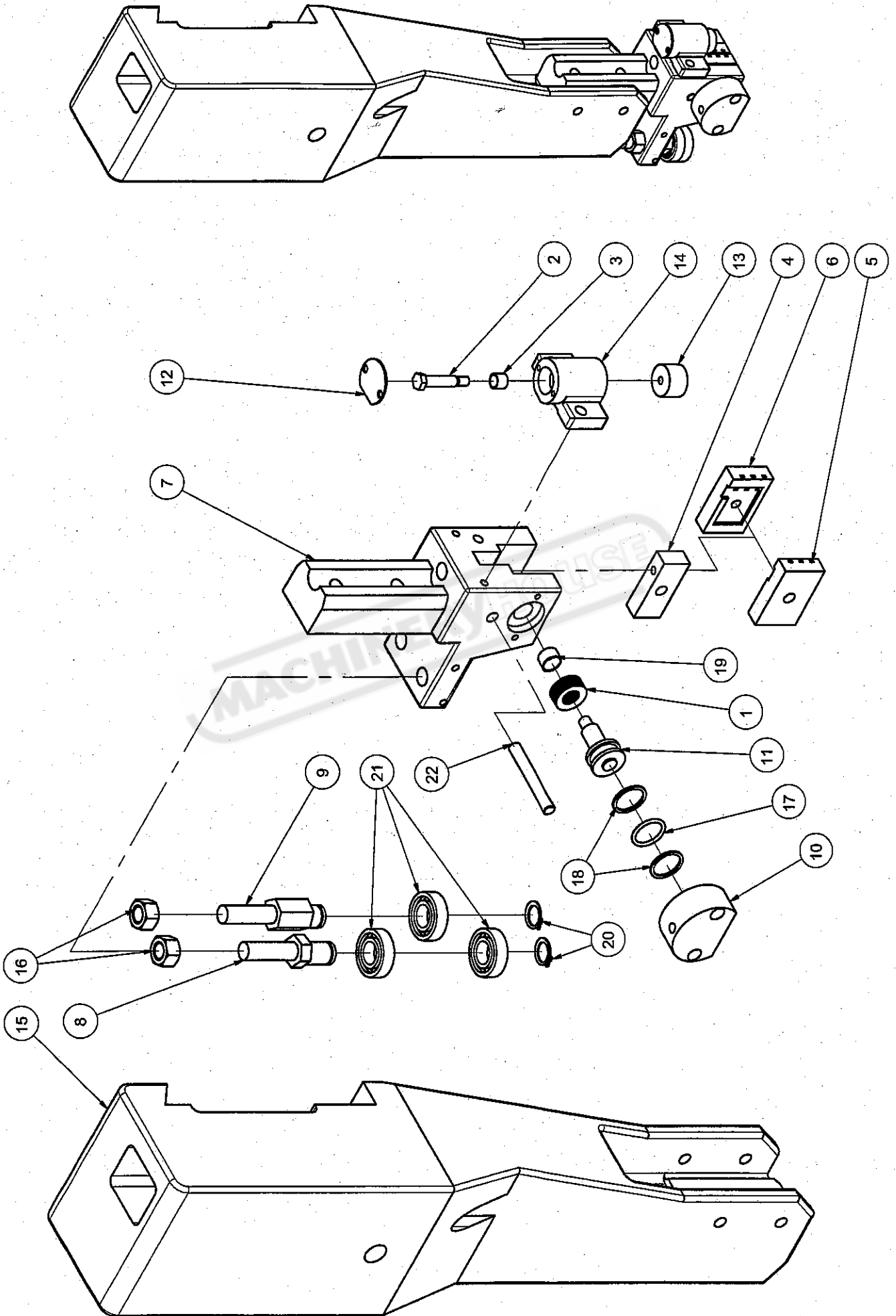


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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	H03240200	DRIVED PULLEY				
2	1	B02040600	BEARING COVER				
3	2	E32210J	CYLINDRICAL ROLLER BEARING				
4	1	B02044000	SPACER RING				
5	1	AN10	BEARING NUT				
6	1	AW10	GASKET				
7	1	H03221300	SHAFT				
8							
9							
10							
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A032008 DRIVED PULLEY UNIT

A032009 LEFT GUIDE ARM UNIT

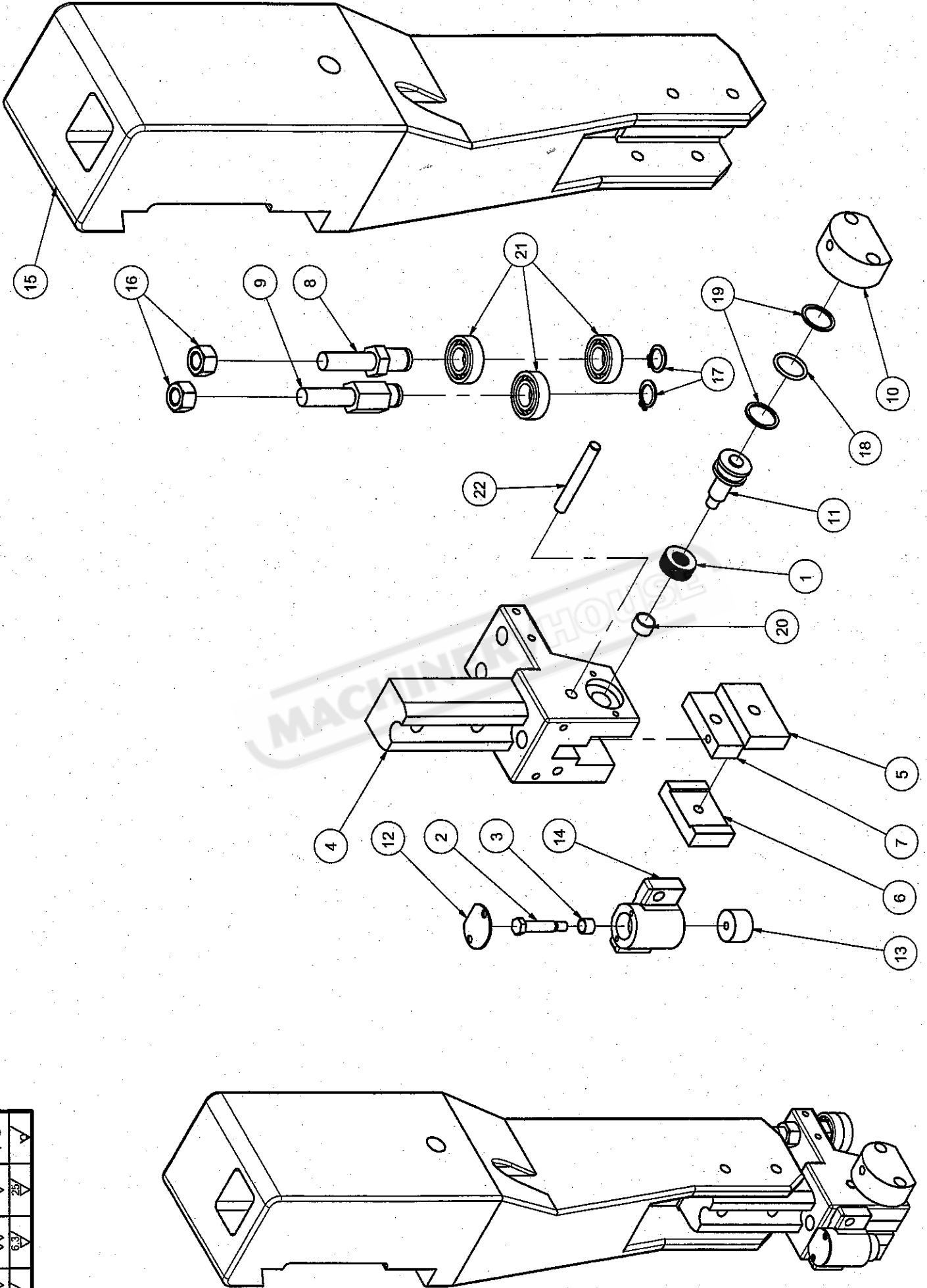


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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	5	Ø 12.2 x Ø 23 x 1t	DISC SPRING				
2	1	200103500	STEEL BRUSH SHAFT				
3	1	200104000	BEARING SLEEVE				
4	1	B02041100	UPPER CARBIDE FIXTURE				
5	1	B02041300	LEFT FRONT CARBIDE FIXTURE				
6	1	B02041400	LEFT BACK CARBIDE FIXTURE				
7	1	B02043800	LEFT GUIDE WHEEL BASE (HYDRAULIC)				
8	1	B02044100	SHORT ECCENTRIC SHAFT				
9	1	B02044200	LONG ECCENTRIC SHAFT				
10	1	B02062600	CYLINDER				
11	1	B02062700	PISTON				
12	1	B02113600	COVER				
13	1	B02141400	ANTI-VIBRATION PAD				
14	1	B02141300	ANTI-VIBRATION BASE				
15	1	H03240600	LEFT GUIDE ARM				
16	2	M12	HEX NUT				
17	1	P20	O RING				
18	2	TP20	BACKING UP RING				
19	1	2DU1208	LUBRICATING BEARING				
20	2	Ø 15	C TYPE RETAINING RING				
21	3	6002	BALL BEARING				
22	1	Ø 8 x 60L	STRAIGHT PIN				
23							
24							
25							

A032009 LEFT GUIDE ARM UNIT

A032010 RIGHT GUIDE ARM UNIT

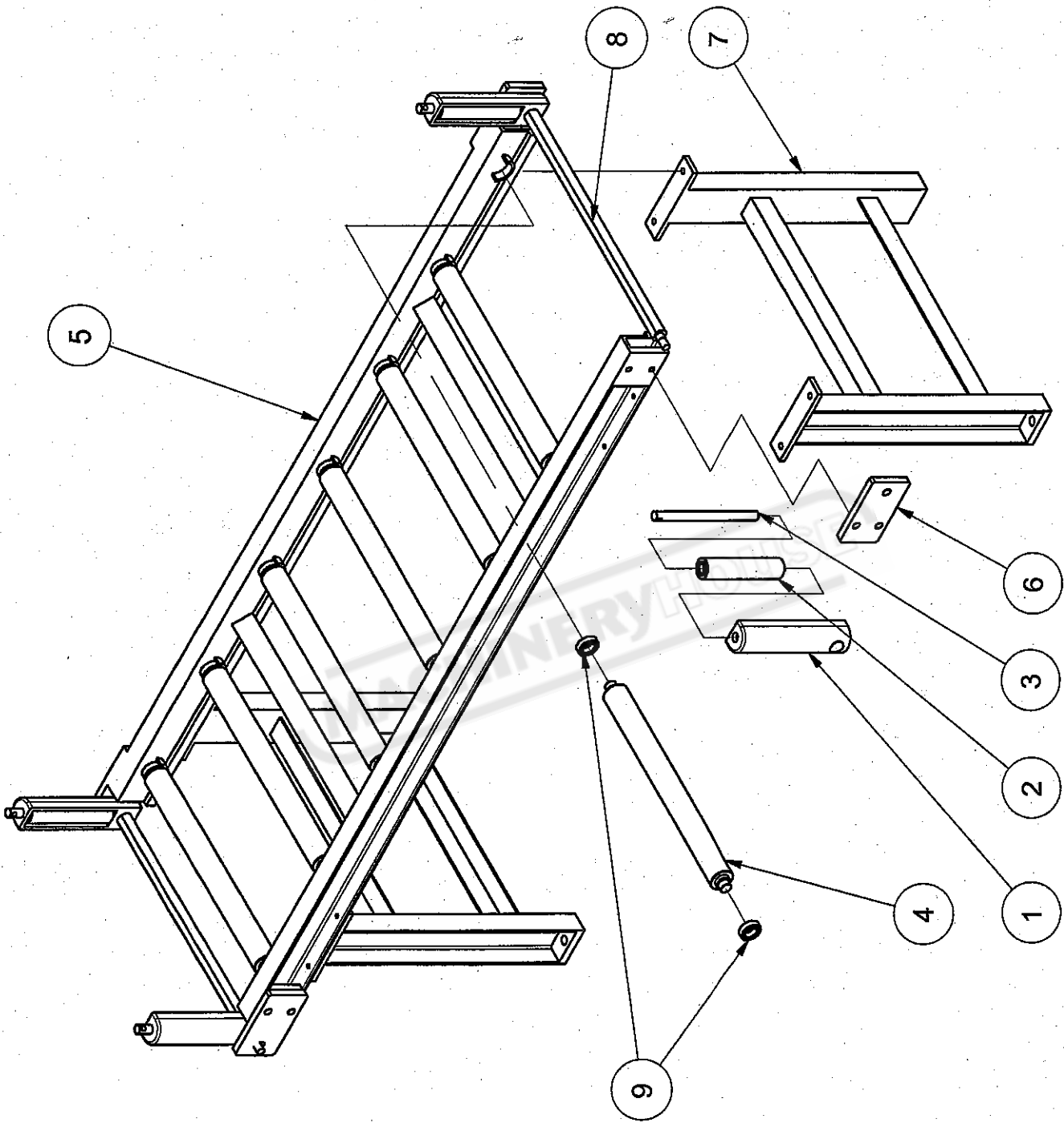


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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	4	φ 12.2 x φ 23 x 1t	DISC SPRING				
2	1	200103500	STEEL BRUSH SHAFT				
3	1	200104000	BEARING SLEEVE				
4	1	B02043700	RIGHT GUIDE WHEEL BASE (HYDRAULIC)				
5	1	B02040900	RIGHT FRONT CARBIDE FIXTURE				
6	1	B02041000	RIGHT BACK CARBIDE FIXTURE				
7	1	B02041100	UPPER CARBIDE FIXTURE				
8	1	B02044100	SHORT ECCENTRIC SHAFT				
9	1	B02044200	LONG ECCENTRIC SHAFT				
10	1	B02062600	CYLINDER				
11	1	B02062700	PISTON				
12	1	B02113600	COVER				
13	1	B02141400	ANTI-VIBRATION PAD				
14	1	B02141300	ANTI-VIBRATION BASE				
15	1	H03240700	RIGHT GUIDE ARM				
16	2	M12	HEX NUT				
17	2	φ 15	C TYPE RETAINING RING				
18	1	P20	O RING				
19	2	TP20	BACKING UP RING				
20	1	2DU1208	LUBRICATING BEARING				
21	3	6002	BALL BEARING				
22	1	φ 8 x 60L	STRAIGHT PIN				
23							
24							
25							

A032010 RIGHT GUIDE ARM UNIT

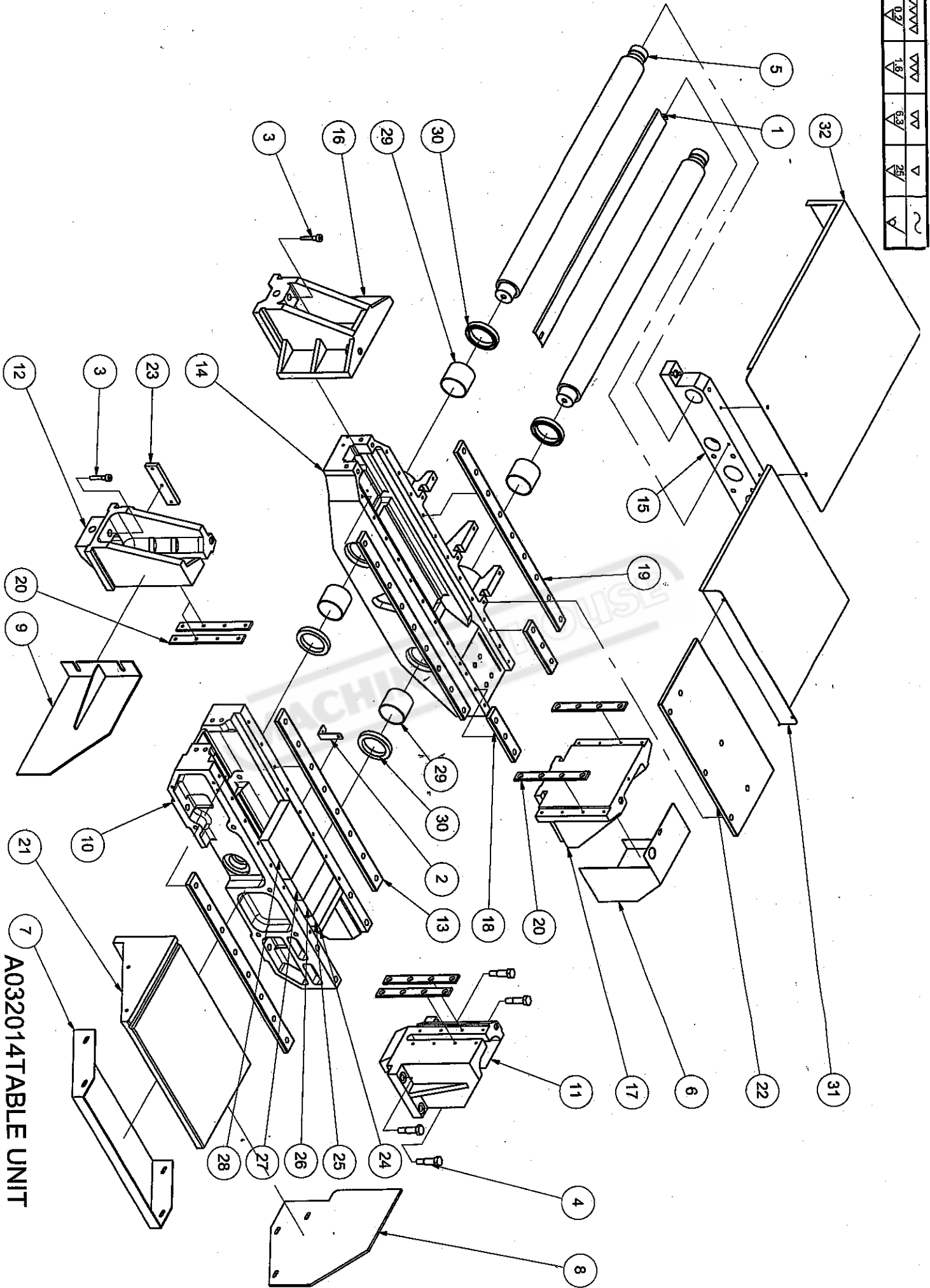


A032011 BACK MATERIAL HOLDER

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	4	B02132200	COVER				
2	4	B02132500	VERTICAL ROLLER				
3	4	B02141100	SHAFT				
4	7	H03230900	FEED ROLLER				
5	1	H03250100	RACK				
6	2	H02250100-2	BLOCK				
7	2	H03250200	STAND				
8	2	H03250300	ADJUSTING ROD				
9	14	6005	BALL BEARING				
10							
11							
12							
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A032011 BACK MATERIAL HOLDER

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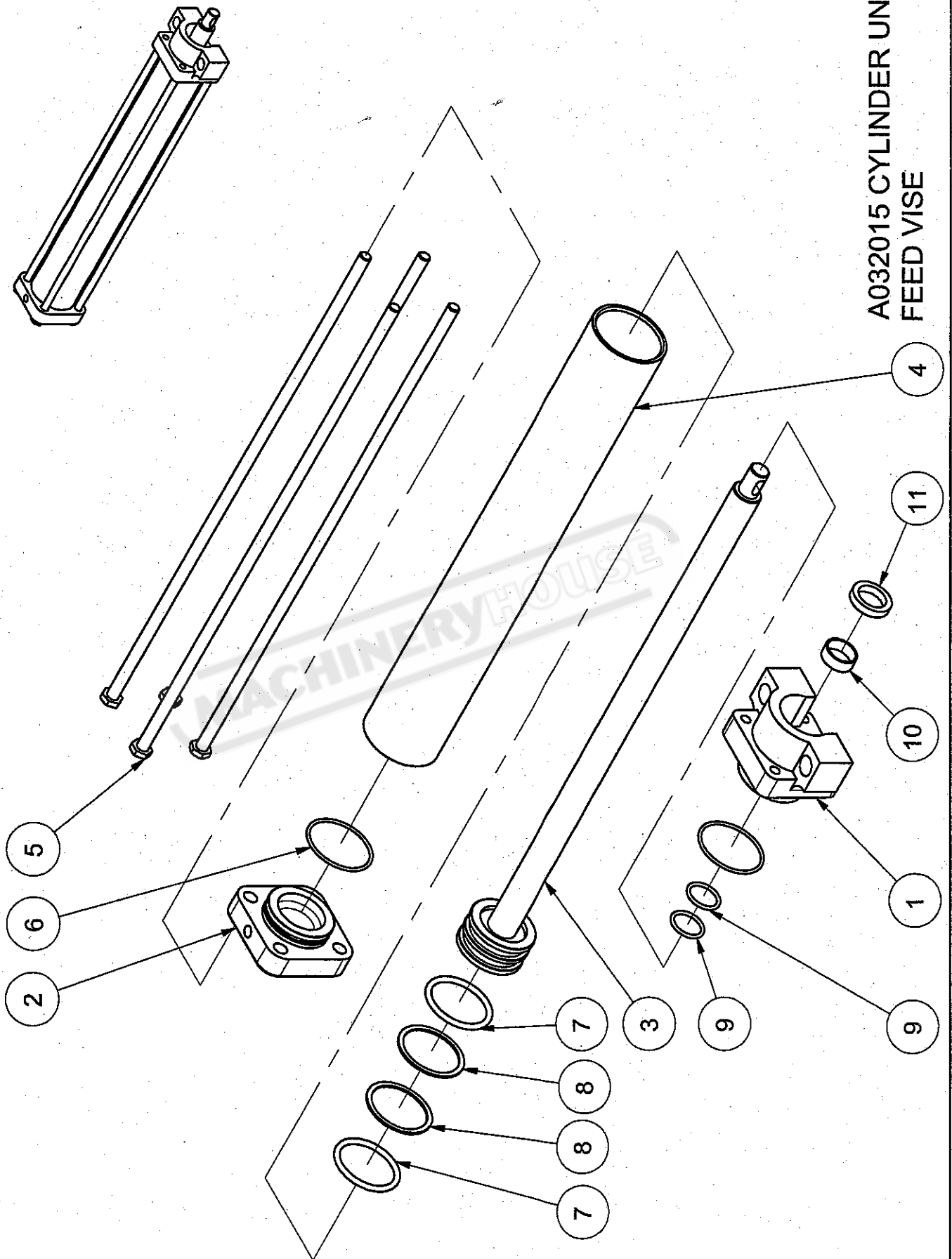


A032014TABLE UNIT  
(FULL STROKE CLAMPING VISE)

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B02110300	PROTECTING COVER	26	1	H03232600-3	
2	1	B02113100	BRACKET	27	1	H03232600-4	
3	2	B02130200	SCREW OF FIXING PIN	28	1	H03232600-5	
4	4	B02130700	LOCATING SCREW	29	4	2DU7060	LUBRICATING BEARING
5	2	B02131101	GUIDE COLUMN	30	4	D95-d70-B13	OIL SEAL
6	1	H03211700	PROTECTING COVER	31	1	H03211600	PLATE
7	1	H03211800	ANTI-SPLASH PLATE	32	1	H03211500	PLATE
8	1	H03212000	ANTI-FALLING PLATE				
9	1	H03212100	MATERIAL HOLDING VISE				
10	1	H03230100	FIXING TABLE				
11	1	H03230200	FIXING VISE				
12	1	H03230500	MOVABLE VISE				
13	2	H03230600	WEARING PLATE				
14	1	H03230800	MOVABLE TABLE				
15	1	H03231200	BASE				
16	1	H03231300	FEED VISE				
17	1	H03231400	FLOATING SHUTTLE VISE				
18	2	H03231500	SHORT WEARING PLATE				
19	2	H03231700	WEARING PLATE				
20	6	H03231800	STEEL PLATE				
21	1	H03232000	MATERIAL HOLDING RACK				
22	1	H03232300	MATERIAL HOLDING PLATE				
23	1	H03232500	PLATE				
24	1	H03232600	STEEL PLATE				
25	1	H03232600-2					

A032014 TABLE UNIT

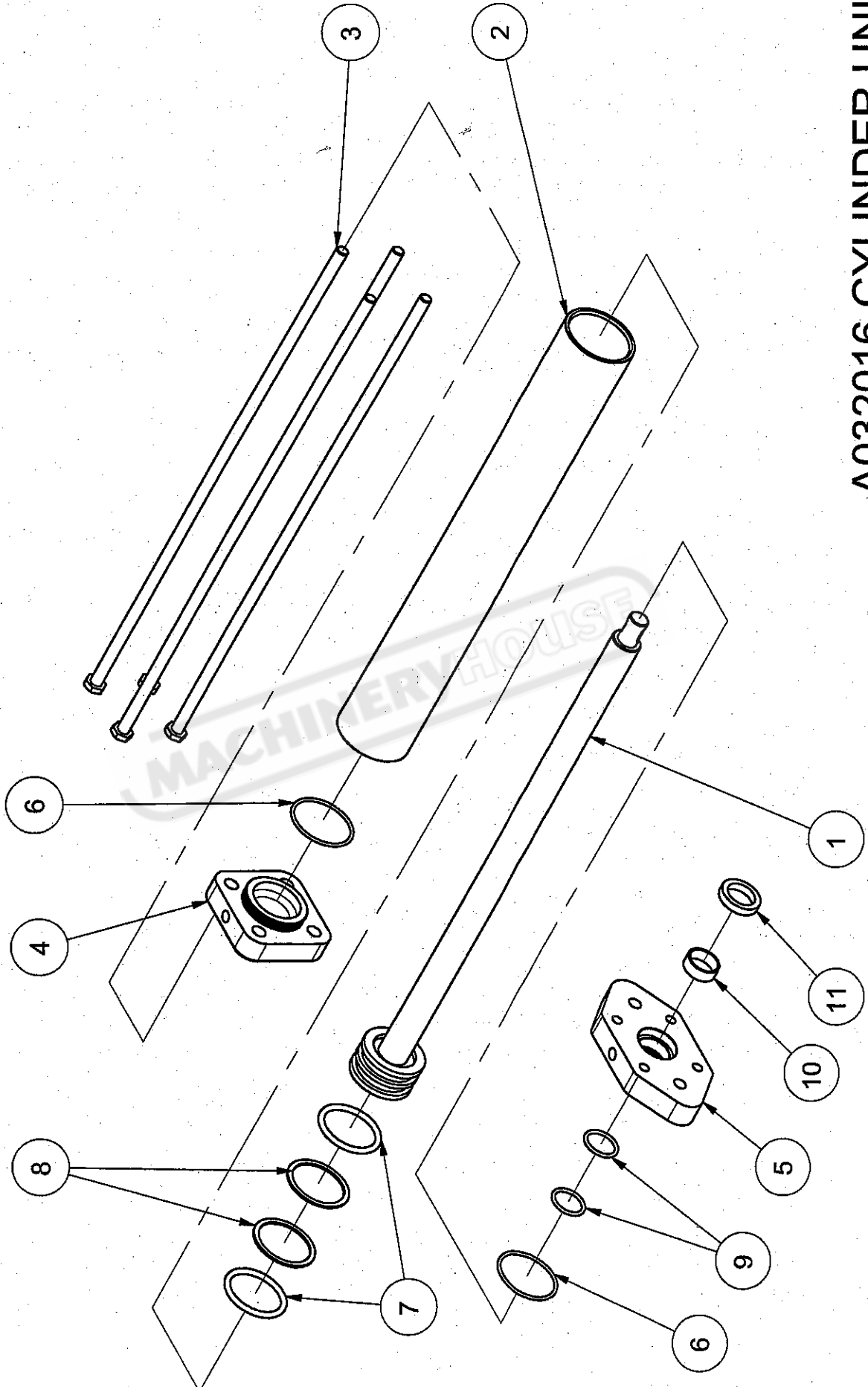
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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	H03262000	FRONT COVER				
2	1	B02162000	BACK COVER				
3	1	H03260500	PISTON BAR				
4	1	H03260600	CYLINDER				
5	4	H03261200	LONG SCREW				
6	2	G65	O RING				
7	2	P60	O RING				
8	2	P60	BACKING UP RING				
9	2	P30	O RING				
10	1	2DU3012	LUBRICATING BEARING				
11	1	D42-d30-B8	OIL SEAL				
12							
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A032015 CYLINDER UNIT OF FEED VISE

# A032016 CYLINDER UNIT OF TABLE VISE

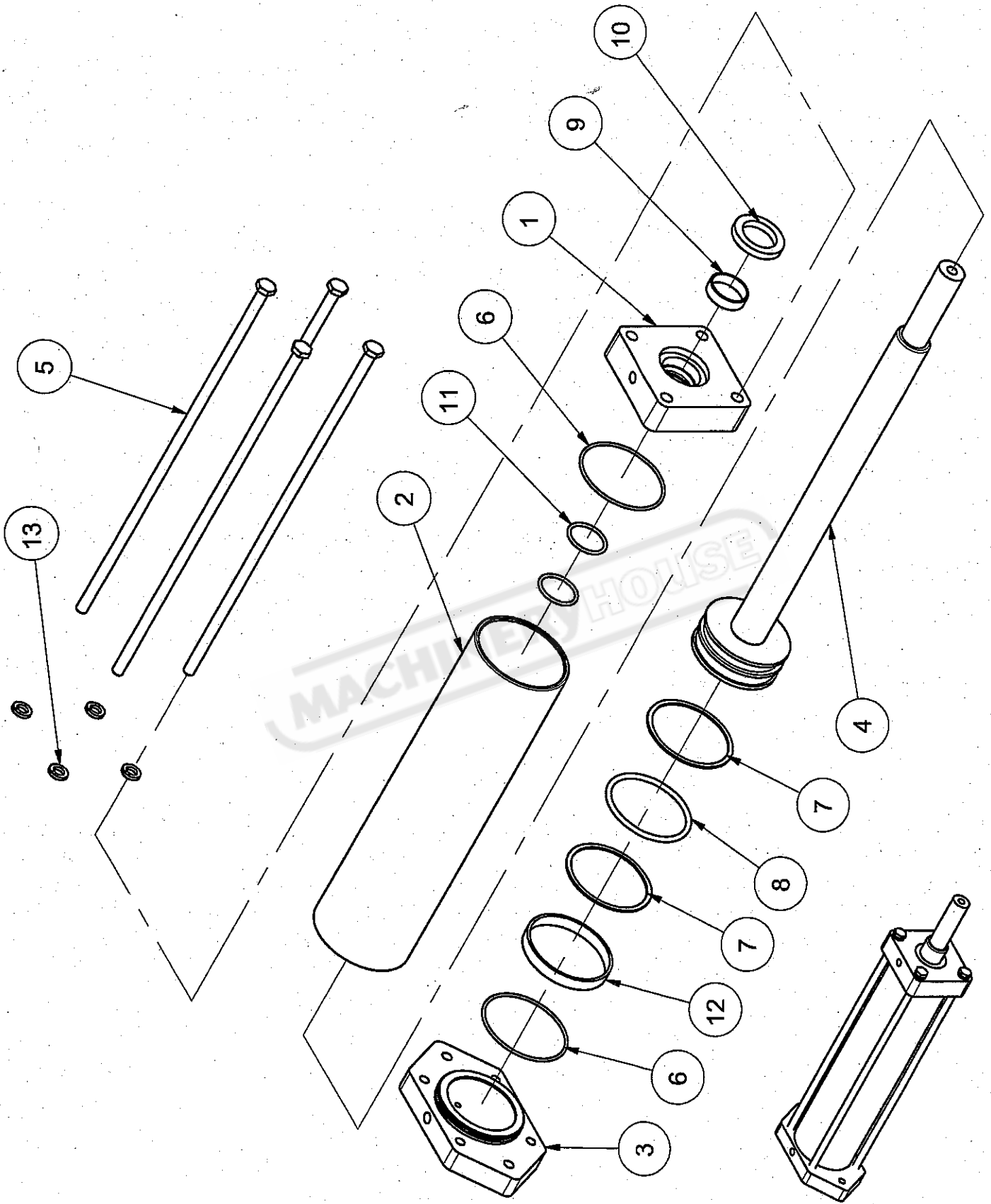


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NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	H03260300	PISTON				
2	1	H03260400	CYLINDER				
3	4	H03261400	LONG SCREW				
4	1	H03261000	BACK COVER				
5	1	H03260900	FRONT COVER				
6	2	G60	O RING				
7	2	P55	O RING				
8	2	TP55	BACKING UP RING				
9	2	P30	O RING				
10	1	2DU3012	LUBRICATING BEARING				
11	1	D42-d30-B8	OIL SEAL				
12							
13							
14							
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A032016 CYLINDER UNIT OF TABLE VISE

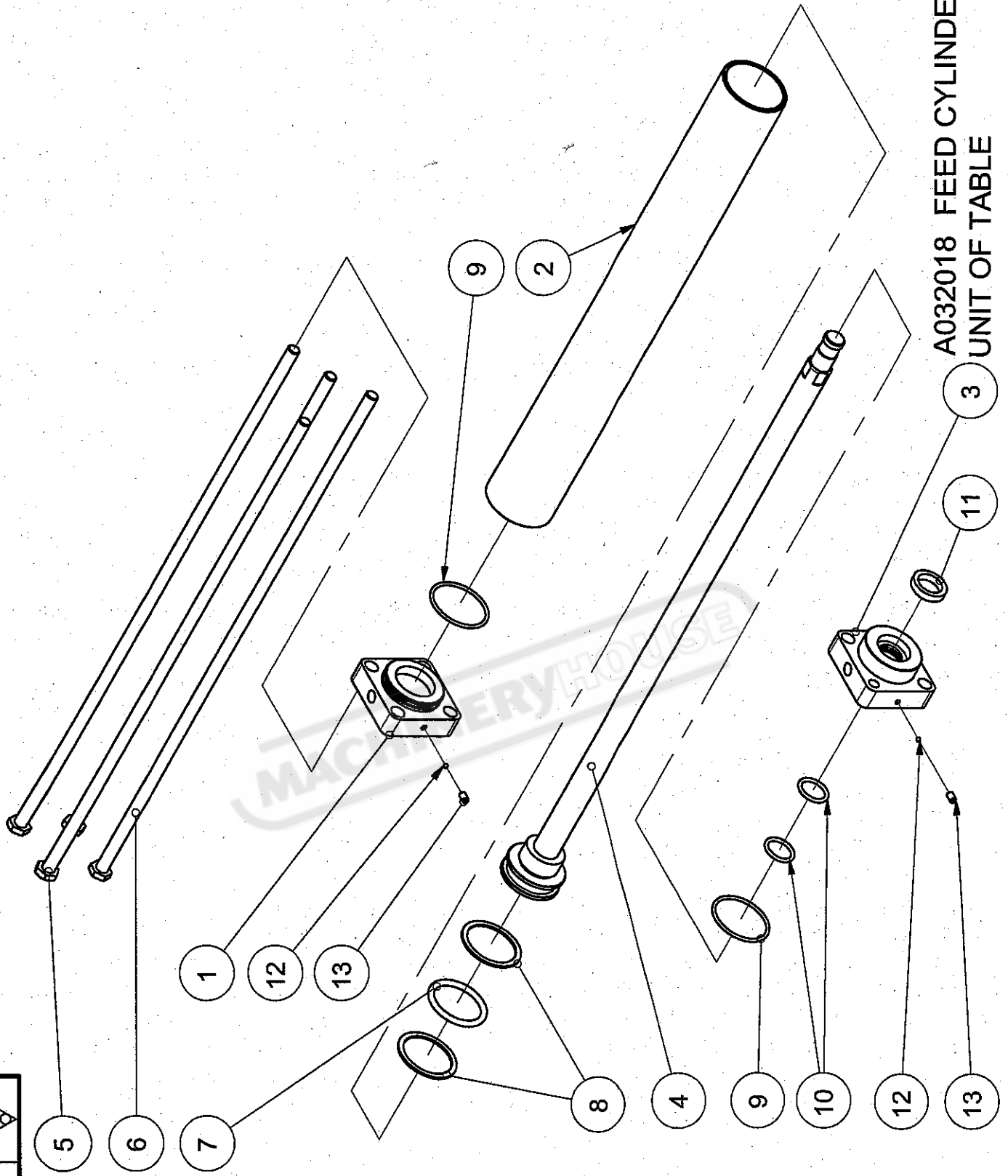


A032017 LIFTING CYLINDER UNIT

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	B02061300	UPPER COVER				
2	1	H02260100	CYLINDER				
3	1	B02061100	UNDER COVER				
4	1	H02260300	PISTON				
5	4	H02260200	LONG SCREW				
6	2	G95	O RING				
7	2	TP90	BACKING UP RING				
8	1	P90	O RING				
9	1	2DU4012	LUBRICATING BEARING				
10	1	4TC40-58-8	TC OIL SEAL				
11	2	P40	O RING				
12	1	MWR100	WEARING RING				
13	4	M12	SPRING WASHER				
14							
15							
16							
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23							
24							
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A032017 LIFTING CYLINDER UNIT

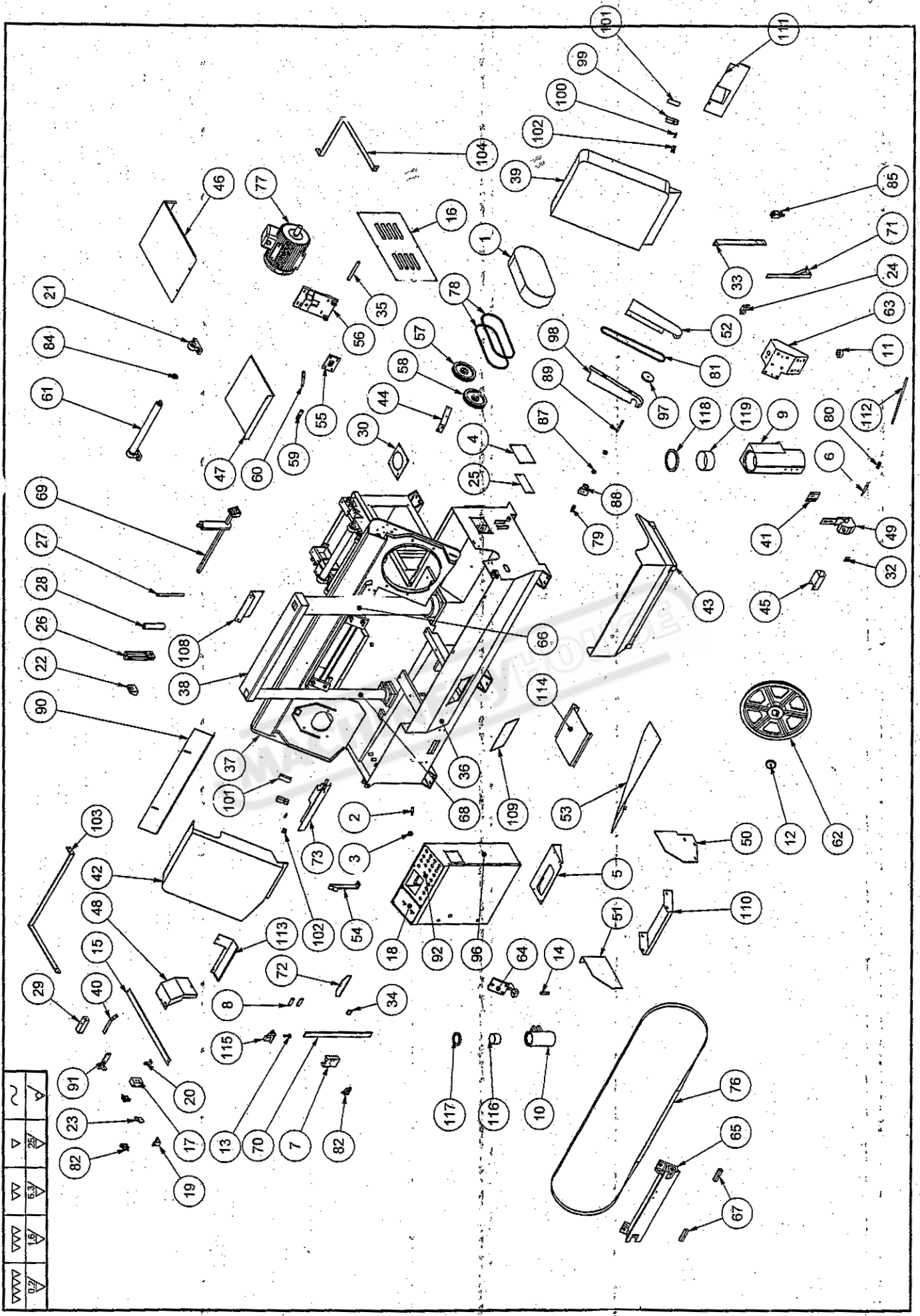
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A032018 FEED CYLINDER  
UNIT OF TABLE

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	H03262100	BACK COVER				
2	1	H03262400	CYLINDER				
3	1	H03262200	FRONT COVER				
4	1	H03262300	PISTON				
5	2	H03261400	LONG SCREW				
6	2	H03262500	LONG SCREW				
7	1	P50A	O RING				
8	2	TP50A	BACKING UP RING				
9	2	G55	O RING				
10	2	P25	O RING				
11	1	D35-d25-B7	OIL SEAL				
12	2	φ 4mm	STEEL BALL				
13	2	M6 x 10L	SOCKET SET SCREW				
14							
15							
16							
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A032018 FEED CYLINDER UNIT OF TABLE



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∇	∇	∇	∇

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NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	1	A032005	COVER	26	2	B02132200	OUT COVER
2	4	B01040200	ADJUSTING SCREW	27	2	B02141100	SHAFT
3	4	B01040300	FIXING SCREW	28	2	B02132500	VERTICAL ROLLER
4	2	B02011000	PLATE	29	1	B02162100	JOINT
5	1	B02012600	BASE	30	1	H03213400	WATER TANK COVER
6	1	B02023200	SHAFT	31	1	B02163800	NET
7	1	B02041700	BASE	32	1	H02213600	PLATE
8	2	B02042100	DU PLATE	33	1	H02214600	SWITCH BASE
9	1	B02043000	SLIDING TUBE	34	1	H02215700	BLOCK
10	1	B02043100	SECONDARY SLIDING TUBE	35	1	H03221000	SHAFT
11	1	B02043200	ADJUSTING SCREW	36	1	H03210100	BASE
12	1	B02043300	WASHER	37	1	H03210200	SAW BOW
13	1	B02043900	ADJUSTING SCREW	38	1	H03210400	CONNECTING ROD
14	1	B02044300	PIN	39	1	H03210500	COVER (DRIVING WHEEL)
15	1	B02110300	PROTECTOR	40	1	H03210600	PLATE
16	2	B02110400	PLATE	41	1	H03210700	BASE
17	1	B02111300	SWITCH BASE	42	1	H03210800	COVER (DRIVED WHEEL)
18	1	B02112301	ELECTRICAL CABINET	43	1	H03211000	PLATE
19	1	B02112800	PLATE	44	1	H03211100	PLATE
20	1	B02113100	BRACKET	45	1	H03211300	PROTECTOR
21	6	B02132400	ROLLER BASE	46	1	H03211500	PLATE
22	2	B02140800	BASE	47	1	H03211600	PLATE
23	1	B02114000	SWITCH BASE	48	1	H03211700	PROTECTOR
24	1	B02013900	SWITCH BASE	49	1	H03211900	COVER
25	1	B02015600	PLATE	50	1	H03212000	PLATE

A032023 METAL STRUCTURE

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
51	1	H03212100	WISE	76	1	5450x41x1.3	SAW BLADE
52	1	H03212300	COVER	77	1	7.5hp-132s	MOTOR
53	1	H03212700	PLATE	78	2	3Vx500	BELT
54	1	H03213200	PLATE	79	4	5UJ-NJ12	CROSS COUPLING
55	1	H03220100	BASE	80	2	5UJ	CROSS COUPLING
56	1	H03220200	MOTOR STAND	81	1	3M510L	BELT
57	1	H03220300	BELT PULLEY	82	3	AZ7310-1	LIMIT SWITCH
58	1	H03220400	BELT PULLEY	84	6	6005	BALL BEARING
59	1	H03221400	PIN	85	1	WL CA2-Q-1	LIMIT SWITCH
60	1	H03221600	ADJUSTING SCREW	86	1	WL CA2-Q	LIMIT SWITCH
61	3	H03230900	FEED ROLLER	87	2	6201	BALL BEARING
62	1	H03240100	DRIVING WHEEL	88	1	H03221800	BASE
63	1	H03240300	CONNECTING BASE	89	1	B02022200	SHAFT
64	1	H03240400	ADJUSTING BASER	90	1	H03213300	PROTECTOR
65	1	H03240500	GUIDE WAY	91	1	H03212900	PLATE
66	1	H03240800	VERTICAL MAIN COLUMN	92	1	B02112300-1	PLATE
67	2	H03240900	BLOCK	93	1	B02112300-2	ELECTRICAL CABINET
68	1	H03241000	ADJUTANT COLUMN	94	1	B02112300-3	ELECTRICAL CABINET
69	1	H03241100	ADJUSTING ROD	95	1	N022	NC CONTROL PANEL
70	1	H03241500	FAST DOWN ROD	96	1	N022-NC	NC CONTROL PANEL
71	1	H03212200	PLATE	97	1	H03221700	BELT PULLEY
72	1	H03242000	PLATE	98	1	H03212400	COVER
73	1	H03211400	PROTECTOR	99	2	E100-01-S51	SWITCH
74	1	H03211400-1	PROTECTOR	100	2	E100-01-S51	PIN
75	1	H03212500	PLATE	101	2	H03213800	SWITCH BASE

A032023 METAL STRUCTURE



NO	QTY	TYPE	DESCRIPTION	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
102	2	H03213900	PLATE					
103	1	H03214100	GUARD RAIL ( LEFT )					
104	1	H03214200	GUARD RAIL ( RIGHT )					
105	1	H03214600	PLATE					
106	1	50239	PRESSURE REGULATOR					
107	1	H03214500	PLATE					
109	1	H03213500	PLATE					
110	1	H03211800	PLATE					
111	1	H03214900	COVER					
112	1	H03230400	SHAFT					
113	1	H02311900	PLATE					
114	1	H03215100	PLATE					
115	1	B02042200	POSITION BLOCK					
116	2	2DU8060	LUBRICATING BEARING					
117	2	4TC80-105-13	OIL SEAL					
118	2	4TC150-180-14	OIL SEAL					
119	2	2DU15080	LUBRICATING BEARING					

**A032023 METAL STRUCTURE**



# WARNING

## General Machinery Safety Instructions

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Machinery House  
requires you to read this entire Manual before using this machine.

- 1. Read the entire Manual before starting machinery.** Machinery may cause serious injury if not correctly used.
- 2. Always use correct hearing protection when operating machinery.** Machinery noise may cause permanent hearing damage.
- 3. Machinery must never be used when tired, or under the influence of drugs or alcohol.** When running machinery you must be alert at all times.
- 4. Wear correct Clothing.** At all times remove all loose clothing, necklaces, rings, jewelry, etc. Long hair must be contained in a hair net. Non-slip protective footwear must be worn.
- 5. Always wear correct respirators around fumes or dust when operating machinery.** Machinery fumes & dust can cause serious respiratory illness. Dust extractors must be used where applicable.
- 6. Always wear correct safety glasses.** When machining you must use the correct eye protection to prevent injuring your eyes.
- 7. Keep work clean and make sure you have good lighting.** Cluttered and dark shadows may cause accidents.
- 8. Personnel must be properly trained or well supervised when operating machinery.** Make sure you have clear and safe understanding of the machine you are operating.
- 9. Keep children and visitors away.** Make sure children and visitors are at a safe distance for you work area.
- 10. Keep your workshop childproof.** Use padlocks, Turn off master power switches and remove start switch keys.
- 11. Never leave machine unattended.** Turn power off and wait till machine has come to a complete stop before leaving the machine unattended.
- 12. Make a safe working environment.** Do not use machine in a damp, wet area, or where flammable or noxious fumes may exist.
- 13. Disconnect main power before service machine.** Make sure power switch is in the off position before re-connecting.
- 14. Use correct amperage extension cords.** Undersized extension cords overheat and lose power. Replace extension cords if they become damaged.
- 15. Keep machine well maintained.** Keep blades sharp and clean for best and safest performance. Follow instructions when lubricating and changing accessories.
- 16. Keep machine well guarded.** Make sure guards on machine are in place and are all working correctly.
- 17. Do not overreach.** Keep proper footing and balance at all times.
- 18. Secure workpiece.** Use clamps or a vice to hold the workpiece where practical. Keeping the workpiece secure will free up your hand to operate the machine and will protect hand from injury.
- 19. Check machine over before operating.** Check machine for damaged parts, loose bolts, Keys and wrenches left on machine and any other conditions that may effect the machines operation. Repair and replace damaged parts.
- 20. Use recommended accessories.** Refer to instruction manual or ask correct service officer when using accessories. The use of improper accessories may cause the risk of injury.
- 21. Do not force machinery.** Work at the speed and capacity at which the machine or accessory was designed.
- 22. Use correct lifting practice.** Always use the correct lifting methods when using machinery. Incorrect lifting methods can cause serious injury.
- 23. Lock mobile bases.** Make sure any mobile bases are locked before using machine.
- 24. Allergic reactions.** Certain metal shavings and cutting fluids may cause an allergic reaction in people and animals, especially when cutting as the fumes can be inhaled. Make sure you know what type of metal and cutting fluid you will be exposed to and how to avoid contamination.
- 25. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.



## Metal Cutting Bandsaw Safety Instructions

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Machinery House  
requires you to read this entire Manual before using this machine.

- 1. Maintenance.** Make sure the bandsaw is turned off and disconnect from the main power supply and make sure all moving parts have come to a complete stop before any inspection, adjustment or maintenance is carried out.
- 2. Bandsaw Condition.** Bandsaw must be maintained for a proper working condition. Never operate a bandsaw that has damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis.
- 3. Blade Condition.** Never operate a bandsaw with a dull, cracked or badly worn blade. Before using a bandsaw inspect blades for missing teeth and cracks.
- 4. Replacing Blade.** Make sure teeth are facing the correct direction. Wear gloves to protect hands and wear safety glasses to protect your eyes.
- 5. Hand Hazard.** Keep hands and fingers clear from the line of cut of the blade and offcuts workpieces. Hands can be crushed in vice or from falling machine components and cut by the blade.
- 6. Leaving a bandsaw Unattended.** Always turn the bandsaw off and make sure all moving parts have come to a complete stop before leaving the bandsaw. Do not leave bandsaw running unattended for any reason.
- 7. Avoiding Entanglement.** Blade guard must be used at all times. Remove loose clothing, belts, or jewelry items. Never wear gloves while machine is in operation. Tie up long hair and use the correct hair nets to avoid any entanglement with the bandsaw moving parts.
- 8. Understand the machines controls.** Make sure you understand the use and operation of all controls.
- 9. Power outage.** In the event of a power failure during use of the bandsaw, turn off all switches to avoid possible sudden start up once power is restored.
- 10. Work area hazards.** Keep the area around the bandsaw clean from oil, tools, chips. Pay attention to other persons in the area and know what is going on around the area to ensure unintended accidents.
- 11. Workpiece Handling.** Workpieces must be supported with table, vice, roller conveyor/stands, or other support fixtures. Unsupported workpieces may cause the machine to tip over and fall. Flag long pieces of material to avoid tripping hazards. Never hold a workpiece with your hands during the cut process.
- 12. Hearing protection and hazards.** Always wear hearing protection as noise generated from bandsaw blade and workpiece vibration, material handling, and power transmission can cause permanent hearing loss over time.
- 13. Hot surfaces.** Workpieces, machine surfaces and chips become hot due to friction and can burn you.
- 14. Starting position.** Never turn the bandsaw on when the blade is resting on the workpiece.
- 15. Guards.** Do not operate bandsaw without the blade guard in place or with the doors open.
- 16. Call for help.** If at any time you experience difficulties, stop the machine and call your nearest branch service department for help.

# PLANT SAFETY PROGRAM

## NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

### Metal Cutting Bandsaw

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures  
This program is based upon the Australian Worksafe Standard for Plant(NOHSC.:1010-1994)

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies <small>(Recommended for Purchase / Buyer / User)</small>
A	ENTANGLEMENT	HIGH	Eliminate, avoid loose clothing / Long hair etc.
B	CRUSHING	LOW	Secure & support Long / heavy material
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Blade guards should always be in the closed position before starting machine. Blade guide system should be adjusted to suit material width. Wear gloves when changing blades. Isolate main power switch before changing blade, cleaning or adjusting. If blade breaks do not open door until both wheels have stopped. Check blade tracking before starting.
D	SHEARING	MEDIUM	Make sure all guards are secured shut when machine is on. Isolate power to machine prior to changing belts or maintenance.
F	STRIKING	LOW	Support long heavy jobs and stand clear of offcuts. Stand clear of machine when in operation. Remove all loose objects around moving parts. Wear safety glasses
H	ELECTRICAL	MEDIUM	All electrical enclosures should only be opened with a tool that is not to be kept with the machine. Machine should be installed & checked by a Licensed Electrician.
O	OTHER HAZARDS, NOISE.	LOW	Wear hearing protection as required.
Plant Safety Program to be read in conjunction with manufactures instructions			



[www.machineryhouse.com.au](http://www.machineryhouse.com.au)

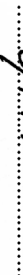


[www.machineryhouse.co.nz](http://www.machineryhouse.co.nz)

Authorised and signed by:  
Safety officer:



Manager:



Revised Date: Aug-08