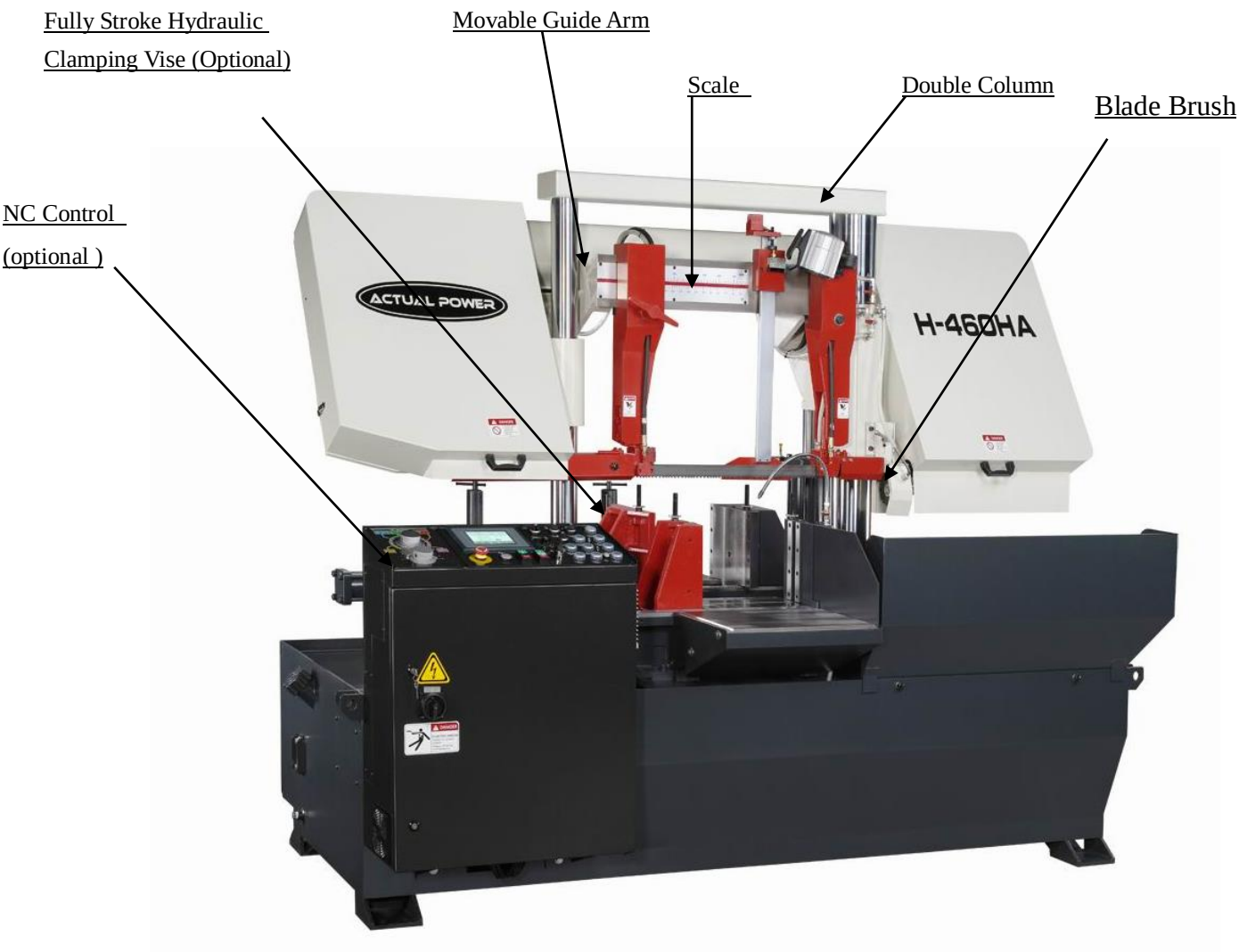
ACTUAL POWER

OPERATION MANUAL

H-460HA (Full Stroke with NC)

I : CHARACTERISTIC & SPECIFICATION

1. MODEL: H-460HA



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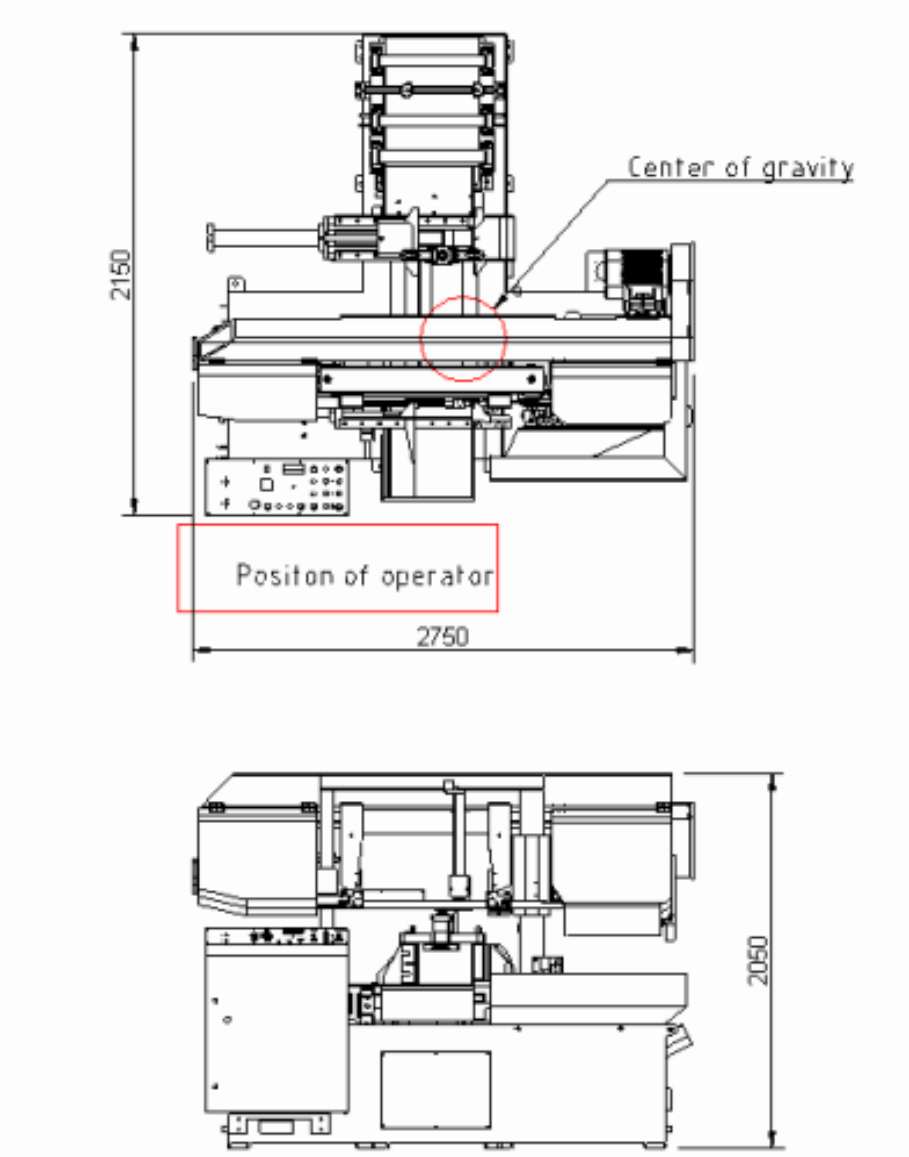
2. SPECIFICATION:

MODEL NO.		**H-460HA**
CAPACITY		○ 460mm
		□ 460x460mm
BUNDLE CUTTING		200x130 ~ 350x240mm (WxH)
BLADE TENSION		HYDRAULIC
BLADE SIZE		L5450xW41xT1.3mm
MOTOR	BLADE	5.5W 7.5HP
	HYDRAULIC	1.5KW 2HP
	COOLANT	0.2KW 1/4HP
TABLE HEIGHT		800mm
MACHINE WEIGHT (N.W.)		3200kgs
HYDRAULIC OIL CAPACITY		90L
CUTTING OIL CAPACITY		110L
MATERILA LENGTH OF SINGLE FEED		500mm x 9
FLOOR SPACE		2800 x 2200mm

II : MACHINE INSTALLATION

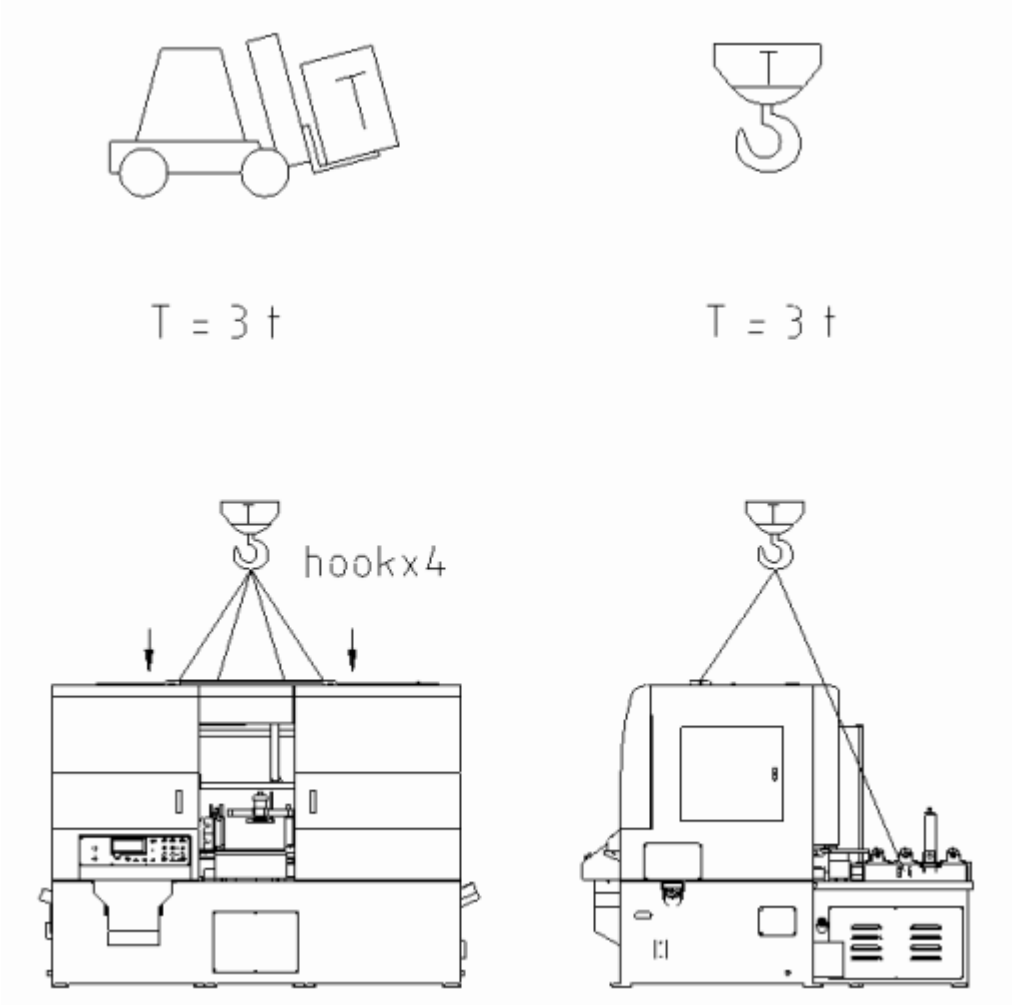
1. Machine Installation

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)



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.

III : OPERATION METHOD

1. The Description Of Operation Panel

MODEL: H-460HA

(1) <u>Emergency Stop Button</u>

Press the button to stop all of the machine function.

(picture 1)

(picture 1)

(2) <u>Power Light</u>

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) <u>Hydraulic Button</u>

Press this button to start the hydraulic motor.

(picture 3)

(picture 3)

(4) <u>Blade Start Button</u>

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) <u>The Button For Material Zero Point Search Of Automatic Feed</u>

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. (**<u>the material original cutting point</u>**)
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) <u>The Switch For Choosing Cooling Water</u>

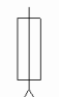
* Turn to the position of ☼
to start the coolant pump and make the cooling water flow. The switch could be turned on independently without the start of blade motor.

(picture 6)

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

(7) <u>The Adjusting Switch For Hydraulic Carbide Fixture</u>

* 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)

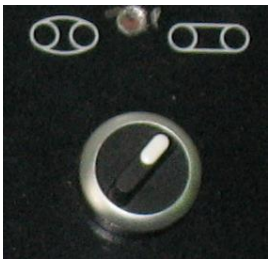
(8) <u>The Switch For Work Light</u>

For work light use only.

(picture 8)

(9) <u>The Adjusting Switch For Blade Tension</u>

* 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) <u>The Switch For Blade Cutting Speed</u>

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

(Picture 10)

(11) <u>The Switch For Circulation And Manual Mode Changeover</u>

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

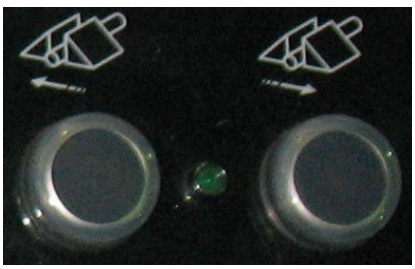
* Turn the position to 
For manual operation.

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

(12) <u>The Adjusting Button For Movable Clamp Of Feeding Table</u>

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)



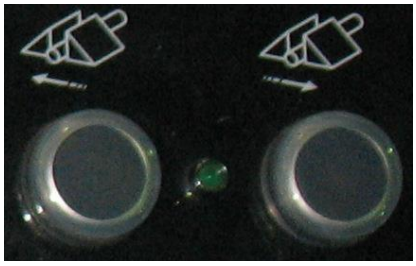
If the guide wheel base is not higher 20mm than
the movable clamp, the moving measure of the clamp (picture 12)
will be 1 inch for one step.

(13) <u>The Adjusting Button For Movable Clamp Of Feeding Table</u>

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.



(picture 13)

Press this button 

The work piece will be loosen.

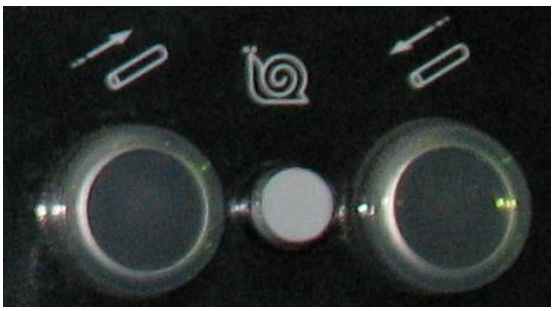
(picture 13)

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.

(14) <u>The Button For The Movement Of Feed Table</u>

Press this button 

To make the feed table move ahead.



Press this button 

To make the feed table move slowly to the requirement.

(picture 14)

Press this button 

To make the feed table move back.

(picture 14)

(15) <u>The Button For Saw Frame UP And Down</u>

Press this button  to make the saw frame UP

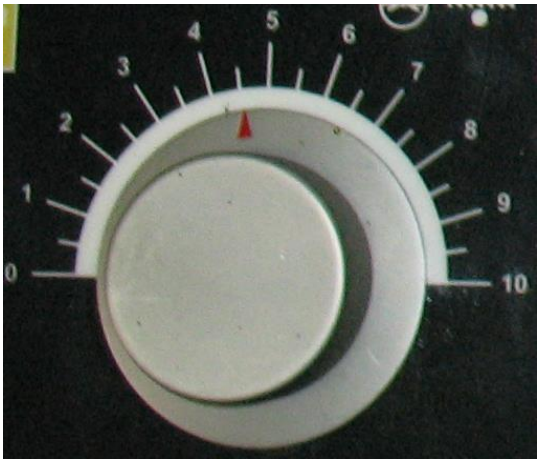
Press this button  to make the saw frame DOWN

(picture 15)

(picture 15)

(16) <u>The Switch Of Hydraulic Oil Control Valve</u>

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



picture 16)

(17) <u>The Switch Of Pressure Control</u>
<u>For Blade Cutting</u>

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)

2. MACHINE PARTS DESCRIPTION

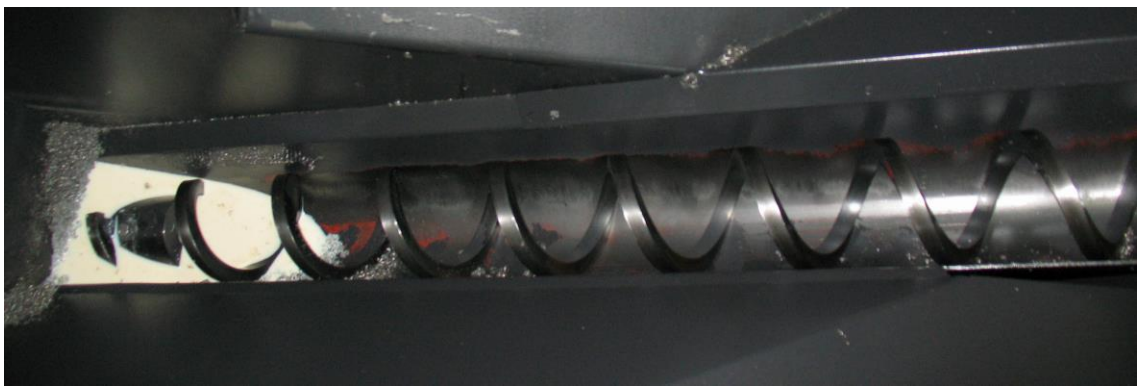
(1) Motor

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

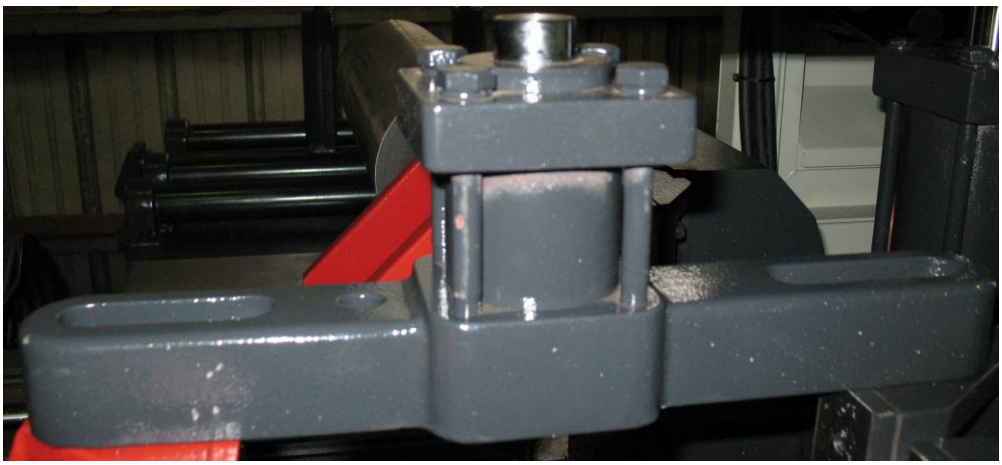
Power Source: hydraulic motor
Banish the iron chipping from the machine.



(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)

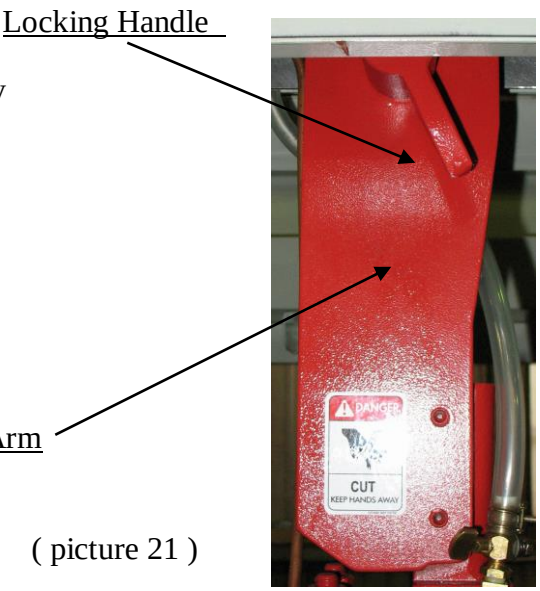


(picture 20)

(4) The Adjustment Of Movable Guide Arm

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

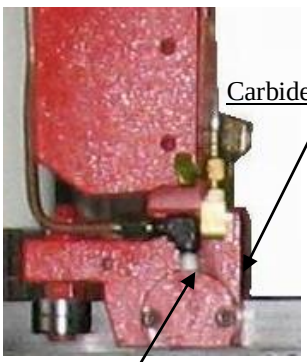
Step 1: loose carbide fixture
Step 2: loose locking handle
Step 3: move the guide arm to the work piece
Step 4: lock the handle
(picture 21)



(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)



(picture 22)

(6) Switch of Safety Guard(For CE)

When the wheel cover be opened, the blade cutting will be stopped automatically.

(picture 23)

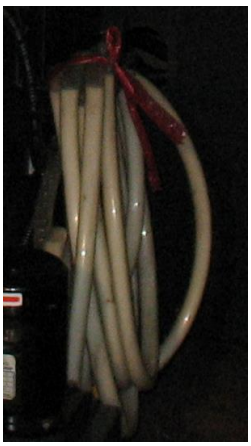
(7) <u>Micro Clamp Device Of Table</u>

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

(picture 24)

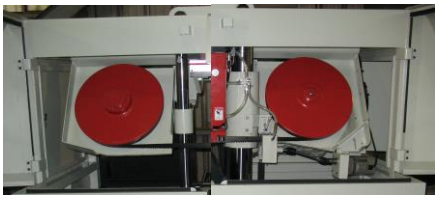
(8) <u>Washing Gun</u>

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



(picture 25)

2. THE INSTALLATION OF SAW BLADE



(picture 26) (picture 27)

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 26 and 27 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 drived 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  (picture7 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:

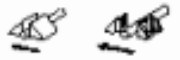
(a.) Start the hydraulic pump  , and choose the mode of manual 

(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  until the lamp was lighted on when the material was clipped tight.

(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.

IV : 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.

3. 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.32

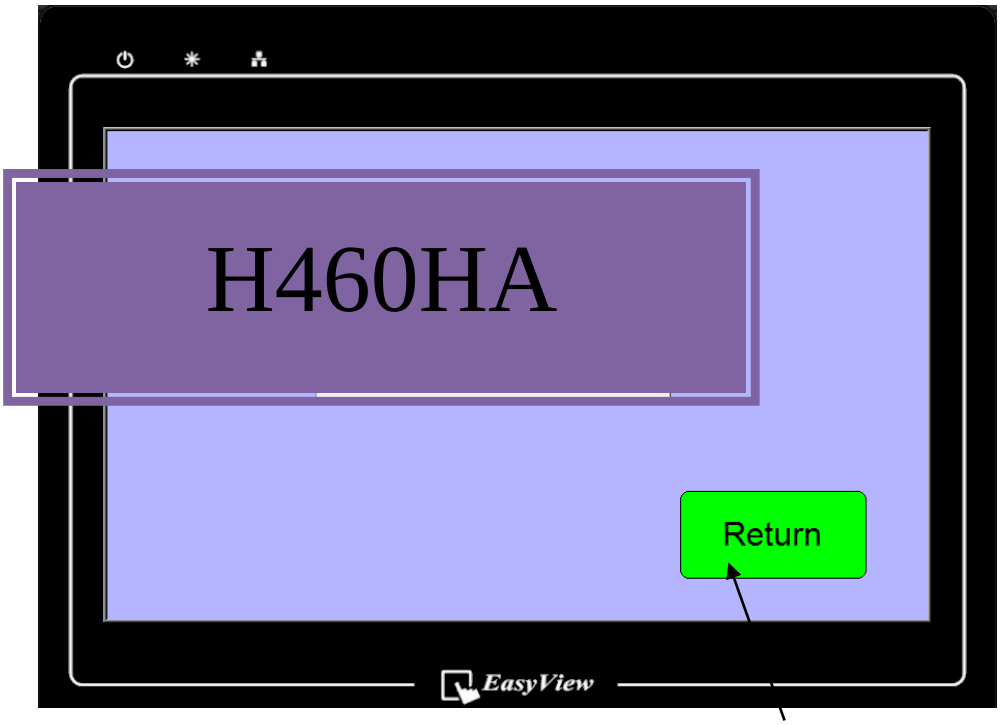
[illegible]
[illegible]
[illegible]

V : SAFE MATTERS

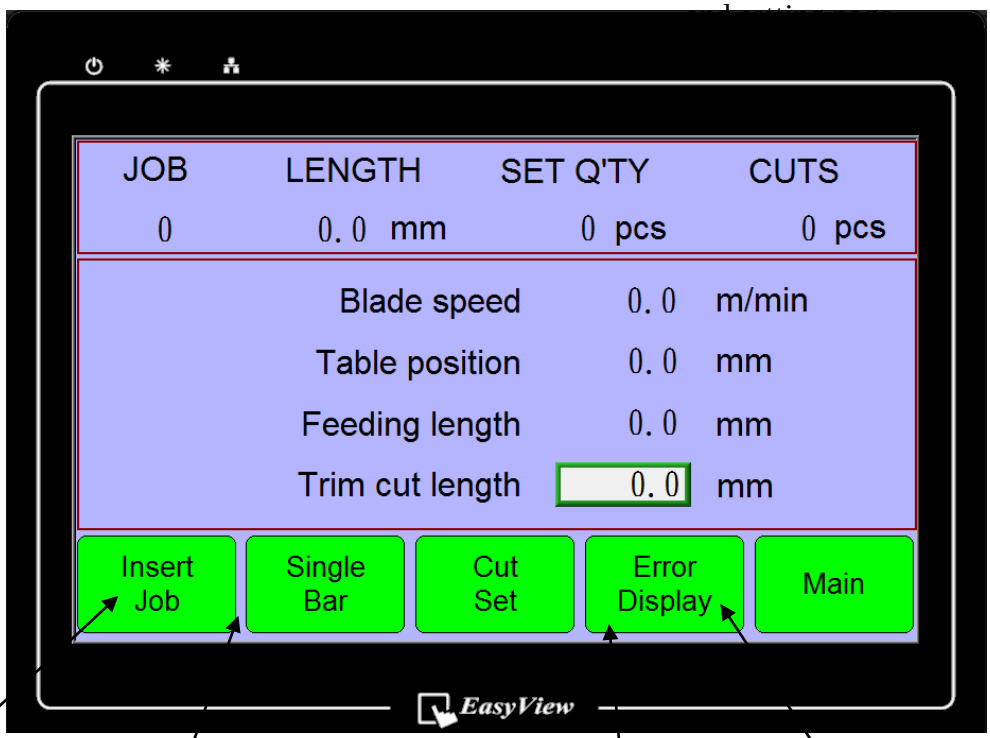
1. Please don’t approach the machine inside when the saw blade is on working.
2. Any maintenance will be forbidden during the machine operation.
3. Please offer the proper material measurement for machine cutting.
4. During the machine operation, please don’t play pranks around.
5. Please don’t smoke 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.

V I: NC CONTROL PANEL DESCRIPTON



Return to the operating

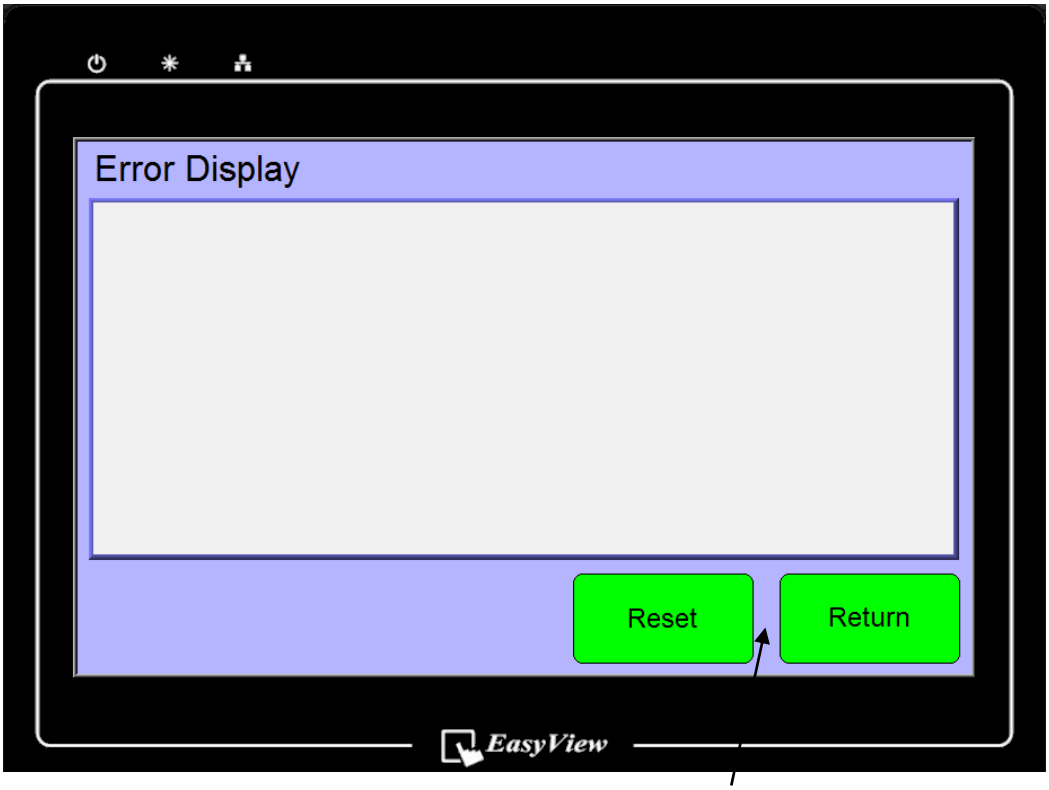


Setting of inserted job

Bundle or single cutting setting

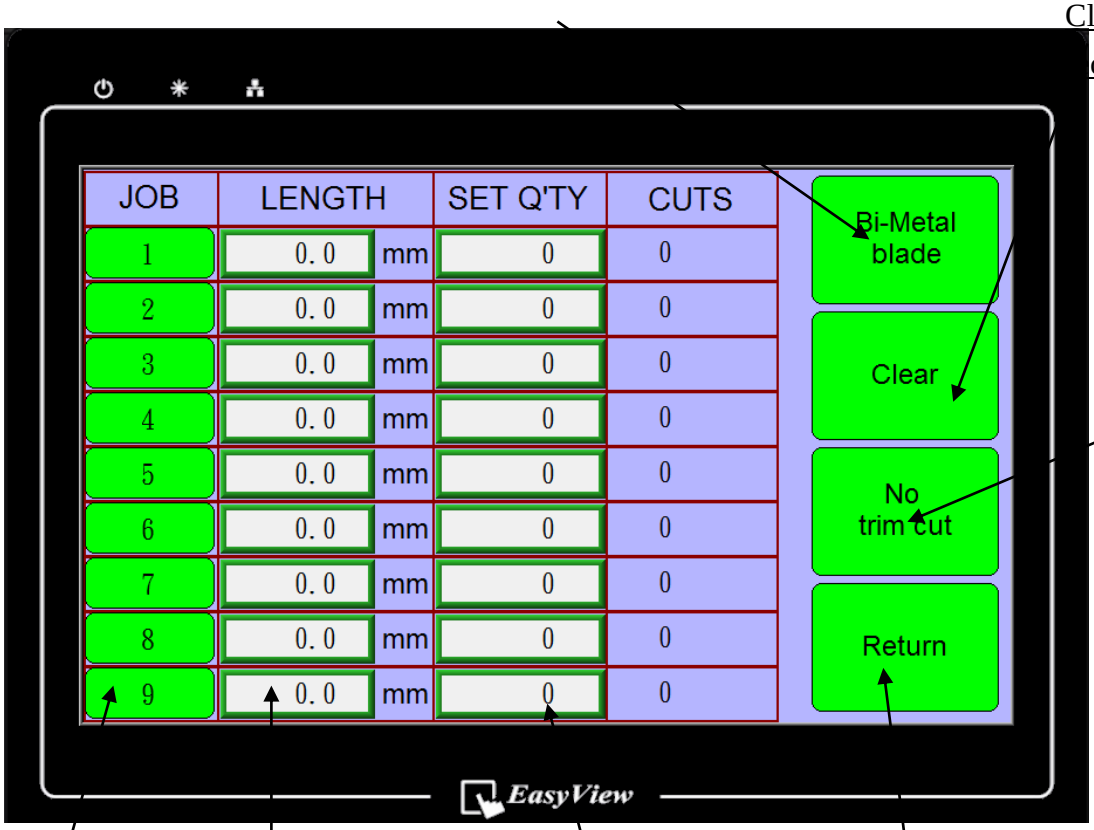
Error Display

Return to the first page



Return to the operating and setting page

Clear the finished cord



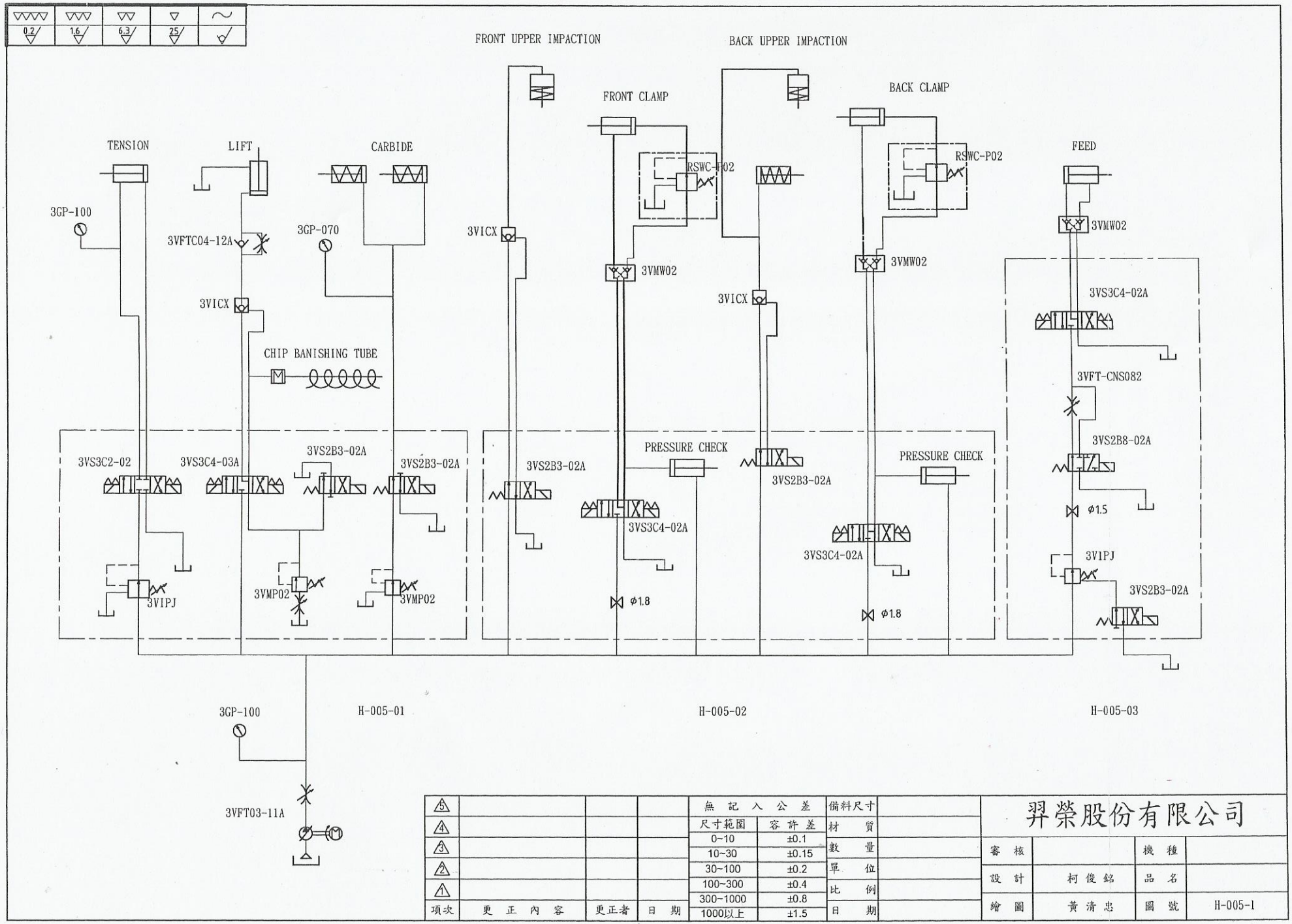
Trim setting

Job setting

Length setting

Quantity setting

Return to the operating and setting page



項次	更正內容	更正者	日期
5			
4			
3			
2			
1			

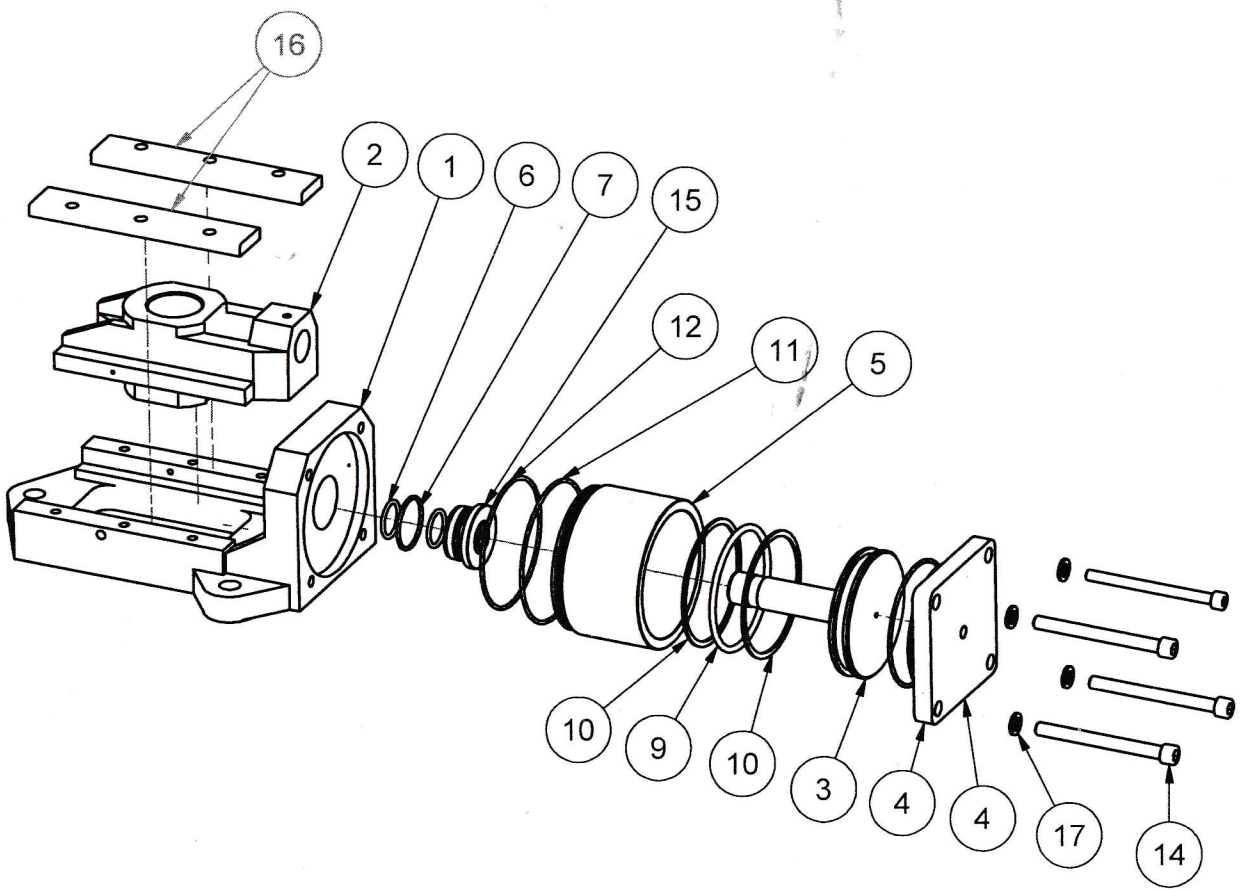
無記入公差	
尺寸範圍	容許差
0~10	±0.1
10~30	±0.15
30~100	±0.2
100~300	±0.4
300~1000	±0.8
1000以上	±1.5

備料尺寸	
材質	
數量	
單位	
比例	
日期	

羿榮股份有限公司

審核		機種	
設計	柯俊銘	品名	
繪圖	黃清忠	圖號	H-005-1

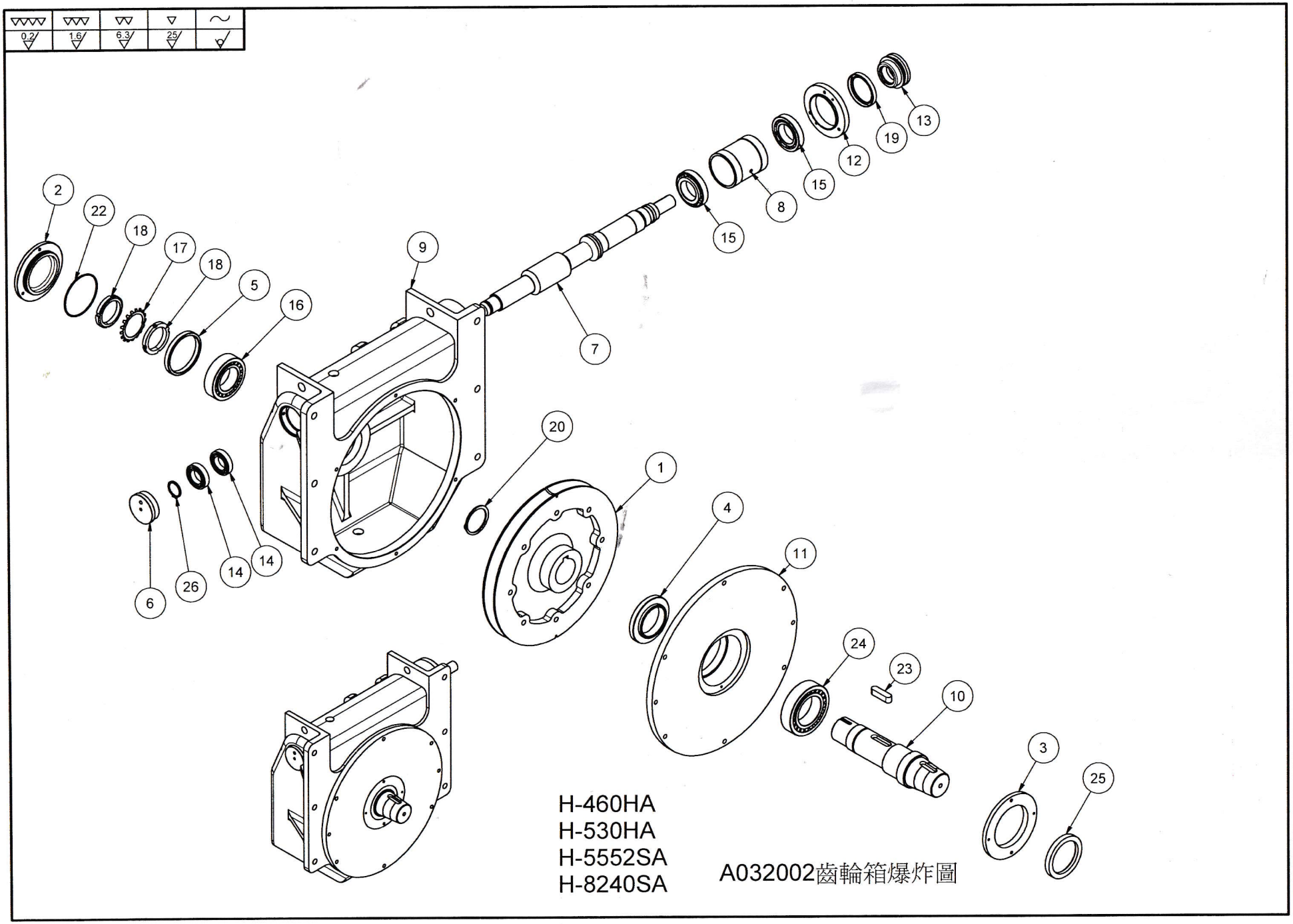
0.2	1.6	6.3	25	



A032001張力組

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	1	H03243600	SLIDE BASE				
2	1	H03243700	SLIDE BLOCK				
3	1	H03262600	PISTON				
4	1	H03262700	COVER				
5	1	H03262800	CYLINDER				
6	2	P30	O RING				
7	1	G45	O RING				
8	1	G115	O RING				
9	1	P110	O RING				
10	2	TP110	BACK UP RING				
11	1	G130	O RING				
12	1	G120	O RING				
13	1	M10x130	HEXAGON SOCKET HEAD SCREW				
14	3	M12x130	HEXAGON SOCKET HEAD SCREW				
15	1	B02060600	COPPER RING				
16	2	H03243800	PLATE				
17	4	M12	SPRING WASHER				
18							
19							
20							
21							
22							
23							
24							
25							

A032001 TENSION BASE UNIT


0.2
1.6
6.3
25
2
22
18
17
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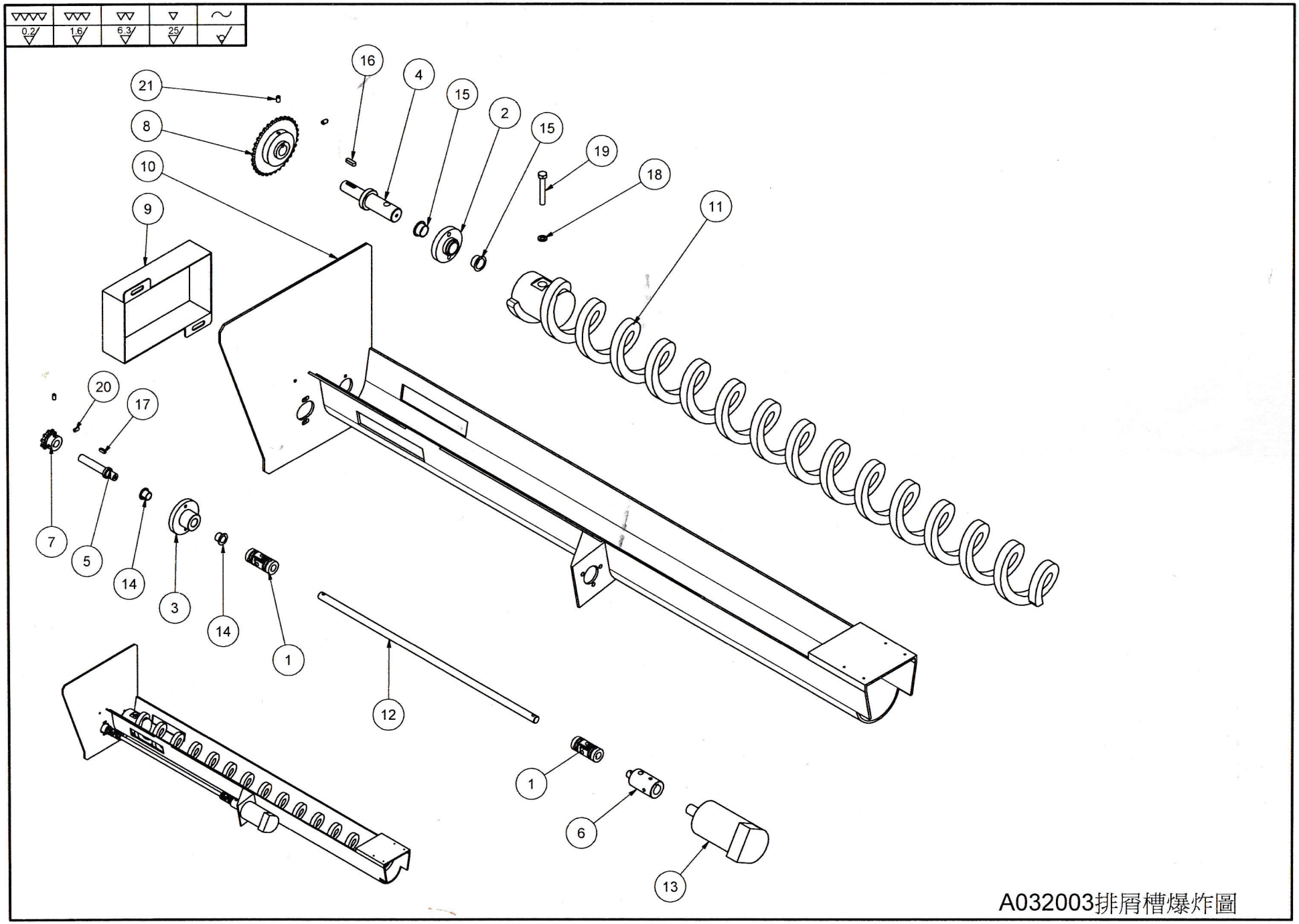
16
9
7
15
8
15
12
19
13
20
1
4
11
24
23
10
3
25
6
26
14
14
H-460HA
H-530HA
H-5552SA
H-8240SA
A032002齒輪箱爆炸圖

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	1	H03220600	WORM GEAR	26	1	35x1.6	C TYPE RETAINING RING
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				
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	-	-	-				
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				

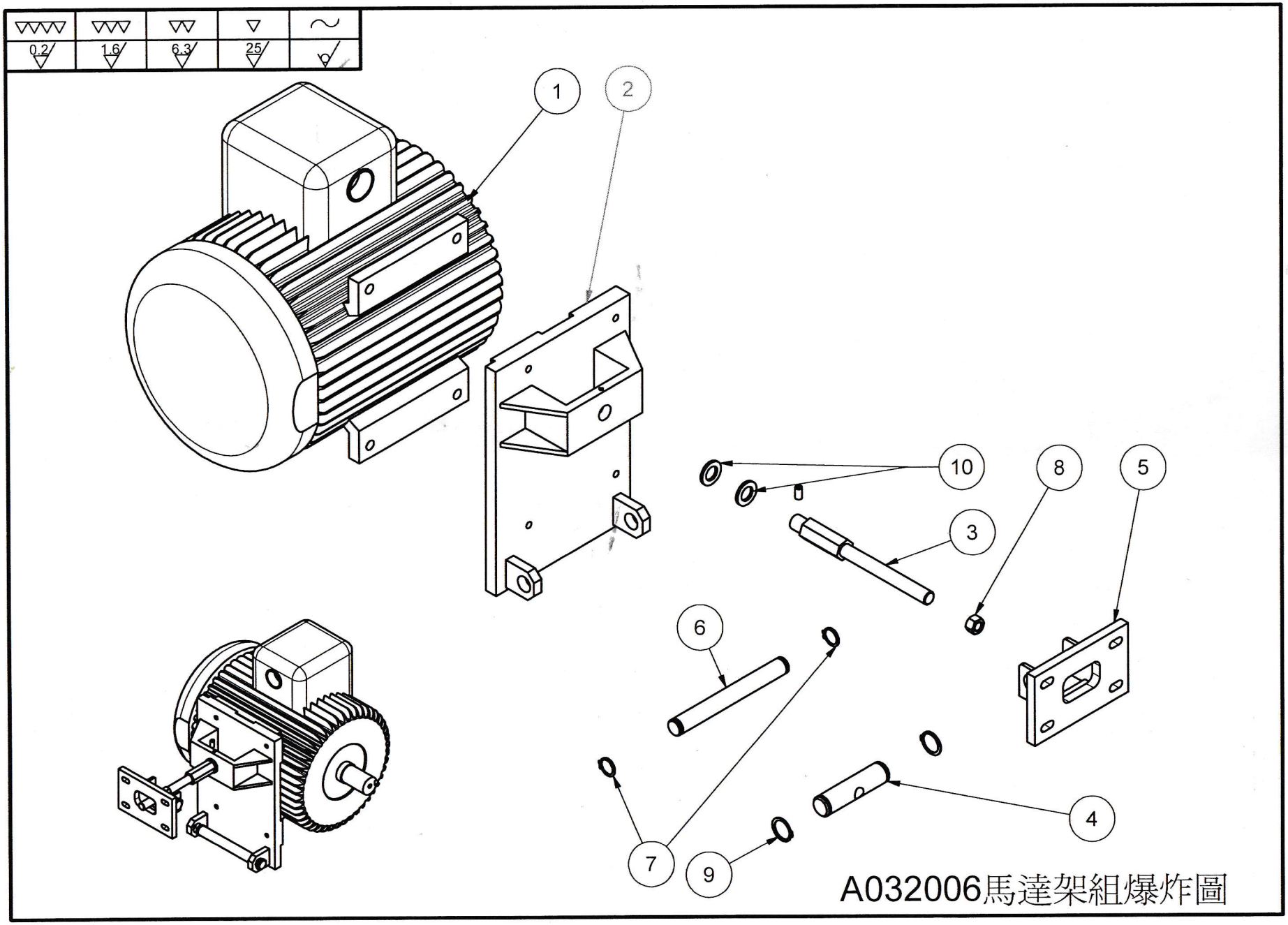
A032002 GEAR BOX UNIT



A032003排屑槽爆炸圖

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	2	5UJ-NJ12	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 DISCHAGE 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


0.2
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A032006馬達架組爆炸圖

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	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							
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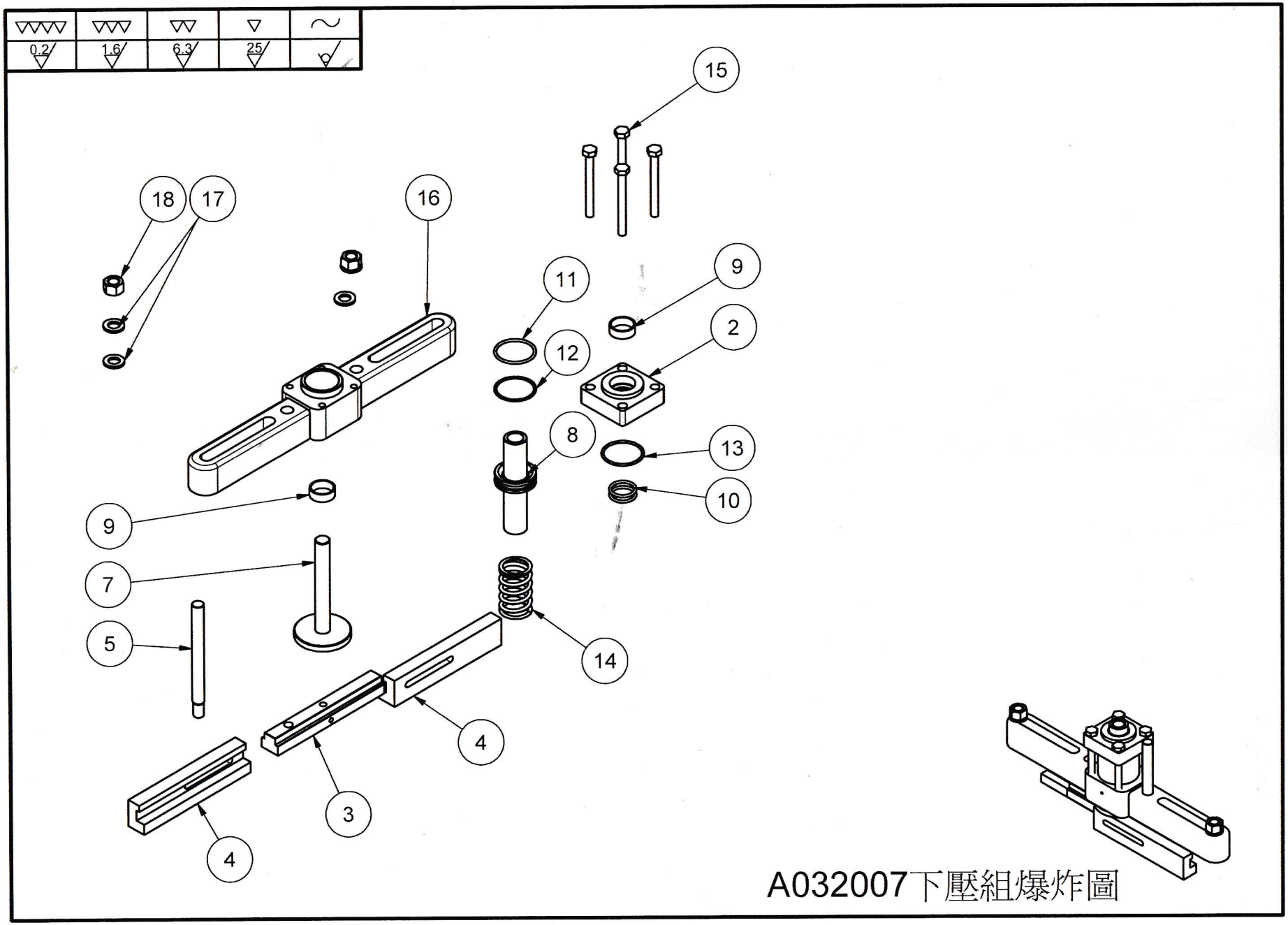
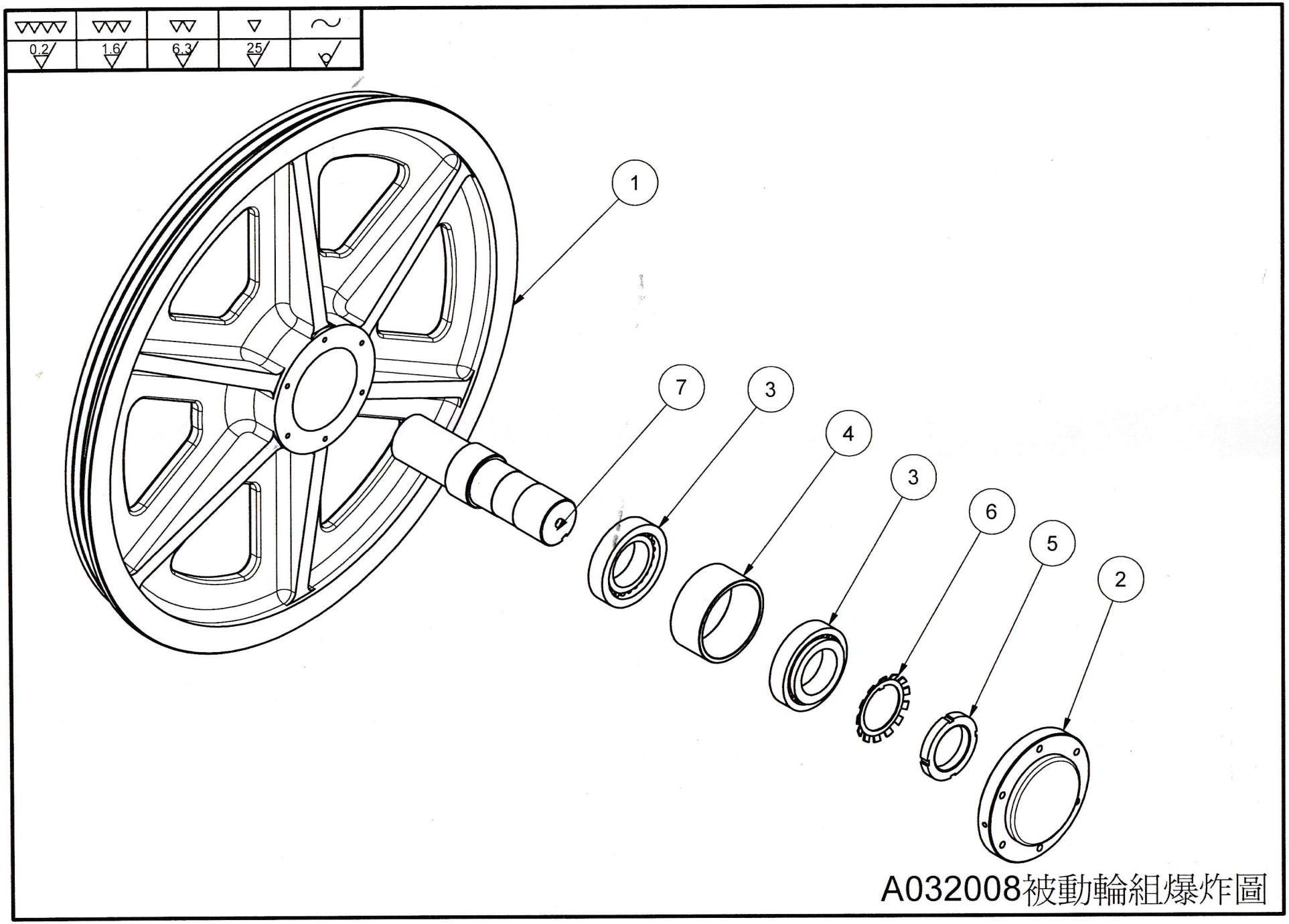
A032006 MOTOR STAND UNIT



A032007下壓組爆炸圖

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	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	-	-	-				
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被動輪組爆炸圖

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	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							
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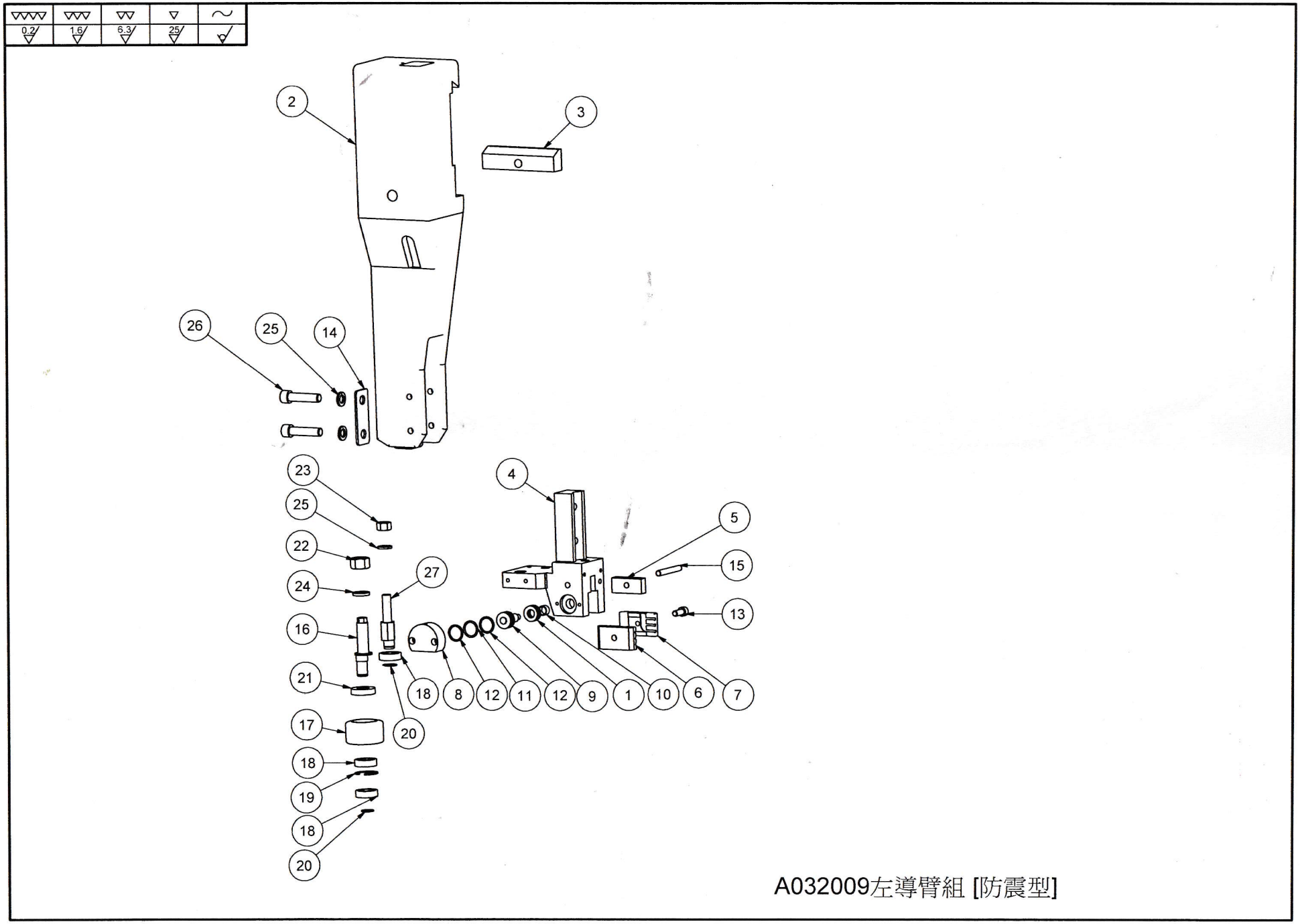
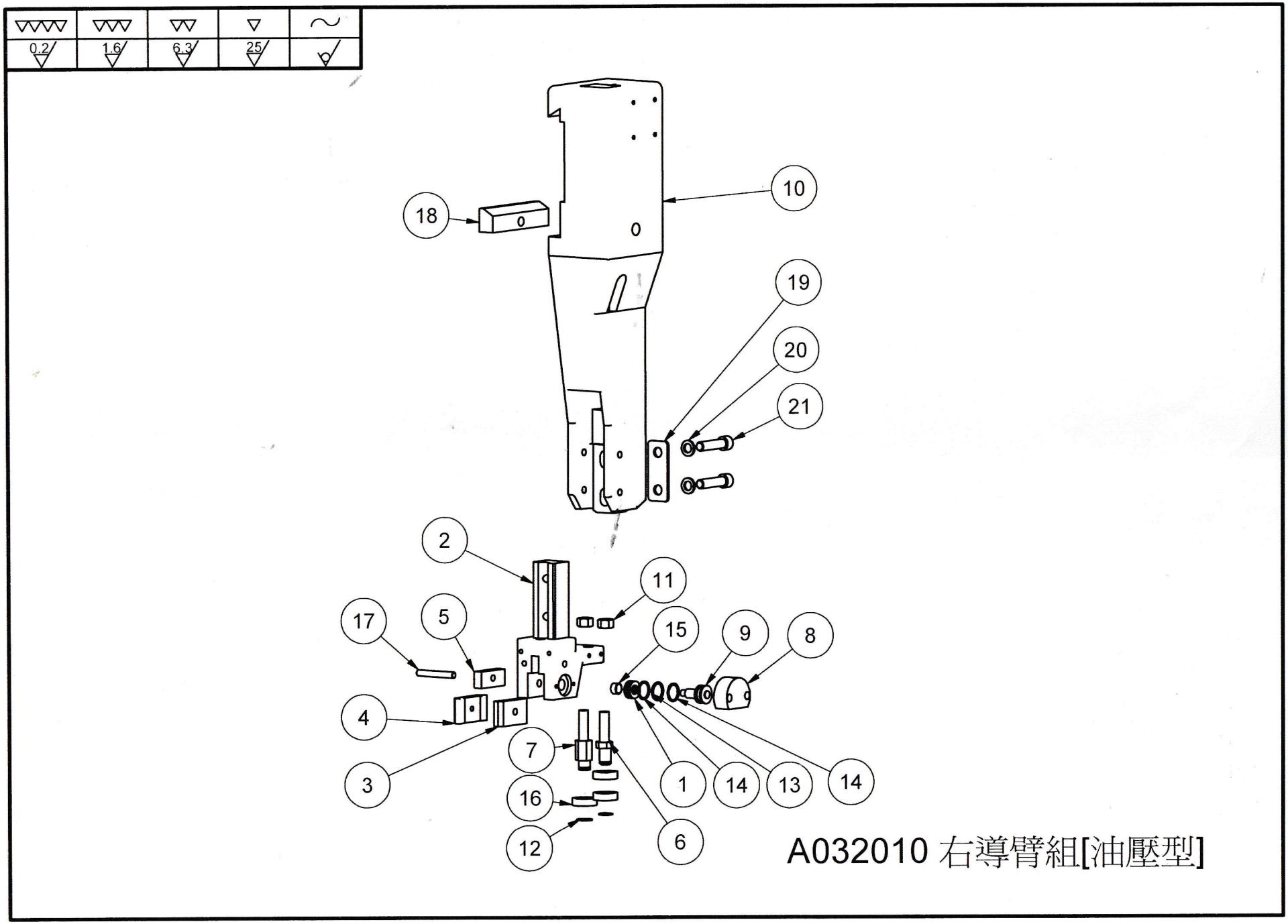
A032008 DRIVED PULLEY UNIT



A032009左導臂組 [防震型]

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	6	12.2x23x1	DISC SPRING	26	2	M12x50	HEX SOCKET SCREW
2	1	H03240600	LEFT GUIDE ARM	27	1	B02044200	LONG ECCENTRIC SHAFT
3	1	H03240900	FIXING PLATE				
4	1	H03242800	LEFT GUIDE WHEEL BASE				
5	1	B02041100	UPPER CARBIDE FIXTURE				
6	1	B02041301	LEFT FRONT CARBIDE FIXTURE				
7	1	B02041401	LEFT BACK CARBIDE FIXTURE				
8	1	B02062600	CYLINDER				
9	1	B02062700	PISTONE				
10	1	2DU1210	SELF LUBRICATING BEARING				
11	1	P20	O RING				
12	2	TP20	BACK UP RING				
13	1	M8x20	HEX SOCKET SCREW				
14	1	H03216200	GASKET				
15	1	8x60L	PING				
16	1	H03242200	SHAFT				
17	1	H03242300	VIBRATION DAMPER ROLLING				
18	3	6002	BEARING				
19	1	R32	C RING				
20	2	S15	CRING				
21	1	D35-d17-B8	OIL SEAL				
22	1	M16	SCREW NUT				
23	1	M12	SCREW NUT				
24	1	M12	SPRING WASHER				
25	3	M12	SPRING WASHER				

A032009 LEFT GUIDE ARM UNIT

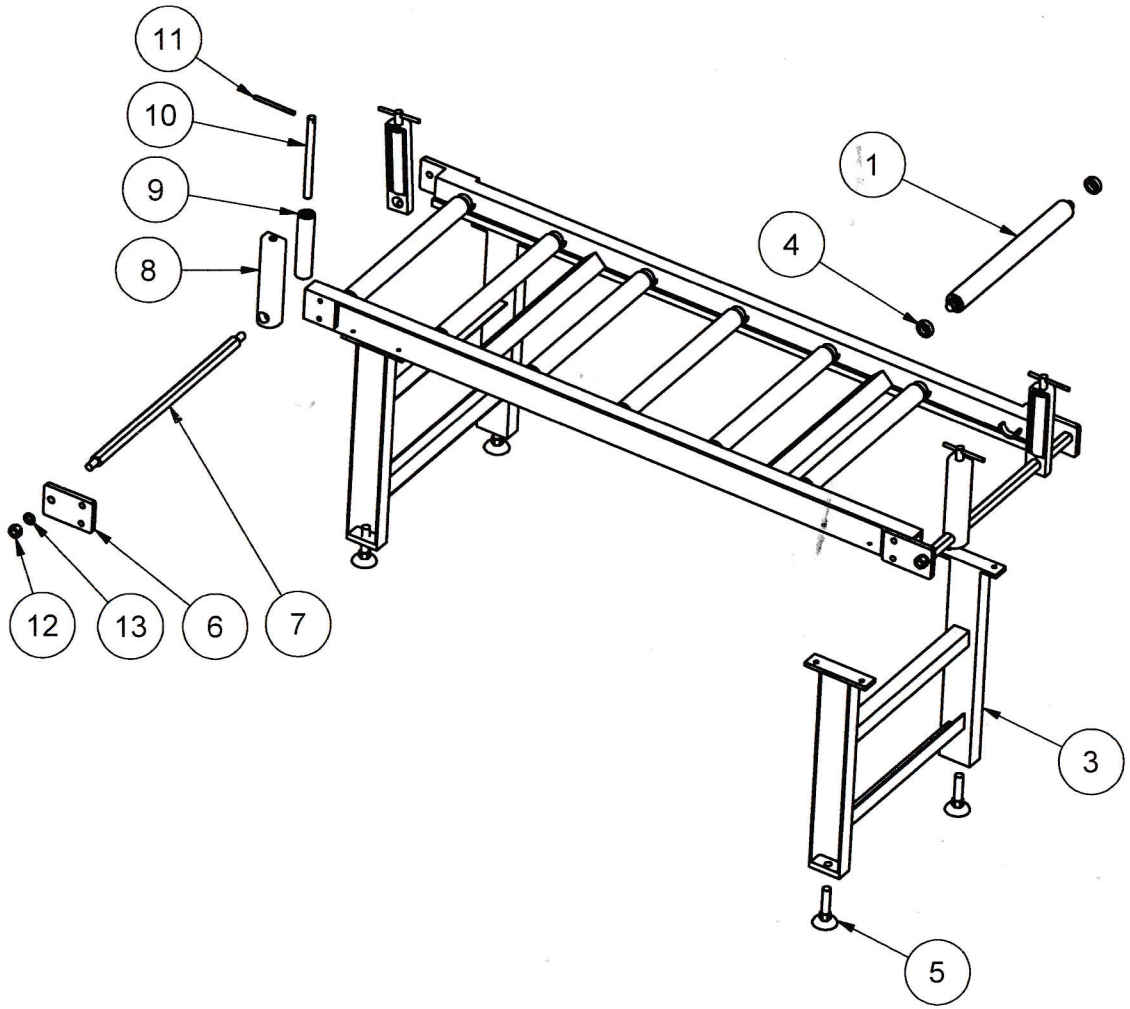


A032010 右導臂組[油壓型]

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	6	ϕ 12.2 x ϕ 23 x 1t	DISC SPRING				
2	1	B02043700	RIGHT GUIDE WHEEL BASE				
3	1	B02040901	RIGHT FRONT CARBIDE FIXTURE				
4	1	B02041001	RIGHT BACK CARBIDE FIXTURE				
5	1	B02041100	UPPER CARBIDE FIXTURE				
6	1	B02044100	LONG ECCENTRIC SHAFT				
7	1	B02044200	SHORT ECCENTRIC SHAFT				
8	1	B02062600	CYLINDER				
9	1	B02062700	PISTONE				
10	1	H03240700	RIGHT GUIDE ARM				
11	2	M12	SCREW NUT				
12	2	15	C RING				
13	1	P20	O RING				
14	2	TP20	BACK UP RING				
15	1	2DU1208	SELF LUBRICATING BEARING				
16	3	6002	BEARING				
17	1	8X60L	PING				
18	1	H03240900	FIXING PLATE				
19	1	H03216200	GASKET				
20	2	M12	SPRING WASHER				
21	2	M12X50	HEX SOCKET SCREW				

A032010 RIGHT GUIDE ARM UNIT

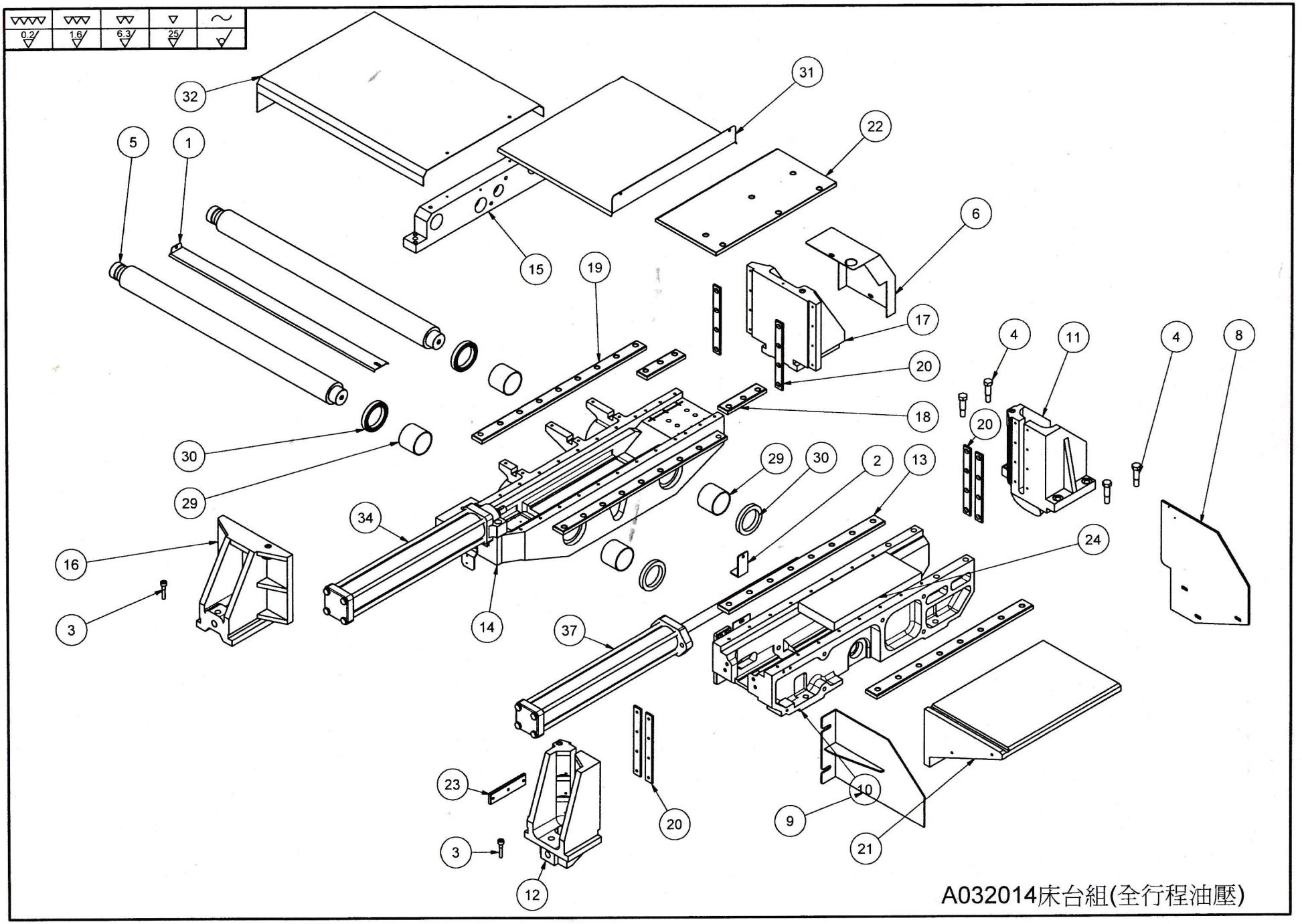
0.2	1.6	6.3	25	



A032011後撐料架組爆炸圖

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	7	H03230900	FEEDING ROLLER				
2	1	H03250100	RACK				
3	2	H03250200	STAND				
4	14	6005	BEARING				
5	4	-	PAD				
6	2	H02250100-2	BLOCK				
7	2	H03250300	ADJUSTING				
8	4	B02133200	COVER FOR VERTICAL ROLLER				
9	4	B02132500	VERTICAL ROLLEER				
10	4	B02141100	SHAFT				
11	4	B02141500	HANDLE				
12	4	M20	HEX SCREW NUT				
13	4	M20	SPRING WASHER				

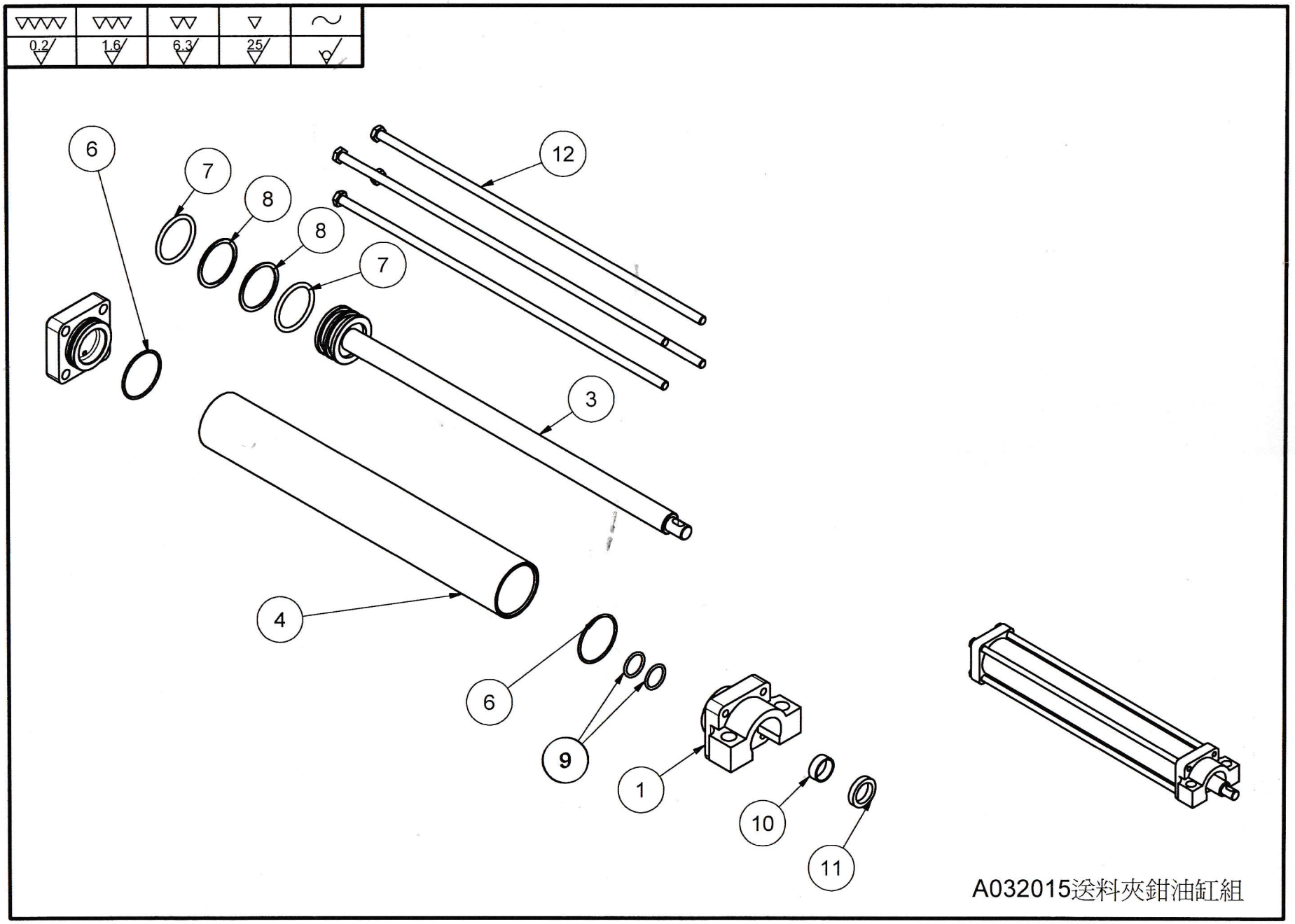
A032011 BACK MATERIAL HOLDER



A032014床台組(全行程油壓)

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	1	B02110300	PROTECT COVER	26	-	-	-
2	1	B02113100	SUPPORT FOR COVER	27	-	-	-
3	2	B02130200	FIXING SCREW	28	-	-	-
4	4	B02130700	FIXING SCREW	29	4	2DU7060	SELF LUBRICATING
5	2	B02131101	GUIDE CLUMN	30	4	D95-d70-B13	OIL SEAL
6	1	H03211700	COVER FOR VISE	31	1	H03211600	COVER PLATE
7	-	-	-	32	1	H03211500	COVER FOR CYLINDER UNIT
8	1	H03212000	ANTI-FALLING PLATE	33	-	-	
9	1	H03212100	METAL HOLDING VISE	34	1	A032015	CYLINDER UNIT OF FEEDING VISE
10	1	H03230100	FIXING TABLE	35	-	-	
11	1	H03230200	FIXING VISE	36	-	-	
12	1	H03230500	MOVABLE VISE	37	1	A032016	CYLINDER UNIT OF TABLE VISE
13	2	H03230600	WEARING PLATE	38	-	-	
14	1	H03230800	MOVABLE TABLE	39	-	-	
15	1	H03231200	BASE				
16	1	H03231300	FEEDING VISE				
17	1	H03231400	FLOATING VISE				
18	2	H03231500	SHORT WEARING PLATE				
19	2	H03231700	WEARING PLATE				
20	6	H03231800	STEEL PLATE				
21	1	H03232000	METAL HOLDING RACK				
22	1	H03232300	SUPPORTING PLATE				
23	1	H03232500	PLATE FOR TOUCH DETECT				
24	1	H03232600	SUPPORTING PLATE				
25	-	-					

A032014 TABLE UNIT (FULL STROKE CLAMPING VISE)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A032015送料夾鉗油缸組

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	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	TP60	BACKING UP RING				
9	2	P30	O RING				
10	1	2DU3012	LUBRICATING BEARING				
11	1	D42-d30-B8	OIL SEAL				
12	4	H03261300	SCREW				
13							
14							
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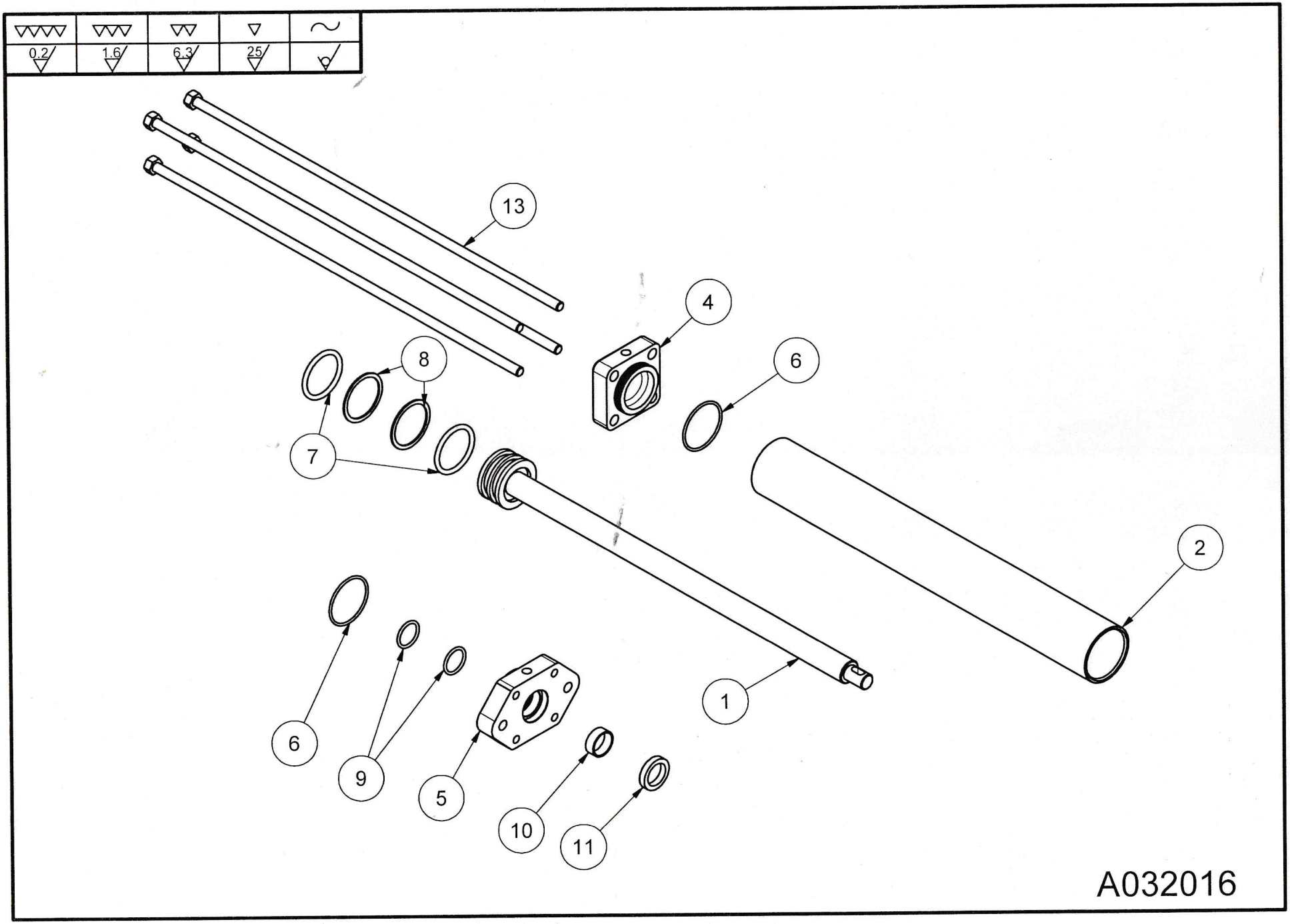
A032015 CYLINDER UNIT OF FEEDING VISE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A032016

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	1	H03260300	PISTON				
2	1	H03260400	CYLINDER				
3	-	-	-				
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	4	H03261200	LONG SCREW				
14							
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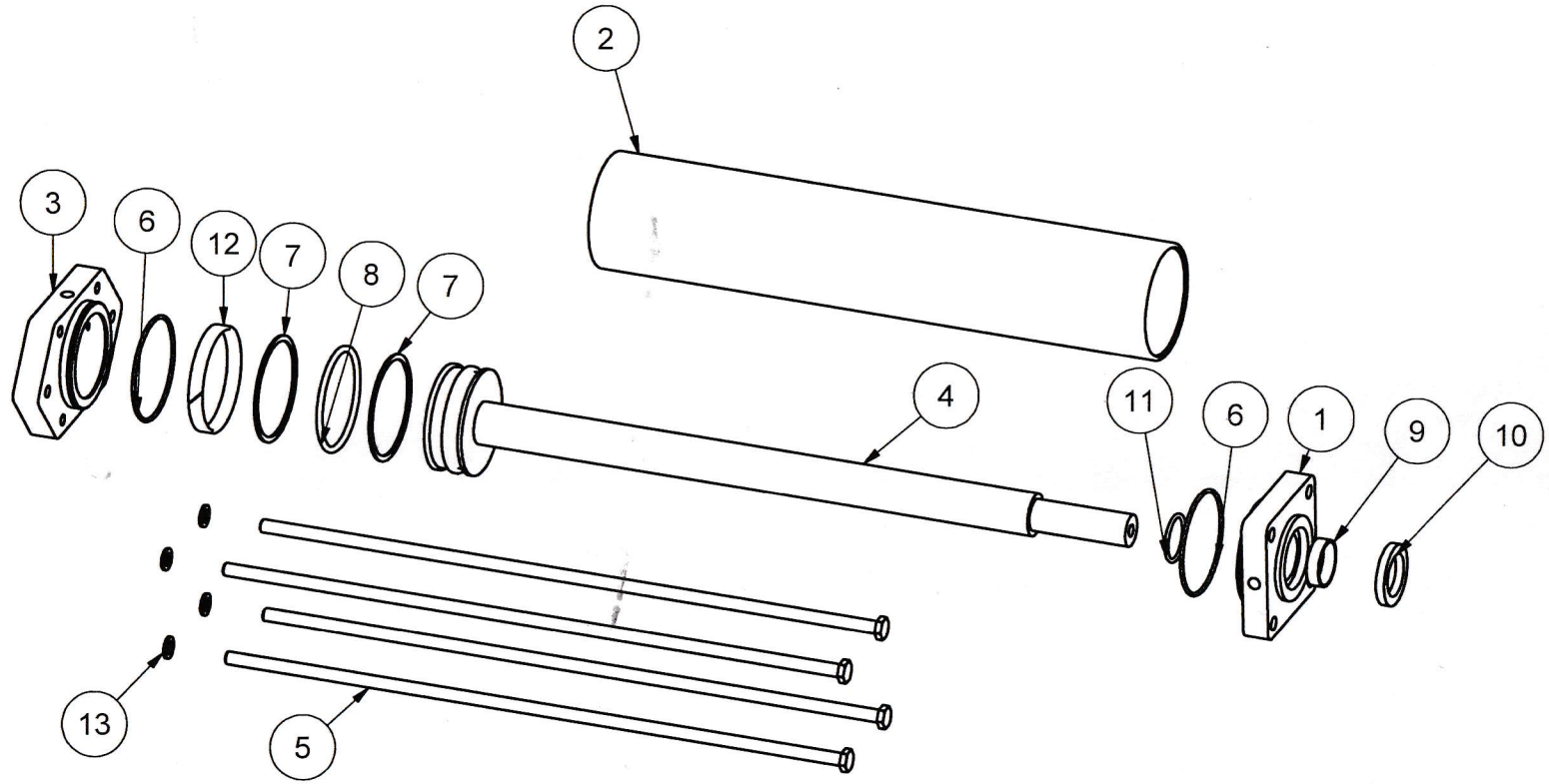
A032016 CYLINDER UNIT OF TABLE VISE

0.2	1.6	6.3	25	



A032017

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	1	B02061300	UPPER COVER				
2	1	H02260100	CYLINDER				
3	1	B02061100	UNDER COVER				
4	1	H03260100	PISTON				
5	4	H03261200	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							
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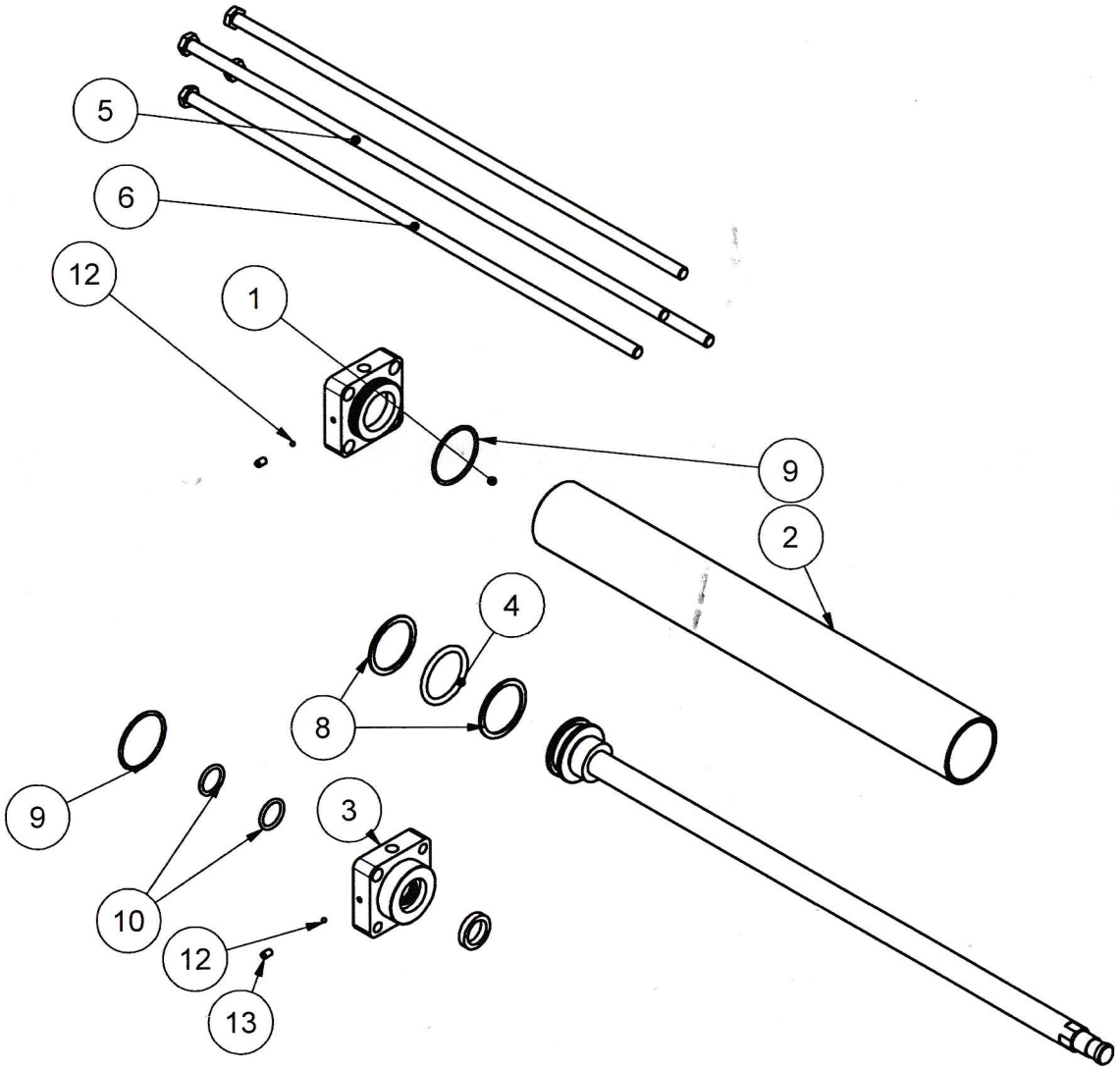
A032017 LIFTING CYLINDER UNIT

0.2	1.6	6.3	25	



A032018床臺送料油缸組爆炸圖

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	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							
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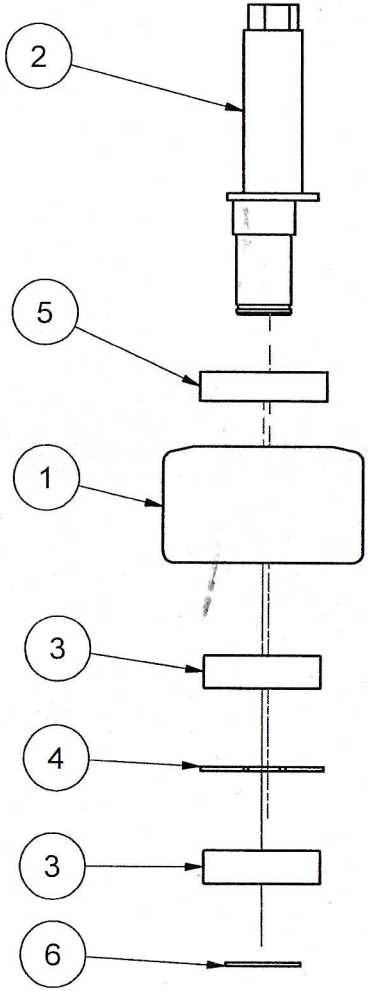
A032018 FEED CYLINDER UNIT OF TABLE

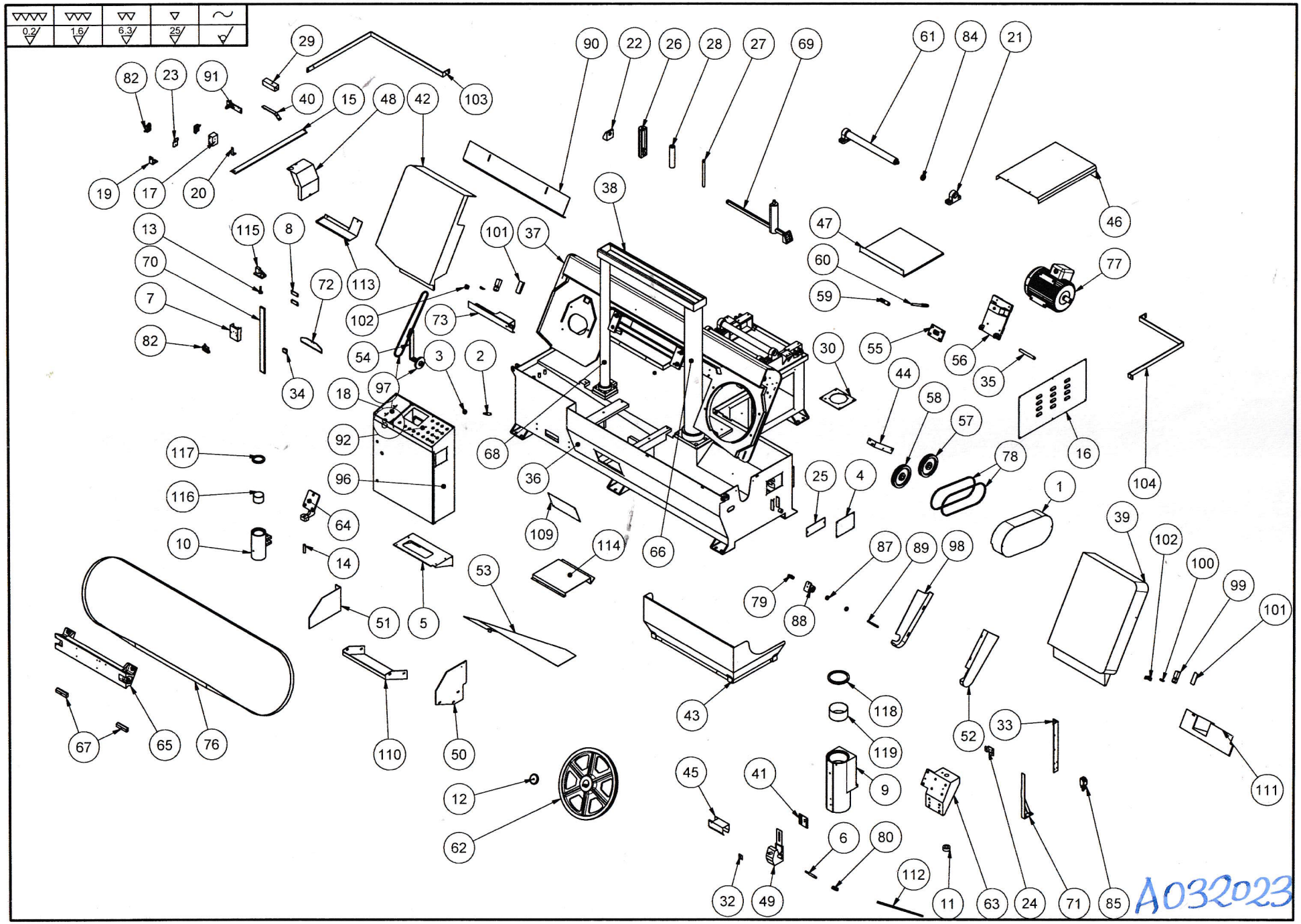
0.2	1.6	6.3	25	



A032022

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	1	H03242300	DAMPER ROLLING				
2	1	H03242200	SHAFT				
3	2	6002	BEARING				
4	1	R32	C TYPE RING				
5	1	D35-d17-B8	OIL SEAL				
6	1	S15	C TYPE RING				

A032022 ANTI VIBRATION DAMPER ROLLING


0.2
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6.3
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A032023

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	-	-	-
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	H02312000	PLATE	50	1	H03212000	PLATE

A032023 METAL STRUCTURE

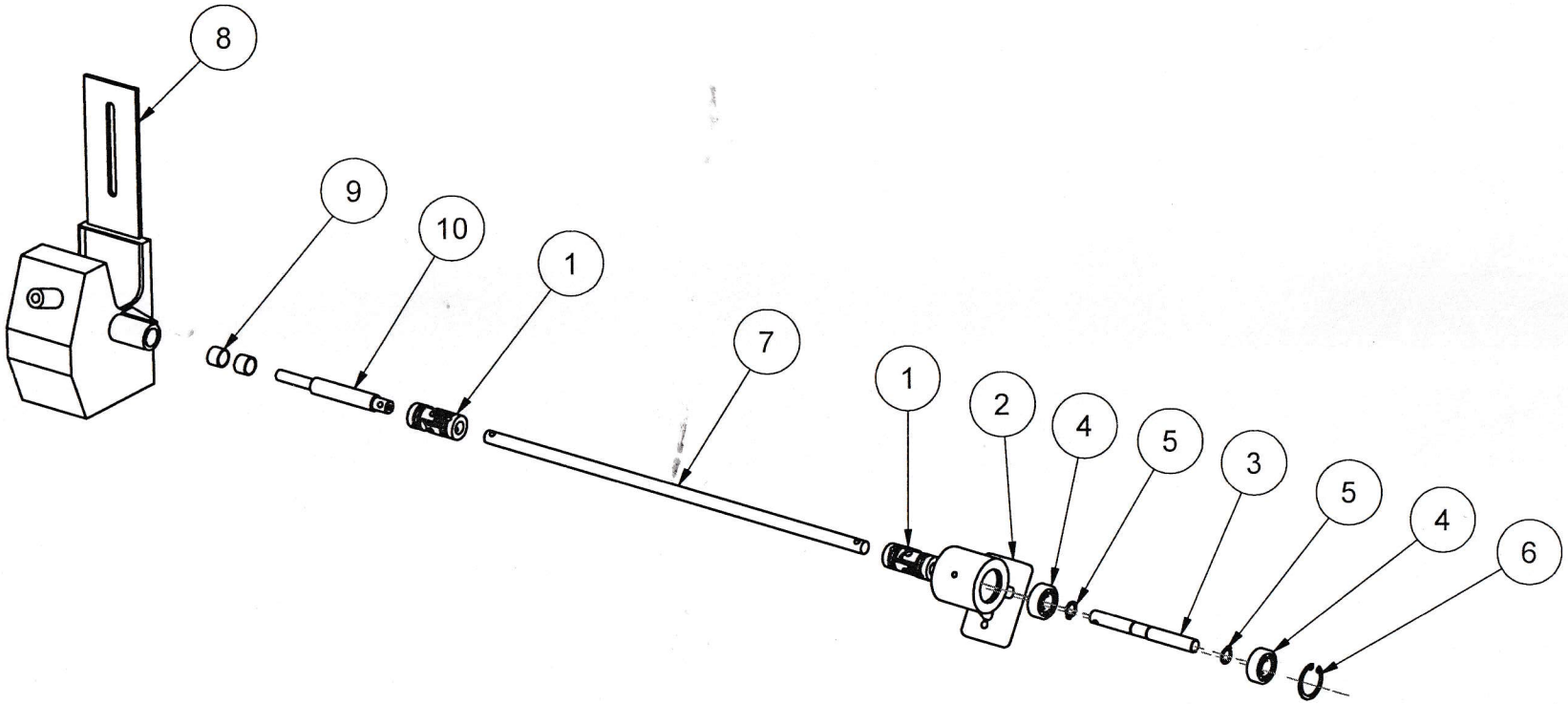
NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
51	1	H03212100	VISE	76	1	5450x41x1.3	SAW BLADE
52	1	H03212300	COVER	77	1	7.5hp-132s	MOTOR
53	1	H03212700	PLATE	78	2	3Vx500	BELT
54	1	H03213200	PLATE	79	4	5UJ-NJ12	CROSS COUPLING
55	1	H03220100	BASE	80	2	5UJ	CROSS COUPLING
56	1	H03220200	MOTOR STAND	81	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	-	-	-
60	1	H03221600	ADJUSTING SCREW	86	-	-	-
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	-	-	-
68	1	H03241000	ADJUTANT COLUMN	94	-	-	-
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	-	-	-	100	2	E100-01-S51	PIN
75	-	-	-	101	2	H03213800	SWITCH BASE

A032023 METAL STRUCTURE

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
102	2	H03213900	PLATE				
103	1	H03214100	GUARD RAIL (LEFT)				
104	1	H03214200	GUARD RAIL (RIGHT)				
105	-	-	-				
106	-	-	-				
107	-	-	-				
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

0.2	1.6	6.3	25	~



A032028

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	2	NJ-12	UNIVERSAL JOINT				
2	1	H03221800	PULLEY BASE				
3	1	B02022200	SHAFT OF PULLEY				
4	2	6201	BALL BEARING				
5	2	S12	EXTERNAL CLIPS				
6	1	R32	INTERNAL CLIPS				
7	1	H03230400	TRANSMISSION SHAFT				
8	1	H03211900	COVER OF WIRE BRUSH				
9	2	2DU1512	SELF-LUBERICATING BEARING				
10	1	B02023200	SHAFT OF WIRE BRUSH				

A032028 BASE UNIT FOR WIRE BRUSH WHEEL