

INSTRUCTION MANUAL

H-5552SA

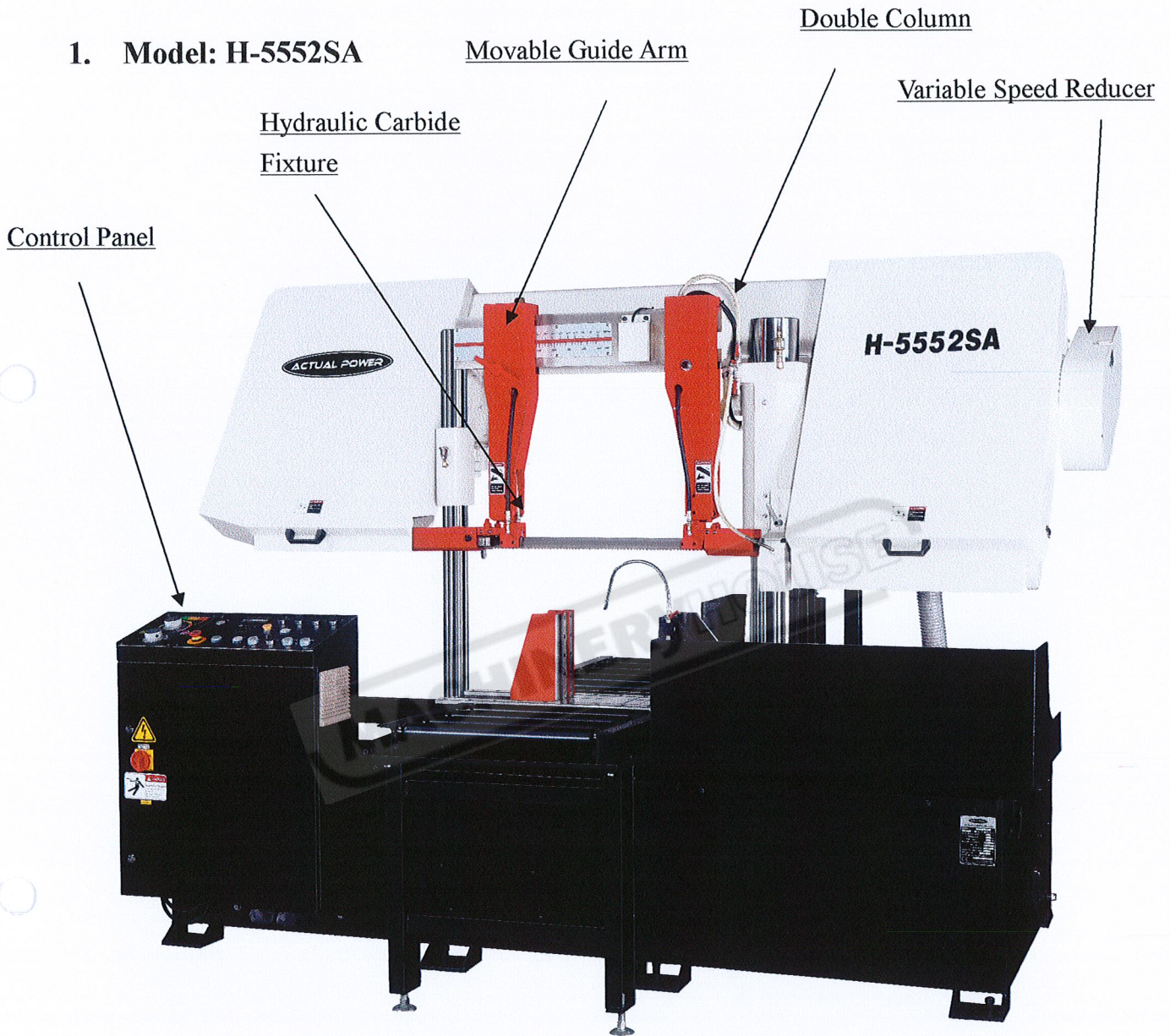
**Semi Automatic Double Column
Heavy Duty Band Saw (415V)
550 x 530mm (W x H) Rectangle**



B127

I : CHARACTERISTIC & SPECIFICATION

1. Model: H-5552SA



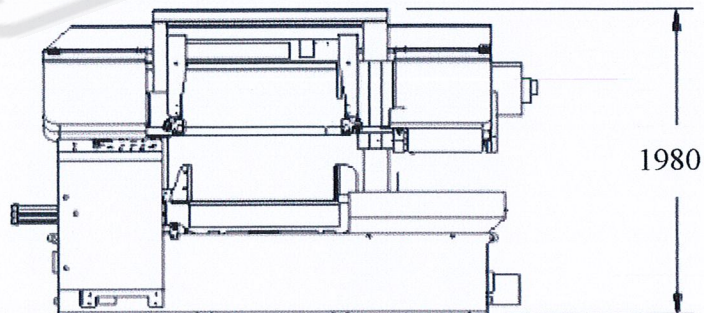
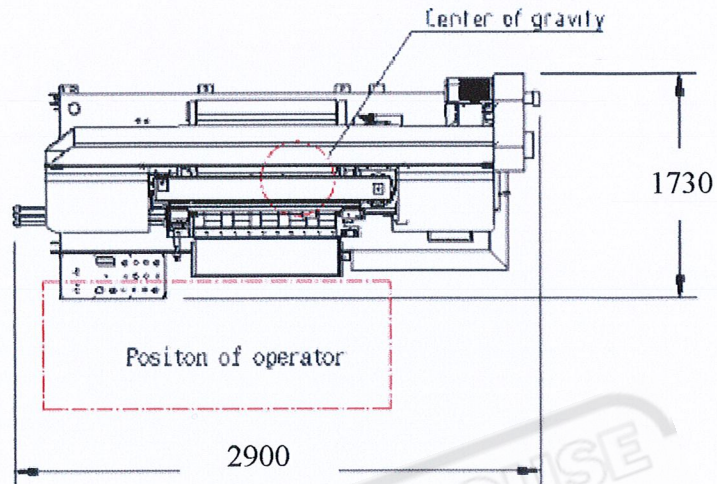
2. Specification:

MODEL NO.		H-5552SA
CAPACITY		○ 530mm
		□ 550x530mm
BLADE SPEED		50HZ 20 ~ 80 M/min
		60HZ 24 ~ 100 M/min
BLADE TENSION		HYDRAULIC
BLADE SIZE		5980L*41W*1.3T
MOTOR	BLADE	5.5KW 7.5HP
	HYDRAULIC	1.5KW 2HP
	COOLANT	0.2KW 1/4HP
TABLE HEIGHT		800mm
CLAMP VISE TYPE		HYDRAULIC
MACHINE WEIGHT		2580kgs
HYDRAULIC OIL CAPACITY		70L
CUTTING OIL CAPACITY		110L
PACKED MEASUREMENT		2900x 1980 x 1730mm (W*L*H)

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:

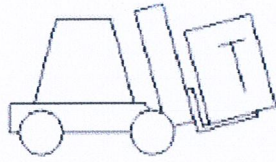


2. Machine Transportation

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

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

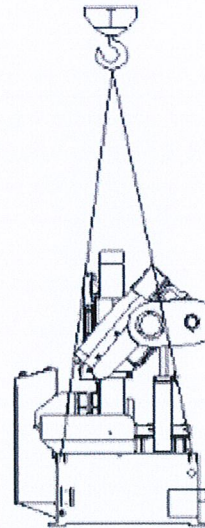
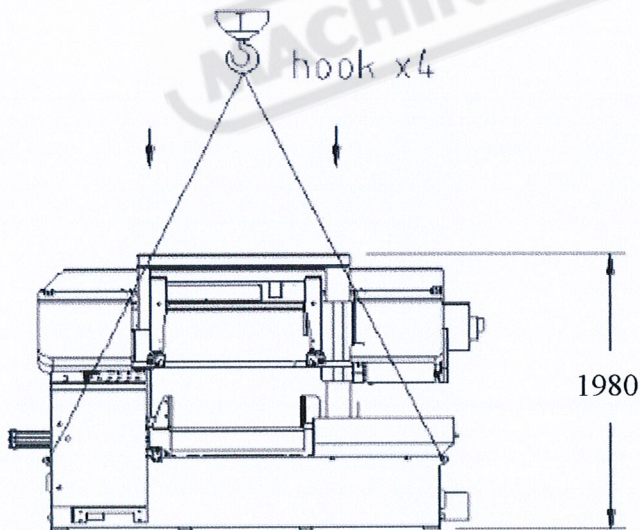
(Machine Weight: 2580kgs)



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.

(Please refer this subject to a certificated electrician.)

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 fixing screw for transport 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 take some inspecting courses below:

1. Take all of the fixing plates for transport 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

III : OPERATION METHOD

1. The Description Of Operation Panel

Model: H-5552SA



(1) Emergent Stop Button

Press the button to stop all of the machine functions.

(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 be descended according to the speed of flow control valve.

(picture 4)

(picture 4)

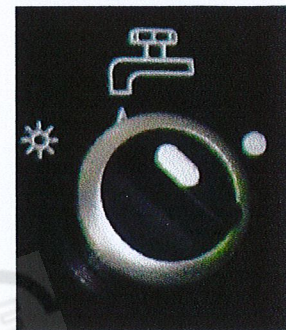
**(5) The Switch For Choosing Cooling Water**


* 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.

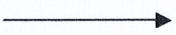
(picture 5)

(picture 5)

**(6) 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 6)

(picture 6)

(picture 6)


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


For work light use only.

(picture 7)

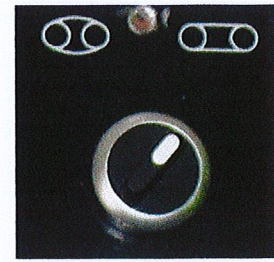


(8) The Adjusting Switch For Blade Tension

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

* Turn the position to 
The blade tension will be loosen
(picture 8)



(picture 8)


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

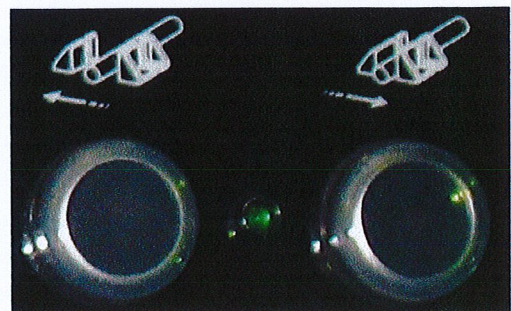
To control the rotational speed of blade cutting.
Clockwise turn for acceleration,
counterclockwise one for deceleration. (picture 9)

(Picture 9)

**(10) The Adjusting Button For Movable Vise Of Table**

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

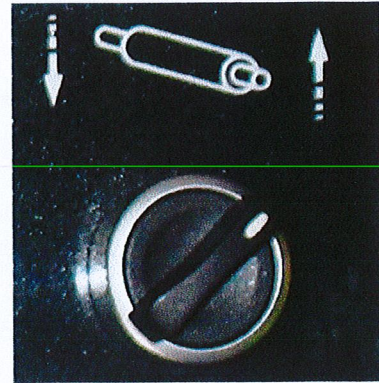
Press this button 
The work piece will be loosen.
(picture 10)



(picture 10)


(11) The Switch Of Feed By Manual


Turn to the clockwise direction way,
and turn the hand wheel for material feed.



(picture 11)

(12) 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 12)

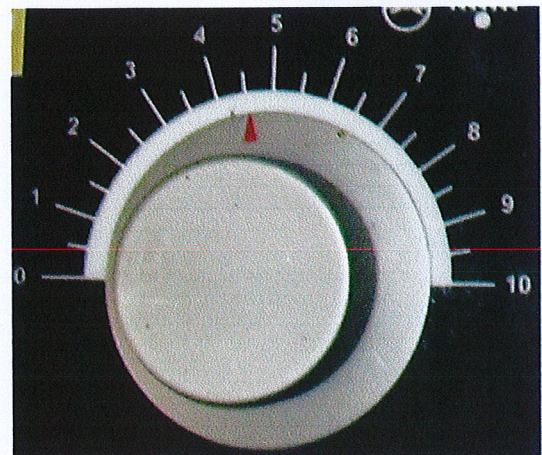


(picture 12)

(13) 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 13)



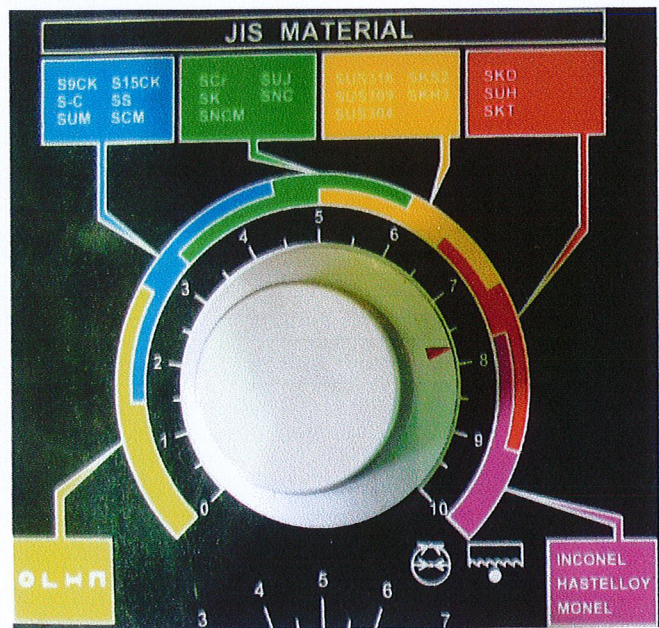
(14) The Switch Of Pressure Control

For Blade Cutting

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

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

(picture 14)



(picture 14)

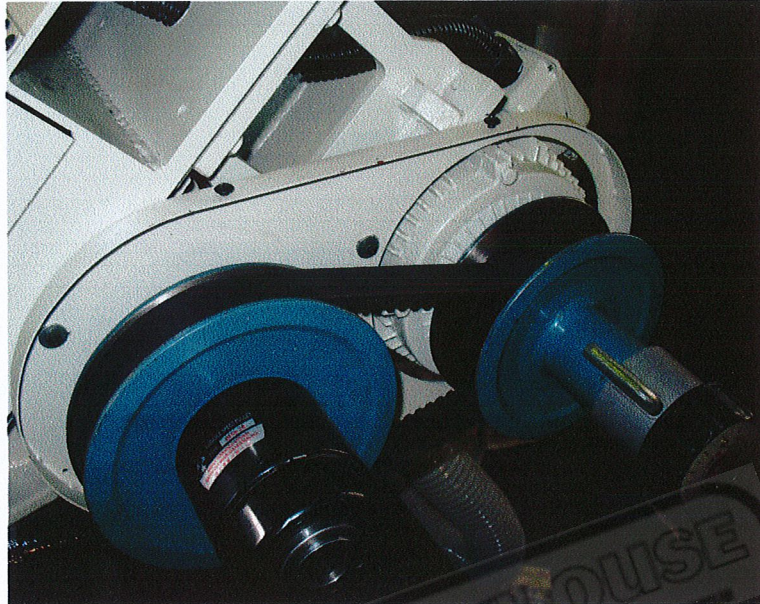
MACHINERYHOUSE

2. FUNCTION DESCRIPTION

(1) Variable Speed Reducer

The motor of driving pulley is **5.5KW (7.5HP)**

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



(picture 15)

(2) The Adjustment Of Movable Guide Arm

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

Step 1: loose the carbide fixture.

Step 2: loose the locking handle.

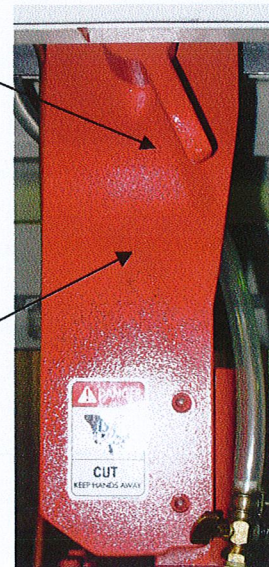
Step 3: move the guide arm to the work piece.

Step 4: lock the handle.

(picture 16)

Locking Handle

Guide Arm



(picture 16)

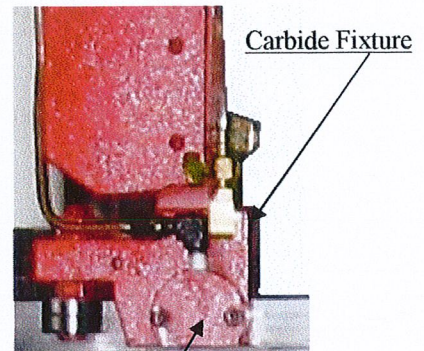
(3) The Guide Wheel Base Of Hydraulic Clipping Carbide Fixture

Hydraulic clamping system make the blade cutting more stable.

Carbide material is more wear-resisting.

(picture 17)

(picture 17)



Hydraulic Tank

(4) Washing Gun

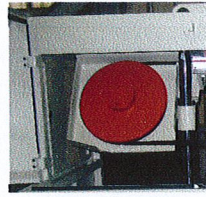
Flush the machine table surface or wash chipping away.

(picture 18)

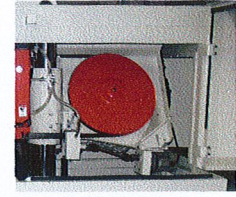


(picture 18)

3. THE INSTALLATION OF SAW BLADE




(picture 19)




(picture 20)

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 19 and 20 above)

Step 3: Turn the adjusting switch of hydraulic carbide fixture to the position to  (picture 6 of Page 8)

Step 4: Turn the adjusting switch of blade tension to the position of  (picture 8 of Page 9)


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


Step 6: Install the blade on the main driving pulley.

(Note: Please wear the glove in the replacement of the saw blade)

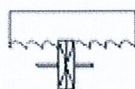
Step 7: The teeth of blade was faced down and turned to the right.

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

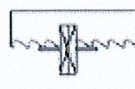
Step 9: Turn the adjusting switch of blade tension to the position of  (picture 8 of Page 9)

Step 10: Turn the adjusting switch of carbide fixture to the position of  (picture 6 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

Step as below:

- (a.) Start the hydraulic pump 
- (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 stopped.
- (b.) Press the start button of blade to cut the work piece.
- (c.) The blade will be stopped when the single cutting was carried out.
- (d.) Take off the remainder.

IV : MAINTENANCE

After Every Day Work:

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

1. Every Day

Before operate the machine, please check the following procedures:

- (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 if it was contacted with the saw blade exactly or not.

2. One Week

Refill the lubrication for: driven & 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

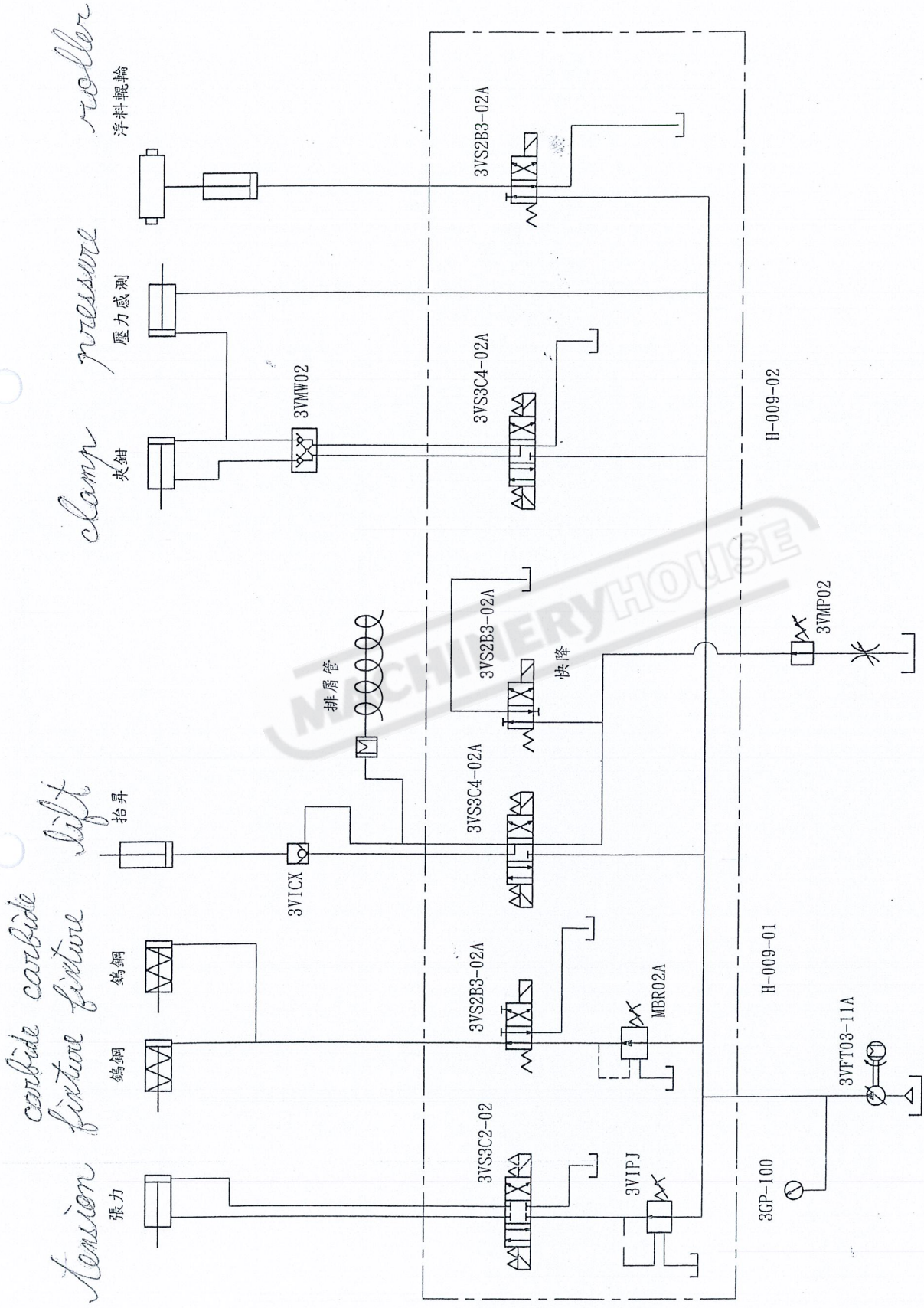
Gear Oil 140
HYDRAULIC OIL AW32 (VG32)
High Temperature Grease NO.3

V : SAFE MATTERS

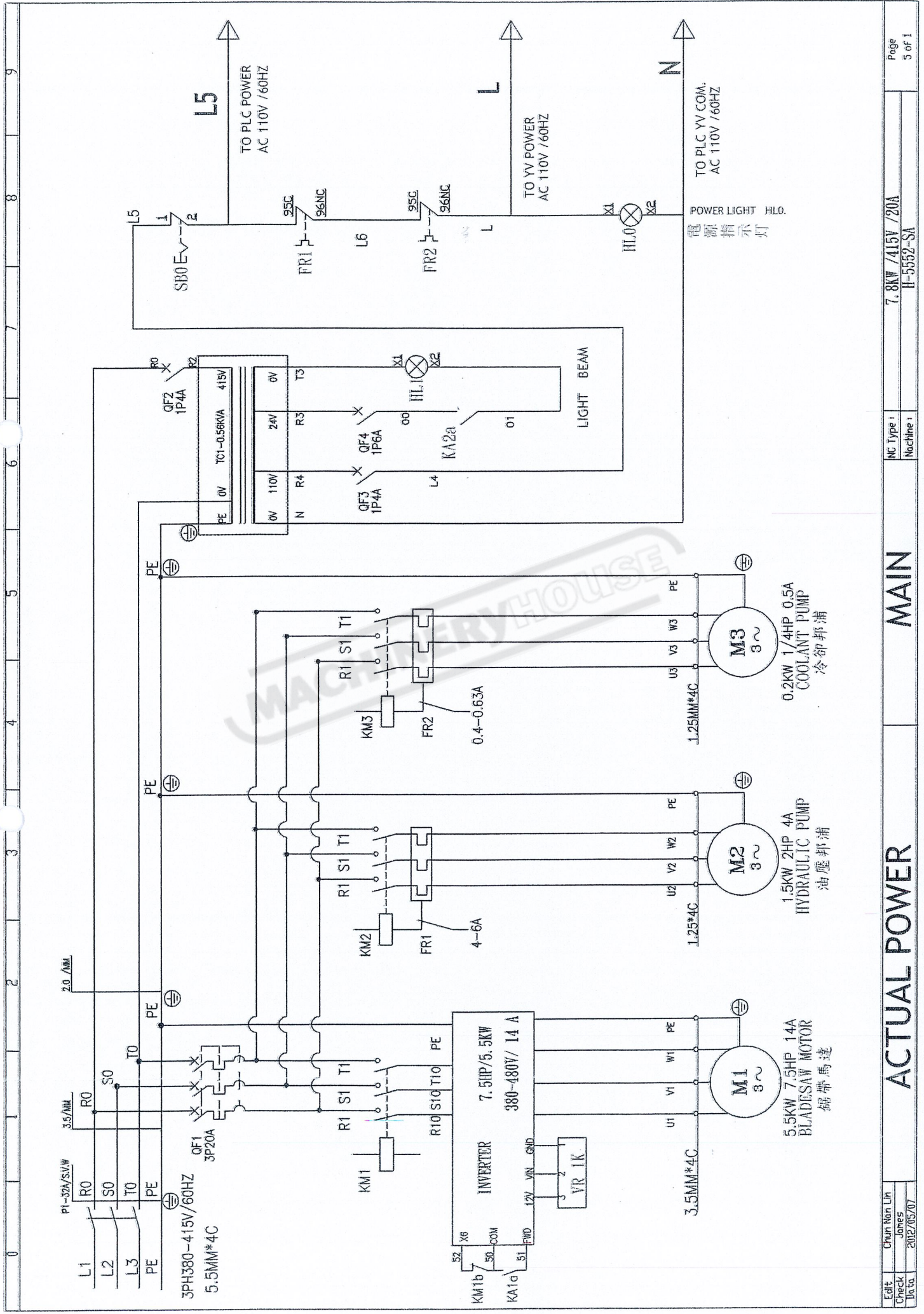
1. Please don't approach the machine inside when the saw blade is on working.
2. Any maintenance will be forbidden during the machine operation.
3. Please offer the proper material measurement for machine cutting.
4. During the machine operation, please don't play pranks around.
5. Please don't smoke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



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 wounding the hand.



設計	黃清忠	機種	H-7670SA H-5552SA
繪圖		品名	H-7670SA油路圖
日期	98.7.20	圖號	H-010



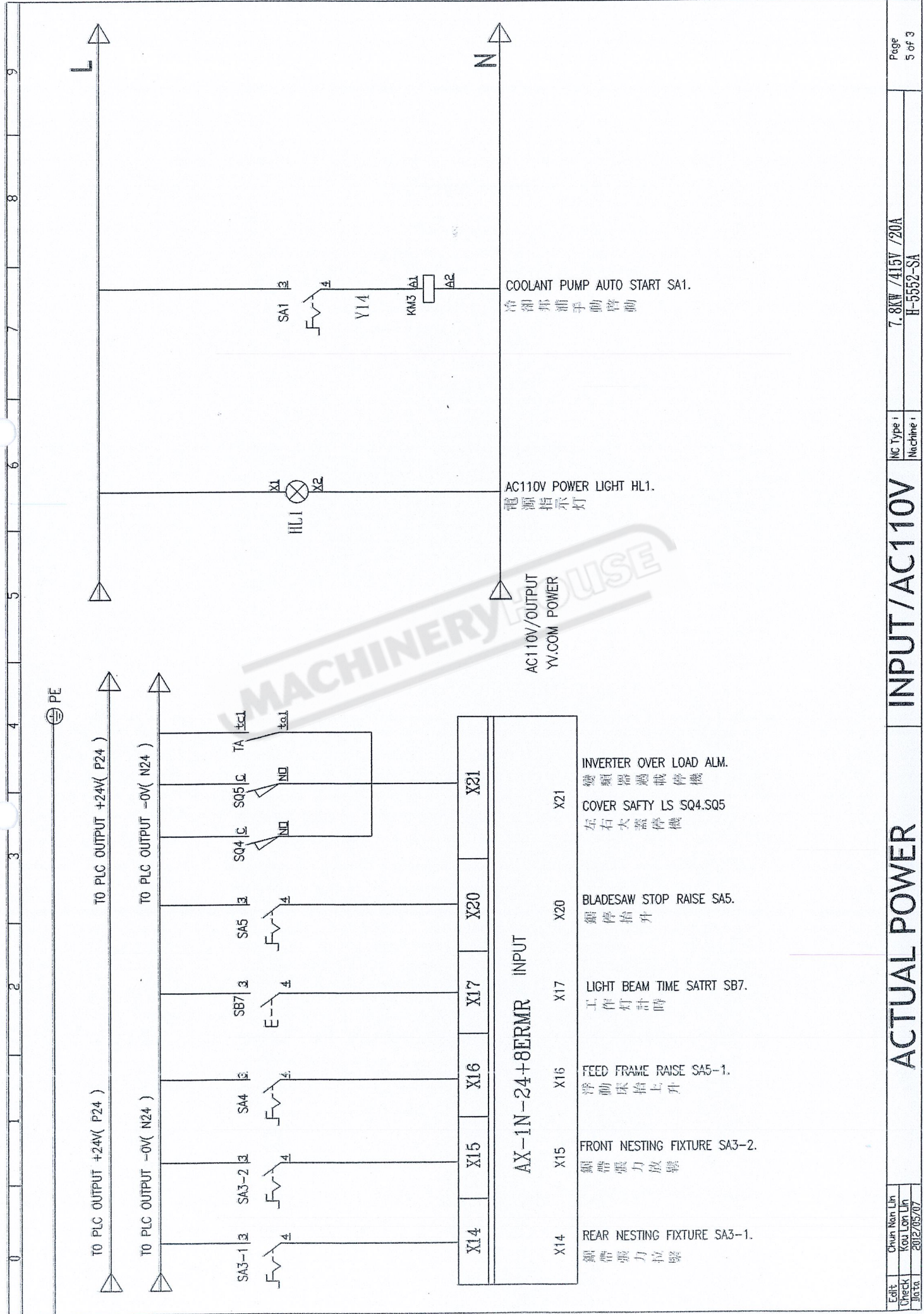
Edit: Chun Nan Lin
 Check: James
 Date: 2012/05/07

ACTUAL POWER

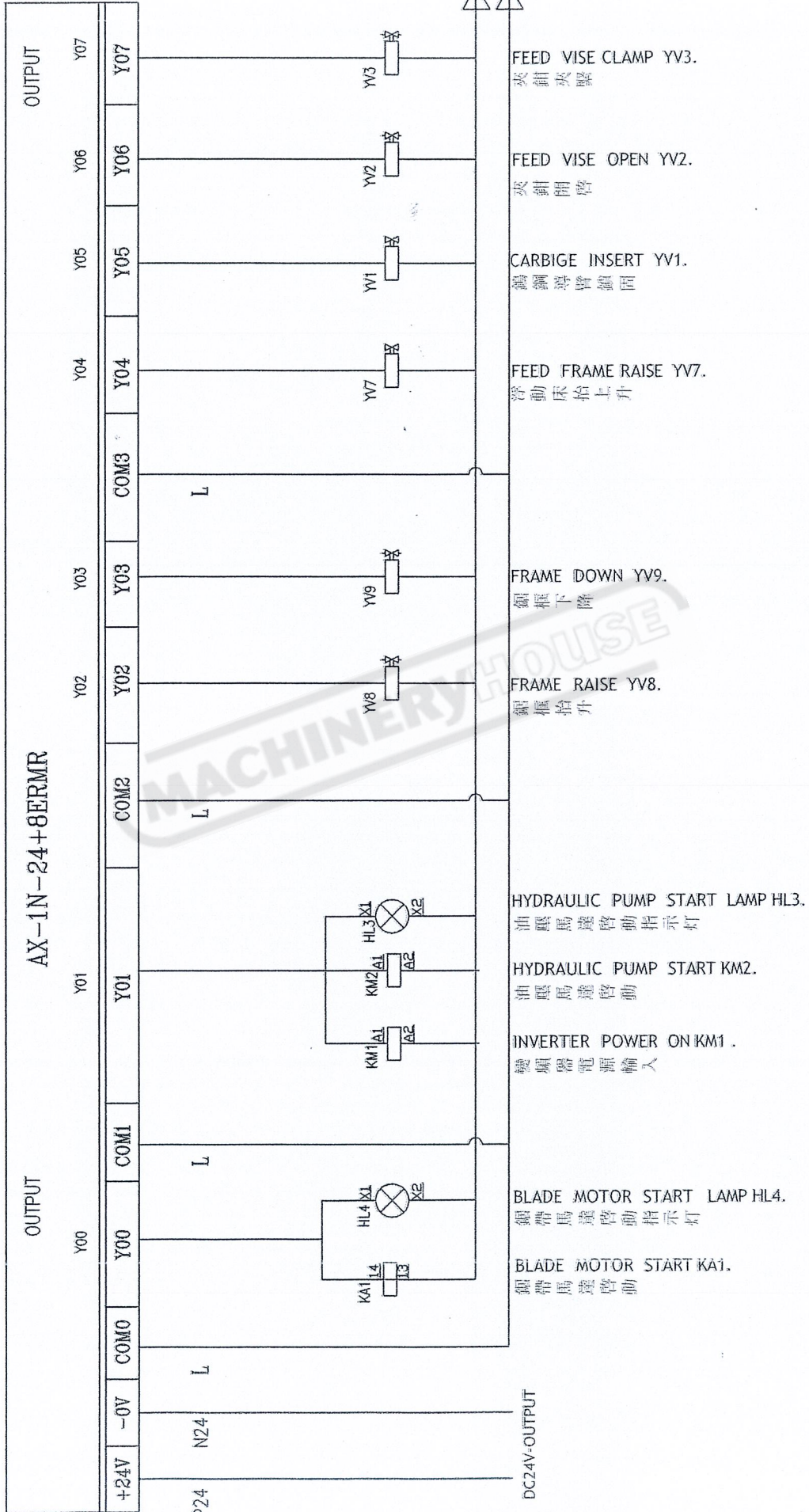
MAIN

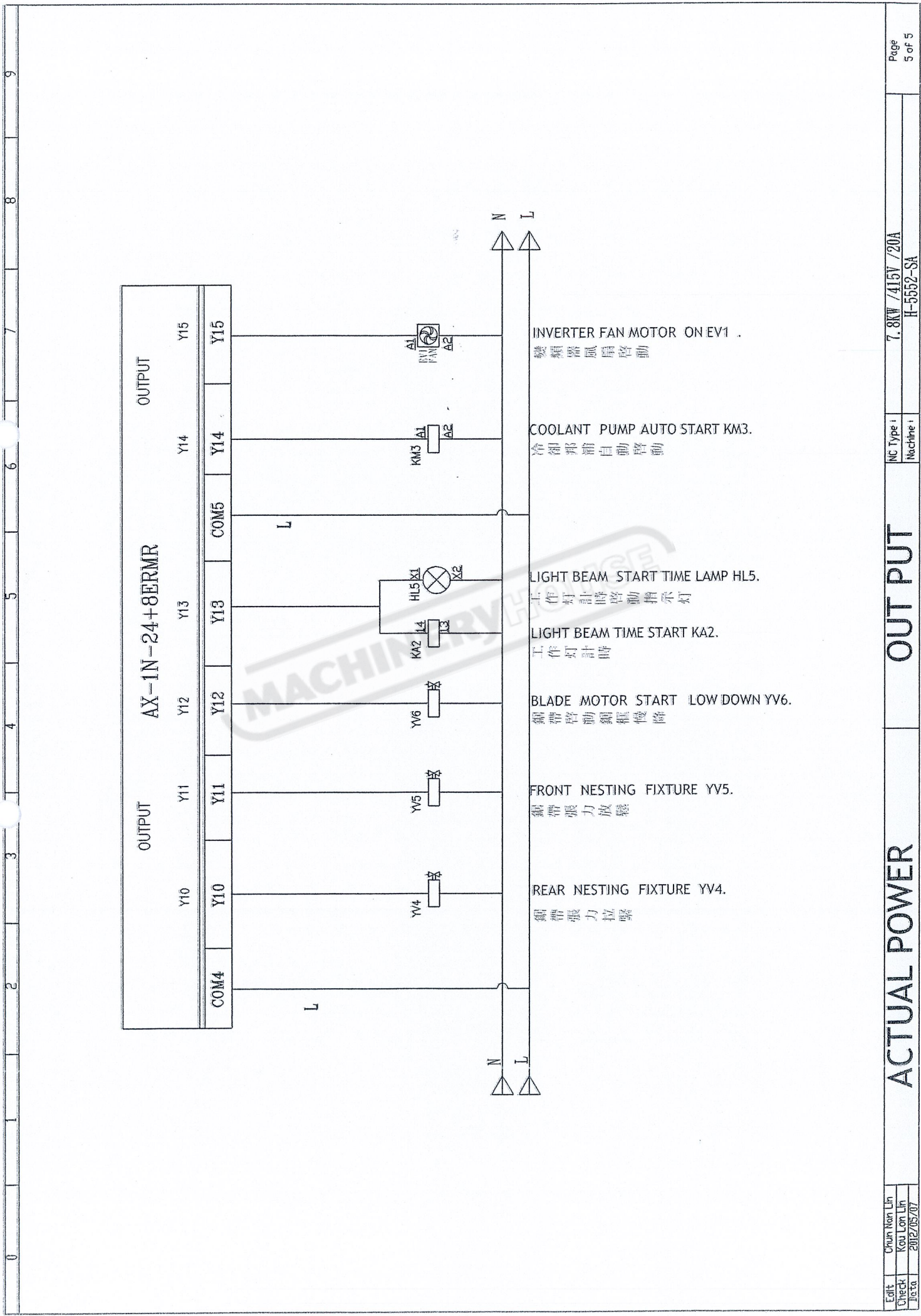
NC Type: 7.8kW / 415V / 20A
 Machine: H-5552-SA

Page: 5 of 1

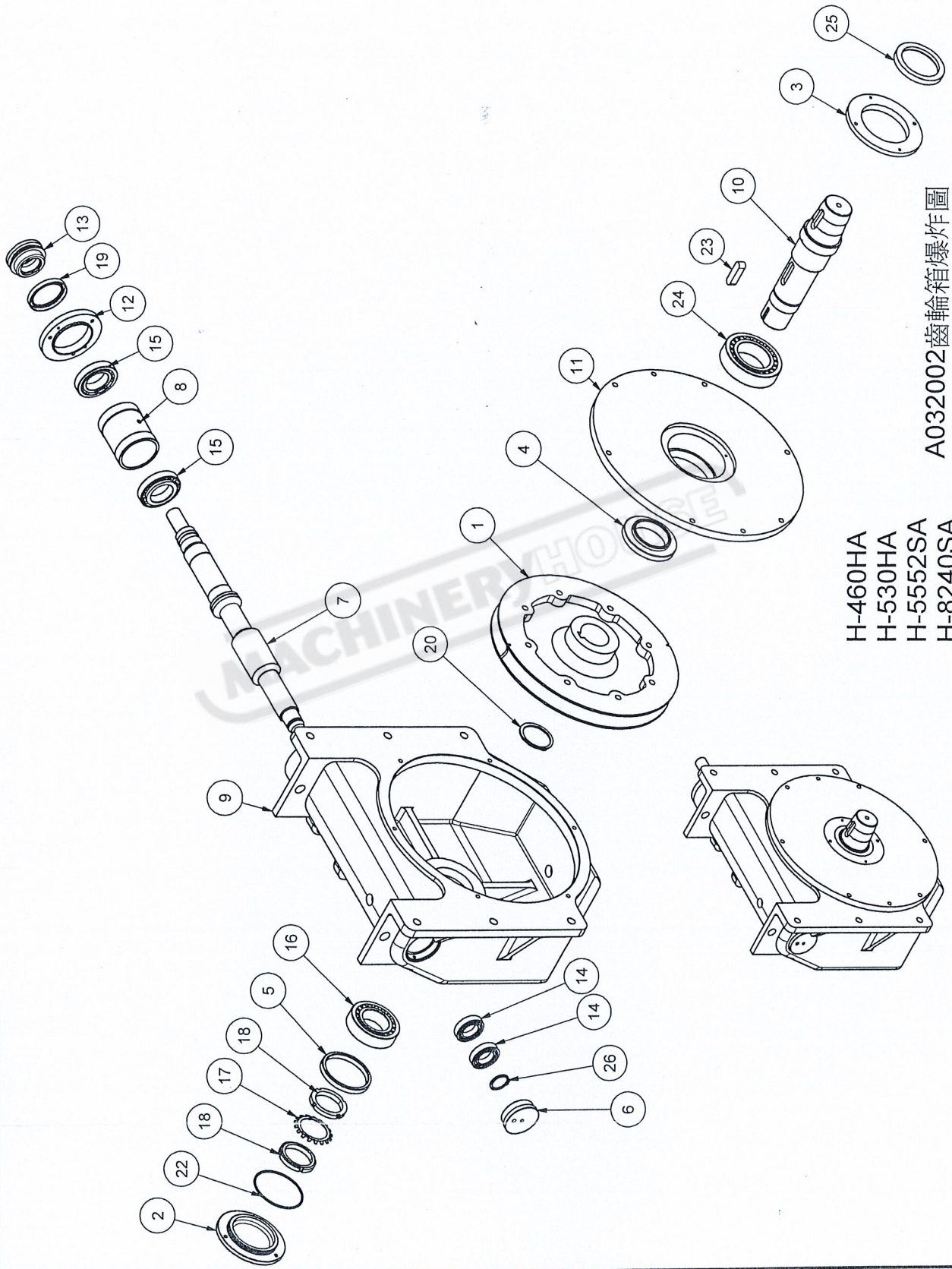


0 1 2 3 4 5 6 7 8 9





0 2 3 4 5 6 7 8 9



A032002齒輪箱爆炸圖

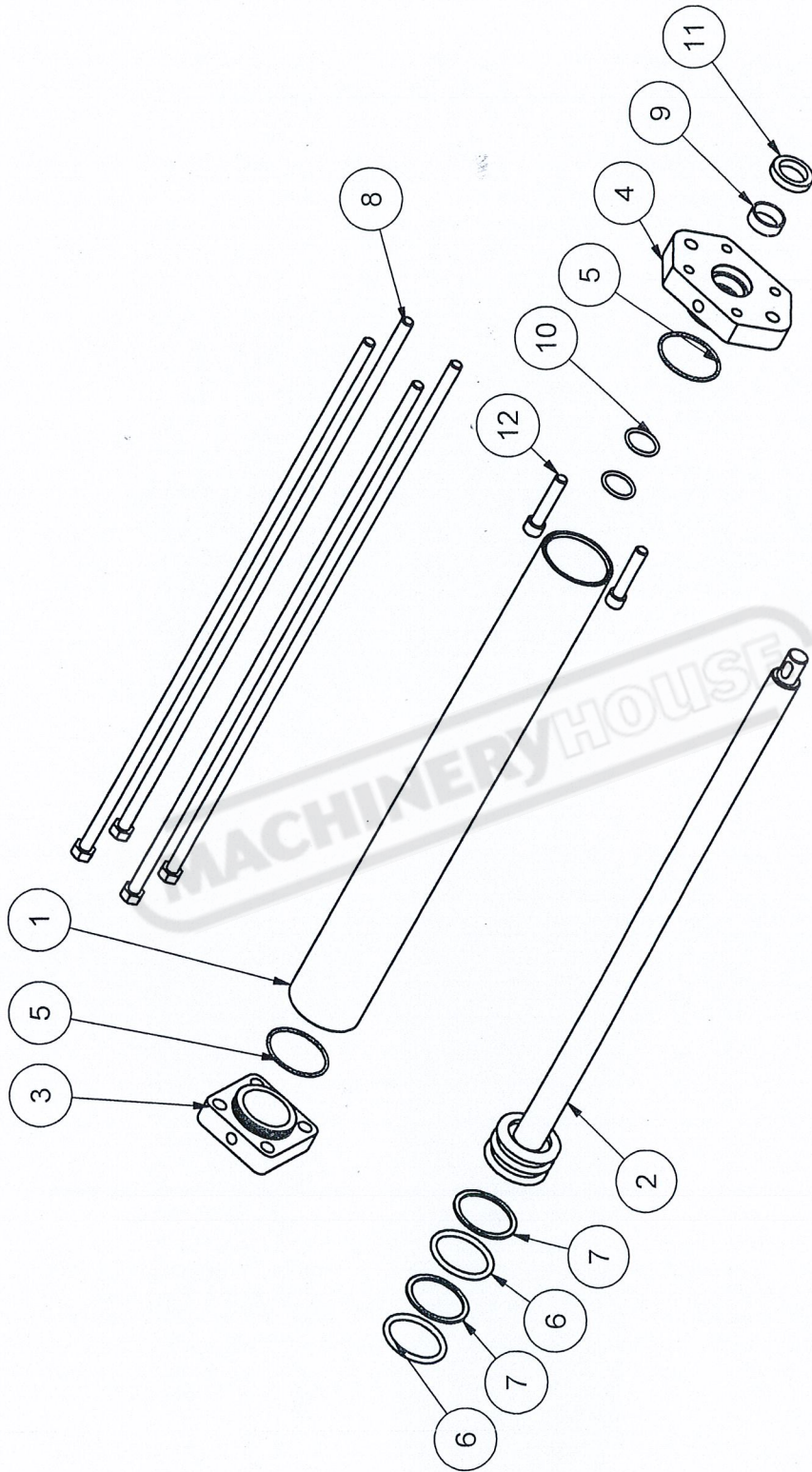
- H-460HA
- H-530HA
- H-5552SA
- H-8240SA

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▽▽	6.3	▽	▽	▽	▽
▽	25	▽	▽	▽	▽

NO	QTY	TYPE	DESCRIPTION	NO	QTY	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

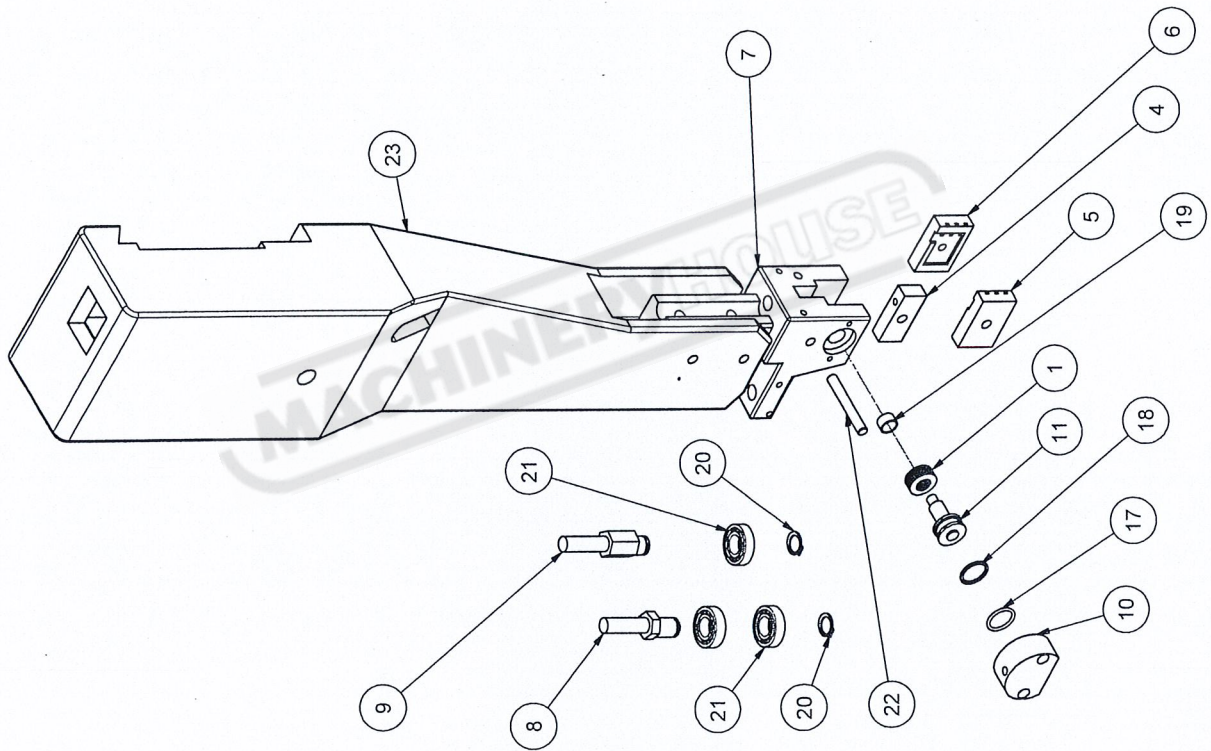
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0.2/▽	1.6/▽	6.3/▽	25/▽	▽



A050004床台夾鉗缸組爆炸圖

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	H05060400	CYLINDER				
2	1	H05060700	PISTON				
3	1	H03261000	BACK COVER				
4	1	H03260900	FRONT COVER				
5	2	G60	O RING				
6	2	P55	O RING				
7	2	P55	BACKING UP RING				
8	4	H05060900	SCREW				
9	1	2DU3012	LUBRICATING BEARING				
10	2	P30	O RING				
11	1	D42-d30-B8	OIL SEAL				
12	2	JIS B 1176-M12 x 60	BOLT				
13							
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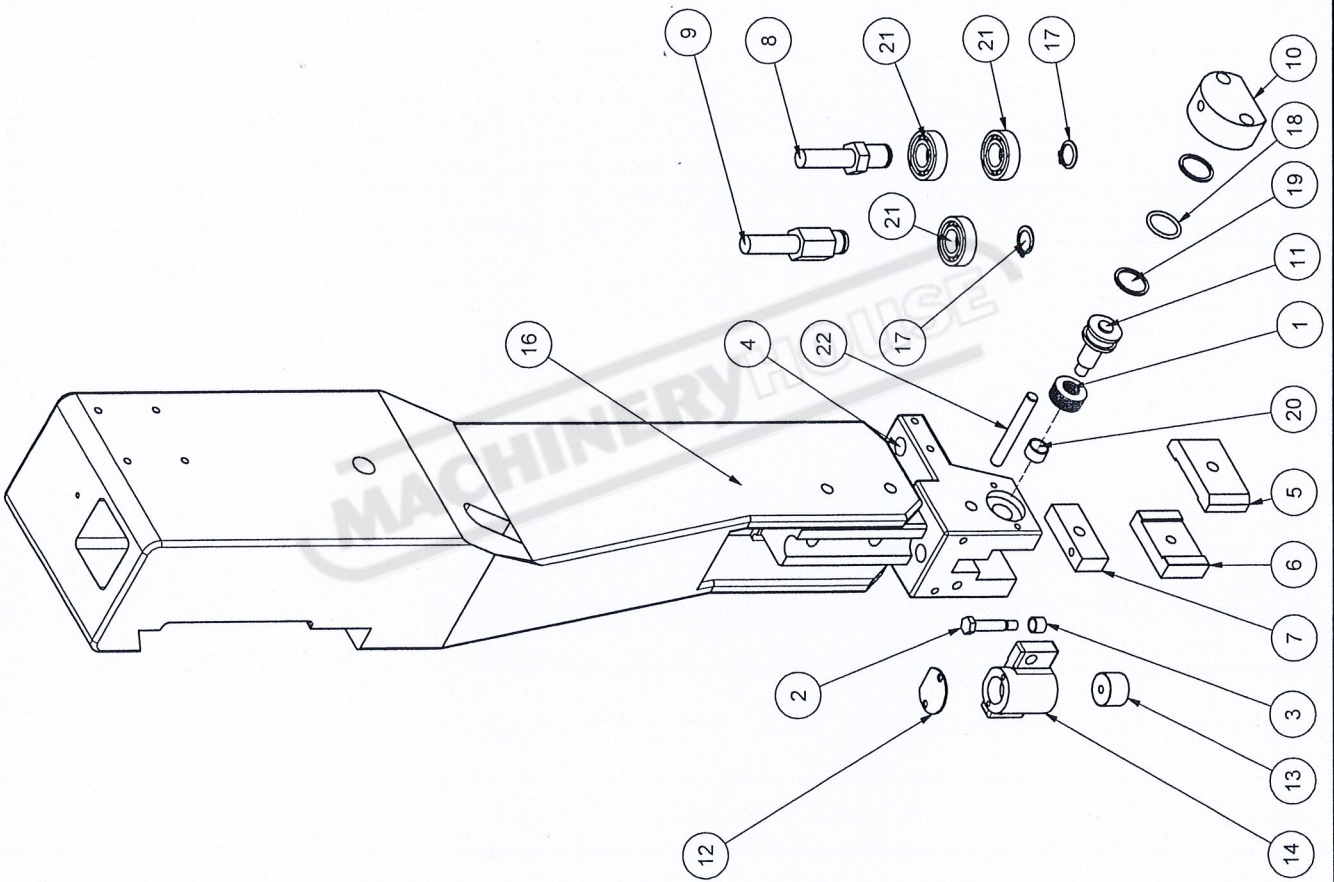
A050004 CYLINDER UNIT OF TABLE VISE



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0.2/▽	1.5/▽	6.3/▽	25/▽

A050009左導臂組爆炸圖

A050010右導臂組爆炸圖

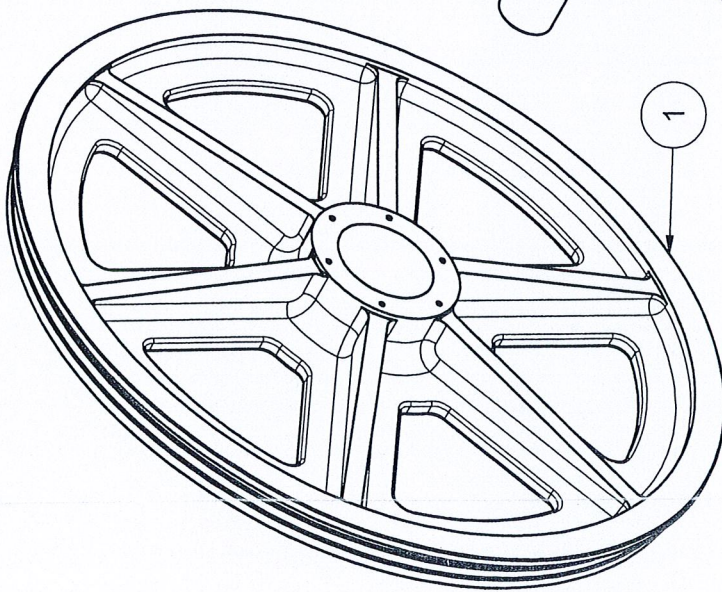


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0.2/▽	1.6/▽	6.3/▽	25/▽	▽

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	§ 12.2 x § 23 x 1t	DISC SPRING				
2	1	200103500	SHAFT				
3	1	200104000	RING				
4	1	B02043700	RIGHT GUIDE WHEEL BASE (HYDRAULIC)				
5	1	B02040901	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				
16	2	JIS B 1181-AM12	HEX NUT				
17	2	§ 15	C TYPE RETAINING RING				
18	1	P20	O RING				
19	2	P20	BACKING UP RING				
20	1	2DU1208	LUBRICATING BEARING				
21	3	6002	BALL BEARING				
22	1	8 x 60L	STRAIGHT PIN				
23	1	H05040700	RIGHT GUIDE ARM				

A050010 RIGHT GUIDE ARM UNIT

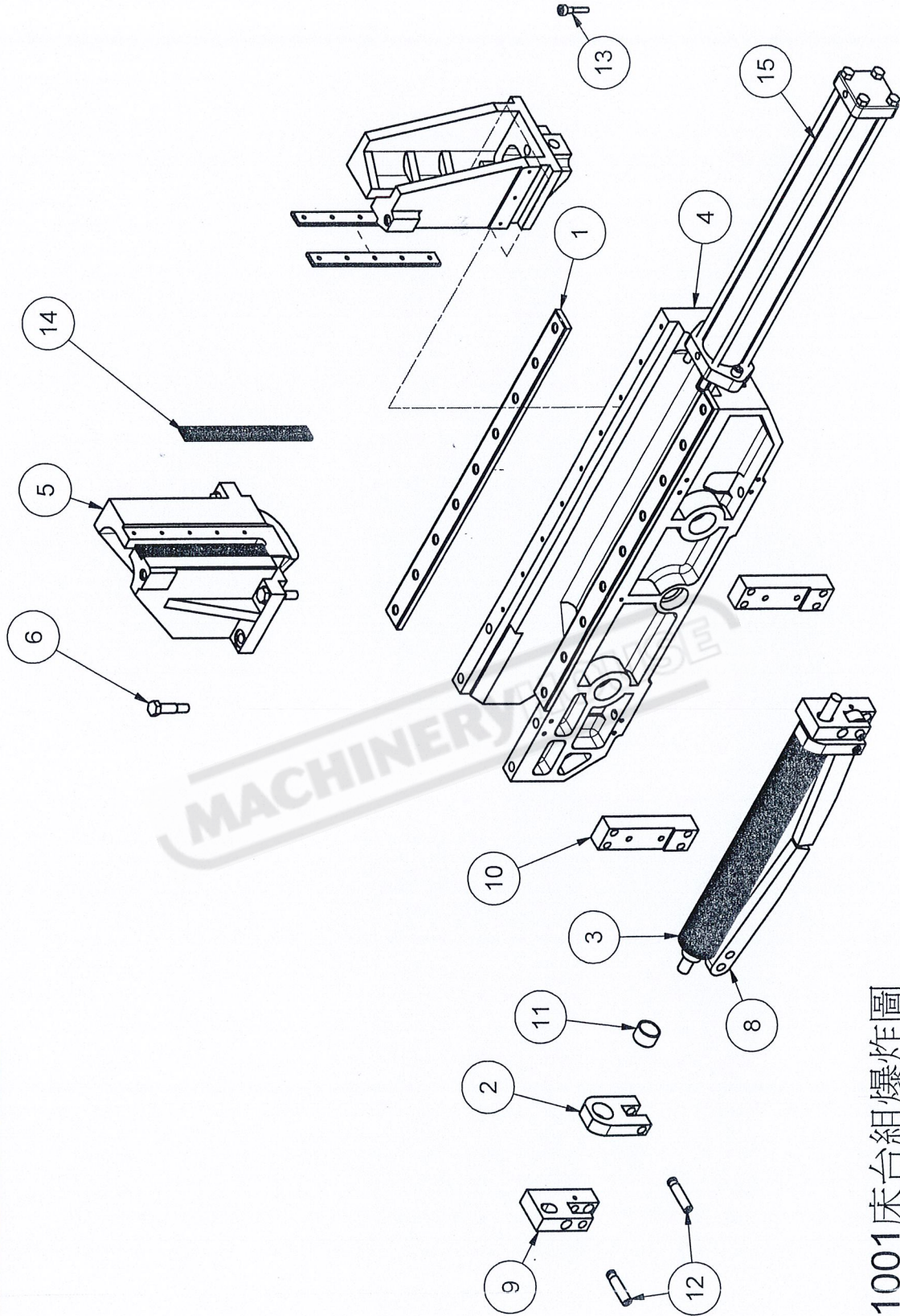
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A050012被動輪組爆炸圖

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	H03240200	DRIVED WHEEL				
2	1	H03221300	SHAFT				
3	1	B02040600	BEARING COVER				
4	1	B02044000	SPACER RING				
5	2	E32210J	BEARING				
6	1	AN10	NUT				
7	1	AW10	GASKET				
8	6	JIS B 1176-M6 x 30	BOLT				
9	6	M6	SPRING WASHER				
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A050012 DRIVED WHEEL UNIT



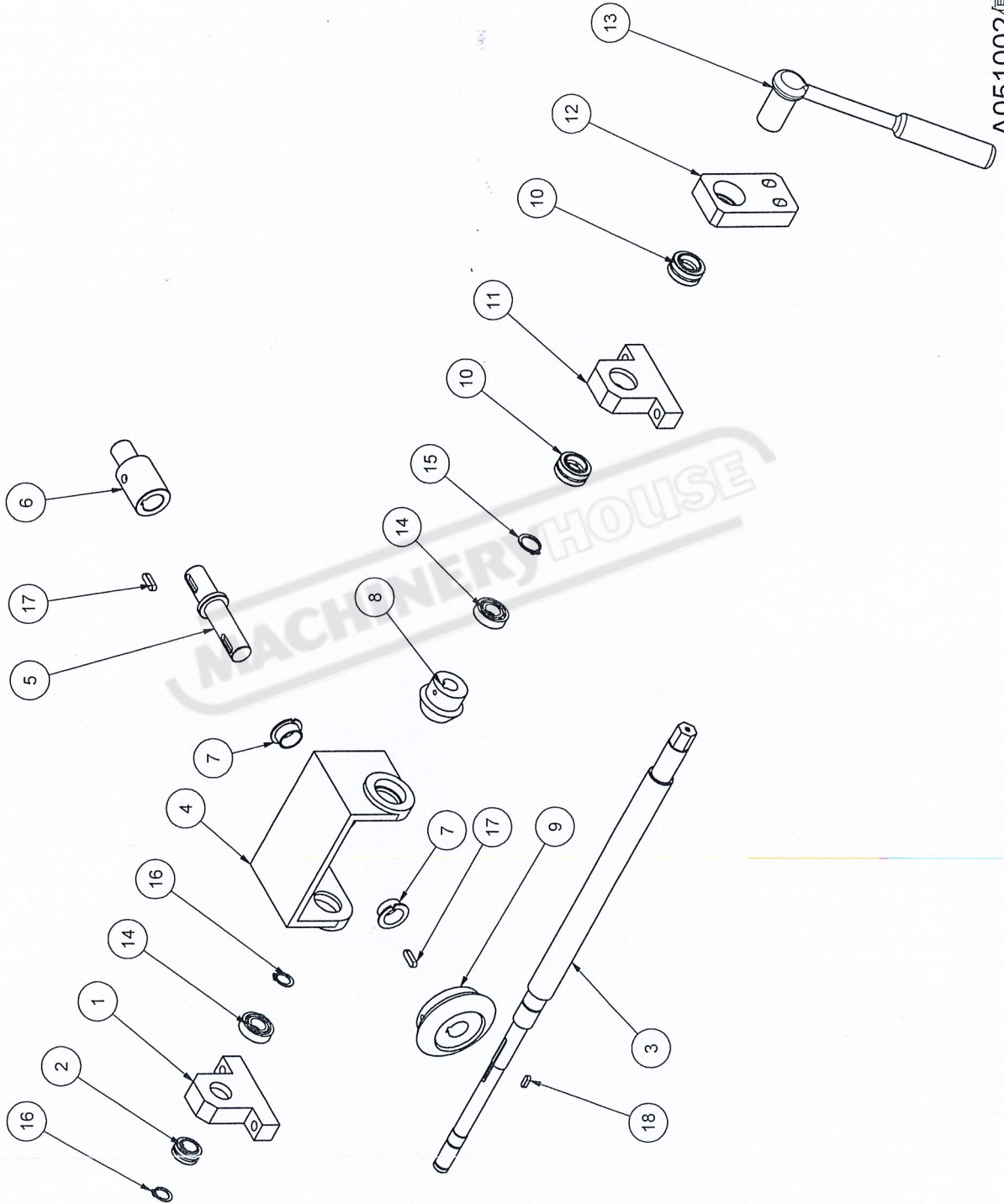
A051001床台組爆炸圖

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0.2/▽	1.6/▽	6.3/▽	25/▽	▽

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	2	H05030600	WEARABLE PLATE				
2	2	B02031200	BASE				
3	1	H05130200	LIFT UP ROLLER				
4	1	H05030100	FIXED TABLE				
5	1	H05131600	FIXED VISE				
6	4	B02130700	SCREW				
7	1	H05131500	MOVABLE VISE				
8	2	H05130600	LEVER ARM				
9	2	B02031000	ROLLER STAND				
10	2	H05130100	BASE				
11	2	2DU3525	LUBRICATING BEARING				
12	4	B02032700	PIN				
13	1	B02130200	SCREW				
14	4	H05030700	PLATE				
15	1	A050004	CYLINDER UNIT OF TABLE VISE				
16	1	H05030500	MOVABLE VISE				
17							
18							
19							
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22							
23							
24							
25							

A051001 TABLE UNIT

▽▽▽	▽▽	▽▽	▽	~
0.2	1.5	5.3	25	▽

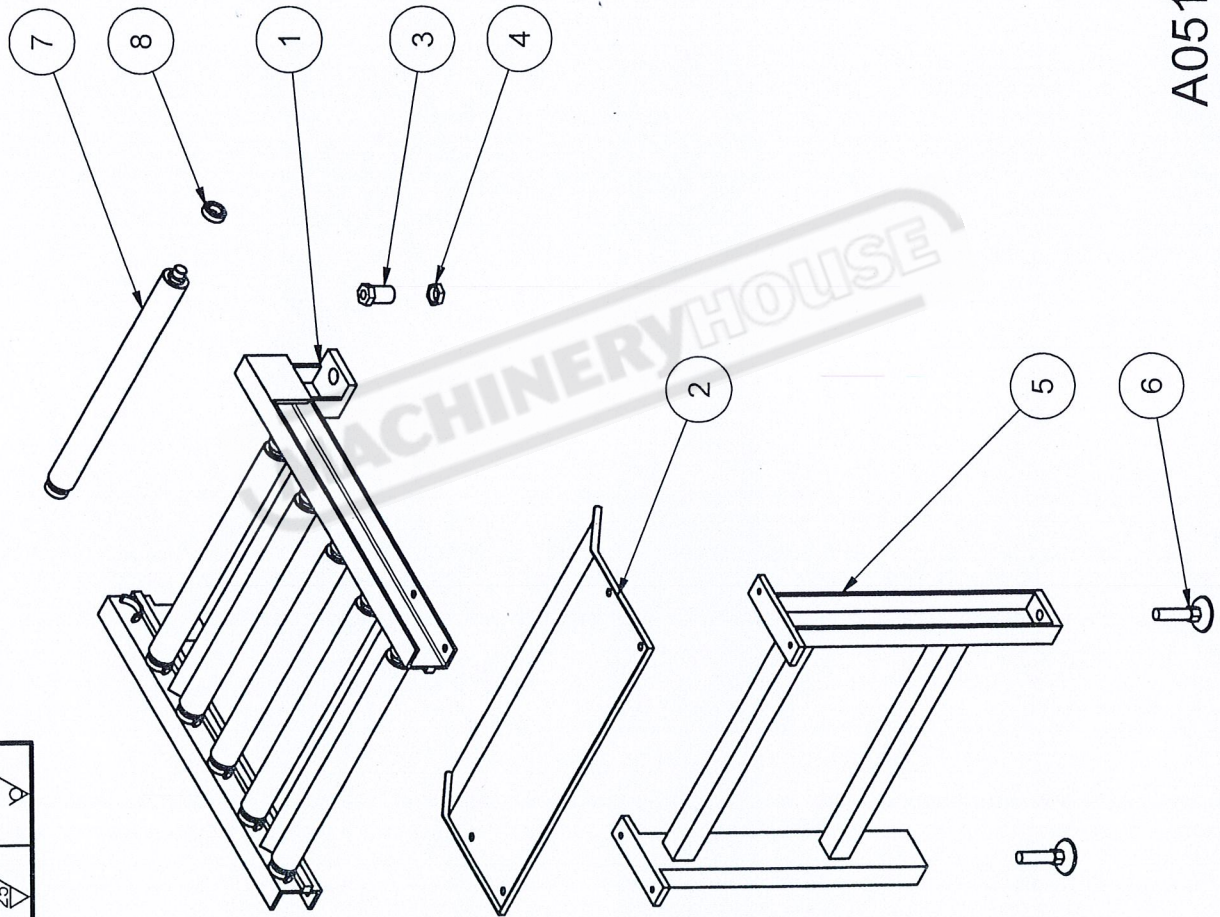


A051002傳動送料組爆炸圖

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	1	H05131100	BRACKET				
2	1	SB15	BEARING				
3	1	H05130700	ROD				
4	1	H05131000	GEAR BOX				
5	1	H05130900	SHAFT				
6	1	H05131200	SHAFT				
7	2	2DUF2010-31	LUBRICATING BEARING				
8	1	B02022901	SMALL GEAR				
9	1	B02023000	SLANT GEAR				
10	2	SB20	BEARING				
11	1	H05130800	BRACKET				
12	1	B02032400	ADJUSTING BASE				
13	1		WRENCH				
14	2	6002	BALL BEARING				
15	1	ϕ 20	C TYPE RETAINING RING				
16	2	ϕ 15	C TYPE RETAINING RING				
17	2	6 x 6 x 20	ROUND KEY				
18	1	5 x 5 x 15	ROUND KEY				
19							
20							
21							
22							
23							
24							
25							

A051002 TRANSMITTING UNIT

▽▽▽	▽▽	▽▽	▽	~
0.2/▽	1.6/▽	6.3/▽	25/▽	▽



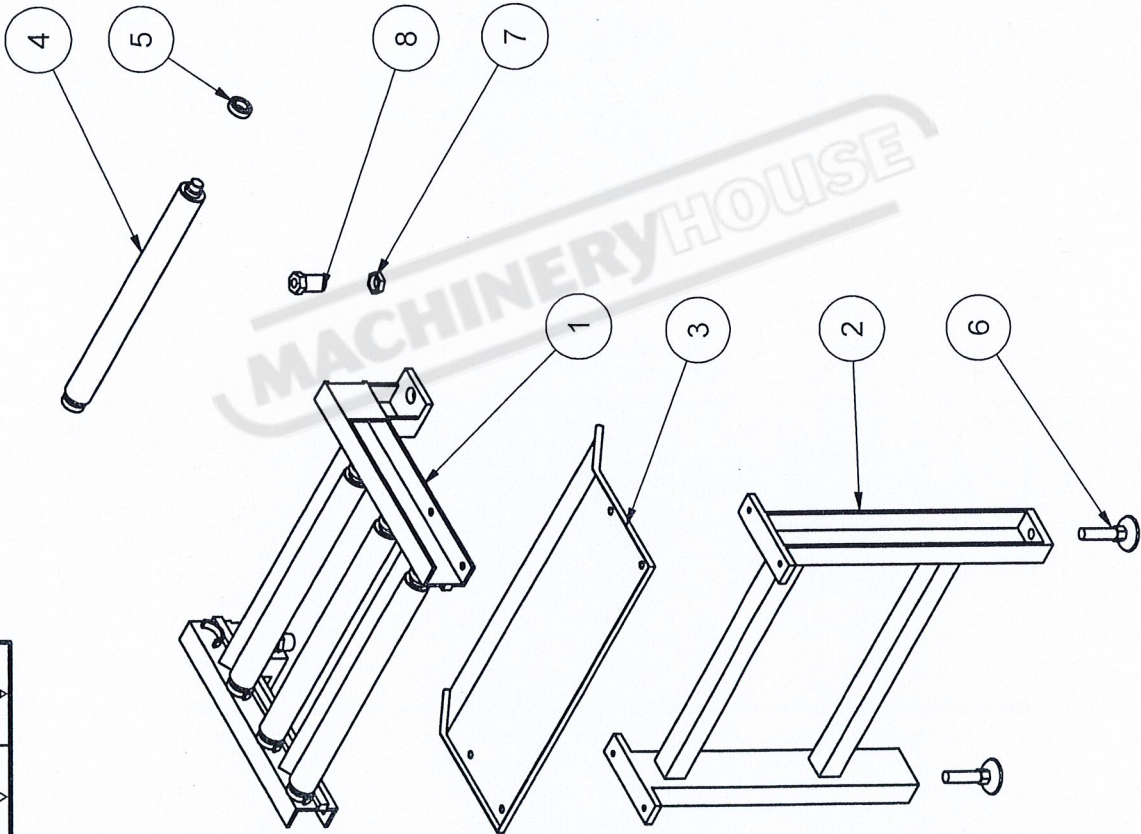
A051004後撐料架組爆炸圖

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	1	H05130300	BACK MATERIAL HOLDER				
2	1	H05111600	PLATE				
3	2	H05130500	ADJUSTING SCREW				
4	2	H06043300	NUT				
5	1	H05130400	STAND				
6	2		PAD				
7	6	H03230900	ROLLER				
8	12	6005	BALL BEARING				
9							
10							
11							
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A051004 BACK MATERIAL HOLDER

A051005前撐料架組爆炸圖

▽▽▽	▽▽	▽▽	▽	~
0.2/▽	1.6/▽	6.3/▽	25/▽	▽



MACHINERYHOUSE

NO	Q'TY	TYPE	DESCRIPTION	NO	Q'TY	TYPE	DESCRIPTION
1	1	H05131300	FRONT MATERIAL HOLDER				
2	1	H05130400	STAND				
3	1	H05111600	PLATE				
4	4	H03230900	ROLLER				
5	8	6005	BALL BEARING				
6	2		PAD				
7	2	H06043300	NUT				
8	2	H05130500	ADJUSTING SCREW				
9							
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A051005 FRONT MATERIAL HOLDER

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
1	1	2p90i	HYDRAULIC MOTOR + PUMP	30	1	7.5HP-132S	MOTOR
2	1	H05010300	PULLEY COVER	31	2	3M530L	BELT
3	2	B02011000	PLATE	32	1	3M530L	BELT
4	1	B02012600	CABINET BASE	33	1		HANDLE
5	1	B02023200	SHAFT	35	1	AS-1942-1	
6	1	B02043200	ADJUSTING SCREW	36	1	AS-1942	
7	1	B02112301	CONTRIBUTION CABINET	37	2	6201	BALL BEARING
8	1	H03213400	COVER	38	1	H03221800	BASE
10	1	H02213600	PLATE	39	1	B02022200	SHAFT
11	1	H03221000	SHAFT	40	1	B02112300-1	PLATE
12	1	H05110100	BASE	41	1	B02112300-2	
13	1	H05010200	SAW BOW	42	1	B02112300-3	
14	1	H05010500	COVER (DRIVING WHEEL)	43	1		CONTROL PANEL
15	1	H05012400	FIXED BASE	44	1		CONTROL PANEL
16	1	H05010600	COVER (DRIVED WHEEL)	45	1	H03221700	PULLEY
17	1	H05010700	ANTI-SPLASH PLATE	46	1	H05010900	COVER
18	1	H03211100	PLATE	47	1	B02043100	SECONDARY SLIDING TUBE
19	1	H03211900	COVER (WIRE BRUSH)	48	1	H03240400	ADJUSTING BASE
20	1	H05010400	COVER	49	1	H05040500	GUIDE WAY
21	1	H03213200	PLATE	50	1	H05010300-1	
22	1	H03220100	BASE	51	1	H05011800	PLATE
24	1	H03220300	PULLEY	52	1	H05011900-1	BLADE PROTECTOR
25	1	H05020100	PULLEY	53	1	H05011900	BLADE PROTECTOR
28	1	H03240800	VERTICAL MAIN COLUMN	54	1	H03241000	ADJUTANT COLUMN
29	1	SW5980-41W-1.3T	SAW BLADE	55	2	H05040900	BLOCK

H-5552SA METAL STRUCTURE

NO	QTY	TYPE	DESCRIPTION	NO	QTY	TYPE	DESCRIPTION
56	1	B02043000	SLIDE TUBE	82	2	H07011300	PLATE
57	1	H05040300	CONNECTING BASE	83	1	H03221601	ADJUSTING SCREW
58	1	H03213500	PLATE	84	1	H05020400	MOTOR STAND
59	1	B02014900	SWITCH BASE				
60	1	H05110200	PLATE				
61	1	B02010800	PLATE				
62	1	H05110300	BASE				
63	1		WRENCH				
64	1	B02110500	PLATE				
65	1	H05110400	PLATE				
66	1	H05110600	SWITCH BASE				
67	1	H05111000	ROD OF HEIGHT				
69	1	H05111400	PLATE				
70	1	H05111500	SWITCH BASE				
71	2	2DU15080	LUBRICATING BEARING				
72	2	D180-d150-B14	OIL SEAL				
73	2	2DU8060	LUBRICATING BEARING				
74	2	D105-d80-B13	OIL SEAL				
75	1	H05012800	BLADE PROTECTOR (UPPER)				
76	1	B02044300	PIN				
77	1	B02015100	HOCK				
78	1	H07014100	INSIDE COVER				
79	1	H07014300	LIGHT BASE				
80	1	H07014700	INDICATOR OF HEIGHT				
81	2	H07013400	PLATE				

H-5552SA METAL STRUCTURE.