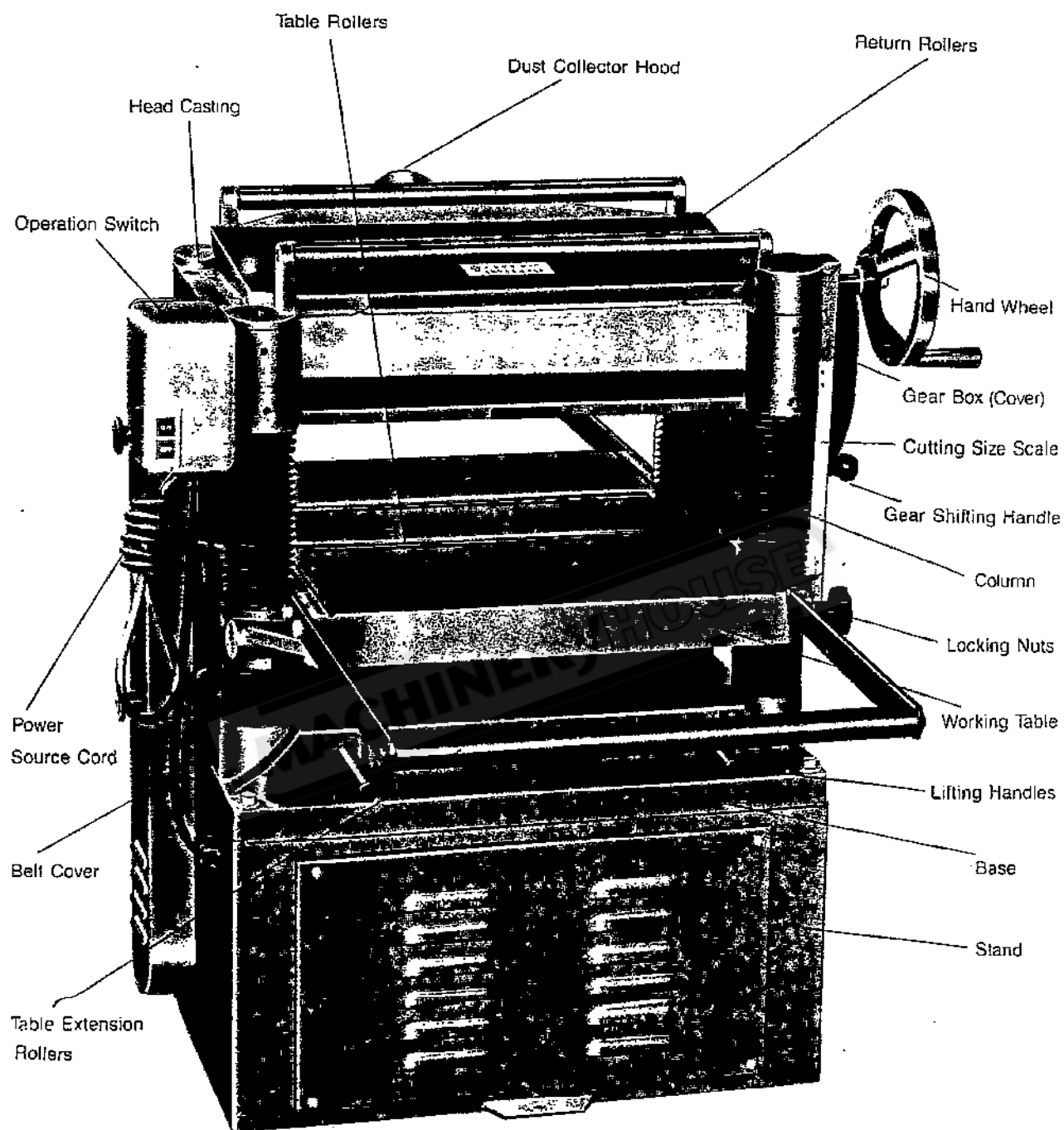


INSTRUCTION MANUAL

NSW Schools / TAFE - T-20 Thickener (415V) 508mm



K8170



GENERAL SAFETY INSTRUCTIONS

1. KEEP GUARDS IN PLACE.

Safety guards must be kept in place and in working order.

2. REMOVE ADJUSTING KEYS AND WRENCHES.

Before turning on machine, check to see that the keys, chucks and adjusting wrenches are removed from the tool.

3. REDUCE THE RISK OF UNINTENTIONAL STARTING.

Make sure switch is in the OFF position before plugging in the tool.

4. DO NOT FORCE TOOLS.

They will do a job better and safer at the rate for which they were designed.

5. USE RIGHT TOOL.

Do not force a tool or an attachment to do a job for which it was not designed.

6. SECURE WORK.

Use clamps or a vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tools.

7. MAINTAIN TOOLS WITH CARE.

Keep tools sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.

8. DISCONNECT TOOLS FROM POWER.

Before servicing, or when changing accessories such as bits, blades, cutters, etc. disconnect from power.

9. USE RECOMMENDED ACCESSORIES.

Consult the owner's manual for recommended accessories. The use of improper accessories may cause risk of injuries.

10. CHECK DAMAGED PARTS.

Check for alignment of moving parts, binding of moving

parts, breakage of parts, mounting, and any other conditions that may affect the tools operation. A guard or other part that is damaged should be properly repaired or replaced.

11. TURN POWER OFF. NEVER LEAVE TOOL RUNNING UNATTENDED.

Do not leave tool until it comes to a complete stop.

12. KEEP WORK AREA CLEAN.

Cluttered areas and benches invite accidents.

13. DO NOT USE IN DANGEROUS ENVIRONMENT.

Do not use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.

14. KEEP CHILDREN AWAY.

All visitors should be kept at a safe distance from the work area.

15. MAKE WORKSHOP CHILD PROOF.

Use padlocks, master switches, and remove starter keys.

16. WEAR PROPER APPARREL.

Loose clothing, gloves, neckties, rings, bracelets or other jewelry may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.

17. ALWAYS USE SAFETY GLASSES AND DUST MASKS.

Use face or dust mask if cutting operation is dusty. Every day eyeglasses only have impact resistant lenses, they ARE NOT safety glasses.

18. DO NOT OVERREACH.

Keep proper footing and balance at all times.

19. NEVER STAND ON TOOL.

Serious injuries could occur if a moving part is unintentionally contacted..

ADDITIONAL SAFETY RULES FOR AUTO-FEED PRECISION PLANER

1. If you are not thoroughly familiar with the operation of planers, obtain advice from your supervisor, instructor or other qualified person.
2. Keep cutterhead sharp and free of all rust and pitch.
3. Check material for loose knots, nails and other defects.
4. Remove shavings only with the power off.
5. Keep hands away from the top surface of the board near the feed rolls.
6. Check that switch is in OFF position before plugging in power cord.
7. Before moving table upward or downward, loosen locking knobs.
After choosing the proper position tighten locking knobs.
The locking knobs are on the right side of machine as shown in PG 6.
8. Be sure the knives of cutterhead are correct and all hex screws are secured tightly before use.
9. Keep hands away from the feed rolls and the cutterhead.
10. Do not operate machine while the gear cover is open.
11. Remove adjusting tools and loose articles from machine before operating.

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UNPACKING AND CLEANUP

To ensure maximum performance from your planer, clean it properly; and install it accurately before use.

As soon as you receive the planer, we recommend you follow these Procedures:

1. Inspect packing crate for damage in transit. Record damage and report it immediately to shipper.
2. Open crate and check that machine arrived in good condition. If not, let your industrial distribution know immediately.
3. Before lifting machine, remove all bolts locking it to its shipping base.
4. Transport machine to location with a hand truck or dolly.
5. Remove the protective coating from the table, bed rolls, feed rolls, cutterhead and loose items packed with the machine, including lifting handles and motor pulley.
This coating may be removed with a soft cloth moistened with Kerosene.
NOTE: Do not use acetone, gasoline, or lacquer thinner for this purpose.
7. Do not use solvents on plastic parts; solvents dissolve or damage plastic.
8. Care must be taken when cleaning the cutterhead as the knives are in the cutterhead and knives are very sharp.

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Lifting Handles

There are four lifting handles, furnished. All lifting handles are of hidden type. Pull the handles out for use, push in when not in use. Two of the lifting handles (A) are as shown in Fig. 1

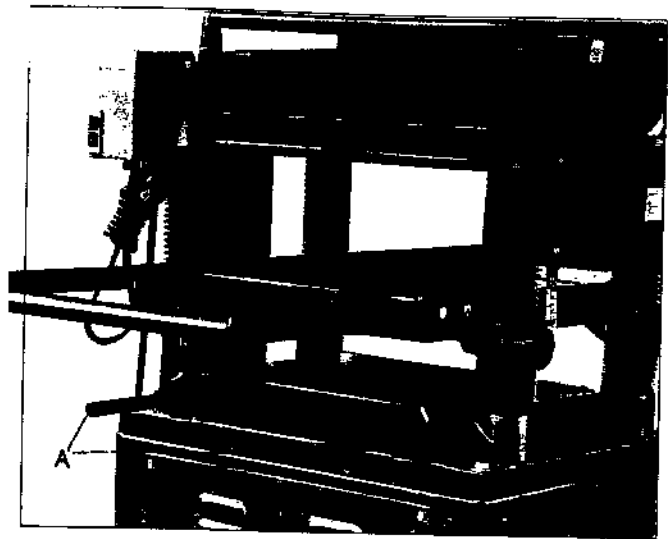


Fig. 1

Lifting Planer

Any type of sling is used to lift machine. be sure to attach to lifting handles only. Be sure that machine is kept in level position while lifting, as shown in Fig. 2

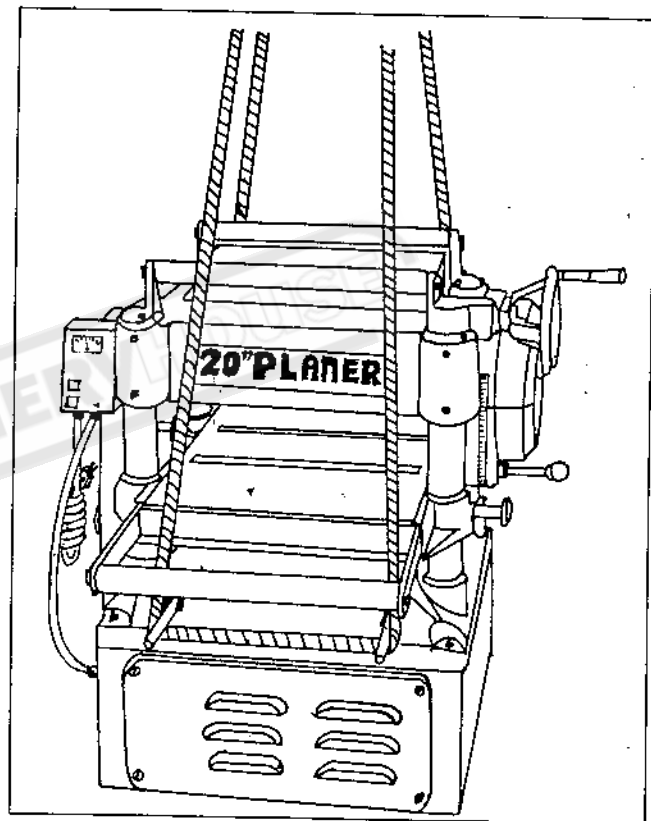


Fig. 2

Stand Assembling

For best planing performance, locate planer on solid, level foundation. With machine in position, test table surface lengthwise and crosswise with machinist level. Place metal jacks under low corners. Check that all four corners are supported, then tighten lag screws, retest level of table surface in both directions; and adjust if necessary.

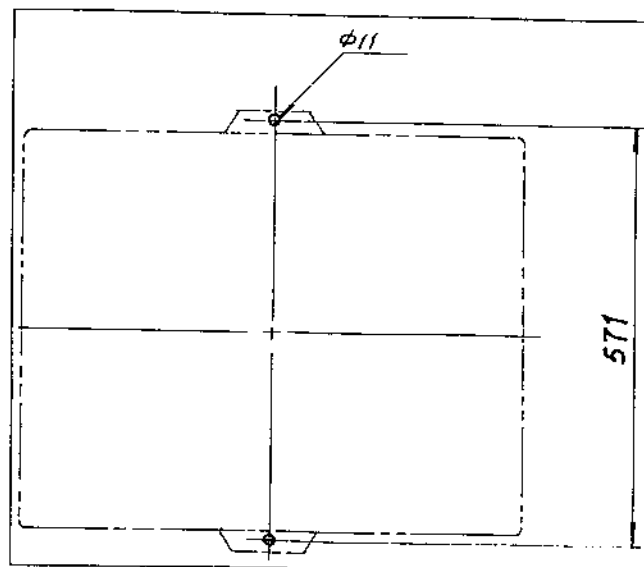


Fig. 3

Lubrication Guide Of CT-508 Auto-Feed Precision Planer

No.	Position	Interval	Suitable Types of Oil	Fig. No.
1	Chain	Frequently	Grease	4
2	Gear Box	When operated more than 2,500 hours	HD-100, Mobil Gear 627, Shell Omala 100, ESSO Spartan EP-100	4
3	Rollers	Frequently	SAE-30	5
4	Worm Gear	Frequently	Grease	6
5	Lead Screw	Frequently	Grease	6
6	Column	Frequently	Clean and SAE-30	6
7	Chain	Frequently	Grease	7
8	Bushing	Frequently	SAE-30	8

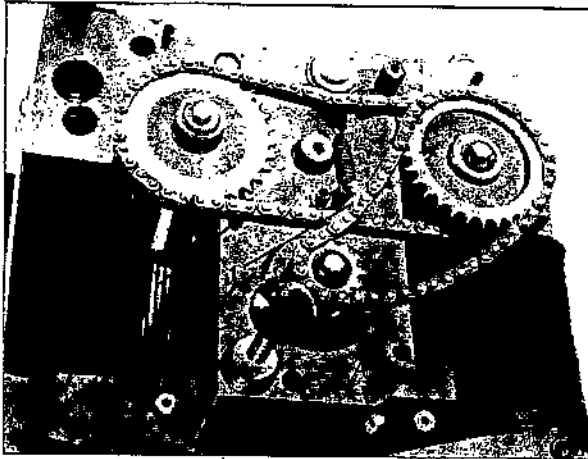


Fig. 4

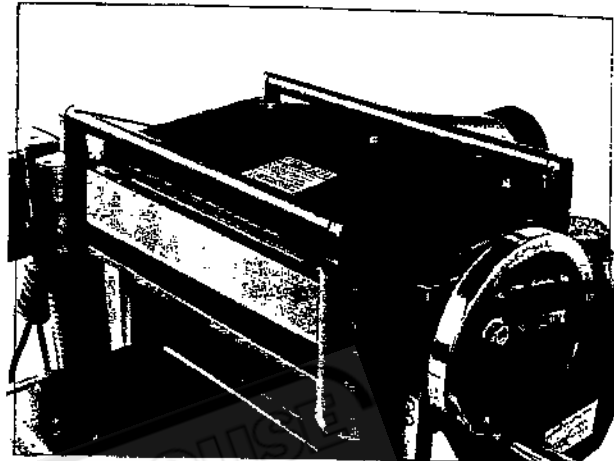


Fig. 5



Fig. 6

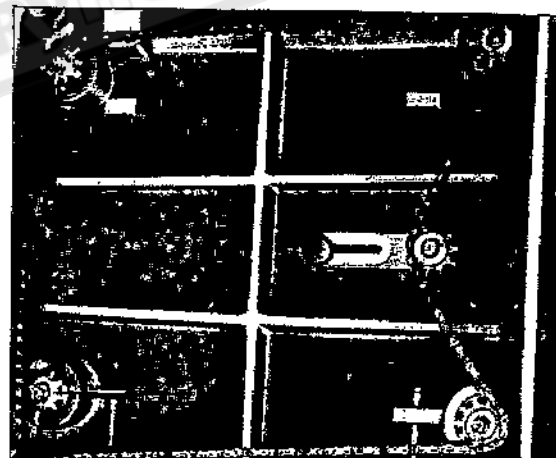


Fig. 7

Lubrication Guide of Gear Box:

The gear box lubricant must be replaced every 2,500 hours. Suitable lubricant is multi purpose gear box lubricant.

To Replace Lubricant:

1. Remove the drain plug (A), Fig. 4 and filler Cap (B), Drain dirty oil thoroughly.
2. Tighten the drain plug (A).
3. Fill with clean lubricant through hole (B).
4. Tighten the filler cap (B).

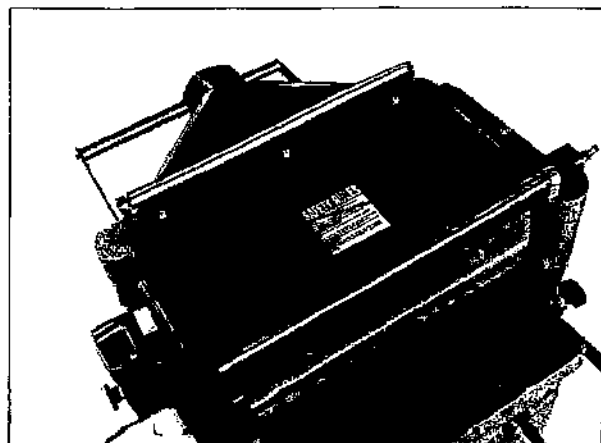


Fig. 8

Assembling And Aligning Motor, Motor Pulley And Belt:

1. Assemble the motor pulley to the motor shaft with the key and tighten the screw in the motor shaft, as shown in Fig. 9.

2. Assemble the motor to the motor mounting plate, as shown in Fig. 10.

NOTE: It is very important that the motor must be mounted to motor plate by using the mounting hardware (A) Fig. 10

Using a straight edge, align the motor and cutter-head pulleys as shown in Fig. 11, the motor plate (B) Fig. 10 can be moved for alignment by loosening the set screws (C) in the motor plate (B) as shown in Fig. 10

Assemble the belts to the two pulleys, as shown in Fig. 11. And adjust for the proper belt tension by raising or lowering the motor plate, as shown in Fig. 12, then tighten the nuts (A) Fig. 12. Correct tension is obtained when there is approx. 1/4" deflection of the center span of the pulleys by using light finger pressure.



Fig. 9

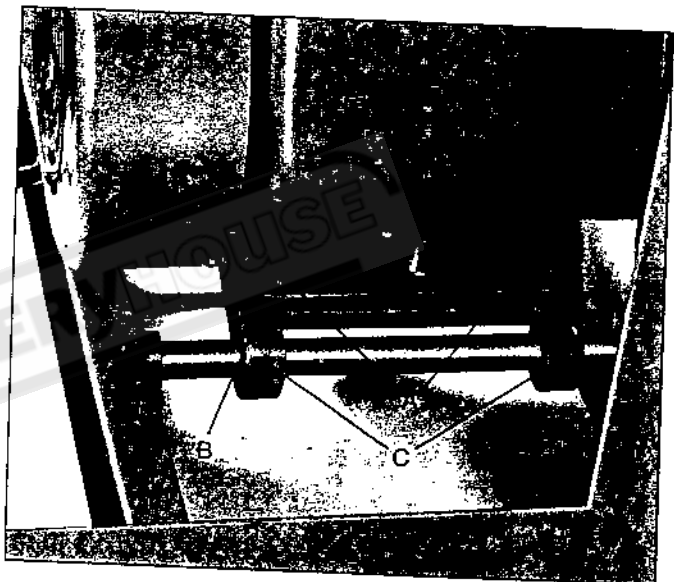


Fig. 10

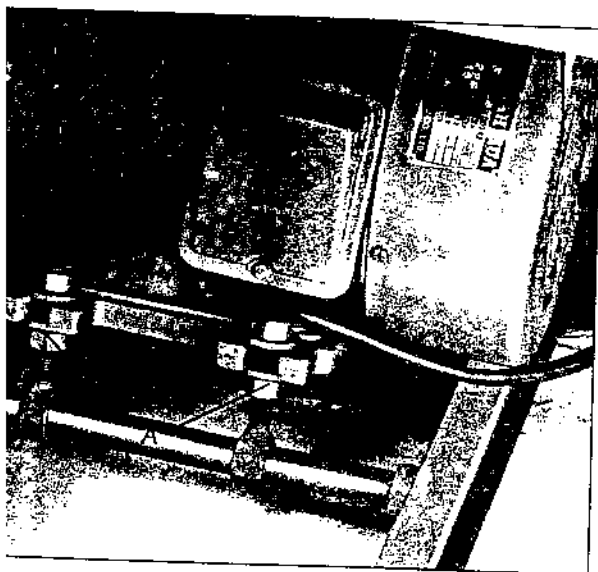
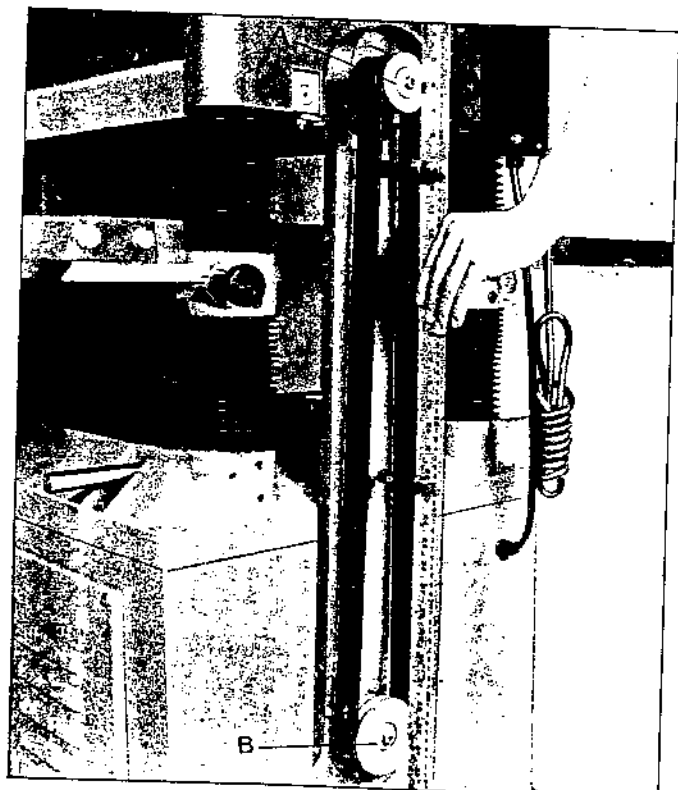


Fig. 12



Adjusting Table Rollers

Your planer is supplied with two table rollers (A) Fig. 13, which aid in feeding the stock by reducing friction and turn as the stock is fed through the planer. It is not possible to give exact dimensions on the proper height setting of the table rollers because each type of wood behaves differently.

As a general rule, however, when planing rough stock, the table rollers should be set at high position, and when planing smooth stock the table rollers should be set at low position.

NOTE: The raising range between 0.003" - 0.006" when raising the roller higher above table as shown in Fig. 14.

The Table Rollers on your planer are set for average planing and are parallel to the table surface. If you desire to adjust the table rollers higher or lower, proceed as follows:

1. Disconnect machine from the power source.
2. Lay a straight edge (A) Fig. 15 across both rollers, loosen the screws (B) Fig. 15, and turn the eccentric shafts (C) to raise or lower the table rollers, when the proper height is obtained tighten screws (B) as shown in Fig. 15. Table rollers must be adjusted on the opposite end of table in the same manner.

NOTE: 1. Be sure that the height of front and rear rollers are the same.
2. The table rollers must always be set parallel to the table.

Assembling Table Extension Rollers

The table extension rollers can be mounted to the table for regular position using the Hex. Hd. screws (A) and washers supplied as shown in Fig. 16



Fig. 13

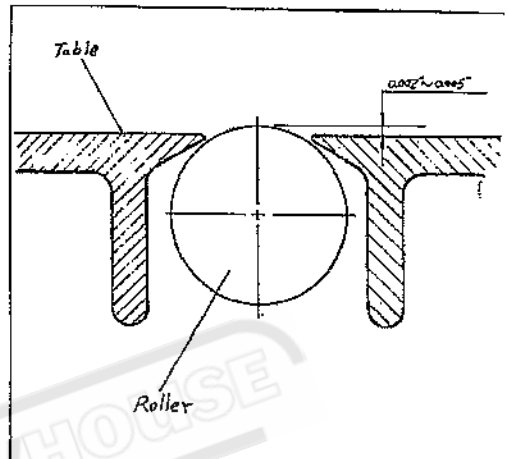


Fig. 14

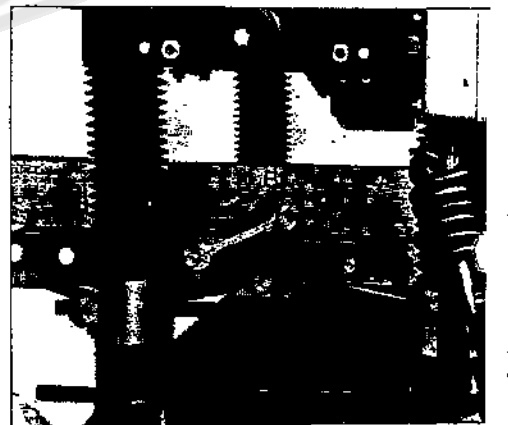


Fig. 15

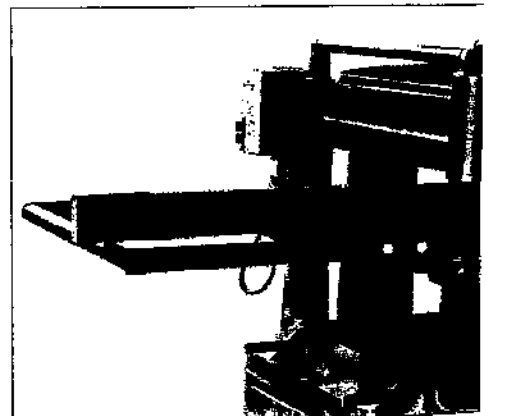


Fig. 16

Adjusting Table Extension Rollers

Place a straight edge between the roller and the table, as shown in Fig. 16 to check the table extension roller and the table are at the same height.

To adjust the table extension rollers, proceed as follows:

Loosen the screws (A) and washer (B) Fig. 17 to move the table extension roller to the proper position, then tighten the screws.

Adjust front and rear table extension rollers in the same manner.

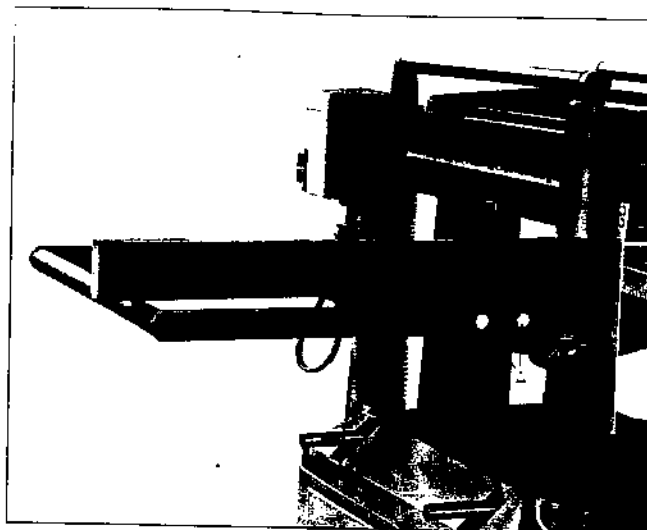


Fig. 17

Controlling The Depth Of Cut

The cutting depth scale is a combination inch/metric scale as shown in Fig. 18, cutting range from 0 to 8" (204mm). The distance of upward or downward movement is controlled by Handwheel (D) in Fig. 18 for one revolution is 0.059" (1.5mm). Before moving the table upward or downward, loosen the lock nuts (C) as shown in Fig. 18. After choosing the proper position, tighten the lock nuts (C).

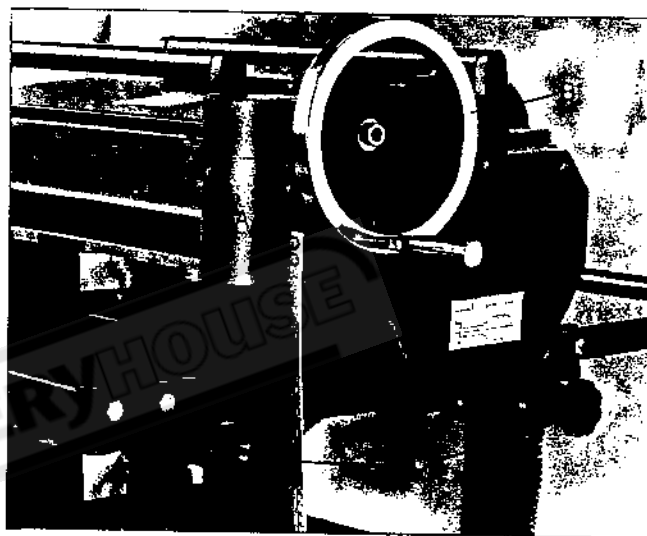


Fig. 18

Adjustments

Though your planer was carefully adjusted at the factory, it should be checked before being put into operation. Any inaccuracies due to rough handling in transit can easily be corrected by following these directions.

In order to check the adjustments you will need a straight edge, feeler gage and a homemade gage block made of hard-wood. This gage block can be made by following the dimensions shown in Fig. 19.

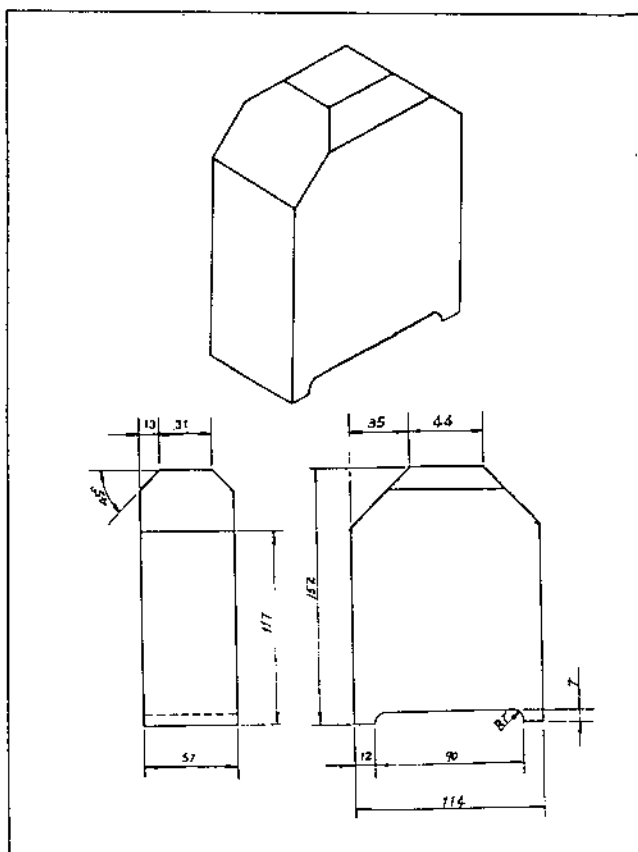


Fig. 19



WARNING

WHEN CHECKING ADJUSTMENTS, ALWAYS MAKE SURE THE PLANER IS DISCONNECTED FROM THE POWER SOURCE.

Checking And Adjusting Of Knives

When checking or adjusting the cutterhead knives, proceed as follows:

1. Disconnect the machine from the power source.
2. Remove the six screws (A), and remove the upper cover (B) as shown in Fig. 20.
3. To check and adjust knives use the knife gage (A) Fig. 22 and check all four knives. Knives should just contact the bottom of the center protrusion (B) of the knife gage, as shown in Fig. 22.
4. If an adjustment to one or more of the knives is necessary, slightly loosen the knife locking bars (C) Fig. 22, of all four knives by turning the 24 locking screws (D) Fig. 22 into the knife locking bars just enough to relieve stress in the cutterhead and not disturb the setting of the knives.
5. Using the knife gage adjust the knife, that must be reset by loosening all six locking screws (D) Fig. 22, by turning them into the knife locking bar. As the knife locking bar becomes loose, lifter springs (E) located under the knife will raise the knife until it comes into contact with the center protrusion (B) of the gage (A) Fig. 22. Then snug up the knife locking bar by lightly backing out the six locking screws (D) against the slot.

NOTE: At this time, only tighten the knife into the slot just enough to hold knife into position.

6. If additional knives must be reset, repeat STEP 5.
7. After all four knives are set with screws just snug, back out and tighten the six screws (D) Fig. 21, 22 against the slot starting with the end screws first, then the center screws until the knife is securely held in the cutterhead. Tighten remaining three knives in the same manner.

NOTE: Double Check all screws for Tightness

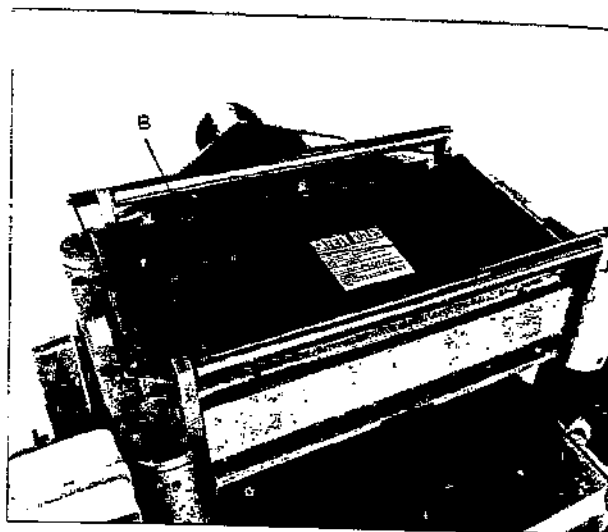


Fig. 20



Fig. 21

Removing And Resetting Of Knives.

When knives are removed for sharpening, care must be exercised in replacing and resetting them, proceed as follows:

1. Disconnect the machine from the power source.

2. Remove six screws (A), and the upper cover (B) as shown in Fig. 20.

3. Remove knife, loosen the knife locking bar (C) Fig. 22, by turning the six knife locking screws (D) into the knife locking bar (C) and remove the knife locking bar (C), knife (F) and springs (E) located under the knives. Please take note, the inner two springs will pop out when removing the knife and knife locking bar.

4. Remove the remaining three knives in the same manner.

5. Thoroughly clean the knife slots, knife locking bars, springs and locking screws. Check the locking screws, if the threads appear worn or stripped or if the heads are becoming rounded, replace them.

6. Inspect the cutting edge of the knives for nicks or wire edge. Hone the knives slightly using a stone or if the knives are to be sharpened, maintain a cutting angle of 15 degrees as shown in Fig. 22.

7. Insert springs (E), knives (F), and knife locking bar (C) into slot of the cutterhead, as shown in Fig. 22. Back out locking screws (D) just enough to hold the knife in the cutterhead.

8. Place the knife gage (A) over the knife as shown in Fig. 22.

9. While holding down on the knife gage (A) Fig. 22, loosen the six locking screws (D) by turning them into the locking bar (C) until cutting edge of knife (F) comes into contact with the protrusion (B) of gage (A). Then snug up the knife locking bar (C) by slightly backing out the six screws (D) against the slot.

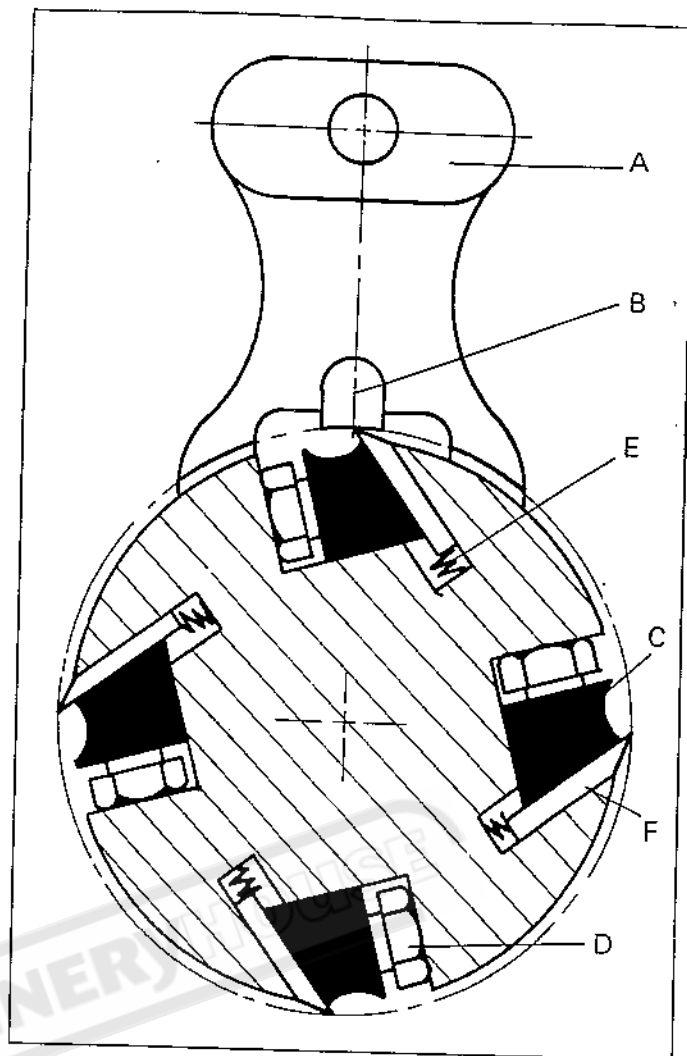


Fig. 22

NOTE: AT THIS TIME, ONLY TIGHTEN THE KNIFE INTO THE SLOT JUST ENOUGH TO HOLD THE KNIFE IN POSITION.

10. Replace and reset the other three knives in the same manner.

11. After all four knives are set with the screws just snug, back out and tighten the six screws (D) Fig. 22, against the slot starting with the end screws first and then the center screws until the knife is securely held in the cutterhead. Tighten the remaining three knives in the same manner.



WARNING

AFTER REPLACING AND CHECKING PLEASE CHECK ONE MORE TIME CAREFULLY. BE SURE THAT THE DIRECTION OF KNIVES IS CORRECT AND ALL 24 LOCKING SCREWS ARE TIGHTENED SECURELY. IT IS VERY IMPORTANT.

Checking Working Table Parallel To Cutterhead

The working table is set parallel to the cutterhead at the factory and no further adjustment should be necessary. If your machine is planing a taper, first check to see if the knives are set properly in the cutterhead. Then check to see if the working table is set parallel to the cutterhead, proceed as follows:

1. Disconnect machine from the power source.
2. Place the gage block (A) Fig. 23 on the working table directly under front edge of head casting (B). Make slight contact by gently raising table as shown in Fig. 23.
3. Move the gage block (A) to opposite end of the working table, as shown in Fig. 24.

IMPORTANT: DISTANCE FROM THE WORKING TABLE TO EDGE OF THE HEAD CASTING SHOULD BE THE SAME.

4. Adjust opposite end in the same manner.

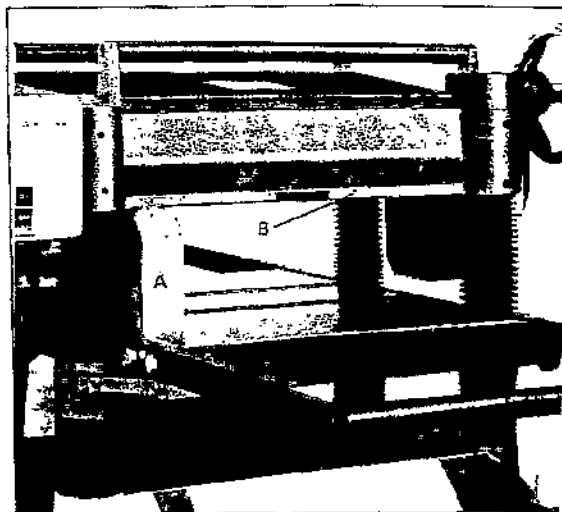


Fig. 23

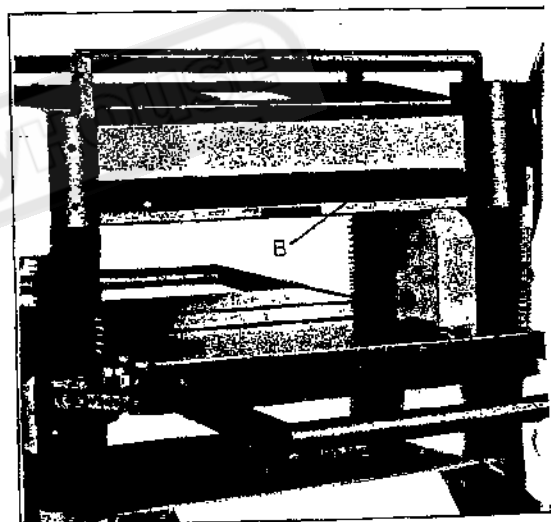


Fig. 24

Adjusting Working Table Parallel To Cutterhead

If the working table is not parallel to the cutterhead, perform the adjustment procedures as follows:

1. Disconnect the machine from power source.
2. Tilt planer on its side to expose underside of base, as shown in Fig. 25
3. Remove bolt (A) and loosen bolt (B) Fig. 25, which will allow you to move the idler sprocket assembly (C) far enough to release tension on chain, as shown in Fig. 26.
4. Remove chain from sprocket on corner of base that must be adjusted. In Fig. 26 chain has been removed from sprocket (D).
5. Turn sprocket (D) Fig. 26 by hand to bring that corner into adjustment with other three corners.

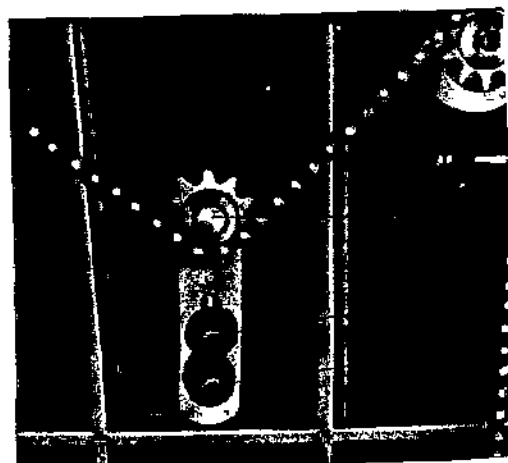


Fig. 25

NOTE: A. Turning sprocket (D), clockwise will increase the distance between the working table and headcasting counter-clockwise will decrease the distance.

B. This adjustment is very sensitive and it should not be necessary to turn the sprocket more than one or two teeth.

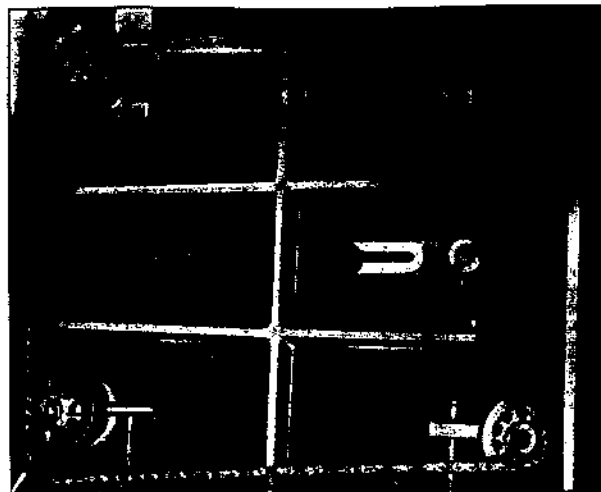


Fig. 26

Know The Transmitting Rollers Of Your Planer

- A. Infeed Roller
- B. Outfeed Roller
- C. Chip breaker
- D. Cutterhead
- E. Pressure Bar
- F. Anti-Kick back Fingers

The infeed roller (A) and outfeed roller (B) Fig. 27 are those parts of your planer that feed the stock while it is being planed. The infeed roller and the outfeed roller are under spring tension and this tension must be sufficient to feed the stock uniformly through the planer without slipping but should not be so tight that it causes damage to the board. The tension should be equal at both ends of each roller.

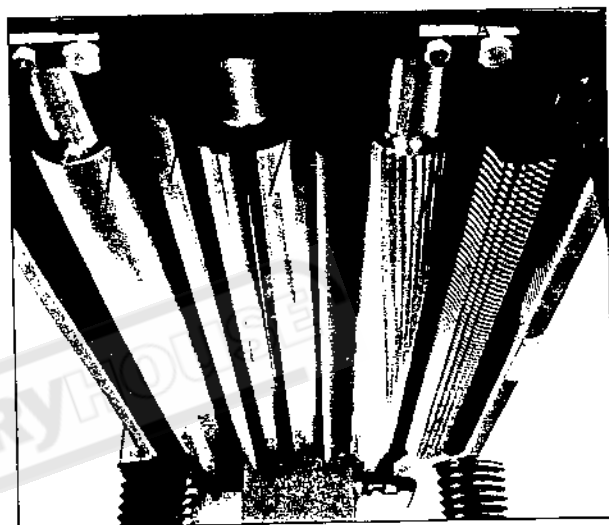


Fig. 27

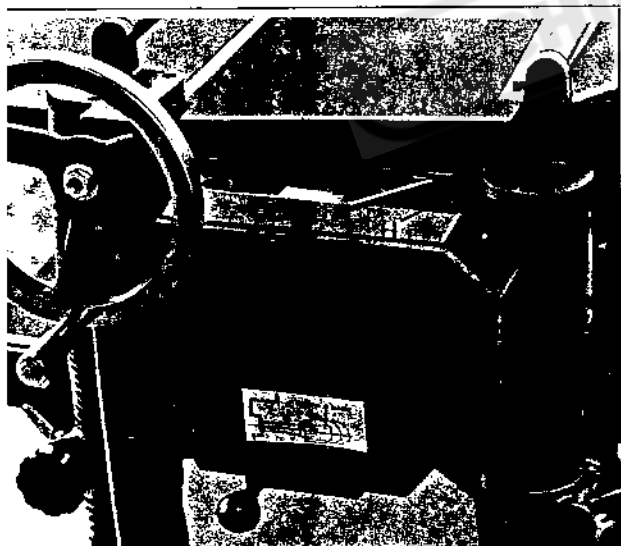


Fig. 28

Adjusting Infeed And Outfeed Rollers Spring Tension

- * To adjust the spring tension of the Infeed/Outfeed roller, turn the screw (G)/(H) Fig. 28. and also the screw on the opposite end of the Infeed/Outfeed roller.

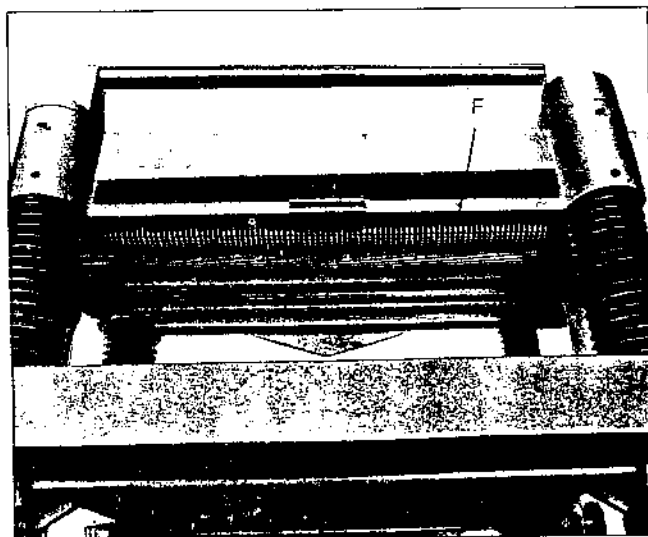


Fig. 29

Anti-Kick Back Fingers

The anti-kickback fingers (F) Fig. 29 are provided on your planer to prevent kickback. These fingers operate by gravity and it is necessary to inspect them occasionally to make sure they are free of gum and pitch so that they move independently and operate correctly.

Checking Adjusting Height Of Infeed Roller, Chipbreaker, Pressure Bar And Outfeed Roller

The infeed roller, chipbreaker, pressure bar and outfeed roller are adjusted at the factory. The infeed roller and the Chipbreaker to be set 0.004" (0.1mm) below the cutting circle, the pressure bar to be set 0.008" (0.2mm) below the cutting circle and the outfeed roller to be set 0.02" (0.5mm) below the cutting circle, as shown in Fig. 30. If an adjustment to the infeed roller, chipbreaker, pressure bar or outfeed roller is necessary, use the manner of the example.

EX. To check and adjust the outfeed roller below the cutting circle 0.02" (0.5mm), proceed as follows:

1. Disconnect machine from the power source.
2. Make sure the knives are adjusted properly as previously explained under CHECKING AND ADJUSTING OF KNIVES.
3. Place the gage block (G) on the table directly underneath the cutterhead, as shown in Fig. 31. Using a 0.02" (0.5mm) feeler gage (H) Fig. 31, placed on top of the gage block, raise the working table until the knife just touches the feeler gage when the knife is at its lowest point. Do not move the working table any further until the outfeed roller is adjusted.
4. Move the gage block (G) under one end of the outfeed roller (B) as shown in Fig. 32. The bottom of the outfeed roller should just touch the top of the gage block. If an adjustment to the outfeed roller is necessary, loosen the lock nut (K) Fig. 32, and turn screw (L) Fig. 32 until the outfeed roller just touches the gage block. Then tighten lock nut (K) as shown in Fig. 32.
5. Check and adjust opposite end of the outfeed roller in the same manner.

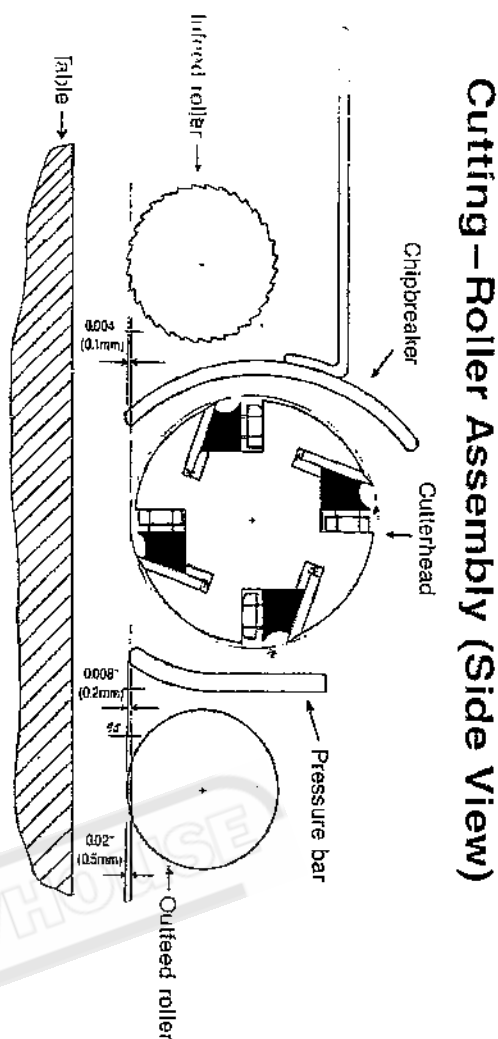


Fig. 30

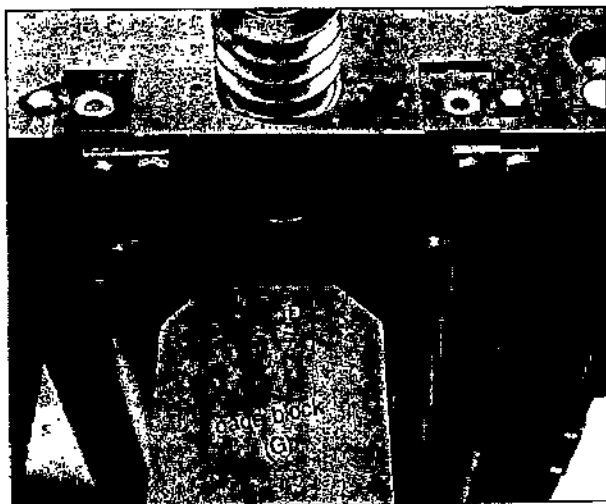


Fig. 31

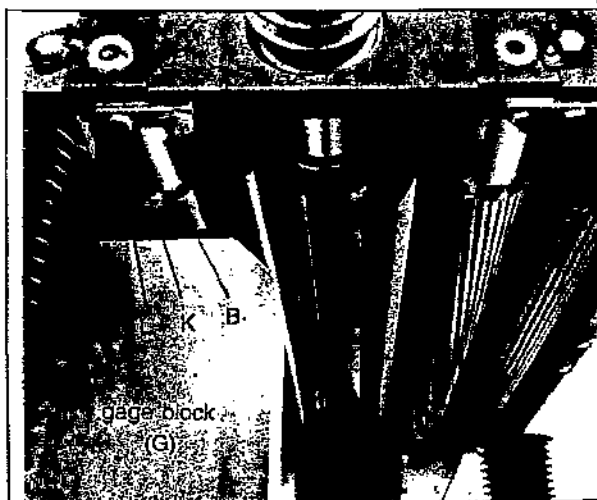


Fig. 32

Feed Speed Control

Your machine is equipped with a spiral, serrated infeed roller and a solid steel outfeed roller. When the feed rollers are engaged, they turn to feed the stock. The Feed rollers slow automatically when the machine is under heavy load for best planing under all conditions. The feed rollers are driven by chains (D) Fig. 33 and the sprockets (E), which takes power directly from the cutterhead through the oil bath gear box (F) Fig. 33.

There are two feed speeds in the gear box by using the shift lever (G) Fig. 33 to pull out or push in, and the feed speed range as shown in Fig. 34.

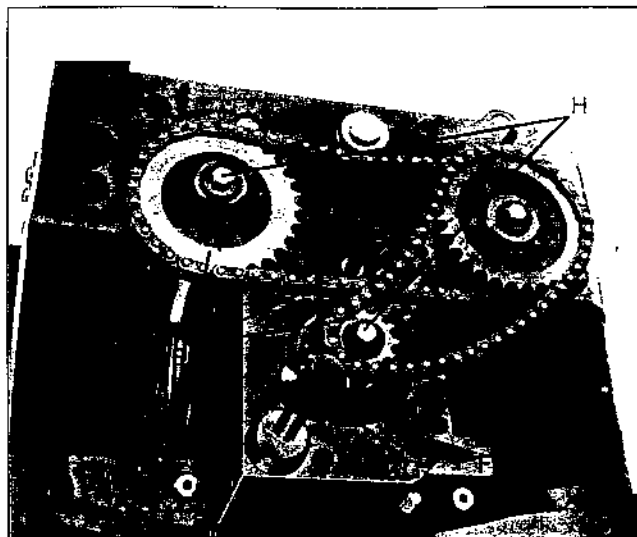


Fig. 33

FEED ROLL SPEED RATE

Speed rate of feed roll is transmitted by shaft gears in gear box.

Shift gears handle, shown as Fig. 34. There are three kinds of operations of gear box by using shaft handle to pull or push. In the position A feed roll is operating on rate 20 FPM. Shown as Fig. 16 In the position B feed roll is operating on rate 0.

In the position C feed roll is operating on rate 16 FPM.

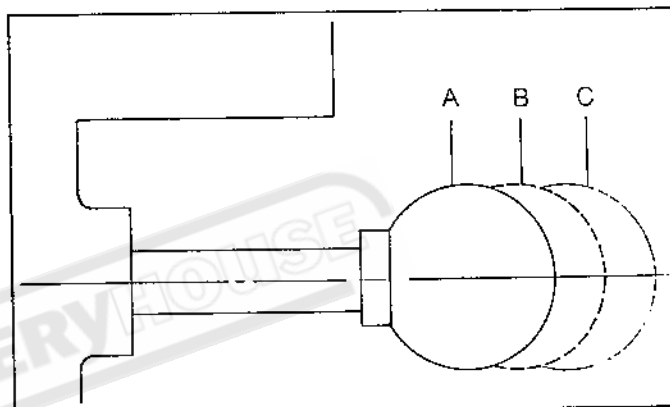


Fig. 34

Return Rollers

The two return rollers (A) Fig. 35 on the top of the machine serve as convenient stock rest. When planed lumber is returned to the infeed side, it saves time and motion, as shown in Fig. 35.

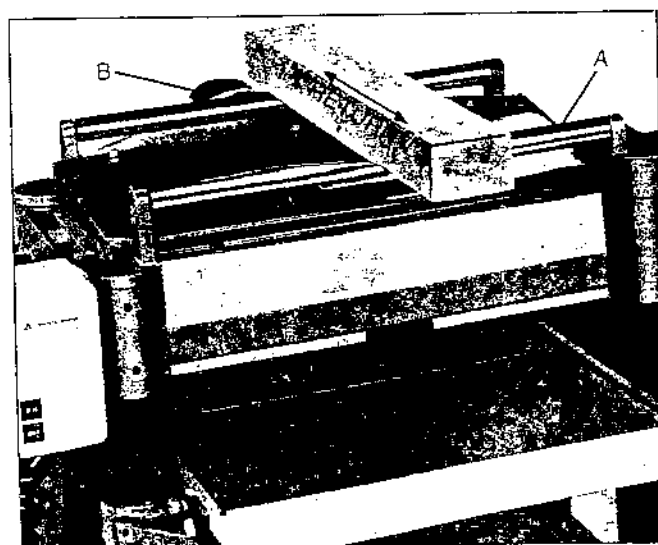


Fig. 35

Accessory Dust Collector Hood

Dust collector hood is standard accessory. Assembled to the rear of the planer using Hex. Hd. Screws and washers. It provides an efficient means of maintaining a clean and safe work area as shown in Fig. 35 (B).

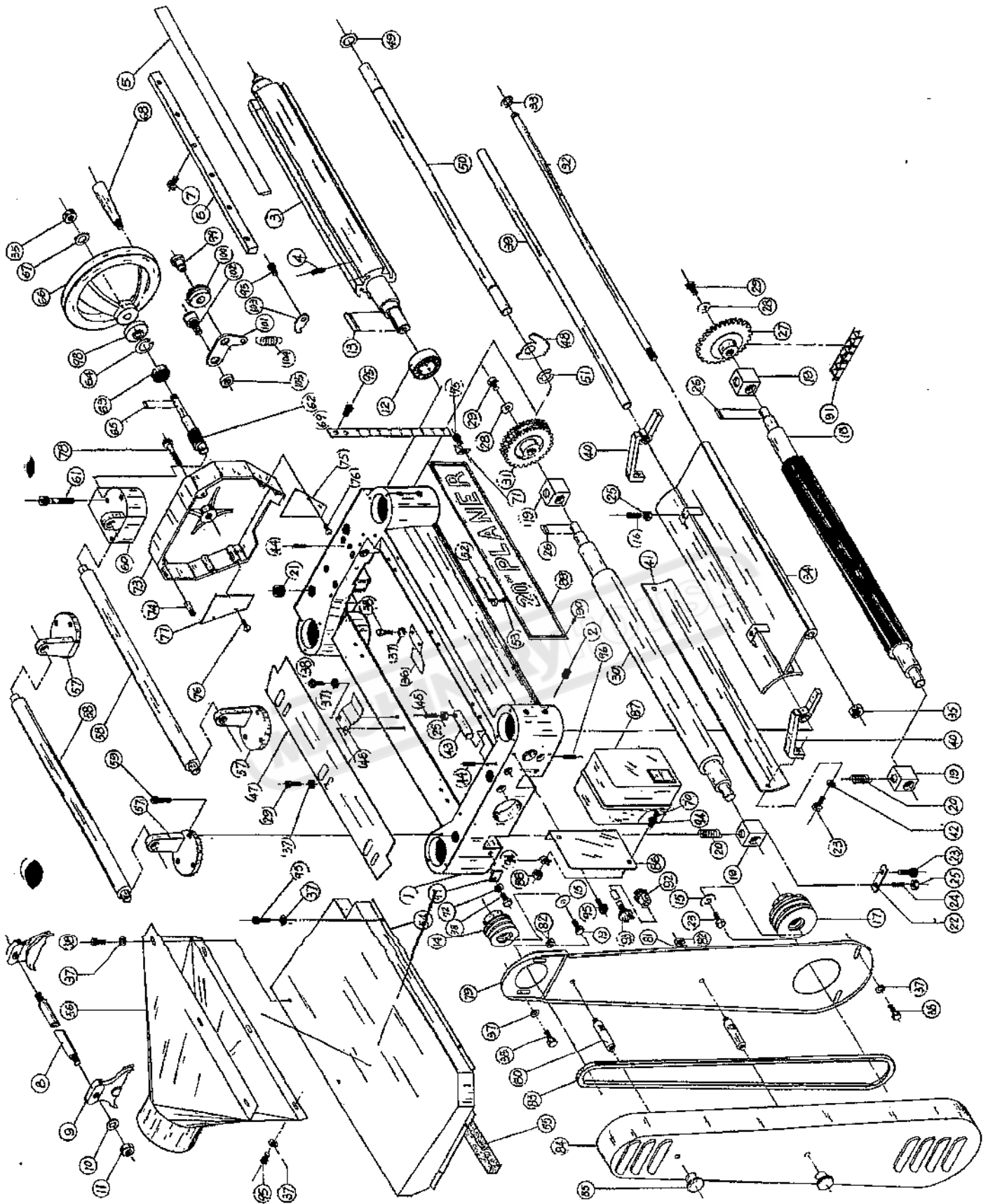


WARNING

IF, AFTER READING THIS MANUAL YOU ARE STILL UNSURE ON HOW TO SAFELY OPERATE THIS MACHINE, DO NOT OPERATE UNTIL YOU HAVE RECEIVED FURTHER INSTRUCTIONS FROM A QUALIFIED PERSON.

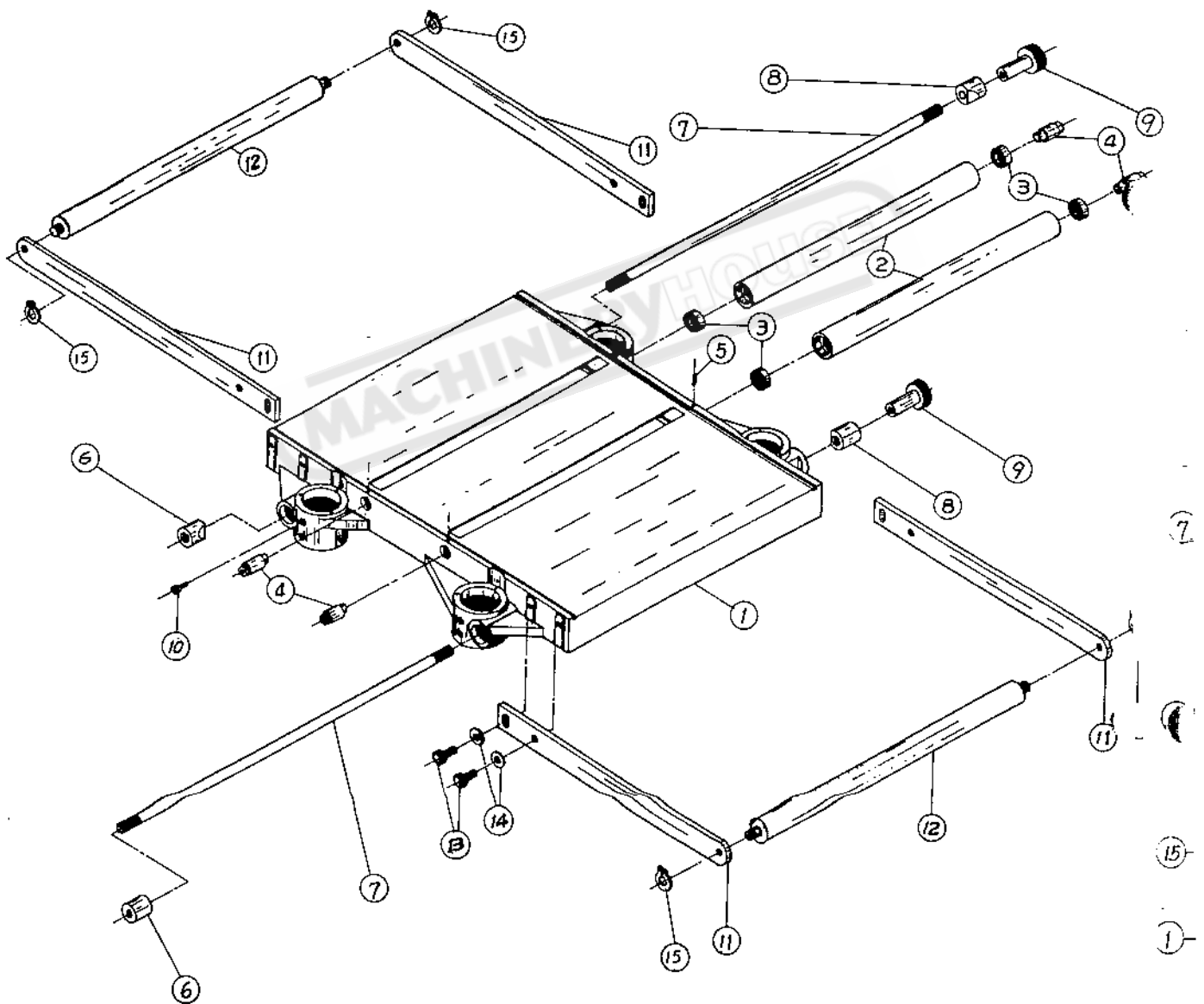
CUTTERHEAD

Index No.	Parts No.	Parts Name	Q'ty	Remark	Index No.	Parts No.	Parts Name	Q'ty	Remark
1	1001	Head Casting	1		53		Flat Hd. Mach		
2		Set Screw	8	M10x1.5P-12"			Scr.	2	M6x1.0P-12
3	1002	Cutter Head	1		54	1034	Upper Cover	1	
4	1005	Spring	8		55	1035	Gasket	1	
5	1006	Knives	4		56	1036	Collector Tube	1	
6	1003	Knife Locking			57	1037	Roller Stand	3	
		Bar	4		58	1038	Roller	2	
7	1004	Hex. Hd. Scr.	24	M8x1.25P-10	59		CAP Screw	9	M6x1.0P-16
8	1008	Club of Knife			60	1039	Worm	1	
		Gage	1		61		CAP Screw	3	M6x1.0P-50
9	1007	Knife Gage	2		62	1040	Worm Gear Box	1	
10		Washer	2	3/8" x 20x2	63		Bearing	1	6201 Z
11		Nut	2	M10x1.25P	64		Retaining Ring	1	RTW-32
12		Bearing	1	6206 ZZ	65		Key	1	4x4x10
13		Key	1	8x8x36	66	1041	Hand Wheel	1	
14	1009	Machine Pulley	1		67		Washer	1	1/2x29x3
15	1011	Washer	2	φ8xφ30x3	68	1042	Handle	1	
16		Set Scr.	2	M6x1.0P-25	69	1043	Scale	1	
17	1010	Motor Pulley	1		70		Machine Screw	2	M5x0.8Px10
18	1012	Infeed Roller	1		71	1044	Cut Limit		
19	1013	Bush	4				Pointer	1	
20	1014	Spring	4		72		Spring Washer	3	M6
21	1015	Screw	4	M22x1.5P-20	73	1045	Cover	1	
22	1016	Plate	4		74		Spring Pin	2	φ6x20
23		Hex. Hd. Scr.	8	M8x1.25P-20	75	1046	Safety Hatch	1	
24		Set Screw	4	M6x1.0P-16	76		Machine Screw	4	M6x1.0P-8
25		Nut	8	M6x1.0P	77	1047	Safety Hatch	1	
26		Key	2	5x5x23	78		CAP Screw	1	M8x1.25P-40
27	1017	Sprocket	1	31"	79	1048	Pulley Guard	1	
28	1018	Washer	2	6.2x22x3	80	1049	Bolt	2	
29		Hex Hd. Scr.	5	M6x1.0P-16	81		Washer	2	5/16" x 16x1.8
30	1019	Outfeed Roller	1		82		Nut	2	5/16"-18NC
31	1020	Sprocket	1		83		Bell	3	
32	1021	Locking Bolt	1		84	1050	Pulley Cover	1	
33		Retaining Ring	1	STW-12"	85	1053	Nut	2	5/16"-18NC
34	1022	Chip Breaker	1		86	1052	Switch Board	1	
35		Nut	2	M12x1.75P	87		Switch	1	
36	1023	Plate Spring	3		88		Nut	2	M5x0.8P
37		Washer	26	1/4x13/1.2	89	1051	Name Plate	1	
38		Hex. Hd. Scr.	20	M6x1.0P-12	90		Rivet	6	
39	1024	Shaft	1		91		Chain	1	06B
40	1026	Bracket	2		92		Relief Bushing	2	
41	1025	Pressure Plate	1		93		Power Supply		
42		Spring Washer	2	M8			Wire	1	
43	1027	Shaft	2		94		Tooth Washer	4	EOW-5
44		Set Screw	3	M6x1.0P-12	95		CAP Screw	14	M6x1.0P-10
45		Set Screw	2	M5x1.0P-20	96		Set Screw	1	M8x1.25P-8
46	1028	Plate Spring	1	0.6"	97	1054	Washer	4	
47	1029	Chip Deflector			98	1055	Collar	1	
		Plate	1		99	1057	Shaft	1	
48	1030	Anti-Kick			100	1058	Idle Pulley,	1	
		Finger	87		101	1059	Bracket	1	
49	1031	Collar	88		102	1060	Shaft	1	
50	1032	Shaft	1		103	1061	Hanger	1	
51		Retaining Ring	2	ETW-15	104	1062	Spring	1	
52	1033	Cut Limiter			105	1063	Collar	1	
		Plate	1						



TABLE

Index No.	Parts No.	Parts Name	Q'ty	Remark	Index No.	Parts No.	Parts Name	Q'ty	Remark
1	2001	Middle Table	1		9	2007	Knob	2	
2	2002	Roll	2		10		CAP Screw	8	M8×1.25P-20
3		Bearing	4	6201 Z	11	2008	Roller Frame	4	
4	2003	Eccentric Shaft	4		12	2009	Roll	2	
5		Set Screw	4	M6×1.0P-12	13		Hex. Hd. Scr.	8	M10×1.5P-25
6	2004	Lock Bar	2		14		Washer	8	3/8" × 20×2
7	2006	Locking Bolt	2		15		Retaining Ring	4	STW-12
8	2005	Locksmith	2						



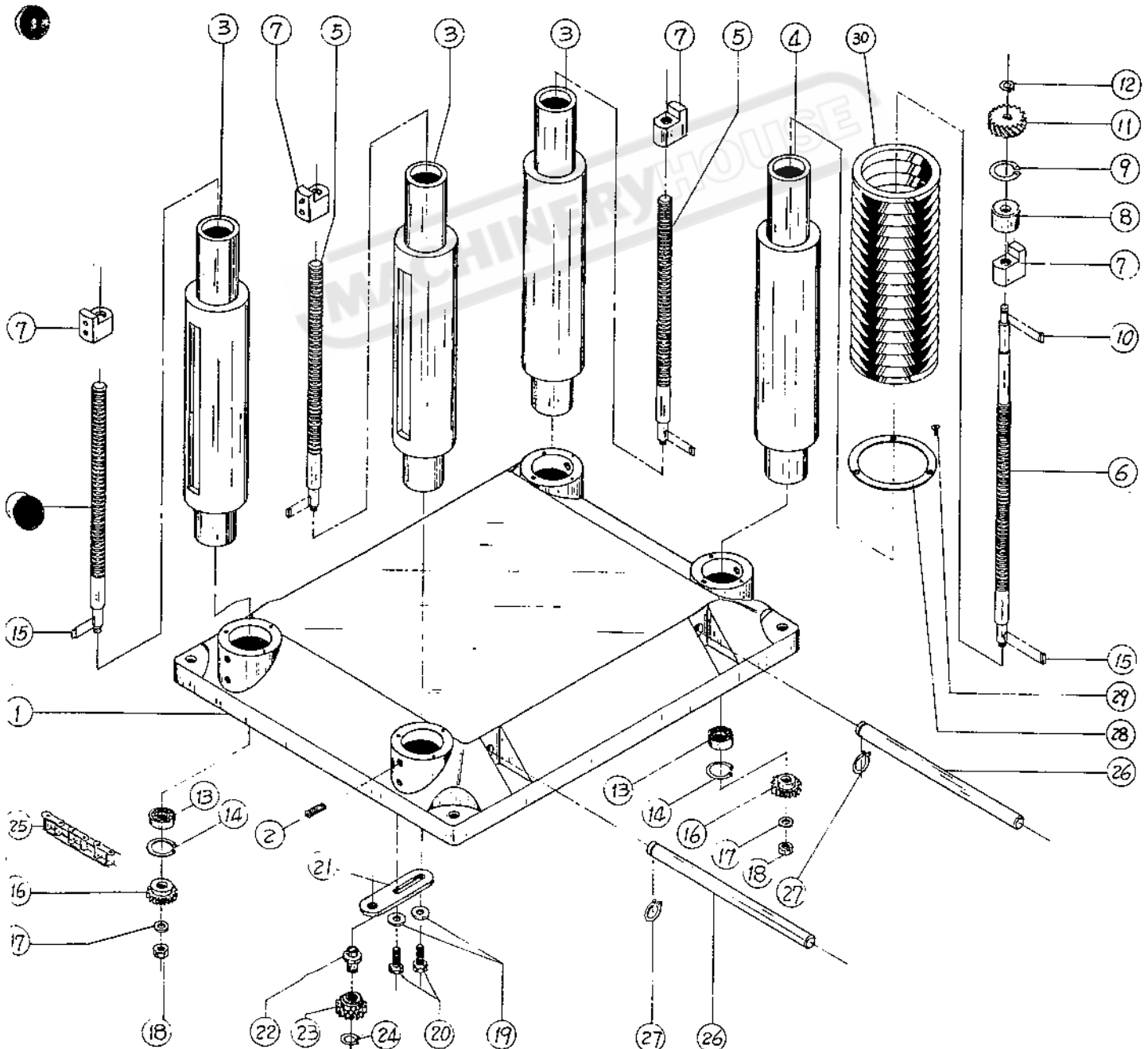
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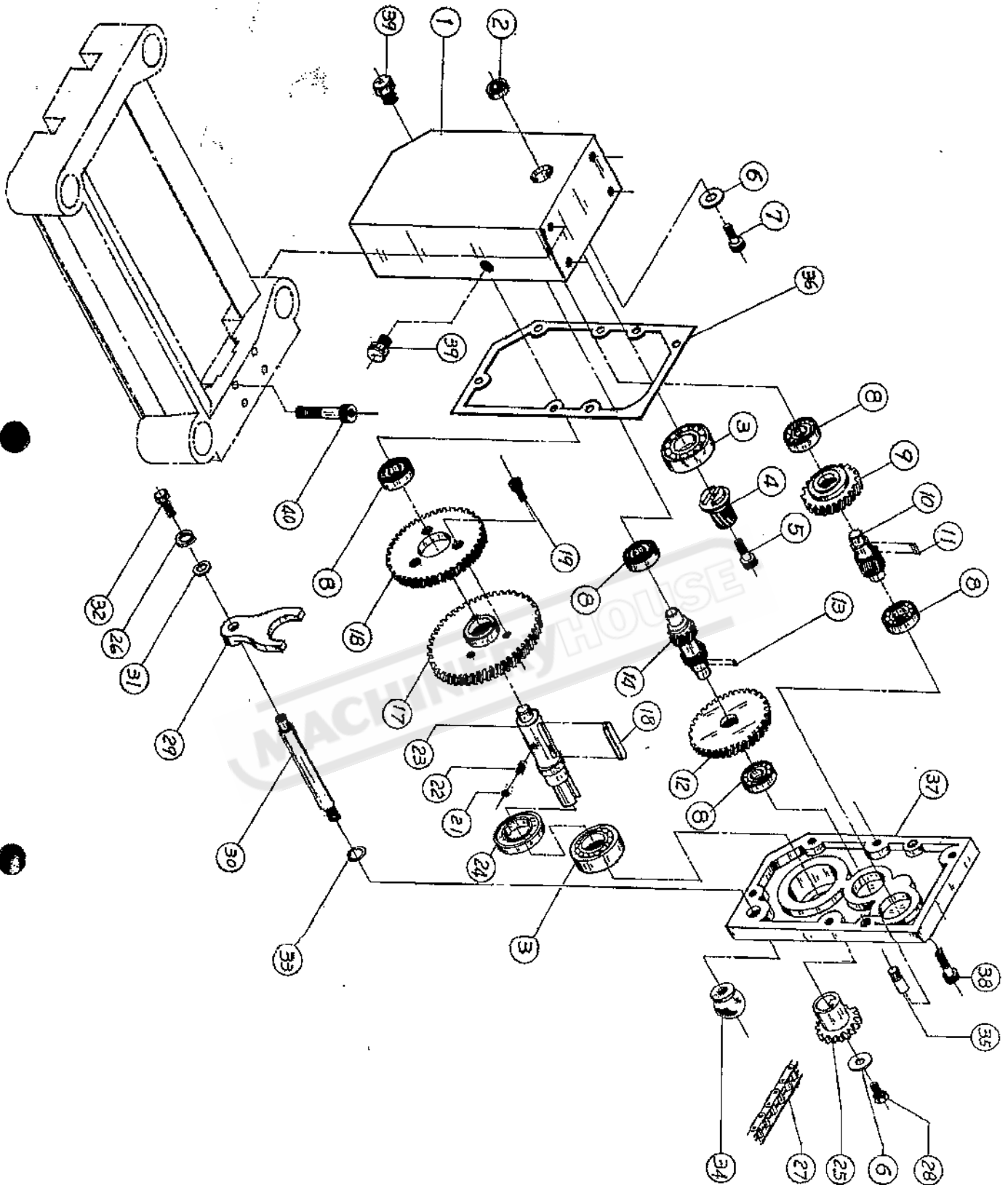
COLUMN

Index No.	Parts No.	Parts Name	Q'ty	Remark	Index No.	Parts No.	Parts Name	Q'ty	Remark
1	3001	Base	1		16	3010	Sprocket	4	10'
2		Set Screw	8	M10×1.5P-12	17		Washer	4	3/8" ×20×2
3	3002	Column	3		18		Nut	4	M10×1.25P
4	3003	Column	1		19	3018	Washer	2	φ8.2×22×3
5	3004	Lead Screw	3		20		Hex. Hd. Scr	2	M18×1.25P-25
6	3005	Lead Screw	1		21	3012	Bracket	1	
7	3006	Nut	4		22	3011	Shaft	1	
8	3007	Bush	1		23	3013	Sprocket	1	10'
9		Retaining Ring	1	RTW-38	24		Retaining Ring	1	STW-15
10		Key	1	4×4×10	25		Chain	1	#40
11	3009	Gear	1	24'	26	3015	Crane Post	4	
12		Retaining Ring	1	STW-12	27		Retaining Ring	4	ETW-19
13		Bearing	4	6202 ZZ	28	3016	Pipe Band	16	
14		Retaining Ring	4	RTW-35	29		Machine Screw	32	M5×0.8P-8
15		Key	4	5×5×16	30	3017	Expansion Bend	8	



GEAR BOX

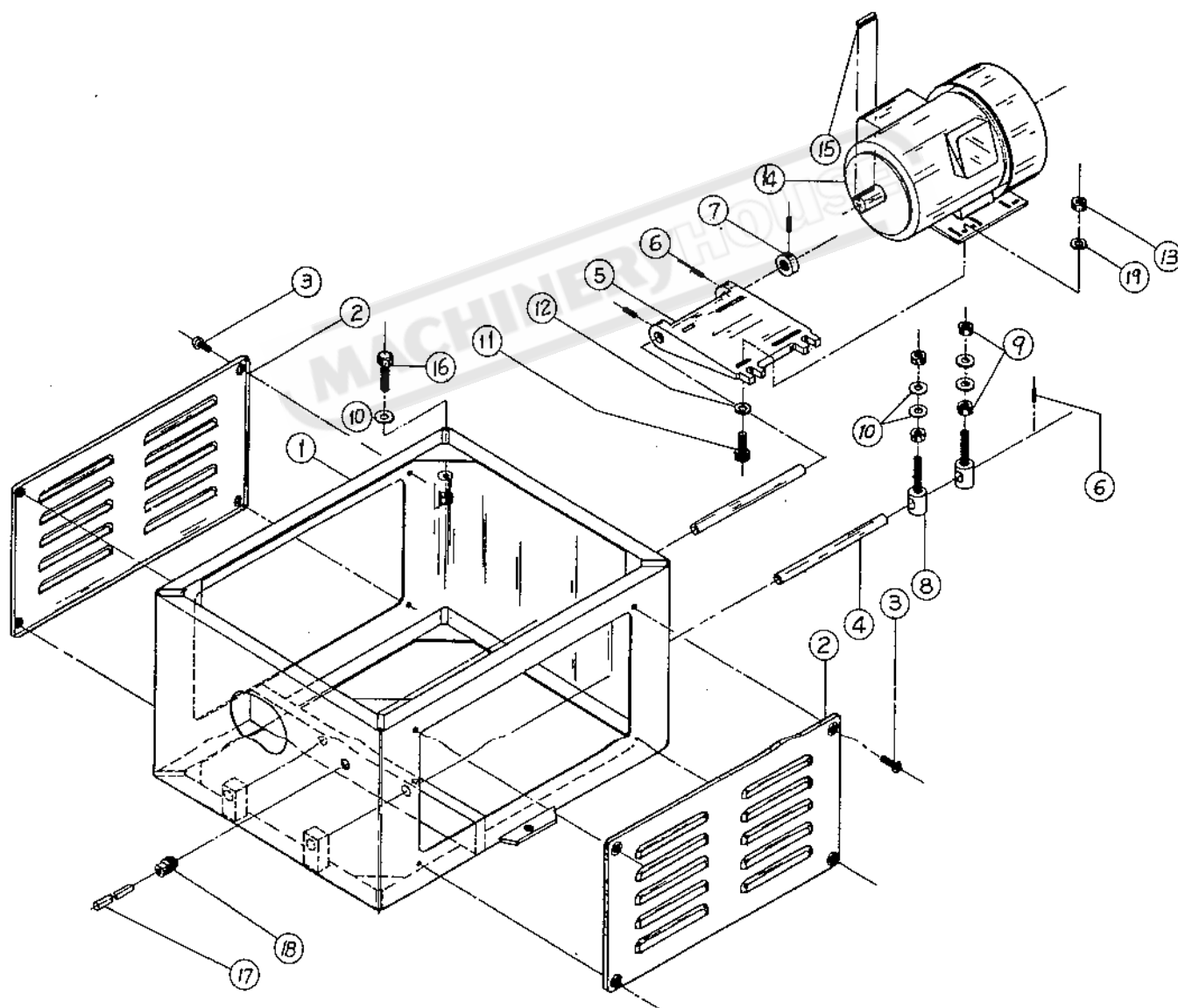
Index No.	Parts No.	Parts Name	Q'ty	Remark
1	5001	Gear Box	1	
2		Oil Seal	1	TC28×40×8
3		Bearing	2	6204 ZZ
4	5002	Gear	1	16 ^t
5		Cap Screw	1	M6×1.0P-20
6	1018	Washer	2	
7		Cap Screw	1	M6×1.0P-16
8		Bearing	5	6201
9	5003	Gear	1	47 ^t
10	5004	Shaft	1	18 ^t
11		Key	1	5×5×12
12	5005	Gear	1	71 ^t
13		Key	1	5×5×10
14	5006	Shaft	1	18 ^t
17	5008	Gear	1	96 ^t
18	5009	Gear	1	92 ^t
19		Cap Screw	3	M6×1.0P-10
20		Key	1	6×6×40
21		Ball	1	φ6
22	5011	Spring	1	
23	5010	Shaft	1	
24		Oil Seal	1	SC25×47×6
25	5018	Sprocket	1	12 ^t
26		Spring Washer	1	M6
27		Chain	1	06B
28		Hex. Hd. Scr.	1	M6×1.0P-16
29	5012	Clutch	1	
30	5013	Handle	1	
31		Washer	1	1/4" ×13×1.2
32		Hex. Hd. Scr.	1	M6×1.0P-12
33		Oil Ring	1	P-12
34	5014	Knob	1	
35	5015	Pin	2	
36	5016	Packing Piece	1	
37	5017	Cover	1	
38		Cap Screw	5	M6×1.0P-25
39		Oil Plug	2	PT1/4-19
40		Cap Screw	4	M8×1.25P-50



BOM

Index No.	Parts No.	Parts Name	Q'ty	Remark
1	4001	Stand	1	
2	4002	Cover	2	
3		Machine Screw	8	M6×1.0P-20
4	4004	Bar	2	
5	4003	Motor Mount	1	
6		Set Screw	4	M8×1.25P-8
7	4005	Coller	1	
8	4006	Adjust Bolt	2	
9		Nut	8	M12×1.75P
10		Washer	4	1/2×29×3

Index No.	Parts No.	Parts Name	Q'ty	Remark
11		Hex. Hd. Scr.	4	M8×1.25P-25
12		Washer	4	5/16"×23×2
13		Nut	4	M8×1.25P
14		Motor	1	3HP or 5HP
15		Key	1	
16		Hex. Hd. Screw	4	M12×1.75P-60
17		Power Supply Wire	1	
18		Relief Bushing	1	
19		Washer	4	5/16"×16×1.8



BASE

Index No.	Parts No.	Parts Name	Q'ty	Remark
1	4001	Stand	1	
2	4002	Cover	2	
3		Machine Screw	8	M6×1.0P-20
4	4004	Bar	2	
5	4003	Motor Mount	1	
6		Set Screw	4	M8×1.25P-8
7	4005	Collar	1	
8	4006	Adjust Bolt	2	
9		Nut	8	M12×1.75P
10		Washer	4	1/2×29×3

Index No.	Parts No.	Parts Name	Q'ty	Remark
11		Hex. Hd. Scr.	4	M8×1.25P-25
12		Washer	4	5/16" x23x2
13		Nut	4	M8×1.25P
14		Motor	1	3HP or 5HP
15		Key	1	
16		Hex. Hd. Screw	4	M12×1.75P-60
17		Power Supply Wire	1	
18		Relief Bushing	1	
19		Washer	4	5/16" x16x1.8

