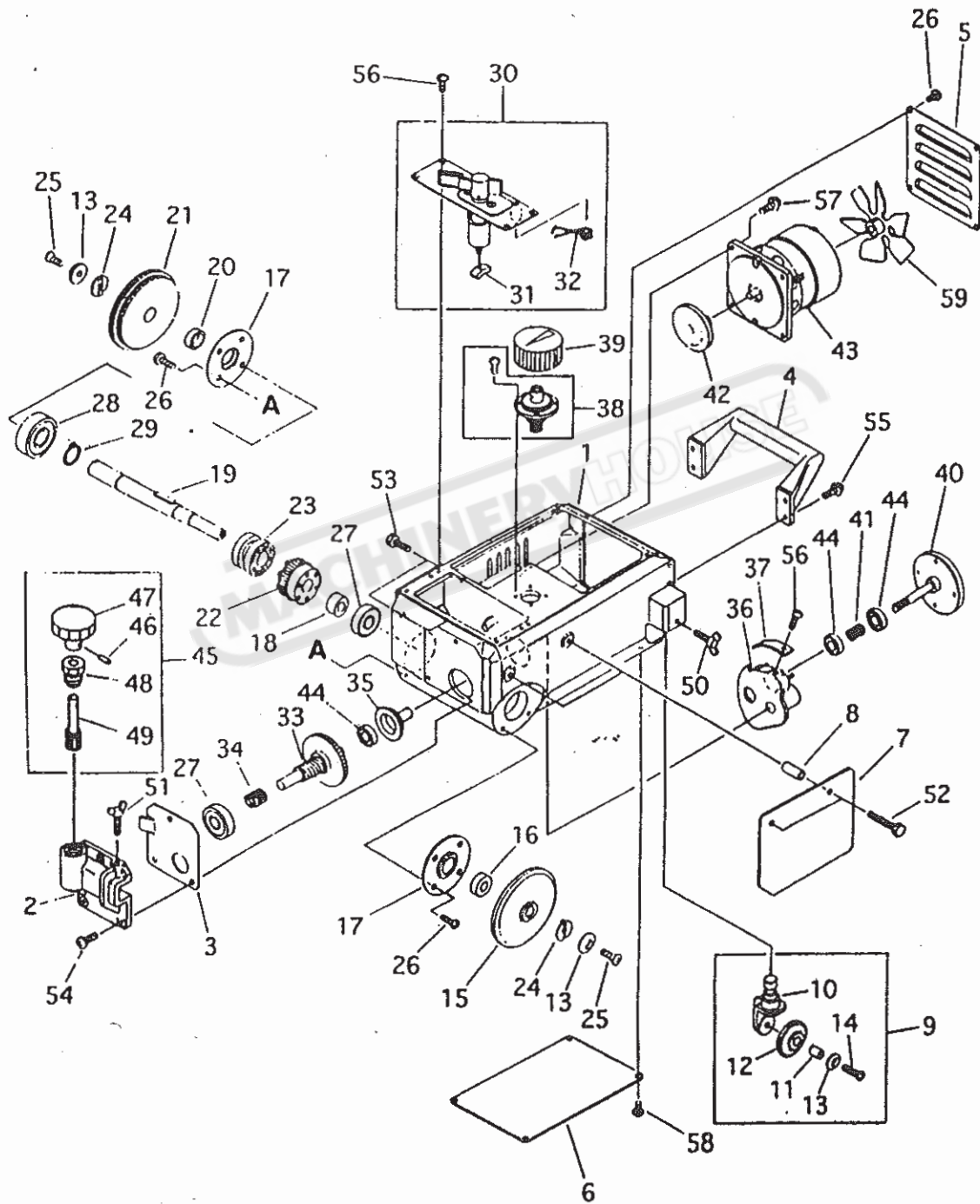


10 Parts list

10.1 Main units

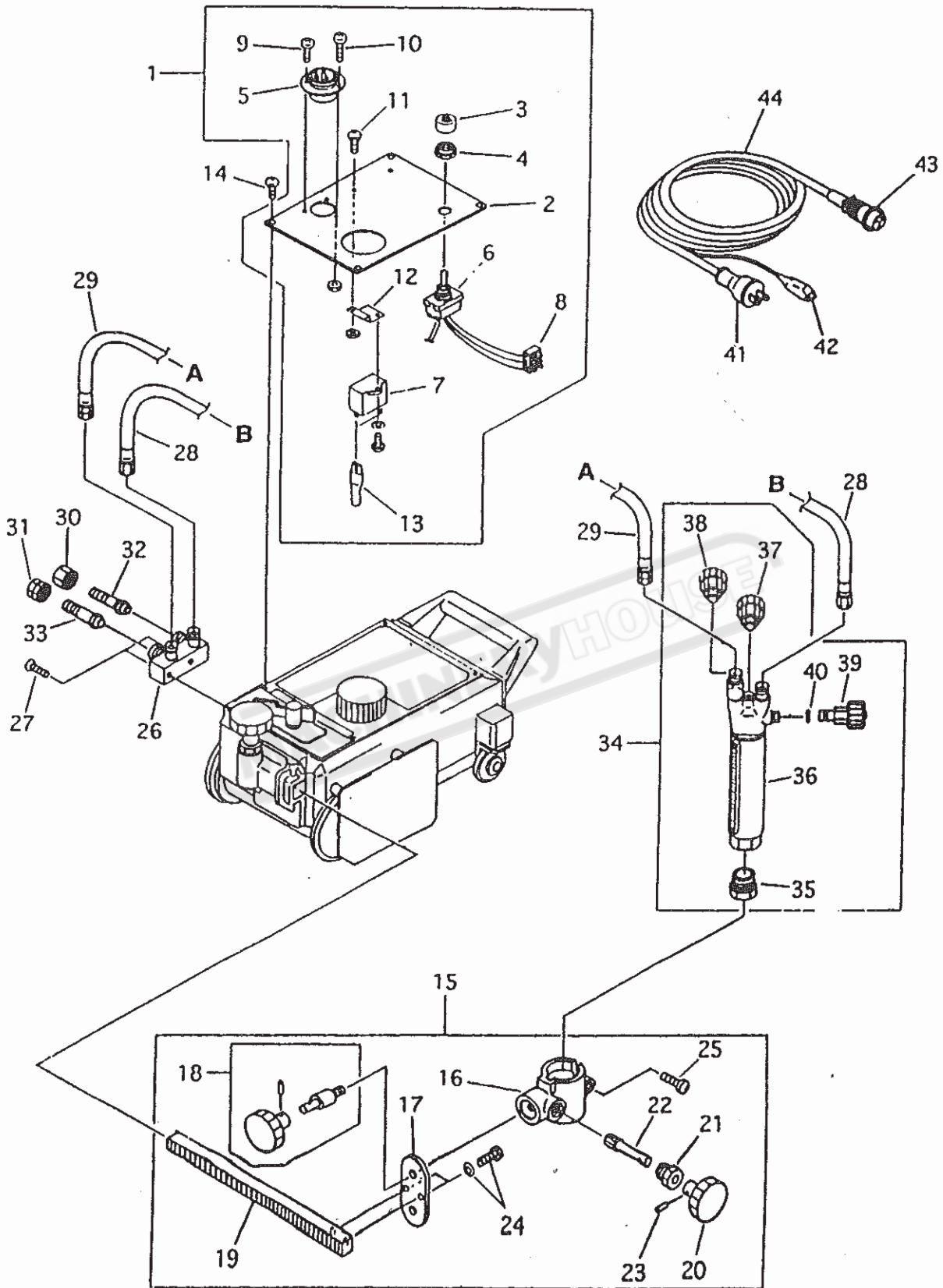


10.1 Main units

| ITEM NO. | PART NAME | QTY | REMARKS |
|----------|-----------------------|-----|----------|
| 1 | Case | 1 | |
| 2 | Cross feed holder | 1 | |
| 3 | Cross feed liner | 1 | |
| 4 | Handle | 1 | |
| 5 | Fan cover | 1 | |
| 6 | Bottom plate | 1 | |
| 7 | Heat shield | 1 | |
| 8 | Heat shield collar | 2 | |
| 9 | Idle wheel unit | 1 | |
| 10 | Idle wheel bracker | 1 | |
| 11 | Roller shaft | 1 | |
| 12 | Roller shaft | 1 | |
| 13 | washer | 1 | |
| 14 | scren | 1 | |
| 15 | Idle wheel | 1 | |
| 16 | collar(A) | 1 | |
| 17 | Bearing retainer | 2 | |
| 18 | Collar(B) | 1 | |
| 19 | Drive wheel shaft | 1 | with key |
| 20 | Collar(C) | 1 | |
| 21 | Drive wheel | 1 | |
| 22 | Worm wheel | 1 | |
| 23 | Clutch | 1 | |
| 24 | Washer | 2 | |
| 25 | Screw | 2 | |
| 26 | Screw | 2 | |
| 27 | Bearing | 2 | 6300ZZ |
| 28 | Bearing | 1 | 6302ZZ |
| 29 | Stop ring | 1 | |
| 30 | clutch lever assembly | 1 | |
| 31 | Slider | 1 | |
| 32 | Clutch spring | 1 | |
| 33 | Worm shaft assembly | 1 | |
| 34 | Worm spring | | |

| ITEM NO. | PART NAME | QTY | REMARKS |
|----------|---------------------------|-----|--------------------|
| 35 | Speed adjusting shaft | 1 | |
| 36 | Speed adjusting bracket | 1 | |
| 37 | Rack | 1 | |
| 38 | Speed adjusting handle | 1 | |
| 39 | Speed adjusting knob | 1 | |
| 40 | Speed adjusting cone assy | 1 | |
| 41 | Cone spring | 1 | |
| 42 | Motor disk | 1 | |
| 43 | Motor | 1 | 100V-120 |
| | Motor | 1 | 200V-220 |
| | Motor | 1 | 230V-240 |
| | Motor | 1 | 42V |
| 44 | Bearing | 1 | 608ZZ |
| 45 | Cross feed pinion unit | 1 | |
| 46 | Spring pin | 1 | |
| 47 | handle(Ø 40) | 1 | |
| 48 | Pinion meral | 1 | |
| 49 | Pinion | 1 | |
| 50 | Wing bolt | 1 | |
| 51 | Wing bolt | 1 | |
| 52 | Hexagon bolt | 2 | |
| 53 | Hexagon bolt | 2 | |
| 54 | Screw | 3 | |
| 55 | Screw | 4 | with spring washer |
| 56 | Screw | 10 | |
| 57 | Screw | 4 | |
| 58 | Screw | 8 | |
| 59 | Motor Fan | 1 | with screw |

10.2 Electrical, gas and torch slide holder units

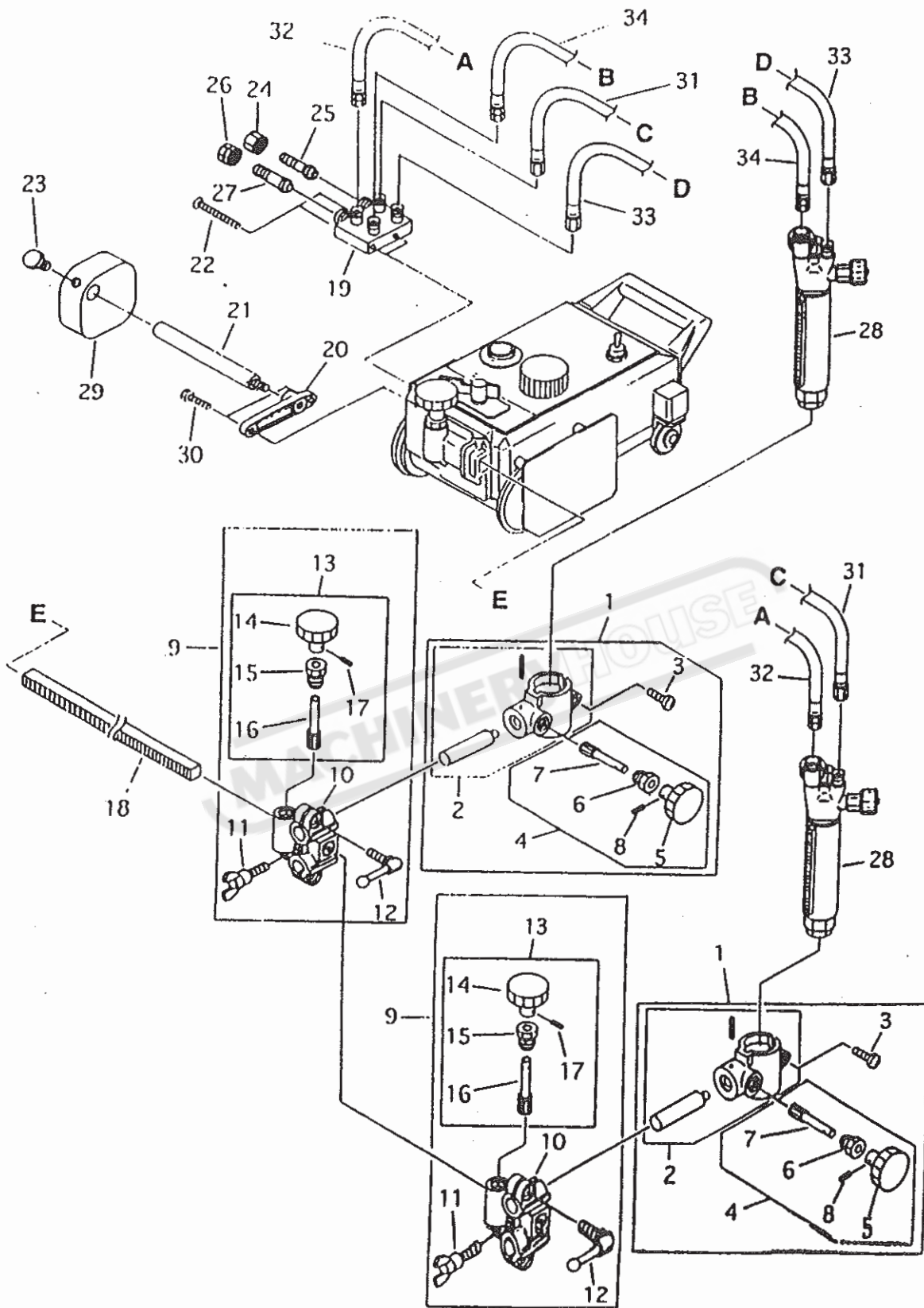


10.2 Electrical, gas and torch slide holder units

| ITEM NO. | PART NAME | QTY | REMARKS |
|----------|---------------------------|-----|------------------|
| 1 | Panel assembly | 1 | 100V-240V |
| | Panel assembly | 1 | 200V-240V |
| | Panel assembly | 1 | 42V |
| 2 | Panel | 1 | |
| 3 | Cap for dust protector | 1 | |
| 4 | Nut for dust protector | 1 | |
| 5 | Metal socket | 1 | 3P |
| | Metal socket | 1 | 4P |
| 6 | Switch | 1 | 100V-120V |
| | Switch | 1 | 200V-240V 42V |
| 7 | Condenser | 1 | 100V |
| | Condenser | 1 | 120V |
| | Condenser | 1 | 200V-220V |
| | Condenser | 1 | 230V-240V |
| | Condenser | 1 | 42V |
| 8 | Terminal | 1 | 100V-120V 3P |
| | Terminal | 1 | 200V-240V 4P |
| 9 | Screw | 2 | With nut |
| 10 | Screw | 1 | with nu |
| 11 | Screw | 2 | |
| 12 | Condenser fixing plate | 1 | |
| 13 | Fston terminal | 2 | |
| 14 | Screw | 4 | |
| 15 | Torch holder assembly | 1 | |
| 16 | Torch holder | 1 | |
| 17 | Torch holder fixing plate | 1 | |
| 18 | Holder fixing handle | 1 | |
| 19 | Rack bar | 1 | |
| 20 | Handle(Ø 40) | 1 | |
| 21 | Pinion metal | 1 | |
| 22 | Pinion | 1 | |
| 23 | Spring Pin | 1 | |
| 24 | Hexagon bolt | 2 | with WS |
| 25 | Screw | 1 | |

| ITEM NO. | PART NAME | QTY | REMARKS |
|----------|--------------------------|-----|--------------------------|
| 26 | Distributor | 1 | Expxct USAKE |
| | Distributor | 1 | USA only |
| | Distributor | 1 | KE only |
| 27 | Screw | 2 | |
| 28 | Hose for oxygen | 1 | M12X600 Except USA KE |
| | Hoes for oxygen | 1 | USA only |
| | Hose for oxygen | 1 | Except USA |
| 29 | Hose for gas | 1 | KE only Except USA |
| | Hose for gas | 1 | USA only |
| 30 | Nut for oxygen | 1 | Except USA |
| | Nut for oxygen | 1 | KE only |
| 31 | Nut for gas | 1 | Except USA |
| | Nut for gas | 1 | KE only |
| 32 | Hose connector(ox) | 1 | Except USA |
| | Hose connector(ox) | 1 | KE only |
| 33 | Hose connector(gas) | 1 | Except USA |
| | Hose connector(gas) | 1 | KE only |
| 34 | Torch | 1 | Facer USA KE |
| | Torch | 1 | Except USA |
| 35 | Torch | 1 | KE only |
| 36 | Tip fixing nut | 1 | |
| 37 | Rack for Beetle | 1 | with screw |
| | Valve for preheat oxygen | 1 | Except KE |
| 38 | Valve for preheat oxygen | 1 | KE only |
| 39 | Valve for gas | 1 | |
| | Valve for jet for oxygen | 1 | Except KE |
| 40 | Valve for jet for oxygen | 1 | KE only |
| 41 | O-ring | 1 | |
| 42 | Rubber plug | 1 | |
| 43 | Earth clip | 1 | |
| | Metal plug | 1 | 4P |
| | Metal Pluy | 1 | 4P |
| 44 | Cabtyre cord assembly | 1 | 4P |
| | Cabtyre cord assembly | 1 | 4P |

10.3 Two torch unit



10.3 Tow torch unit

| ITEM NO. | PART NAME | QTY | REMARKS |
|----------|-------------------------|-----|---------------|
| 1 | Torch holder assembly | 2 | |
| 2 | Torch holder | 2 | |
| 3 | Screw | 2 | |
| 4 | Torch up/down handle | 2 | |
| 5 | Handle(φ40) | 2 | |
| 6 | Pinion metal | 2 | |
| 7 | Pinion | 2 | |
| 8 | Spring pin | 2 | |
| 9 | Torch cross feed holder | 2 | |
| 10 | Cross feed holder | 2 | |
| 11 | Wing bolt | 2 | |
| 12 | Crank handle | 2 | |
| 13 | Cross feed pinion unit | 2 | |
| 14 | Handle (φ40) | 2 | |
| 15 | Pinion metal | 2 | |
| 16 | Pinion | 2 | |
| 17 | Spring pin | 2 | |
| 18 | Rack bar | 1 | |
| 19 | Distributor | 1 | Except USA,KE |
| | Distributor | 1 | KE only |
| | Distributor | 1 | USA only |
| 20 | Fitting | 1 | |
| 21 | Weight supporter | 1 | |
| 22 | Screw | 2 | |
| 23 | Hexagen bolt | 1 | |
| 24 | Nut for oxygen | 1 | Except USA |
| | Nut for oxygen | 1 | KE only |
| 25 | Hose connector(ox) | 1 | Except USA |
| | Hose connector(ox) | 1 | KE only |
| 26 | Nut for gas | 1 | Except USA |
| | Nut for gas | 1 | KE only |
| 27 | Hose connector(gas) | 1 | Except USA |
| | Hose connector(gas) | 1 | KE only |

| ITEM NO. | PART NAME | QTY | REMARKS |
|----------|-----------------|-----|------------------------------|
| 28 | Torch | 2 | Except USA, KE |
| | Torch | 2 | USA only |
| | Torch | 2 | KE only |
| 29 | Weight | 1 | |
| 30 | Hexagon bolt | 2 | |
| 31 | Hose for oxygen | 1 | M12X900 Except USA,KE |
| | Hose for oxygen | 1 | USA only |
| | Hose for oxygen | 1 | KE only |
| 32 | Hose for gas | 1 | M12X900 lkh Except USA,KE |
| | Hose for gas | 1 | USA only |
| 33 | Hose for oxygen | 1 | M12X600 |
| | Hose for oxygen | 1 | USA only |
| | Hose for oxygen | 1 | KE only |
| 34 | Hose for gas | 1 | M12X600lkh |
| | Hose for gas | 1 | USA only |

1 1 Cutting data

106 (STANDARD SPEED) For Propane
Metric System

| PLATE THICKNESS (mm) | TIP SIZE | CUTTING SPEED (mm/min) | OXYGEN PRESSURE (kg/cm ²) | | FUEL GAS PRESSURE (kg/cm ²) | KERF WIDTH (mm) |
|----------------------|----------|------------------------|---------------------------------------|---------|---|-----------------|
| | | | CUTTING | PR-HEAT | | |
| 3 | 1/32 | 680 | 1.5 | 1.5 | 0.2 | 1.0 |
| 6 | 1/32 | 610 | 2.0 | 2.0 | 0.2 | 1.3 |
| 10 | 3/64 | 560 | 2.0 | 2.0 | 0.2 | 1.5 |
| 12.5 | 3/64 | 530 | 2.5 | 2.5 | 0.2 | 1.8 |
| 19 | 3/64 | 460 | 3.0 | 3.0 | 0.25 | 2.0 |
| 25 | 1/16 | 430 | 3.0 | 3.0 | 0.25 | 2.0 |
| 38 | 1/16 | 355 | 3.0 | 3.0 | 0.25 | 2.3 |
| 50 | 1/16 | 320 | 3.0 | 3.0 | 0.25 | 2.8 |
| 60 | 1/16 | 280 | 4.0 | 4.0 | 0.3 | 3.0 |
| 75 | 1/16 | 250 | 4.0 | 4.0 | 0.3 | 3.0 |
| 100 | 5/64 | 200 | 4.0 | 4.0 | 0.3 | 3.6 |
| 125 | 5/64 | 180 | 4.0 | 4.0 | 0.4 | 3.6 |
| 150 | 3/32 | 150 | 4.5 | 4.5 | 0.4 | 4.1 |
| 200 | 1/8 | 130 | 4.5 | 4.5 | 0.4 | 4.3 |
| 250 | 1/8 | 80 | 4.5 | 4.5 | 0.4 | 5.6 |
| 300 | 1/8 | 50 | 4.5 | 4.5 | 0.4 | 6.6 |

Inch System

| PLATE THICKNESS (inches) | TIP SIZE | CUTTING SPEED (in.min) | OXYGEN P.S.I.G | | FUEL GAS P.S.I.G | KERF WIDTH (inches) |
|--------------------------|----------|------------------------|----------------|---------|------------------|---------------------|
| | | | CUTTING | PR-HEAT | | |
| 1/8 | 1/32" | 27 | 20 | 20 | 2.8 | 0.04 |
| 1/4 | 1/32" | 24 | 30 | 30 | 2.8 | 0.05 |
| 3/8 | 3/64" | 22 | 30 | 30 | 2.8 | 0.06 |
| 1/2 | 3/64" | 21 | 40 | 40 | 2.8 | 0.07 |
| 3/4 | 3/64" | 18 | 45 | 45 | 3.6 | 0.08 |
| 1 | 1/16" | 17 | 45 | 45 | 3.6 | 0.08 |
| 1-1/2 | 1/16" | 14 | 45 | 45 | 3.6 | 0.09 |
| 2 | 1/16" | 12.5 | 45 | 45 | 4.3 | 0.11 |
| 2-1/2 | 1/16" | 11 | 55 | 55 | 4.3 | 0.12 |
| 3 | 1/16" | 10 | 55 | 55 | 4.3 | 0.12 |
| 4 | 5/64" | 8 | 55 | 55 | 5.7 | 0.14 |
| 5 | 5/64" | 7 | 55 | 55 | 5.7 | 0.14 |
| 6 | 3/32" | 6 | 65 | 65 | 5.7 | 0.16 |
| 8 | 1/8" | 5 | 65 | 65 | 5.7 | 0.17 |
| 10 | 1/8" | 3 | 65 | 65 | 5.7 | 0.23 |
| 12 | 1/8" | 2 | 65 | 65 | 5.7 | 0.27 |

- Note:
- 1) All pressures are torch inlet pressures.
 - 2) Oxygen purity is minimum of 99.7% ; propane is minimum of JIS Grade 3.
 - 3) Depending on the surface condition of the steel plate (scale, paint), either increase the fuel gas pressure decrease cutting speed. Also, when precision cutting is required, adjust all data.

102 (STANDARD SPEED) For Acetylene

| PLATE THICKNESS (mm) | TIP SIZE | CUTTING SPEED (mm/min) | OXYGEN PRESSURE (kg/cm ²) | | FUEL GAS PRESSURE (kg/cm ²) | KERF WIDTH (mm) |
|----------------------|----------|------------------------|---------------------------------------|---------|---|-----------------|
| | | | CUTTING | PR-HEAT | | |
| 3 | 1/32 | 680 | 1.5 | 1.5 | 0.2 | 1.0 |
| 6 | 1/32 | 610 | 2.0 | 2.0 | 0.2 | 1.3 |
| 10 | 3/64 | 560 | 2.0 | 2.0 | 0.2 | 1.5 |
| 12.5 | 3/64 | 530 | 2.5 | 2.5 | 0.2 | 1.8 |
| 19 | 3/64 | 460 | 3.0 | 3.0 | 0.2 | 2.0 |
| 25 | 1/16 | 430 | 3.0 | 3.0 | 0.2 | 2.0 |
| 38 | 1/16 | 355 | 3.0 | 3.0 | 0.2 | 2.3 |
| 50 | 1/16 | 320 | 3.0 | 3.0 | 0.25 | 2.8 |
| 60 | 1/16 | 280 | 4.0 | 4.0 | 0.3 | 3.0 |
| 75 | 1/16 | 250 | 4.0 | 4.0 | 0.3 | 3.0 |
| 100 | 5/64 | 200 | 4.0 | 4.0 | 0.35 | 3.6 |
| 125 | 5/64 | 180 | 4.0 | 4.0 | 0.35 | 3.6 |
| 150 | 3/32 | 150 | 4.5 | 4.5 | 0.4 | 4.1 |
| 200 | 1/8 | 130 | 4.5 | 4.5 | 0.4 | 4.3 |
| 250 | 1/8 | 80 | 4.5 | 4.5 | 0.4 | 5.6 |
| 300 | 1/8 | 50 | 4.5 | 4.5 | 0.4 | 6.6 |

Inch System

| PLATE THICKNESS (inches) | TIP SIZE | CUTTING SPEED (in.min) | OXYGEN P.S.I.G | | FUEL GAS P.S.I.G | KERF WIDTH (inches) |
|--------------------------|----------|------------------------|----------------|---------|------------------|---------------------|
| | | | CUTTING | PR-HEAT | | |
| 1/8 | 1/32" | 27 | 20 | 20 | 2.8 | 0.04 |
| 1/4 | 1/32" | 24 | 30 | 30 | 2.8 | 0.05 |
| 3/8 | 3/64" | 22 | 30 | 30 | 2.8 | 0.06 |
| 1/2 | 3/64" | 21 | 40 | 40 | 2.8 | 0.07 |
| 3/4 | 3/64" | 18 | 45 | 45 | 2.8 | 0.08 |
| 1 | 1/16" | 17 | 45 | 45 | 2.8 | 0.08 |
| 1-1/2 | 1/16" | 14 | 45 | 45 | 2.8 | 0.09 |
| 2 | 1/16" | 12.5 | 45 | 45 | 3.6 | 0.11 |
| 2-1/2 | 1/16" | 11 | 55 | 55 | 4.3 | 0.12 |
| 3 | 1/16" | 10 | 55 | 55 | 4.3 | 0.12 |
| 4 | 5/64" | 8 | 55 | 55 | 5.0 | 0.14 |
| 5 | 5/64" | 7 | 55 | 55 | 5.0 | 0.14 |
| 6 | 3/32" | 6 | 65 | 65 | 5.7 | 0.16 |
| 8 | 1/8" | 5 | 65 | 65 | 5.7 | 0.17 |
| 10 | 1/8" | 3 | 65 | 65 | 5.7 | 0.23 |
| 12 | 1/8" | 2 | 65 | 65 | 5.7 | 0.27 |

- Note: 1) All pressures are torch inlet pressures.
 2) Oxygen purity is minimum of 99.7%
 3) Depending on the surface condition of the steel plate (scale, paint), either increase the fuel gas pressure or decrease cutting speed. Also, when precision cutting is required, adjust all data.