

3.3. Operation Recommendations

- Select the correct saw blade with the correct tooth pitch and form to suit the material to be cut to provide minimum burr and maximum blade lifespan.
- Use the smallest diameter blade and coarsest pitch that is practical within the required speed and material limitations.
- Generally use a tooth pitch to give 2 - 4 teeth engagement with the material during cutting.
- Ensure that sufficient coolant is flowing over the cutting teeth.
- Do not allow the machine's gearbox to run idle in the upright position for more than **3 minutes** otherwise, damage can occur to the drive system.
- The rate of feed affects the quality of the final cut and blade life. This varies also by the material and cross-sectional dimensions. When cutting stainless steel or high carbon steel (**Brinell hardness above 200**), the slowest speed machine should be used together with a cobalt type high speed steel blade.
- When manually feeding the saw head, keep in mind to maintain a steady, continuous pressure, thus **avoiding work hardening** on the cutting piece. Avoid 'forcing' the blade through the material as this might damage or break the blade.
- As a rule of thumb **the softer the component, the faster the rate of speed**. Thus, it is recommended that slower speeds be used for hard and tough materials and higher speeds for soft, ductile materials. Note that for non-ferrous materials such as brass, copper, aluminium etc. require much faster speeds than provided on this machine. If these are the majority of materials cut, a **Brobo NF Series** machine should be considered.

CHAPTER 4 - Drawings, Layouts, Assembly and Spare Parts



1/ PROVIDE END FLOAT OF 0.1 MM BY USING SHIMS IF REQUIRED.

Parts List for VS350D (S042)

107	9304170	1	QUICK ACTION NUT	A4	
106	931490		VICE LOCKING HANDLE	A4	
105	9305350		SHIM Ø 50 X Ø 62 X 0.1		QTY. AS REQ.
104	9405020	1	WINDOW GASKET Ø 1/2" BSP		
103	9405010	1	DIL SIGHT WINDOW 1/2" BSP		
102	1045020	1	KNOB Ø 38 X M12 - BLACK		
101	9305020	1	TAPER ROLLER BRG. Ø 30 X Ø 62 X 17.25		TYPE 30206
100	9302120	1	BEARING COVER PLATE (CAST AL.)	A4	
99	9605260	1	CUP PLUG (PLASTIC)		
98	9505250	1	HANDLE GRIP		
97	9504110	1	OPERATING HANDLE	A4	
96	9554030	1	SPRING BRACKET UPPER	A4	
95	9305150	1	COMPRESSION SPRING	A4	
94	8735160	2	NYLOC NUT M8		
93	9314690	1	SHOULDER SCREW BR. M.S. Ø 16 X 60	A4	
92	9304660	1	SPACER Ø 39 X Ø 28 X 13	A4	BALDR
91	9504120	1	SPACER Ø 39 X Ø 24 X 14	A4	CMG MOTOR
90	9301430	1	COUPLING SET Ø 25 X Ø 28		BALDR MOTOR
89	9301420	1	COUPLING SET Ø 25 X Ø 24		CMG MOTOR
88	9304430	1	KEY 8 X 7 X 31	A4	

35	8715730	2	DRIVE PIN NO. 2		
34	1065100	1	SERIAL NUMBER PLATE	A4	
33	9332070	1	BACK FENCE LH (CAST IRON)	A3	
32	9304770	2	HOLLOW DOWEL Ø 22 X 30	A4	
31	8705380	4	FLAT HEAD SOCKET SCREW M8 X 16		
30	9514280	2	WEAR PLATE LH & RH	A4	
29	9814010	1	MAIN SPINDLE - S400	A3	
28	9504090	1	MAIN SPINDLE - S315/S350	A3	
27	8735090	1	SOCKET HEAD CAP SCREW M16 X 40 LH	A4	
26	8735360	2	DOWEL PIN Ø 10 X 30		FOR S400
25	8715080	2	DOWEL PIN Ø 8 X 25		FOR S315/S350
24	9824000	1	COUNTER PLATE - S400	A4	
23	9504090	1	COUNTER PLATE - S315/S350	A4	
22	9305010	1	DIL SEAL Ø 70 X Ø 90 X 10		PR4277
21	1033010	2	SHIM Ø 25 X Ø 17 X 0.1	A4	
20	8705440	1	SOCKET HEAD SHOULDER SCREW Ø 12 X 20 X M10		
19	8715260	2	DISC SPRING Ø 28 X Ø 12.2 X 1.0		QTY. AS REQ.
18	8705050	5	SOCKET HEAD CAP SCREW M6 X 12		
17	9035140	1	SABLADE Ø 400 X 3 X Ø 40 X 200 TEETH		HSS 4.04 T.P.I.
16	9025800	1	SABLADE Ø 350 X 2.5 X Ø 40 X 180 TEETH		HSS 4.16 T.P.I.
15	9015880	1	SABLADE Ø 300 X 2.5 X Ø 40 X 160 TEETH		HSS 4.31 T.P.I.
14	9512000	1	SAW HEAD/GEARBOX - 315/350/400	A1	CAST IRON
13	9304017	1	PIN - COOLANT PUMP	A4	
12	9405450	1	COOLANT PUMP (GSS 6 6923/CORDNA 1895/6)		INC. GASKET
11	8705120	2	SOCKET HEAD SCREW M8 X 20		
10	9324070	1	COVER PLATE (PUMP TO GEARBOX)	A3	
9	8705350	8	FLAT HEAD SOCKET SCREW M6 X 16		
8	8705850	6	SPRING WASHER Ø 8		
7	8705060	12	SOCKET HEAD CAP SCREW M6 X 16		
6	9802000	1	INNER GUARD - 400 (CAST AL.)	A3	
5	9502040	1	INNER GUARD - 350 (CAST AL.)	A3	
4	9302030	1	INNER GUARD - 315 (CAST AL.)	A3	
3	9505210	1	LABLE (WARNING STICKER)	A4	
2	9532050	1	OUTER GUARD - 350/400 (CAST AL.)	A3	
1	9342040	1	OUTER GUARD - 315 (CAST AL.)	A3	

E	REVISED	ANH	01/06/2017	RAW MAT. #.	Drawn	Scale	 BRBO WALDOWN AUSTRALIA Pty Ltd	
D	SPRING AND UPPER SPRING BRACKET REVISED	M.G.	15-08-00	Moss in Kg.	Date	01/06/2017		Checked
C	P/N'S 9324070, 9405450 WERE 9314070, 9505230, P/N 9304017 ADDED	M.G.	13-11-98					
B	P/N 9312030 WAS 9302030 & COOLANT MANIFOLD REPLACED WITH NOZZLE	M.G.	22-07-96	Mat./Spec	Titled			
A	REDRAWN ON COMPUTER	M.G.	16-05-96					
					SAW ASSEMBLY S315D, S350D, S400B		Dwg No. 9540000 SHEET 1 OF 3	Revision

DRG/PART No.
Page 3
9540000
SHEET 2 OF 3

DD NOT SCALE
COMMERCIAL STOCK SIZES
EXCEPTED AND UNLESS
OTHERWISE NOTED
TOLERANCES ON
DIMENSIONS ARE:
METRIC

Size To Mach. Cast*
6 mm ± 0.1 ± 0.5
30 mm ± 0.2 ± 1.0
100 mm ± 0.3 ± 1.5
300 mm ± 0.5 ± 2.0
1000 mm ± 0.8 ± 3.0
2000 mm ± 1.2 ± 5.0

* INCLUDES STRUCTURAL
STEEL WORK.
REMOVE ALL BURRS AND
SHARP EDGES BY 0.3 x 45°
UNLESS OTHERWISE STATED
SURFACE FINISH

Roughness Value	
Met Um	Grade No.
50	N12
25	N11
12.5	N10
6.3	N 9
3.2	N 8
1.6	N 7
0.8	N 6
0.4	N 5
0.2	N 4
0.1	N 3
0.05	N 2
0.025	N 1

DRAWING PRACTICE TO
AS 1100 - PROJECTION
SYSTEM (UNLESS NOTED)

3RD
ANGLE

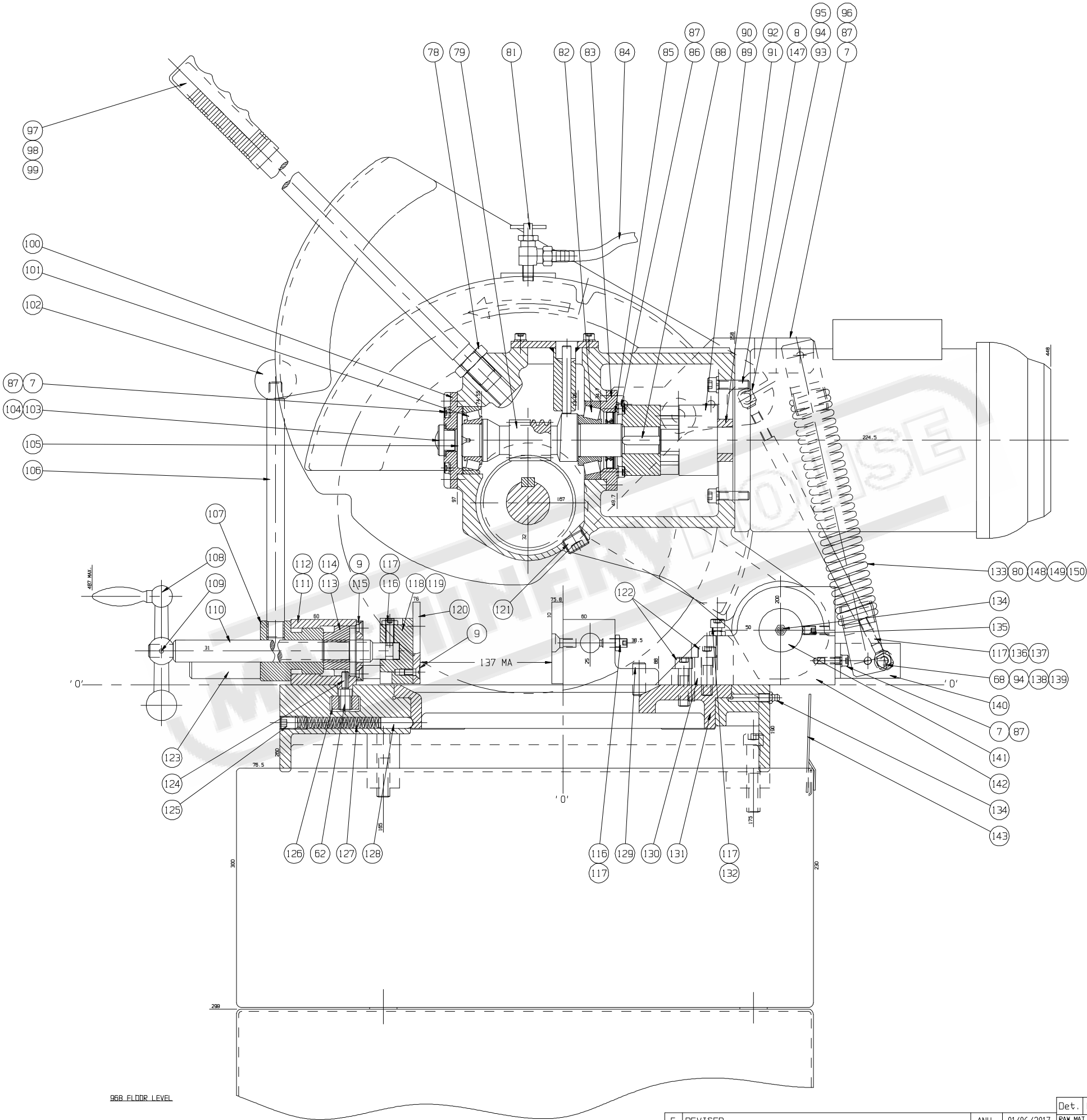
ANGULARITY TOLERANCE
< 0° 7'

CONCENTRICITY
0.1 mm

THIS DESIGN OR DRAWING IS
NOT SOLD, BUT LENT AND IS
SUBJECT TO RECALL.
REPRODUCTIONS OF THIS
DRAWING IN ANY MATERIAL
FORM ARE RESERVED TO
BROB WALDOWN Pty. Ltd.
UNDER COPYRIGHT LAW.

Parts List for VS350D (S042)

04/04/2019



E	REVISED	ANH	01/06/2017	Det.	Part No.	Qty.	Name & Material	Sheet	Remark
D	SPRING AND UPPER SPRING BRACKET REVISED	M.G.	15-08-00	RAW MAT. #	AS LISTED	Drawn	ANH	Scale	1:2
C	P/N'S 9324070, 9405450 WERE 9314070, 9505230, P/N 9304017 ADDED	M.G.	13-11-98	Mass in Kg.	N/A	Date	01/06/2017	Checked	
B	P/N 9312030 WAS 9302030 & COOLANT MANIFOLD REPLACED WITH NOZZLE	M.G.	22-07-96	Mat/Spec	AS LISTED	Titled	SAW ASSEMBLY S315D, S350D, S400B	Drw No.	9540000
A	REDRAWN ON COMPUTER	M.G.	16-05-96					Revision	01111

Page 4

Part No. 9540000

SHEET 3 OF 3

DO NOT SCALE

COMMERCIAL STOCK SIZES EXCEPTED AND UNLESS OTHERWISE NOTED TOLERANCES ON DIMENSIONS ARE:

METRIC

Size	To	Mach.	Cost*
6 mm	± 0.1	± 0.5	
30 mm	± 0.2	± 1.0	
100 mm	± 0.3	± 1.5	
300 mm	± 0.5	± 2.0	
1000 mm	± 0.6	± 3.0	
2000 mm	± 1.2	± 5.0	

* INCLUDES STRUCTURAL STEEL WORK.

REMOVE ALL BURRS AND SHARP EDGES BY 0.3 x 45° UNLESS OTHERWISE STATED

SURFACE FINISH

	Roughness Value	
	Met Umm	Grade No.
ROUGH	50	N12
	25	N11
	12.5	N10
MED	6.3	N 9
	3.2	N 8
FINE	1.6	N 7
	0.8	N 6
S. FINE	0.4	N 5
	0.2	N 4
POLISH LAP	0.1	N 3
	0.05	N 2
	0.025	N 1

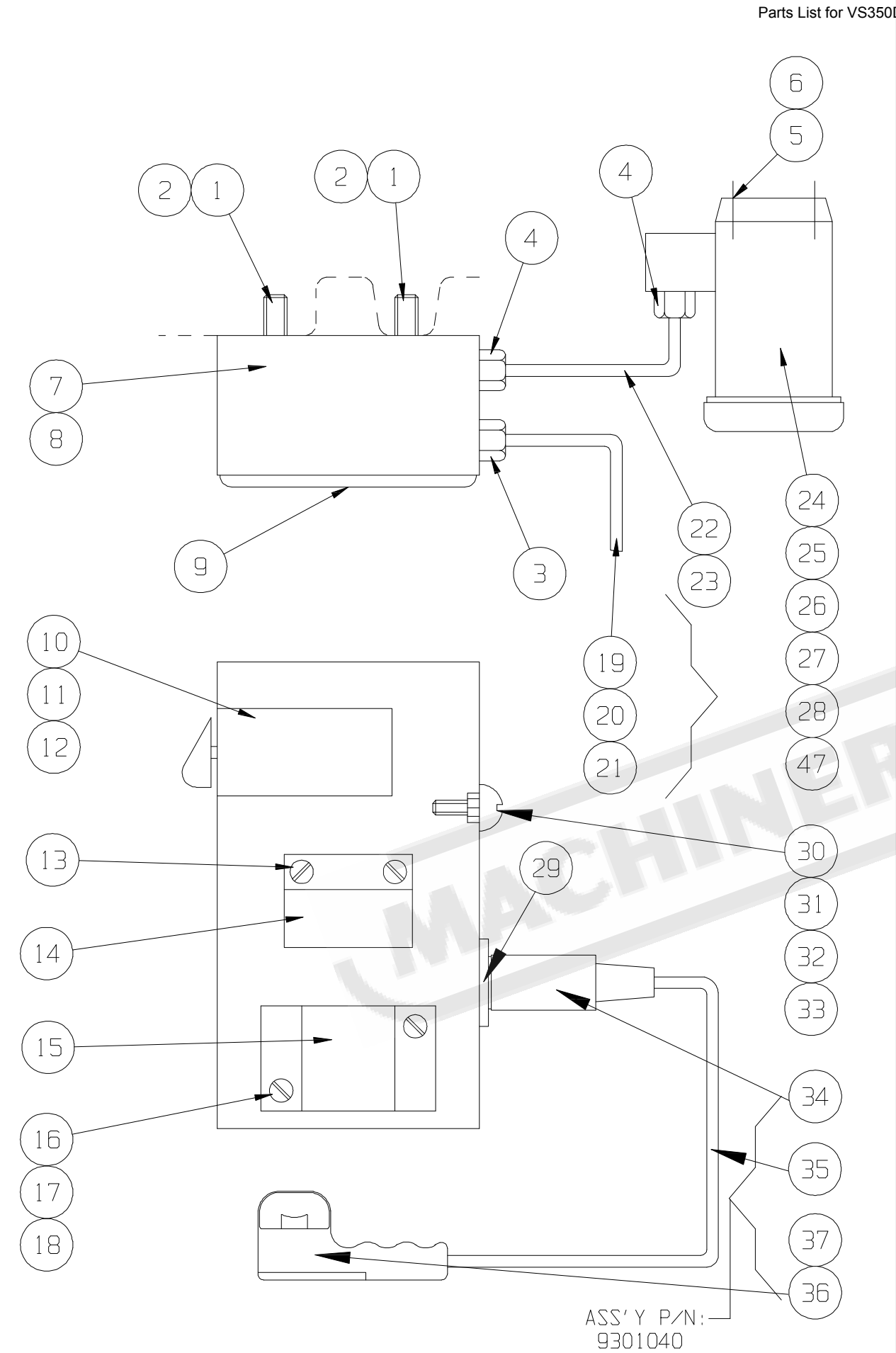
DRAWING PRACTICE TO AS 1100 - PROJECTION SYSTEM (UNLESS NOTED)

3RD ANGLE

ANGULARITY TOLERANCE < 0' 7"

CONCENTRICITY 0.1 mm

THIS DESIGN OR DRAWING IS NOT SOLD, BUT LENT AND IS SUBJECT TO RECALL. REPRODUCTIONS OF THIS DRAWING IN ANY MATERIAL FORM ARE RESERVED TO BROBD WALDOWN Pty. Ltd. UNDER COPYRIGHT LAW.



44	9504210	2	JUMPER LEAD	A4	
43	8745180	12	CABLE TIE 412mm LG.		
42	8725210	4	EYELET		
41	8725290	15	SPADE		
40	9504250	1	JUMPER LEAD	A4	
39	9504240	4	JUMPER LEAD	A4	NOT SHOWN
38	9504220	3	JUMPER LEAD	A4	NOT SHOWN
37	9104010	1	OPERATING HANDLE BAR MS PIPE	A4	
36	9105040	1	OPERATING HANDLE SWITCH WITH ENCLOSURE		
35	9304400	1	OPERATING SWITCH LEAD	A4	MAT: 8745100
34	9615500	1	SOCKET		
33	8725650	2	LOCK WASHER		
32	8705770	2	FLAT WASHER Ø 5		
31	8705700	2	HEX. NUT M5		
30	8715310	1	ROUND HD. SLOTTED SCREW M5 x 20 LG. (EARTH)		
29	9615490	1	PLUG		
28	9505620	1	MOTOR 440V, 3PH, 8/4POLE, 1.1/1.5kW, 60Hz		L90 FRAME, FACE MOUNT
27	9505080	1	MOTOR 415V, 3PH, 8/4POLE, 1.1/1.5kW, 50Hz		L90 FRAME, FACE MOUNT
26	9505010	1	MOTOR 415V, 3PH, 4/2POLE, 1.5/2.2kW, 50Hz		L90 FRAME, FACE MOUNT
25	9505150	1	MOTOR 220V, 3PH, 8/4POLE, 1.1/1.5kW, 60Hz		L90 FRAME, FACE MOUNT
24	9505220	1	MOTOR 240V, 1PH, 4POLE, 1.7kW, 50Hz		L90 FRAME, FACE MOUNT
23	9304850	1	MOTOR LEAD 3PH, (ASS'Y) 2 SPED	A4	
22	9304860	1	MOTOR LEAD 1PH, (ASSEMBLY)	A4	
21	9304870	1	SUPPLY LEAD 3PH, (ASSEMBLY)	A4	
20	9314540	1	SUPPLY LEAD 1PH, (NO PLUG FOR USA)	A4	
19	9501280	1	SUPPLY LEAD 1PH, 15AMP	A4	
18	8705760	2	FLAT WASHER Ø 4		
17	8705690	2	HEX. NUT M4		
16	8715280	2	ROUND HD. SLOTTED SCREW M4 x 12 LG.		
15	9315190	1	TRANSFORMER 220-440/24V, 50/60Hz		
14	9315220	1	CONTACTOR		
13	8715850	2	ROUND HD. SLOTTED SCREW M3 x 10 LG.		
12	9305960	1	SWITCH, ROTARY CAM		(N.S.W.-P.W.D.)
11	3835190	1	SWITCH, ROTARY CAM, 1PH & 3PH, 1 SPEED		
10	9305180	1	SWITCH, ROTARY CAM, 3PH, 2 SPEED		
9	9505200	1	LABEL, ELECTRICAL WARNING	A4	
8	9364810	1	ENCLOSURE, LARGE (WITH DEADMAN SWITCH)	A3	USE : 9305880
7	9524130	1	ENCLOSURE, SMALL (STD MACHINE)	A3	USE : 9505260
6	8705850	4	SPRING WASHER Ø 8		
5	8705130	4	SOC. HD. CAP SCREW M8 x 25 LG.		
4	3215270	2	CORDCLAMP STB13		ONLY IF 2 SPEED MOTOR FITTED
3	9305600	1	CORDCLAMP R20		
2	8705780	2	FLAT WASHER Ø 6		
1	8705050	2	SOC. HD. CAP SCREW M6 x 12 LG.		

Det.	Part No.	Qty.	Name & Material	Sheet	Remark
RAW MAT. #.	Drawn	ANH	Scale	N.T.S.	
Mass in Kg.	Date	02/06/2017	Checked		
Mat/Spec	Titled	ELECTRICAL ASSEMBLY DIAGRAM S315D, S350D, S400B	Drg No.	9540000	Revision
AS LISTED				SHEET 3 OF 3	

50					
49					
48					
47	9505670	1	MOTOR 220V, 3PH, 4/2 POLE, 1.1/1.5kW, 60Hz		
46	9904110	1	LEAD - ELECTRIC INTERLOCK	A4	
Det.	Part No.	Qty.	Name & Material	Sheet	

BROBD WALDOWN
Pty Ltd

DRG/PART No.
961000-5

DO NOT SCALE
COMMERCIAL STOCK SIZES
EXCEPTED AND UNLESS
OTHERWISE NOTED
TOLERANCES ON
DIMENSIONS ARE:
METRIC

Size To	Mach.	Cost*
6 mm	± 0.1	± 0.5
30 mm	± 0.2	± 1.0
100 mm	± 0.3	± 1.5
300 mm	± 0.5	± 2.0
1000 mm	± 0.6	± 3.0
2000 mm	± 1.2	± 5.0

* INCLUDES STRUCTURAL
STEEL WORK.

REMOVE ALL BURRS AND
SHARP EDGES BY 0.3 x 45°
UNLESS OTHERWISE STATED

SURFACE FINISH

	Roughness Value	
	Met Ulm	Grade No.
ROUGH	50	N12
	25	N11
	12.5	N10
	6.3	N9
MED	3.2	N8
FINE	1.6	N7
S FINE	0.8	N6
POLISH	0.4	N5
LAP	0.2	N4
	0.1	N3
	0.05	N2
	0.025	N1

DRAWING PRACTICE TO
AS 1100 - PROJECTION
SYSTEM (UNLESS NOTED)

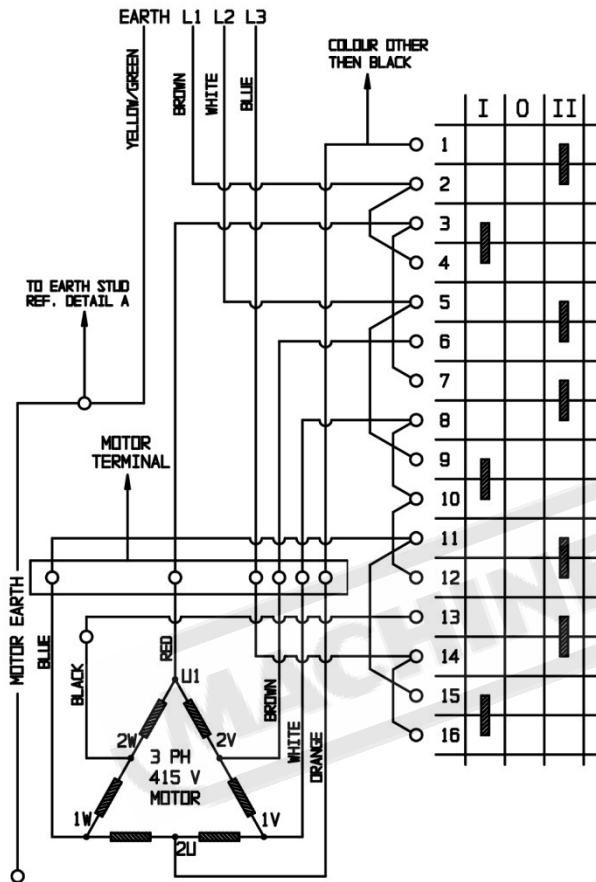
3RD
ANGLE

ANGULARITY TOLERANCE
< 0° 7'

CONCENTRICITY
0.1 mm

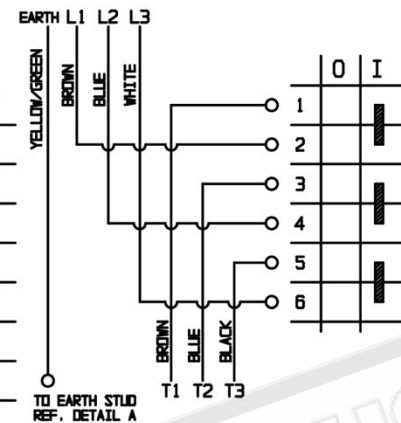
THIS DESIGN OR DRAWING IS
NOT SOLD, BUT LENT AND IS
SUBJECT TO RECALL.
REPRODUCTIONS OF THIS
DRAWING IN ANY MATERIAL
FORM ARE RESERVED TO
BROBO WALDOWN (AUST)
Pty. Ltd.
UNDER COPYRIGHT LAW.

415 V, 50 Hz, 3 PH (ALT: 220/440 V, 60Hz 3 PH)
SUPPLY



3 PH, DUAL SPEED

415 V, 50 Hz, 3 PH (ALT: 220/440 V, 60Hz 3 PH)
SUPPLY

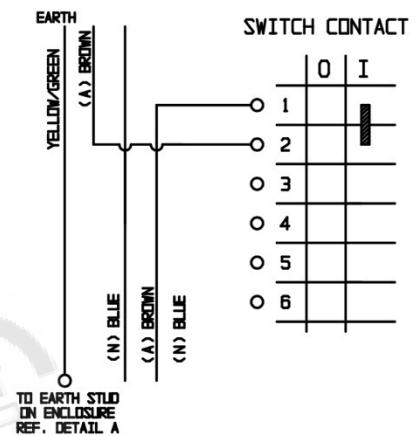


TO MOTOR
415 V, 50 Hz, 3 PH

3 PH, ONE SPEED
P/N:383519

MOTOR CABLE MARKING	CMG MOTOR TERMINAL MARKING	TECO MOTOR TERMINAL MARKING
1 RED	1U RED	RED
2 WHITE	1V YELLOW	YELLOW
3 BLUE	1W BLUE	BLUE
4 ORANGE	2U WHITE	WHITE
5 BROWN	2V BLACK	BLACK
6 BLACK	2W ORANGE	ORANGE

240 V, 50 Hz, 1 PH (ALT: 220 V, 60Hz 1 PH)
SUPPLY



TO MOTOR
240 V, 50 Hz, 1 PH

1 PH
SINGLE PHASE
ON/OFF SWITCH

A TECO TERMINAL MARKINGS ADDED

M.G. 13-08-03

Det.	Part No.	Qty.	Name & Material	Sheet	Remark
RAW MAT. #.	N/A	Drawn	M.G.	Scale	1:1
Mass in Kg.	N/A	Date	28 Jun 95	Checked	
Mat/Spec	N/A	Titled	ELECTRICAL CIRCUIT FOR 1ph, 3ph & 3ph DUAL SPEED - KLOCKNER MOELLER	Drng No.	961000-5
		Revision			



BROBO WALDOWN
AUSTRALIA Pty Ltd

CADKEY A3

DRG/PART No.

9301400

DO NOT SCALE

COMMERCIAL STOCK SIZES
EXCEPTED AND UNLESS
OTHERWISE NOTED
TOLERANCES ON
DIMENSIONS ARE:

METRIC

Size	To	Mach.	Cast*
8	nn	± 0.1	± 0.5
30	nn	± 0.2	± 1.0
100	nn	± 0.3	± 1.5
300	nn	± 0.5	± 2.0
1000	nn	± 0.6	± 3.0
2000	nn	± 1.2	± 5.0

* INCLUDES STRUCTURAL
STEEL WORK.

REMOVE ALL BURRS AND SHARP EDGES BY 0.3 x 45°

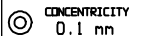
SURFACE FINISH

	Roughness Value	
	Met Uhn	Grade No.
ROUGH	50	N12
	25	N11
	12.5	N10
MED	6.3	N 9
	3.2	N 8
	1.6	N 7
FINE	0.8	N 6
S FINE	0.4	N 5
POLISH	0.2	N 4
LAP	0.1	N 3
	0.05	N 2
	0.025	N 1

DRAWING PRACTICE TO
AS 1100 - PROJECTION
SYSTEM (UNLESS NOTED)



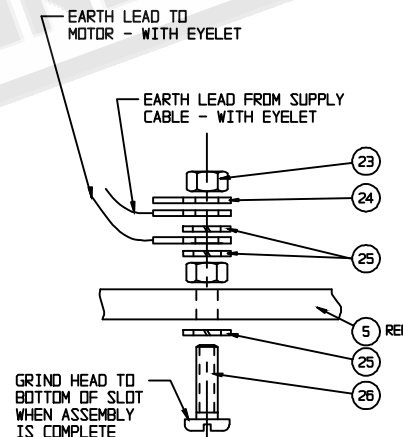
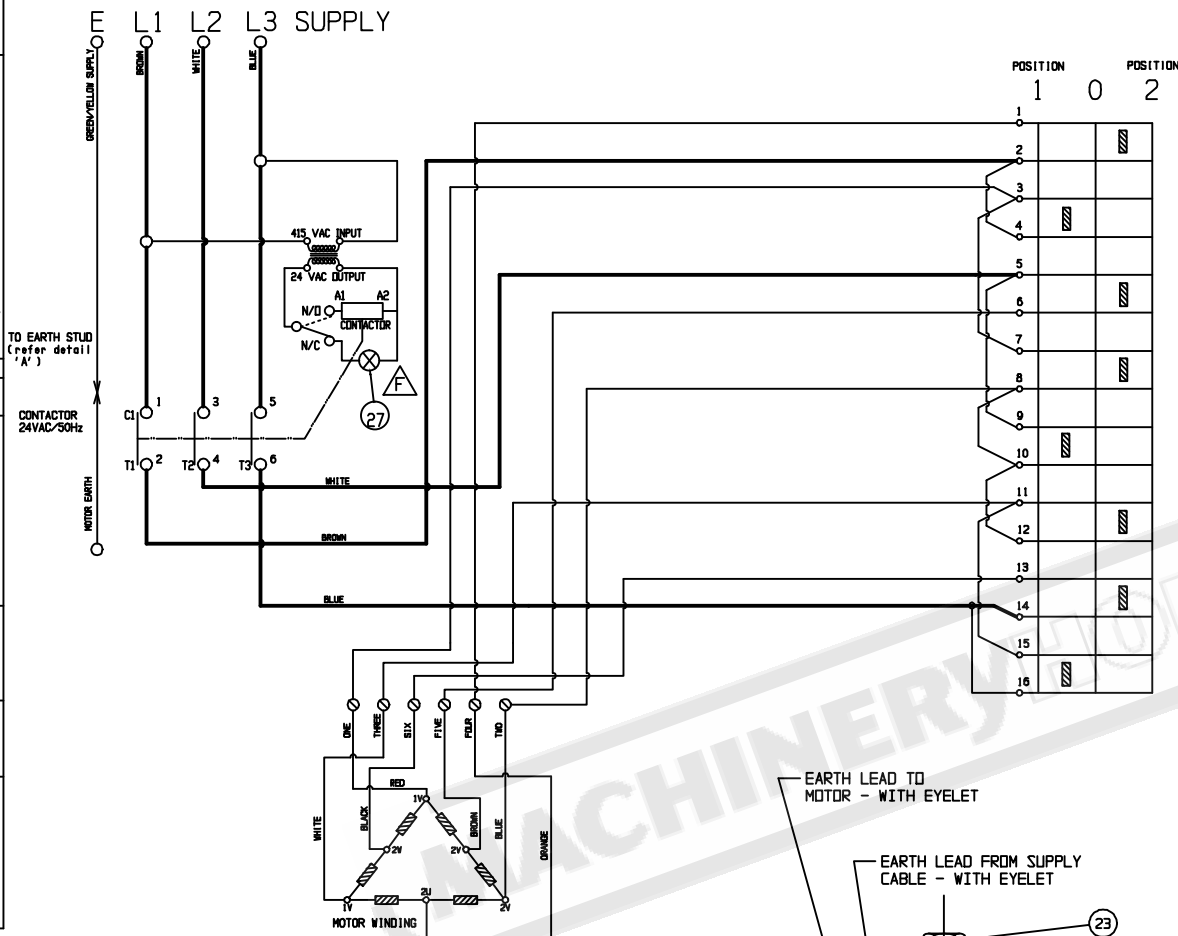
ANGULARITY TOLERANCE
 $< 0^{\circ} 7'$



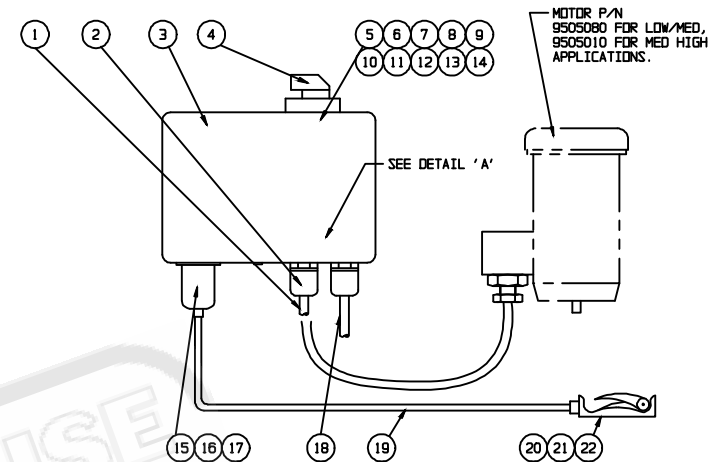
THIS DESIGN OR DRAWING IS
NOT SOLD, BUT LENT AND IS
SUBJECT TO RECALL.
REPRODUCTIONS OF THIS
DRAWING IN ANY MATERIAL
FORM ARE RESERVED TO
BROBOWALDOW (AUST)
Pty. Ltd.
UNDER COPYRIGHT LAW.

NOTES:

- 1/ ITEM 1 CONSISTS OF 4 CORE 30/0.25 FLEX WITH 1 OFF H3115 EYELET FOR EARTH, AND 7 OFF BLP150 BOOT LACE PINS.
- 2/ ITEM 18 CONSISTS OF 7 CORE 30/0.25 FLEX WITH 2 OFF H3115 EYELETS FOR EARTH, AND 12 OFF BLP150 BOOT LACE PINS.
- 3/ ITEM 19 CONSISTS OF 2 CORE 32/0.20 FLEX, ONE END STRIP 13mm, OTHER END CRIMP WITH 2X SPADE LUG (FIGCI 25.6.4.06) OR SOLDER,
- 4/ ALL OTHER WIRES CONNECTING BETWEEN SWITCHGEAR AND COMPONENTS TO HAVE BLP150 BOOT LACE PINS.



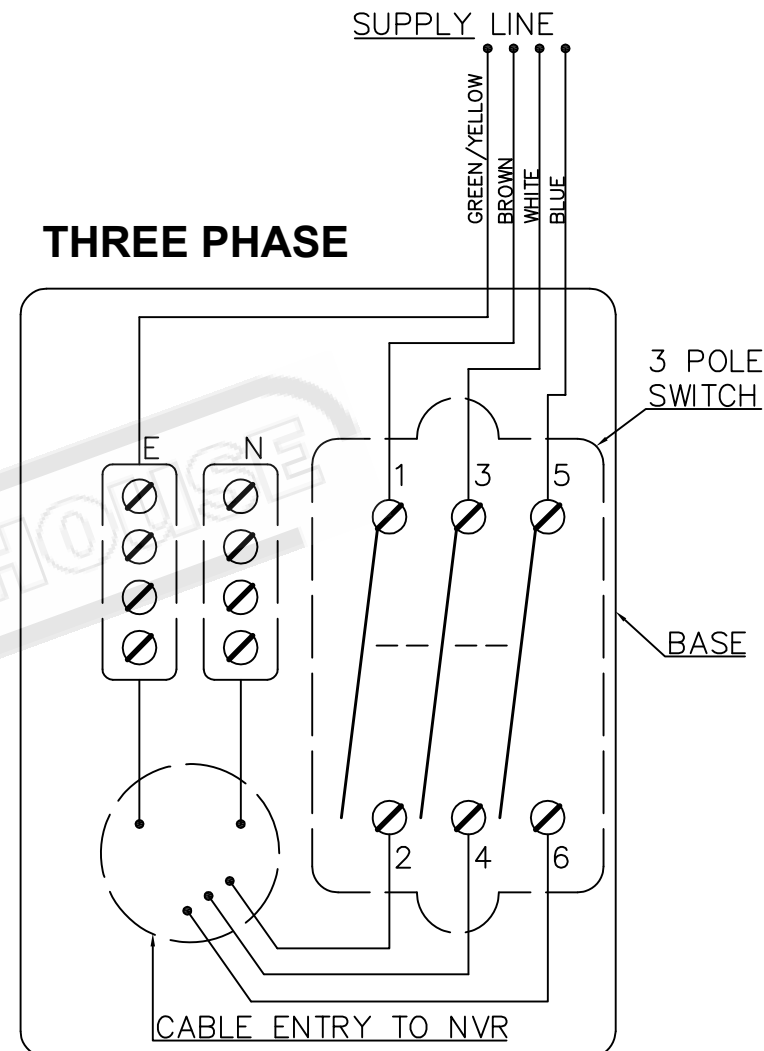
DETAIL 'A'



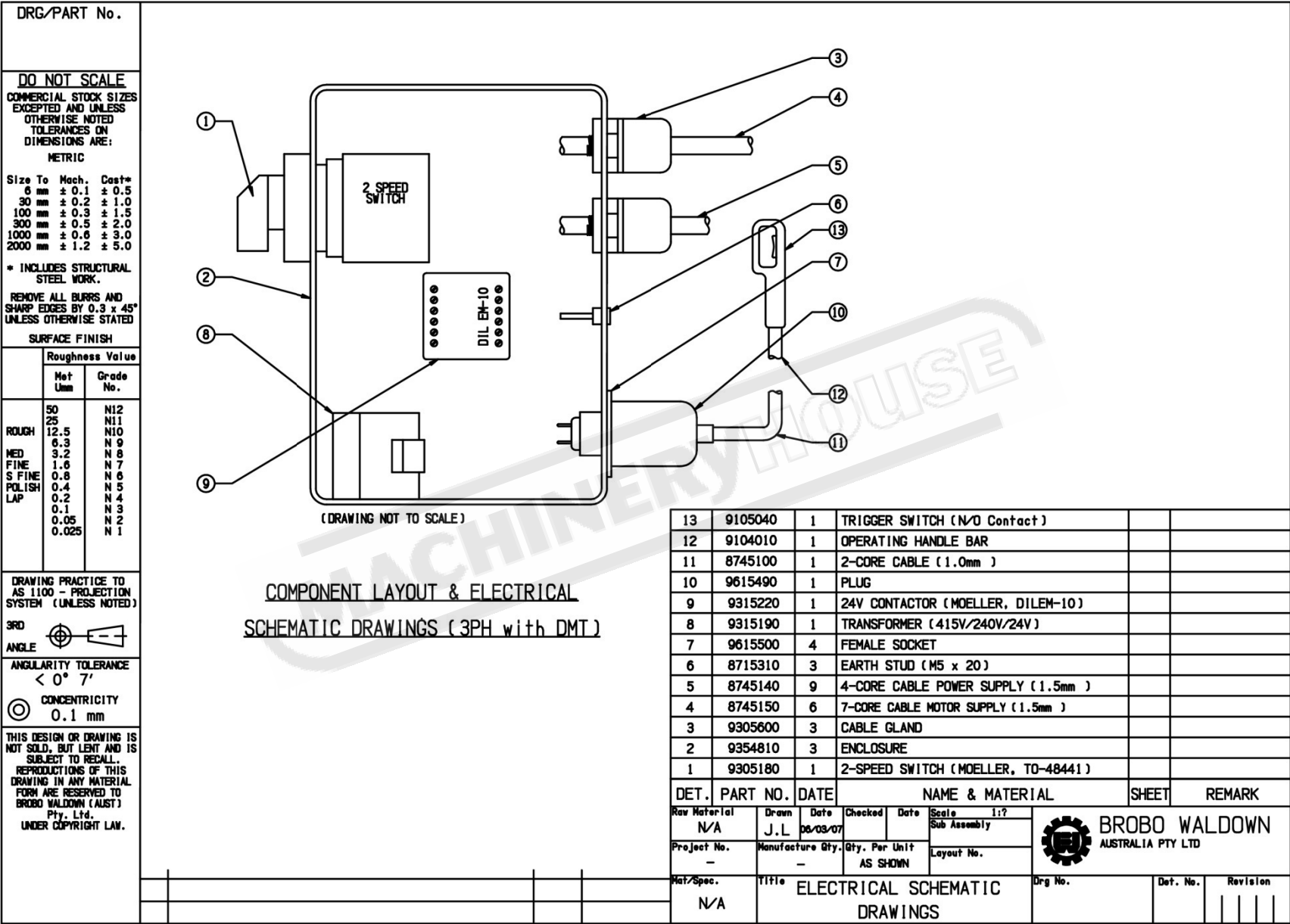
27	3875475	1	LED STANDBY		
26	8715310	1	CHEESE HEAD SLOTTED SCREW M5 X 20		
25	8725650	3	LOCKWASHER Ø 5		
24	8725210	1	EYELET Ø 5 NON INSULATED		SUPPLIED LOOSE
23	8705700	2	HEX NUT M5		
22	9105040	1	OP. HANDLE SWITCH WITH ENCLOSURE		
21	9305140	1	HEX LOCK NUT M20 X 1.5		
20	9104010	1	OP. HANDLE BAR Ø21.3 X 355 LG	A4	
19	9304400	1	OP. SWITCH LEAD 2 CORE 32/0.20	A4	
18	9304850	1	MOTOR LEAD - 3 PHASE	A4	
17	8725720	2	FLAT HEAD SLOTTED SCREW M4 X 16		
16	9615490	1	PLUG IEC 480		
15	9615500	1	SOCKET IEC 550		
14	8745180	12	CABLE TIE 142 MM LONG		
13	8745440	8	BOOTLACE PINS BLP150		
12	8745590	1	SINGLE SOLIDCORE INS. WIRE Ø 1.4 X 1 METRE		
11	8705760	2	FLAT WASHER Ø 4		
10	8705690	2	HEX NUT M4		
9	8705900	2	LOCKWASHER Ø 5/32		
8	8735410	4	CHEESE HEAD SLOTTED SCREW M4 X 10		
7	9315220	1	CONTACTOR 24V AC	A4	
6	9315190	1	TRANSFORMER 220-440/24V 50/60 Hz		
5	9364810	1	ENCLOSURE - LARGE	A3	
4	9305180	1	SWITCH ROTARY CAM - 3 PH		
3	9505200	1	LABEL - ELECTRICAL WARNING	A4	
2	9305600	3	CORROCLAMP R20		
1	9304870	1	SUPPLY LEAD - 3 PHASE	A4	

F	REVISED	ANH	08-05-17	Det. Part No.	Qty.	Name & Material	Sheet	Remark
E	P/N 8725210 WAS 8735400, 8735390 DELETED	M.G.	15-08-02	RAW MAT. #	N/A	Drawn	Scale	 ROBO WALDOWN AUSTRALIA Pty Ltd
D	P/N'S 9615490, 9615500 WERE 9605490, 9605500.	M.G.	9-04-96	Loss in Kg.	N/A	Date	Checked	
C	REDRAWN ON COMPUTER, REVISED AND SCHEMATIC ADDED	M.G.	11-10-95	Mat/Spec	N/A	Titled		
B	ITEM 12 WAS 8705030 FLEX CABLE	G.F.	7-03-94	ELECTRICAL ASS'Y FOR 3 PHASE SAWS WITH DMT HANDLE			Dwg No. 9301400	
A	ITEMS 15 & 16 WERE 930517/F & 930517/M	G.F.	3-12-93				Revision	

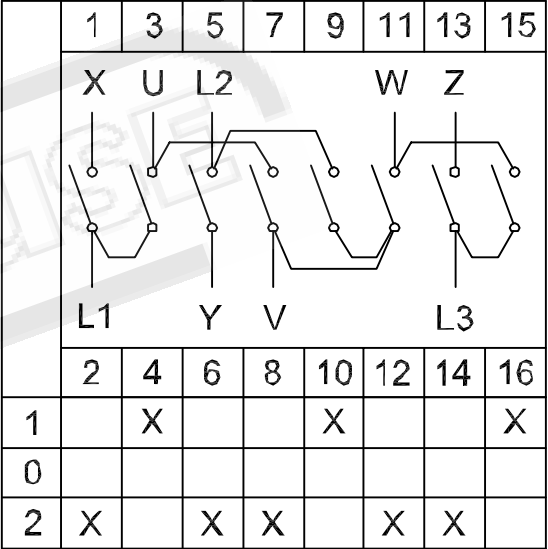
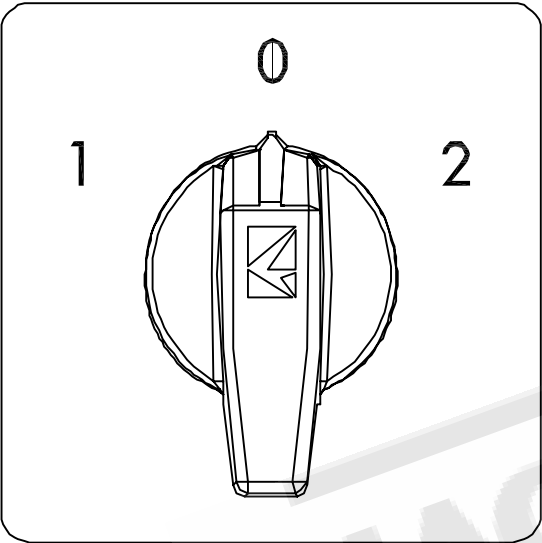
THREE PHASE



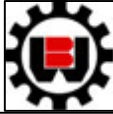
FILE NAME	Electrical Diagram.dwg	SHEET	-	SCALE	NTS
SIZE	A3				
DRAWN					
CHECK					
APPR.			BROBO GROUP 8 Fowler Road Dandenong Vic3175		
ISSUED	31.03.2017 ANH				
REV	1				
CONTRACT NO		DWG NO 2017-0331			



RevNo	Revision note	Date	Signature	Checked
0	ISSUED	28/08/2017		ANH

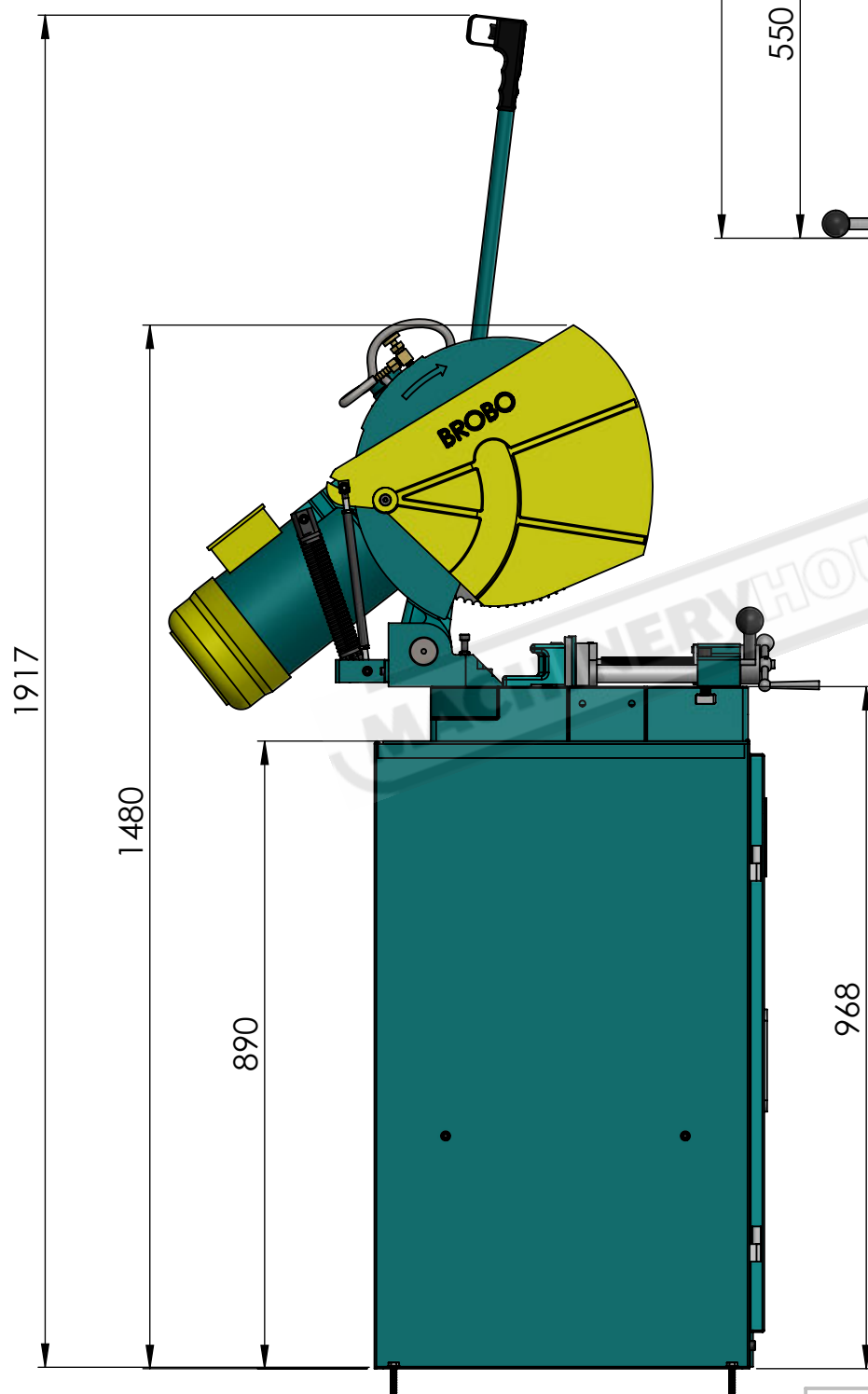
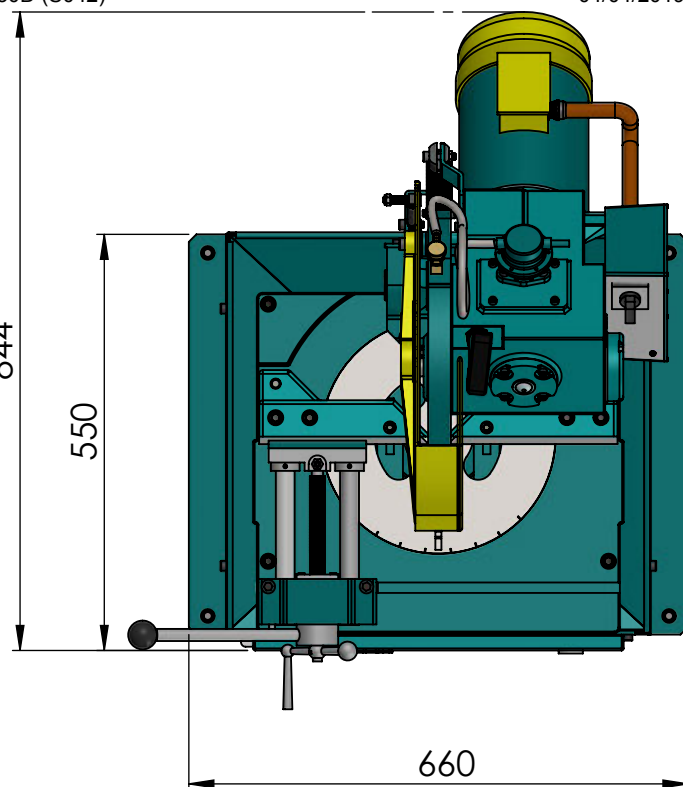


ELECTRICAL DIAGRAM
2 Speed Switch (1-0-2)

FILE NAME	E2017082801 PSA Cam Switch.dwg	SHEET	-	SCALE	NTS
SIZE	A3	 BROBO GROUP 8 Fowler Road Dandenong Vic3175			
DRAWN					
CHECK					
APPR.					
ISSUED	28.08.2017 ANH	DWG NO E2017082801			
REV	0				
CONTRACT NO					

NOTE

MINIMUM 600MM ALL
AROUND SAFE SPACE FOR
OPERATING ZONE

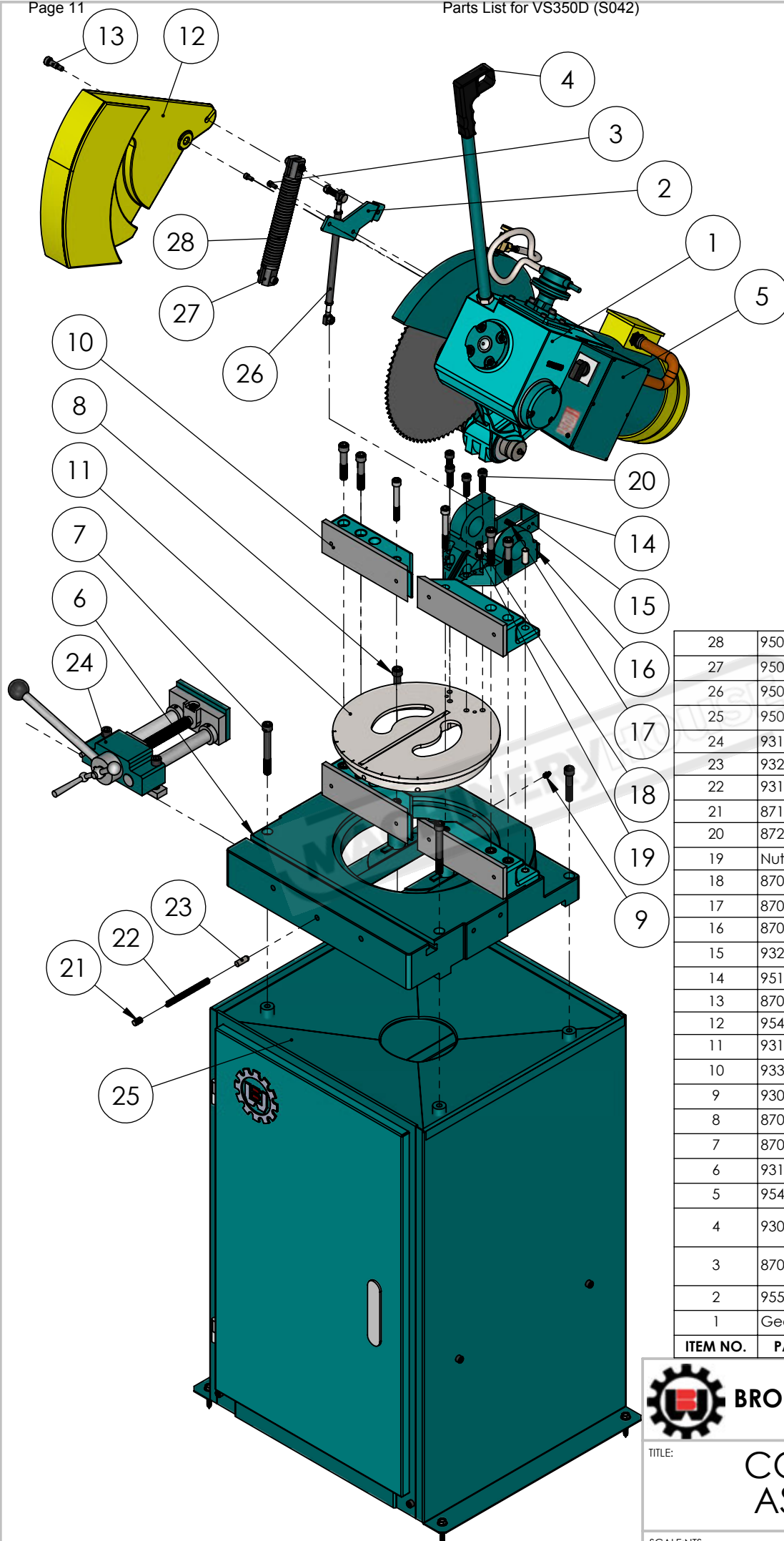
**SIDE VIEW****TOP VIEW****BROBO GROUP**ISSUED DATE 25.08.2017
DRAWN BY ANH

TITLE:

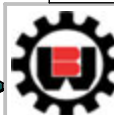
**COLD SAW
MAIN DIMENSIONS****A4**

SCALE:NTS

SHEET 1 OF 1



28	9501670	Spring Assembly	1
27	9502120	Spring Clevis	2
26	9501300	Link Assembly	1
25	9503130	Saw Stand Assembly	1
24	9311060	Standard Manual Vice	1
23	9324180	Pin Lock	1
22	9315000	Spring 9.5x110mm	1
21	8715810	Head Set M12x16	1
20	8725500	Soc HD Cap M10x35	4
19	Nut M8	Hex Head M8	3
18	8705140	Soc HD Cap M8x35	3
17	8705130	Screw M8x25	1
16	8705340	Hex HD Cap M6x16	2
15	9324270	Spring Bracket Lower	1
14	9512030	Pivot Block	1
13	8705440	SH Shoulder M10	1
12	9542050	Outer Guard	1
11	9312020	Rotary Table	1
10	9332060	Back Fence Assembly	2
9	9305110	Grease Nipple M8	1
8	8705270	Soc HD Cap M12x60	2
7	8705300	Soc HD Cap M12x100	2
6	9312000	Clamping Table	1
5	9540000	Electrical Box Assembly	1
4	9301040	Deadman Trigger Assembly	1
3	8705050	Screw Soc Hex HD Cap M6x12	2
2	9554030	Spring Bracket Upper	1
1	Gearbox	Gearbox Assembly	1
ITEM NO.	PART NO.	DESCRIPTION	QTY.



BROBO GROUP

ISSUED DATE 03.11.2017
DRAWN BY ANH

TITLE:

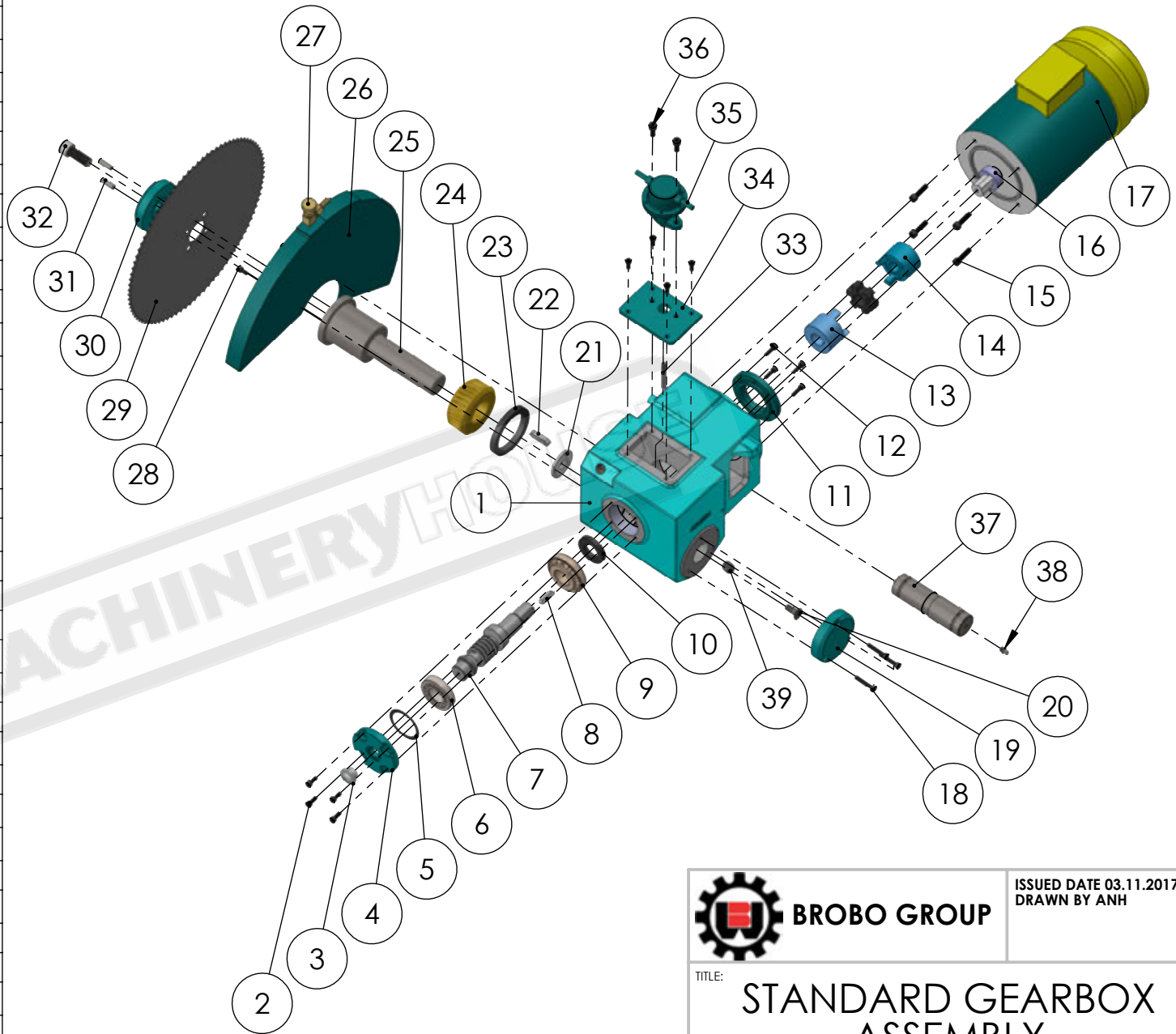
COLD SAW
ASSEMBLY

A4

SCALE:NTS

SHEET 1 OF 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	9512000	Gearbox	1
2	8705340	Hex HD Cap M6x16	8
3	9405010	Oil Sight Window	1
4	9302120	Front Cover Plate	1
5	9305350	Shim 50x62x0.1	1
6	9305020	Taper Roller Bearing 30x62x17.25	1
7	9314000	Worm Shaft	1
8	9304430	Key Wormshaft 7x8x32	1
9	9305030	Taper Roller Bearing 30x72x20.75	1
10	9315040	Oil Seal $\phi 52 \times \phi 30 \times 8$	1
11	9312100	Retainer Ring	1
12	8705070	Screw Soc Hex HD Cap M6x20	4
13	9301430	Jaw Coupling ML100 25mm	1
14	9301420	Jaw Coupling ML100 24mm	1
15	8725770	Screw Soc HD Cap M8x30	4
16	9504120	Spacer 39x24x14	1
17	-	Motor	1
18	8705090	Screw Soc Hex HD Cap M6x35	3
19	9302110	Side Cover Plate	1
20	8705420	Screw Flat Head M10x25	1
21	9304130	Retainer Washer 55x10	1
22	9314420	Key - Main Spinder	1
23	9305010	Seal	1
24	9314050	WormWheel	1
25	9504080	Main Spindle S315.S350	1
26	9502040	Inner Guard	1
27	9105050	Coolant Tap	1
28	8705050	Screw Soc Hex HD Cap M6x12	2
29	9025800	Sawblade 350	1
30	9504090	Spindle Counter Plate	1
31	8715080	Roll Pin 8x25	2
32	8735090	M16 x 40	1
33	9304017	Pin - Coolant Pump	1
34	9324070	Cover Plate (10)	1
35	9405450	Coolant Pump	1
36	8705120	Screw M8x20	2
37	9304030	Pivot Shaft	1
38	9305110	Grease Nipple M8	2



* Bolt M6 with Spring Washer $\phi 6$ (8705840)



BROBO GROUP

ISSUED DATE 03.11.2017
DRAWN BY ANH

TITLE:

**STANDARD GEARBOX
ASSEMBLY**

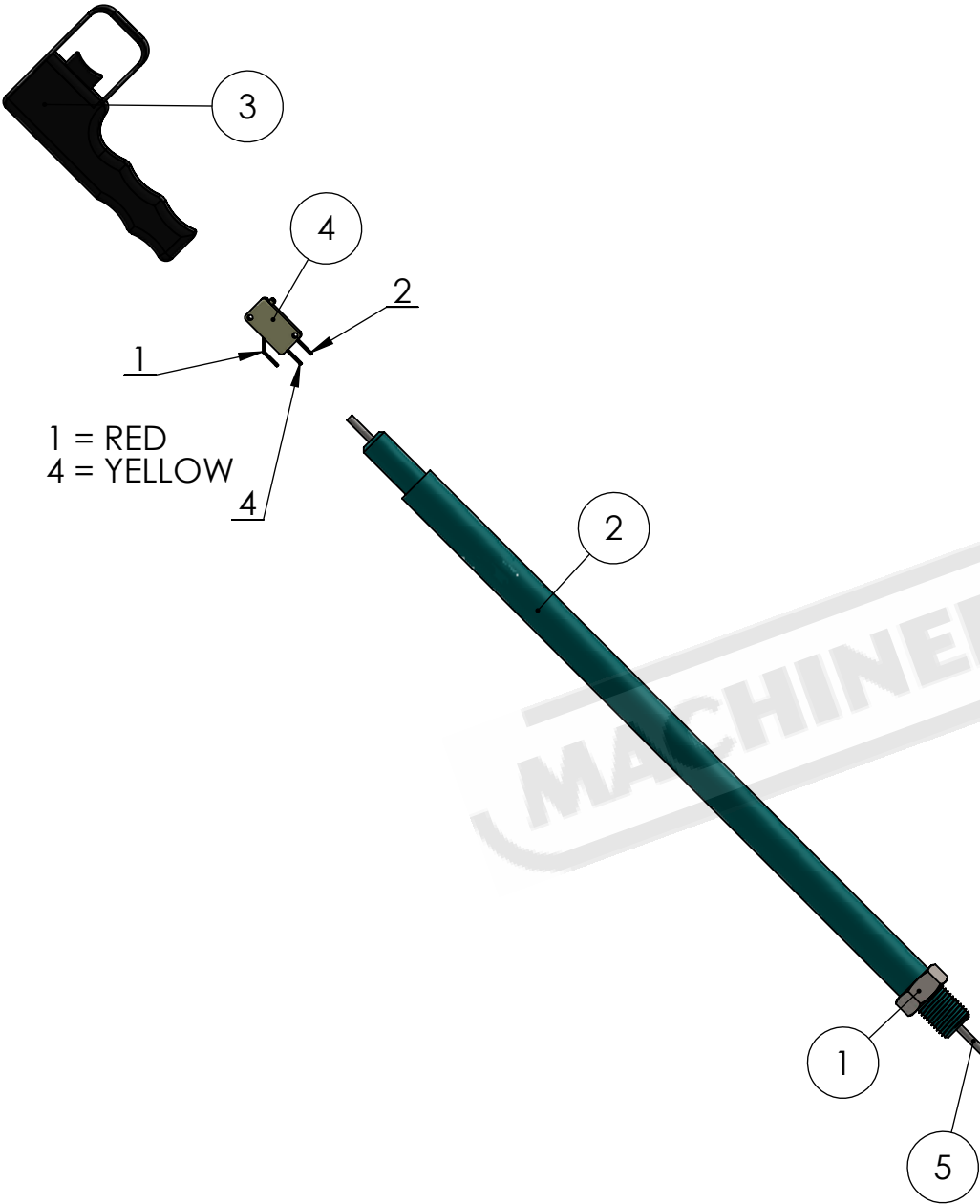
PART NO.

-

A4

SCALE:NTS

SHEET 1 OF 1

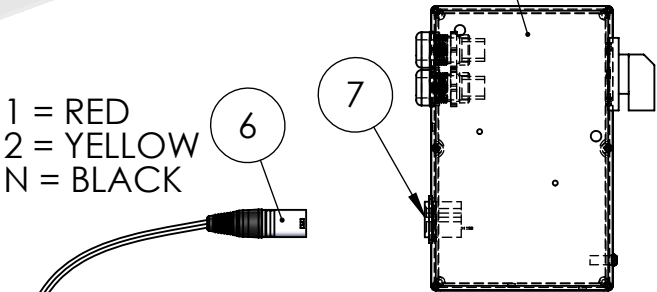


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	-	Nut M16	1
2	9104010	Swing Handle	1
3	9105040	Deadman Trigger	1
4	MS	Micro Switch	1
5	Cable	Cable White	1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
6	9615500	XLR Line Plugs AC3MM PD5302	1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
7	9615490	XLR Socket PD5367	1

Electrical Box Assembly



BROBO GROUP

ISSUED DATE 25.07.2017
DRAWN BY ANH

TITLE:

DEADMAN TRIGGER
ASSEMBLY

PART NO.

9301040

A4

SCALE:NTS

SHEET 1 OF 1

0000	Cover Plate	1
0120	Vice Nut	1
0270	Soc HD Capscrew M12x60 LG	2
0500	Vice Block	1
0170	Quick Action Nut	1
0020	Vice Screw	1
0440	Handle Crank	1
0940	Rollpin $\varnothing 4 \times 24$ LG	1
0020	Knob 38x M12	1
0090	Quick Action Handle	1
0380	Rollpin $\varnothing 8 \times 40$ LG	1
0280	Vice Block Clamp	2
0980	Rollpin $\varnothing 6 \times 16$ LG	1
0090	Compression Spring	2
0460	Screw Flat HD M5x8 LG	2
0100	Socket Button Head Cap Screw M6x16	4



BROBO GROUP

ISSUED DATE 08.11.2017

TITLE: **STANDARD MANUAL VICE ASSEMBLY**

PART NO. **9311060**

A4

SCALE:1:5

SHEET 1 OF 1



BROBO GROUP

ISSUED DATE 08.11.2017

TITLE:

STANDARD MANUAL VICE ASSEMBLY

PART NO.

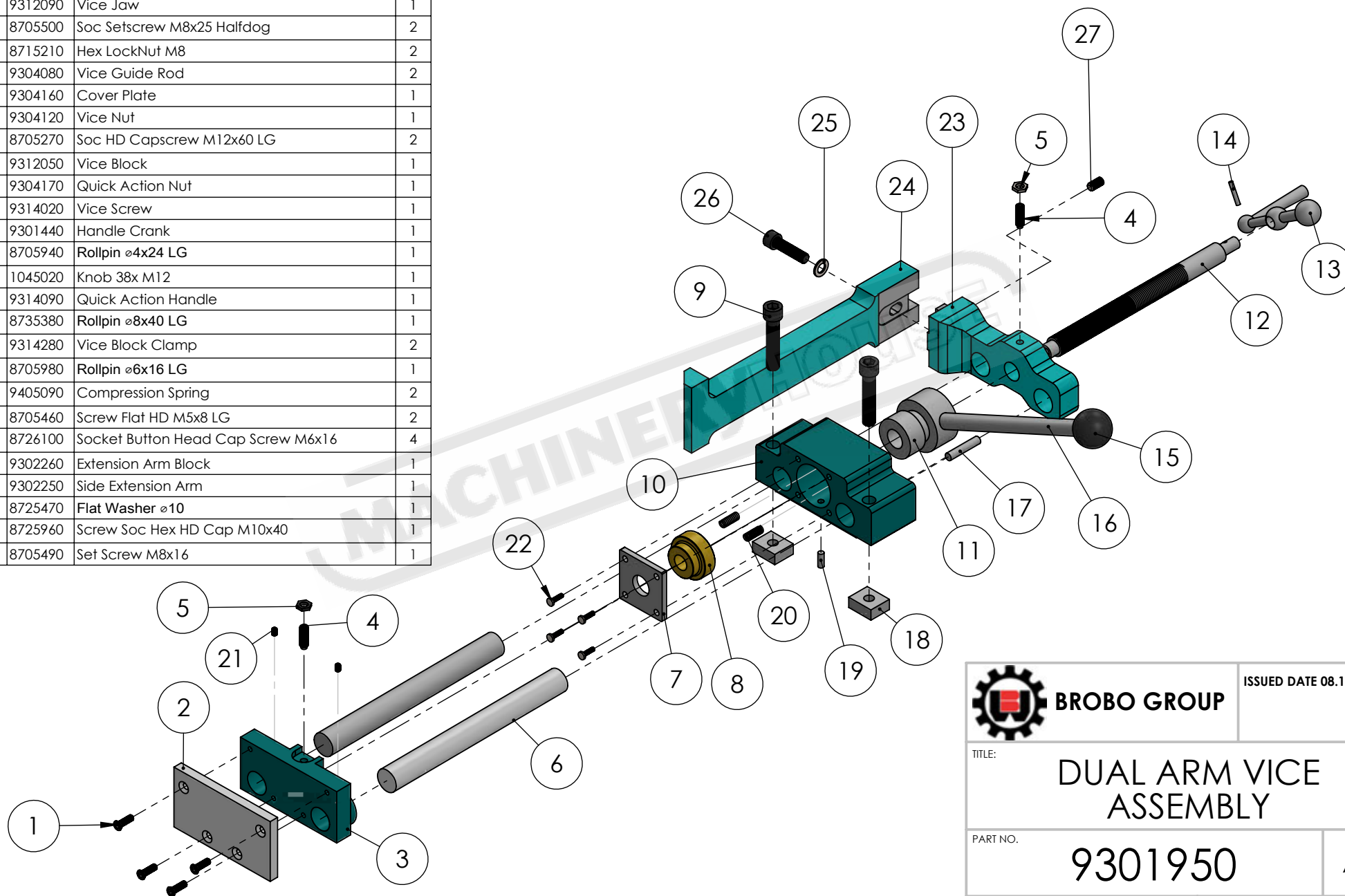
9311060

A4

SCALE:1:5

SHEET 1 OF 1

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	8705350	Flat Hex HD Cap M6x16	4
2	9314100	Jaw Pad (Front)	1
3	9312090	Vice Jaw	1
4	8705500	Soc Setscrew M8x25 Halfdog	2
5	8715210	Hex LockNut M8	2
6	9304080	Vice Guide Rod	2
7	9304160	Cover Plate	1
8	9304120	Vice Nut	1
9	8705270	Soc HD Capscrew M12x60 LG	2
10	9312050	Vice Block	1
11	9304170	Quick Action Nut	1
12	9314020	Vice Screw	1
13	9301440	Handle Crank	1
14	8705940	Rollpin $\varnothing 4 \times 24$ LG	1
15	1045020	Knob 38x M12	1
16	9314090	Quick Action Handle	1
17	8735380	Rollpin $\varnothing 8 \times 40$ LG	1
18	9314280	Vice Block Clamp	2
19	8705980	Rollpin $\varnothing 6 \times 16$ LG	1
20	9405090	Compression Spring	2
21	8705460	Screw Flat HD M5x8 LG	2
22	8726100	Socket Button Head Cap Screw M6x16	4
23	9302260	Extension Arm Block	1
24	9302250	Side Extension Arm	1
25	8725470	Flat Washer $\varnothing 10$	1
26	8725960	Screw Soc Hex HD Cap M10x40	1
27	8705490	Set Screw M8x16	1



BROBO GROUP

ISSUED DATE 08.11.2017

TITLE:

DUAL ARM VICE
ASSEMBLY

PART NO.

9301950

A4

SCALE:1:5

SHEET 1 OF 1