

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

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	25	N12
	12.5	N11
RELISH	6.3	N10
	3.2	N9
MED	1.6	N8
	0.8	N7
FINE	0.4	N6
	0.2	N5
S. FINE	0.1	N4
	0.05	N3
POLISH	0.025	N2
	0.01	N1

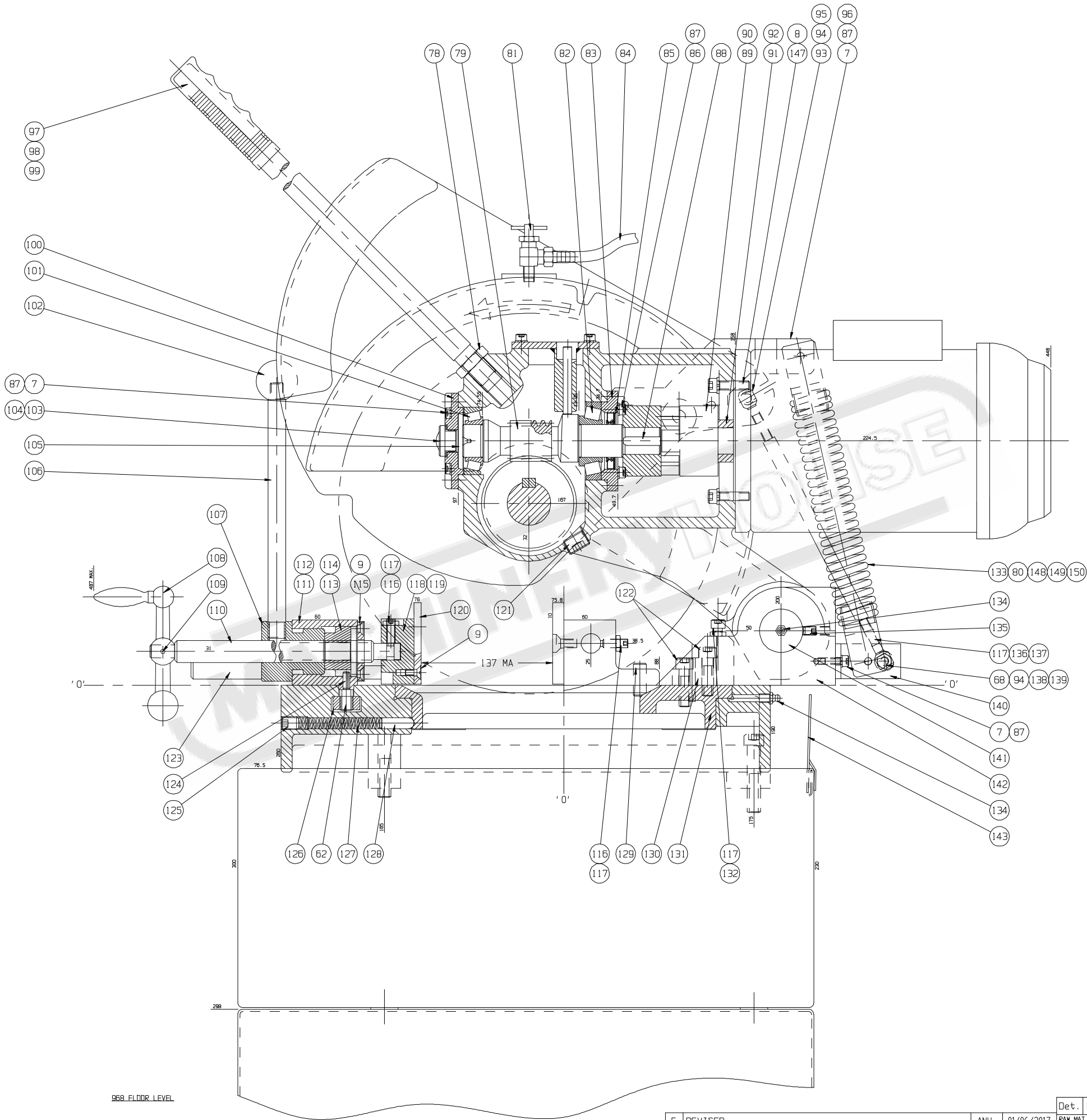
DRAWING PRACTICE TO
AS 1100 - PROJECTION
SYSTEM (UNLESS NOTED)

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
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E	REVISED	ANH	01/06/2017
D	SPRING AND UPPER SPRING BRACKET REVISED	M.G.	15-08-00
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
A	REDRAWN ON COMPUTER	M.G.	16-05-96

Det.	Part No.	Qty.	Name & Material		Sheet	Remark
RAW MAT. #	AS LISTED	Drawn	ANH		Scale 1:2	 BROBD WALDOWN AUSTRALIA Pty Ltd
Mass in Kg.	N/A	Date	01/06/2017		Checked	
Mat/Spec	AS LISTED	Titled SAW ASSEMBLY S315D, S350D, S400B			Drw No. 9540000 SHEET 2 OF 3	Revision

DRG/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	

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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
	6.3	N 9
MED	3.2	N 8
	1.6	N 7
FINE	0.8	N 6
	0.4	N 5
POLISH LAP	0.2	N 4
	0.1	N 3
	0.05	N 2
	0.025	N 1

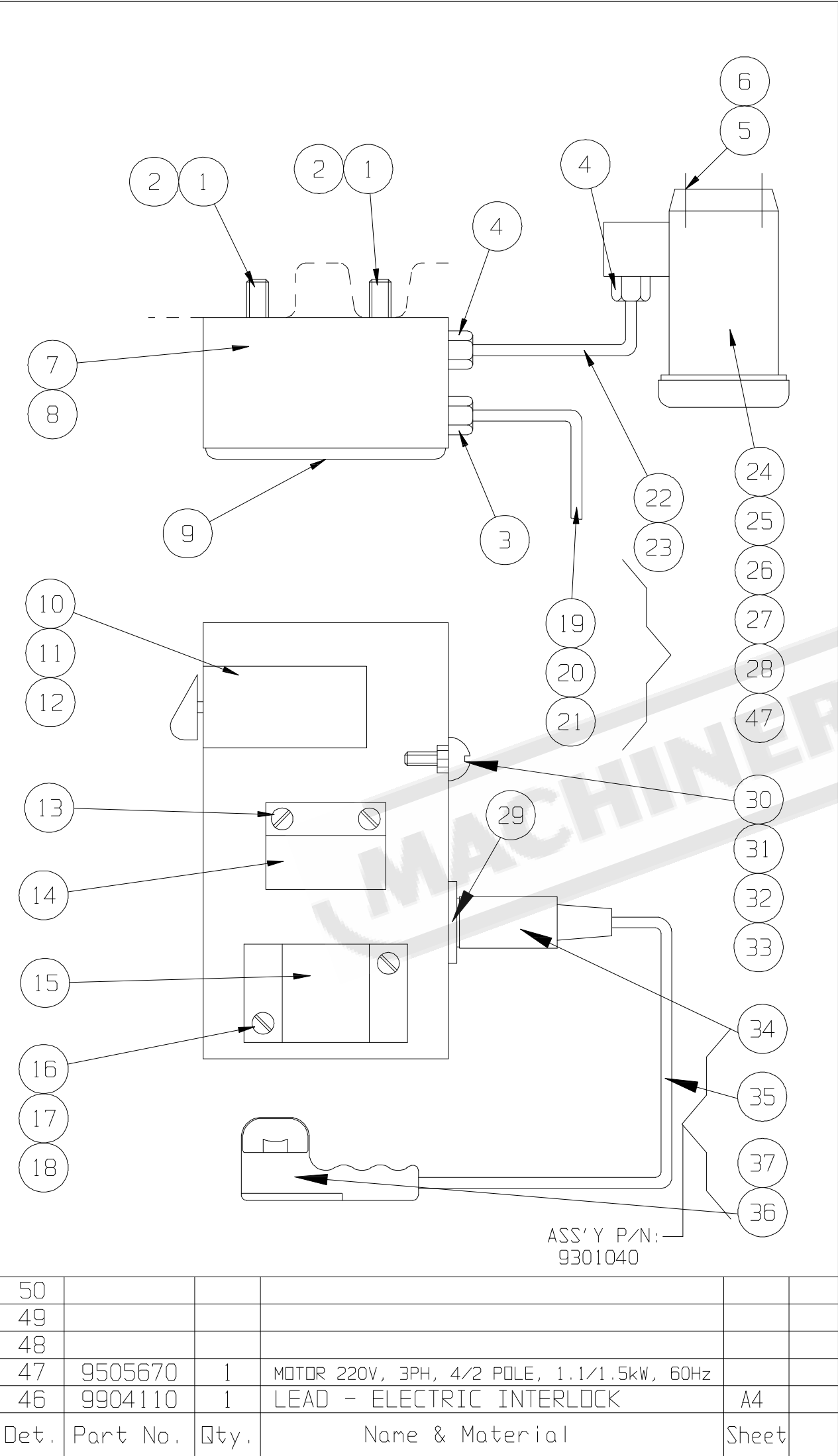
DRAWING PRACTICE TO
AS 1100 - PROJECTION
SYSTEM (UNLESS NOTED)

3RD
ANGLE

ANGULARITY TOLERANCE
< 0' 7"

CONCENTRICITY
0.1 mm

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45	9904100	1	LEAD - TRANSFORMER FEED	A4	
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
AS LISTED				Revision	
Det.	Part No.	Qty.	Name & Material	Sheet	