

# INSTRUCTION MANUAL

**MC-370PV**

**Soco Cold Saw Includes Stand (415V)**

**110 x 110mm**

**Dual Speed 22-44rpm with Self Centring  
Vice & Pneumatic Vice**



**S842**

## Model : MC-370F Trouble Shooting Guide

Problems	Sources	Solutions
1. Machine will not start	<ul style="list-style-type: none"> <li>a. Main power cable is not connected to the power source.</li> <li>b. Feed lever switch is broken, or the control wire is disconnected.</li> <li>c. The transformer is shorted and broken.</li> <li>d. The Phase Converter is broken (if using Phase Converter).</li> </ul>	<ul style="list-style-type: none"> <li>a. Check power supply.</li> <li>b. Use multi meter to test the feed lever switch and the control wire.</li> <li>c. Use multi meter to test the transformer. If the output value is incorrect, the transformer is broken. Replace it when needed.</li> <li>d. Use multi meter to test the Phase Converter. Replace the Phase Converter when needed.</li> </ul>
2. Motor will not start	<ul style="list-style-type: none"> <li>a. One or more of the 3 phases of the main power is not connected.</li> <li>b. The Select Switch is shorted and broken.</li> <li>c. The Solenoid Switch is not well connected. (One or more of the connecting wires is not connected).</li> <li>d. The motor is shorted or broken.</li> </ul>	<ul style="list-style-type: none"> <li>a. Use multi meter to test if all of the 3 phases are connected.</li> <li>b. The Select Switch controls the high or low speed. If one of the speeds is not working, the select switch is broken. To test, connect power supply directly to the motor to see if the select Switch is broken. Replace when needed.</li> <li>c. Use multi meter to test the Solenoid Switch. If one or more of the connecting wires is not connected, replace the Solenoid Switch.</li> <li>d. Use multi meter to test the 3 phases of the main power. If all 3 phases are normal, the motor may be broken. Replace it when needed.</li> </ul>
3. Coolant Pump not working	<ul style="list-style-type: none"> <li>a. Inadequate coolant.</li> <li>b. The Coolant Pipe Check Valve is clogged.</li> <li>c. The Coolant Nozzle is clogged.</li> <li>d. Coolant pump is reversed or burned.</li> </ul>	<ul style="list-style-type: none"> <li>a. Refill coolant (up to 8/10 of the tank).</li> <li>b. Clean Coolant Pipe Check Valve, or replace it.</li> <li>c. Clean Coolant Nozzle or replace it.</li> <li>d. If the coolant pump is reversed, switch any 2 of the 3 phases. Replace the coolant pump if it is burned.</li> </ul>
4. Clamping Vise cannot be moved	<ul style="list-style-type: none"> <li>a. The rail shaft is rusted.</li> <li>b. Accumulated metal fragments around the screw shaft or the nuts.</li> <li>c. The holes on the Clamping Vise</li> </ul>	<ul style="list-style-type: none"> <li>a. Take off the rail shaft and clean up the rust.</li> <li>b. Take off the screw shaft and the nuts on the shaft. Clean up the metal fragments on these parts.</li> <li>c. Test by moving the whole Clamping Vise Set.</li> </ul>

	are worn out, or the rail shaft is worn out.	If it is loose (the set is worn out), replace it with a new set.
5. Broken or Chipped Blade	<ul style="list-style-type: none"> <li>a. Incorrect selection of the blade (incorrect number of teeth).</li> <li>b. The work piece is loose, and the locking nut in front of the handle is loose.</li> <li>c. The vise is worn out and loose.</li> <li>d. The gear inside of the machine head is worn out. As a result, the blade is loose (if moved by hand, the blade rotates too much).</li> <li>e. The blade is installed facing the wrong direction (The sharpened end of the teeth must face the same direction toward which the blade rotates).</li> <li>f. The blade is loose.</li> </ul>	<ul style="list-style-type: none"> <li>a. The selection of the blade and the number of teeth on the blade depend on the material of the work piece. Please consult our service centers for the correct selection of the blade.</li> <li>b. Make sure the work piece is properly secured, and the locking nut in front of the handle is properly placed and tightened.</li> <li>c. Replace the vise.</li> <li>d. Replace the gear. Please contact our service centers for replacement.</li> <li>e. When installing the blade, make sure the sharpened end of its teeth faces the correct direction. Please follow the arrow instruction.</li> <li>f. Make sure the blade is properly secured.</li> </ul>
6. Inaccurate Cutting Angle	<ul style="list-style-type: none"> <li>a. The blade vibrates too much.</li> <li>b. If the blade is too thin, it may not cut in the correct angle.</li> <li>c. The Clamping Vise Set is worn out and shakes.</li> <li>d. The handle on the rotary support is loose.</li> <li>e. The screws used to secure the vise body are loose.</li> </ul>	<ul style="list-style-type: none"> <li>a. Can be identified by looking at the blade or testing with measuring equipment.</li> <li>b. Replace with thicker blade.</li> <li>c. Replace the Clamping Vise Set.</li> <li>d. Push the handle to the right and tighten it.</li> <li>e. Readjust and tighten and screws on the vise body.</li> </ul>

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## 1. SAFETY PRECAUTION

- (1) Operator of the machine shall read the operation instruction carefully and understand the safety requirement and the function of all parts of machine thoroughly.
- (2) Only the authorized and dedicated operators are allowed to operate the machine.
- (3) The machine is designed and manufactured to meet the applicable safety regulation of your country. Please do not remove or modify any safety device or parts, such as safety cover and guard of saw blade, emergency stop button, etc.
- (4) Assure the correct electric power, such as capacity of voltage, amperage and protection, is connected to the machine before operation.
- (5) Please wear a pair of goggles when operating the machine.
- (6) Please push the emergency stop button and turn off the main switch immediately when any malfunction or emergency situation should occur.
- (7) Please disconnect the electric power when install, maintain, repair or disassemble the machine.
- (8) Please pay extreme attention to adjust or exam the machine with electric power has been connected.
- (9) Please operate the machine in a bright and clean environment
- (10) Please clean and maintain the machine periodically to assure the machine running in proper condition.
- (11) Do not operate the machine excess its allowable condition.

## 2. SPECIFICATIONS AND OUTLINE DRAWING

### 2.1 Technical Data

MC-370F TECHNICAL DATA		
	A-TYPE	B-TYPE
MAIN MOTOR	3/2 HP, 2/4 POLE	2/1.4 HP, 4/8 POLE
ARBOR RPM (60 HZ)	44/22	22/11
SAW BLADE TYPE	HIGH SPEED STEEL BLADE	
SAW BLADE SIZE	OD: 300/350/370 mm	
COOLING PUMP	1/8 HP	
AIR PRESSURE	--	
WEIGHT	260 KG	

### 2.2 Cutting Capacity

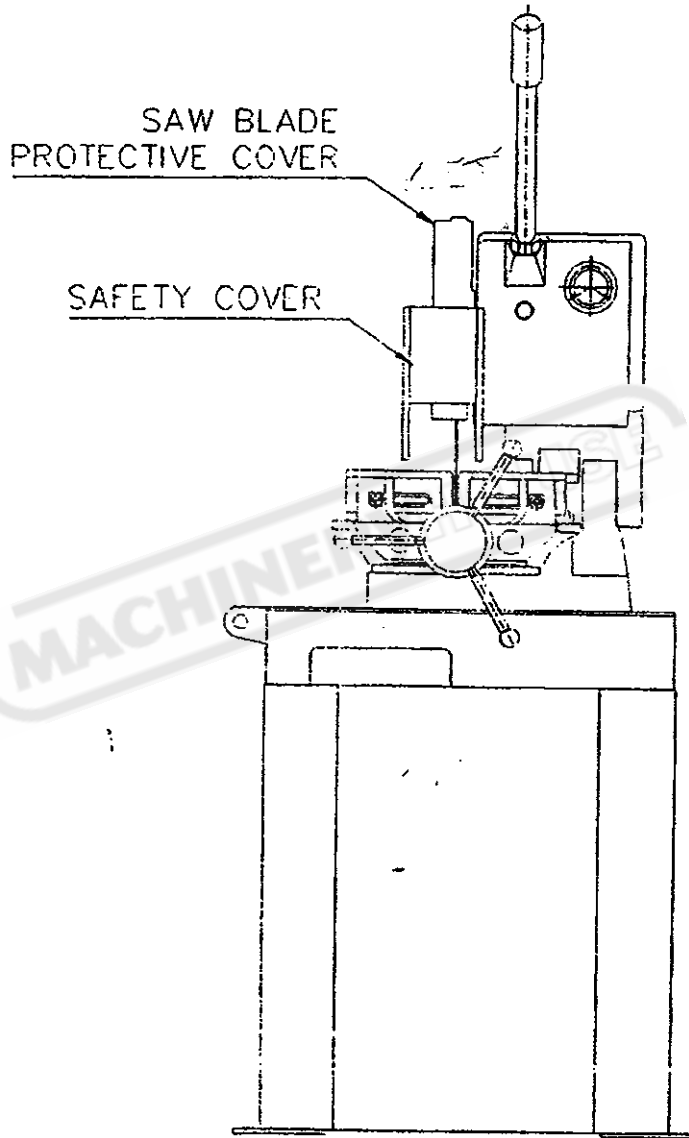
MC-370F CUTTING CAPACITY( USE $\varphi$ 370 BLADE) mm		
FOR MILD STEEL	CUTTING ANGLE	
	90°	45°
ROUND TUBE	$\varphi$ 115	$\varphi$ 115
SQUARE TUBE	110×110	100×100
ANGLE	110×110	100×100
RECTANGLE	110×110	100×100
SOLID ROUND TUBE	$\varphi$ 75	$\varphi$ 50
SOLID SQUARE TUBE	75x75	50x50

### 2.3 Accessory

- (1) One set simple adjustable length stopper
- (2) One package of hand tool

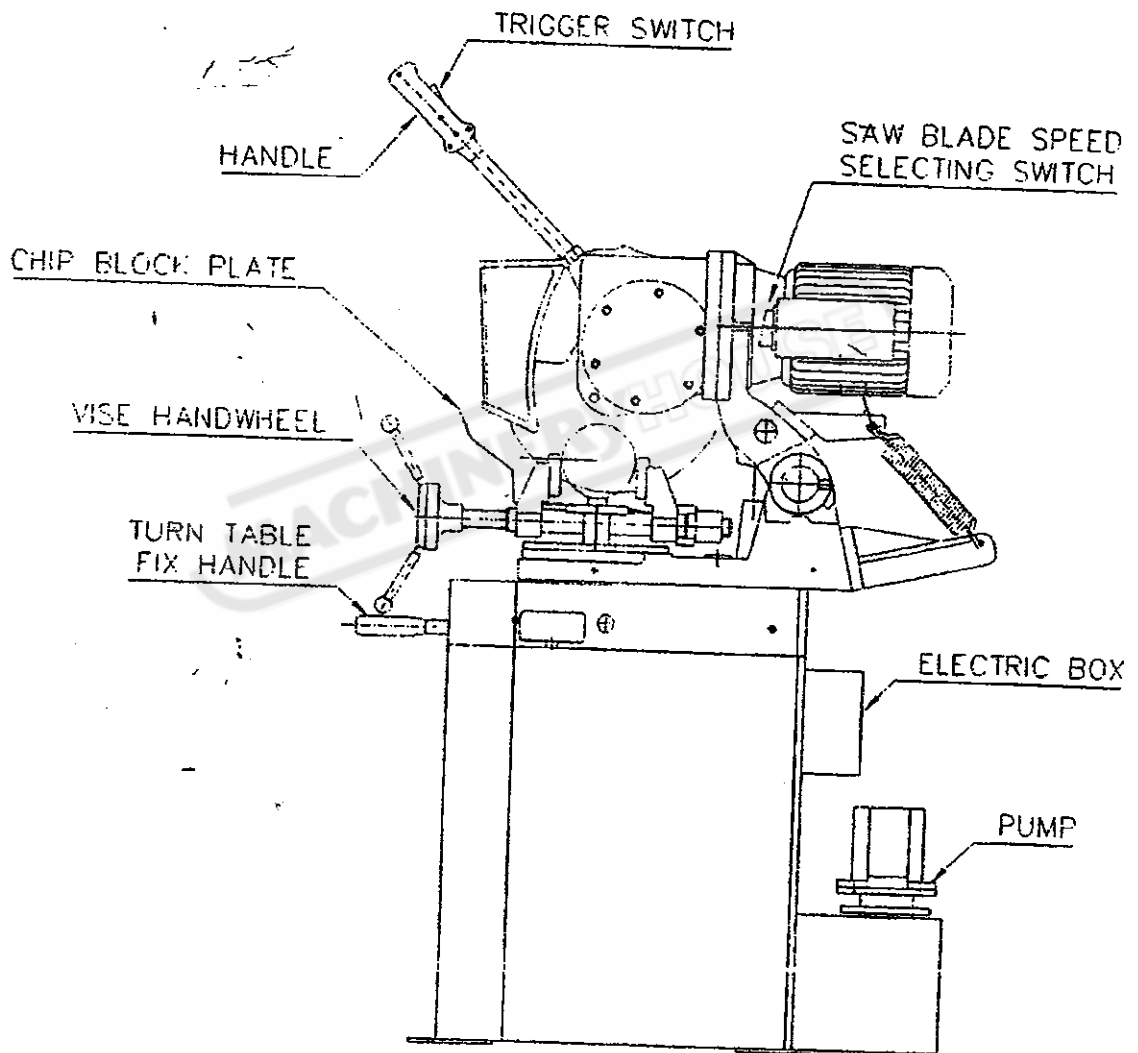
## 2.4 Outline Description

### (1) Front View



FRONT VIEW

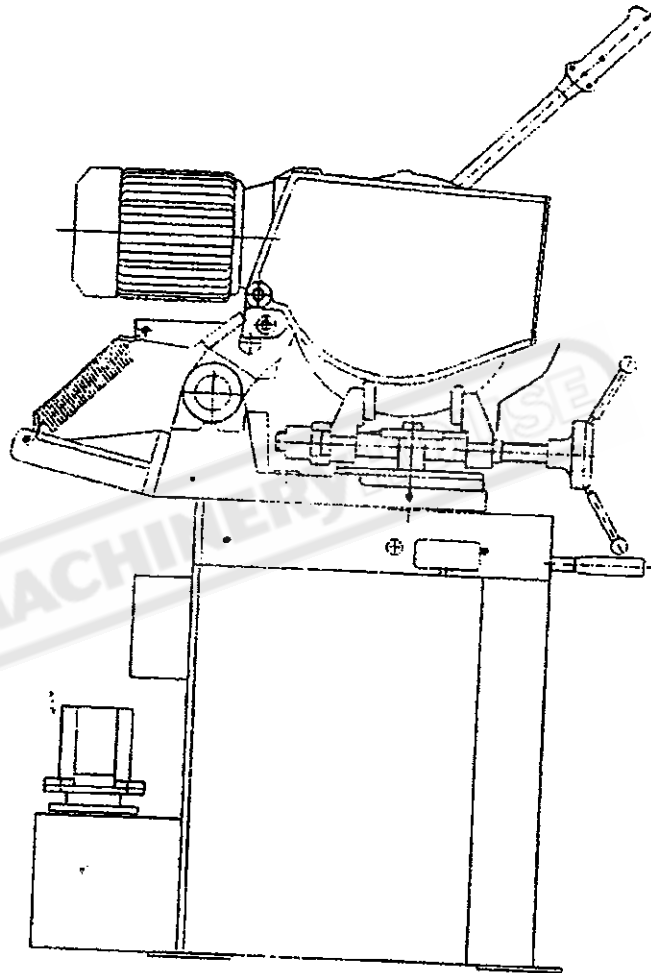
(2) Right Side View



RIGHT SIDE VIEW



**(3) Left Side View**



LEFT SIDE VIEW

### 3. INSTRUCTION OF INSTALLATION

**Note: Please read the instruction carefully before installation.**

**If having any question please contact your dealer for prompt service.**

#### 3.1 Unpacking and Inspection

- (1) Check if there is any damage on the wooden case or the plastic bag that used to pack the machine. Should any damage be found on the machine, please claim for the damage against the delivery or insurance company.
- (2) Check the machine and accessories against the packing list. Should any shortage, please contact your dealer.

#### 3.2 Lifting, Moving and Anchoring

- (1) Lifting eyebolts have been mounted on the machine. Please use hoist and sling devices with enough capacity to lift and move the machine.
- (2) Slots, designed at the bottom of the machine, can be used by forklift to move the machine.
- (3) Please watch over the obstacle or personnel that may be on the way of moving the machine.
- (4) Place the machine on a horizontal foundation. Use anchor bolt and nut to fix the machine on the foundation.

#### 3.3 Connecting Electric Power

**Note:**

- (1) Assure the main power switch is at "OFF" position and the saw blade motor speed select switch is at "OFF" position before connecting the machine to electric power source
- (2) Do not install saw blade on the main shaft when checking the rotational direction of the main shaft.

- (1) Only qualified electrician can connect electric power.
- (2) The voltage, amperage and protection capacity of the power source shall meet the requirement of the machine.

- (3) Check the rotation of the saw blade shaft (arbor). Change over two conductors in junction box if the direction of rotation does not consist with the direction of the label on the saw blade safety cover.

### 3.4 Filling coolant

- (1) Pour the diluted sawing oil on the table of the machine. The solution will flow into the coolant tank.
- (2) The dilute ratio (water: oil) is 5:1 for hard or high alloy steel and 10:1 for mild steel.

### 3.5 Procedure to install the stopper

- (1) Mount the stopper arm at the "0" point on the stopper support beam as illustrated on following figure1.
- (2) Put the stopper support beam into the hole in the base plate.
- (3) Fix the stopper support beam when the stopper is just touching the sawblade as illustrated on following figure2.

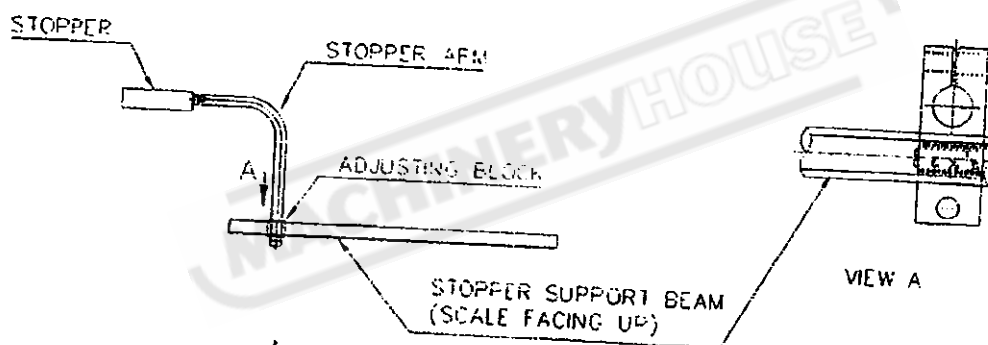


FIGURE 1

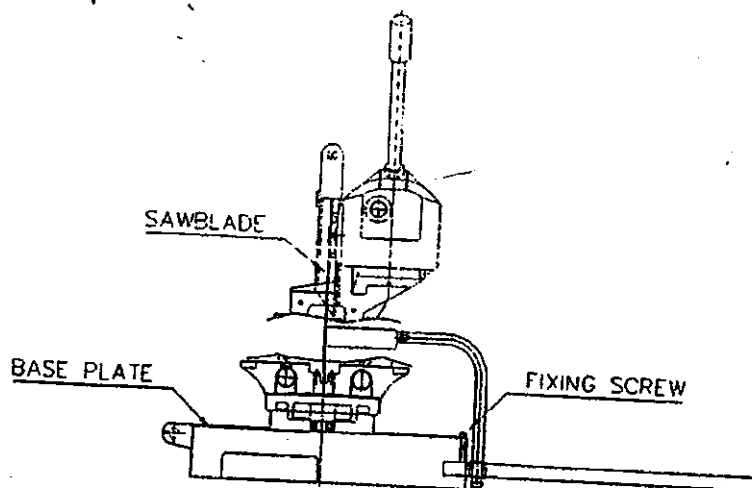


FIGURE 2

## 4. FUNCTION OF CONTROL DEVICES

### (1) Trigger Switch

This is an "ON-OFF" two-position trigger Switch on the handle to connect or disconnect power to the machine. The main (saw blade) motor and coolant motor run when this switch is pressed. The above motor stop when this switch is released.

### (2) Saw Blade Motor Speed Select Switch

This is a "LOW-OFF-HI" three-position level switch on the right side of the motor for selecting a suitable speed for saw blade to cut material.

MACHINERYHOUSE

## 5. INSTRUCTION OF OPERATION

### 5.1 Preparation for Operation

#### 5.1.1 Adjustment of the Clamping Vise

- (1) Release the handle.  
(Cutting head shall be at up position)  
(Saw blade motor shall stop.)
- (2) Turn the hand wheel of clamping vise counter-clockwise to open the vise.
- (3) Put a work piece into the clamping area of vises.
- (4) Turn the hand wheel of clamping vise clockwise to close the vise and fasten work piece.
- (5) Turn the hand wheel of clamping vise 1/2 (half) turn counter-clockwise. This is the ready position.

#### 5.1.2 Installation of the Saw Blade

- (1) Release the handle.
- (2) Turn off the saw blade motor speed select switch.
- (3) Open saw blade safety cover.
- (4) Remove the clamping flange from the saw arbor.
- (5) Clean the clamping surfaces of flange and arbor free from any dirt or chips.
- (6) Clean the clamping area of the saw blade.
- (7) Mount saw blade on the arbor. Align the pinholes of saw blade and arbor. Put the clamping flange on the saw blade, and tighten the center bolt.  
**Note:** The rotation of saw blade shall be counter-clockwise while looking at the mounting surface. There is a directional mark labeled on the protection cover.
- (8) When lock the center bolt, keep the front part of saw blade downward to eliminate the gap between pin and pinhole.
- (9) Close the saw blade safety cover.

**Note:** The following Charts of " Number of Saw Blade Tooth Selection " are for reference.

Number of Saw Blade Tooth (T) for Mild Steel Solid Bar Cutting					
Wall Thickness of Tube ( mm )	Diameter of Saw Blade ( mm )				Remark
	Φ250	Φ275	Φ300	Φ350	

0.6~0.8	T=280	280	300	320	For Tube Diameter D ≥ 10 mm
0.8~1.0	240	280	280	320	
1.0~1.2	220	240	240	280	
1.2~1.6	200	220	240	240	
1.6~2.0	180	200	220	220	
2.0~2.5	150	180	180	200	D ≥ 15 mm
2.5~3.5	120	150	150	180	D ≥ 20 mm
3.5~4.5	90	120	120	150	D ≥ 25 mm
4.5~5.5	80	80	90	120	D ≥ 30 mm
5.5~7.0	64	64	80	90	D ≥ 40 mm

For Wall Thickness ≥ 2 mm, the Formula for Number of Tooth T is as following

$$T = 2 \times (\text{Diameter of Saw Blade} \times 3.14) \div (\text{Wall Thickness of Tube})$$

Size of Bar (mm)	Diameter of Saw Blade (mm)			
	Φ250	Φ275	Φ300	Φ350
6~10	T=180	200	200	220
10~14	160	160	180	200
14~18	150	160	160	180
18~22	120	150	150	160
22~28	90	90	120	160
28~35	80	80	90	120
35~45	70	70	80	90
45~50	64	64	70	80

For size of Bar ≥ 38 mm, the Formula for Number of Tooth T is as following

$$T = 4 \times (\text{Diameter of Saw Blade} \times 3.14) \div (\text{Size of Bar})$$

1. For stainless steel, the number of tooth is one grade more than mild steel.
2. For aluminum and copper, the number of tooth is one grade less than mild steel.
3. For 45° miter cutting, the number of tooth is one grade less than 90° cutting.

### 5.1.3 Adjustment of the Saw blade Low Stop Position

- (1) Pull down the handle to the position that the saw blade just breaks through the work piece.
- (2) Adjust the bolt and lock nut that is under the saw head to just stop the saw head going down.

### 5.1.4 Adjustment of the Saw Blade Rotating Speed

Turn the saw blade speed-selecting switch to one of "LOW", "HI" or "OFF" position.

### 5.1.5 Adjustment of the Miter Cutting

- (1) Push the turning table fixing handle leftward.
- (2) Turn the turning table to the required angle.
- (3) Push the fixing handle rightward.

## 5.2 Steps of Operation

- (1) Prepare the machine as states in Section 5.1.
- (2) Put a work piece into vise.
- (3) Turn the clamping vise hand wheel to clamp the work piece.
- (4) Pull down the handle and press trigger switch.
- (5) The saw blade starts rotating. The coolant starts flowing out of nozzle.
- (6) Continue to pull down the handle until the saw blade cuts off the work piece.
- (7) Release the trigger switch and let the saw head moves up slowly.
- (8) Turn the clamping vise hand wheel to release the work piece.
- (9) Repeat step (2) through (9) to finish the job.

**NOTE:** Release the trigger switch immediately if any malfunction or abnormal situation happens.

## 5.3 Daily Inspection and Maintenance

### 5.3.1 Gear Box of Cutting Head

- (1) Change gear oil (SAE 140) every six months (3.7 liters are required).
- (2) Check temperature of the gearbox during continuous operation.

### 5.3.2 Chip Collecting Tray

Remove chip from collecting tray everyday.

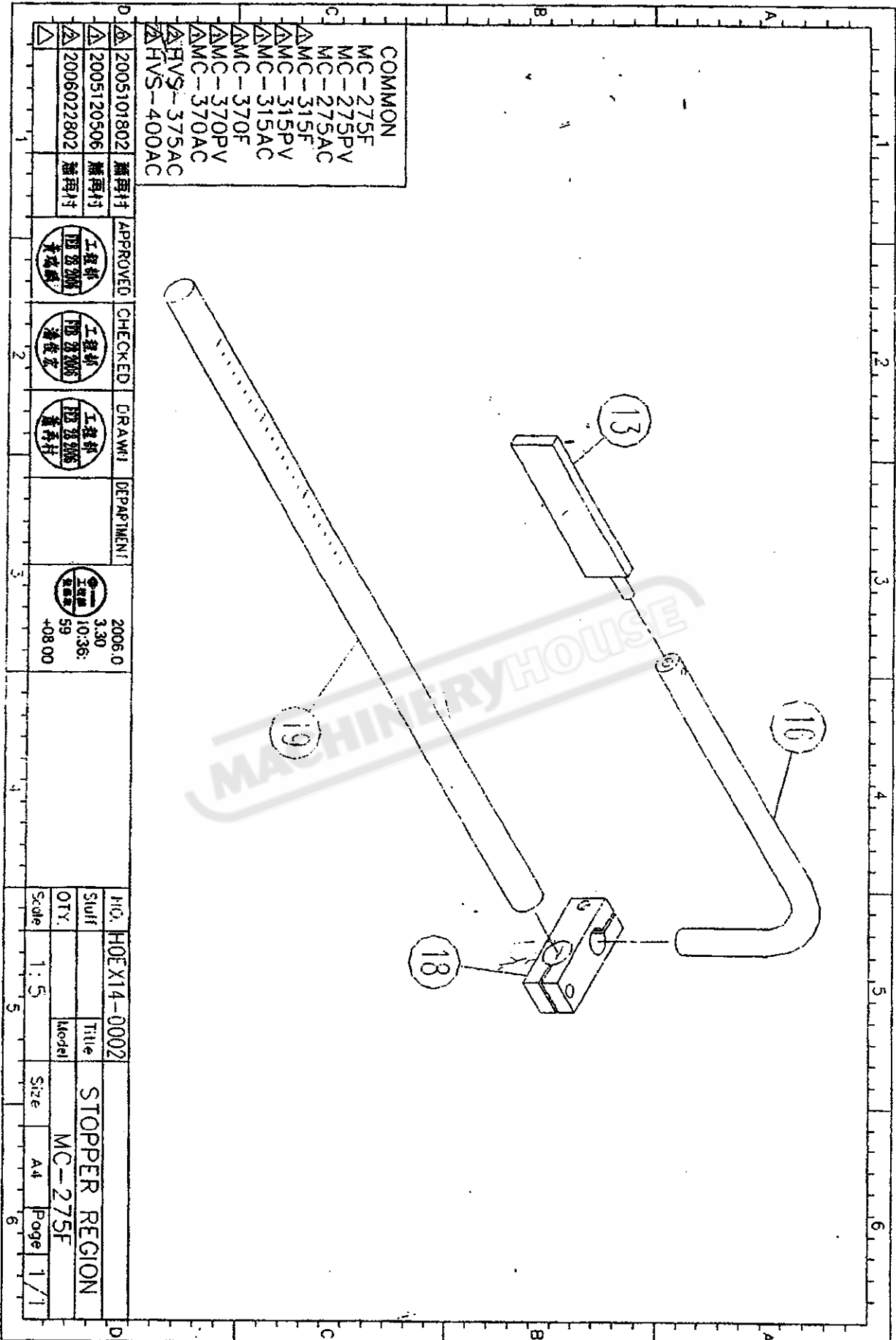
## 6. ELECTRICAL SYSTEM DIAGRAM









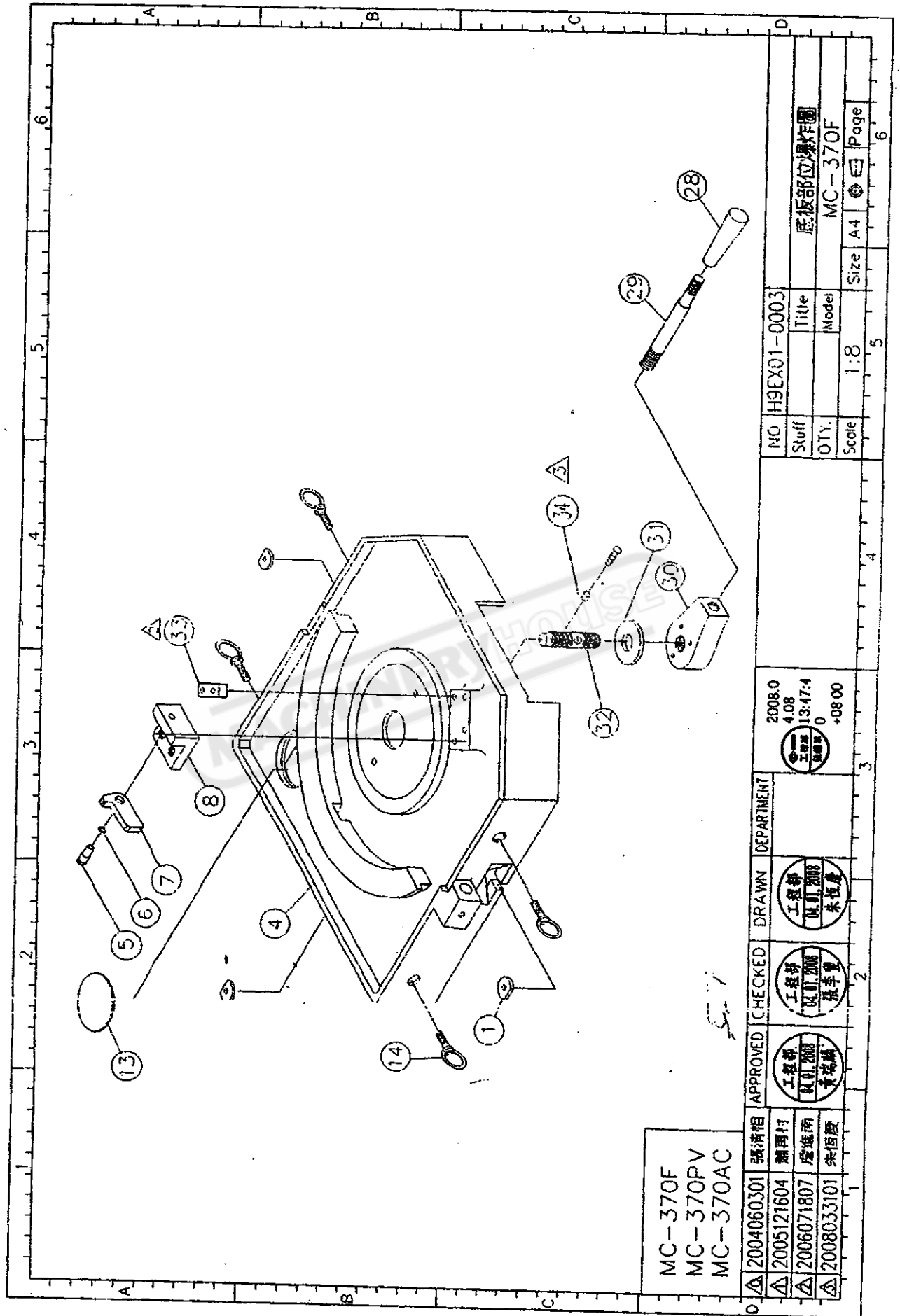


- COMMON
- △ MC-275F
  - △ MC-275PV
  - △ MC-275AC
  - △ MC-315F
  - △ MC-315PV
  - △ MC-315AC
  - △ MC-370F
  - △ MC-370PV
  - △ MC-370AC
  - △ HVS-375AC
  - △ HVS-400AC

△ 2005101802	蕭再村	APPROVED	工程師 蕭再村	CHECKED	工程師 潘俊宏	DRAWN	工程師 蕭再村	DEPARTMENT	2006.0 3.30 10:36 59 +08 00
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△ 2006022802	蕭再村								

FIG.	HOEX14-0002	Scale	1:5
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QTY.		Page	1/1
Model	STOPPER REGION		
	MC-275F		





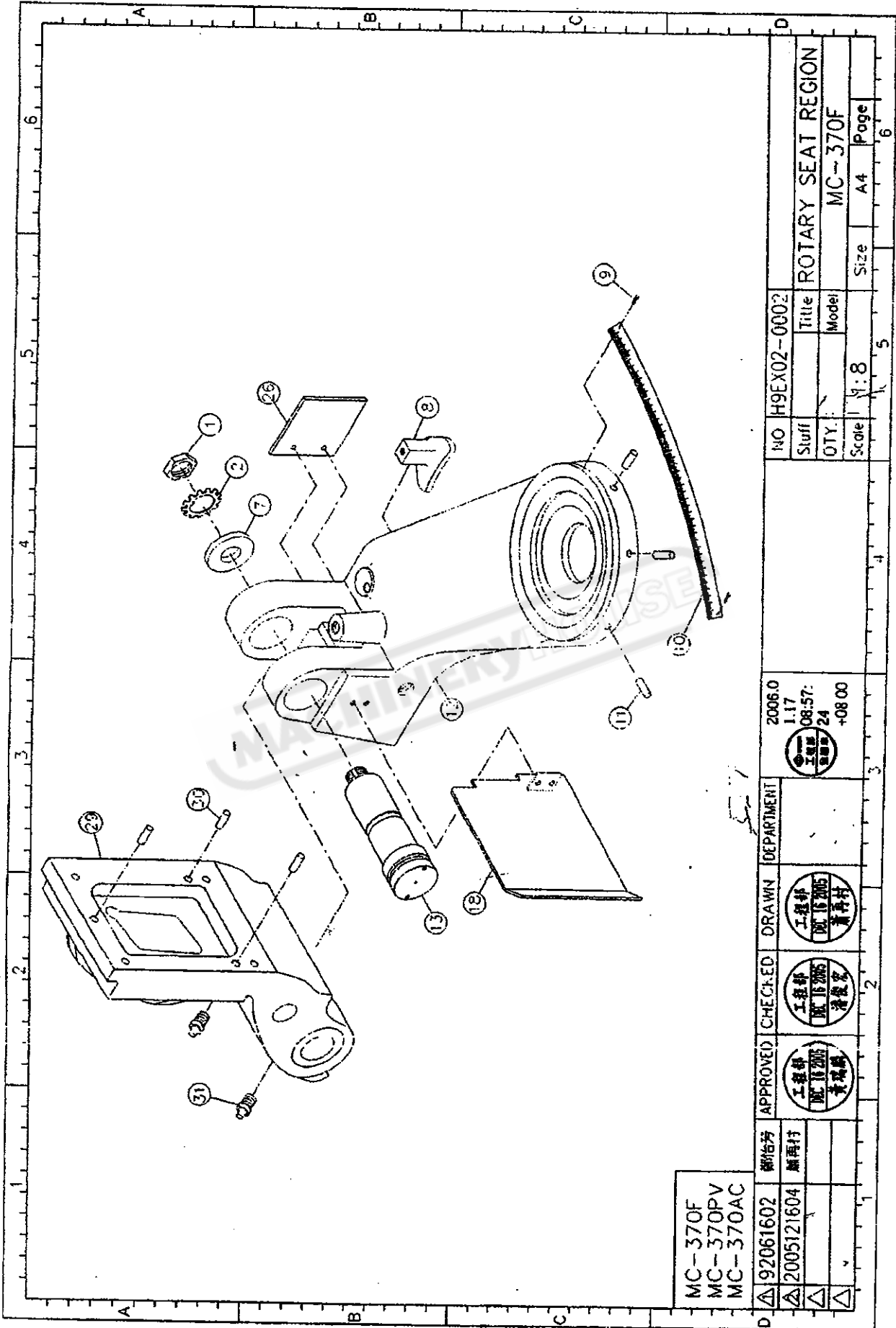
MC-370F  
 MC-370PV  
 MC-370AC

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△	2005121604	蕭再村	CHECKED
△	2006071807	陸維南	DRAWN
△	2008033101	朱恒慶	DEPARTMENT

2008.0	2008.0	2008.0	2008.0
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Stuff	
OTY	
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Title	底板部位爆炸圖
Model	MC-370F





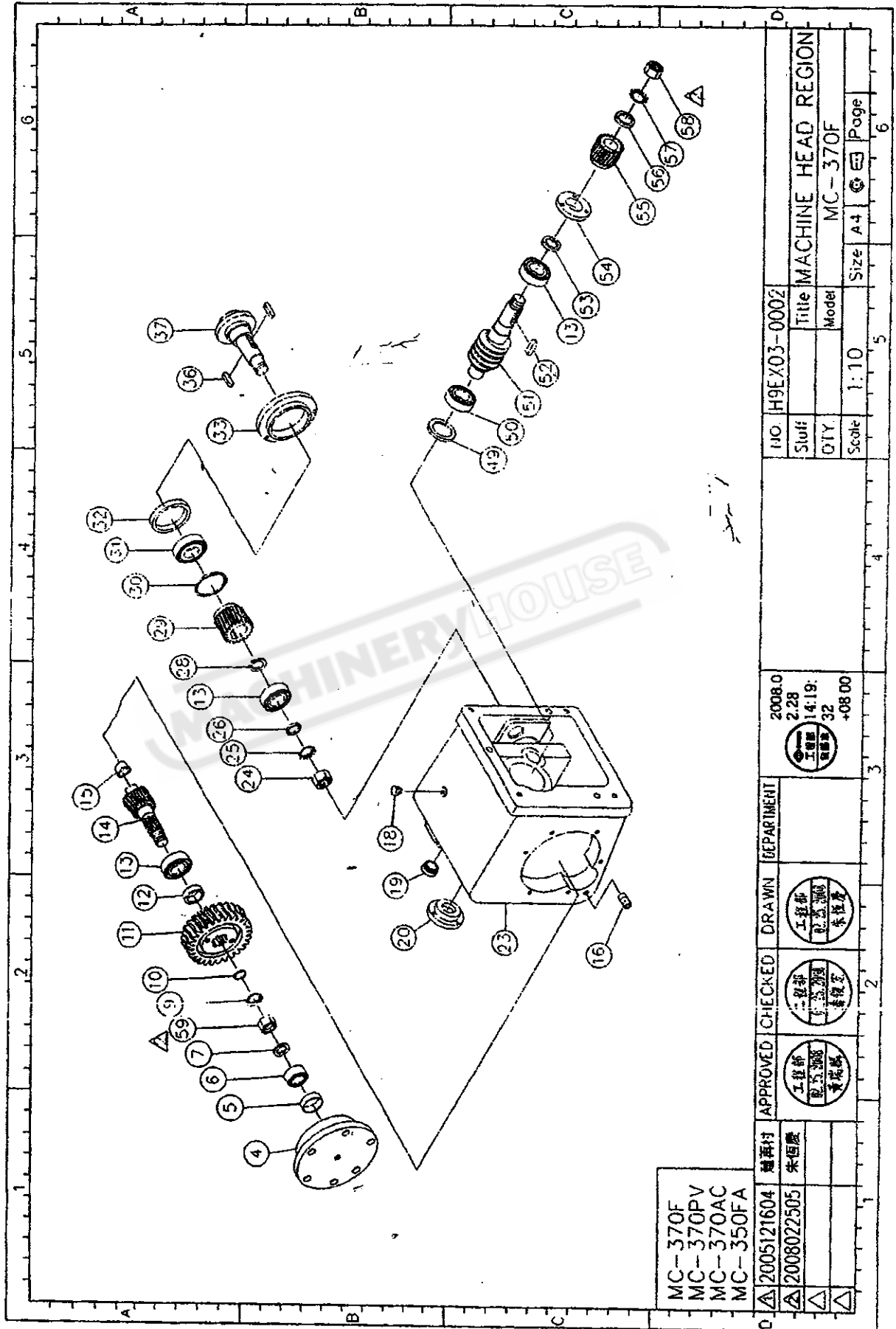
MC-370F  
 MC-370PV  
 MC-370AC

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						ROTARY SEAT REGION				
						MC-370F				

H9EX03-0002 (1/1) \*\*\*\*\* MC-370F \*\*\*\*\*

序號	件號	品名	用量	規格	序號	件號	品名	用量	規格
004	H5C006	側 (染黑)	1		032	ZQ0148	油封	1	65.88.12
005	H5C007	軸承壓環	1		033	H5C004	軸承蓋(染黑)	1	
006	VG0019	軸承	1	E30304J	036	ZV0041	雙頭圓鍵	2	8*7*45
007	H5C008	蝸輪軸墊環	1		037	H5C005	主軸(防銹)	1	
009	ZK0258	梅花墊片	1	AW 05,D25 彎舌型	049	H5C014	軸承壓環	1	
010	H5C009	外襯圈	1		050	VG0028	軸承	1	E32204J
011	H5C010	蝸輪	1		051	H5C015	蝸桿軸	1	
012	H5C011	蝸輪內襯環	1		052	ZV0031	雙頭圓鍵	1	8*7*32
013	VG0029	軸承	3	E32206J	053	H5C016	襯環	1	
014	H5C012	螺旋齒輪控槽軸	1		054	H5C017	軸承蓋(染黑)	1	
015	VF0054	軸承	1	TLAN 202620	055	H5C018	螺旋齒輪	1	
016	ZE0010	塞頭	1	PT3/8"	056	H5C019	襯環	1	
018	ZE0013	注油孔螺絲	1	3/8"PT(PVC)	057	ZK0390	梅花墊圈	1	AW-04,D20 直舌型
019	IK0031	油鏡	1	21mm	058	H9C001	螺帽	1	M20*P1.5*邊 26*6.5mm厚(染黑) 右
020	H5C013	封蓋(染黑)	1		059	H9C002	螺帽	1	M25*P1.5*邊 32*9mm厚(染黑) 右
023	H5A001	機頭	1						
024	H0C006	六角螺帽	1	M30*P1.5					
025	ZK0259	梅花墊片	1	AW 06,D30 彎舌型					
026	H5C002	主軸內襯套	1						
028	ZP0011	C型扣環	1	R-45					
029	H5C001	螺旋齒輪	1						
030	H5C003	墊環	1						
031	VG0017	軸承	1	E30211J					

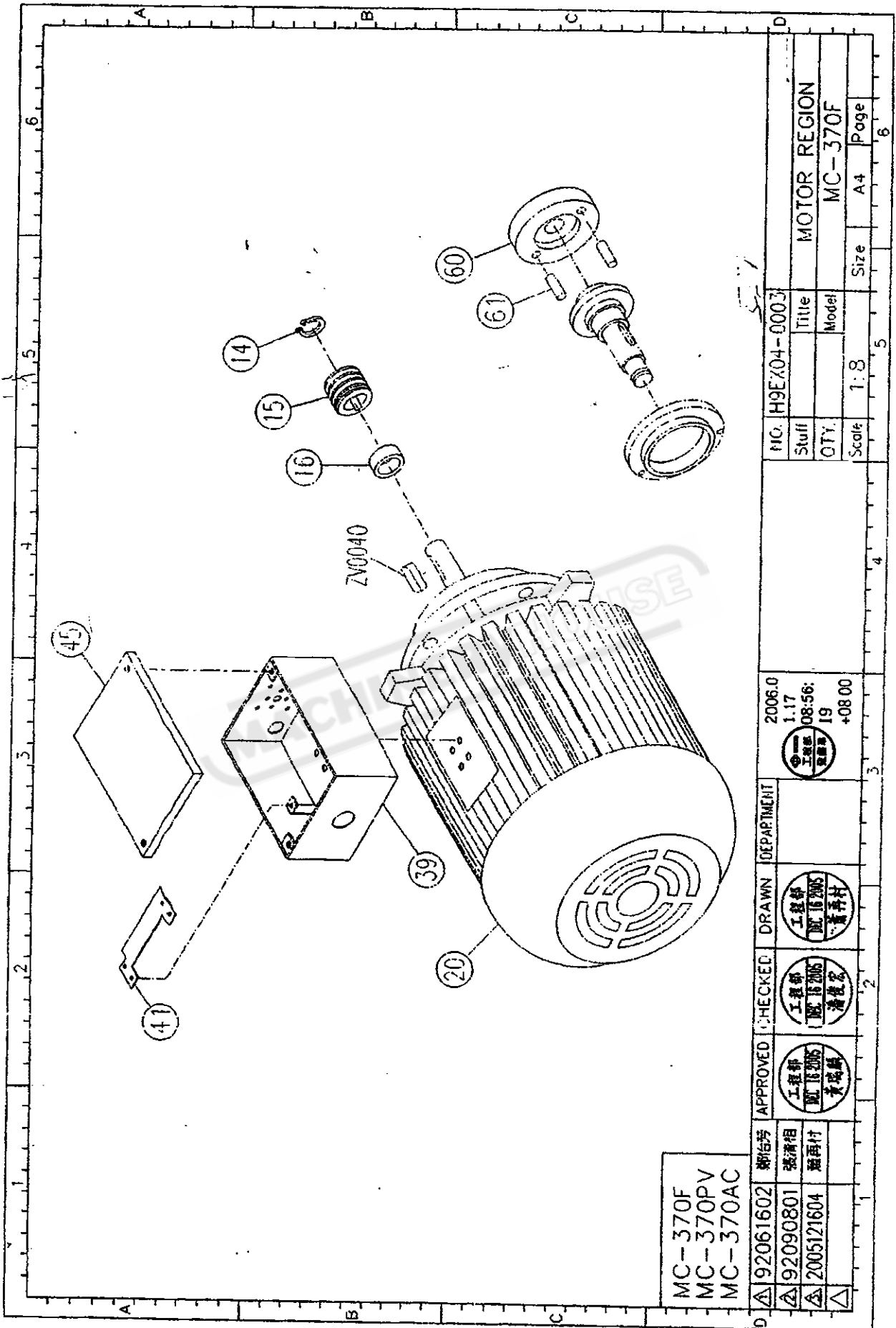




MC-370F  
 MC-370PV  
 MC-370AC  
 MC-350FA

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△			DEPARTMENT	車機部	+08 00	Scale	Scale
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						Model	
						MC-370F	
						Size	
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						Page	
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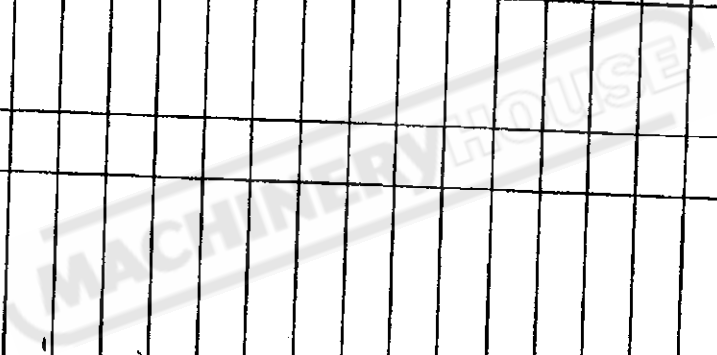


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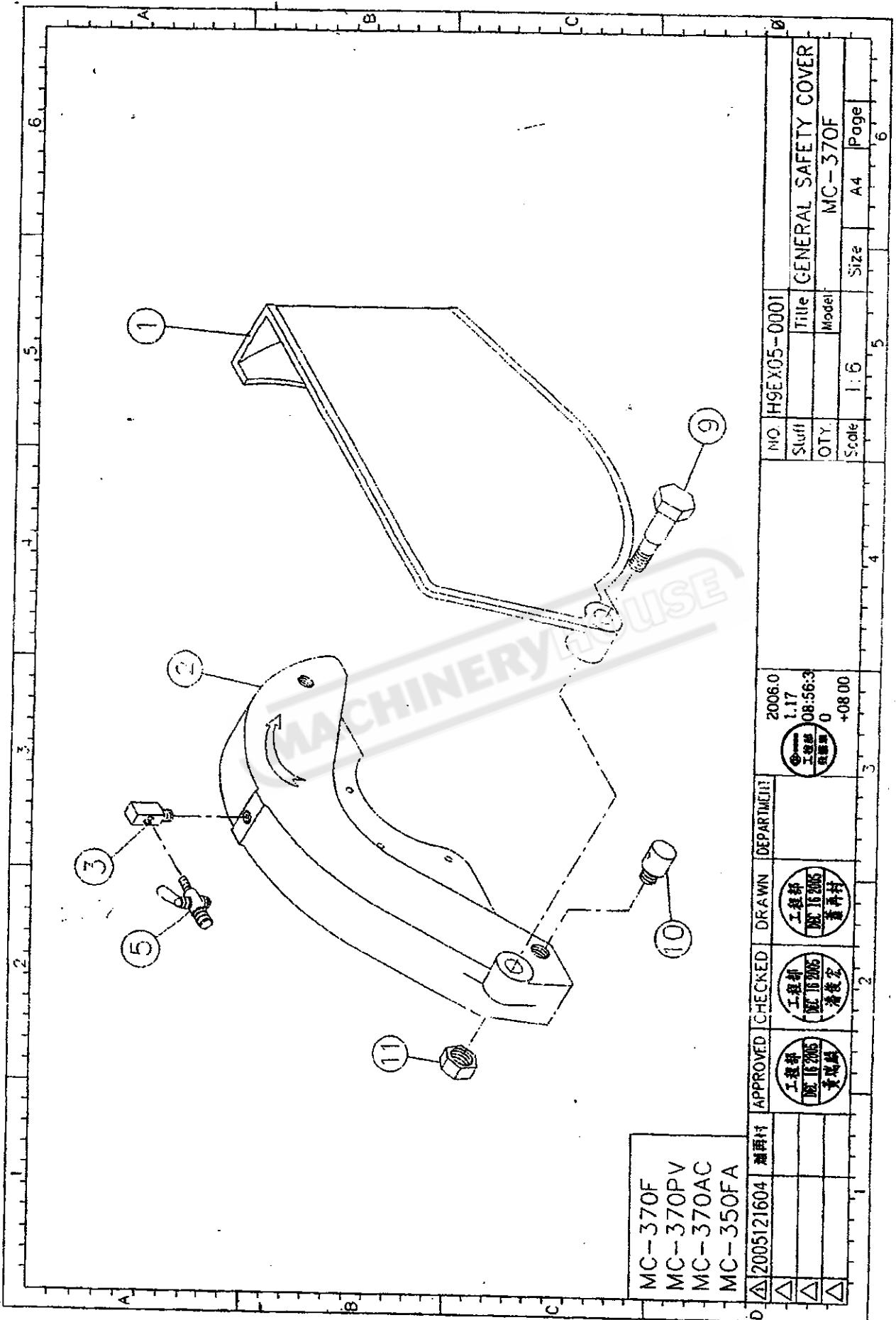
MOTOR REGION	
MC-370F	

H9EX05-0001 (1/1) \*\*\*\*\* MC-370F \*\*\*\*\*

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001	H5F005	安全蓋(噴漆)	噴橘色								
002	H5F006	鋁片膠蓋(噴漆)									
003	ZK0190	銅彎頭	M8-PT1/8"-90度								
005	IB0150	銅控制閥(考克)	1/8PT*3/8插心								
009	H5F003	迴轉軸(染黑)									
010	H5F008	固定螺絲(染黑)									
011	N16H	防鬆U槽	M16*P2.0								



521

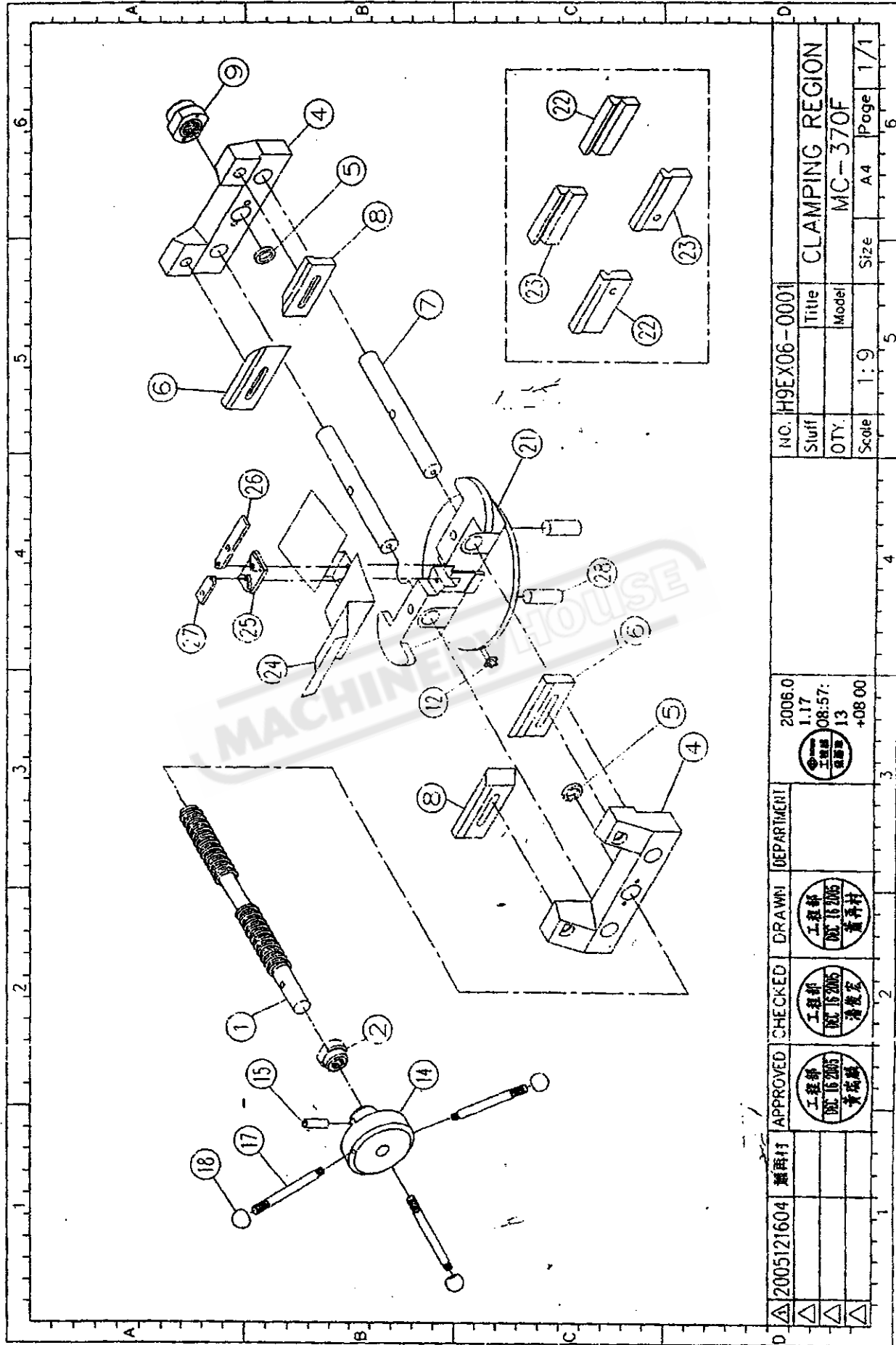


MC-370F  
 MC-370PV  
 MC-370AC  
 MC-350FA

NO.	HSEX05-0001	
Stuff	Title	GENERAL SAFETY COVER
QTY	Model	MC-370F
Scale	1:6	Size A4 Page 6
2006.0	2006.0	2006.0
L17	L17	L17
08:56:3	08:56:3	08:56:3
0	0	0
+08 00	+08 00	+08 00
APPROVED	CHECKED	DRAWN
DEPARTMENT	DEPARTMENT	DEPARTMENT
工程師 DEC 16 2005 黃煥麟	工程師 DEC 16 2005 潘俊宏	工程師 DEC 16 2005 黃煥麟

H9EX06-0001 (1/1) \*\*\*\*\* MC-370F \*\*\*\*\*

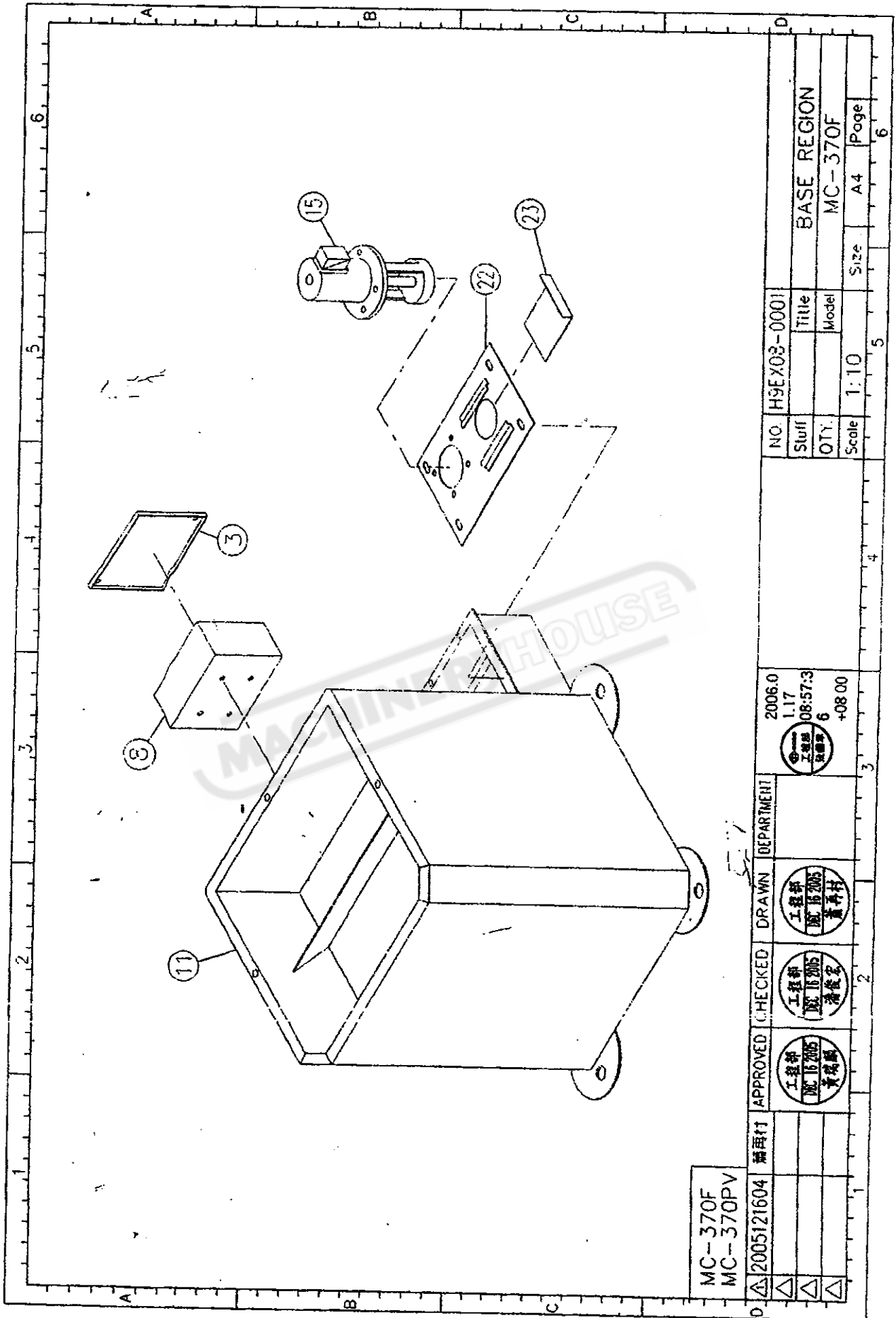
序號	件號	品名	用置	規	格	序號	件號	品名	用置	規	格
001	H5D001	螺桿	1								
002	H5D015	前螺帽 (噴漆)	1								
004	H9D002	夾鉗(噴漆)	2								
005	ZQ0058	油封	2	28.40.5	VC						
006	H5D011	夾塊(平夾)(染黑)	2	前右							
007	H5D009	滑軌軸	2								
008	H5D008	夾塊(平夾)(染黑)	2	前左							
009	H5D016	後螺帽(噴漆)	1								
012	H0A017	角度指針	1								
014	H0D016	把手頭	1								
015	ZK0200	彈簧槍	1	6*40							
017	H0D017	旋緊把手 (染黑)	3								
018	ZK0033	把手球	3	1/2"	圓珠						
021	H9D001	夾鉗本體(噴漆)	1								
022	H9K001	V型夾塊(染黑)	2	前左							
023	H9K002	V型夾塊(染黑)	2	前右							
024	H5D002	遮屑板(染黑)	1								
025	H0D003	壓塊 (染黑)	1								
026	H5D005	夾鉗座本體整塊(染黑)	1	(大)							
027	H5D004	夾鉗座本體整塊(染黑)	1	(小)							
028	H0C012	平行銷	2	D10*L28							



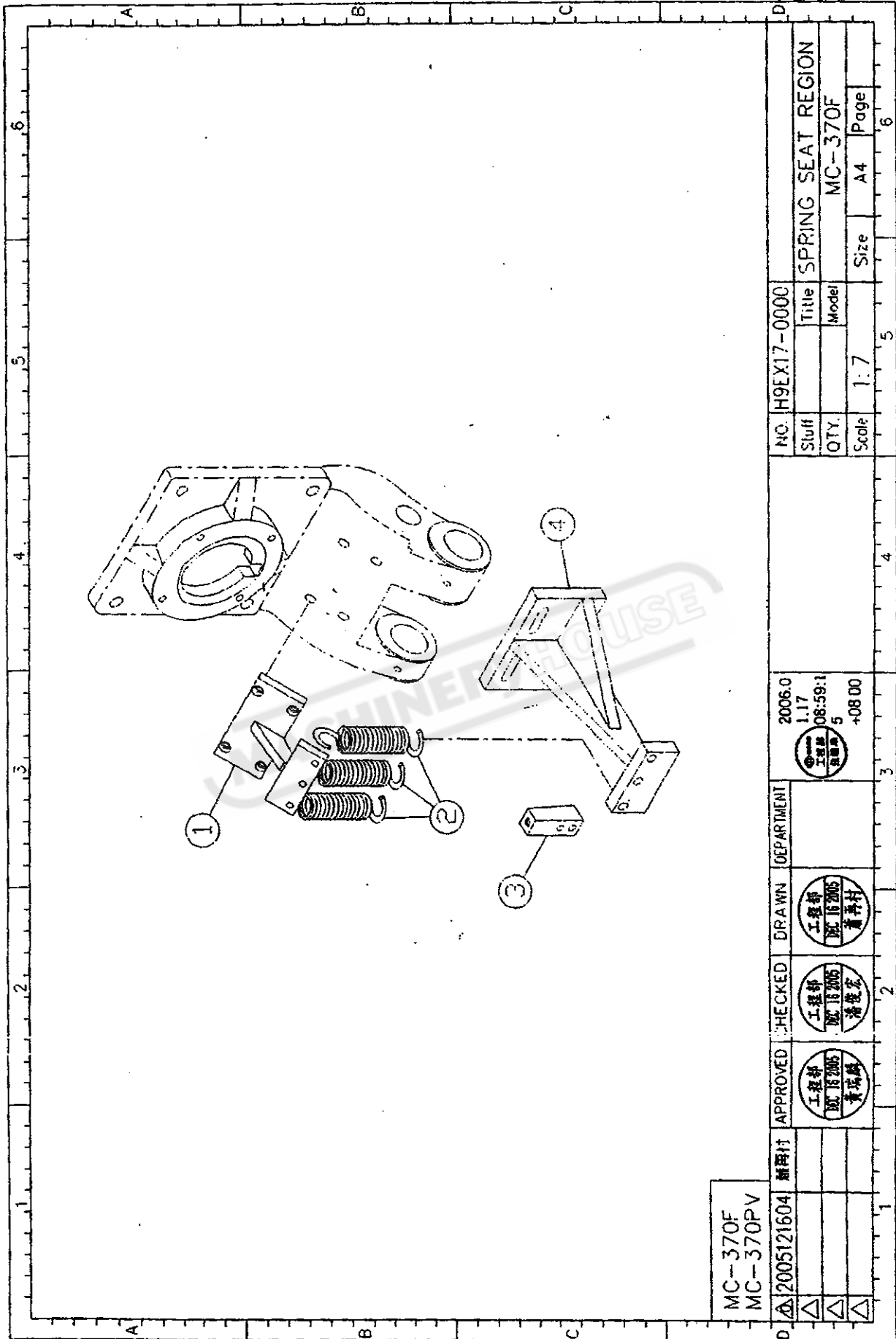
NO.	H9EX06-0001		
Stuff	Title	CLAMPING REGION	
QTY.	Model	MC-370F	
Scale	1:9	Size A4 Page 1/1	
2006.0			
1.17			
08:57			
13			
+08:00			
APPROVED	CHECKED	DRAWN	DEPARTMENT
2005121604 魏再村	工程科 DEC 19 2006 清俊宏	工程科 DEC 16 2006 董再村	
	工程科 DEC 16 2006 黄瑞麟		







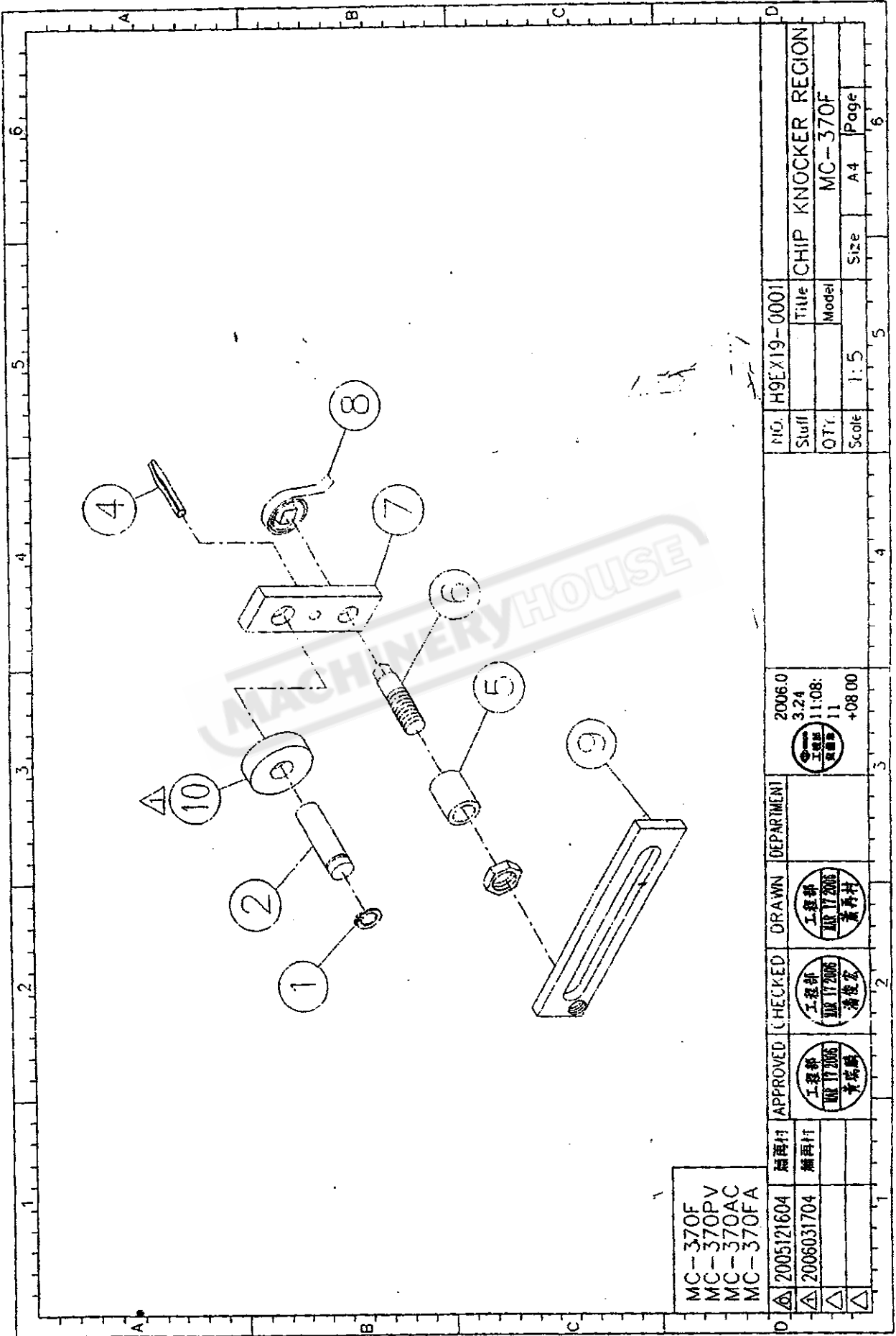




MC-370F  
MC-370PV

△	2005121604	胡再打	APPROVED	工程師 2005 12/16	黃瑞麟	APPROVED	工程師 2005 12/16	潘德宏	CHECKED	工程師 2005 12/16	黃再村	DRAWN	工程師 2005 12/16	黃再村	DEPARTMENT	2006.0	1.17	08:59:1	5	+08 00	NO. H9EX17-0000	Sluff	Model	MC-370F	Title	SPRING SEAT REGION	Scale	1:7	Size	A4	Page	6
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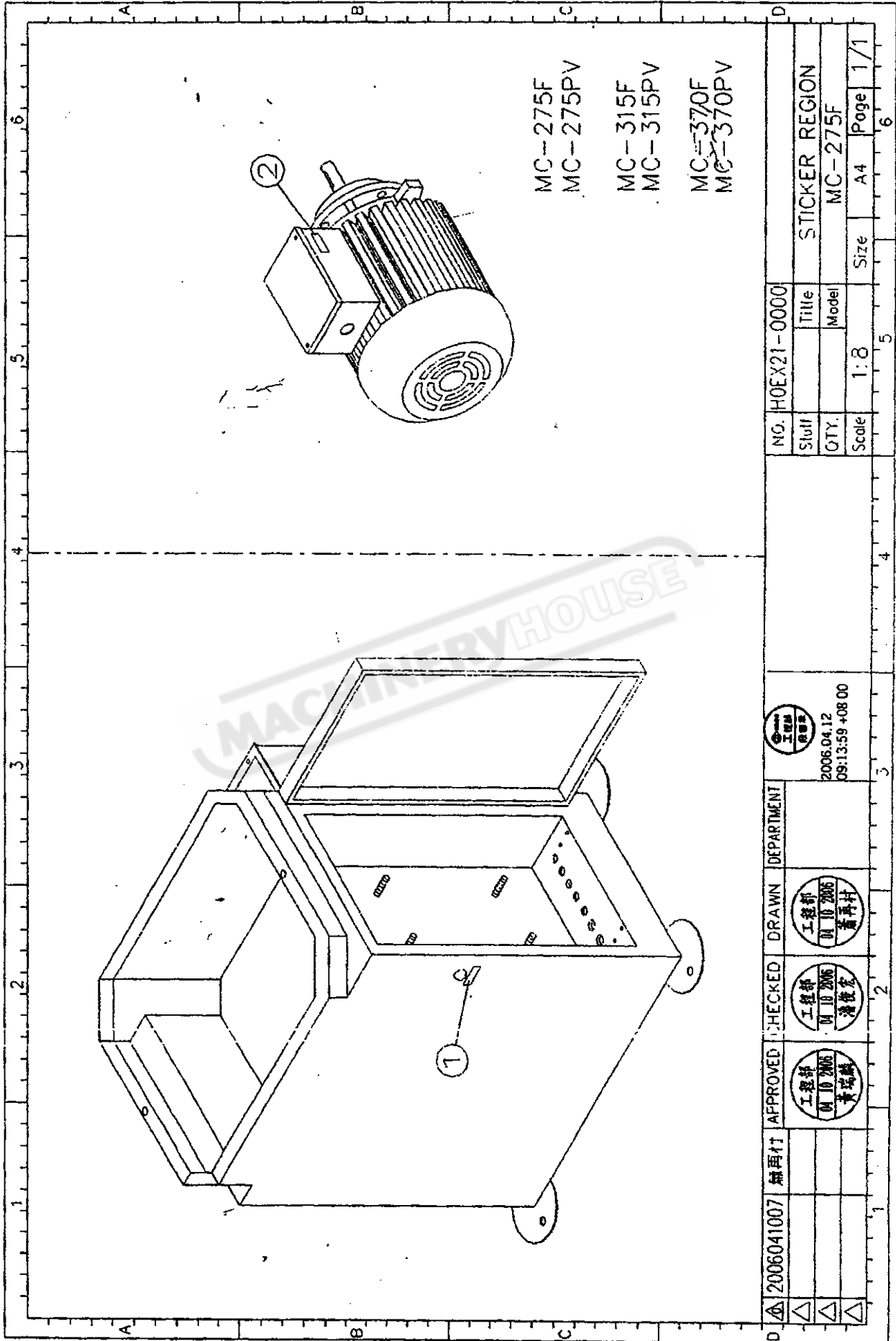


MC-370F  
 MC-370PV  
 MC-370AC  
 MC-370FA

△	2005121604	編再付	編再付	2006.0	2006.0	3.24	11:08	11	+08.00	NO. H9EX19-0001	Stuff	Title	CHIP KNOCKER REGION
△	2006031704	編再付	編再付	2006.0	2006.0	3.24	11:08	11	+08.00	OTr.	Model	MC-370F	
△										Scale	1:5	Size	A4
△										Sheet	5	Page	6

MACHINERYHOUSE





MC-275F  
MC-275PV  
MC-315F  
MC-315PV  
MC-370F  
MC-370PV

NO.	HOEX21-0000	
Staff	Title	STICKER REGION
QTY.	Model	MC-275F
Scale	1:8	Size A4
	5	Page 1/1

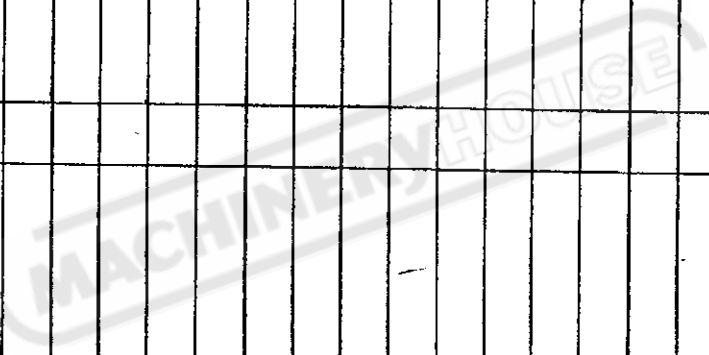
  

	2006.04.12 09:13:59 +08:00
	工程部 黃再村
工程部 黃俊宏	工程部 黃再村
工程部 黃瑞麟	工程部 黃再村

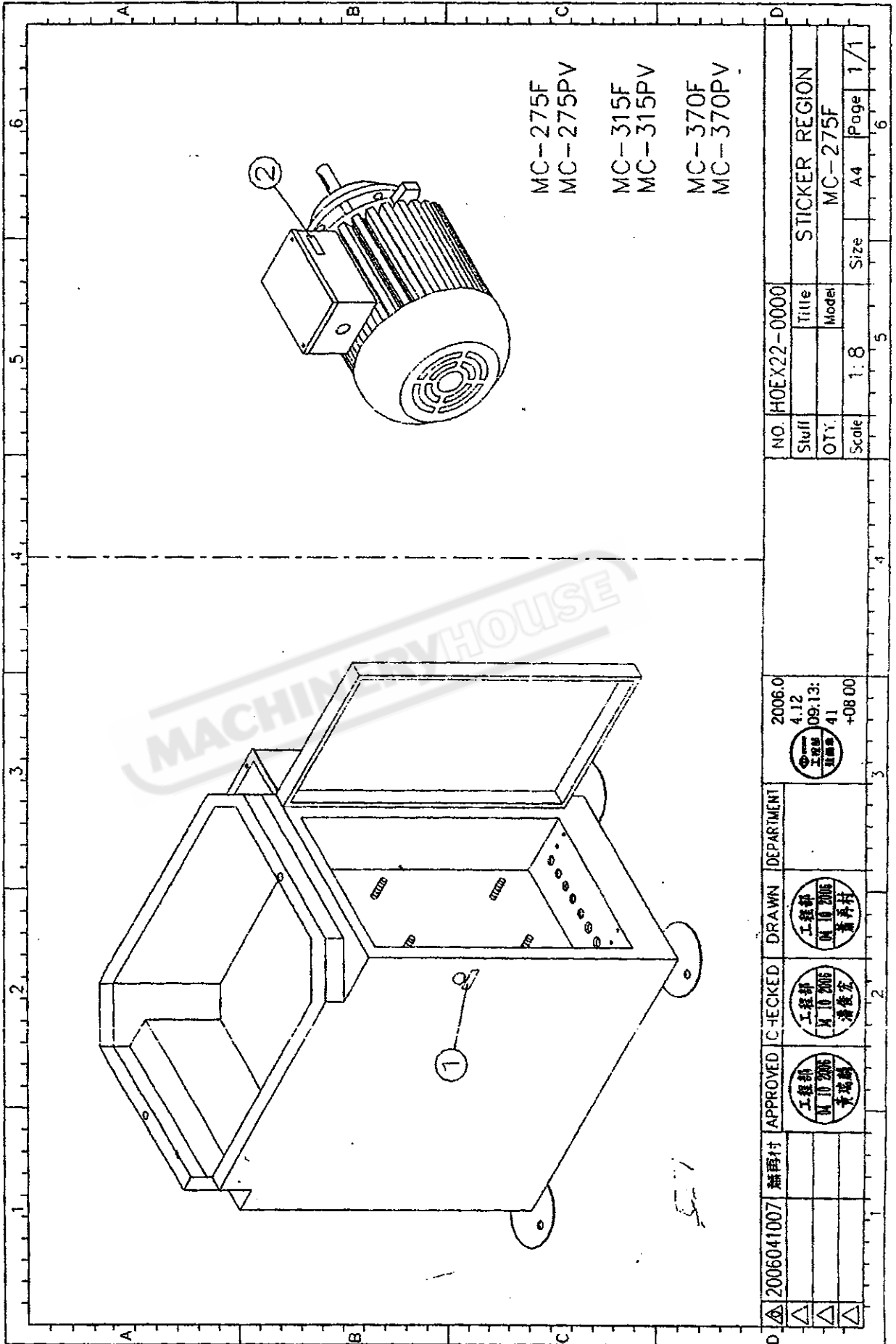
\*\*\*\*\* MC-275F \*\*\*\*\*

HOEX22-0000 (1/1)

序號	件號	品名	數量	規格	序號	件號	品名	數量	規格
001	HOT011	貼紙	1	Power Light					
002	HOT012	貼紙	1	Motor Switch					







MC-275F  
MC-275PV  
MC-315F  
MC-315PV  
MC-370F  
MC-370PV

NO.	HOEX22-0000	
Stuff	Title	STICKER REGION
QTY.	Model	MC-275F
Scale	1:8	Size A4 Page 1/1

2006.04.12	2006.09.13	2006.10.31	2006.11.08
工程師 黃再村	工程師 潘俊宏	工程師 黃再村	工程師 黃再村
工程師 黃再村	工程師 潘俊宏	工程師 黃再村	工程師 黃再村