

# OPERATION MANUAL

## WINTER E 45 - 3200 DELUXE I



### **WARNING!**

*The operator must thoroughly read this manual before operation.  
Keep this manual for future reference.*

**Henrik Winter Holztechnik GmbH**

Druckereistr. 8  
04159 Leipzig

Tel: +49 (0)341/ 4619021 Fax: +49 (0)341/4618358 Funk: +49 (0)171/2820443  
Em@il: [info@winter-holztechnik.de](mailto:info@winter-holztechnik.de) Internet: [www.winter-holztechnik.de](http://www.winter-holztechnik.de)

# Table of Contents

I.	GENERAL INFORMATION	
1-1.	General information & safety rules .....	p.3
II.	SPECIFICATIONS	
2-2.	Feature.....	p.8
2-3.	Specifications.....	p.9
III.	INSTALLATION	
3-1.	Unpacking.....	p.10
3-2.	Check machine accessories.....	p.11
3-3.	Fitting sliding table.....	p.12
3-4.	Fitting crosscut table & crosscut fence.....	p.13
3-5.	Fitting the extension table .....	p.14
3-6.	Fitting guard and control panel (optional).....	p.15
3-7.	Fitting rip fence.....	p.17
3-8.	Fitting motorize rip fence (optional) ... ..	p.18
3-9.	Fitting the saw blade.....	p.19
3-10.	Fitting the riving knife .....	p.21
3-11.	Installation scoring blade.....	p.23
3-12.	Edge shoe & hold down.....	p.24
3-13.	Connection to the dust collection .....	p.25
3-14.	Wiring & test run .....	p.26
IV.	SAW UNIT & FRAME, PARALLEL FENCE	
4-1.	.....	p.27
4-2.	Saw blade lifting and tilting.....	p.28
4-3.	Scoring blade adjusting .....	p.29
4-4.	Control panel operation .....	p.31
4-5.	Speed change.....	p.34
4-6.	Setting to zero the fence for parallel cuts.....	p.35
4-7.	Sliding table.....	p.37
4-8.	Setting to zero the rest rule.....	p.38
	**Optional: Manual for motorized rip fence.....	p.49
V.	MAINTENANCE	
5-1.	Machine cleaning & check.....	p.40
5-2.	Periodical lubrication .....	p.41
5-3.	Replacing belt.....	p.42
VI.	TOOLS LIST.....	p.43
VII.	TROUBLE SHOOTING.....	p.44
VIII.	WIRING DIAGRAM .....	p.46~48

# Table of Contents

## IX. PARTS LIST

- ASSEM01- Machine body & table .....
- ASSEM02- Control panel .....
- ASSEM03- Power unit .....
- ASSEM04- Saw blade angel device .....
- ASSEM05- Saw blade rise & fall device .....
- ASSEM06- Scoring device .....
- ASSEM07- Outrigger arm .....
- ASSEM08- Crosscut table .....
- ASSEM09- Crosscut fence .....
- ASSEM10- Rip fence .....
- ASSEM11- Sliding table .....
- ASSEM12- Saw blade guard device .....
- ASSEM13- Angle encode .....
- ASSEM14- Accessories .....
- ASSEM15- Electric board .....
- ASSEM16- Cables .....

# 1. GENERAL INFORMATION & SAFETY RULES

- OAV equipment & tools, inc. is specialized to supply full series of panel saw from 1600, 2300, 2500, 3200 to 3800mm. The outlook design of this machine is so unique, complete cast iron trunnion bracket instead of sheet metal, enlarged outrigger and carriage, direct dust collection outlet. Term its overall condition. The table saw is also an important product after our band saw series, please enjoy your operation on this machine and if you have any comment to improve this saw, please don't hesitate to contact us through your agent.
- The panel saw are professional for woodworking machine designed to rip solid wood, chipboard, fiberboard, plywood and so these materials. Be careful for rigidity of working materials; don't try forbidden materials such as low flash point metals and high stiff stone...etc.

HSS (High Speed Steel) saw blade and milling tools should not be used. The saw blade made in accordance with EN847-1: 1997 shall be used on the machine.

Generally speaking, this machine will be installed as the following conditions:

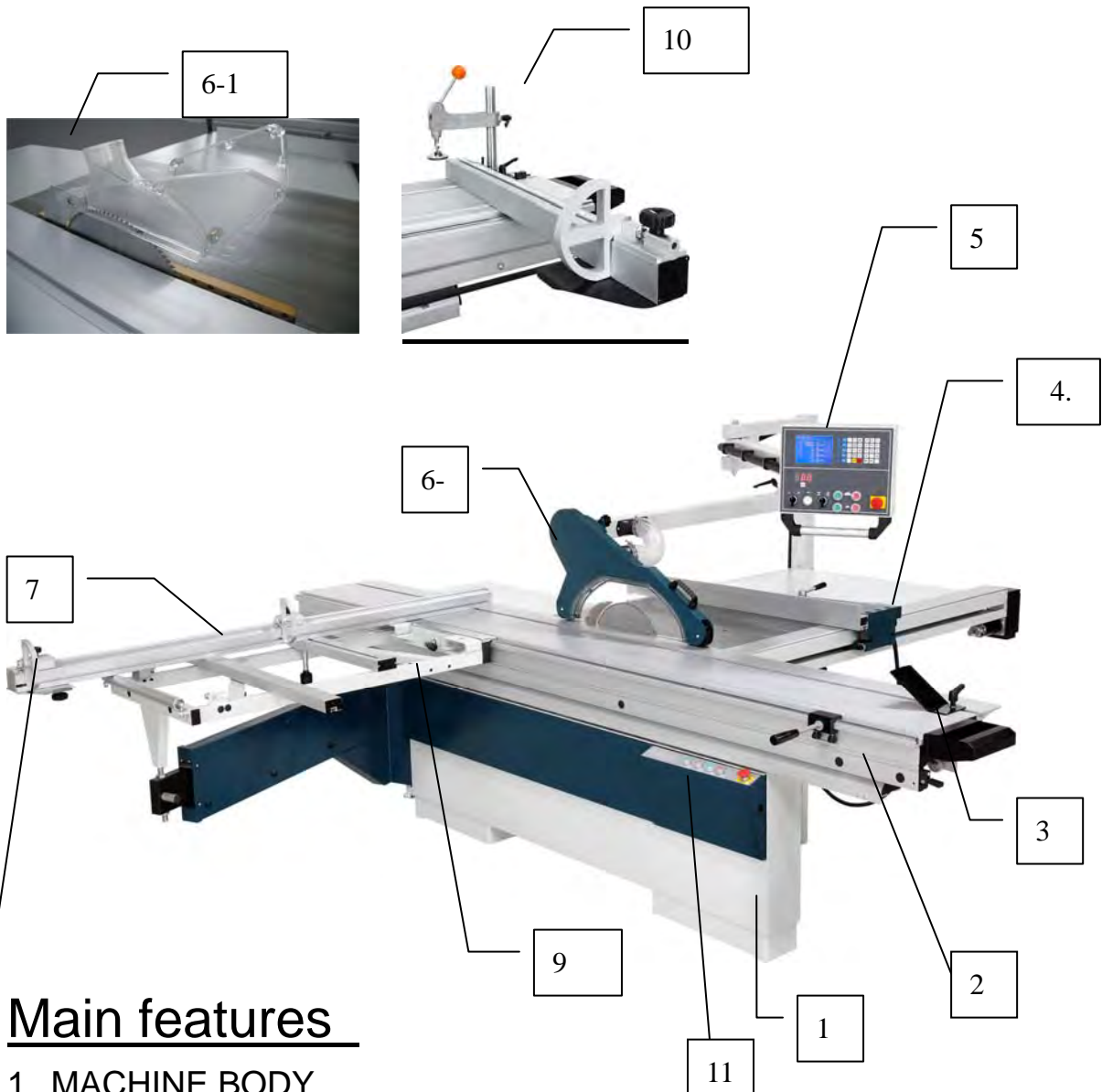
- 1) Supply voltage: 0.9 - 1.1 normal supply voltage
  - 2) Source frequency : 0.99 - 1.01 normal frequency
  - 3) Ambient temperature: 5°C - 40°C.
  - 4) Altitude: shall be at altitudes up to 1000m above the middle sea level.
  - 5) Relative humidity: not exceed 50% at 40°C.
  - 6) Atmosphere: Free from excessive dust, acid fume, corrosive gases and salt.
  - 7) Avoid exposing to direct sunlight or heat rays which can change the environmental temp.
  - 8) Avoid exposing to abnormal vibration.
  - 9) Electrical equipment shall withstand the effects of transportation and storage temperature within a range of -25°C to 55°C. Then, for short periods, it does not exceed 24 hours at up to +70°C.
- This machine was designed for certain applications only. We strongly recommend that this machine **NOT** be modified and/or used for any application which for other than its design. If you have any question which is relative to its application, **DO NOT** use the machine until you have had detail instruction from your dealer.

# Safety Rules

## For your own safety read instruction manual before operating

- 1) **Read instruction manual before operating the machine for your safety.**  
People who operate the machine must be trained, read and understood to use the safety measures, possess the ability to obey, and execute the regulation stated in this manual. Learn the machine's application and limitations as well as the specific hazards peculiar to it.
- 2) **Ground all machines.**  
It should make sure the "PE" terminal being connection before machine operating.
- 3) **Keep guards in place and working area clean.**  
Keep guards in place and in working order.
- 4) **Don't use in dangerous environment.**  
Don't use machines in damp or wet locations, or expose them to rain.  
Please provide a suitable illumination around the machine for safety operation.
- 5) **Keep children and visitors away.**  
All children and visitors should be kept in a safe distance from working area.
- 6) **Store idle tools (cutting spindle).**  
When not in usage, tools should be stored in a dry, high or locked up place, out of reach for children.
- 7) **Wear proper apparel.**  
No loose clothing, glove neckties, rings bracelets, or other jewelry to get caught in moving parts. Wear protective hair covering to contain long hair.  
**Please wear glove to take/ replace saw blade and wear eye-shield/ ear-shield to operation.**
- 8) **Stay alert.**  
Watch what you are doing. Do not operate machine when you are tired.
- 9) **Don't force machines.**  
It will do the job better and be safer at the rate for which it was designed.
- 10) **SHUT OFF** the power, removed the products, and isolated energy before leaving the machine.  
Shut off the power and carried out only when the machine is stationary before inspection, maintenance, adjustment and cleaning.
- 11) **No smoking!!** Don't smoking while operate machine.

## D405A/D405M/D405



### Main features

1. MACHINE BODY
2. SLIDING TABLE
3. EDGE SHOE
4. MOTORIZED RIP FENCE (OPTIONAL)
5. CONTROL PANEL (OPTIONAL)
6. OVERHEAD GUARD(OPTIONAL)
- 6-1. ONE PIECE STANDARD GUARD
7. CROSSCUT FENCE
8. FLIP STOPS
9. CROSSCUT FRAME
- 10.HOLD DOWN WITH MITER FENCE (OPTIONAL)
11. Control Panel (with angle read-out)

**12) Have your machine repaired by a qualified person.**

Repairs should be carried out by qualified-persons using original spare parts; otherwise this may result in considerable danger to the user.

**13) Check damaged parts.**

Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine what it will operate properly and perform its intended function. Being check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced

**14) Disposing of wasted material**

Disposing wasted material and wasted lubricating oil shall obey the local regulation and be deeply careful.

**15) Fire extinguisher:**

Workshop of user shall be with the fire extinguisher or other devices according to the local safety regulations and be deeply careful.

**16) Stand on proper position for operation.**

Please stand in front of machine for operation. Please refer to the following drawing.

**17) Use recommended ancillary equipment.**

Consult of the instruction manual of drawing for recommended accessories.

The use of improper accessories may cause risk of injury to persons.

If ancillary equipment is removed the original guards or safety devices shall be replaced.

OAV and our authorized agency are responsible for a future connection of the machine with ancillary equipment only if we ourselves have designed such connection.

**18) Reduce the risk of unintentional starting.**

Make sure switches of control panel are OFF position before operating.

**19) Never leave machine running unattended.** Turn power off from the hand-held disconnecting device. Don't leave machine until it comes to a complete stop.

**20) Make sure machine is disconnected from power supply:**

Make sure machine is disconnected from power supply before started the normal maintenance and service, adjustment, or repairing.

**21) Reaction with emergency situation:**

This machine provides two emergency buttons. One is self-latching push-button on the control panel of access position. Other emergency buttons are position on the front side on the machine near in-feed working area. The emergency button is colored red and yellow background. After emergency stop, follow the normal start up procedure and suitable operation to obviate the hazard. Please see the afterward pages of emergency stop position diagram.

- 22) Never open the protective cover or the machine door while the machine is running.
- 23) When the machine is out of order while running, shut it down and to call servicemen for help as soon as possible.
- 24) Wear ear protectors (plugs or muffs) during extended periods of operation.
- 25) Remove adjusting keys and wrenches before turning machine on. Be sure that the keys and adjusting wrenches have been removed and all the nuts and bolts are secured.
- 26) After switching off the saw motor, allow the saw blade to stop freely. Never attempt to stop the cutting by hand or other objects.
- 27) Never cut the wood plate if there is no completed width or too small.
- 28) The max. Rotation speed marked on the saw blade must not be exceeded.
- 29) The machine shall be not loaded with more than work piece at a time.
- 30) During making wooden cases, it will emit harmful dust. User must install exhaust system for the extraction of harmful dust.
- 31) Use correctly sharpened saw blades. Observe the max. Speed marked on the saw blade. User shall be to select the optimum speed for saw blade.
- 32) Report faults on the machine, including guards or saw blades, as soon as they are discovered.
- 33) Adopt safe procedures for cleaning, maintenance and remove chips and dust regularly to avoid the risk of fire.
- 34) Follow manufacturer's instructions for operating, adjustment and repair of saw blades.
- 35) Ensure that any spacers and spindle rings used are suitable for the purpose as stated by the manufacturer.
- 36) Refrain from removing any off-cut or other part of the work piece from the cutting area whilst the machine is running.
- 37) Ensure that guards and other safety devices necessary for machine operation are in position, in good working order and properly maintained.



38) Safety working practice.

a) Use of push block and push stick- Push stick should be used to avoid working with hands close to the saw blade. Push blocks should be between 300mm and 400mm long, 80mm to 100mm wide and 15mm to 20mm deep. Push blocks should be used when cutting small work pieces and in circumstances where it is necessary to push the work piece against the fence.

b) Selection of saw blade and riving knife- the operator should only select saw blade of a diameter and thickness suitable for the machine.

c) Selection of riving knife slot- The riving knife guiding slot should be no more than 0.5mm wider than the riving knife guiding elements.

d) Fixing of saw blade to spindle- Where the spindle diameter is less than the saw blade bore diameter, flanged bushes provided by the machine manufacture should be used to make up the difference. The use of loose rings or bushes is not permitted.

e) Lighting- it is important to provide adequate lighting around the machine.

39) Guide the work piece along the rip fence and through the rotation saw blade, using the push stick if necessary. Any damage, please replace new one that specification according below drawing.

40) Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.

41) **The dust generated by certain woods products can be injurious to your health.**

Always operate machinery in well-ventilated areas, and provide for proper dust removal. Use wood dust collection systems whenever possible

42) Any other maintenance is welcome to be contacted manufacturer or our distributor.

## SPECIFICATIONS

ITEM	MODEL D405A
Sliding table dimension	3200x395mm
Cast Iron table	548x896mm
Extension table (rear)	952x896mm
Extension table (front)	830X320mm
Table size	1500x1725mm
Round rail	φ50mm
Main saw blade /Optional	φ 355 (14")/Max. 400 (16")
Main saw bore	φ30mm
Max. cutting height at 90° (355mm)	105
Max. cutting height at 45° (355mm)	70
Main motor power (3ph)	7.5 HP (5.6 KW)
Main blade speed	3000/4000/5000rpm
Scoring saw blade	φ 120
Scoring saw blade bore	φ20mm
Scoring blade motor power	1 HP (0.75kw)
Scoring blade speed	8000 rpm
Cuting width	1300mm
Cuting width adjustment	Manual
Main saw blade tilting adjustment	Motorized (0° ~ 45° )
Main saw height adjustment	Motorized
Scoring saw adjustment	Manual
Motorized rip fence	Optional
Dust collection system	120/75mm
N.W./G.W./MEAS.: (Machine)	670/770kgs (2105x1150x1120mm)/94'
N.W./G.W./MEAS.: ( sliding table)	150/196kgs (3475x490x365mm-sliding)/22'
N.W./G.W./MEAS.: (overhead guard)	34/36 kgs (3 cartons)
N.W./G.W./MEAS.: (motorized rip fence)	2040x575x360mm, 83/106kgs /15'
Ctn QTY (with overhead guard)	7/17sets

Due to needs of continuous improvement, specification are subject to change without prior notice

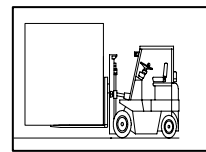
## 3-1. UNPACKING

### SETUP SAFETY

- For offering the completed information regarding to the operation and maintenance of our OAV machine, the operator are sure to protect the production as well as the equipments.
- Our sales organization is always at your disposal for any technical problem (reparation, spare part delivery. ), and to help your business.
- Keep this handbook for future information besides it shall always be with the machine.  
And follow the instruction of this handbook is very important .

- Provide for adequate space surrounding work area and around the machine clean and free of scrap material, oil and grease.

- The Model D405 series is a heavy-duty machine. **For equipments when unpack .**



- The sliding table for the machine weighs over 160kgs. **Use at least four strong people to lift it in position.** Improper lifting techniques or inadequate lifting assistance could result in serious crushing or strain injuries.

- Place a level on the saw table and adjusting 4 screws when necessary , so the saw table is level from left to right and from front to back.

**©IMPORTANT!! REMOVE THE FIXING PLATE(A,B) FROM D405 BEFORE OPERAT**



## 3-2. CHECK MACHINE ITEM

### D401/D405 Packing List

- \* Machine body one unit -1 wooden crate
- \* Sliding Table one unit -1 wooden crate
- \* Assembly parts for crosscut fence. x1
- \* Assembly parts for crosscut table. x1
- \* Assembly parts for swing tube. x1
- \* Assembly parts for rip fence x1
- \* Assembly parts for tool box x1+ instruction manual x1 +guard x1 + Flip stop x 2-
- \* Assembly parts for rear extension table. x1
- \* Assembly parts for left extensioin table x 1
- \* Assembly parts for edge shoe x1
- \* Assembly parts for scale x 1
- \* Assembly parts for round bar x 1

### Optional parts

- \* Assembly parts for overhead saw balde guard A1 type x 1 ( 5 packages)



### 3-3. FITTING THE SLIDING TABLE

Fitting the parts demounted for transport reason. For packing and transport reasons, some machine members are removed.

© **All fitting operations require approx. 4 people**

The accessories bag contains hex head bolts for fixing the sliding table

- Reset the sliding table complete with rail on the machine frame
- To lock the rail with the machine frame, screw down into the threaded hole
- Push the sliding table up against the stop screws prior to be tighten(fig. 3-3.1)

© **Working table is adjusted and fixed before shipment. When assebmle, suggest to attach directly without to re-adjust again.**

If demanded, please unscrew nuts A(fig 3-3.2) to ajust working table position. And check the position by the right angle ruler.



fig 3-3.1

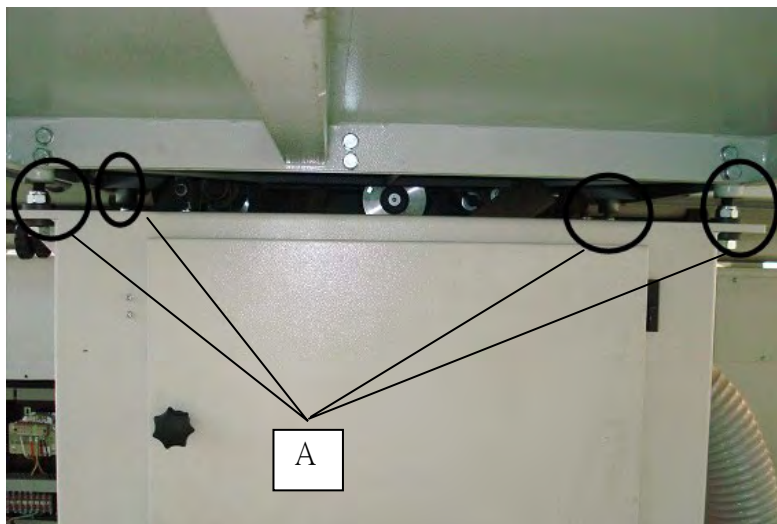


fig 3-3.2



## 3-4. FITTING CROSSCUT TABLE & CROSSCUT FENCE

© All fitting and demounting operations require **at least 2 people**

### Fitting the crosscut support

- Fit pivot "A" (fig 3-4.1) into the end of pivoting arm "B" (fig 3-4.1) first
- direct attach crosscut frame "C" (fig 3-4.1) to the sliding table through the the groove "D" (fig3-4.1) of the sliding table, (3-4.1) tighten lever "E" to fix on the sliding table (fig 3-4.1).

Note : To remove the crosscut frame, by withdraw E (fig 3-4.1).

### Fitting the crosscut table & fence

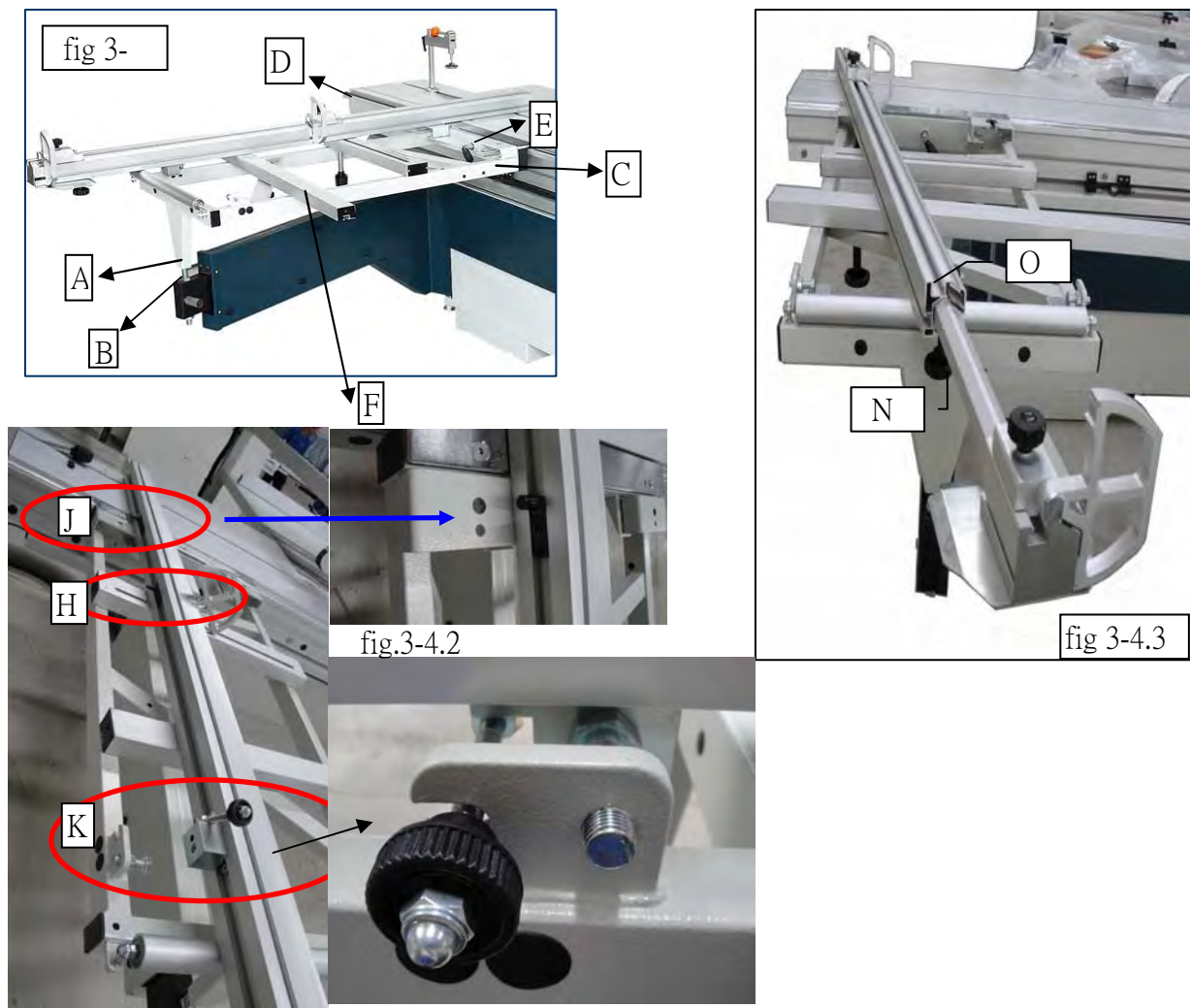
- Fit groove "F" (fig 3-4.1) to the holes (fig 3-4.1) of crosscut frame.
- Insert the fix block and set screw to the cross cut fence first then match the position "J" "H" "K"
- Put the crosscut fence on the cross cut fence on the crosscut table.

Parallel the crosscut fence and table, tighten the Screw knob to fix it. (fig. 3-4.2)

### Fitting the flip stop units

- Unlocking knob "N" (fig 3-4.3) of the extension piece and
- Put the flip stop unit to groove "O" (fig 3-4.3) of crosscut fence.

NOTE : For D405, Position "K" to adjust to parallel the table.



## 3-5. FITTING THE EXTENSION TABLE

### EXTENSION TABLE

© All fitting and demounting operations require 2 people

- Position the extension table over the holes on the cast iron table with the screws, before fasten the screw check the extension table and keep it aligned with working table (check the alignment with a ruler or straight edge placed on the tables)
- Screw down the three screw A(fig 3-5.1)
- Adjust the alignment with grub screws B when is needed. (fig 3-5.1)

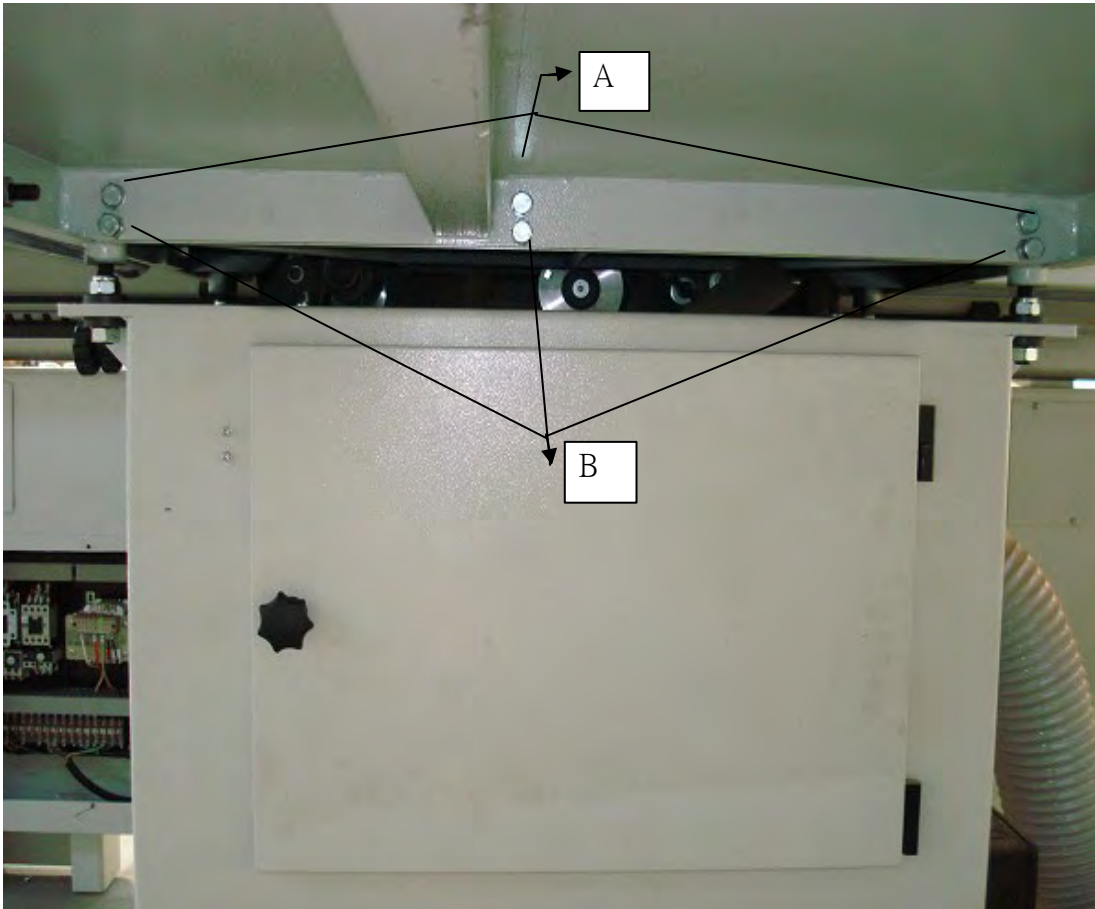


fig 3-5.1



### 3-6-2.1 OVERHEAD SAW BLADE GUARD & CONTROL PANEL

1. When the max saw blade dia. More 355mm, the overhead saw blade guard is necessary to follow the CE regulation. The saw is offered with wide hood for tilting cutting.

2. install the overhead safety guard. The blade guard assembly consists of 2 parts, one support arm and 2pcs of clear plastic blade guard shield. (one flat shield and one wide shield for tilting cutting).

3. Position the support arm over the holes on the side of machines and secure it within the nuts M20x3pcs and lock washers.(Fig3.6.2.1)

4. (fig.3.6.2.3)Assembled the support bracket arm with screw not yet fasten it install the fix plate between the support bracket and the table (fig. 3.6.2.4) parallel it then fasten it. If is not in the right position, adjust the bolt to the right position (3.6.2.2).

5. Insert the long support bracket through the arm (fig. 3.5.2.5) overhead saw blade guard. (Fig3.5.2.5)



Fig3..6.2.1

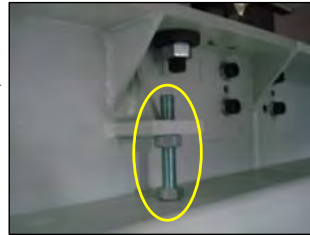


Fig3.6.2.2

fig.3.6.2.4



fig.3.6.2.3



fig. 3.6.2.5





6 Use 3pcs of head screw M6 to assemble the fixed plate for Install adaptor to the the hose to the saw blade guard.(Fig3.6.2.6 & 3.6.2.7)

Fig3.6.2.6



3.6.2.7



7. Install the control panel support arm to the support bracket fasten it with (fig. 3.6.2.8)



Fig. 3.6.2.8

### 3-7. FITTING RIP FENCE

© All fitting and demounting operations require 2 people

Remove the washer and nut from the round bar first and then

– Insert the screw rod of the round bar into the holes A (fig 3-7.1) of working table extension table put the washer and nut at the back side of the table, then fasten it in the right position.

– Mount the fence scale (ruler) set to the edge of the working table and extension table B (fig 3-7.1) fasten the fence scale (ruler) set with washer and lock washer.

– Slide rip fence support C (fig 3-7.1) into round bar D (fig 3-7.1)

– Handle E (fig 3-7.1) Up to release rip fence, down to lock the rip fence.

– Mounting aluminum fence F (fig 3-7.1) to clamping assembly in upward position.

NOTE : Before operation, the 0 mark on the rip fence scale must be aligned with the right side of the blade to ensure the processing accurate. And release the screw to adjust the scale position.

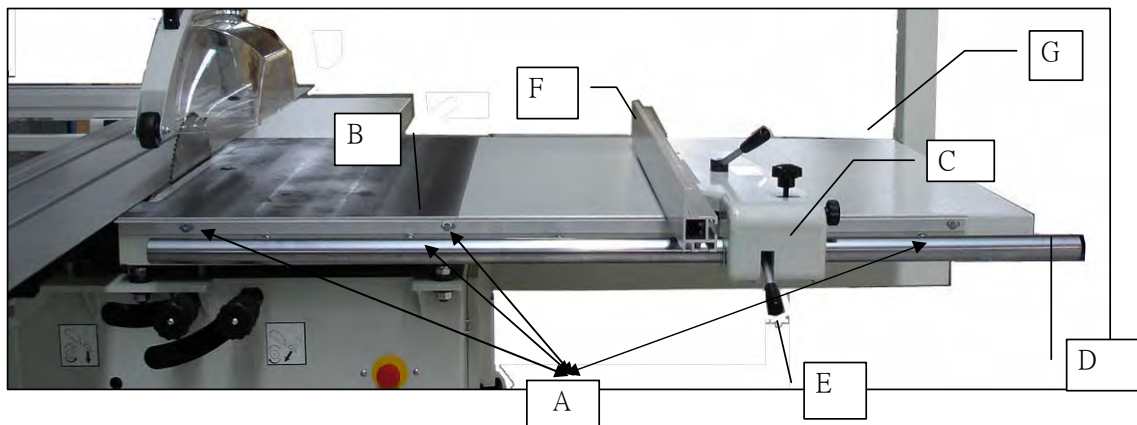
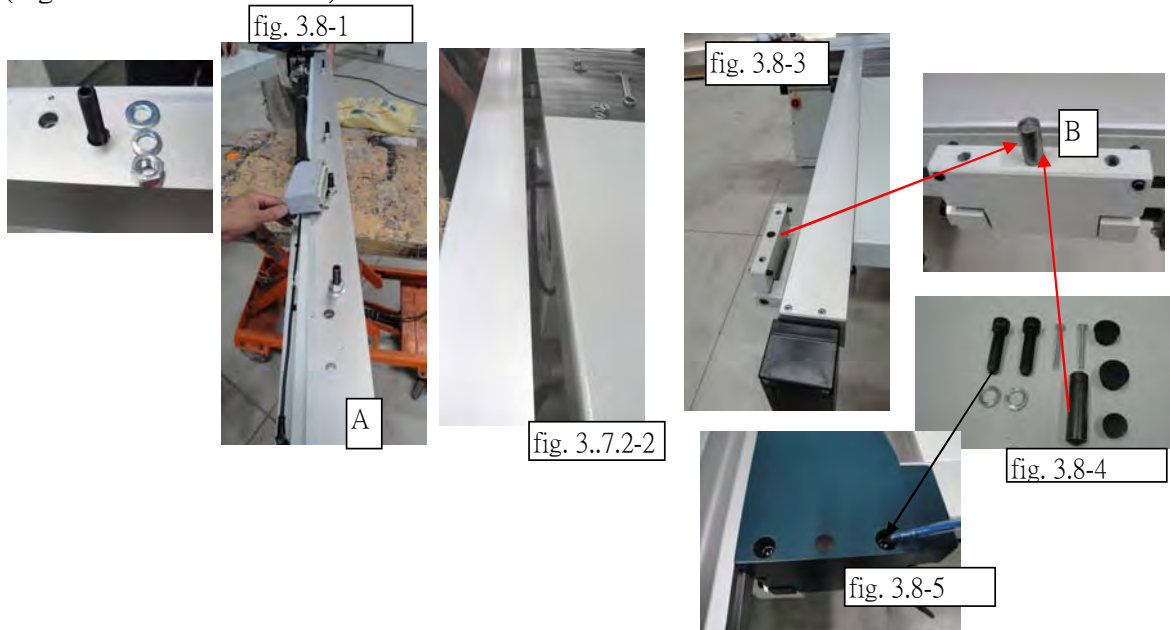


fig 3-7.1

### 3.8 FITTING MOTORIZED RIP FENCE

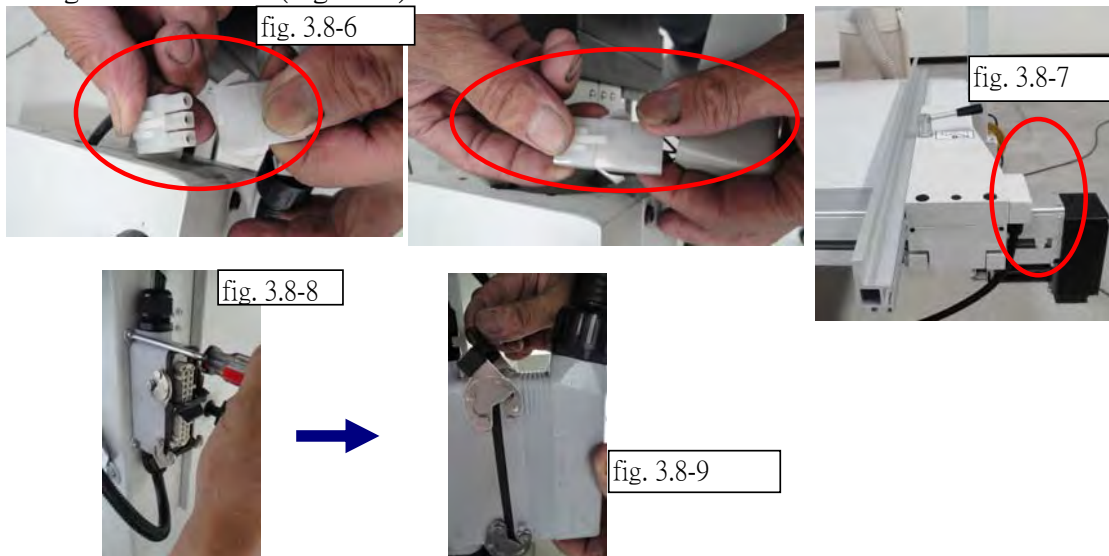
(1.) Motorized rip fence(Fig.3.8-1)(Fig.3.8-2) Firstly, remove the nut and washer from the liner guide Position the Motorized rip fence liner guide unit A in the location holes along the working table and the extension table , parallel it with table then fasten it . Before that fasten it. Note—The center mounting post is positioned closer to one end of the rail. Align the mounting posts with the mounting holes accordingly. Use the straight edge to check the alignment of the table.

(2). Insert the pin to the rip fence set see " B" , assemble the fence body to the rip fence set Use screw to fasten the rip fence and put the lead to cover the hole, to prevent the dust . (Fig.3.8-3 & 3.8-4 & 3.8-5)



(3). (Fig.3.8-6)Connect the wiring of Push-botton Switch at the right side of the rip fence put mount the cover back when finish (Fig.3.8-7)

(4).Install the wire set on the machine bodyfig. 3.8-8, connect the Motorized rip fence corrugated wire unit . (Fig.3.8-9)



## 3-9. FITTING THE SAW BLADE

### Safety notes

- ⊙ Install the saw blade with gloves, always pay attention when changing the blade.
- ⊙ Open blade protect guard before install the saw blade (fig3-9.2a).

For fitting or replacing the saw blade proceed as follows:

- Adjust the main saw blade unit in 90 degree by turning handwheel A(fig3-9.1).
  - Rise up the main saw blade by turning knob B (fig 3-9.1) clockwise
  - Press the emergency button
  - Move the sliding table totally to the right
  - Open the blade protect guard -red cover (fig 3-9.2)
- 
- With thumb press the button for locking the spindle through hole F(fig 3-9.3) and at the same time turn the saw spindle in order to lock it.
  - By turning the proper wrench clockwise totally unscrew screw G(fig 3-9.3)and washer H(fig 3-9.3) which clamps the saw blade.

Note : Continue to press the button until the screw is loosen.

- Before fitting the saw blade, make sure that the flange H(fig 3-9.3) is clean to avoid vibrations when the saw blade is rotating
- Fit washer H(fig 3-9.3) ,screw G(fig 3-9.3)
- Tighten screw G(fig 3-9.3) by turning the screw counter clockwise

⊙ **During the machine operation, pay attention to the saw unit.**

**Pay attnetion when the blade guard is open , always close it and make sure no one around before you move back your sliding table.**

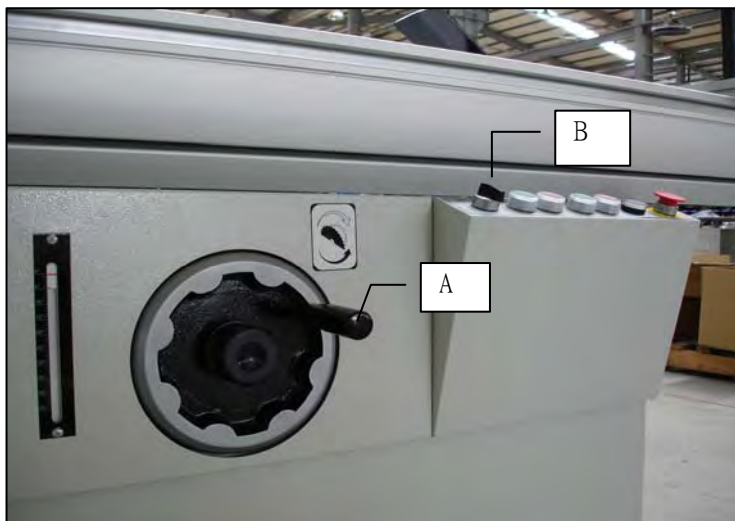


fig 3-9.1

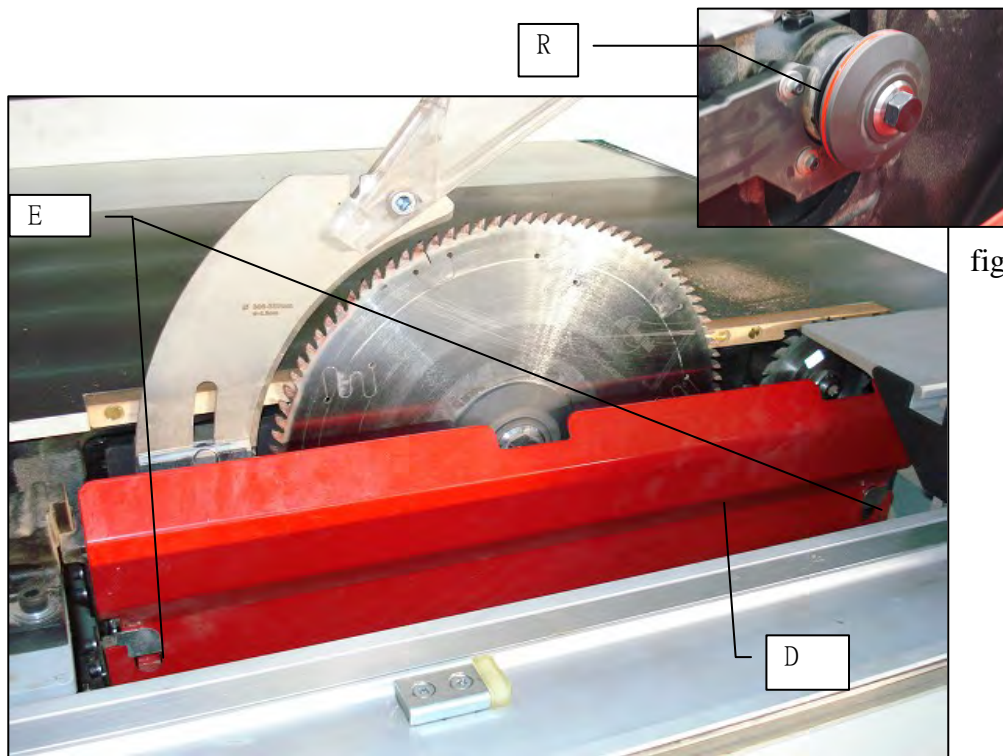


fig 3-9.2a

fig 3-9.2

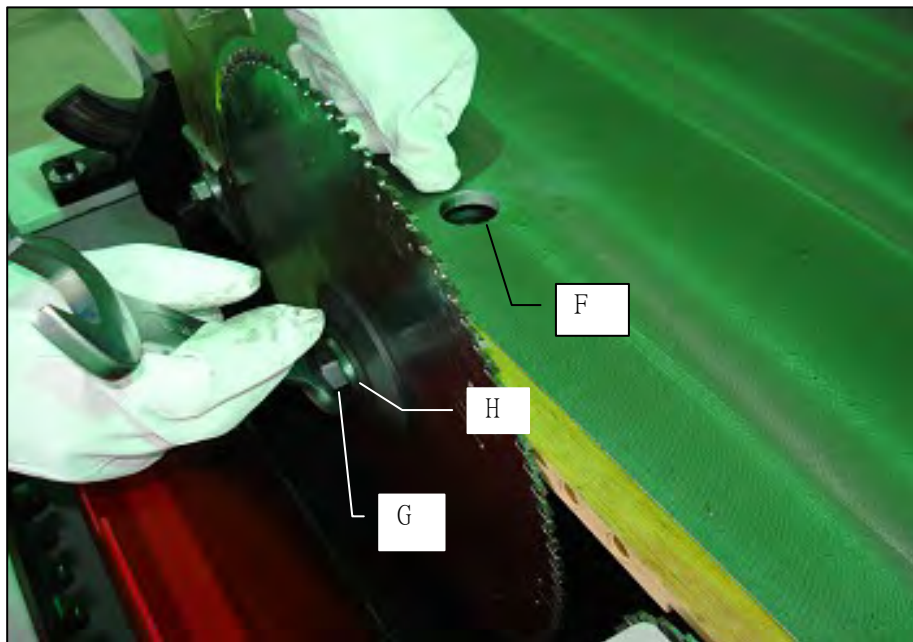


fig 3-9.3



## 3-10. RIVING KNIFE

© **Install the riving knife with gloves.**

NOTE : The machine is always equipped with one riving knife for 355mm saw blade

© **Always fit the proper riving knife**

- Loosen nut A (fig 3-10.1) insert the riving knife with a wrench without complete tightening it.
- Position the riving knife about 3mm or 1/8" away from the nearest tooth on the main blade.  
( gap L between saw blade and riving knife shall be 3mm approx.)
- Tighten the nut A to secure the riving knife in the position. (fig 3-10.1)
- Move the blade guard back to the position, move the sliding table to center.

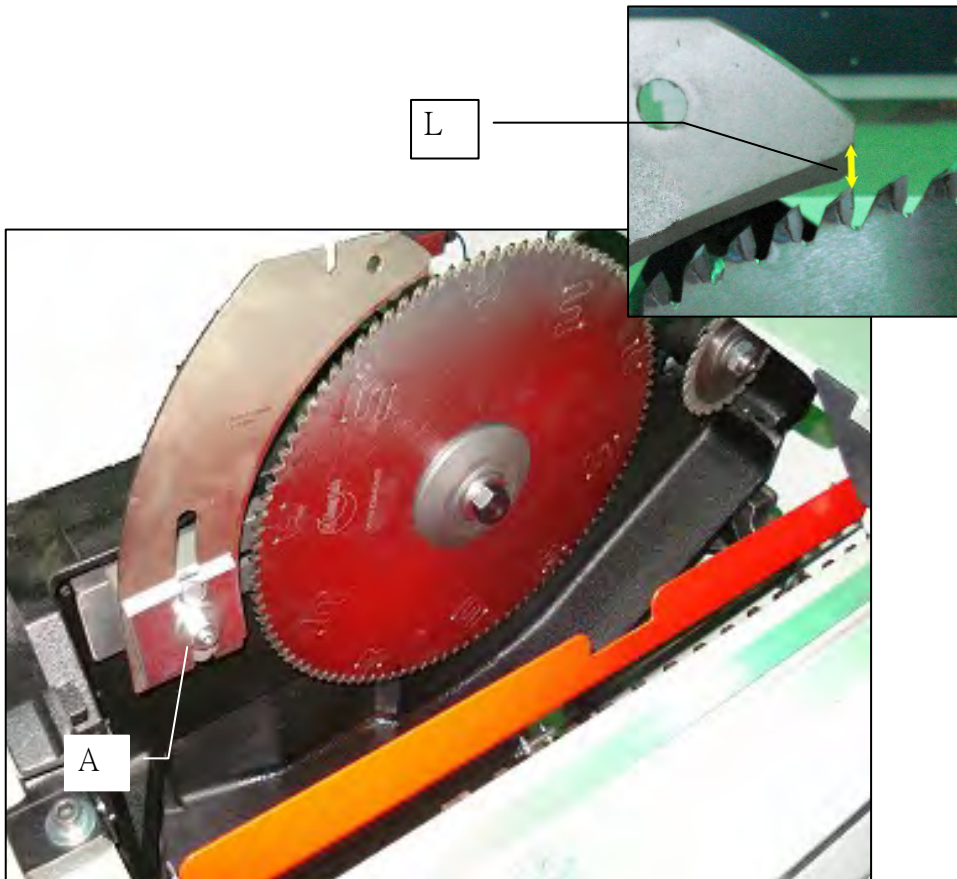


fig 3-10.1a

fig 3-10.1

## 3-11. Changing scoring blade

© **Changing scoring blade with gloves, always pay attention when changing the blade.**

- Press the emergency button
- Set the saw blade in 90 degree by turning the handwheel A (fig. 3-11.1)
- Loosen knob B (fig 3-11.1), turning knob A(fig 3-11.1) clockwise to set the sawblade upward
- Lock knob B (fig 3-11.1)
- Move the sliding table totally to the left
- Open the blade protect guard -red cover (fig 3-11.2)
- Hold the spindle in a fix position by inserting the fixing bar E(fig 3-11.3)
- Loosen nut with hex- wrench
- Take off nut and one flange
- Make sure that flanges and scorer blade are clean
- Fit the scoring blade, flange and nut then tighten nut E
- Move the fixing bar from Table
- Release the emergency button

NOTE : for safety concern, always close the blade guard when finished, (fig. 3-11.2); move back the sliding table to the center.

© **During the machine operation, pay attention to the saw unit & when the blade guard is open , always closed the guard when is finised , make sure no people around before you move back your sliding table.**

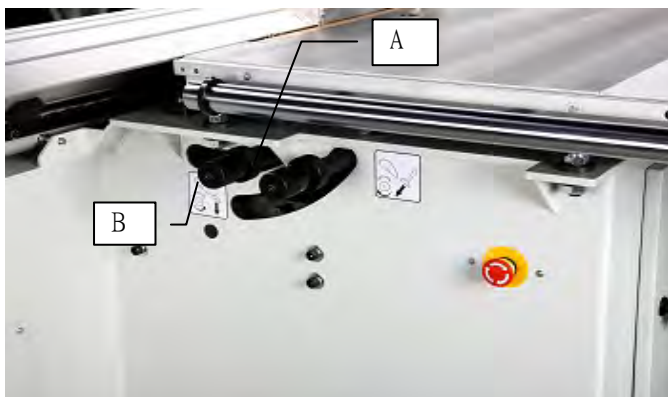


fig 3-11.1

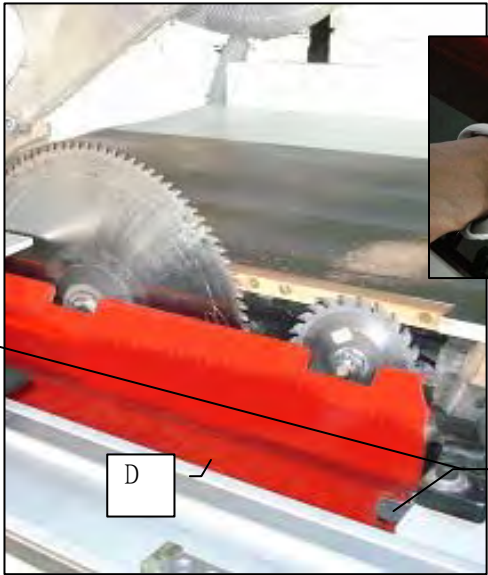


fig 3-11.2a

fig 3-11.2

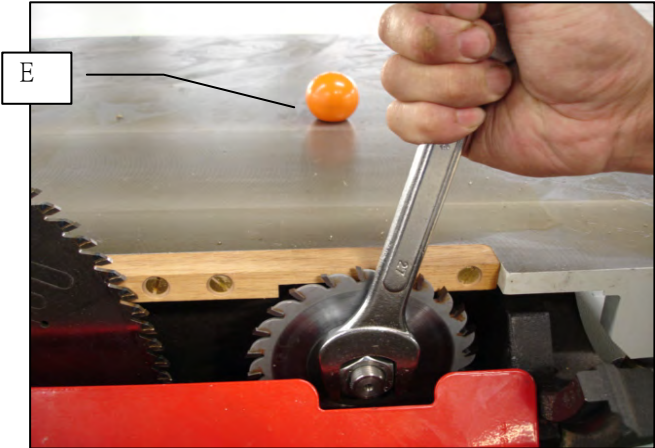


fig 3-11.3



## 3-12. EDGE SHOE ,HOLD DOWN & MITER FENCE

Edge shoe

– The edge shoe is used for trimming planks and fixes the workpiece on the sliding table.

NOTE : Edge shoe is demanded in heavy duty processing.



fig 3-12.1

Miter Fence with hold down(Optional)

– Allows precise miter cuts between  $+ 45^\circ$  and  $- 45^\circ$  on the sliding table and clamping the workpiece.

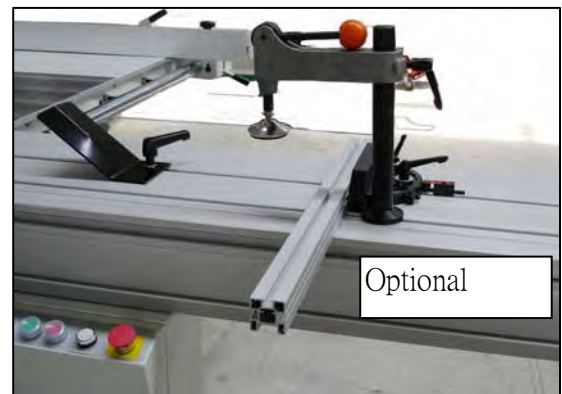


fig 3-12.2



### 3-13. CONNECTION TO THE DUST COLLECTION

© **The connection to the dust collection is necessary for the good machine operation. Always work with the dust collector in operation.**

The saw is equipped with two dust ports connected to a dust collection system before operation.

–Exhaust pipe ( fig 3-13.1) diameter 120mm

–Exhaust pipe (fig 3-13.2) diameter 75mm. Make sure the exhaust pipe well placed along overhead guard arm.

If other machines are connected to the centralized collection system, carry out a test with all collection system in operation.

The right operation of the collection system reduces the risks of dust inhalation.



fig 3-13.1

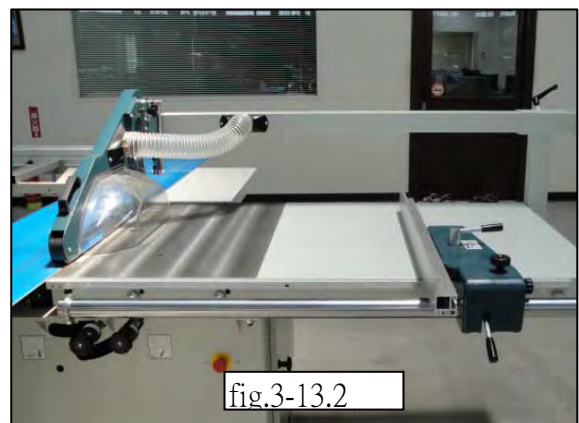


fig.3-13.2

### 3-14. WIRING & TEST RUN

– Make sure that the electric system of the workshop may absorb the machine power and that the grounding system agrees with the prescriptions in force.

NOTE : Comply with local codes to prevent fire accident.

– The power cord section need to fit motor power rating

– Please **CUT OFF** power source before open the terminal box for the electrical connection.  
The connection terminals for the supply cables are marked with L1, L2, L3, N and PE.

– Make sure all electrical circuits are grounded before you connect them to the machine.

– If the motor wrong rotary, the power source is connected to the reverse phase.  
Please change the incoming wire L2 and L3.



fig 3-14.1

– Test run :

© **Make sure safety device. Machine operator is to be trained for the use, adjust, and operation.**

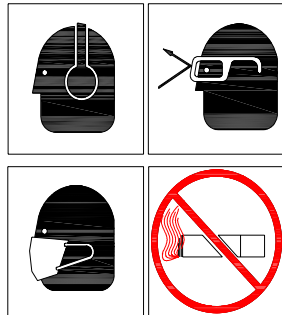
– All operations requiring the demounting of machine components must be carried out only by suitable skilled and authorized personnel.

Keep the safety prescriptions as well as the general work safety regulations.

– If any problems happen, press the emergency STOP

button. If you need help, please take the troubleshooting section of this manual or contact your local agent.

- Always wear safety glasses, a respirator, and hearing protection and NO smoking when operating this machine



- Turn the main switch **ON**. (Fig3.14.2)  
Test run the main blade rise/fall  
Test run the main blade tilting  
Test run the main blade  
Test run the scoring blade

fig 3-14.2



## 4-2. SAW BLADE LIFTING AND TILTING

### SAW BLADE LIFTING

- Turn knob A(fig. 4-2.1)counter clockwise : the saw blade rises.
- Adjust the saw blade height according to the workpiece thickness.
- The saw blade height is right when it exceeds the piece thickness 1 ~ 1.5cm
- Set the standard guard C(fig. 4-2. 2) to a max. height 4 ~ 5mm from the workiece.

### SAW BLADE TILTING

- Turn handwheel B(fig 4-2.1) to tilt the saw blade up to the demanded degree based on scale

© **During the machine working, pay attention when the sliding table is totally on the left, the blades remains uncovered.(fig 3-9.2)**

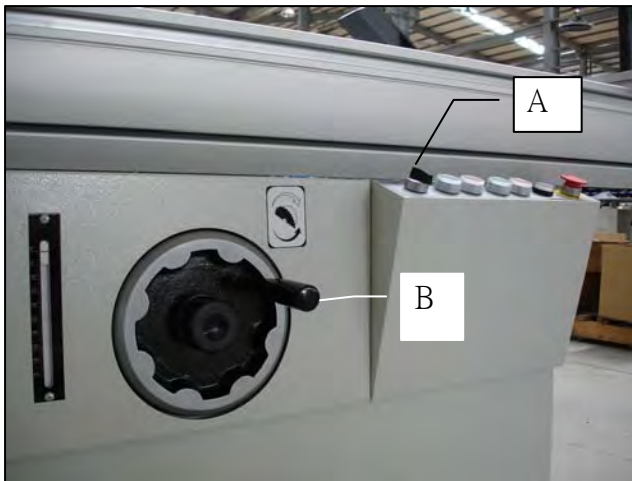


fig 4-2.1

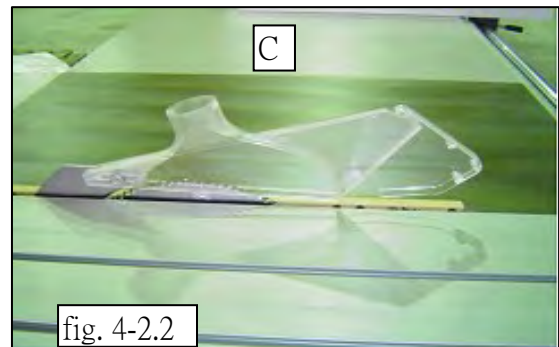


fig. 4-2.2

## 4-3. SCORING ADJUSTING

### SCORING HEIGHT ADJUSTING

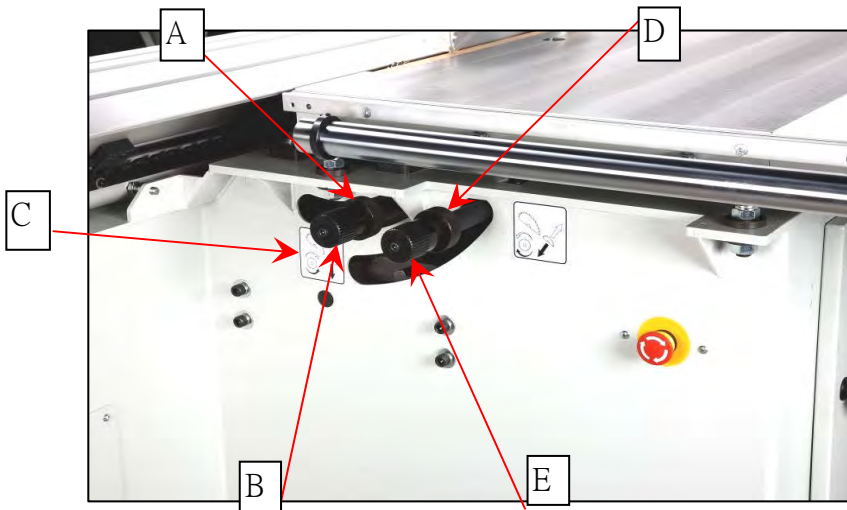
- Loosen nut A(fig 4-3.1)
- Move the draw bar B(fig 4-3.1) along the sector C(fig 4-3.1) to the height desired, and tighten nut A(fig 4-3.1)
- The projection adjusting range varies from 0 to 5mm

NOTE : When it is not necessary to use the corer, lower the scorer to the end of stroke under the table.

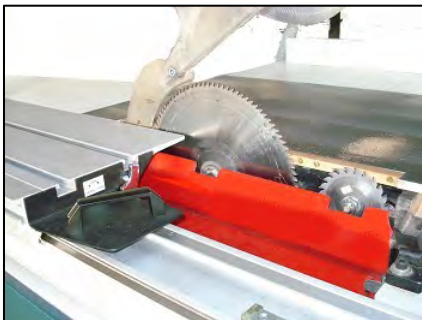
### ALIGNING THE SCORING WITH THE SAW BLADE :

- The operator have to make some cutting tests.
- Loosen nut D(fig 4-3.1)
- Turn draw bar E(fig 4-3.1) to the desired position, and tighten nut D(fig 4-3.1)
  - turn clockwise, the scorer move to left
  - turn counter clockwise , the scorer move to right
- The range for traverse adjustment of the scorer is approx. +/-2mm

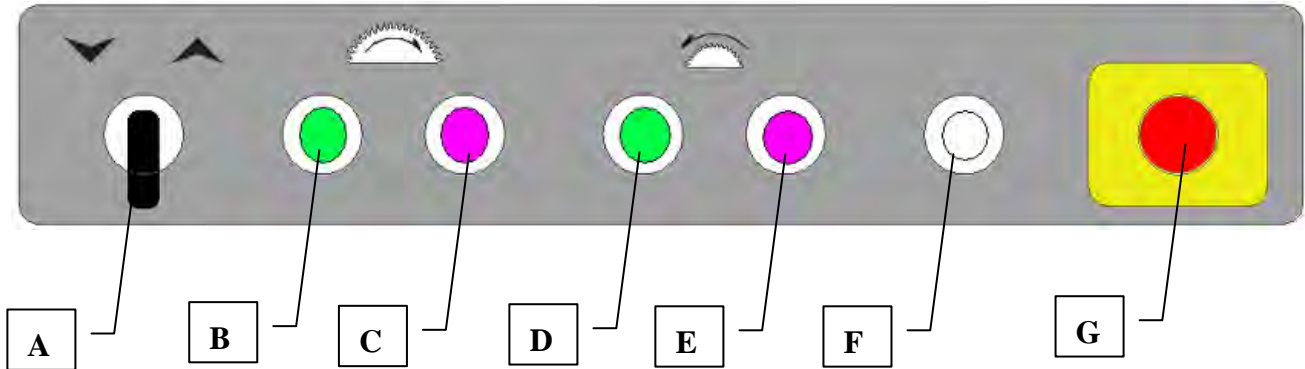
NOTE : Test cut to check the alignment is necessary.



© During the machine use with scoring unit, pay attention when the sliding table is totally on the left ,for working a part of the blades remains uncovered.



## 4-4.OPERATIONS-D405

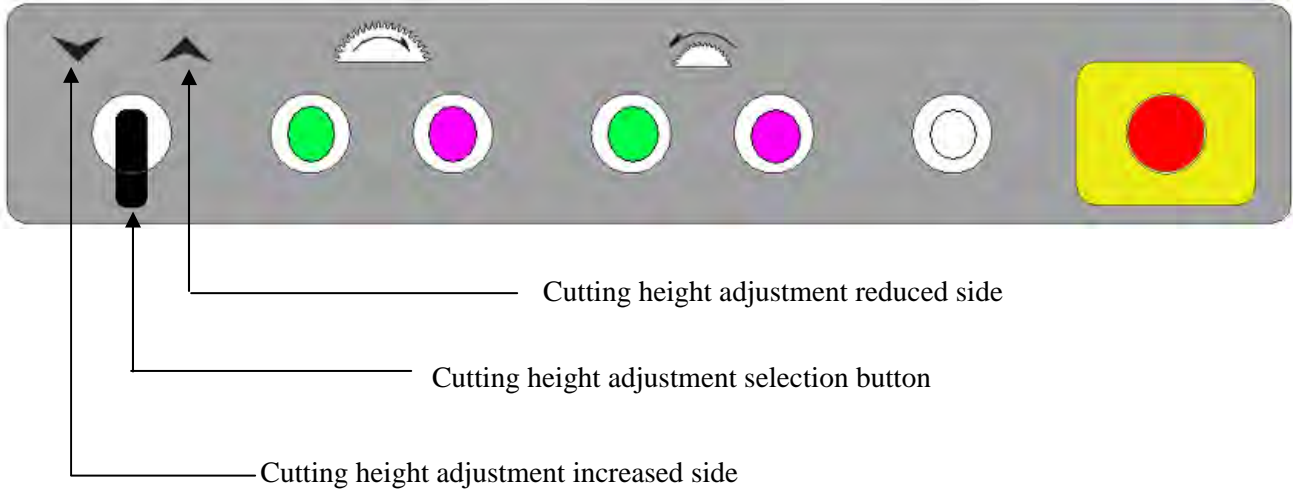


### Control panel close-up





- A. MAIN BLADE Rise / Fall Switch—Rise/Fall function switch of the main saw blade.
- B. MAIN BLADE ON Button—Starts the main saw blade.
- C. MAIN BLADE OFF Button—Stops the main blade.
- D. SCORING BLADE ON Button—Starts the scoring blade. Note—The main saw blade must be ON for the scoring blade to start.
- E. SCORING OFF Button—Stops the scoring blade.
- F. POWER LIGHT.
- G. EMERGENCY STOP Button—Disconnects power to all motors in the motor cabinet

## ● Raise and Fall of the main saw blade

- Height adjustment of the main saw blade



### Cutting height adjustment

- Infinite precision adjustment:
- The cutting height is reduced by Press the  **Selection button** turn to  reduced side.
- The cutting height is increased by Press the  **Selection button** turn to  increased side.



### 4-5. 3 SPEED CHANGE

- Set the saw unit down
  - Stop the machine , turn the main switch to 0 ; then lock it and indicating this with a sign
  - Open the rear door
  - Loosen knob A(fig 4-5.1)
  - Lift lever B(fig 4-5.1) of belt stretcher to the end of stroke, then tighten knob A(fig 4-5.1) the belts are slack and may be replaced
  - Set the belts in the proper races ( the smallest dia. gap set as 5000rpm, the middle dia. gap sets as the smallest dia. groove set as 5000rpm, the middle dia. groove set as 4000rpm, the largest dia. groove set as 3000rpm.
  - Loosen knob A(fig 4-5.1)
  - Move lever B(fig 4-5.1) of belt stretcher to iniiial position ( that is totally down) to stretch the belts
  - Tighten knob A(fig 4-5.1)
  - Close the rear door
- \* Make sure that the selected rotation speed is proper for the working and for the saw blade.

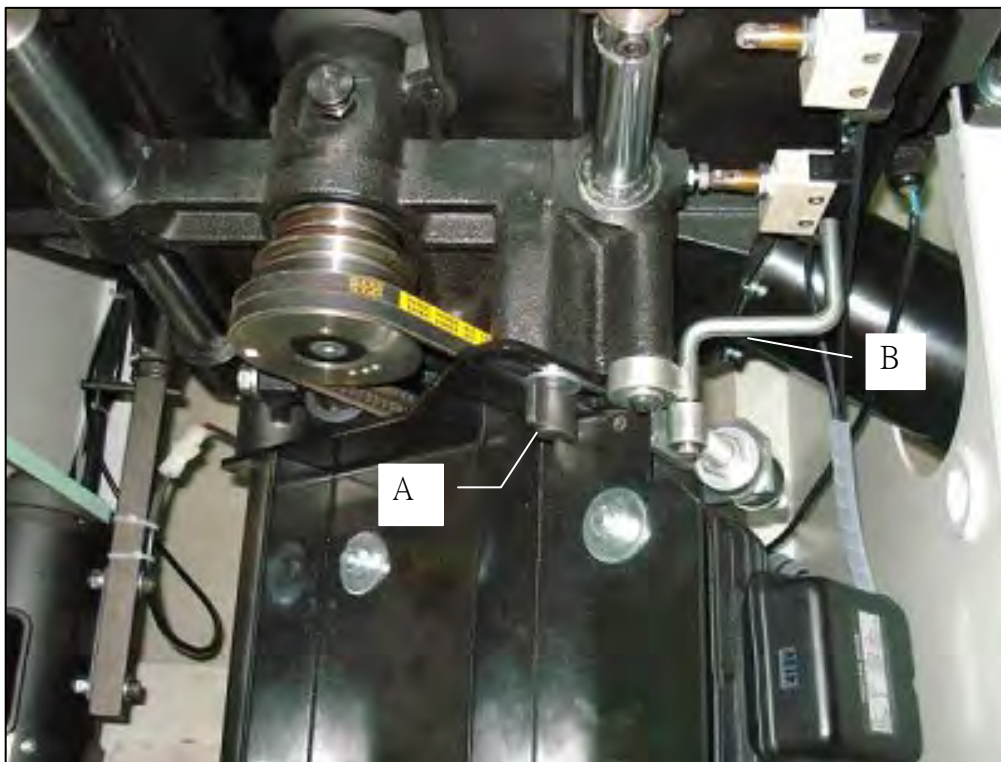


fig 4-5.1

## 4-6. SETTING TO ZERO THE FENCE FOR PARALLEL CUTS

Make sure the distance before operation

- Turn off power , and lift the saw guard
- Unlock the fence for parallel cuts A(fig 4-6.1) by means of knob F(fig 4-6.1) & handle B(fig 4-6.1) and move it in order to read a value between edge C(fig 4-6.1) turned to the blade and millimeter rule
- Measure the distance D(fig 4-6.1) between saw blade and parallel fence
- Loosen ruler screw and move millimeter rule in order to read the same value previously measured on the edge C(fig 4-6.1) of fence.
- Lock the fence unit with handle B(fig 4-6.1) , lower the guard and make a test cut
- Tighten knob F(fig 4-6.1)

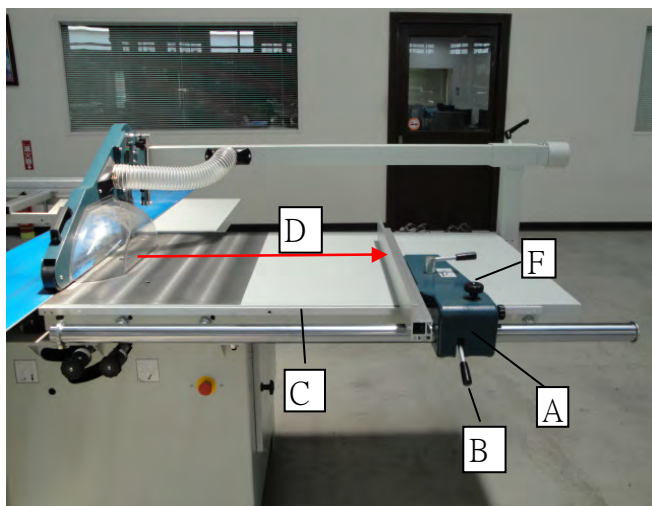


fig 4-6.1

USE THE FENCE FOR PARALLEL CUTS

ADJUSTING :

- Move sliding table M(fig 4-6.3) lock knob K(fig 4-6.3)
- Lift lever A(fig 4-6.2) for unlocking the fence unit.
- Move the fence unit near the desired measure as much as possible ( read out the value on millimeter rule C(fig 4-6.2))
- For micrometric setting rip fence,turn knob B(fig 4-6.2) clockwise for locking rip fence, unlock lever A (fig 4-6.2), turn knob D(fig 4-6.2)

Turn clockwise, the rip fence move to left ; turn counter clockwise, the rip fence move to right

- After reaching the measure, lock the fence unit by lowering lever A(fig 4-6.2)

Rule F(fig 4-6.2) can move in longitudinal direction after unlocking handles G(fig 4-6.2) ; after every adjustment, tighten handles

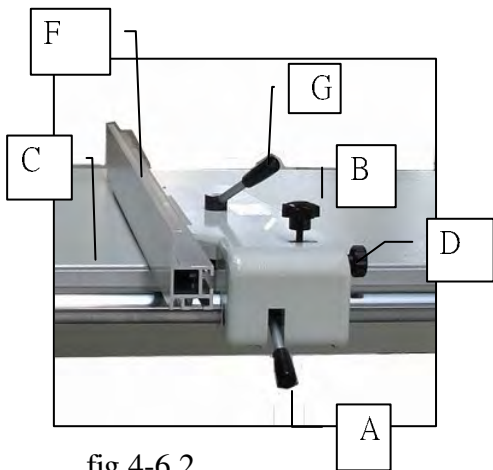


fig 4-6.2

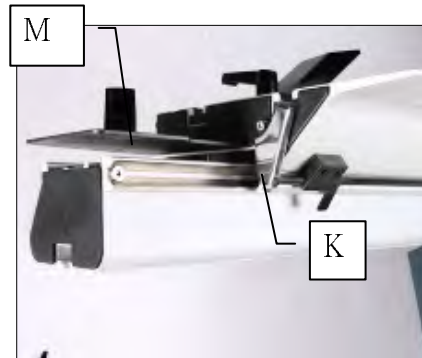


fig 4-6.3

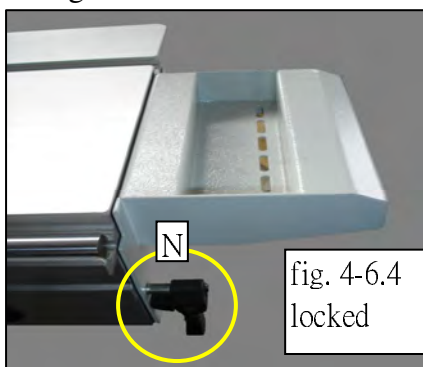


fig. 4-6.4  
locked

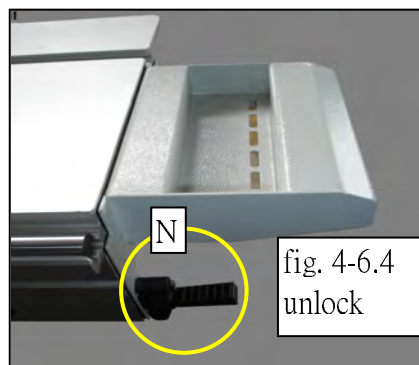


fig. 4-6.4  
unlock

**Note : For D405, PLEASE RELEASE OR LOCK THE ROD N (fig4-6.4) FOR MOVING THE SLIDING TABLE.**

#### POSITION OF ALLOY RULE

- Vertical position F(fig 4-6.2) turn to the workpiece
- Horizontal position for cutting thin workpiece and for slanting cuts.
- It is possible to move the workpiece forwards by using pusher.
- Tighten the handle G(fig 4-6.2)

\* For the execution of special working, the operator is obliged to put his hands near the tools.  
Based on safety reasons, use a proper pusher to move the workpiece forwards. To push it against the fence or to move it away after cutting.

#### NOTE : Take off the rip fence unit

- Loosen lever A(fig 4-6.2)
- Loosen knob B(fig 4-6.2)
- Move rip fence to the max. distance from the saw blade.
- Lightly turn fence unit around bar , and to switch it off.

## 4-7. SLIDING TABLE

The sliding table moves on high precision slideways made of hardened steel in order to ensure the uniform and smoothly motion with small friction, necessary for obtaining precise cut. The sliding table is locked and unlocked by means of lever A (fig 4-7.1)

- Lever up : sliding table unlocked
- Lever down : sliding table locked.

NOTE : Lock sliding table before placing heavy workpiece for safe location.

### USE OF SLIDING TABLE AND FRAME FOR LARGE PANELS

Longitudinal positioning of the frame

D401M : Lock/Unlock the sliding table by means of knob A for placing large workpiece

D405M : Lock/Unlock the sliding table by means of rod B for placing large workpiece

- Move the frame by means handle M (fig 4-7.2) or C (fig.4-7.3)
- Lock knob

© To remove the sliding table of D405M over the saw blade center , please move to the end and backward a little for opening the second positioning design

USE OF THE HOLD DOWN :

- Loosen handle to adjust the foot height

© To ensure a strong panel clamping, the foot shall be at a 2mm height from the panel surface before lowering the lever.

- By means of lever H (fig 4-7.3) lower foot F (fig 4-7.3) for clamping the workpiece

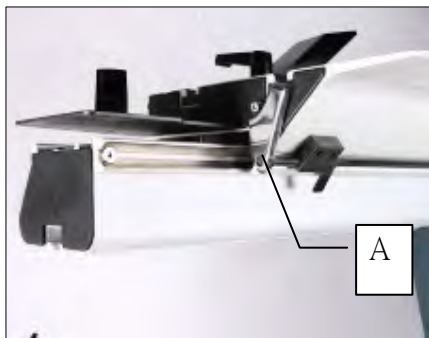


fig 4-7.1



fig 4-7.2

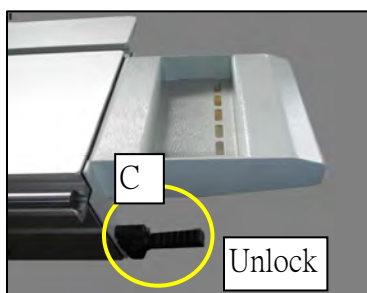


fig 4-7.3



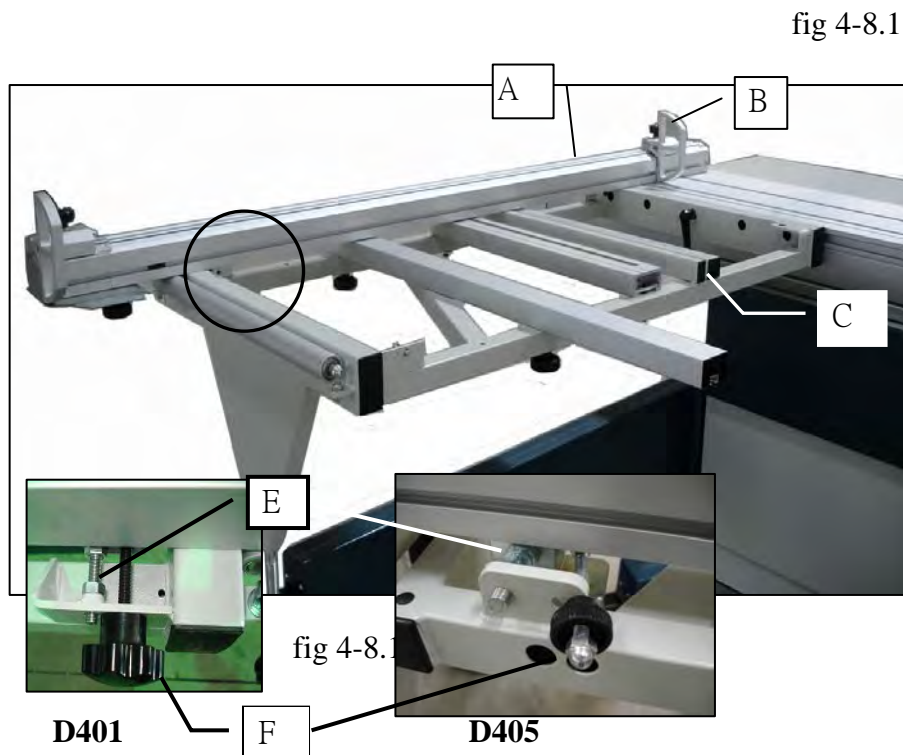
fig 4-7.4

## 4-8 SETTING TO ZERO THE REST RULE

NOTE : Before starting the zero setting align rule A(fig 4-8.1),  
After aligning the crosscut fence, lift and turn it over on the frame.

- Fit crosscut fence into the groove C(fig 4-8.1) of crosscut table based on demands.
- Lock knob for fixing
- Turn threaded nut E (fig4-8.1b) to adjust crosscut fence and crosscut table be parallel.  
Then lock knob F (fig4-8.1b) for fixing.

Turn on the machine, then trimming with the crosscut fence.



### ZEROSSETTING CHECK

- Lower the guard, trim a panel on 2 sides in order that they are perpendicular to each other
- Lock stop G(fig 4-8.2) on the rule at given measure, so that the panel may be cut.
- Rest the panel edge already trimmed against crosscut fence, and the other trimmed edge against stop G
- After cutting, measure the cutting width.

### SETTING TO ZERO THE CENTRAL MILLIMETER RULE

For cutting panels of width exceeding 1860mm, you have to use the extension part A(fig 4-8.2) by loosening knob B(fig 4-8.2)

- Move extension part A(fig 4-8.2) , so that it touches fixed part C(fig 4-8.2)
- Take the measure corresponding to internal edge of stop D(fig 4-5.8) on millimeter rule E(fig 4-8.2) , so that point F(fig 4-8.2) indicates the same measure
- Tighten knob

Everytime while using extension part for cutting large panels , point F(fig 4-8.2) indicates the measure.

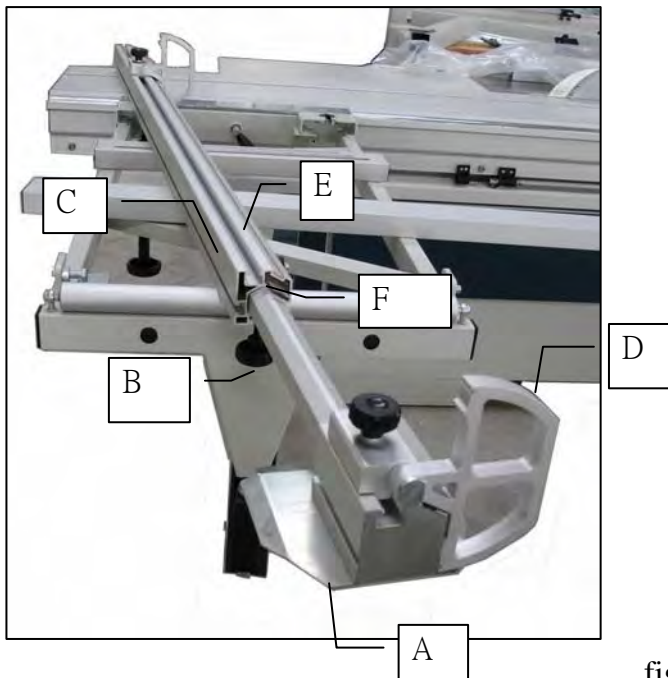


fig 4-8.2

### RULE ADJUSTING FOR OBLIQUE CUTS

- Loosen knob D(fig 4-8.1) & grub screw F(fig 4-8.1b) to change position of crosscut fence
- Adjust the position for making sure the right side of the fence G(fig 4-8.1) aligning with the desired angle
- Tighten knob

### Cleaning & Checking Schedule

Check items	Daily	Weekly	Monthly	3-months	6-months	yearly
Check emergency stop and indicate lamp whether normal or not?	✓				✓	
Check the integrity of noise, pressure and ventilation of the machine.	✓			✓	✓	
Clean the exterior part of the machine	✓		✓			
Check all the screws from the machine whether tight or not?					✓	
Check screws and nuts of limit switch whether tight or not?	✓				✓	✓
Check all wires and electric connections near the power switch to see if there have any			✓		✓	✓
Check belt running normal or not? If any break or failure, replace it.	✓		✓		✓	
Check the load voltage and current of the motor			✓			✓
Check the continuity of all the wires		✓				
Clean the interior part of the electrical box and check the continuity of the wires.			✓			
Tighten the terminal screws of the power supply wires in the control box					✓	
Any worn or damaged parts and unsafe condition.	✓			✓		
Clean & vacuum dust buildup from inside cabinet.			✓			

## 5-1. MACHINE CLEANING & CHECK

- ⊙ **Before carrying out maintenance operations, adjustments or to demount any machine member turn main switch to 0 , lock it then indicate this with a sign.**

The general cleaning ensure the long life of the machine and is an important safety factor.

Using aspirator to clean the machine

- Eliminate dust and chips from the table and all cavities
- Weekly clean all moving parts in particular the elements exposed to the dust and to the resin by using a brush or cloth with safe solvent.
- Carefully clean : guides of crosscut fence , slideways of the sliding table , rod of the fence , and groove by safe solvent.

### ⊙ CHECK OF SAFETY DEVICES

For safe usage of the machine, the safety devices shall be efficient.

Check the controls for emergency stops every 2 weeks with a test :

With the machine under normal operating condition, press the emergency button arranged on the machine : the saw blade shall stop.

NOTE : If the belts get slack, the braking time may increase. Therefore, make sure that the belts are stretched or in good condition.

Please stop processing and contact the local agent a.s.a.p. while the machine has troubles.

### MACHINE REMOVAL - STORING

Disconnect the machine from the electrical and pneumatic system. After totally clean the machine, wipe antirust protection on it, and preventing the machine in environments.



## 5-2. PERIODICAL LUBRICATION

An accurate lubrication ensures the long life as well as the best performance of the machine.

Weekly lubricate with grease

\* Disconnect the electrical and pneumatic system.

WormsB(fig 5-2.1) and toothed sector A(fig 5-2.2) for height adjusting and tilting of the saw blade



fig 5-2.1

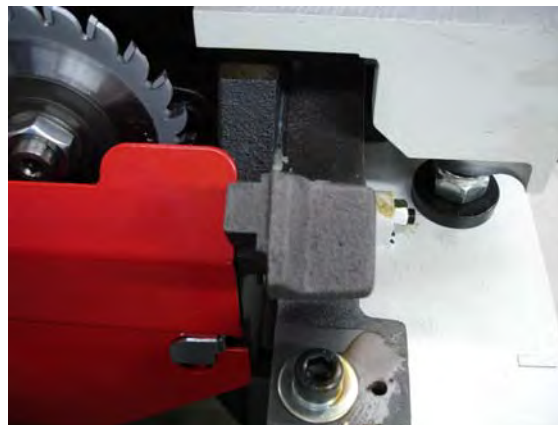


fig 5-2.2

## 5 - 3. REPLACING BELT

**Disconnect the machine from the electrical and pneumatic system**

### **REPLACING THE SCORER SPINDLE BELT**

- Take off the rear door
- Lift the small motor A(fig 5-3.1) and support it. The belt is slack and can be replaced
- Replace the new belt and lower the motor
- Manually make the belt cover 2 or 3 complete turns , so that it can get the right settling.
- Fit the rear cover again

The belt remains always stretched by the motor weight.

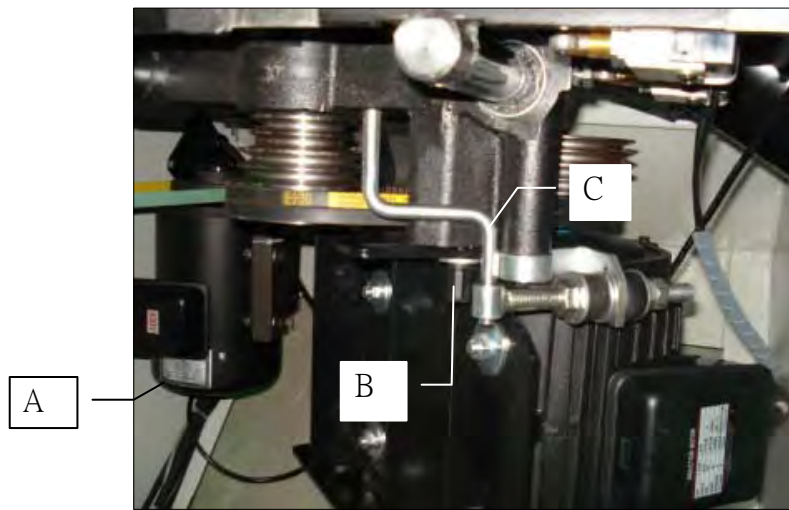


fig 5-3.

### **REPLACING THE SAW SPINDLE BELTS**

- Set the saw unit down.
- Open rear door
- Loosen knob B(fig 5-3.1)
- Lift lever C(fig 5-3.1) of belt stretcher to the end of stroke, then tighten knob A(fig 5-3.1).

The belts are slack and can be replaced.

- Set the belts in the proper races
- Move lever C(fig 5-3.1) of belt stretcher to initial position ( that is totally down ) to stretch the belts
- Tighten knob A(fig 5-3.1), and close the rear door

NOTE : Never couple belts of different make , and set. Replace the pair of belts instead of only one belt is necessary.

### **BELT STRETCHING**

⊙After the first working period, or after many working hours, the belts get slack. It will increase the time required to stop the saw blade. So periodically check this part is necessary.

## 6. TOOLS

### TOOLS INVENTORY

- Tool Box
- Riving Knife  $\Phi 300\sim 350$
- Open spanner 24~27,30mm
- Arbor Set
- Push Stick & Supporting Pad

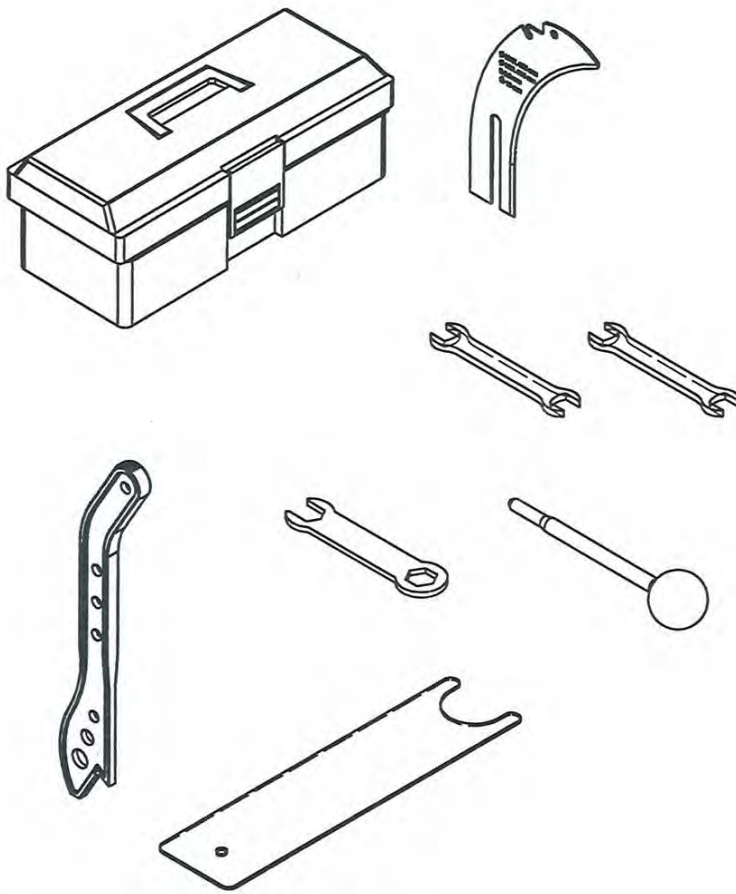


fig 6-1.2

## 7-1. Troubleshooting

**WARNING-Disconnect the machine from the power source. For preventing serious personal injury, the professional technician turn off power before troubleshooting.**

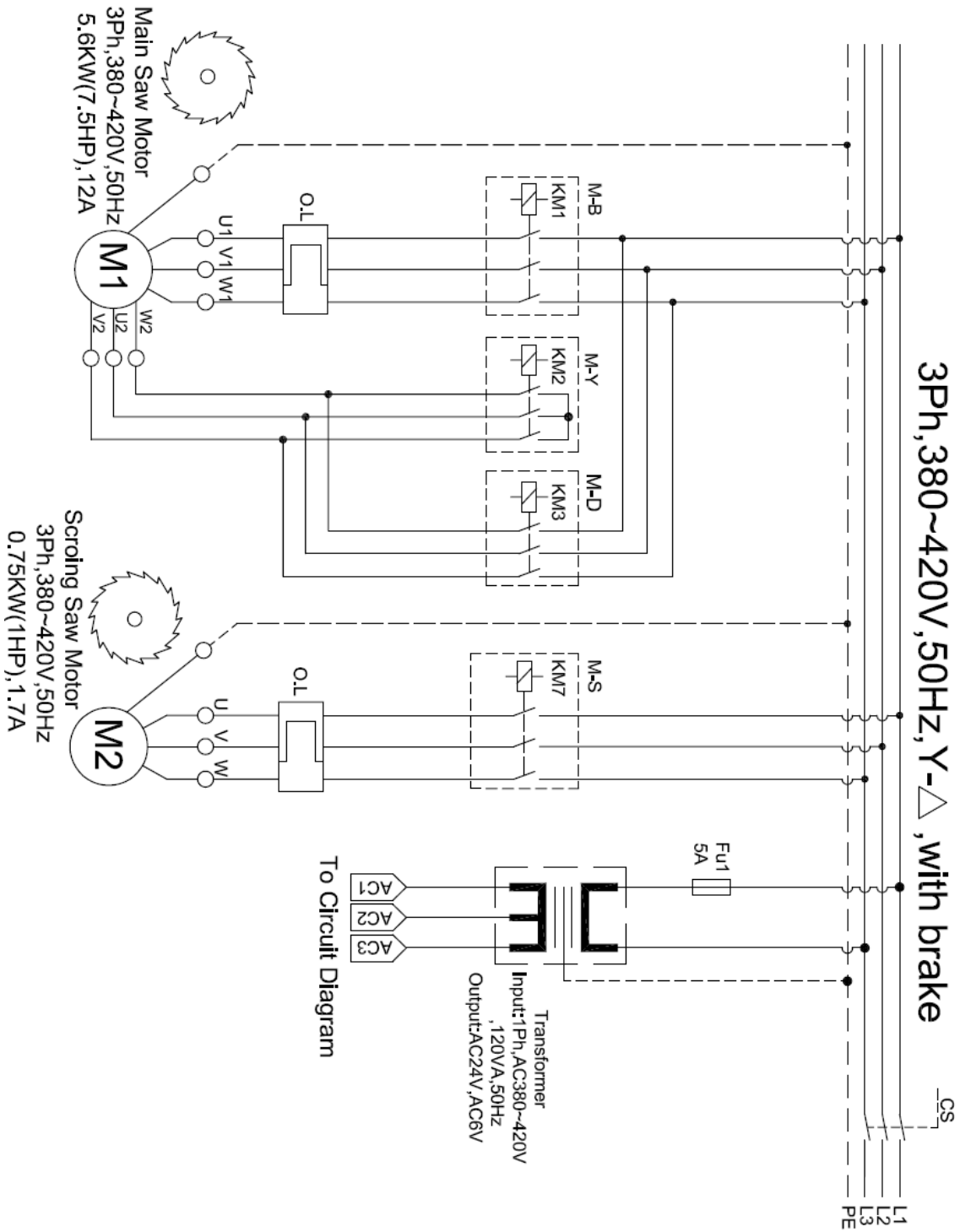
Problem	Possible cause	Troubleshooting
The machine cannot be switched on.	<ol style="list-style-type: none"> <li>1. Door in machine frame or saw blades cover plate is opened.</li> <li>2. Control circuit fuses defective.</li> </ol>	<ol style="list-style-type: none"> <li>1. Close the machine door or cover plate.</li> <li>2. Turn off the main switch, open the switch cabinet and identify which of the fuses is defective and remove it. Replace new fuses, only using fuses of the same rating!</li> </ol>
The machine switches off automatically during operation.	<ol style="list-style-type: none"> <li>1. Power failure in one or several phases due to responding factory fuses.</li> <li>2. Overload protection has responded due to blunt saw or excessive feed speed.</li> <li>3. Control circuit fuses defective.</li> </ol>	<ol style="list-style-type: none"> <li>1. Eliminate cause of phase failure.</li> <li>2. Change saw blade or reduce feed speed. Allow motor to cool down.</li> <li>3. Turn off the main switch, open the switch cabinet and identify which of the fuses is defective and remove it. Replace new fuses, only using fuses of the same rating!</li> </ol>
Motor will not start, or it growls on start up.	<ol style="list-style-type: none"> <li>1. Emergency stop button is depressed.</li> <li>2. Power supply fuse or circuit breaker has tripped.</li> <li>3. Thermal overload has tripped.</li> <li>4. Toggle switch is broken inside.</li> <li>5. Start capacitor is at fault.</li> <li>6. Motor fan cover is dented, stopping the fan from being able to spin.</li> <li>7. Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Rotate the button clockwise and allow it to pop out.</li> <li>2. Disconnect power, and inspect circuit for electrical shorts and repair. Replace circuit breaker if it is old or has tripped many times.</li> <li>3. Reset the thermal overload.</li> <li>4. Disconnect power, and use an ohmmeter to check switch terminals for continuity, and replace switch if required.</li> <li>5. Replace start capacitor.</li> <li>6. Replace motor fan cover (and fan, if damaged).</li> <li>7. Replace motor.</li> </ol>
Motor fails to develop full power (output of motor decreases rapidly with decrease in voltage at motor terminals).	<ol style="list-style-type: none"> <li>1. Power line overloaded with lights, appliances, and other motors.</li> <li>2. Undersized wires or circuits too long.</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce load on power line.</li> <li>2. Increase wire sizes or reduce length of the circuit.</li> </ol>

<b>Problem</b>	<b>Possible cause</b>	<b>Troubleshooting</b>
Motor overheats.	1. Motor overloaded. 2. Air circulation through the motor restricted.	1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded.	1. Repair loose or shorted terminals, or worn insulation on motor. 2. Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Main blade runs backwards.	1. Two of the power wires are reversed.	1. Exchange wires L1 & L3 in the terminal box.
Blade makes a squealing noise on start-up.	1. Belt worn out.	1. Replace belt .
Workpiece jammed when feeding forward.	1. Blunt saw blade. 2. Riving knife thickness does not match the saw blade used.	1. Fit a sharp saw blade 2. Fit the correct riving knife; it must be thicker than the main saw blade (or at least the same)
The finished size of the cut workpiece does not match the cutting width set on the rip fence.	1. Dimension scale for cutting widths is misadjusted. 2. Incorrect scale position.	1. Reset the dimension scale to correct size. 2. Reset scale position. Cut a workpiece on the rip fence, precisely measure the cut width and position the scale to match workpiece size.
The finished size of the cut workpiece does not match the cutting width set on the crosscut stop.	1. Dimension scale for cutting widths is misadjusted. 2. Incorrect fence position.	1. Reset the flip stop to correct size. 2. Cut a workpiece on the crosscut fence, precisely measure the cut width and reset crosscut fence position to match workpiece size.
Sliding table saw does not cut square.	1. Sliding table is not parallel to blade. 2. Rip fence is not parallel to blade. 3. Crosscut fence is not perpendicular to the blade.	1. Adjust the sliding table . 2. Adjust the rip fence . 3. Adjust the crosscut fence perpendicular to the blade .
Saw blade burns on the sliding table side.	1. Insufficient free cut on sliding table.	1. Readjust the free cut.
Saw blade burns on the rip fence side.	1. Excessive free cut on the rip fence. 2. Insufficient free cut on rip fence.	1. Readjust the rip fence. 2. Readjust the free cut.

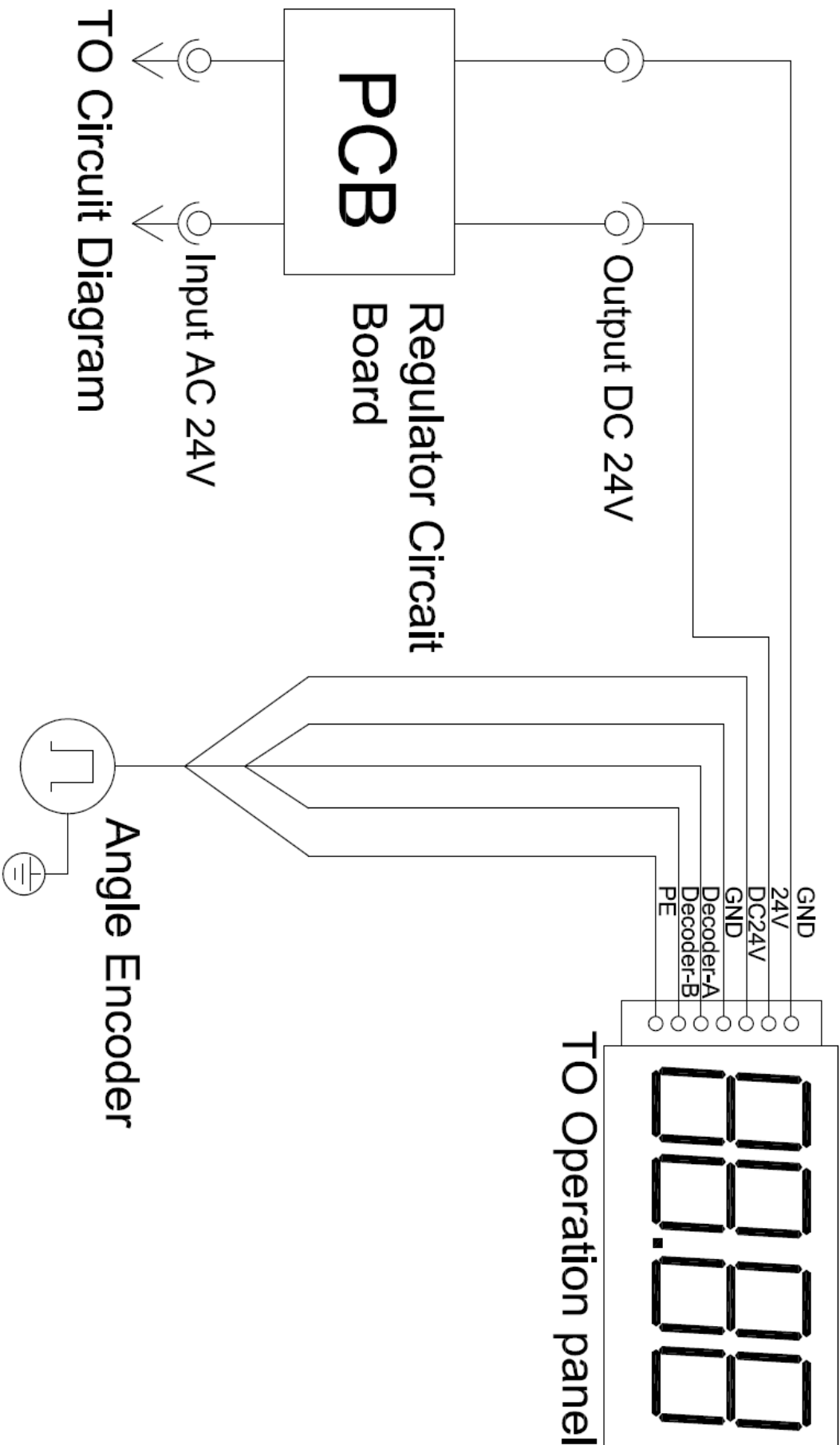
<b>Problem</b>	<b>Possible cause</b>	<b>Troubleshooting</b>
Saw blade burns on both sides.	<ol style="list-style-type: none"> <li>1. Incorrect free cut setting.</li> <li>2. Cut material jammed.</li> <li>3. Operating error.</li> </ol>	<ol style="list-style-type: none"> <li>1. Readjust the free cut</li> <li>2. Insert a riving knife in the cutting line or use a wider riving knife</li> <li>3. Either move the workpiece to the left- or right-hand stop. Do not guide the workpiece on the rip fence when cutting with the sliding table</li> </ol>
Workpiece has burn marks.	<ol style="list-style-type: none"> <li>1. Blunt saw blade.</li> <li>2. Feed too low.</li> <li>3. Saw blade has too many teeth.</li> <li>4. Incorrect free cut.</li> </ol>	<ol style="list-style-type: none"> <li>1. Change the saw blade.</li> <li>2. Increase the feed rate.</li> <li>3. Change the saw blade.</li> <li>4. Readjust the free cut.</li> </ol>
Workpiece has burned edges, binds, or kicks back.	<ol style="list-style-type: none"> <li>1. Sliding table is not parallel to blade.</li> <li>2. Riving knife is not aligned with the blade.</li> <li>3. Blade is warped.</li> </ol>	<ol style="list-style-type: none"> <li>1. Make sliding table parallel to the blade .</li> <li>2. Shim the riving knife to align it with the main blade.</li> <li>3. Replace the blade.</li> </ol>
Workpiece has chip out on the bottom edge.	<ol style="list-style-type: none"> <li>1. Scoring blade height is incorrect.</li> <li>2. Scoring blade is not aligned with the main blade.</li> <li>3. Scoring blade kerf does not match the main blade.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust the height of the scoring blade.</li> <li>2. Align the scoring blade.</li> <li>3. Adjust the scoring blade kerf .</li> </ol>
Breakout in spite of scoring.	<ol style="list-style-type: none"> <li>1. Scoring not aligned with main saw blade.</li> <li>2. Scoring blade too narrow.</li> </ol>	<ol style="list-style-type: none"> <li>1. Readjust free cuts; the free cut should be almost "0".</li> <li>2. Adjust saw width.</li> </ol>
Workpiece rises when cut with the scoring.	<ol style="list-style-type: none"> <li>1. Blunt scoring blade .</li> <li>2. Cutting height too low .</li> </ol>	<ol style="list-style-type: none"> <li>1. Exchange the sawing blade.</li> <li>2. Set the scoring blade higher.</li> </ol>
Loud repetitious noise coming from machine.	<ol style="list-style-type: none"> <li>1. Pulley setscrews or keys are missing or loose.</li> <li>2. Motor fan is hitting the cover.</li> <li>3. Belts are defective or damaged.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect keys and setscrews. Replace or tighten if necessary.</li> <li>2. Adjust fan cover mounting position, tighten fan, or shim fan cover.</li> <li>3. Replace belts.</li> </ol>
Vibration when running or cut-ting.	<ol style="list-style-type: none"> <li>1. Loose or damaged blade.</li> <li>2. Worn arbor bearings.</li> <li>3. Worn or damaged belts.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten or replace blade.</li> <li>2. Check/replace arbor bearings.</li> <li>3. Replace belts.</li> </ol>
Fence hits table top when sliding across table.	<ol style="list-style-type: none"> <li>1. Front rail is too low.</li> <li>2. Rip fence roller is too low.</li> </ol>	<ol style="list-style-type: none"> <li>1. Raise the rail.</li> <li>2. Adjust the roller.</li> </ol>

# The main control circuit

3Ph, 380~420V, 50Hz, Y- $\Delta$ , with brake



# Angle Encoder circuit diagram

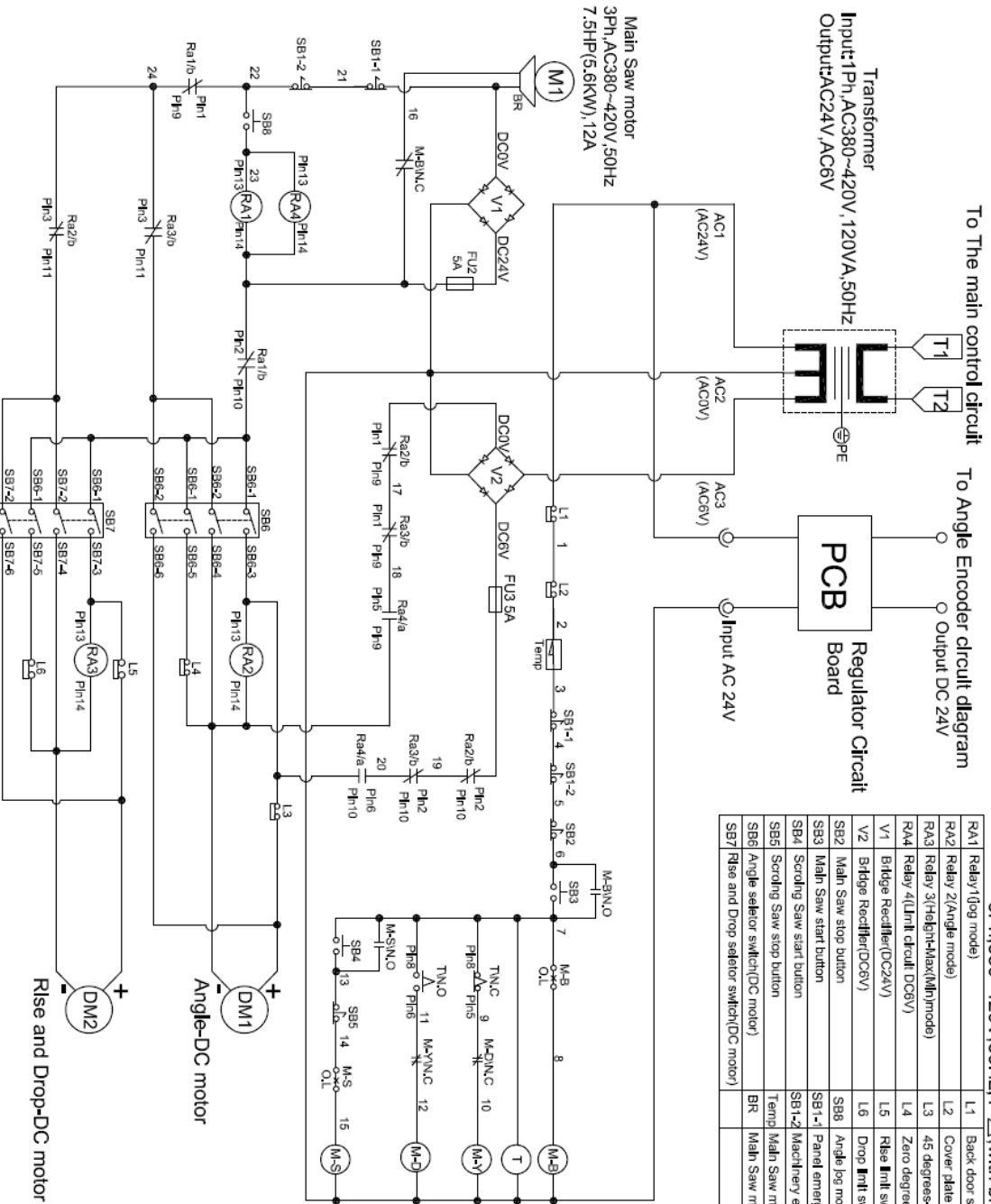


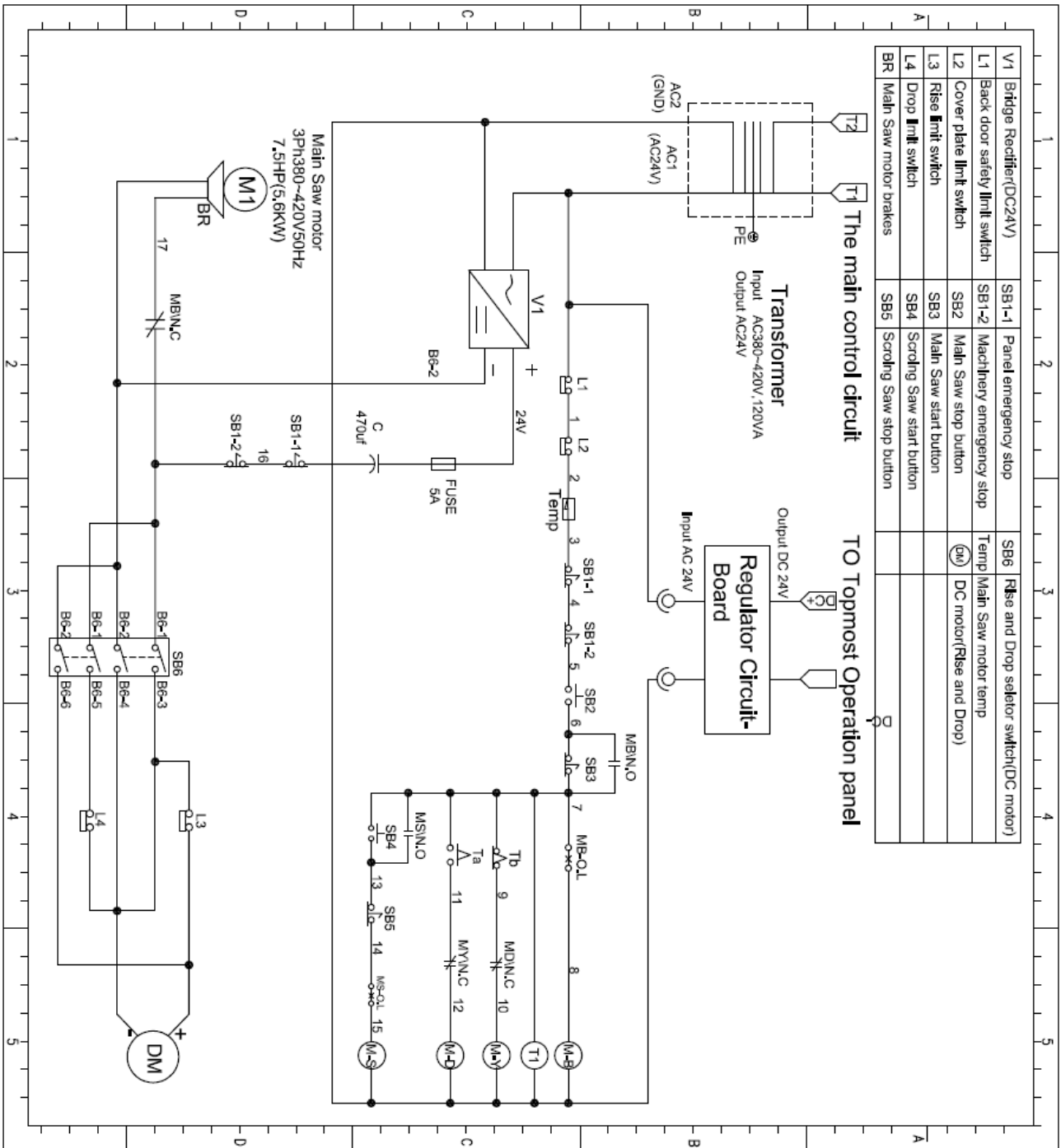
TO Circuit Diagram

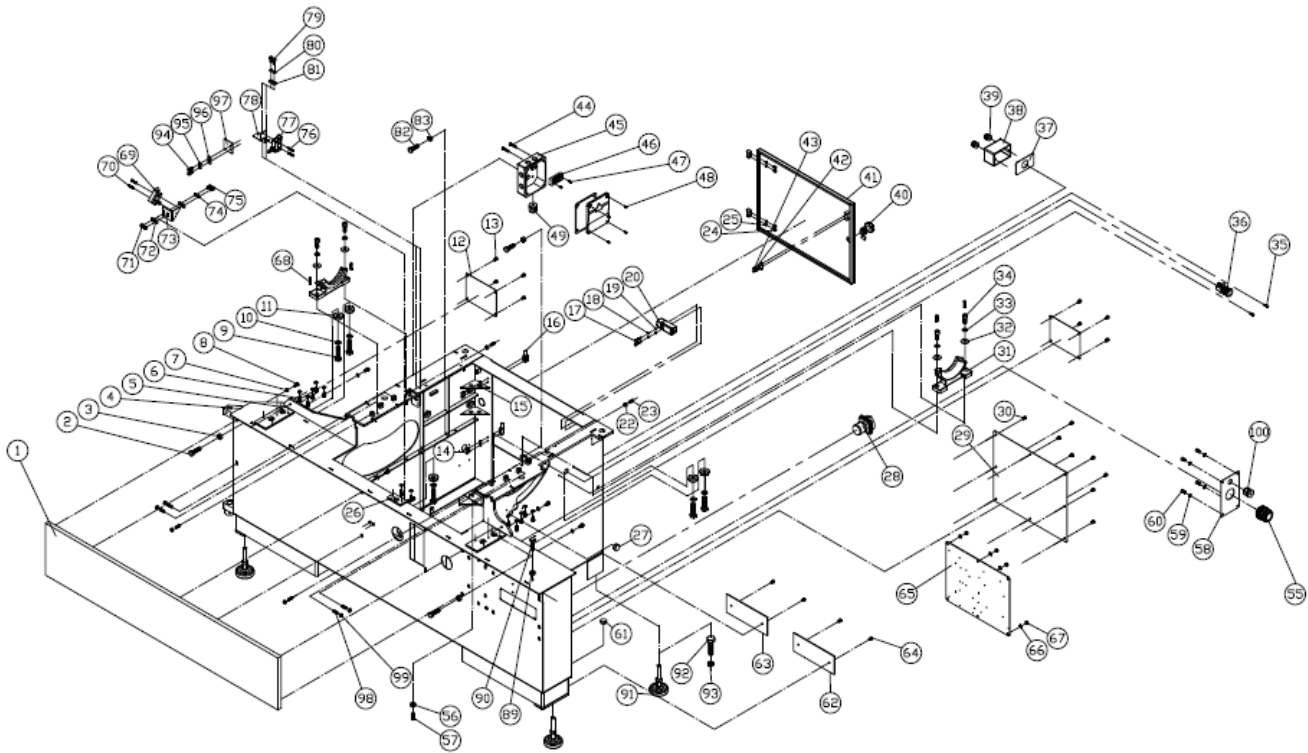
TO Operation panel



### Circuit Diagram



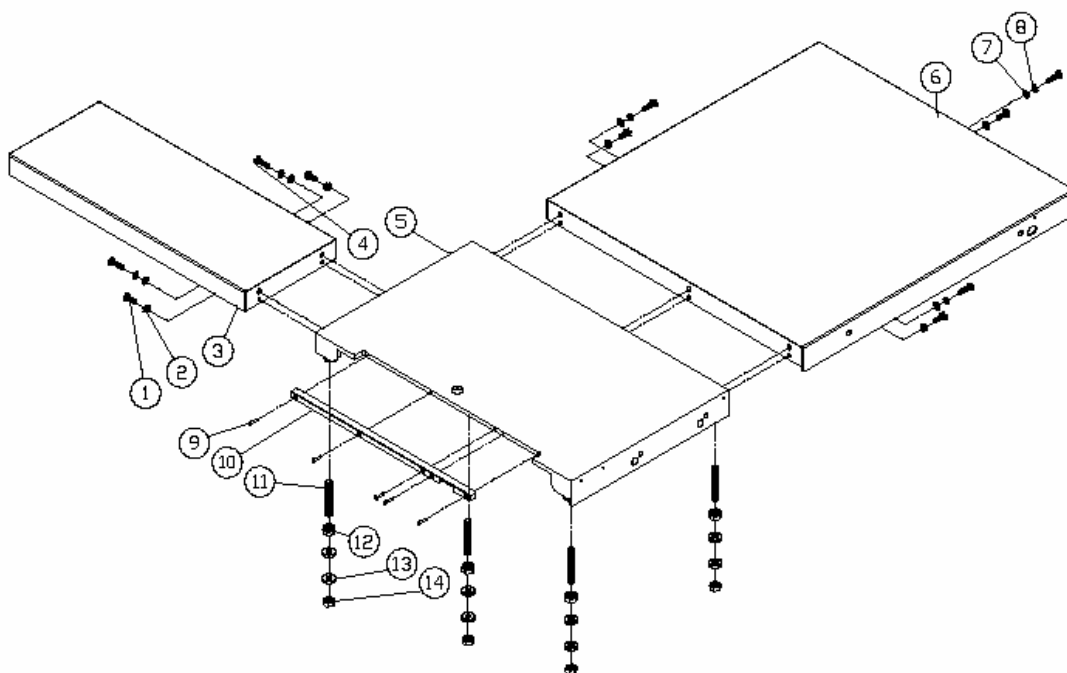




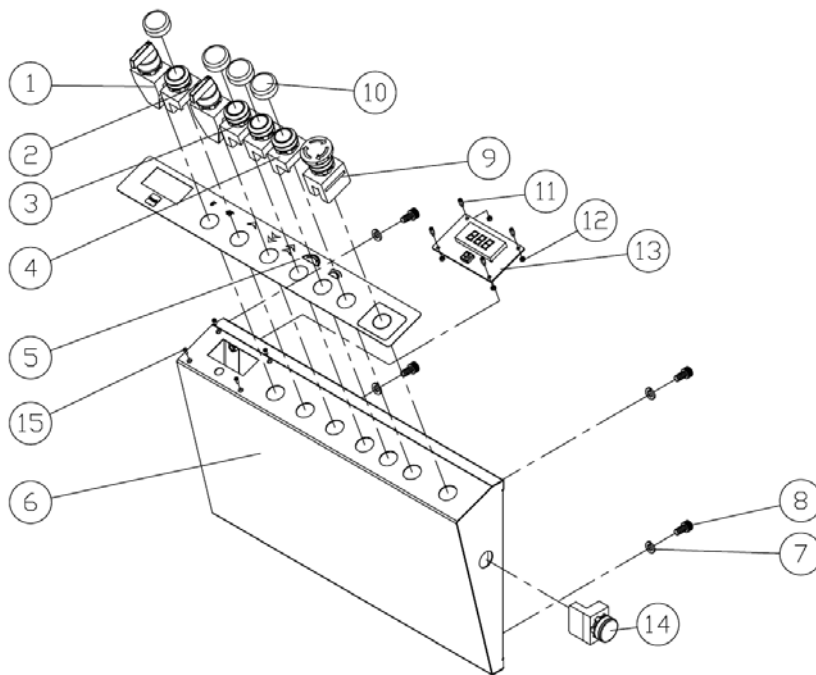
ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
1	207445	Plate		1	GK/ D405A
	207820	Plate		1	GK/ D405A3
2	SH100800	Hex Head Bolt	M10*40	2	
3	NH101700	Hex Nut	M10	2	
4	207835	Machine frame		1	R/D405A/A3
5	205200-27	Plate		2	R
6	SR069300	Cap Screw	M6*12	12	
7	WS060000	Lock Washer	M6	18	
8	SR069400	Cap Screw	M6*16	6	
9	SH121000	Hex Head Bolt	M12*50	5	
10	WS120000	Lock Washer	M12	5	
11	203410	Ring		5	
12	207128	Plate		2	R
13	SJ069300	Button Head Screw	M6*12	8	
14	SR059300	Cap Screw	M5*12	4	
15	WS050000	Lock Washer	M5	4	
16	203412	Block		2	
17	SR040600	Cap Screw	M4*30	2	
18	WS040000	Lock Washer	M4	2	
19	WF040808	Washer	M4* $\psi$ 8	2	
20	136457	Door Safety Switch	AZD-S11	1	

ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
22	NH081300	Hex Nut	M8	2	
23	SS080700	Set Screw	M8*35	2	
24	SR059200	Cap Screw	M5*8	4	
25	WS050000	Lock Washer	M5	4	
26	205200-28	Plate		1	R
27	201458	Hole Plugs	HP-22	6	
*28	994809	Power Switch	ZH-HD-2	1	
29	207129	Operate Housing Cover		1	R
30	SJ060200	Button Head Screw	M6*10	8	
31	207540	Base		2	X2
32	WF102830	Washer	M10* $\Psi$ 28	4	
33	WS100000	Lock Washer	M10	4	
34	SR100700	Cap Screw	M10*35	4	
35	ST050400	Tap Screw	M5*20	2	
36	994817	Emergency Stop Button	R2 PNR4-2B-R	1	
	994819	Emergency Stop Button	R2 PNR4-3B-R	1	A3
37	150956	Pad		1	
38	605408	Switch Box		1	
39	998621	Strain Relief		2	
40	203430	Lock		1	
41	205259	Door		1	R
42	WS040000	Lock Washer	M4	2	
43	SP049300	Pan Head Screw	M4*12	2	
44	SJ060400	Button Head Screw	M6*20	2	
45	201105	Power Box	CE端子台	1	CE
	201105A	Power Box	無端子台	1	CSA
46	994805	Terminal	PB2504 4P	0	CE
	994805	Terminal	PB2504 4P	1	CSA
47	SP059200	Pan Head Screw	M5*8	2	
48	SJ059300	Button Head Screw	M5*12	4	
49	709421	Strain Relief	M20	2	
*55	207749	Strain Relief	MGB50-39B	1	
56	NH101700	Hex Nut	M10	1	
57	207268	Set Screw	M10*50	1	
*58	207748	Plate		1	T
59	WS060000	Lock Washer	M6	4	
60	SR069300	Cap Screw	M6*12	4	
61	201458	Hole Plugs	HP-22	1	
62	207299-32	Plate		1	R
63	207309-33	Plate		1	R
64	SJ069300	Button Head Screw	M6*12	4	

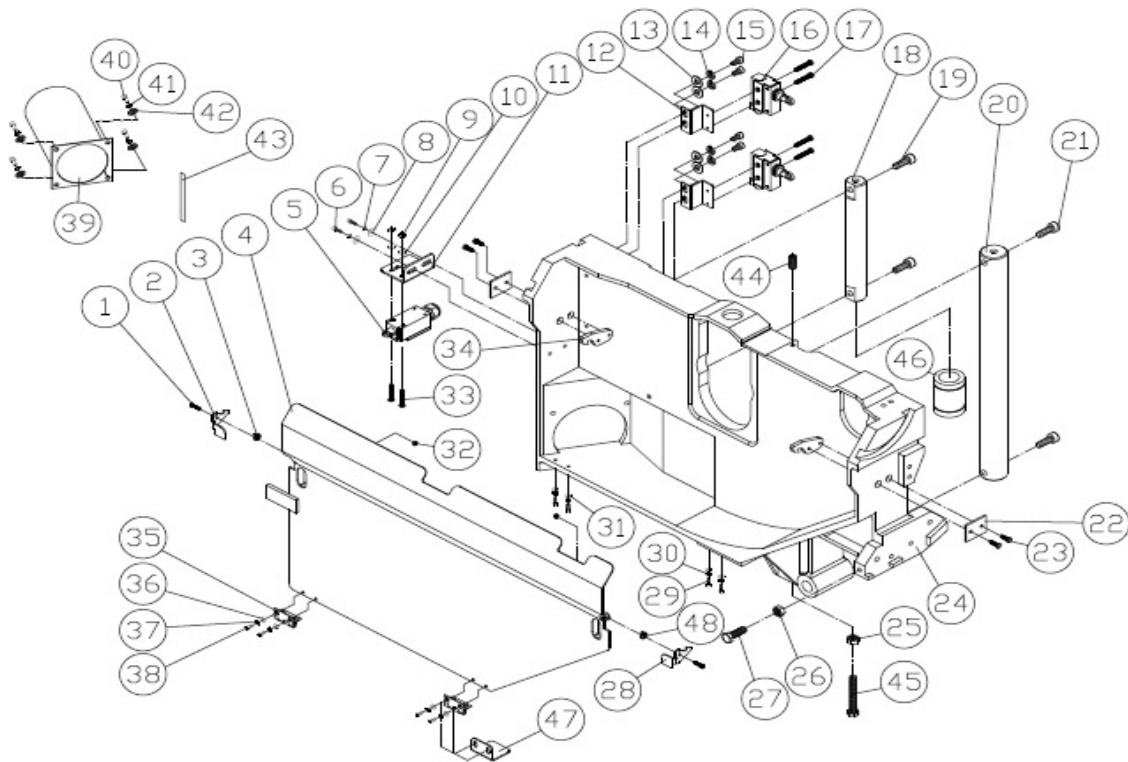
ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
*65	207723	Plate		1	S,SPEED 2
	207149	Plate		1	S,SPEED 2
66	WS060000	Lock Washer	M6	4	
67	NH061000	Hex Nut	M6	4	R
68	PS062500	Spring Pin	ψ 6*25	4	R
69	205397A	Door Safety Switch	AZ7311	1	
70	SP040600	Pan Head Screw	M4*30	2	
71	NH061000	Hex Nut	M6	2	
72	WF061620	Washer	M6*ψ 16	4	
73	207752	Plate		1	
74	WS060000	Lock Washer	M6	2	
75	SR069400	Cap Screw	M6*16	2	
76	SP040600	Pan Head Screw	M4*30	2	
77	205397A	Door Safety Switch	AZ7311	1	
78	207751	Plate		1	
79	SR069400	Cap Screw	M6*16	2	
80	WS060000	Lock Washer	M6	2	
81	WF061620	Washer	M6*ψ 16	2	
82	SH100700	Hex Head Bolt	M10*35	2	
83	NH101700	Hex Nut	M10	2	
89	NH101700	Hex Nut	M10	1	
90	SH100800	Hex Head Bolt	M10*40	1	
91	201150	Adjust Foot	M16x100	4	S
92	SH161100	Hex Head Bolt	M16x50	4	S
93	NH162400	Hex Nut	M16	4	S
94	SR069400	Cap Screw	M6*16	2	
95	WS060000	Lock Washer	M6	2	
96	WF061620	Washer	M6*ψ 16	2	
97	207756	Plate		1	
98	SS080500	Set Screw	M8*25	6	
99	NH081300	Hex Nut	M8	6	
*100	709421	<b>Strain Relief</b>	M20	1	



ITEM	PART NO	PARTS NAME	SIZE	Q`TY	NOTE
1	SH100500	Hex Head Bolt	M10*25	5	
2	NH101700	Hex Nut	M10	5	
3	207077	Left Ext. Plate	(Standard small one)	1	R
	207151	Left Ext. Plate	(Standard big one)	1	R / S
4	SH100500	Hex Head Bolt	M10*25	5	
5	207006	Table		1	R
6	207078	Ext. Plate	(Standard big one)	1	R
	207079	Ext. Plate	(Standard small one)	1	R / S
7	WF102030	Washer	M10* $\psi$ 20	5	
8	WS100000	Lock Washer	M10	5	
9	205093	Sunk Head Screw	M6*30 Cooper	5	
10	205444	Table Insert		1	
	207283	Table Insert	(Alloy)	1	S
11	SS162000	Set Screw	M16*100	4	
12	NL162400	Lock Nut	M16	4	
13	205016	Washer		8	
14	NH162400	Hex Nut	M16	4	



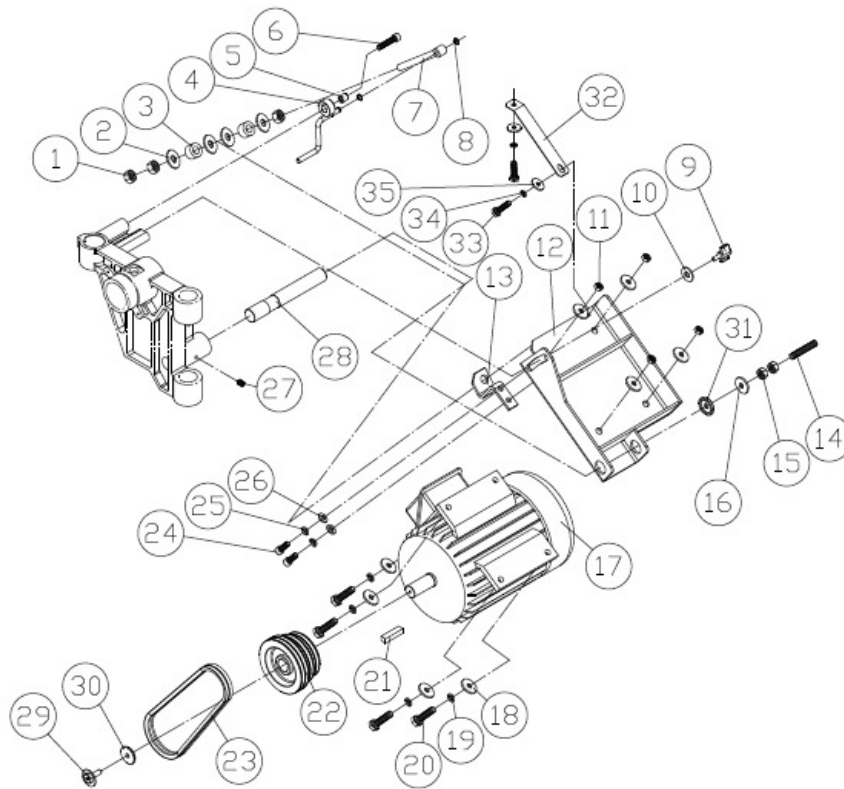
ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	205240	Switch Button Cut Out		2	
2	994993	Switch Button	R2 PNF-1A-W	1	
3	994855	Switch Button-ON	R2 PNF-1A-G	2	
4	994856	Switch Button-OFF	R2 PNF-1B-R	1	
5	207738	Label		1	
6	207671	Plate		1	GK
7	WS060000	Lock Washer	M6	4	
8	SR069400	Cap Screw	M6*16	4	
9	994817	Emergency Stop Button	R2 PNR4-2B-R	1	
10	994855A	Dust Cove	R2 PRCF	4	
11	201736	Rod		4	
12	NH030600	Hex Nut	M3	4	
13	207653	IC Board		1	
14	996002	Pilot Lamp	YK.24V $\varnothing$ 22 (W)	1	
15	SI039100	Counter Sunk Screw	M3*6	4	



ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
1	SR040600	Cap Screw	M4*30	2	
2	207055	Hook(L)		1	
3	207057	Spring		1	
4	207061	Cover		1	F1L
5	136012	Door Safety Switch		1	
6	SR060200	Cap Screw	M6*10	2	
7	WS060000	Lock Washer	M6	2	
8	WF061310	Washer	M6* $\phi$ 13	2	
9	NH040700	Hex Nut	M4	2	
10	WF040805	Washer	M4* $\phi$ 8	2	
11	200853	Fix Plate		1	
12	205477	Plate		2	
13	WF061310	Washer	M6* $\phi$ 13	4	
14	WS060000	Lock Washer	M6	4	
15	SR069300	Cap Screw	M6*12	4	
16	205397A	Door Safety Switch	AZ7311	2	
17	SP040600	Pan Head Screw	M4*30	4	
18	207005	Shaft		1	
19	SR080700	Cap Screw	M8*35	2	
20	207004	Shaft		1	

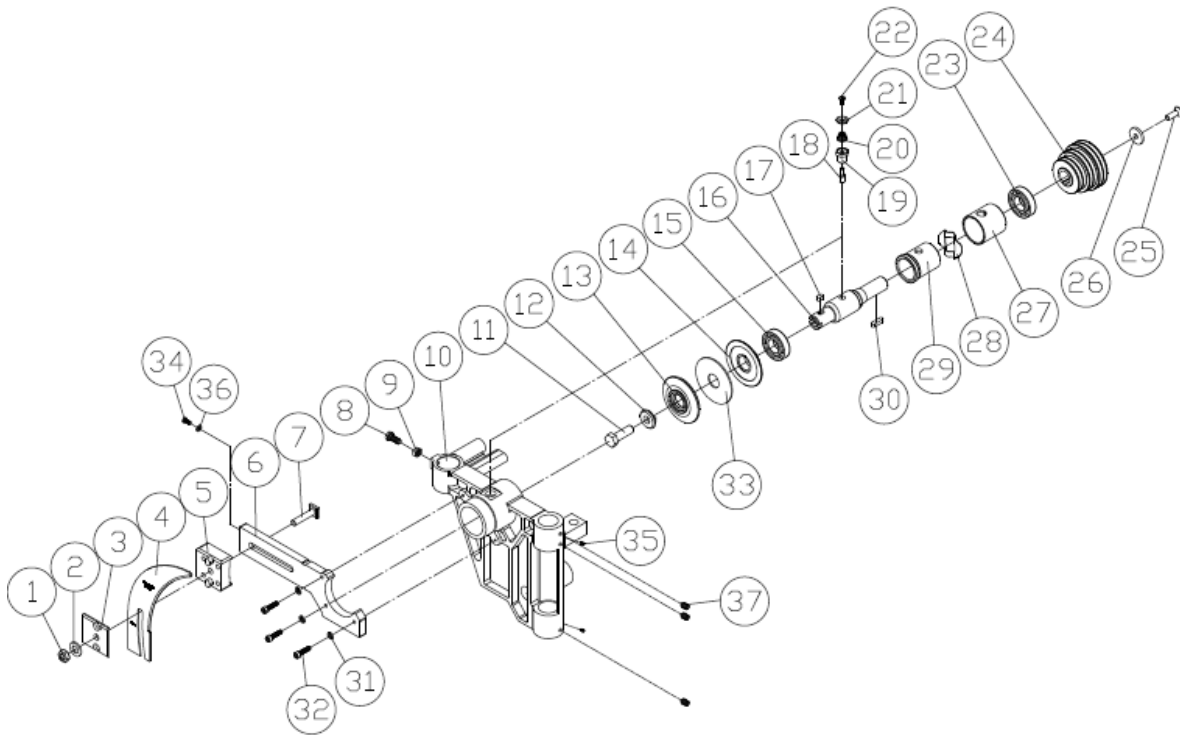


ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
21	SR080900	Cap Screw	M8*45	2	
22	207071	Plate		2	
23	SH060400	Hex Head Bolt	M6*20	4	
24	207001	Channel Base		1	
25	NH081300	Hex Nut	M8	1	
26	NH081300	Hex Nut	M8	1	
27	SH080500	Hex Head Bolt	M8*25	1	
28	207056	Hook(R)		1	
29	SR050200	Cap Screw	M5*10	4	
30	WS050000	Lock Washer	M5	4	
31	WF051010	Washer	M5*10	4	
32	NL040700	Lock Nut	M4	2	
33	SP040700	Pan Head Plate	M4*35	2	
34	207066	Hook		2	
35	010333	Hinge		2	
36	WF051010	Washer	M5*10	4	
37	WS050000	Lock Washer	M5	4	
38	SR059200	Cap Screw	M5*8	4	
39	207132	Dust Port		1	
40	SR089400	Cap Screw	M8x16	4	
41	WS080000	Lock Washer	M8	4	
42	WF081818	Washer	M8x18	4	
43	150527	Sponge		2	
44	SS080400	Setscrew	M8*20	1	
45	SH081000	Hex Head Bolt	M8*50	1	
46	BL450602	Bearing	LM30UU	1	
47	207152	Plate		1	
48	207057A	Spring		1	



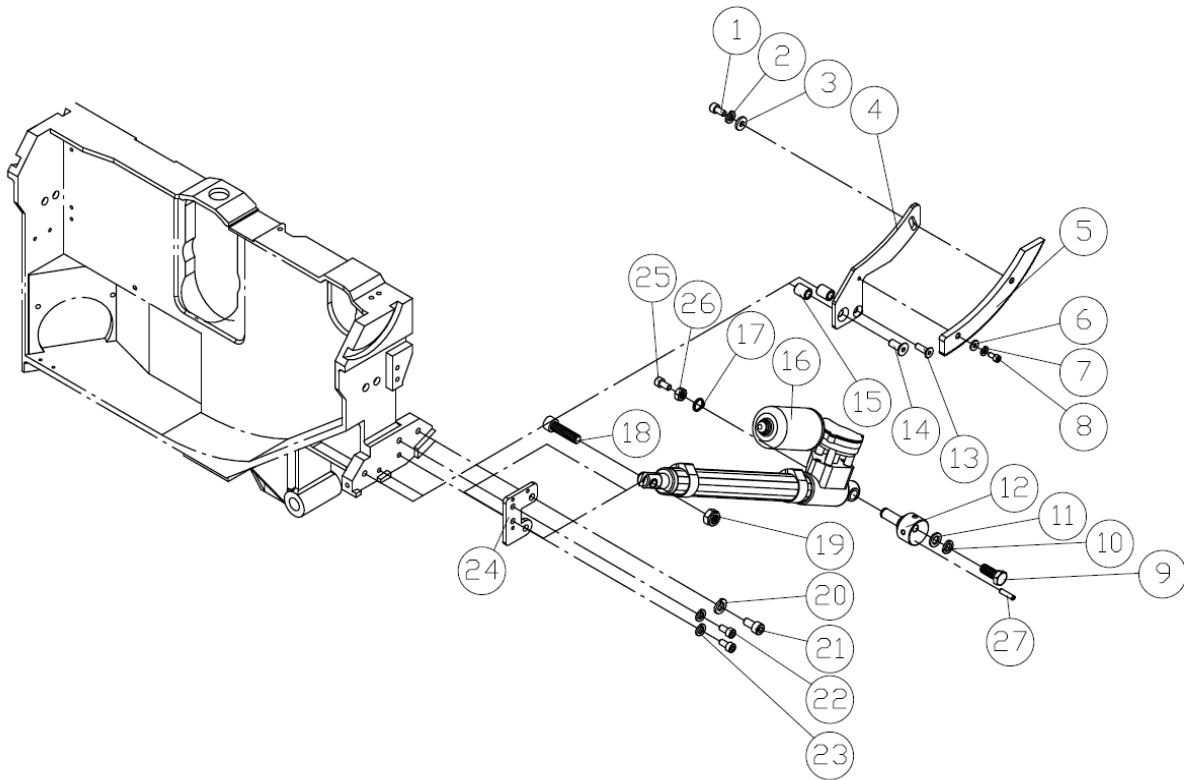
ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
1	NH142200	Hex Nut	M14	3	
2	WF143030	Washer	M14* $\phi$ 30	4	
3	207048	Pad		2	
4	207043	Adjusting Shaft		1	
5	200999	Bushing		1	
6	SR080700	Cap Screw	M8*35	1	
7	207046	Adjusting Screw		1	
8	RS100000	Retaining Ring	S10	2	
9	207156	Lock Knob		1	
10	WF083030	Washer	M8* $\phi$ 30	1	
11	NH101700	Hex Nut	M10	4	
12	207138A	Motor Plate		1	
13	207042	Plate		1	
14	SS101100	Set Screw	M10*55	1	
15	NH101700	Hex Nut	M10	2	
16	WF104030	Washer	M10* $\phi$ 40	1	
17	MH207003	Main Motor		1	
	MH207004	Main Motor	Y- $\Delta$ START	1	S
18	WF104030	Washer	M10* $\phi$ 40	8	
19	WS100000	Lock Washer	M10	4	
20	SH100800	Hex Head Bolt	M10*40	4	

ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
21	KS080750	Key	8*7*50	1	
22	207053	Motor Pulley	50HZ	1	X2, CE
	207110	Motor Pulley	60HZ	1	CSA
23	207130	V-Belt	3VX-315	2	CE
	207141	V-Belt	3VX-300	2	CSA
24	SR080500	Cap Screw	M8*25	2	
25	WS080000	Lock Washer	M8	2	
26	WF081818	Washer	M8* $\phi$ 18	2	
27	SS089300	Set Screw	M8*12	1	
28	207050	Shaft		1	
29	SG100400	Hex Head Cap Screw/W	M10*20	1	
30	WF104030	Washer	M10* $\phi$ 40*3t	1	
31	207153	Washer		1	
32	207188	Plate		1	F1L
33	SH089400	Hex Head Bolt	M8*16	2	
34	WS080000	Lock Washer	M8	2	
35	WF081818	Washer	M8* $\phi$ 18	2	



ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
1	NH121900	Hex Nut	M12*1.75	1	
2	WF163030	Washer	M16* $\phi$ 30	1	
3	207030			1	
4	205032	Plate	$\phi$ 350~400	1	
5	207040	Block		1	
6	207037	Bracket		1	X2
7	207031	Screw		1	
8	SH080400	Hex Head Bolt	M8*20	1	
9	NH081300	Hex Nut	M8	1	
10	207003	Bracket		1	
11	207019	Bolt	M16*2p(L)	1	
12	207012	Washer		1	
13	207014	Flange	$\phi$ 30	1	CE
	207157	Flange	$\phi$ 25.4	1	CSA
14	207013	Flange		1	
15	BB620604	Ball Bearing	6206LLB(BLACK)	1	
16	207015	Main Shaft	$\phi$ 30	1	CE
	207158	Main Shaft	$\phi$ 25.4	1	CSA
17	KD080715	Key	8*7*15	1	
18	207009	Shaft		1	
19	207010	Block		1	
20	207011	Cone Spring		1	

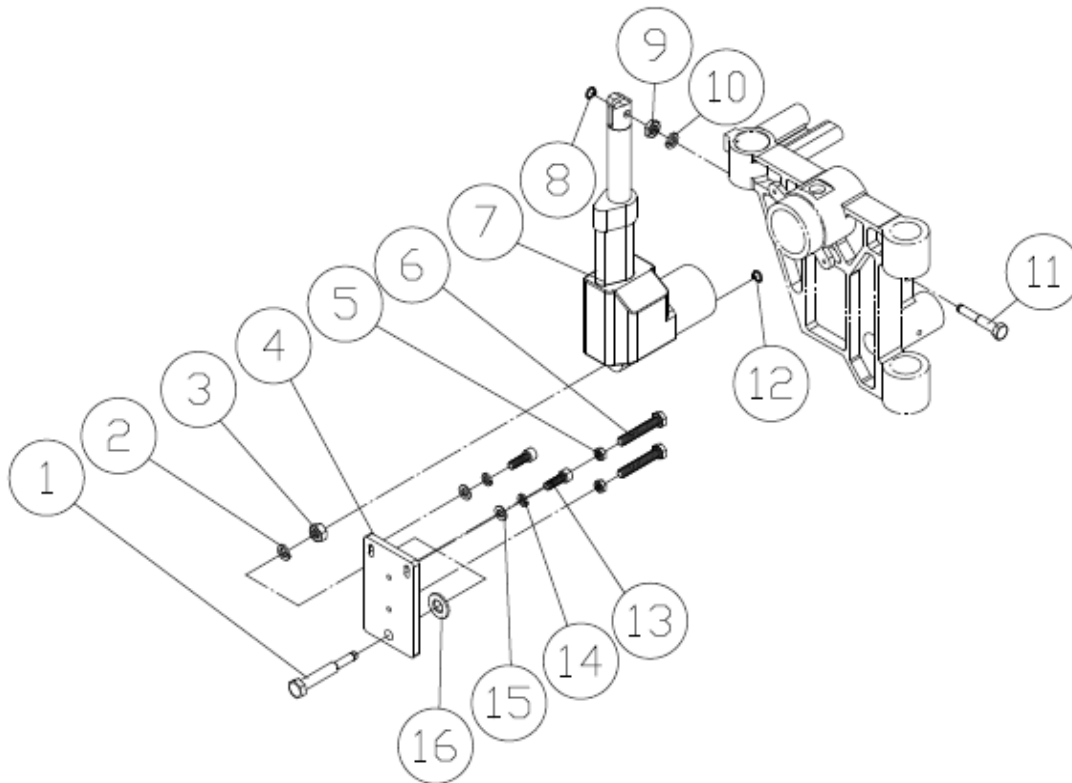
ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
21	207008	Washer		1	
22	SI059300	Counter Sunk Screw	M5*12	1	
23	BB620604	Ball Bearing	6206LLB(BLACK)	1	
24	207020	Pulley		1	X2
25	SI100500	Counter Sunk Screw	M10*25	1	
26	205035	Washer		1	
27	207016	Ring		1	
28	WW425203	Wave Washer	$\phi 42^* \phi 52 t=0.3 (6205)$	1	
29	207017	Ring		1	
30	KD080730	Key	8*7*30	1	
31	WS060000	Lock Washer	M6	3	
32	SR060500	Cap Screw	M6*25	3	
33	207144	Washer		1	FIL
34	SJ069300	Button Head Screw	M6*12	1	
35	203198	Oil Filler Point		2	
36	WF061920	Washer	M6* $\phi 19$	1	
37	205481	Screw		3	



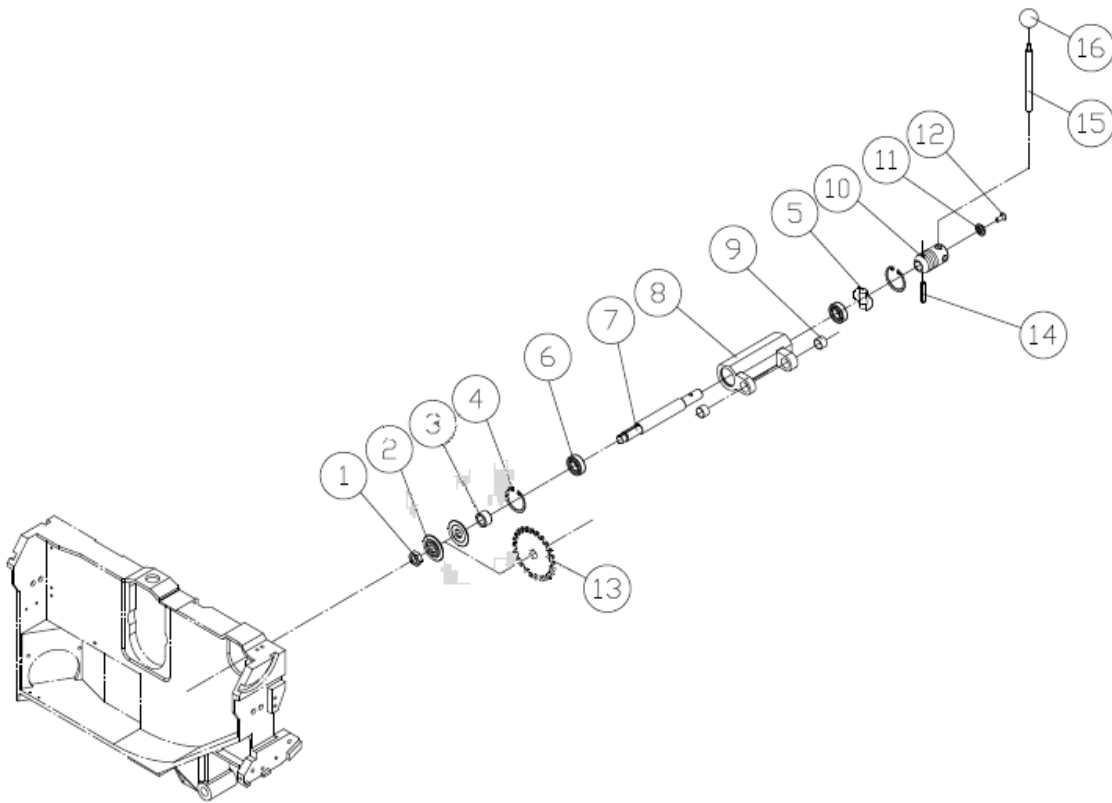
ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	SR080400	Cap Screw	M8*20	1	
2	WS080000	Lock Washer	M8	1	
3	WF081818	Lock Washer	M8x $\phi$ 18	1	
4	207656	Plate	8"	1	
5	207654	Rack	7x7x20	1	
6	WF061620	Washer	M6* $\phi$ 16	1	
7	WS060000	Lock Washer	M6	1	
8	SR060400	Cap Screw	M6*20	1	
9	SH120600	Hex Head Bolt	M12*30	1	
10	WS120000	Lock Washer	M12	1	
11	WF123025	Washer	M12* $\phi$ 30	1	
12	207485	Shaft		1	
13	SI080800	Counter Sunk Screw	M8x40	1	
14	SI100800	Counter Sunk Screw	M10x40	1	
15	207664	Bushing		2	
16	207449	Angle Driver		1	
17	RS140000	Retaining Ring	S14	1	
18	SR100800	Cap Screw	M10*40	1	
19	NL101700	Lock Nut	M10	1	
20	WS100000	Lock Washer	M10	1	

ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
21	SR100500	Cap Screw	M10*25	1	
22	SR080500	Cap Screw	M8*25	2	
23	WS080000	Lock Washer	M8	2	
24	207657	Plate		1	
25	SR080500	Cap Screw	M8*25	1	
26	NH081300	Hex Nut	M8	1	
27	PP052000	Pin	$\phi$ 5*20	1	

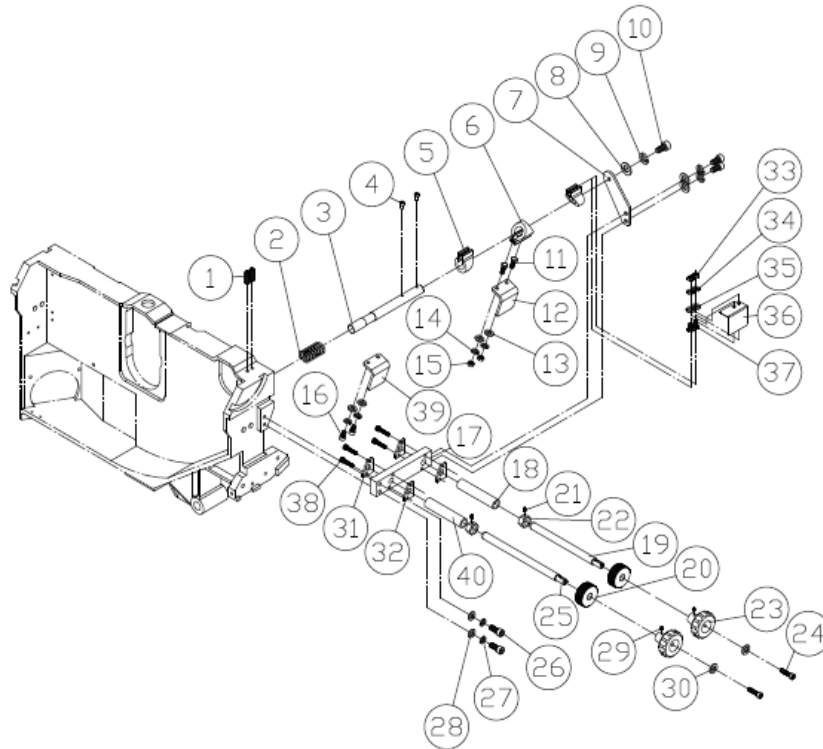




ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
1	207139	Bar		1	
2	WS140000	Lock Washer	M14	1	
3	NH142200	Hex Nut	M14	1	
4	207140	Plate		1	
5	NH081300	Hex Nut	M8	2	
6	SH081000	Hex Head Bolt	M8*50	2	
7	AB205545	Height Driver		1	A
	205545	Height Driver		1	
	205545-1	Gear		1	
	994656	Switch		1	
8	RS100000	Retaining Ring	S10	1	
9	NH121904	Hex Nut	M12	1	THIN
10	WS120000	Lock Washer	M12	1	
11	207142	Bar		1	
12	RS100000	Retaining Ring	S10	1	
13	SR080600	Cap Screw	M8*30	2	
14	WS080000	Lock Washer	M8	2	
15	WF081818	Washer	M8* $\phi$ 18	2	
16	WF143030	Washer	M14* $\phi$ 30	1	

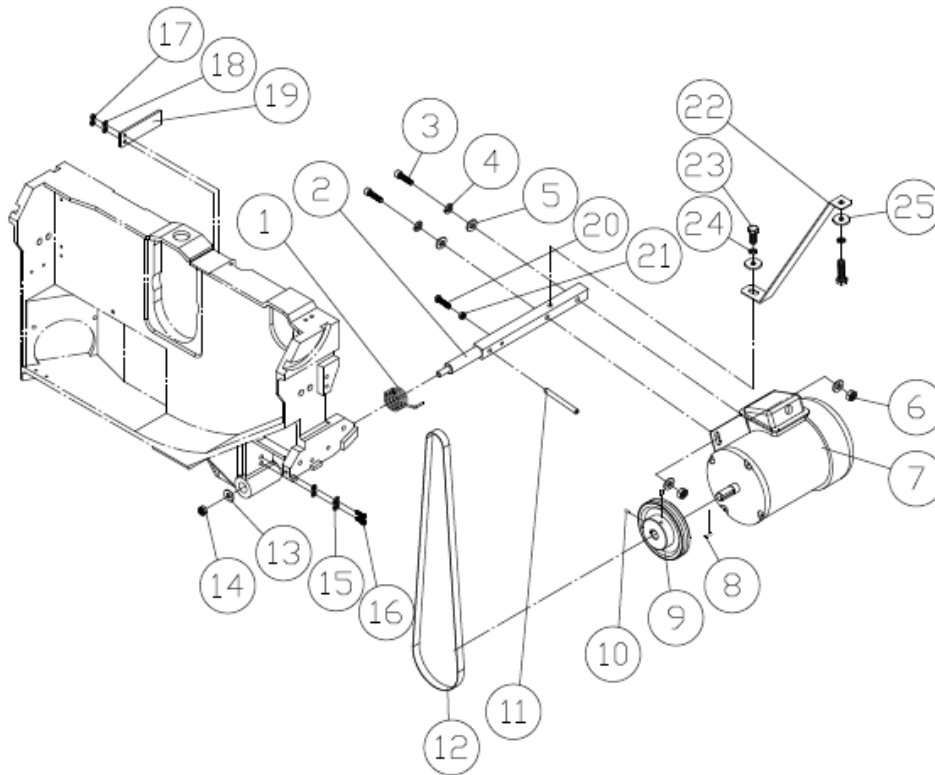


ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	207024	Hex Nut	M18*1.5p	1	
2	207025	Flange		2	
3	207027	Bushing		1	
4	RR420000	Int. Retaining Ring	R42	2	
5	WW304003	Wave Washer	$\phi 30.1 * \phi 40.6 t=0.3 (6302)$	2	
6	BB600404	Ball Bearing	6004LLB(BLACK)	2	
7	207233	Shaft		1	
8	207022	Bracket		1	
9	994352	Bushing Bearing	DU2015	2	
10	207232	Pulley		1	
11	203035	Washer		1	
12	SI080500	Counter Sunk Screw	M8*25	1	
13	200973	Scoring Saw Blade	$\phi 20$	1	
14	PS064000	Spring Pin	$\phi 6*40$	1	
15	205088	Rod		1	
16	100271	Ball Knob	M8*1.25P	1	



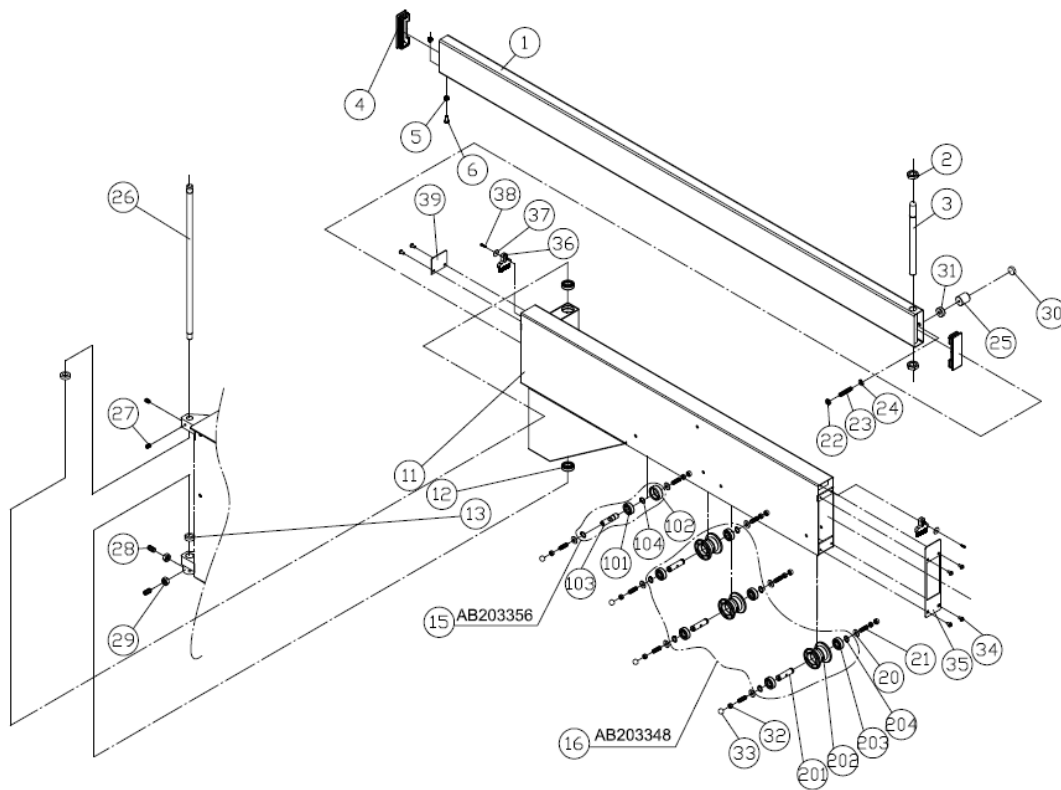
ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	SS080400	Setscrew	M8x20	2	
2	207041	Spring		1	
3	207032	Shaft		1	
4	SR060200	Cap Screw	M6*10	2	
5	207033	Ring		2	
6	207034	Ring		1	
7	207045	Plate		1	
8	WF081818	Washer	M8* $\phi$ 18	3	
9	WS080000	Lock Washer	M8	3	
10	SR089400	Cap Screw	M8*16	3	
11	SH069400	Hex Head Bolt	M6*16	2	
12	207036A	Block		1	
13	WF061310	Washer	M6* $\phi$ 13	4	
14	WS060000	Lock Washer	M6	4	
15	NH061000	Hex Nut	M6	2	
16	SR069300	Cap Screw	M6*12	2	
17	207035	Block		1	
18	207039	Bushing		1	
19	207038	Screw Threads		1	
20	207044	Hex Nut		2	

ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
21	SS060100	Setscrew	M6*5	2	
22	207135	Hex Nut		2	
23	201868	adjust Knob		2	
24	SR060600	Cap Screw	M6*30	2	
25	207047	Screw Threads		1	
26	SR080700	Cap Screw	M8*35	2	
27	WS080000	Lock Washer	M8	2	
28	WF081818	Washer	M8* $\phi$ 18	2	
29	SS050200	Setscrew	M5*10	2	
30	WF061310	Washer	M6* $\phi$ 13	2	
31	207133-B	Plate		2	
32	207133-A	Plate		2	
33	NH061000	Hex Nut	M6	2	
34	WS060000	Lock Washer	M6	2	
35	WF061310	Washer	M6* $\phi$ 13	2	
36	207150	Plate		1	
37	SH069300	Hex Head Bolt	M6*12	2	
38	SR050600	Cap Screw	M5*30	4	
39	207036	Block		1	
40	207039A	Bushing		1	



ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	207072	Spring		1	
2	207052	Fix Pole		1	
3	SR080900	Cap Screw	M8*45	2	
4	WS080000	Lock Washer	M8	2	
5	WF081818	Washer	M8* $\phi$ 18	4	
6	NH081300	Hex Nut	M8	2	
7	MH207002	Motor		1	
8	KS050530	Key	5*5*30	1	
9	201028	Pulley	50HZ	1	CE
	201029	Pulley	60HZ	1	CSA
10	SS060400	Setscrew	M6*20	2	
11	PS087500	Spring pin	$\phi$ 8X75L	1	
12	LF420010	Belt	15W*1085L(50HZ)	1	CE
	LF410010	Belt	15W*1050L(60HZ)	1	CSA
13	WF104030	Washer	M10* $\phi$ 40	1	
14	NL101700	Lock Nut	M10	1	
15	WS080000	Lock Washer	M6	2	
16	SR060400	Cap Screw	M6*20	2	
17	NH061000	Hex Nut	M6	2	
18	WF061620	Washer	M6* $\phi$ 16	4	
19	207230	Stop Plate		1	
20	SH080800	Hex Head Bolt	M8*40	1	

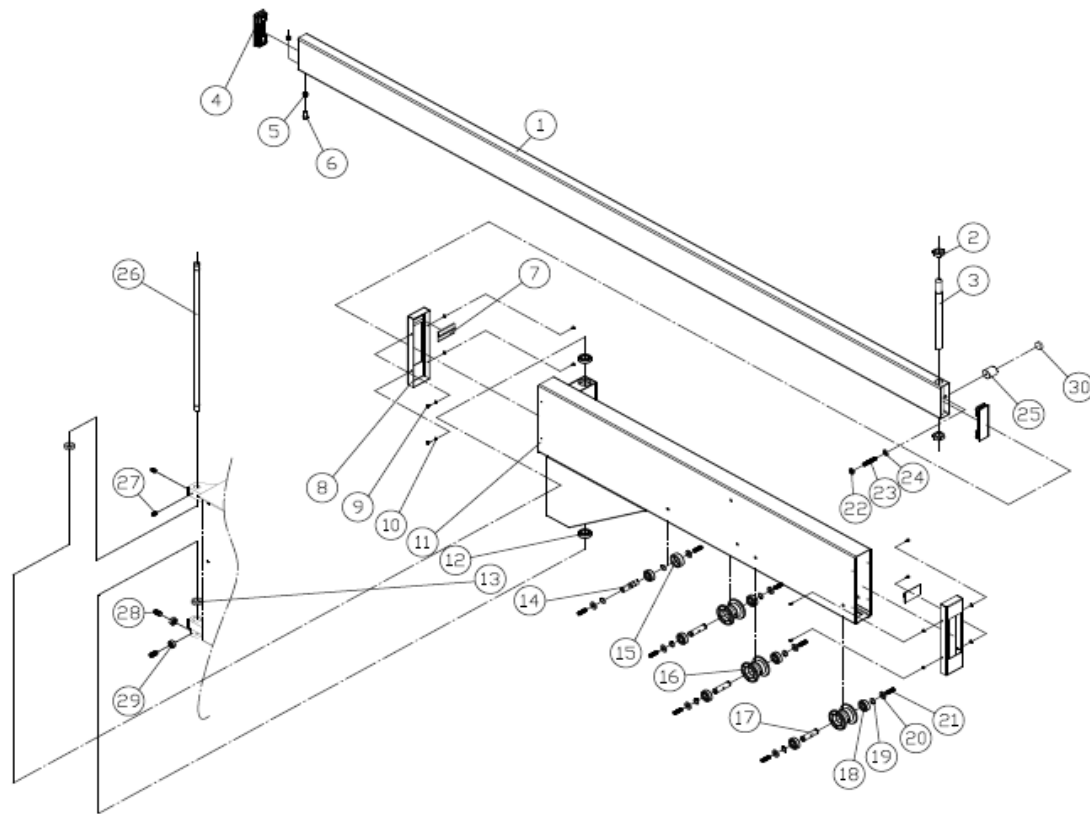
ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
21	NH081300	Hex Nut	M8	1	
22	207189	Plate		1	F1L
23	SH089400	Hex Head Bolt	M8*16	2	
24	WS080000	Lock Washer	M8	2	
25	WF081818	Washer	M8* $\phi$ 18	2	



ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	205208	Sliding Tube		1	
2	203545	Hex Nut	M20	2	
3	205505	Screw Threads	M20	1	
4	203470	Plug	40*120	2	
5	NH081300	Hex Nut	M8	2	
6	SH080400	Hex Head Screw	M8*20	1	
7					
8					
9					
10					
11	207459	Rotary Arm		1	GK
12	BB600302	Ball Bearing	6003ZZ	2	
13	205519	Washer		2	
14					
15	AB203356	Ring Assembly		1	
101	BB620202	Ball Bearing	6202ZZ	1	
102	203356	Ring		1	
103	203357	Shaft		1	
104	RS150000	Retaining Ring	S15	2	

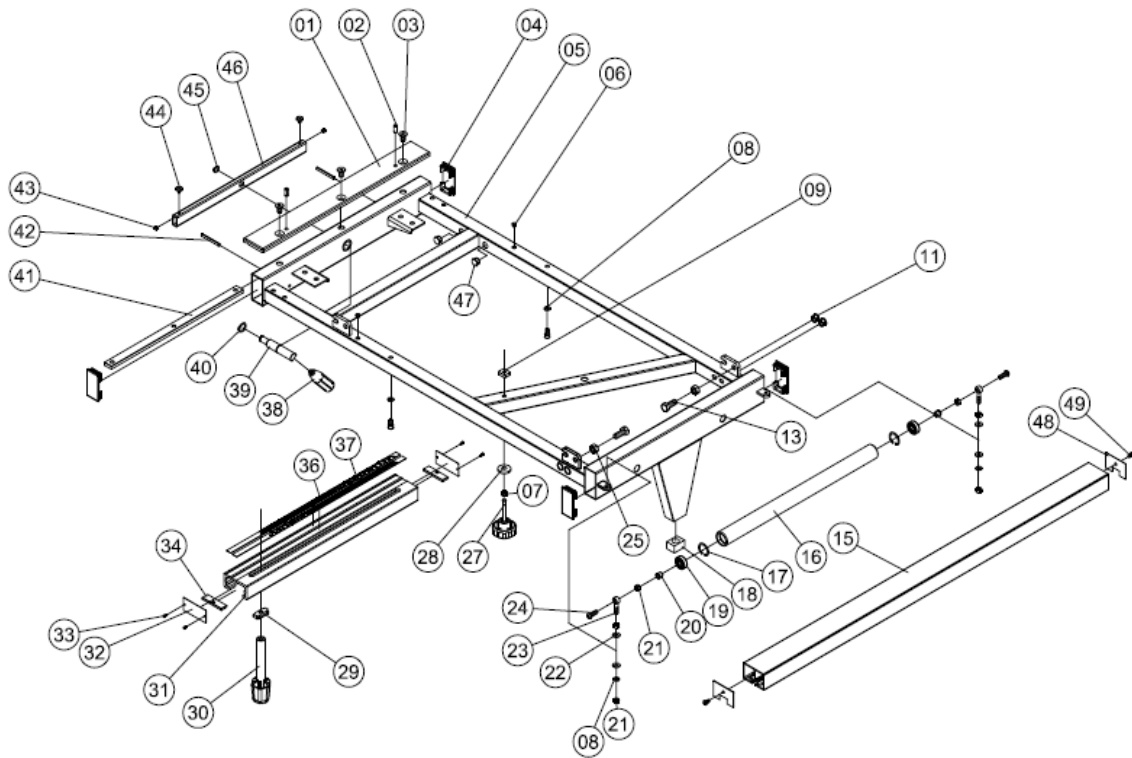


ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
16	AB203348	Roller Assembly		3	
201	203349	Shaft		1	
202	203348	Roller		1	
203	BB620202	Ball Bearing	6202ZZ	2	
204	RS150000	Retaining Ring	S15	2	
17					
18					
19					
20	WF081818	Washer	M8* $\phi$ 18	8	
21	SS080600	Set Screw	M8*30	8	
22	203239	Hex Nut	M8*1.25P	1	
23	SS080700	Set Screw	M8*35	1	
24	WS080000	Spring Washer	M8	1	



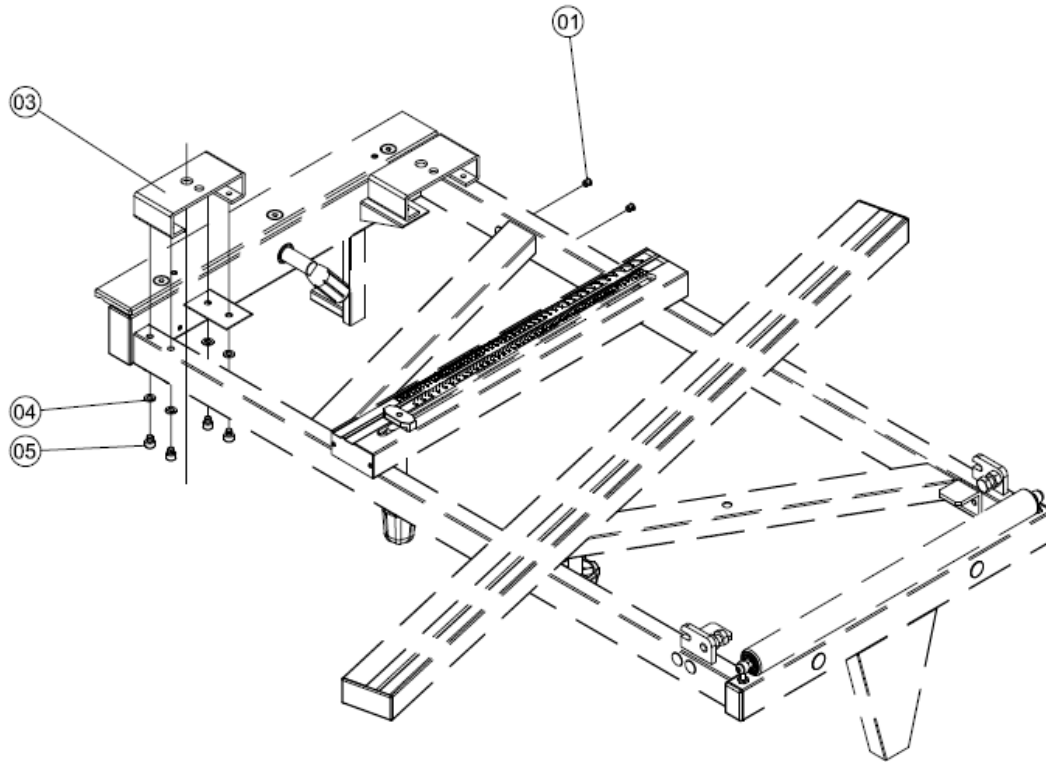
ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
1	205395	Sliding Tube		1	T
2	203545	Hex Nut	M20	2	
3	205505	Screw Threads	M20	1	
4	203470	Plug	40*120	2	
5	NH081300	Hex Nut	M8	2	
6	SH080400	Hex Head Screw	M8*20	1	
7	203479	Seal Strip		2	
8	203417	Plate		2	GK
9	SJ049200	Button Head Screw	M4*8	8	
10	WS040000	Lock Washer	M4	8	
11	205391	Rotary Arm		1	GK
12	BB600302	Ball Bearing	6003ZZ	2	
13	205519	Washer		2	
14	203357	Shaft		1	
15	203356	Ring		1	
16	203348	Roller		3	
17	203349	Shaft		3	
18	BB620202	Ball Bearing	6202ZZ	7	
19	RS150000	Retaining Ring	S15	8	
20	WF081818	Washer	M8* $\phi$ 18	8	

ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
21	SS080600	Set Screw	M8*30	8	
22	203239	Hex Nut	M8*1.25P	1	
23	SS080700	Set Screw	M8*35	1	
24	WS080000	Spring Washer	M8	1	
25	201146-1	Magnetic Bracket		1	
26	205518	Shaft		1	
27	SS089300	Set Screw	M8*12	2	
28	SS100400	Set Screw	M10*20	4	
29	NH101700	Hex Nut	M10	4	
30	200934-2	Magnetic Iron		1	

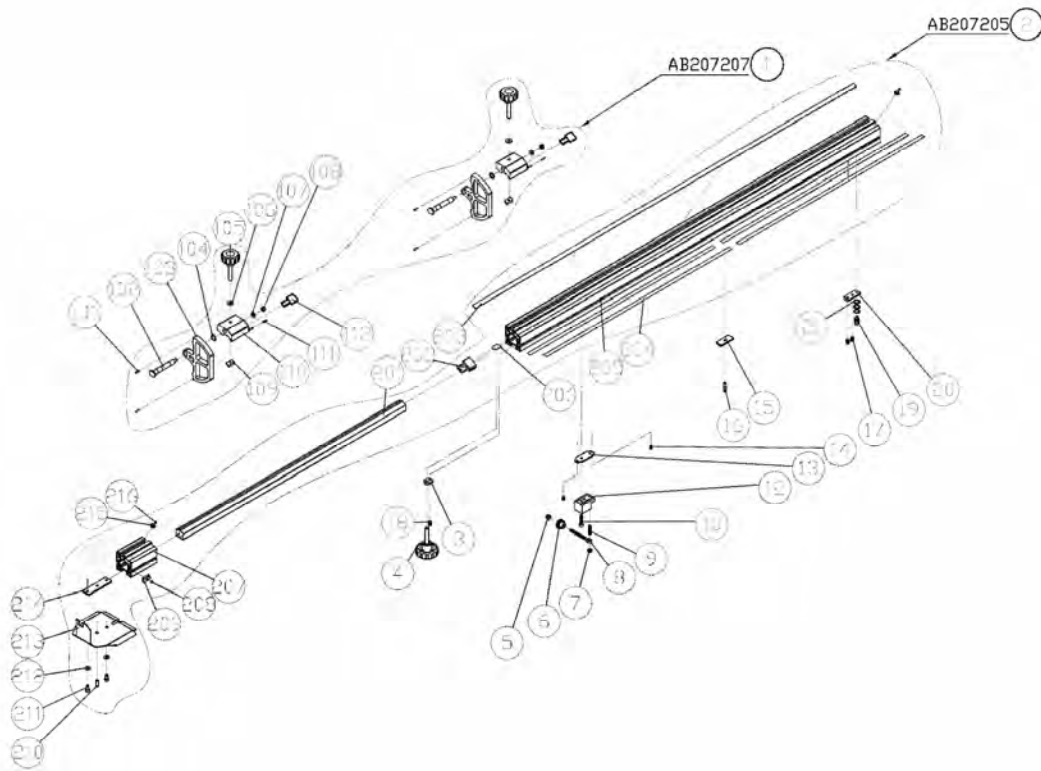


ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	203116	Fixed Plate		1	
2	PS082000	Spring Pin	ψ 8×20	2	
3	SI100400	Counter Sunk Screw	M10×20	3	
4	200910	Plug	40×80	4	
5	203979	Frame		1	R
6	201576	Hole Plugs	HP-09	2	
7	NH081300	Hex Nut	M8	1	
8	WS080000	Lock Washer	M8	4	
9	201103	T-Nut	M8x1.25p	1	
11	203284	Hole Plugs	HP-19	4	
13	SH120801	Screw	M12×1.25×40	2	
15	200833	Pipe		1	
16	203302	Roller		1	
17	RR320000	Retaining Ring	R32	2	
18	203094	Plug		1	
19	BB620102A	Ball Bearing	6201ZZ	2	
20	017058	Bearing		2	
21	NH081300	Hex Nut	M8	6	
22	WF081818	Washer	M8x18	4	
23	201542	Eye Bolt	M8×40	2	

ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
24	SJ080500	Button Head Screw	M8x25	2	
25	NH121900	Nut	M12	2	
27	200827	Knob	M8x1.25px40L	1	
28	WF083020	Washer	M8	1	
29	203122	Block		1	
30	203128	Handle		1	
31	203855	Pipe		1	X7
32	203856	Plate		2	
33	SJ039200	Button Head Screw	M3x8	4	
34	203121	Fixed Block		2	
36	207924-2	Ruler		1	
37	207924-1	Ruler		1	
38	203719	Knob		1	
39	203114	Eccentric Shaft		1	
40	RS200000	Retaining Ring	S20	1	
41	203288	Fixed Block		1	
42	PS066000	Spring Pin	ψ 6x60	2	
43	NS050800	Square Nut	M5	2	
44	203110	Screw	M5x10	2	
45	RS140000	Retaining Ring	S14	1	
46	203109	Square Pipe		1	
47	203230	Hole Plugs	HP-16	2	
48	200955	Cover		2	
49	ST040200	Tap Screw	#8x3/8"	2	



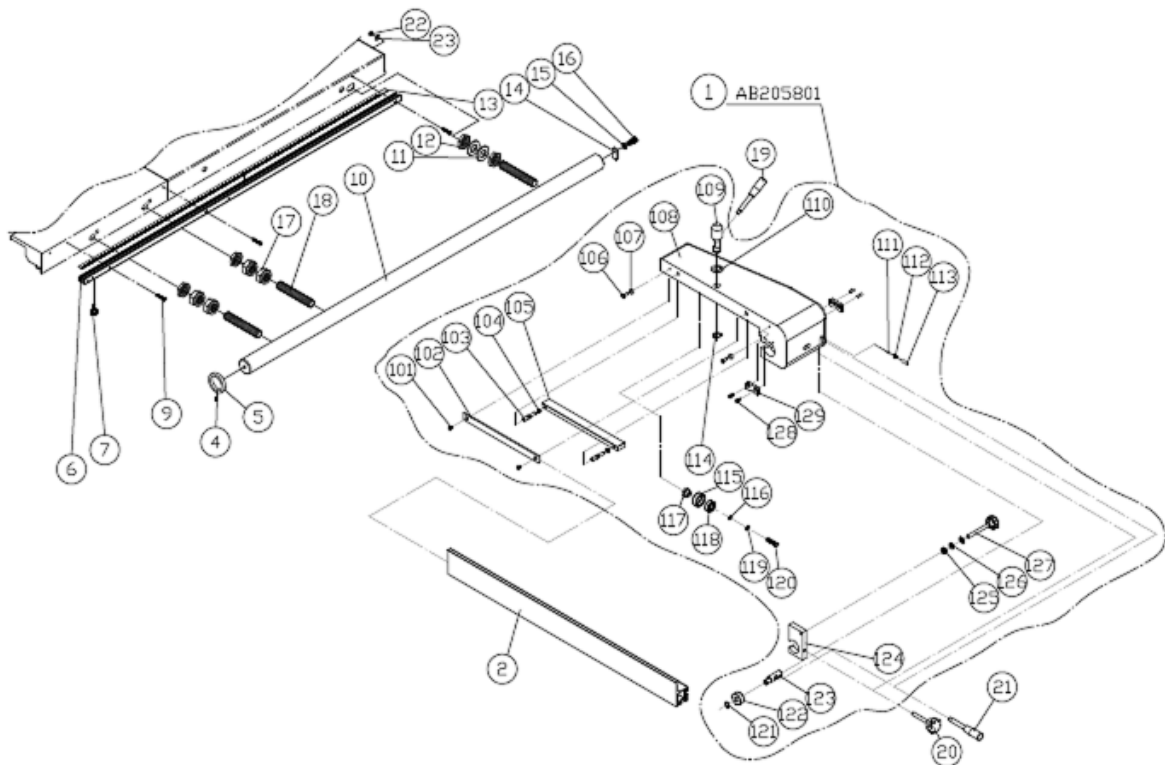
ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	201576	Hole Plugs	HP-09	2	
3	207734	Fixed Plate		2	R
4	WS080000	Lock Washer	M8	8	
5	SR080200	Cap Screw	M8x10	8	



ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
1	AB207207	Flip Stop Assembly		2	A
101	207223	Pipe		2	
102	207203	Shaft		1	
103	207207	Flip Stop		1	
104	207208	Washer		1	
105	207263	Knob	M8x1.25px42L	1	
106	200472	Washer	M8x20x1	1	
107	WF081818	Washer	M8x18	1	
108	207235	Nut	M8	1	
109	207200	Nut		1	
110	207201	Stop Bracket		1	
111	207223	Pipe		2	
112	207202	Magnifier		1	
2	AB207205A	Ext. Fence Assembly	mm	1	S,,A
	AB207205	Ext. Fence Assembly	Inch	1	S , A
201	207212-1	Extended Tube	mm	1	S,
	207212	Extended Tube	mm/inch	1	S
202	207213	Magnifier		1	
203	207216-1	Rule	mm	1	S,
	207216	Rule	mm/inch	1	S
204	205544	Wearing Tape	875x15	4	

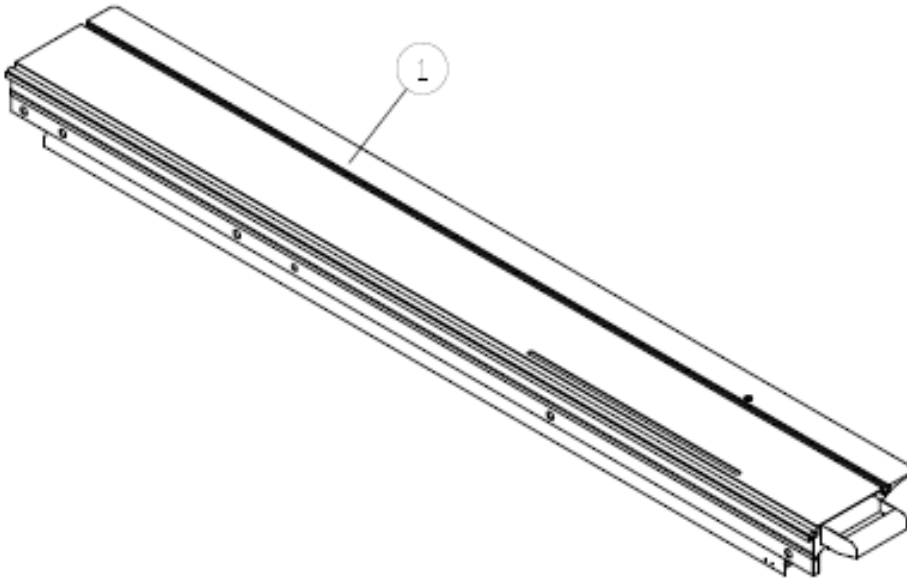
ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
205	207205-1	Ext. Fence		1	
206	207214	Pad		1	
207	207205-2	Ext. Fence		1	
208	SS069100	Setscrew	M6x6	1	
209	207211	Stop Block		1	
210	SS080500	Setscrew	M8x25	1	
211	SR089400	Cap Screw	M8x16	2	
212	WF081818	Washer	M8x18	2	
213	207210	Locate Plate		1	
214	207209	Plate		1	
215	207204	Nut		2	
216	SS050100	Setscrew	M5x5	2	
3	207222	Block		1	H
4	200827	Knob	M8x1.25px40L	1	H
5	NA081300	Nut	M8	1	
6	203790	Knob	M8*1.25p	1	
7	NL081300	Lock Nut	M8	1	
8	203598	Screw	M8*1.25p	1	
9	SS080700	Setscrew	M8*35	1	
10	SR060800	Cap Screw	M6*40	1	
11					
12	207219	Fixed Block		1	
13	207220	Plate		1	
14	SS069100	Setscrew	M6*6	2	
15	207218	Fixed Block		1	H
16	SS080700	Setscrew	M8*35	1	H
17	SS089300	Setscrew	M8*12	2	H
18	SS089300	Setscrew	M8*12	1	H
19	200832	Rotate Shaft		1	H
20	207737	Fixed Block		1	H
21	200069	Fiber Washer	10x18	3	H





ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	AB205801	Rip Fence Housing Assembly		1	GK
101	SI069400	Counter Sunk Screw	M6*16	2	
102	203172	Fixed Plate		1	
103	203193	Shafts		2	
104	NL081000	Lock Nut	M8	2	
105	203192	Plate		1	
106	SH069400	Hex Head Bolt	M6*16	2	
107	203179	Eccentric Ring		2	
108	205801	Seat		1	GK
109	203213	Eccentric Shaft		1	
110	WF203630	Washer	$\psi$ 20* $\psi$ 36	1	
111	994181	Steel Ball	$\psi$ 8	1	
112	150099	Spring		1	
113	SS100200	Set Screw	M10*10	1	
114	RS200000	Retaining Ring	S20	1	
115	203356	Ring		1	
116	WF061920	Washer	M6* $\psi$ 19	1	
117	203195	Eccentric Bushings		1	
118	BB620202	Ball Bearing	6202ZZ	1	
119	WS060000	Lock Washer	M6	1	
120	SH060700	Hex Head Bolt	M6*35	1	
121	RS150000	Retaining Ring	S15	1	
122	203649	Ring		1	

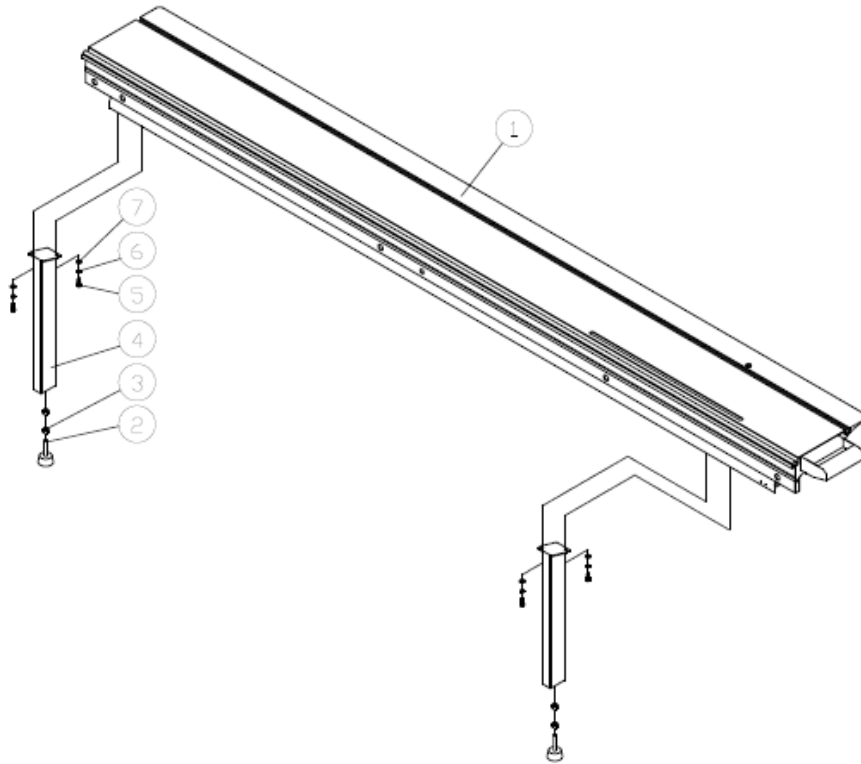
ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
123	203650	Shaft		1	
124	205826	Fixed Block		1	
125	NL101700	Lock Nut	M10	1	
126	200069	Washer	M10	2	
127	205114	Adjust Knob	M10*90	1	
128	SR060200	Cap Screw	M6*10	4	
129	205115	Scraper	$\psi$ 50	2	X7 / S
	205663	Fence Plate	1M	1	
2	203191	Fence Plate	1.2M	1	X7 / S
4	SS060200	Setscrew	M6*10	1	S*1
5	205554	Ring Stop		1	S*1
6	205008	Measuring Rule Rail		1	
7	205109	Screw	M6*20	1	
9	SI060700	Sunk Head Screw	M6*35	3	H
10	205015	Round Rail		1	
11	WF203730	Washer	M20* $\psi$ 37	2	
12	203545	Hex Nut	M20	4	
	205078	Rule		1	X7 / S
13	205078-1	Rule		1	X7 / S
14	206437	End Washer		1	
15	WS080000	Lock Washer	M8	1	
16	SR089400	Cap Screw	M8*16	1	
17	NH203000	Hex Nut	M20	4	
18	205116	Screw	M20*130	3	
19	200884	Handle		1	
20	206432	Handle	M10*55	1	
21	200884	Handle		1	
22	NH061000	Hex Nut	M6	1	H
23	WF061620	Washer	M6x16x2	1	H



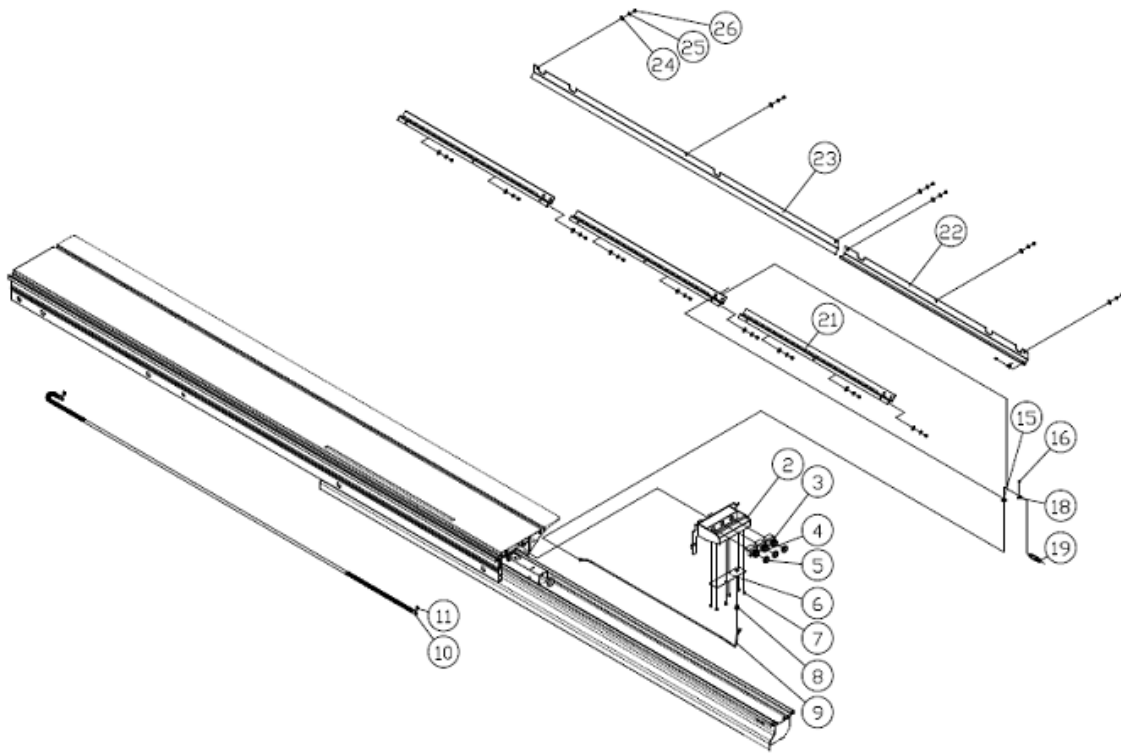
ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
1	2385320C	Table		1	

3800mm

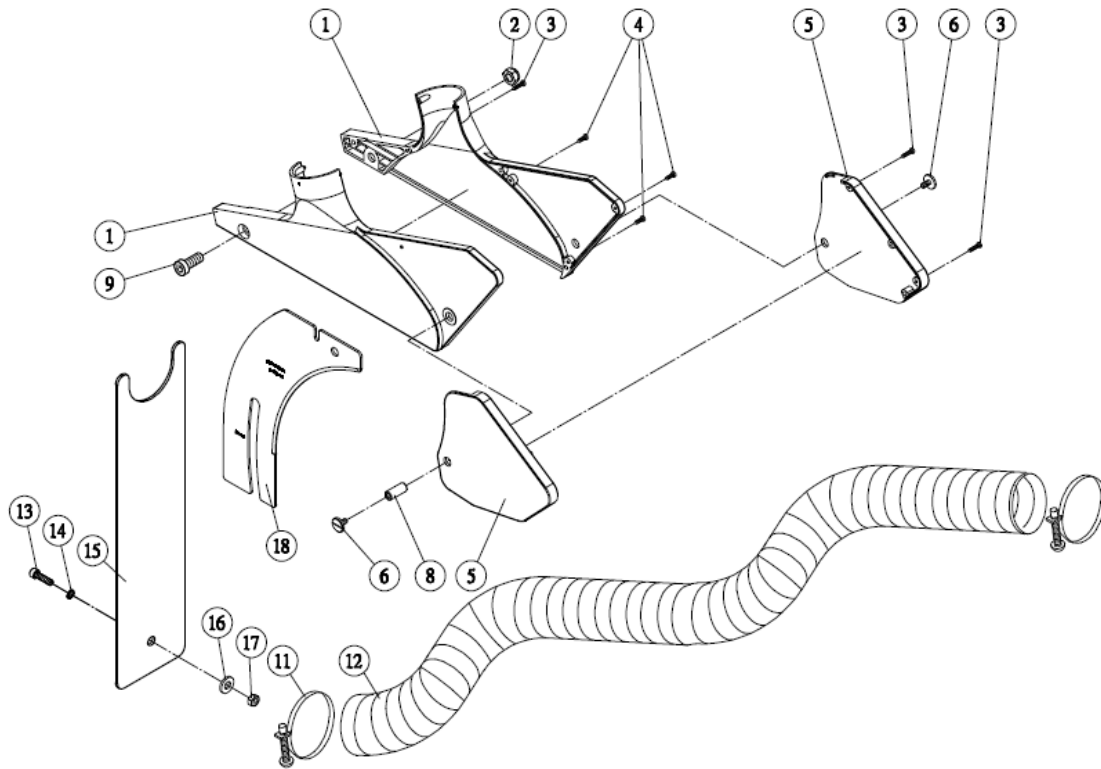
ASSEM11-2.1



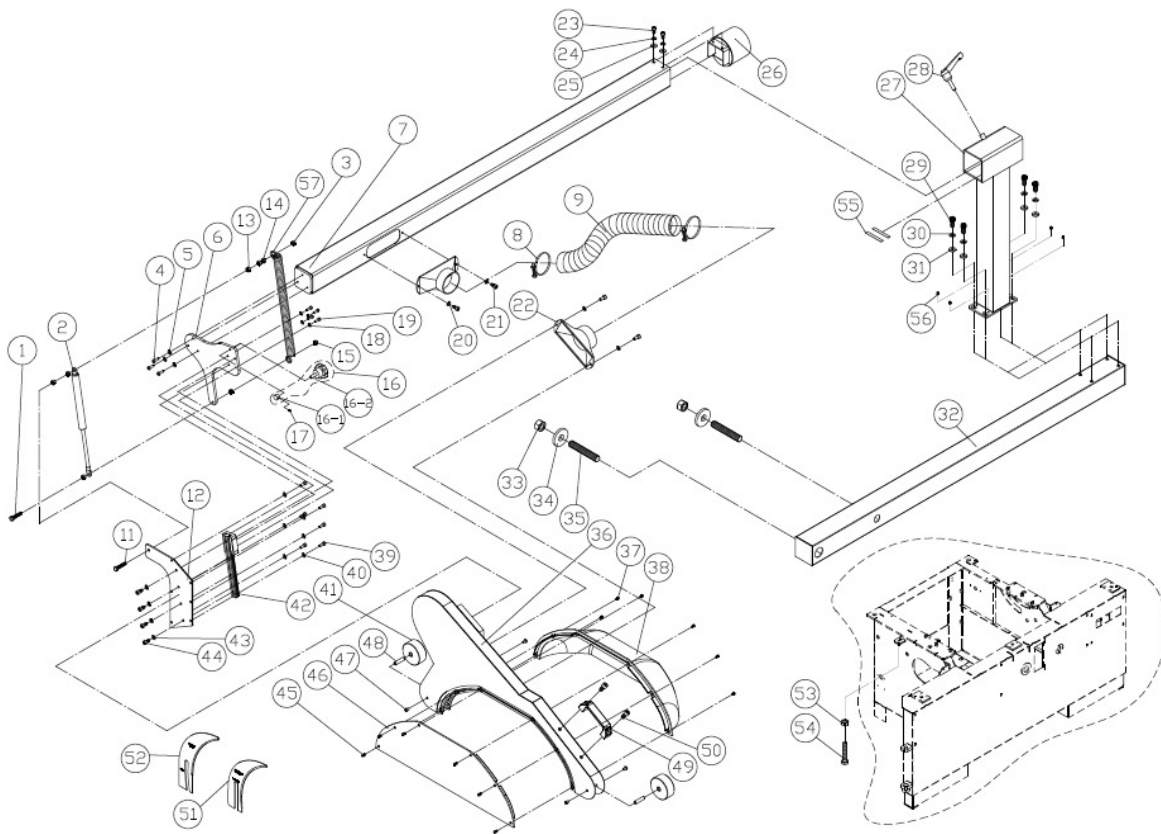
ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	2385380C	Table	385x3800mm	1	
2	201544	Foot Pad		2	
3	NH121900	Hex Nut	M12	4	
4	205394	Support Tube		2	
5	SR080400	Cap Screw	M8*20	4	
6	WS080000	Lock Washer	M8	4	
7	WF081818	Washer	M8* $\phi$ 18	4	



ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
2	203967	Hander		1	T3
3	994856	Switch Button-OFF	R2 PNF-1B-R	1	
4	994855	Switch Button-ON	R2 PNF-1A-G	2	
5	994855A	Dust Cove	R2 PRCF	3	
6	203968	Plate		1	T3
7	SJ049200	Button Head Screw	M4*8	6	
8	998621	Strain Relief	6N-4	1	
9	IC207045	Cord		1	
10	205798	Chain		1	
11	SJ049100	Button Head Screw	M4*6	4	
15	201023	Plug		1	
16	SJ049100	Button Head Screw	M4*6	2	
18	998625	Lashing Ring	5/16"	2	
19	205795	Plug	6P	1	
21	207926	Plate		3	T
22	207927	Plate		1	T
23	207928	Plate		1	T
24	WF061620	Washer	M6x16x2	15	
25	WS060000	Lock Washer	M6	15	
26	SJ069300	Button Head Screw	M6*12	15	



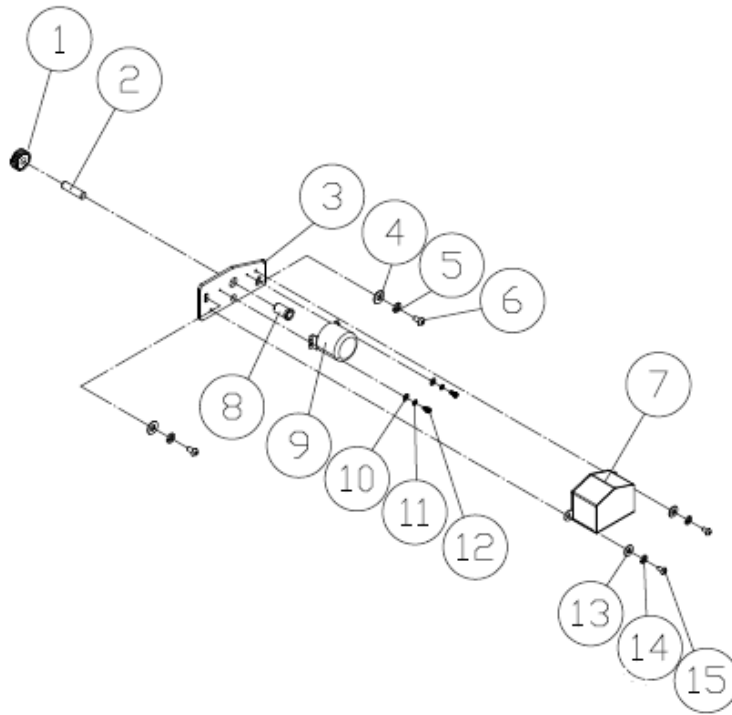
ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	205075	Hood		1	
2	NL101700	Lock Nut	M10	1	
3	ST029404	Screw	M3×16	3	
4	ST029304	Screw	M3×12	3	
5	205076	Hood		1	
6	203110	Screw	M5×10	2	
7					
8	205124	Shaft		1	
9	205162	Cap Screw	M10×25	1	
10					
11	200535	Hose Clamp	2-1/2"	2	
12	200536	Hose	φ 60x3000	1	
13	SR100400	Cap Screw	M10x20	1	
14	WS100000	Lock Washer	M10	1	
15	200965	Hose Support Plate		1	
16	WF102025	Washer	M10x20	1	
17	NH101700	Hex Nut	M10	1	
18	205067	Plate	φ 300~350	1	



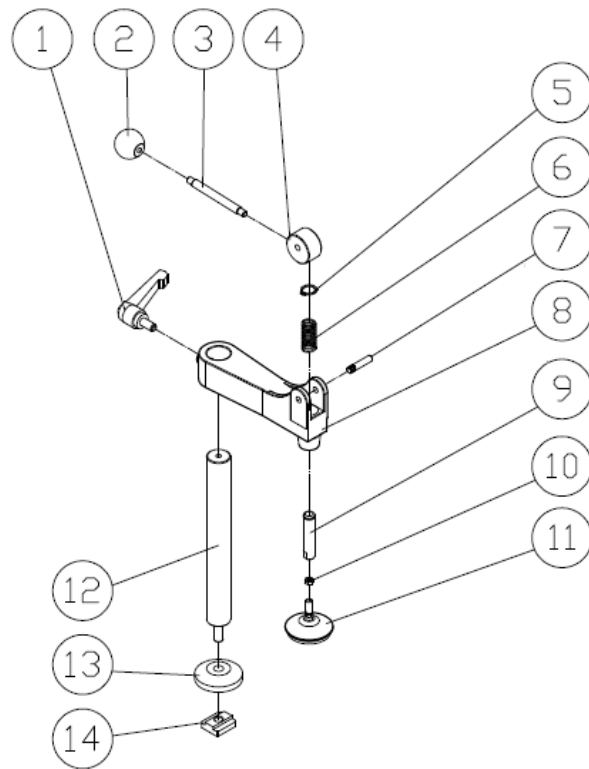
ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	SH080800	Hex Head Bolt	M8*40	1	
2	205307	Gas Expansion Cylinder		1	
3	NH081300	Hex Nut	M8	4	
4	SJ060400	Button Head Screw	M6*20	3	
5	WS060000	Lock Washer	M6	3	
6	205306	Fixed Plate		1	GK
7	206389	Arm		1	R
	206397	Arm		1	R/S(D30P)
8	204158	Hose Clamp	3-1/4"	2	
9	HS330004	Hose	φ 3"x42cm透明	1	
10					
11	SH081200	Hex Head Bolt	M8*60	1	
12	205314	Fixed Plate		1	GK
13	NL081300	Lock Nut	M8	1	
14	NH081300	Hex Nut	M8	3	
15	NL081300	Lock Nut	M8	1	
16	AB205304	Knob Screw SET		1	A
16-1	205304	Locating Block		1	
16-2	200937	Knob Screw	M8*1.25p*25L	1	
17	SS059100	Setscrew	M5*6	1	
18	WS050000	Lock Washer	M5	4	

ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
19	SR059400	Cap Screw	M5*16	4	
20	WS060000	Lock Washer	M6	4	
21	SJ069300	Cap Screw	M6*12	4	
22	204061	Dust Port		2	
23	SJ069300	Cap Screw	M6*12	2	
24	WS060000	Lock Washer	M6	2	
25	WF061920	Washer	M6* $\phi$ 19	2	
26	206390	Dust Port		1	<b>R</b>
27	206388	Fixed Bracket		1	<b>R</b>
28	201109	Fasten Handle	M10x35	1	
29	SR080500	Cap Screw	M8x25	4	
30	WS080000	Lock Washer	M8	4	
31	WF081818	Washer	M8x18	4	
32	206391	Fixed Bracket		1	<b>R</b>
	206398	Fixed Bracket		1	<b>R/S,D30P</b>
33	NH203000	Hex Nut	M20	2	
34	203338	Washer	$\phi$ 22* $\phi$ 60*t8	2	
35	203547	Screw	M20*120	2	
36	206387	Guard		1	<b>GK</b>
37	SP049200	Pan Head Screw	M4*8	6	
38	205355	Protection Hood		1	
39	SR069300	Cap Screw	M6*12	6	
40	WS060000	Lock Washer	M6	6	
41	203355	Roller		2	
42	203216	Liner Guide		1	
43	WS060000	Lock Washer	M6	4	
44	SR069300	Cap Screw	M6*12	4	
45	SP049200	Pan Head Screw	M4*8	6	
46	205356	Protection Hood		2	
47	SJ069200	Button Head Screw	M6*8	4	
48	203354	Shaft		2	
49	201624	Handle		1	
50	SR089400	Cap Screw	M8*16	2	
51	201844	<b>Plate</b>	$\phi$ 300~350	1	
52	205032	<b>Plate</b>	$\phi$ 350~400	1	<b>S</b>
53	NH121900	Hex Nut	M12	1	
54	SH121400	Hex Head Bolt	M12X70	1	
55	201039	Pad		8	
56	<b>SS069150</b>	<b>Setscrew</b>	<b>M6*6</b>	4	
57	207797	Spring		1	

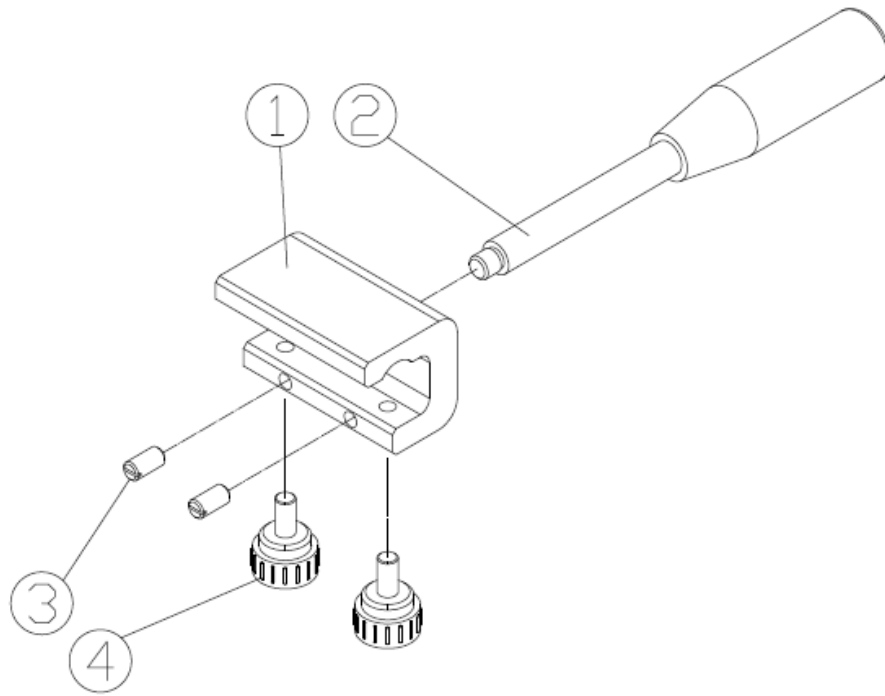




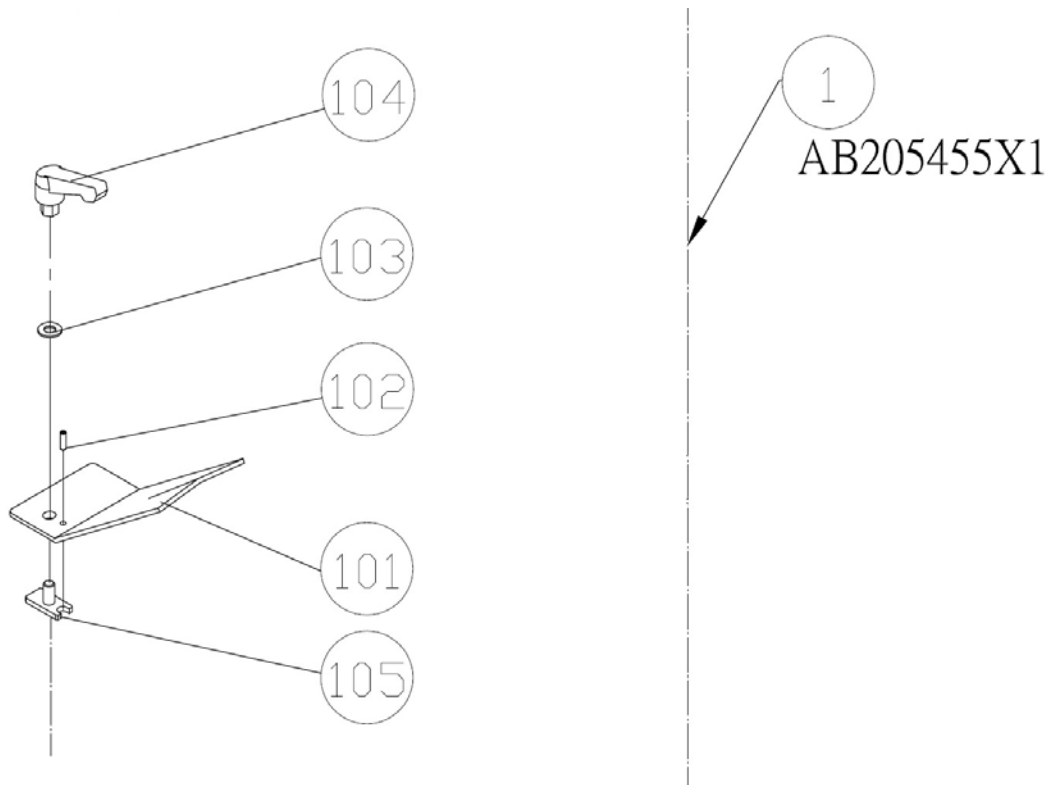
ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	203017	Gear Wheel		1	
2	PP105000	Pin	$\phi$ 10*50	1	
3	207658	Encoder Fixed Plate		1	<b>R</b>
4	WF061620	Washer	M6* $\phi$ 16	2	
5	WS060000	Lock Washer	M6	2	
6	SJ069300	Button Head Screw	M6*12	2	
7	207655	Cover		1	<b>R</b>
8	207747	Encoder Shaft Ring		1	
9	203154	Encoder		1	
10	WF030605	Washer	M3* $\phi$ 6	2	
11	WS030000	Lock Washer	M3	2	
12	SR039100	Cap Screw	M3*6	2	
13	WF051210	Washer	M5* $\phi$ 12	2	
14	WS050000	Lock Washer	M5	2	
15	SJ059200	Button Head Screw	M5*8	2	



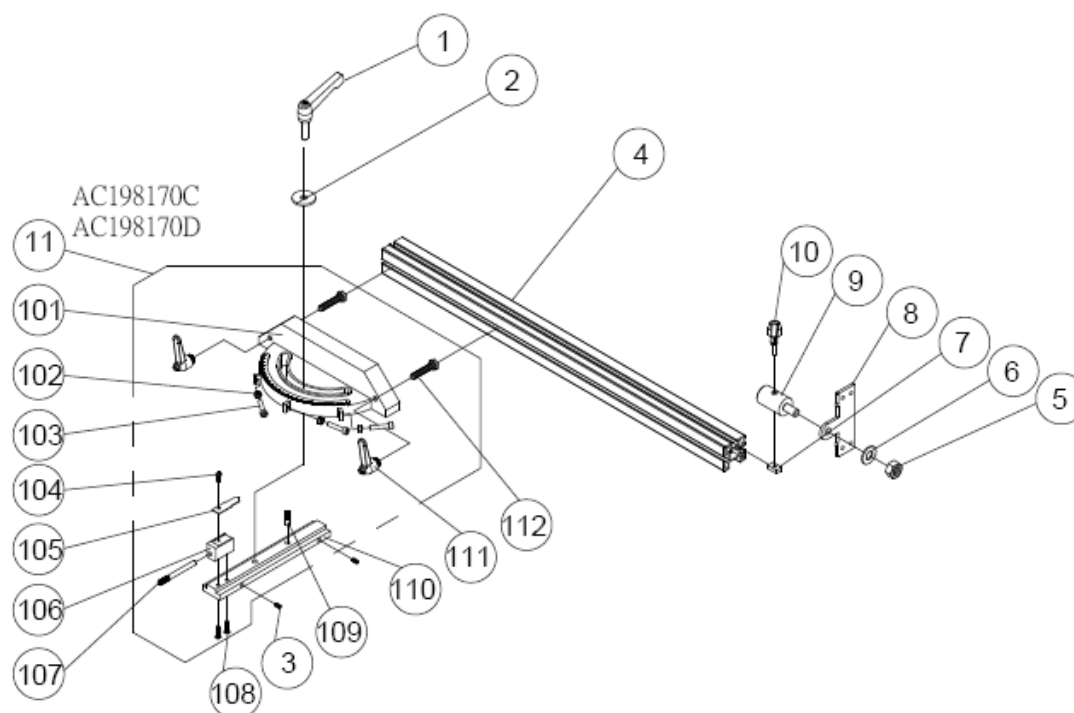
ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	207143	Adjust Handle		1	
2	100271	Ball Knob	M8xP1.25	1	
3	207070	Handle Bar		1	
4	207067	Cam		1	
5	RS140000	Ext. Retaining Ring	S14	1	
6	207069	Spring		1	
7	207145	Pin		1	
8	207065	Down Press		1	
9	207068	Shaft		1	
10	NH602300	Hex Nut	5/16	1	
11	200807	Large Washer		1	
12	205253	Shaft		1	
13	200809	Washer		1	
14	201855	T-Nut		1	S, B
	205255	T-Nut		1	S, D



ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
1	205264	Block		1	
2	203740	Handle		1	
3	203238	Set Screw	M8x16	2	D
	SS080500	Set Screw	M8x25	2	C
4	203720	Knob	M8x16	2	

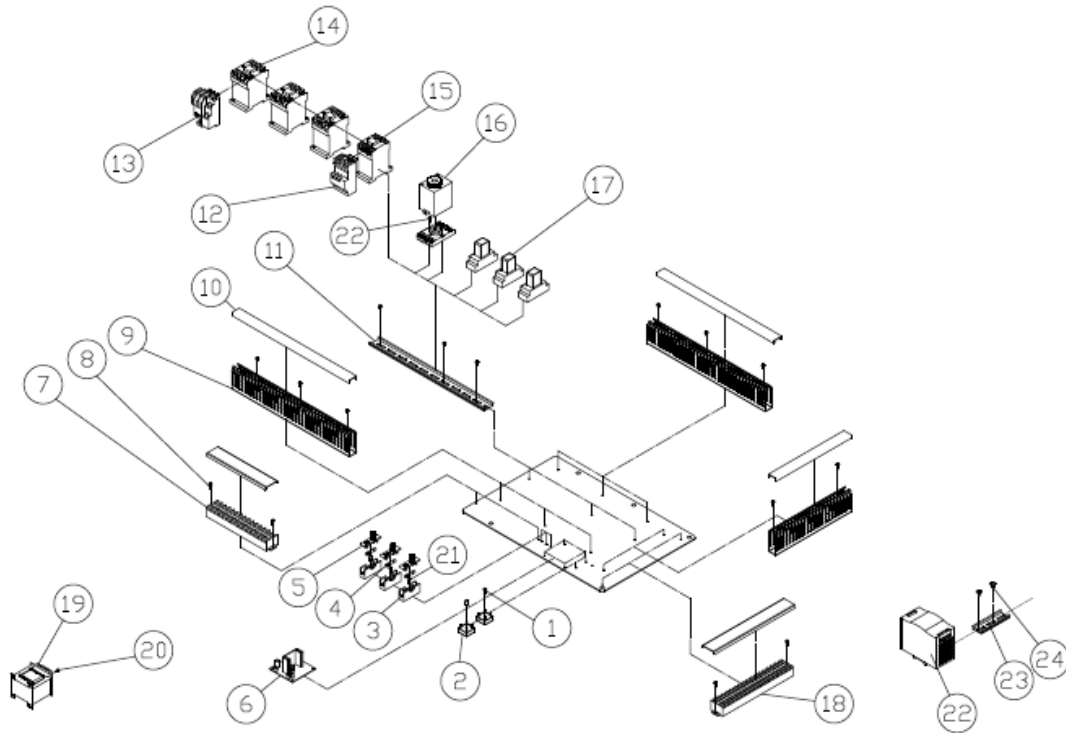


ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
1	AB205455X1	Edge Shoe Plate Assembly			X1
101	205455	Edge Shoe Plate			X1
102	PS051800	Spring Pin	$\varphi 5 \times \varphi 18$		
103	WF102025	Washer	M10x25		
104	201222	Fasten Handle	M10x1.5px20L		X1
105	201829	T-Nut	M10x1.5p		



ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	200814	Fasten Handle		1	
2	WF083030	Flat Washer	M8×φ 30	1	
3	201632	Spring plungers with ball	M4×9	2	
4	017210	Square Fence		1	
5	NL101700	Lock Nut	M10	1	
6	WF102025	Flat Washer	M10×φ 20	1	
7	NS061000	Square Nut	M6	1	
8	017219	Stop Plate		1	
9	200343	Lock Shaft		1	
10	200415	Adjust Handle	M6×30	1	
11	<b>AC198170C</b>	Miter Gauge Assembly	SS- C	1	S, A
	<b>AC198170D</b>	Miter Gauge Assembly	SS- D	1	S, A
101	198170	Miter Gauge Body		1	
102	NH050800	Hex Nut	M5	3	
103	SR050500	Cap Screw	M5×25	3	
104	SP049300	Pan Head Bolt	M4×12	1	
105	201366	Pointer		1	
106	201365	Fixed Block		1	
107	201367	Stop Bar		1	
108	SP049400	Pan Head Bolt	M4×16	2	
109	198174	Shaft		1	
	205721	Fixed Base		1	C
110	205254	Fixed Base		1	D

ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
111	017003	Adjust Handle		2	
112	SH060600	Hex Head Bolt	M6x30	2	



ITEM	PART NO	PARTS NAME	SIZE	QTY	NOTE
1	SP059400	Pan Head Screw	M5*16	2	
2	205407	Rectifier	KBPC2506 24A 600V	2	
3	205416	Fuse block	1P	3	
4	994942	Fuse	3A 250VAC 30mm	3	
5	205416-01	Cover	DC燈	3	
6	207764	Steady-state voltage circuit board		1	
7	205371	Terminal & Cover	TA-030 15P	1	
8	ST040200	Tapping Screw	M4*10	15	
9	205180-01	Slot		1	
10	205180-02	Cover		1	
11	205186	Aluminum Rail		0.3	
12	994779	Ovre current protection	TH-P12SPP(1.7A),AC380~420V	1	7.5HP , S
13	994738	Ovre current protection	TH-P20SPP(15A),AC380~420V	1	7.5HP , S
14	994732	Contactor	SP-16S AC24V AC200~420V	1	7.5HP , S
15	994761	Contactor	SP-11S AC24V AC380~420V	1	7.5HP , S
	AB205414	Timing device	TRD-N AC24V 30S	1	
16	205414-1	Timing device	TRD-N AC24V 30S	1	
	205414-2	Timing device		1	

ITEM	PART NO	PARTS NAME	SIZE	Q'TY	NOTE
1	IC207001	DC MOTOR CORD		1	
2	IC207002	DOWN SWITCH CORD		1	
3	IC207003	UP SWITCH CORD		1	
4	IC207004	7.5HP MOTOR CORD(CE)		1	
5	IC207005	1HP MOTOR CORD (CE)		1	
6	IC207006	DOOR SWITCH CORD		1	
7	IC207007	CONTROL PANEL CORD		1	
8	IC207008	STOP SWITCH CORD		1	
9	IC207009	BREAKER POWER CORD		1	