

# INSTRUCTION MANUAL

## BS-460AS Dual Mitre, Swivel Head Metal Cutting Band Saw (415V) 600 x 440mm (W x H) Rectangle



**B035**

## TABLE OF CONTENTS

1	ACCIDENT PREVENTION AND SAFETY REGULATION .....	1
	1.1 Advice for the operator .....	1
	1.2 The electrical equipment according to European Standard" CENELEC EN 60204-1" .....	1
	1.3 Warning labels .....	1
	1.4 Emergencies according to European Standard "CENELEC EN 60204-1" .....	1
2	MACHINE TRANSPORTATION AND INSTALLATION .....	2
	2.1 Machine dimensions .....	2
	2.2 Transporting the machine .....	2
	2.3 Minimum requirements for housing the machine .....	2
	2.4 Installing the rear coolant return tray .....	2
	2.5 Install the outlet tray, length stop device and mobile coolant trays. ....	3
	2.6 Securing to foundation .....	3
	2.7 Leveling the machine .....	3
	2.8 Deactivation of machine .....	4
3	DESCRIPTION OF MACHINE PARTS .....	4
	3.1 Control panel .....	4
	3.2 Indicator lights .....	4
	3.3 The saw bow .....	5
	3.4 The vise system .....	5
	3.5 The base .....	5
	3.6 Chip tray .....	5
	3.7 Blade broken micro switch .....	5
	3.8 Chip brush .....	5
	3.9 Blade speed indicator .....	5
	3.10 Open Blade Cover Safety Device .....	6
	3.11 Speed change dial .....	6
	3.12 Blade angle scale .....	6
	3.13 Attached coolant device .....	6
4	SET UP AND PRE-OPERATIONS .....	6
	4.1 Adjusting the tungsten carbide guides .....	6
	4.2 Thrust Roller Adjustment .....	7
	4.3 Guide Roller adjustment .....	7
	4.4 Adjusting the cutting precision .....	7
	4.5 Blade tracking adjustment (Manual blade tension type) .....	7
	4.6 Blade tracking adjustment (Hydraulic blade tension type) .....	8
	4.7 Placing the saw blade onto the drive wheel and flywheel .....	8
	4.8 Hydraulic vise pressure .....	8
5	OPERATION PREPARATIONS .....	8
	5.1 Setting the stroke limit .....	8
	5.2 Positioning the vise .....	9
	5.3 Angle cutting .....	9
	5.4 Using the vise .....	9
	5.5 Adjusting the blade speed .....	9
	5.6 Changing the transmission belt .....	9
	5.7 Selecting Automatic and Manual operation .....	10
	5.8 Changing the blade (Manual blade tension type) .....	10
	5.9 Changing the blade (Hydraulic blade tension type) .....	10
	5.10 Laser guide device (optional) .....	11
	5.11 Install the vertical press on the vise jaws for bundle cutting (optional) .....	11
6	OPERATION CYCLE .....	12
	6.1 Operation cycle .....	12
	6.2 Stopping or emergency stopping .....	12
	6.3 Automatic shutoff during machine operation .....	12
7	ROUTINE AND SPECIAL MAINTENANCE .....	13
	7.1 Daily maintenance .....	13
	7.2 Weekly maintenance .....	13
	7.3 Monthly maintenance .....	13
	7.4 Six-monthly maintenance .....	13
	7.5 Oils for lubricating coolant .....	13
	7.6 Oil disposal .....	13
	7.7 Special maintenance .....	13
	7.8 Changing gear oil .....	13
8	TECHNICAL CHARACTERISTICS .....	14
	8.1 Table of cutting capacity and technical details .....	14
	8.2 NOISE TESTS .....	14

## 1 ACCIDENT PREVENTION AND SAFETY REGULATION

This machine has been designed to comply with national and community accident- prevention regulations. Improper use and/or tampering with the safety devices will relieve the manufacturer of all responsibility.

### 1.1 Advice for the operator

- Check, the line voltage is the same as the voltage required by the machine's motor.
- Check the efficiency of your electric supply and grounding system; connect the power cable of the machine to the socket and the ground lead (yellow- green in color) to the grounding system.
- When the machine is in suspended mode (or stopped) the blade must not move.
- Only the blade section used for cutting must be kept unprotected. To remove guards to expose more of the cutting blade adjust the blade guides.
- It is forbidden to use the machine without its shields
- Always disconnect the machine from the power socket before blade change or carrying out any maintenance job, even in the case of abnormal machine operation.
- Always wear suitable eye protection.
- Never put your hands or arms into the cutting area while the machine is operating.
- Do not shift the machine while it is cutting.
- Do not wear loose clothing like: shirts with sleeves that are too long, gloves that are too big, bracelets, chains or any other object that could get caught in the machine during operation. Tie back long hair.
- Keep the area free of miscellaneous object; i.e. equipment, tools, etc...
- Perform only one operation at a time. Never have several objects in your hands at the same time. Keep your hands as clean as possible.
- All internal operations, maintenance or repairs, must be performed in a well-lit area or where there is sufficient light from extra sources to avoid the risk of accidents.

### 1.2 The electrical equipment according to European Standard" CENELEC EN 60204-1"

- The electrical equipment ensures protection against electric shock as a result of direct or indirect contact. The active parts of this equipment are housed in a box to which access is limited by screws that can only be removed with a special tool; the parts are fed with alternating current as low voltage (24V). The equipment is protected against splashes of water and dust.
- Protection of the system against short circuits is ensured by means of rapid fuses and grounding; in the event of a motor overload, protection is provided by a thermal probe.

- In the event of a power cut, the specific start-up button must be reset.
- The machine has been tested in conformity with point 20 of EN 60204

### 1.3 Warning labels



Replace warning labels if they become obscured or removed.

- Keep hands and other body parts away from a running blade.
- Do not open the blade cover while machine is running.
- Do not store combustible materials near or around machine.
- Always wear approved safety glasses/face shields while using this machine.
- Keep machine guards in place at all times.
- Do not wear gloves.
- Remove loose clothing and confine long hair.
- Keep the work area clean and free miscellaneous objects.

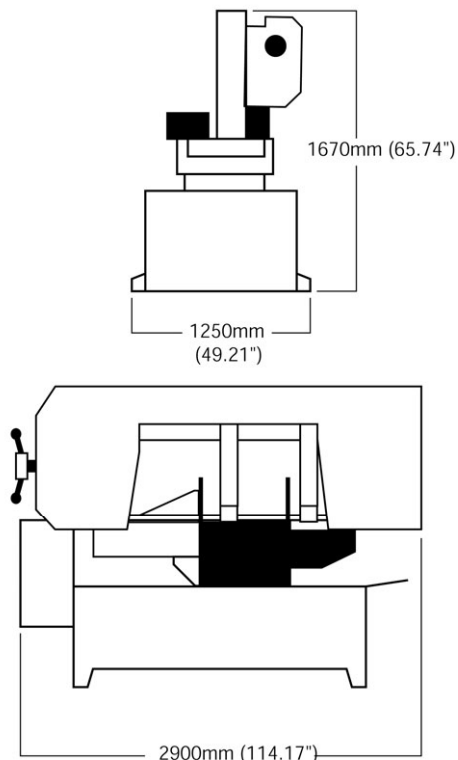
### 1.4 Emergencies according to European Standard "CENELEC EN 60204-1"

- In the event of incorrect operation or a danger condition, the machine may be stopped immediately by pressing the red mushroom shaped button.

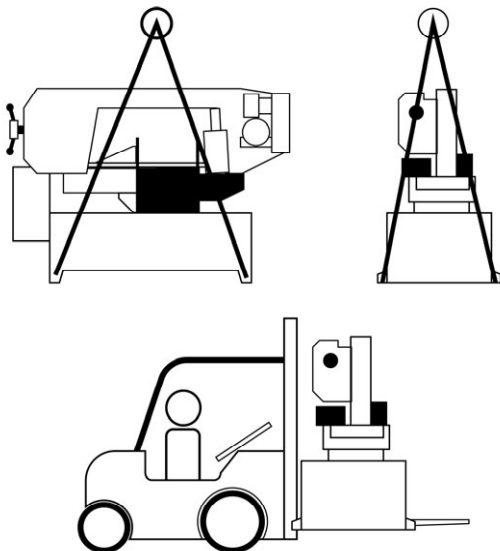
NOTE: Resetting of machine operation after each emergency stop requires resetting the emergency stop button.

## 2 MACHINE TRANSPORTATION AND INSTALLATION

### 2.1 Machine dimensions



### 2.2 Transporting the machine



Unpack your machine carefully, and use a crane or forklift to set it in position. If a crane is used to lift the machine, attach the lifting cable carefully to the machine. Sufficient space should be left around the machine to allow safe handling of materials, inspection, and maintenance operations. Take precautions to choose a location that will keep the machine free of vibration and dust caused by other machinery.

### 2.3 Minimum requirements for housing the machine

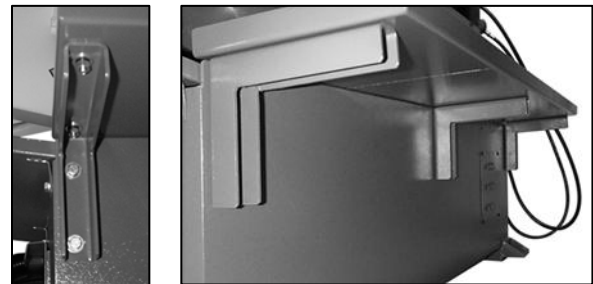
- Main voltage and frequency must comply with the machine's motor requirements.
- Environment temperature should fall within (-10°C to + 50 °C).
- Relative humidity cannot be over 90%.

### 2.4 Installing the rear coolant return tray

The rear coolant-return tray must be installed after the machine is set in place. Install the coolant return trays first.

#### Installing three channeled L-bracket

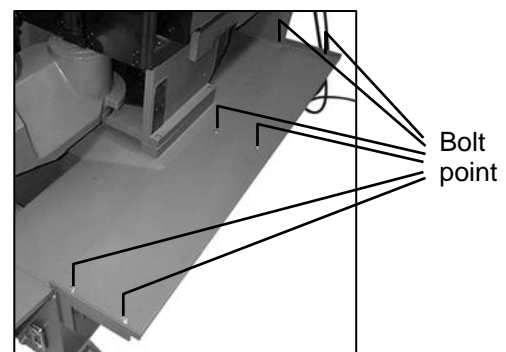
Install three channeled L-bracket to the back of the machine stand. Attaching the brackets requires 6 hex head bolt, 6 spring washers, 6 washers, and 6 nuts.



- Place a spring washer and washer on each hex head bolt.
- Face the long side of the bracket up.
- Align the holes of short side of the bracket to the machine panel's holes.
- Place the 2 hex head bolts and their washers through each bracket and machine panel.
- Use a nut on the inside of the machine stand to secure each hex head bolt.

#### securing the rear tray

Attaching the trays requires 6 hex head bolt, 6 spring washers, 6 washers, and 6 nuts.

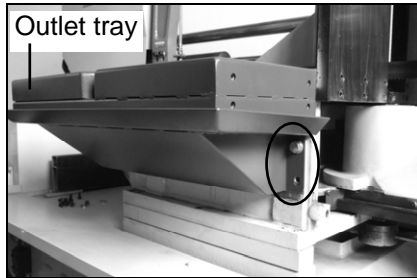


- Arrange the tray rims to facing up and away from the machine.
- Place the rear return tray onto brackets at the back of the machine.
- Align the holes of the rear tray and the six-channeled L-brackets.
- Place 6 hex head bolts through the holes of the trays and brackets.
- Secure each hex head bolts with a washer, spring washer, and hex nut.

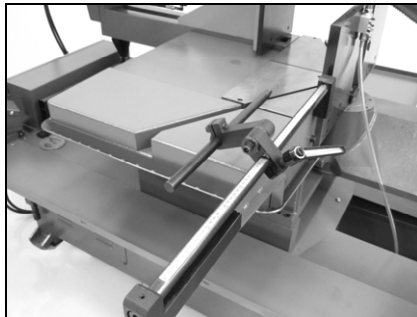
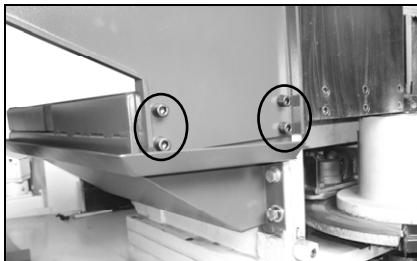
## 2.5 Install the outlet tray, length stop device and mobile coolant trays.

Install the outlet tray and stop bar on to the machine after setting up the machine already as below steps:

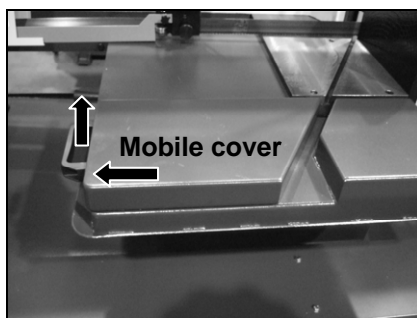
1. Assemble the new outlet tray on to the machine by screw in the four screws on the both side as picture. Tighten the four screws after make sure the top of outlet surface same as table.



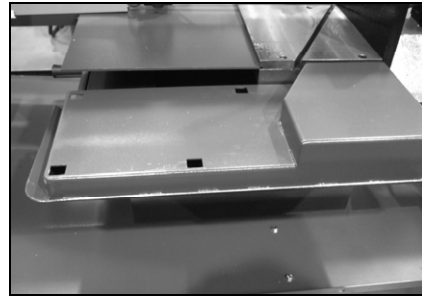
2. Install stop device on to the outlet tray at the right side by tighten four screws.



3. If miter cutting on the front way or move the vise to this side for another way miter cutting, the movable cover on the left side can be removed by pull handle up and out as arrow direction to remove it from being cut.



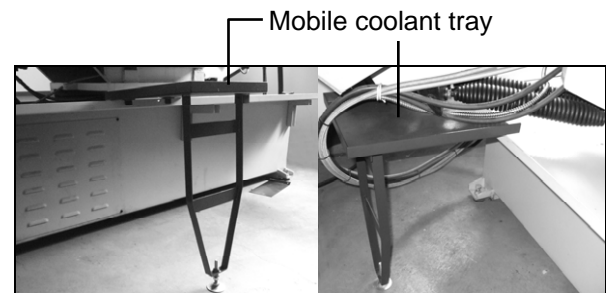
Remove mobile cover by lift handle up and pull it out from the base as showing direction.



There are four slots on the cover base after removing the mobile cover for this way miter cutting.

Install the mobile cover to the four slots and push it to the right side to secure it.

4. They are two mobile coolant trays can be moved and used in miter cutting on front and rear side to prevent coolant spray on to the floor.



## 2.6 Securing to foundation

Position the machine on a flat and level foundation of reinforced concrete. Level machine and anchor it to the foundation with anchor bolts. Maintain a minimum distance of 800mm from the rear of the machine to the wall. Position the anchors using screws and expansion plugs or tie rods sunk in cement.

## 2.7 Leveling the machine

The operating accuracy of all precision machinery depends on the accuracy of the installation of the machine. Manufacturing tolerance of the machine can only be guaranteed if the machine is firmly and properly installed. Once the machine is lowered on the prepared foundation, machinist levels should be used alternately on the vice slide plates and work feed table, adjust the left to right and front to back level of the machine with leveling bolts.

- When leveling left to right level, adjust left side to be approximately 3mm higher than the level of the right side. This will provide proper return of the cutting fluid. After proper leveling of the machine, use anchor bolts to secure to the foundation. Caution: All leveling bolts should support the weight the machine evenly

## 2.8 Deactivation of machine

If the machine is to be out of use for a long period, it is advisable to proceed as follows:

- 1) Disconnect from the power supply
- 2) Loosen the tension on the blade
- 3) Release the bow return spring
- 4) Empty the coolant tank
- 5) Carefully clean and grease the machine
- 6) If necessary, cover the machine.

Dismantling (due to deterioration and/or obsolescence)

As a General Rule,

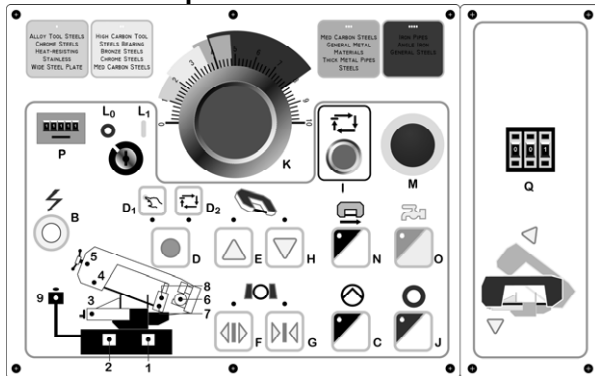
If the machine is to be permanently demolished and/or scrapped, divide the material to be disposed of according to type and composition, as follows:

- 1) Cast iron or ferrous materials, composed of metal alone, are secondary raw materials, so they may be taken to an iron foundry for re-smelting after having removed the contents (classified in point 3).
- 2) Electrical components, including the cable and electronic material (magnetic cards, etc.), fall within the category of material classified as being assimilated to urban waste according to the laws of your local, state, or federal government, so they may be set aside for collection by the public waste disposal service;
- 3) Old mineral and synthetic and/or mixed oils, emulsified oils and greases are considered hazardous or special refuse, so they must be collected, transported and disposed of at a special waste disposal service.

NOTE: The standards and legislation concerning refuse is in a constant state of evolution, therefore is subject to changes. The user must keep informed of the regulations at the time of disposal as these may differ from those described above.

## 3 DESCRIPTION OF MACHINE PARTS

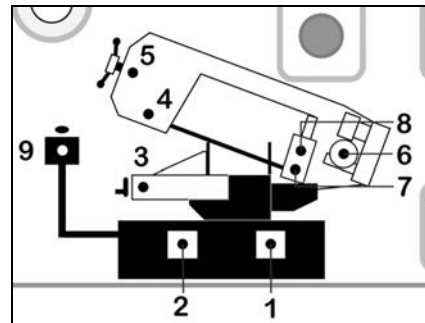
### 3.1 Control panel



- A. Main connect switch – main power
- B. Main power indicator light – indicates that main power is active
- C. Hydraulic flow control start switch – activates hydraulic power

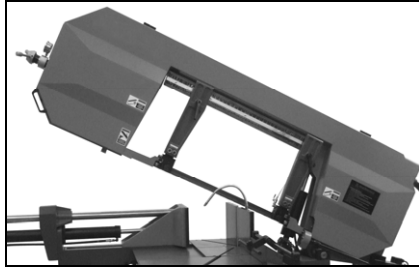
- D. Operation mode switch – selects either automatic or manual operation mode.
- D1. Manual operation mode – press switch D until the manual mode's indicator light shows up.
- D2. Automatic operation mode – press switch D until the automatic mode's indicator light shows up.
- E. Bow up switch – press to raise the saw bow
- F. Vise open switch – press to open the vise
- G. Vise close switch – press to close the vise
- H. Bow down switch – press to lower the saw bow
- I. Cycle start switch – press to begin operation
- J. Stop switch – press to stop operation cycle and return to start position
- K. Cutting feed rate – adjust the rate of cutting of the saw bow.
- L. Key lock power switch – to start or stop power.
- L0. Power off switch – key switch to turn power off
- L1. Power on switch – key switch to turn power on
- M. Emergency Stop Button – Press to stop all machine functions
- N. Blade tracking switch – press to activate blade tension and set the blade tracking.
- O. Coolant start switch – press to activate or stop coolant flow
- P. Counter – counts the pieces cut, press the button to reset units to zero.
- Q. Stroke height switch – limits the stroke height to eliminate the wasted motion and time. Maximum height limit is 330mm.

### 3.2 Indicator lights



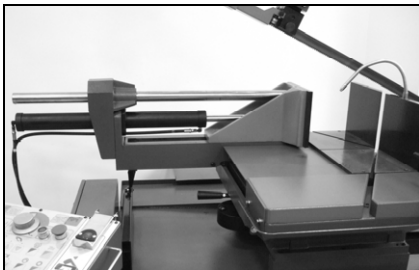
1. Coolant pump warning light
2. Hydraulic pump warning light
3. Vise pressure warning light
4. Open blade cover warning light
5. Broken blade warning light
6. Main motor warning light
7. Lower stroke limit indicator light
8. Upper stroke limit indicator light
9. Emergency stop indicator light

### 3.3 The saw bow



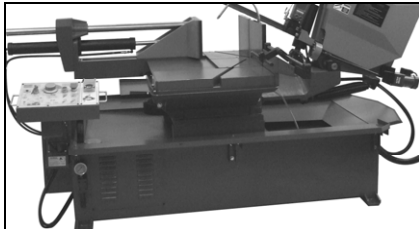
Machine parts consisting of drive members (gear motor, variable speed motor, and flywheels), tightening and guide (blade tightening slide, blade guide blocks) of tool.

### 3.4 The vise system



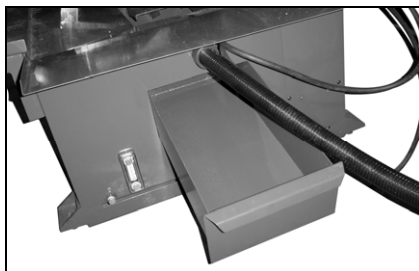
A hydraulic vise is used for clamping work material. Each of the vises has a miter slot, which is good for the right or left side's angle cutting to 60°.

### 3.5 The base



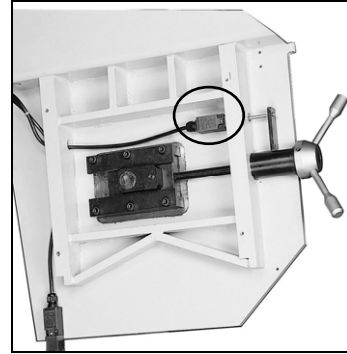
The base is the structure supporting the saw bow (the bow pivot point and respective blocking system), the vises, and containing chip tray and coolant system.

### 3.6 Chip tray



Removable chip tray for capture of chips and debris.

### 3.7 Blade broken micro switch



This machine is equipped with automatic power shut-off safety device to prevent any further damage when a blade has been broken. There is a reduction in tension when an adjustment bolt actuates micro switch's plunger. To keep the micro switch in proper contact with the blade's tension. An adjustment of the actuator bolt is required.

### 3.8 Chip brush



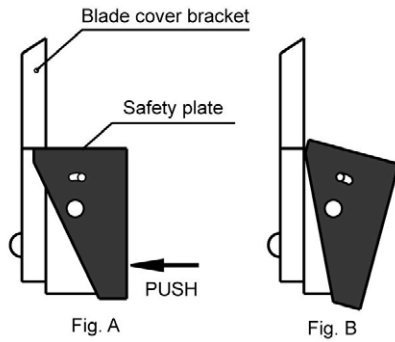
This model has a powered chip brush driven by an axle transfer from the drive motor. The chip brush is designed to clean the blade thus prolonging the life of the blade.

### 3.9 Blade speed indicator



A digital display indicates the blade speed in MPM. This works in conjunction with speed changing dial to give you precise control of blade speed.

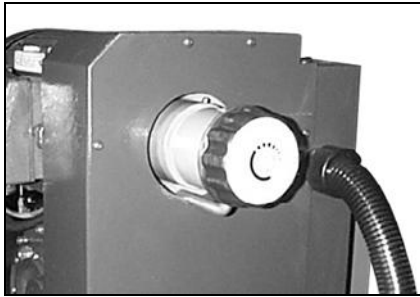
### 3.10 Open Blade Cover Safety Device



When blade cover is open, close the blade cover as instructed below:

1. Use one hand on the cover handle to hold the blade cover.
2. Use the other hand to push in the safety plate (Fig. A), so the bracket will release (Fig. B).
3. Lower the cover down slowly and carefully.

### 3.11 Speed change dial



The speed change dial adjusts the variable speed transmission so that there is a change in blade speed. Change only while blade is moving.

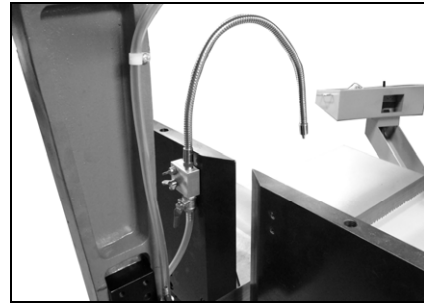
This machine has a variable speed transmission using a variable pulley - system. The speed is changed by rotating the speed changer dial to adjust the width of the pulley discs. When compressed, the pulley discs cause the belt to ride the outer edge of pulley discs and changing the speed. The speed must be changed while belt is moving.

### 3.12 Blade angle scale



The scale indicates the cutting angle of the blade. The scale has preset stops at every 15°.

### 3.13 Attached coolant device

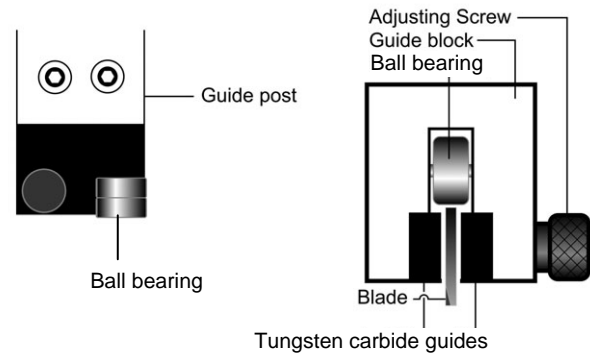


An attached coolant device that is screwed on the front vise jaw for supply enough coolant to the cutting material. This device can be unscrewed, and move to the rear vise jaw for easy both side miter cutting.

## 4 SET UP AND PRE-OPERATIONS

### 4.1 Adjusting the tungsten carbide guides

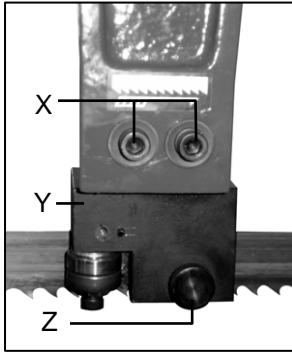
The blade is guided by the upper ball bearings, side ball bearings, and tungsten carbide guides.



- When ready to cut the work piece, the carbide guide must be adjusted by adjusting the screws to properly compressed blade. The tungsten carbide blades should touch, but not pinch the blade.
- For moving the blade guide posts or changing blade, the tungsten carbide guides should be released by using the adjusting screw.

In case the blade needs to be replaced, make sure to always install 1.3mm thick blade.

#### 4.2 Thrust Roller Adjustment

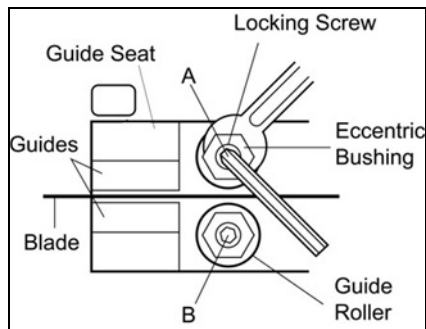


1. **Disconnect machine from the power source.**
2. Loosen two hex socket cap screws (X)
3. Move guide seat (Y) up or down until a clearance of .003" to .005" between back of blade and thrust roller is obtained.
4. Tighten two hex socket cap screws (X).
5. Repeat for other blade guide assembly.
6. Connect machine to the power source.

#### 4.3 Guide Roller adjustment

##### Note:

Only bearing (A) is adjustable. Bearing (B) is fixed.

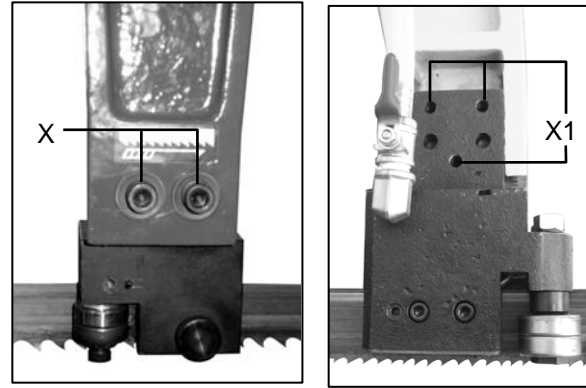


1. **Disconnect machine from the power source.**
2. Loosen blade guides by loosening guide adjustment screw (Z4.2).
3. Loosen locking screws (A) by using a hex wrench.
4. Adjust the eccentric bushings with a combination wrench until the ball bearings are snug to the blade (A)

**Note:** blade should travel freely up and down between the ball bearings. do not pinch the blade.

5. Tighten locking screws (A).
6. Connect machine to the power source.

#### 4.4 Adjusting the cutting precision

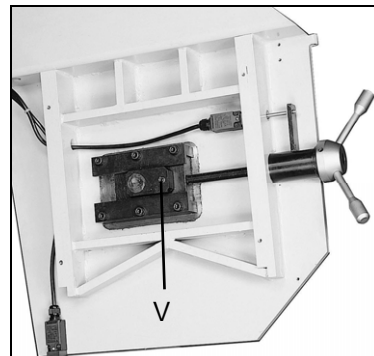


The cutting precision has been set at the factory. This adjustment should only be accomplished by a qualified personnel that are familiar with this type of adjustment.

- Disconnect the machine from power supply.
- Loosen the adjusting bolts (X) slightly, if needed.
- Use the setscrews (X1) to adjust the direction of the guide blocks.
- After adjusting, tighten the adjusting bolts (X).

#### 4.5 Blade tracking adjustment (Manual blade tension type)

This adjustment must be accomplished by qualified personnel that are familiar with this type of adjustment and the dangers associated with it.

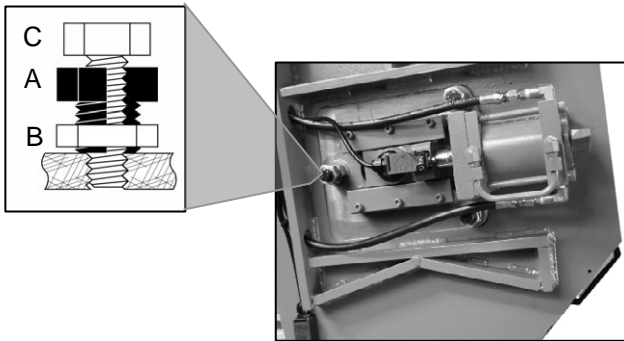


Blade tracking has been set at the factory and has no adjustment required. If a tracking problem occurs, adjust the machine as follows:

- Raise saw arm to the proper position.
- Locate tracking adjustment screw (V) on the front of the saw blade, flywheel side.
- Reduce the blade tension a little.
- Turn the tracking adjustment screw (V) to adjust the saw blade ride.
- Re-tension the blade tension.
- Connect the machine power to run the blade for 1-2 minutes. Then stop the machine operation.
- Remove the blade guides and open covers to check the blade tracking
- Close covers, replace the blade guides and tighten the setscrews.
- If necessary, readjust it again.

#### 4.6 Blade tracking adjustment (Hydraulic blade tension type)

This adjustment must be accomplished by qualified personnel that are familiar with this type of adjustment and the dangers associated with it.



The blade tracking has been set by factory and should not require any adjustment. If a tracking problem occurred, adjust the machine as follows:

- Raise saw arm to a usable height.
- Disconnect the machine from the power source.
- Locate tracking adjustment bolt on the backside of the saw bow behind the flywheel.
- Loosen hex cap screw C, located on the top of the track-adjusting bolt A and tracking nut B .
- Either raising or lowering track-adjusting bolt A accomplishes track adjusting.
- Tracking is set properly when the back of the blade lightly touches the wheel flange. Note: over tracking (allowing blade back to rub hard against wheel flange) will damage the blade wheels and blade.
- Tighten hex cap screw C and tracking nut B.
- Connect machine to the power source.

#### 4.7 Placing the saw blade onto the drive wheel and flywheel

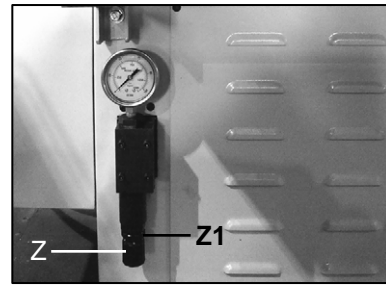
- Disconnect from power supply
- Remove the blade guards
- Turn the blade tension handle counterclockwise, to fully loosen the flywheel.
- Open the blade cover and place the saw blade onto the race of the drive wheel and flywheel.
- \*Check the cutting direction of the saw blade.
- Insert the saw blade into the rollers of the left and right blade guide.
- The back edge of the saw blade should make contact with the flange of the drive and flywheel; turn clockwise the blade tension handle to tighten the saw blade, until the blade is properly tensioned.
- Replace the blade guards.
- Use the blade running switch 3.1N to check the proper ride of the blade.

#### 4.8 Hydraulic vise pressure

The hydraulic vise pressure can be monitored and adjusted by a pressure gauge on the base of the machine. The normal pressure is set at 35kgs/cm<sup>2</sup>. This is good for most solid firm materials. For softer, hollow, or pipe materials reduce the pressure to over 25kgs/cm<sup>2</sup>. Other

materials may require different clamping force.

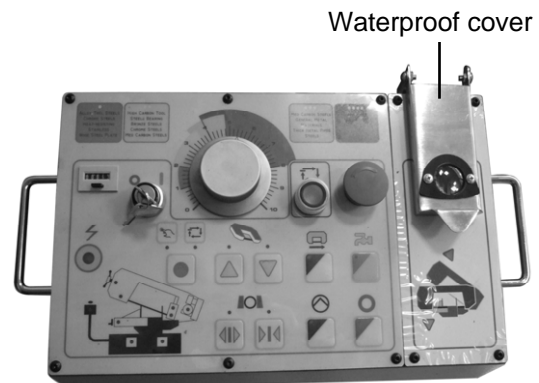
The clamping pressure may be adjusted by a knob at the base of the pressure gauge assembly.



- Start by pressing the vise close switch (3.1G) continuously in manual mode to have the vise clamp onto a work piece.
- Next, unlock the fluted knob (Z) by releasing fluted lock nut (Z1).
- Turn the fluted knob (Z) counterclockwise to decrease the pressure, clockwise to increase the vise pressure.
- Lock the fluted nut (Z1) after adjustment.

## 5 OPERATION PREPARATIONS

### 5.1 Setting the stroke limit



The numerical bow stroke height adjusting switch is covered with waterproof cover, set the bow height need to open the cover, after setting bow raise up stroke already, cover the cover to prevent the coolant permeate into the switch to cause the switch damaged.

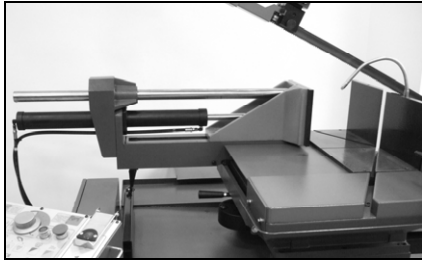


Q

This machine is equipped with a numeral switch Q to set the saw bow an efficient return height. If cutting lots of pieces, set the saw bow's return stroke height switch according to the work-piece's diameter will reduce the overall time of one operation cycle.

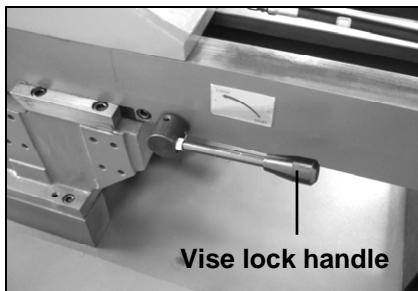
### 5.2 Positioning the vise

When cutting angles, the relocation of the vise is necessary to prevent the blade from cutting the hydraulic vise.



#### Adjusting the hydraulic vise for angle cutting

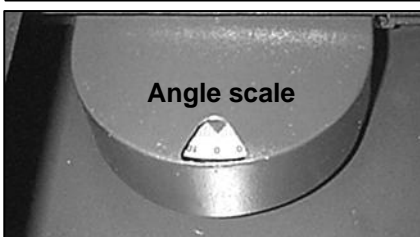
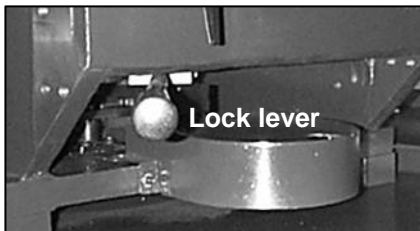
.- The saw bow must be raised to clear the vise.



- Unlock the hydraulic vise lock handle.
- Push the hydraulic vise toward other side.
- Visually check clearance of the blade and saw bow against the hydraulic vise. Readjust the position if necessary.
- Lock the hydraulic vise in position using its lock handle.

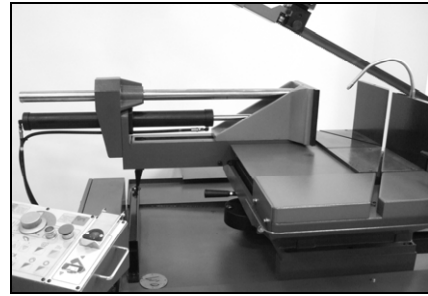
### 5.3 Angle cutting

The machine can cut angles up to 60° in both directions



- Check that the saw bow is raised to clear the vise fixed vise jaw.
- Turn off power.
- Unlock the saw bow by using the lock lever under the machine bench.
- Rotate the saw bow to the desired cutting angle. Refer to the scale to determine the proper angle.
- Lock the cutting angle in place by using the lock lever.
- Next, adjust the location of the vise to avoid contact with the blade.

### 5.4 Using the vise



The hydraulic vise operates automatically and can be controlled using the control panel. Use the vise open switch 3.1F and vise close switch 3.1G to open and close the vise. Power must be active. Hydraulics must be active.

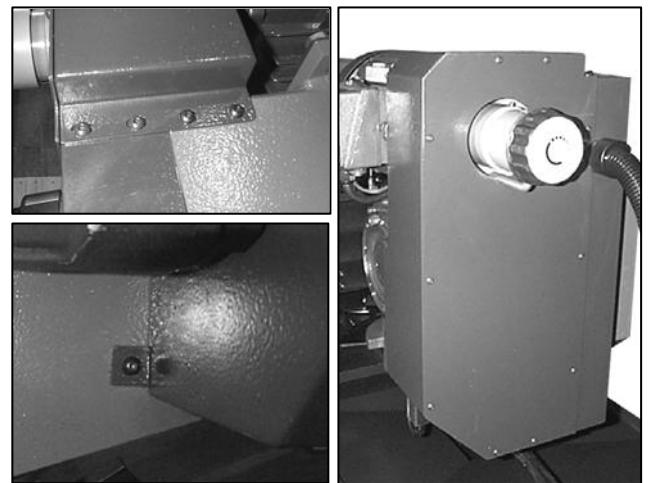
### 5.5 Adjusting the blade speed

\*Blade speed must be changed while belt and blade are moving.

- Check that the machine is running and blade is moving.
- Rotate the speed change dial 3.10 and check the speed indicator 3.9 for desired speed. Turn the dial clockwise to raise blade speed, and turn the dial counter clockwise to reduce blade speed. The speeds available are 26-80MPM (32-96FPM).

### 5.6 Changing the transmission belt

Over time and due to normal wear and tear the pulley belt will need to be changed.



- Disconnect the machine from power supply.
- Open the belt cover. Remove 4 screws from the top. Remove 1 screw from the front. Remove 8 screws from the cover.
- Turn the dial counter-clockwise to open the pulley discs and loosen the belt.
- Replace the belt.
- Turn the dial to pretension the belt.

### 5.7 Selecting Automatic and Manual operation

- To select manual mode, press operation mode switch 3.1 D.
- Check the indicator light 3.1 D1 lightening.
- To select automatic operation, press operation mode switch 3.1 D.
- Check the indicator light 3.1 D2 lightening.

### 5.8 Changing the blade (Manual blade tension type)



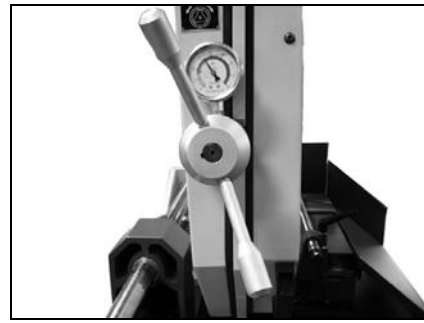
#### WARNING

**Disconnect the machine from the power source before making any adjustments or repairs! Failure to comply may result in serious injury!**

- Raise the saw bow approximately 6" in height.
- Disconnect the machine from the power source.
- Remove both blade guides from the blade guide blocks and cover.
- Loosen the cover's lock screws and open the covers.
- Take off the chip brush device by loosen it's screws.
- Loosen left blade guide arm's lock handles and slides it to the right side as far as possible.
- Release blade tension by turning the blade tensioning handle counter-clockwise until blade is free.
- Remove the old blade from both wheels and out of each blade guide.

**⚠ Caution:** Even dull blades are sharp to the skin! Use extra caution handling band saw blades!

- Position the blade and making sure that the teeth are pointed downward in the cutting direction.
- Position the blade on the wheels. Make sure back of the blade rests lightly against the wheel flange of the both wheels. Twist blade slightly to allow it to slip into guides.
- Tension the blade to the tension indicator shown line 460DSA. Replace the chip brush device so that it touches the blade and tighten setscrew.



- Close all covers and guards and fasten securely. Connect machine to power and run the blade freely for 1-2 minutes.
- Turn the power off and recheck the blade tension and chip brush. If further adjustment is necessary disconnect the saw from the power source, make adjustments, and re-connect the power.

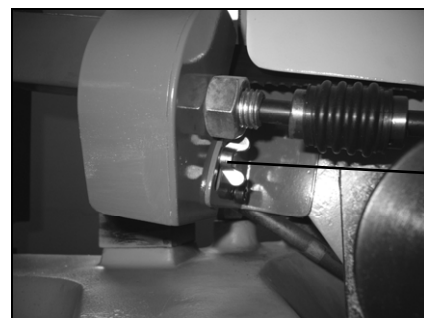
### 5.9 Changing the blade (Hydraulic blade tension type)



#### WARNING

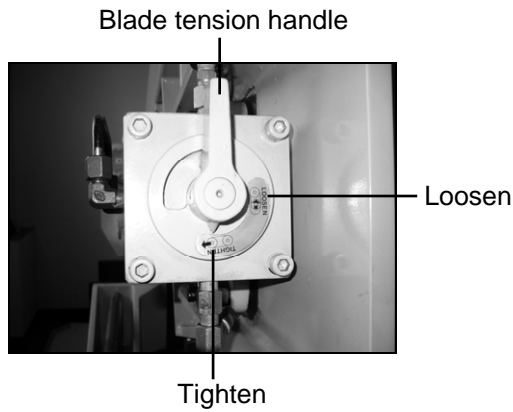
**Disconnect the machine from the power source before making any adjustments or repairs! Failure to comply may result in serious injury!**

- Raise the saw bow approximately 6" in height.
- Disconnect the machine from the power source.
- Remove both blade guides from the blade guide blocks and cover.
- Loosen the cover's lock screws and open the covers.
- Lower the chip brush device away from the blade by loosen the wing nut.



Wing nut

- Loosen left blade guide arm's lock handles and slides it to the right side as far as possible.
- Release blade tension by turning the blade tension handle counter-clockwise to the loosen position that blade will free.



- Remove the old blade from both wheels and out of each blade guide.

**⚠ Caution:** Even dull blades are sharp to the skin! Use extra caution handling band saw blades!

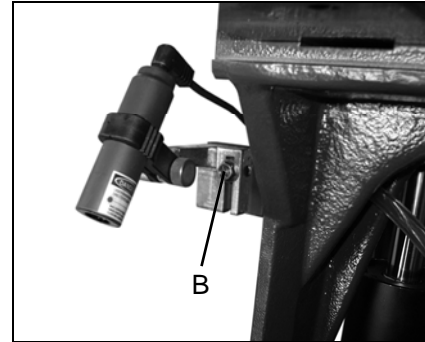
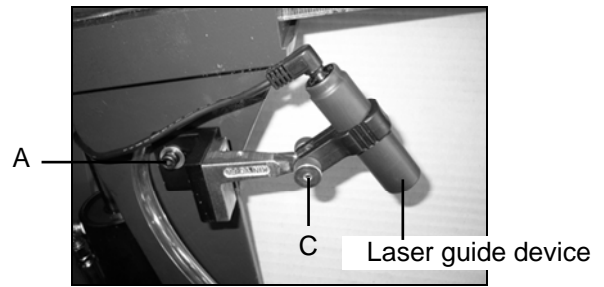
- Position the blade and making sure that the teeth are pointed downward in the cutting direction.
- Position the blade on the wheels. Twist blade slightly to allow it to slip into guides.
- Turn the blade tension handle to the tighten direction a little bit and check the blade to make sure back of the blade rests lightly against the wheel flange of the both wheels.
- Turn the blade tension handle to the Tighten position to tension the blade by the tension cylinder automatically.
- Replace the chip brush device so that it touches the blade and tighten setscrew.
- Close all covers and guards and fasten securely. Connect machine to power and run the blade freely for 1-2 minutes.
- Turn the power off and recheck the blade tension and chip brush. If further adjustment is necessary disconnect the saw from the power.
- Close all covers and guards and fasten securely. Connect machine to power and run the blade freely for 1-2 minutes.
- Turn the power off and recheck the blade tension and chip brush. If further adjustment is necessary disconnect the saw from the power source, make adjustments, and re-connect the power.

### 5.10 Laser guide device (optional)

The laser guide has been set correctly before shipment. The laser guide - line works when machine power on, the red line will align and close with the blade.

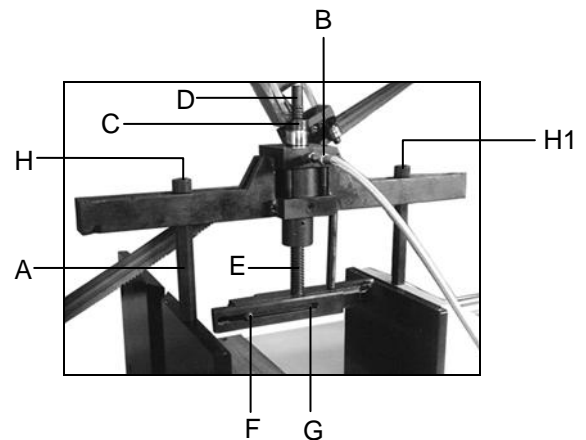
if any situations have to readjust Laser device, see below pictures.

- A screw for moving the device forward or backward.
- B screw for moving the device downward or upward.
- Loosen C thumb knob for adjust the device angle.

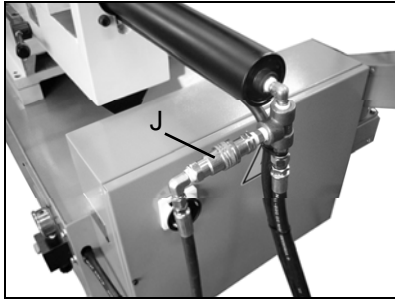


### 5.11 Install the vertical press on the vise jaws for bundle cutting (optional)

- Standard press capacity (W x H) 250~485 x 150~240 mm. Vise plates height 240 mm
- Special press capacity (W x H) 250~485 x 300~400 mm. Vise plates height 400 mm



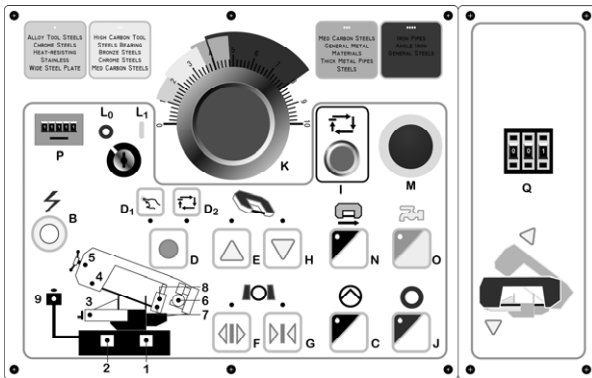
- Open the vise more than 250mm.
- Attach and Tighten posts' (A) on to vises. Then attach the vertical press to the top of the post bolts. Connect the Hydraulic connector (B).
- Attach the nuts (H) on to the posts, but do not make the nut (H1) on moveable vise jaw too tight. \*Otherwise, the vise won't be able to clamp the work piece or the post bolts will be damaged.
- Adjust the vise press (E) to sit approximately 5-8mm above the work piece. Loose nut (C) and rotate the bolt (D) to raise or lower the vise press (E).
- Adjust the vise press width to fit the work piece size. Loosen screws (F) on both sides of the vise press then move press extender bars (G) desired width.



- Turn OFF the hydraulic pump.
- Attach the hydraulic hose to connector (B) and then attach the quick link connector (J) to the 90-degree fitting.
- Switch ON the hydraulic pump.

## 6 OPERATION CYCLE

### 6.1 Operation cycle



- Turn on the main connect switch A. on the door of electrical box.
- Turn the key to automatic operation mode L1 to unlock the machine. The indicator light B should be lit.
- Start the hydraulic system, use switch C.
- Press the selector D to manual operation mode D1, and its indicator light will be lit.
- Raise the saw bow, Use bow up switch E.
- Open the vise, use vise open switch F.
- Load the working material.
- Secure the material, use the vise close switch G.
- Base on the diameter of the material; set the saw bow's height Q.
- Choose the blade speed appropriate for the material.
- If cutting many pieces, set the saw bow return stroke height.
- Select the operation cycle mode 6.1 D2 to press the selector 6.1 D. The indicator light will be lit.
- Restart the hydraulic system. Press the hydraulic start switch 6.1 C.
- Start operation by using the start switch 6.1 I.
- The digital display 6.1 P will present pieces cut.
- When the cutting operation is finished the saw bow will automatically rise to the preset height ready for the next operation.

### 6.2 Stopping or emergency stopping

There are two ways to stop the machine in an event of an emergency or improper operation.

- For most situations, use the stop switch 6.1 J. Using the stop switch 6.1 J will not reset the controls and your operation setting. The blade and drive motor will stop. Then the saw bow will rise to the start position. Adjustments can be made.
- Use the cycle start switch to continue the cutting cycle.
- For unsafe and emergency conditions use the emergency stop button 6.1 M. Using emergency stop button 6.1 M will stop the machine in last position. The motor and hydraulic will stop and control setting will be reset.
- To restart, the emergency stop button 6.1 M must be turned to release from the pressed position. Then the operation cycle 6.1 must be restarted.

### 6.3 Automatic shutoff during machine operation

If there are any improper operation or situation, the machine is designed to automatically shut off during the operation cycle to prevent any further damage from occurring.

- If the hydraulic pump is on and the machine has not been active for 5 minutes, the power will be shut off.
  - If the time take to clamp the vise is over 40 sec, the power will shut off. The vise pressure warning light will flash in warning.
  - After cutting the saw bow has taken more than 40 sec to rise to the start position, the power will shut off. The upper stroke-limit indicator light will flash in warning.
  - After pressing the start button, the vise clamps the work piece, and saw bow begins cutting. If the cutting time is unable to finish within 90 minutes, the lower stroke limit indicator will flash in warning and the power will be shut off.
- If any of the above situations occurs, reset the machine by pressing 6.1D. This will change the operation mode – manual or automatic.

## 7 ROUTINE AND SPECIAL MAINTENANCE

The maintenance jobs are listed below, divided into daily, weekly, monthly and six-month intervals. If the following operations are neglected, the result will be premature wear of the machine and poor performance.

### 7.1 Daily maintenance

- Give general cleaning to the machine to remove accumulated shavings.
- Clean the lubricating coolant drain hole to avoid excess fluid.
- Top off the level of lubricating coolant.
- Check blade for wear.
- Rise of saw frame to top position and partial slackening of the blade to avoid useless yield stress.
- Check functionality of the shields and emergency stops.

### 7.2 Weekly maintenance

- Thoroughly clean the machine to remove shavings, especially from the coolant tank.
- Removal of pump from its housing, cleaning of the suction filter and suction zone.
- Clean the filter of the pump suction head and the suction area.
- Use compressed air to clean the blade guides (guide bearings and drain hole of the lubricating cooling).
- Clean flywheel housings and blade sliding surfaces on flywheels.

### 7.3 Monthly maintenance

- Check the tightening of the drive wheel screws.
- Check that the blade guide bearings on the heads are perfect running condition.
- Check the tightening of the screws of the motor, pump, and accident protection guarding.

### 7.4 Six-monthly maintenance

- Test the continuity of the equipotential protection circuit.

### 7.5 Oils for lubricating coolant

Considering the vast range of products on the market, the user can choose the one most suited to their own requirements, using as reference the type SHELL LUTEM OIL ECO. THE MINIMUM PERCENTAGE OF OIL DILUTED IN WATER IS 8 - 10 %.

### 7.6 Oil disposal

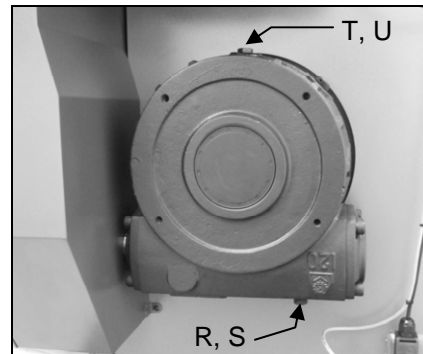
The disposal of these products is controlled by strict regulations. Please see the Chapter on "Machine dimensions Transport - Installation" in the section on Dismantling.

### 7.7 Special maintenance

Special maintenance must be conducted by skilled personnel. We advise contacting your nearest dealer and/or importer. Other protective and safety equipment, devices (of the reducer), the motor, the motor pump, and other electrical components also require special maintenance.

### 7.8 Changing gear oil

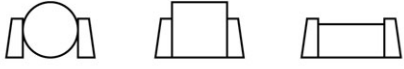
The gear box requires periodic changing of oil. The oil must be changed by the first 6 months of a new machine and every year thereafter.



- To change the gear box oil
- Lower the saw bow to horizontal position.
- Disconnect the machine from the power source.
- Release the drain hold (R) to draw off gear oil by loosening the hex head screw (S).
- Open fill hole (T) by releasing hex head screw (U)
- Replace the screw (S) after oil completely flows off.
- Filling in gear oil from T hole, until oil be sight from the visual glass.
- Replace hole using the fill hole (T).
- Replace hex head screw (U)

## 8 TECHNICAL CHARACTERISTICS

### 8.1 Table of cutting capacity and technical details

Cutting Capacity			
	90°	45°	60°
	460mm	460 x 460mm	440x600mm
	445mm	445 x 445mm	
	295mm	295 x 295mm	

Electric motor-blade rotation	3.7kW
Reduction unit in oil bath	40:1L
Blade Dimensions	41x1.3x5330mm
Blade speed cutting	32-96MPM
Coolant tank volume	55L
Hydraulic tank volume	15L
Machine weight	1320kgs
Packing measurement	2810x1130x1870mm

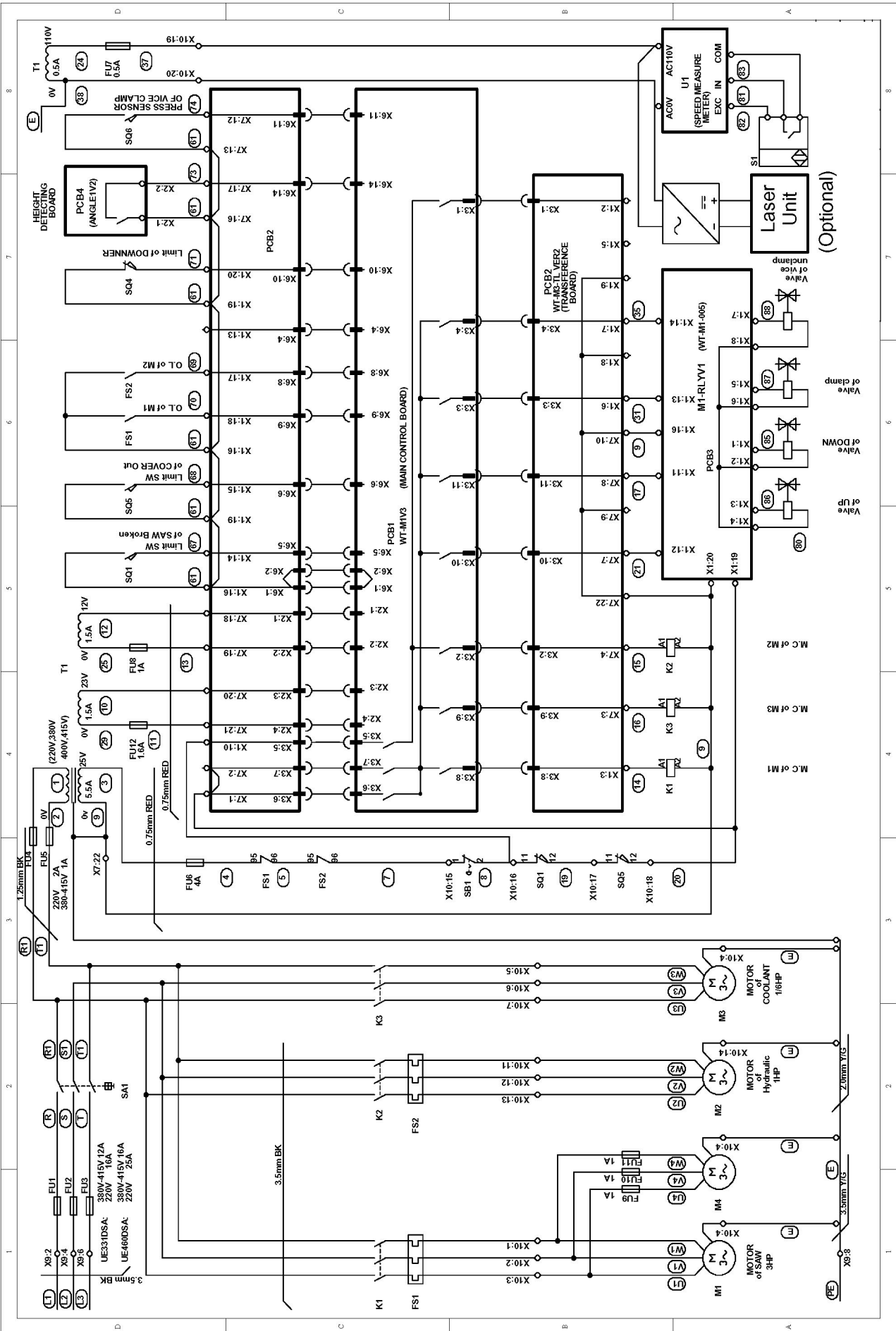
USE	TYPES OF STEEL					CHARACTERISTICS		
	I UNI	D DIN	F AF NOR	GB SB	USA. AISI-SAE	Hardness BRINELL HB	Hardness ROCKWELL HRB	R=N/mm²
Construction steels	Fe360	St37	E24	----	----	116	67	360÷480
	Fe430	St44	E28	43	----	148	80	430÷560
	Fe510	St52	E36	50	----	180	88	510÷660
Carbon steels	C20	CK20	XC20	060 A 20	1020	198	93	540÷690
	C40	CK40	XC42H1	060 A 40	1040	198	93	700÷840
	C50	CK50	----	----	1050	202	94	760÷900
	C60	CK60	XC55	060 A 62	1060	202	94	830÷980
Spring steels	50CrV4	50CrV4	50CV4	735 A 50	6150	207	95	1140÷1330
	60SiCr8	60SiCr7	----	----	9262	224	98	1220÷1400
Alloyed steels for hardening and tempering and for nitriding	35CrMo4	34CrMo4	35CD4	708 A 37	4135	220	98	780÷930
	39NiCrMo4	36CrNiMo4	39NCD4	----	9840	228	99	880÷1080
	41CrAlMo7	41CrAlMo7	40CADG12	905 M 39	----	232	100	930÷1130
Alloyed casehardening steels	18NiCrMo7	----	20NCD7	En 325	4320	232	100	760÷1030
	20NiCrMo2	21NiCrMo2	20NCD2	805 H 20	4315	224	98	690÷980
Alloyed for bearings	100Cr6	100Cr6	100C6	534 A 99	52100	207	95	690÷980
Tool steel	52NiCrMoKU	56NiCrMoV7C100K	----	----	----	244	102	800÷1030
	C100KU	C100W1	----	BS 1	S-1	212	96	710÷980
	X210Cr13KU	X210Cr12	Z200C12	BD2-BD3	D6-D3	252	103	820÷1060
	58SiMo8KU	----	Y60SC7	----	S5	244	102	800÷1030
Stainless steels	X12Cr13	4001	----	----	410	202	94	670÷885
	X5CrNi1810	4301	Z5CN18.09	304 C 12	304	202	94	590÷685
	X8CrNi1910	----	----	----	----	202	94	540÷685
	X8CrNiMo1713	4401	Z6CDN17.12	316 S 16	316	202	94	490÷685
Copper alloys Special brass Bronze	Aluminium copper alloy G-CuAl11Fe4Ni4 UNI 5275					220	98	620÷685
	Special manganese/silicon brass G-CuZn36Si1Pb1 UNI5038					140	77	375÷440
	Manganese bronze SAE43 - SAE430					120	69	320÷410
	Phosphor bronze G-CuSn12 UNI 7013/2a					100	56,5	265÷314
Cast iron	Gray pig iron		G25			212	96	245
	Spheroidal graphite cast iron		GS600			232	100	600
	Malleable cast iron		W40-05			222	98	420

### 8.2 NOISE TESTS

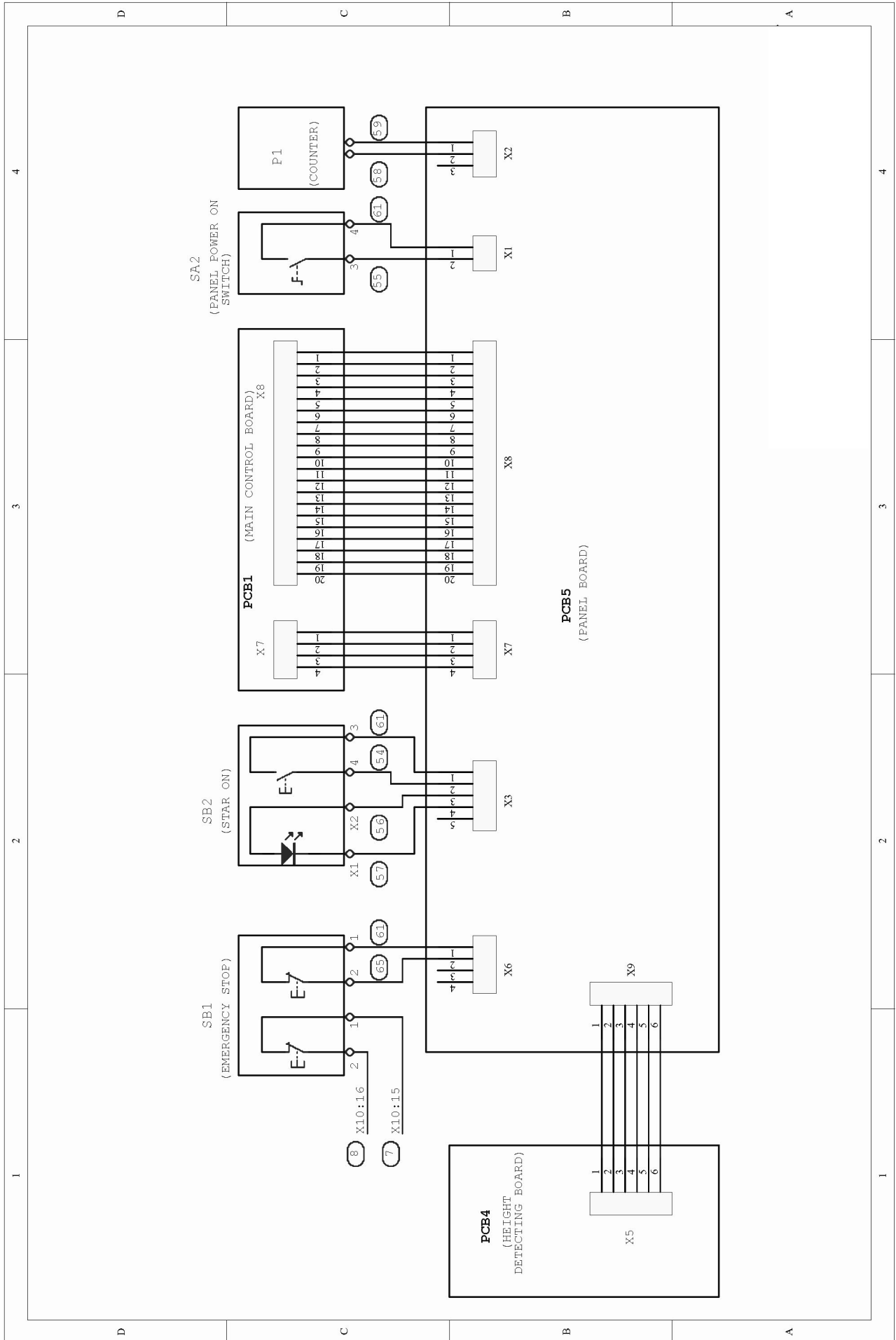
The test was held under environmental noise levels of 65db. Noise measurements with the machine operating unload was 71db. Noise level during the cutting of mild carbon steel was 73db.

NOTE: with the machine operating, the noise level will vary according to the different materials being processed. The user must therefore assess the intensity and if necessary provide the operators with the necessary personal protection, as required by Law 277/1991.

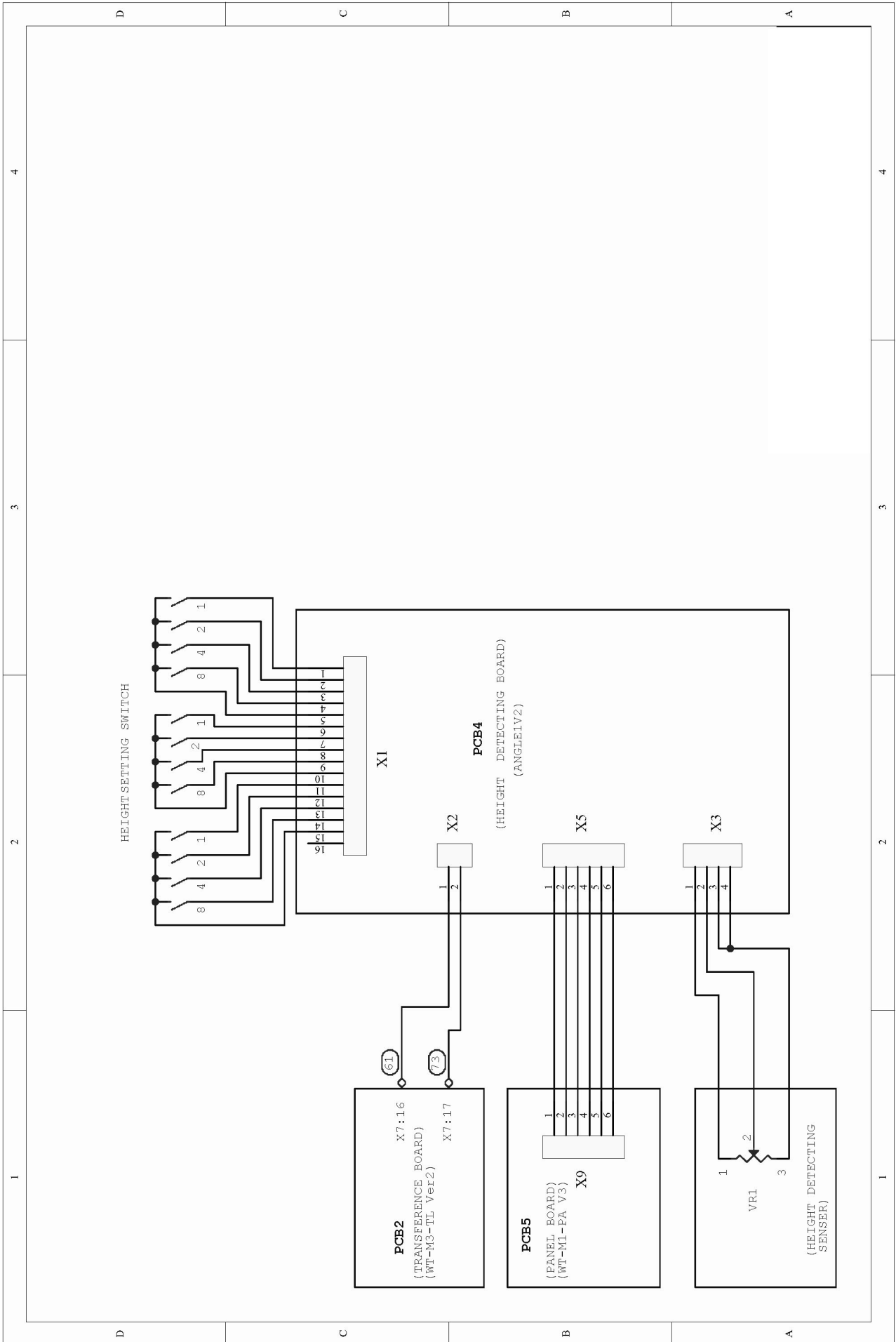
# Control Circuit Diagram



# Panel Board Wiring Diagram



# Saw Bow Stroke Wiring Diagram



## PART LIST

Part No.	Description	Size No.	Q'ty	Part No.	Description	Size No.	Q'ty
1	Base		1	54	Fuse Seat	10x38-1P	2
2	Hex. Cap Bolt	M8x20	12	55	Fuse Seat	ASK2S/(5X20-1P)	3
3	Spring Washer	M8	12	55A	Fuse Seat (Not shown, Non CE)	6X30-1P	3
4	Washer	M8	12	56	Transformer	CE-250VA	1
5	Supporter		1	57	Relay PC Board	M1-RLY	1
6	Set Screw	M6x6	2	58	Connector PC Board	WT-M3-TL	1
7	Hex. Socket Cap Screw	M6x12	2	59	Dual Terminal Connector	ASL-TD-015H	10
7-1	Spring Washer	M6	2	60	Fuse Seat	10x38-1P	3
8	Fixing Bracket		3	61	Ground Terminal Connector	AVK10T	1
8-1	Fixing Bracket (RF)		1	61A	Ground Terminal Connector (Not shown, Non CE)	HT-4E	1
8-2	Fixing Bracket		2	62	Terminal Connector	AVK10	3
9	Nut	M8	12	62A	Terminal Connector (Not shown, Not CE)	HT-10	3
10	Spring Washer	M8	12	63	Grounding Plate	G-8P	1
11	Washer	M8	12	64	Overload Contactor	ABB-TA25DU 7.5~11A	1
12	Coolant Tray (L)		1	64A	Overload Contactor (Not shown, Non CE)	NTH-8~11A	1
12-1	Coolant Tray (R)		1	65	Overload Connector	ABB-TA25DU 2.2~3.1A	1
13	Hex. Cap Bolt	M8x20	12	65A	Overload Relay (Not shown, Not CE)	NTH-1.8~2.5A	1
14	Chip Drawer		1	67	Electric Box Cover		1
15	Side Coolant Tray		1	68	Power Switch (Upper)	YMXN6	1
16	Washer	M8	2	69	Washer	M6	1
17	Spring Washer	M8	2	70	Spring Washer	M6	1
18	Hex. Cap Bolt	M8x16	2	71	Hex. Socket Cap Screw	M6x30	1
19	Coolant Pump		1	72	Hinges	Ø8x50	2
20	Hex. Cap Bolt	M6x12	2	73	Main PC Board	WT-M1	1
21	Washer	M6	2	74	Control Panel		1
22	Pump Plate		1	74-1	Control PCB		1
23	Button Head Socket Screw	M6x12	2	75	Counter		1
24	Plate		1	76	Button Head Socket Screw	M5x8	10
25	Button Head Socket Screw	M6x8	4	77	Key Lock Power Switch		1
37	Hydraulic Unit		1	78	Cutting Feed Rate		1
38	Hex. Cap Bolt	M8x16	2	79	Cycle Start Switch		1
39	Front Plate		1	80	Emergency Stop Button		1
40	Button Head Socket Screw	M6x8	4	81	Stroke Panel		1
41	Hex. Cap Bolt	M16x60	4	81-1	Bow Height PCB		1
42	Nut	M16	4	82	Stroke Height Switch		1
43	Rear Plate		1	83	Button Head Socket Screw	M5x8	4
44	Button Head Socket Screw	M6x8	4	84	Plate		1
45	Vise Pressure Adjusting Valve		1	85	Handle		2
46	Electrical Box		1	86	Button Head Socket Screw	M5x8	4
47	Washer	M6	4	87	Control Box		1
48	Hex. Socket Cap Screw	M6x16	4	88	Cover		1
49	Electrical Plate		1	88-1	Round Head Screw	M6x8	6
50	Hex. Socket Cap Screw	M6x12	4	89	Control Box Bracket		1
51	Power Switch (Seat)	XA323B/B-40A	1	89-1	Button Head Socket Screw	M6x8	4
52	Contactor	A9-40-00 (COIL: AC24V)	2	90	Swiveling Bracket		1
52A	Contactor (Not shown, Non CE)	C09D10A7 (COIL: AC24V)	2	90-1	Hex. Socket Cap Screw	M6x16	4
53	Contactor	A12-30-10 (COIL: AC24V)	1	91	Hex. Cap Bolt	M8x16	4
53A	Contactor (Not shown, Non CE)	C12D10A7 (COIL: AC24V)	1	91-1	Spring Washer	M8	4

## PART LIST

Part No.	Description	Size No.	Q'ty	Part No.	Description	Size No.	Q'ty
92	Handle	M8x30	1	144	Hex. Socket Cap Screw	M8x20	8
93	Swiveling Base		1	145	Hex. Cap Bolt	M5X15	1
94	Set Screw	M8x20	2	146	Wire Connector		1
95	Nut	M8	2	147	Swiveling		1
96	Connect Base		1	148	Shaft		1
96-1	Spring Washer	M8	4	149	Taper Bearing	30312	2
96-2	Hex. Cap Bolt	M8x16	4	150	Upper Cover		1
98	Plate		1	151	Set Screw	M6x25	1
99	Button Head Socket Screw	M5x8	4	152	Hex. Socket Cap Screw	M8x20	8
100	Cam Shaft		1	153	Tighten Plate		1
101	Bearing	6000ZZ	1	154	O Ring	ØP60	2
102	Spring Washer	M10	1	155	Hex. Cap Bolt	M20x65	1
103	Nut	M10	1	156	Nut	M20	1
104	Cam Seat		1	157	Hex. Cap Bolt	M10x60	1
105	Button Head Socket Screw	M8x25	2	158	Nut	M10	1
106	C Ring	S16	1	159	Screw Holder		2
107	Hex. Socket Cap Screw	M10x40	1	160	Spring Bracket		1
108	Extend Spring		1	161	Washer	1/2"	2
109	Nut	M10	1	162	Nut	1/2"	2
110	Joint Plate		1	163	Spring Washer	M8	4
111	Set Bolt		1	164	Hex. Socket Cap Screw	M8x25	4
112	Connect Unit		1	165	Cutting Bench		1
113	Hex. Socket Cap Screw	M10x50	1	166	Pin	Ø8x20	2
114	Handle Level		1	167	Hex. Socket Cap Screw	M10x60	2
115	Nut	M12	1	168	Cutting Plate		1
116	Handle		1	169	Hex. Socket Cap Screw	M10x55	2
117	Angle Setting		1	170	Hex. Socket Cap Screw	M8x20	2
118	Hex. Socket Cap Screw	M8x20	2	171	Vise Jaw-Left		1
119	Set Block		1	172	Vise jaw-Right		1
120	Button Head Socket Screw	M6x8	2	173	Hex. Socket Cap Screw	M10x30	8
121	Cover		1	174	Hex. Socket Cap Screw	M8x20	4
121-1	Hex. Socket Cap Screw	M4x6	2	175	Vise Plate		1
121-2	Magnifier Holder		1	176	Hex. Socket Cap Screw	M8x20	1
121-3	Angle Magnifier		1	177	Hex. Socket Cap Screw	M12x30	2
122	Hex. Socket Cap Screw	M10x40	1	178	Vise Jaw		1
123	Washer		1	179	Vise Slide		1
124	Angle Wheel		1	180	Cylinder		1
125	Wire Connector		1	181	Hex. Socket Cap Screw	M12x30	2
126	Hex. Cap Bolt	M5x15	1	182	Hex. Socket Cap Screw	M10x40	6
127	Bush		1	182-1	Spring Washer	M10	6
128	Steel Wire	Ø1.2	1	183-1	Rod Seat		1
129	Extend Spring		1	183-2	Oil Less Bush	45x55x40	2
130	Bed Plate		2	183-3	Rod		1
131	Pin	Ø8x20	4	183-4	Vise Table		1
132	Hex. Socket Cap Screw	M12x130	6	183-5	Spring Pin	M8x20	2
133	Set Screw	M12x25	4	183-6	Position Plate		1
134	Bed		1	183-7	Hex. Socket Cap Screw	M12x35	4
135	Nut	M10	1	184	Bench Supporter		1
136	Hex. Socket Cap Screw	M10x40	1	185	Nut	M10	1
137	Seating Block		2	186	Spring Washer	M10	2
138	Hex. Socket Cap Screw	M10x35	4	189	Bearing	6200ZZ	1
139	Hex. Socket Cap Screw	M10x20	5	190	Spring Washer	M10	2
140	Spring Washer	M10	5	191	Hex. Socket Cap Screw	M10x30	1
141	Pin	Ø8x20	2	192	Handle		1
142	Angle Plate		1	193	Handle Rod		1
143	Lower Cover		1	194	Nut	M10	1

## PART LIST

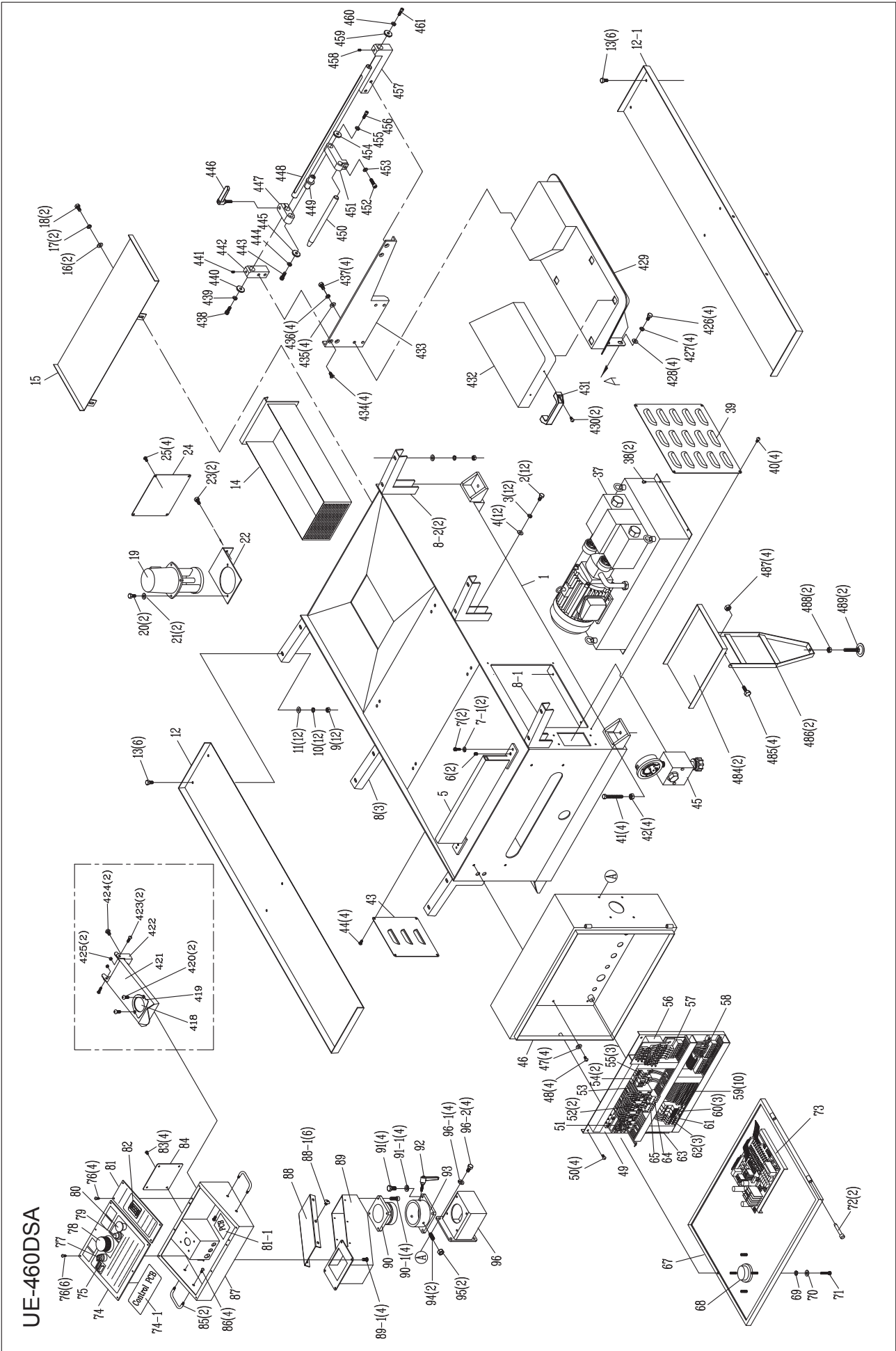
Part No.	Description	Size No.	Q'ty	Part No.	Description	Size No.	Q'ty
195	Adjusting Part		1	247	Spring Washer	M10	4
196	Set Screw	M8x8	2	248	Washer	M10	4
197	C Ring	S17	2	249	Set Screw	M8x16	6
198	Shaft		1	250	Adjustable Bracket-Left		1
199	Key	5x5x20	1	251	Lock Handle	M12x50	2
200	Cam		1	252	Lock Block		2
201	Hex. Socket Cap Screw	M6x16	1	253	Round Head Screw	M5x8	5
202	Hex. Cap Bolt	M6x16	1	254	Steel Plate		1
203	Nut	M6	1	255	Hex. Socket Cap Screw	M10x20	4
204	Bolt		1	256	Set Screw	M10x16	4
205	Hex. Socket Cap Screw	M8x40	2	257	Set Plate		1
206	Spring Washer	M8	2	258	Tension Spring		2
207	Washer	M8	2	259	Hex. Socket Cap Screw	M10x25	3
208	Set Block		1	260	Spring Washer	M10	3
209	Set Screw	M8x8	2	261	Spring Bracket		1
210	Set Block		1	262	Washer	1/2"	4
211	Copper Parts		2	263	Nut	1/2"	4
212	Vise Guide		1	264	Brush		1
213	Hex. Socket Cap Screw	M12x35	4	264-1	Nut	M6	1
214	Plate		1	264-2	Spring Washer	M6	1
215	Spring Washer	M8	2	264-3	Washer	M6	1
216	Hex. Cap Bolt	M8x20	2	265	Oil Less Bush	1212	2
217	Retrieval Vise		1	266	Set Bush		1
218	Set Handle	M8x30	1	267	Brush Cover		1
219	Round Head Screw	M6x8	2	268	Brush Bracket		1
220	Handle		1	268-1	Hex. Cap Bolt	M8x20	2
221	Handle Seat		1	268-2	Spring Washer	M8	2
222	Pin	Ø6x28	1	268-3	Washer	M8	2
223	Screw Sleeve		1	269	Wing Screw	M6x10	1
224	Set Handle	M12x45	1	270	Spring Washer	M6	1
225	Rod		1	271	Hex. Socket Cap Screw	M6x20	1
226	Set Screw	M8x8	1	272	Brush Shaft		1
227	Sleeve Rod		1	273	Nut	M20	1
228	Shaft		1	274	Brush Rod		1
229-1	Mobile Fence		1	274-1	Key	4x15	4
230	Set Screw	M8x8	1	275	Universal Joint		2
231	Blade Cover		1	275-1	Set Screw	M5x6	8
231-1	Button Head Socket Screw	M6x8	2	276	Plastic Cover		2
235	Blade Guide-Right		1	277	Safety Cover		1
236	Pin	Ø4x12	1	277-1	Button Head Socket Screw	M5x8	2
237	Adjustable Bracket-Right		1	278	Brush Bracket		1
237-1	Laser Device	(Optional)	1	278-1	Spring Washer	M8	2
237-2	Laser Bracket		1	278-2	Hex. Socket Cap Screw	M8x20	2
237-3	Screw	M6	1	279	Nut	M6	8
237-4	Hex. Socket Cap Screw	M5x15	1	280	Brush Motor		1
237-5	Spring Washer	M5	1	281	Hex. Socket Cap Screw	M6x90	4
237-6	Washer	M5	1	282	Set Plate		1
238	Button Head Socket Screw	M6x16	4	283	Spring Washer	M6	2
239	Fixed Bracket		2	284	Hex. Socket Cap Screw	M6x12	2
240	Pin	Ø8x70	2	285	Sensor		1
241	Button Head Socket Screw	M8x30	4	286	Round Head Screw	M3x20	2
242	Free Block		2	287	Nut	M3	2
243	Pin	Ø4x12	1	288	Saw Bow		1
244	Knob	M5x8	1	289	Spring Washer	M12	4
245	Blade Guide-Left		1	290	Hex. Cap Bolt	M12x45	4
246	Hex. Socket Cap Screw	M10x35	4	291	Lock Pin		1

## PART LIST

Part No.	Description	Size No.	Q'ty	Part No.	Description	Size No.	Q'ty
292	Drive Wheel		1	347	Bearing	51203	1
293	Washer		1	348	Bolt Sleeve		1
294	Flat Head Hex. Soc. Screw	M12x25	1	349	Key	5x5x30	1
295	Hex. Socket Cap Screw	M12x70	4	350	Set Screw	M8x10	1
296	Washer		1	351	Handle Wheel		1
297	Upper Shaft		1	352	Handle		2
298	Holder		1	353	Limit Switch		1
299	Nut	M20xP1.5	1	354	Hex. Socket Cap Screw	M4x35	2
300	Saw Bow Cylinder		1	355	Washer		1
301	C Ring	S20	4	356	C Ring	S45	2
302	Hex. Socket Cap Screw	M8x20	2	357	Shaft Device		1
303	Cylinder Seat		1	358	Slide		1
304	Lower Shaft		1	359	Shaft	Ø16x90	1
305	Block		1	360	Set Screw	M12x25	1
306	Spring Washer	M8	2	361	Slide Guide		2
307	Button Head Socket Screw	M8x40	2	362	Slide Plate		2
308	Round Shaft		2	363	Spring Washer	M10	6
309	Sidle Wheel		2	364	Hex. Socket Cap Screw	M10x60	6
310	Bearing	6005	2	365	Blade Cover		1
311	C Ring	R42	2	366	Button Head Socket Screw	M6x8	4
312	Washer	M10	2	367	Limit Switch		1
313	Spring Washer	M10	2	368	Hex. Socket Cap Screw	M4x30	2
314	Hex. Socket Cap Screw	M12x60	2	369	Button Head Socket Screw	M5x8	2
315	Steel Plate Holder		2	370	Indicator Seating		1
316	Washer	M10	4	371	Oil Less Bush	4040	2
317	Spring Washer	M10	4	372	Set Block		2
318	Hex. Socket Cap Screw	M10x30	4	373	Hex. Cap Bolt	M10x20	1
319	Taper Bearing	32009	2	374	Nut		1
320	Idle Wheel		1	375	Spring Washer		1
321	Anti-Dust Cover	32009AV	2	376	Washer		1
322	Star Washer	AW09	1	377	Sensor Bracket		1
323	Nut	AN09	1	378	Sensor		1
324	Cover Switch		1	379	Round Head Screw	M4x10	2
325	Hex. Socket Cap Screw	M4x30	2	380	Cover		1
326	Nut	M8	2	381	Button Head Socket Screw	M5x8	4
327	Bracket		1	382	Gear Box		1
328	Upper Bush		1	383	Key	12x8x50	1
328-1	Lower Bush		1	384	Motor		1
328-2	Holding Bracket Bush		1	385	Hex. Cap Bolt	M10x35	4
329	Round head Socket Screw	M8x25	4	386	Spring Washer	M10	4
330	Bracket		1	387	Washer	M10	4
331	Holding Bracket		1	388	Key	10x8x40	1
332	Spring		1	389	Pulley Cover		1
333	Safe Locker		1	390	Belt	1922V504	1
334	Set Screw	M4x12	2	391	Variable Speed Adjustable		1
335	Hex. Cap Bolt	M8x20	2	392	Input Pulley		1
336	Spring Washer	M8	2	393	Hex. Socket Cap Screw	M8x65	1
337	Hex. Cap Bolt	M8x20	1	394	Cover		1
338	Disc Washer Seat		1	394-1	Cover		1
339	Spring Pin	M5x12	2	394-2	Button Head Socket Screw	M5x8	2
340	Disc Washer		8	395	Button Head Socket Screw	M5x8	8
341	Slide Bolt		1	396	Long Bearing Shaft		4
342	Hex. Cap Bolt	M8x60	1	397	Bearing	6201	8
343	Nut	M8	1	398	Bearing Bush (long)		2
344	Plate		1	399	Bearing Bush (short)		2
345	Bushing		1	400	Spring Washer	M10	4
346	Blade Tension Gauge		1	401	Nut	M10	4

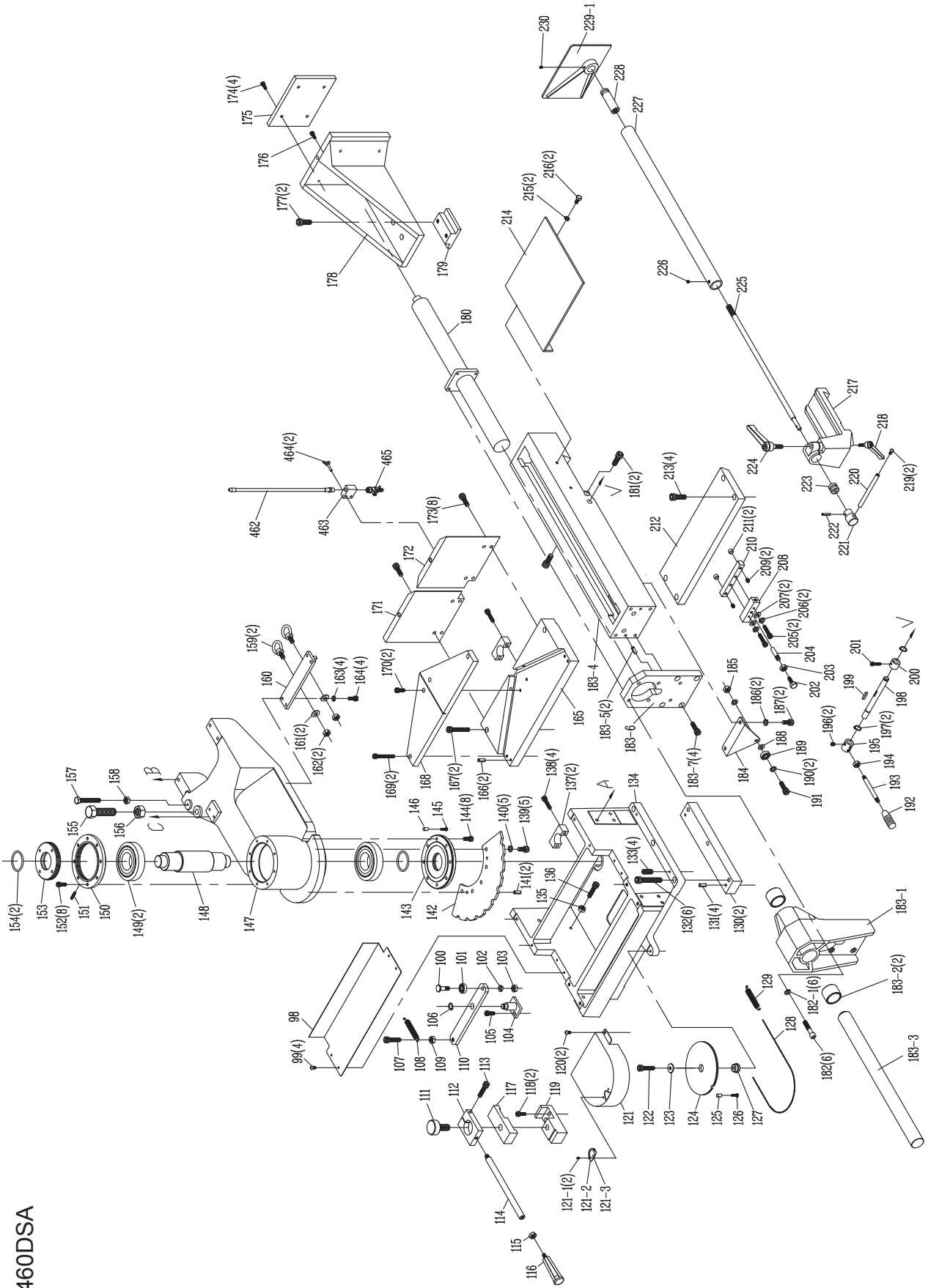
## PART LIST

Part No.	Description	Size No.	Q'ty	Part No.	Description	Size No.	Q'ty
402	Hex. Socket Cap Screw	M6x20L	4	458	Set Screw	5/16"x5/16"L	1
403	Adjusting Knob		2	459	Washer		1
404	Spring		2	460	Spring Washer	3/8"	1
405	Shaft		2	461	Hex. Socket Cap Screw	3/8"x1"L	1
406	Hex. Socket Cap Screw	M8x40L	2	462	Hose		1
407	Front Bearing Seat		1	463	Pipe Fitting Seat		1
408	Bearing	6200	4	464	Wing Screw	M6x30L	2
409	Bearing Bracket		2	465	Coolant Switch	1/4"PTx1/4"	1
410	Bush		2	466	Hex. Socket Cap Screw	M10x150L	4
411	Shaft		4	467	Spring Washer	M10	4
412	Carbide Guide (Left front)		1	468	Blade Tension Cylinder		1
413	Carbide Guide (Left back)		1	469	Tension Slider		1
414	Spring Pin	D5x12L	4	470	Limit Switch for Tension		1
415	Rear Bearing Seat		1	471	Hex. Socket Cap Screw	M12x25L	2
416	Carbide Guide (Right front)		1	472	Slide Plate		2
417	Carbide Guide (Right back)		1	473	Idle Wheel Washer		1
418	Bow Height Magnifier		1	474	Spring Washer	M12	1
419	Magnifier Bracket		1	475	Hex. Socket Cap Screw	M12x25L	1
420	Round Head Screw	M4x6L	2	476	Hex. Socket Cap Screw	M8x20L	6
421	Height Scale Cover		1	477	Spring Washer	M8	6
422	Cover Bracket		1	478	Hex. Cap Bolt	M12x70L	3
423	Round Head Screw	M4x12L	2	479	Spring Washer	M12	3
424	Big Round Head Screw	M4x6L	2	480	Adjusting Screw		3
425	Nut	M4	2	481	Nut	M22x2.5	3
426	Hex. Cap Bolt	M12x25L	4	482	Slider Seat		1
427	Spring Washer	M12	4	483	Idle Wheel Shaft		1
428	Washer	M12	4	484	Movable Coolant Tray		2
429	Outlet Support		1	485	Hex. Cap Bolt	M6x12L	4
430	Big Round Head Screw	M6x12L	2	486	Tray Bracket		2
431	Handle		1	487	Nut	M6	4
432	Movable Support		1	488	Nut	1/2"	2
433	Side Support Plate		1	489	Adjusting Screw		2
434	Flat Head Screw	5/16"x3/4"L	4	490	Cock	1/4x1/4	1
435	Washer	M10	4	491	Spring Washer	M12	1
436	Spring Washer	M10	4	492	Fixing Bracket		1
437	Hex. Cap Bolt	M10x25L	4	493	Fitting	1/4x1/4	1
438	Hex. Socket Cap Screw	3/8"x1"L	1	494	Big Round Head Screw	M6x8L	2
439	Spring Washer	3/8"	1	495	Fitting	1/4x1/4	1
440	Washer		1	496	Hose	1/4"x185mm	1
441	Set Screw	5/16"x5/16"L	1	497	Hose	1/4"x2215mm	1
442	Right Positioning		1	498	Cock	1/4x1/4	1
443	Hex. Socket Cap Screw	3/8"x1"L	1	499	Nozzle Set		1
444	Spring Washer	3/8"	1	500	Nozzle	1/4"x18"L	1
445	Washer		1	501	Y Fit		1
446	Lock Handle		1	502	Hose	1/4"x2700mm	1
447	Length Adjusting Block		1	503	Hose	1/4"x1580mm	1
448	Length Rod		1	504	Cock	1/4x1/4	1
449	Welding Shaft		1	505	90° Fitting	1/4x1/8	1
450	Stop Bar		1	506	Fitting	3/8x1/4	1
451	Position Bracket		1	507	90° Fitting	3/8x1/4	1
452	Hex. Socket Cap Screw	3/8"x1"L	1	508	Fitting Set	3/8	1
453	Spring Washer	3/8"	1	509	90° Fitting	1/2x3/8	1
454	Washer		1	510	Coolant Pump	1/6"x150L	1
455	Spring Washer	3/8"	1	511	Hose	1/4"x1400mm	1
456	Hex. Socket Cap Screw	3/8"x1"L	1				
457	Left Positioning		1				



1000307-V4

UE-460DSA

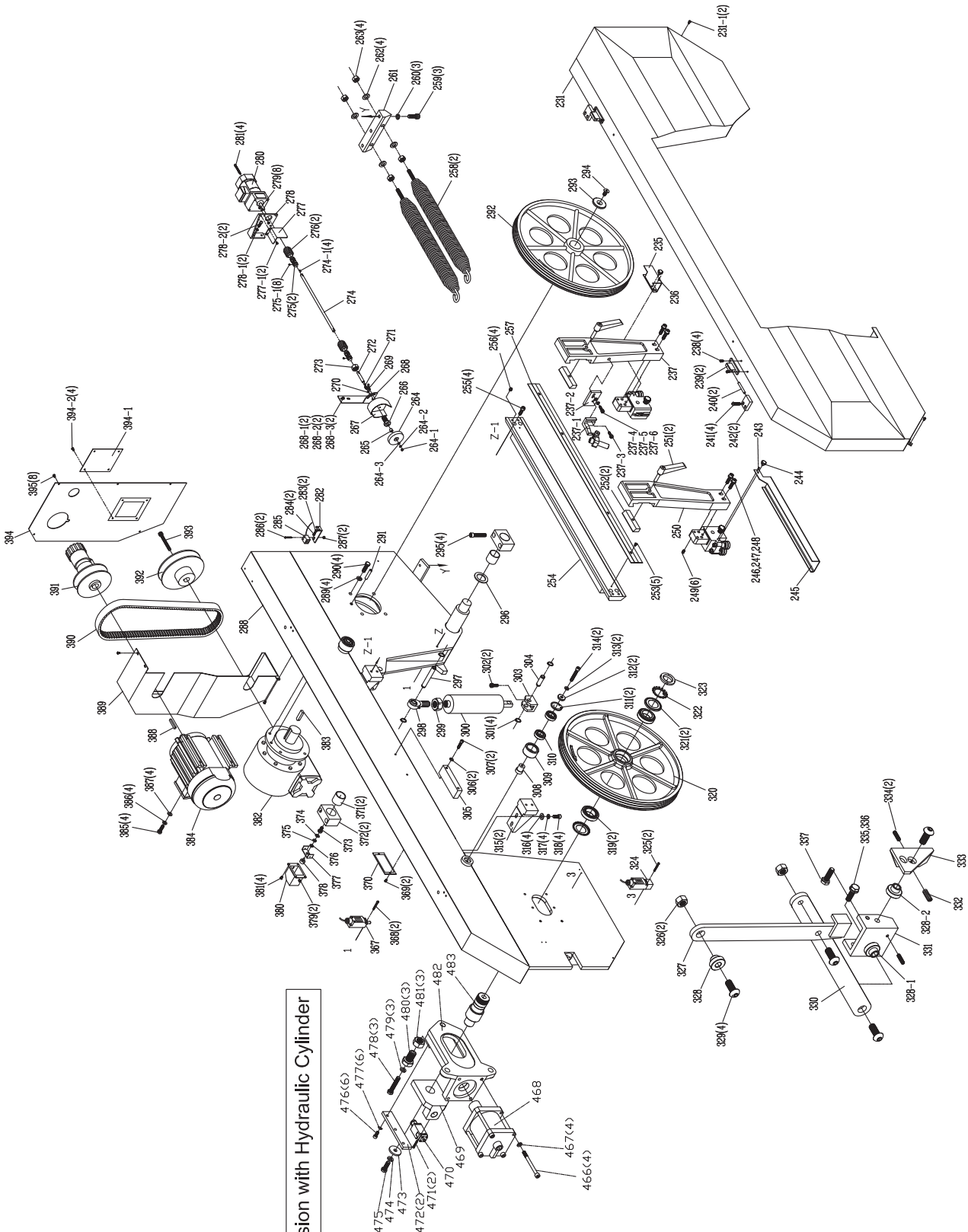




UE-460DSA

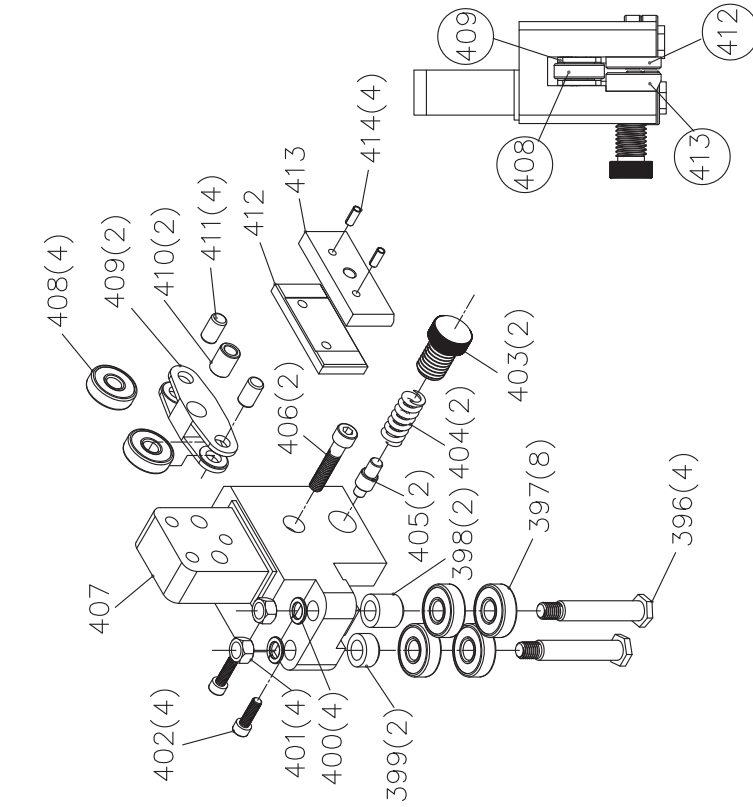
Blade Tension with Hydraulic Cylinder

1000307-V3

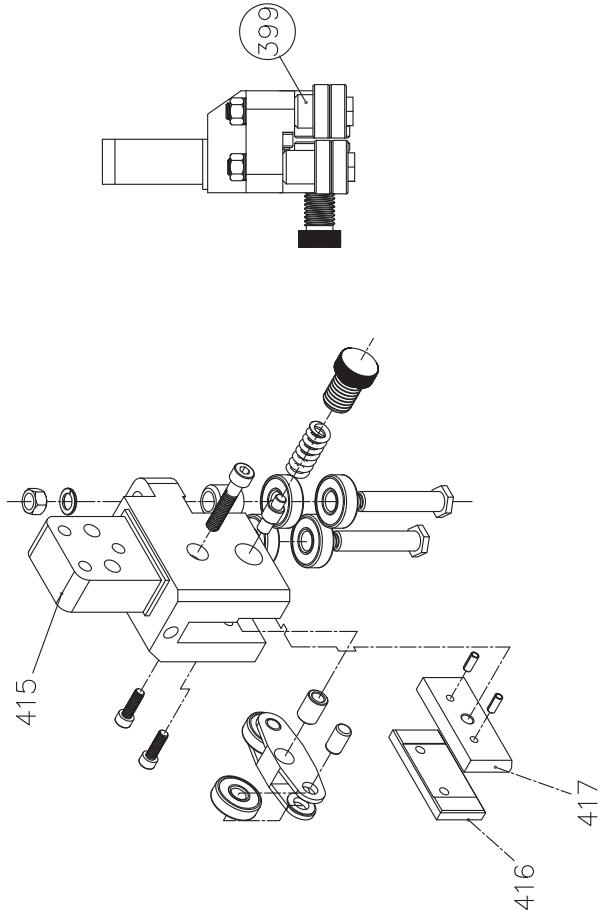


UE-460DSA

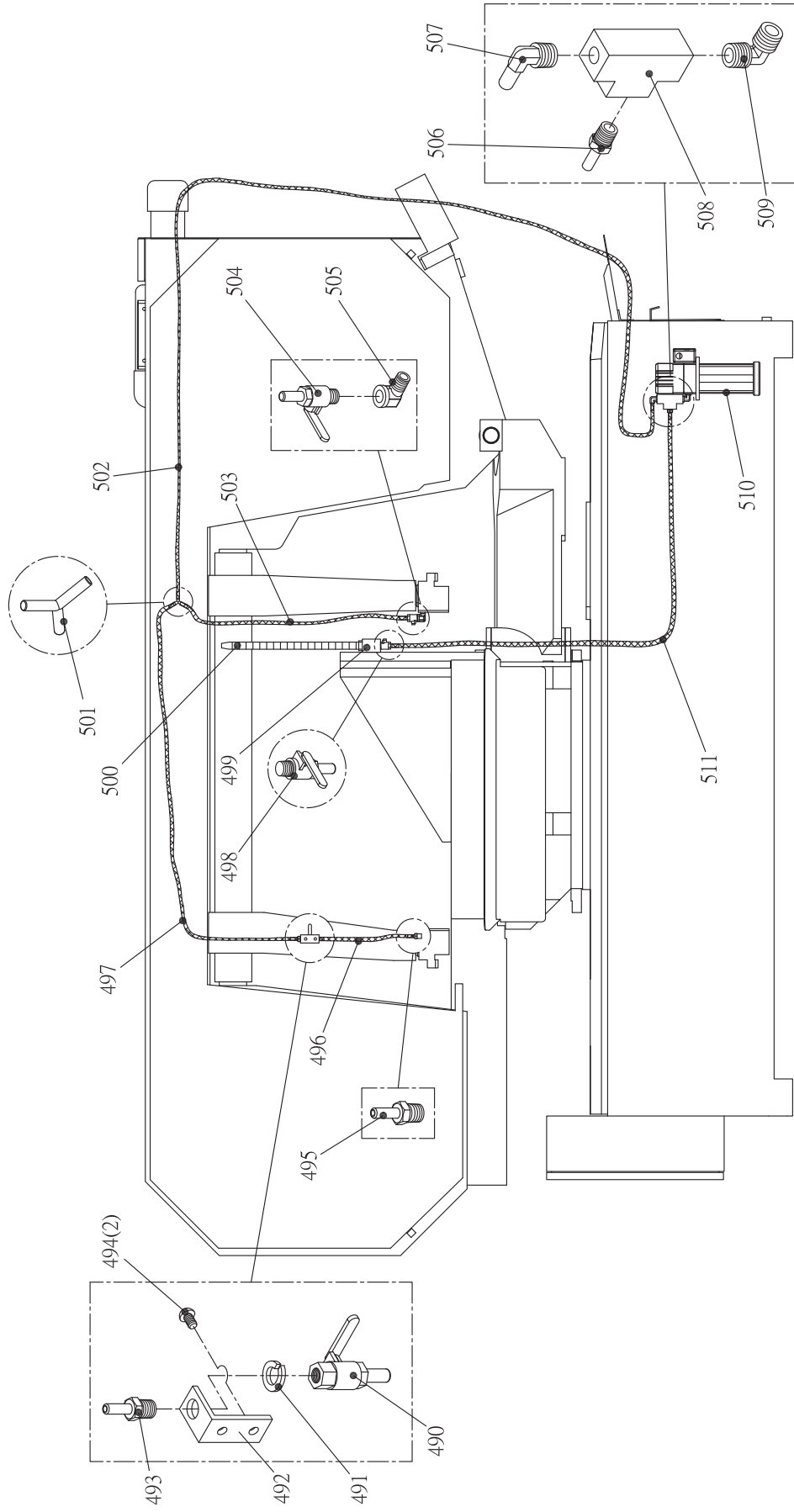
FRONT BEARING SEAT



REAR BEARING SEAT



UE-460DSA



1000622-V1