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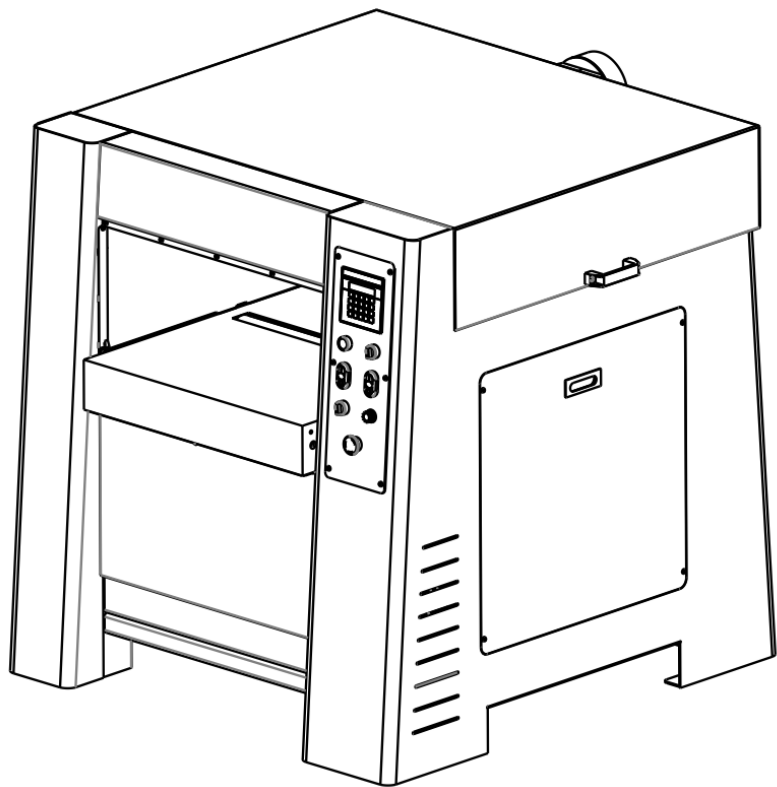


TOUGH CUT

USE AND MAINTENANCE HEAVRY-DUTY THICKNESSER

ILMENITE 530D

ILMENITE 630D



IMPORTANT

KEEP THIS HANDBOOK FOR FUTURE INFORMATION BESIDES IT SHALL ALWAYS BE WITH THE MACHINE.



Always wear safety glasses when using woodworking equipment.



Always read the instructions provided before using woodworking equipment.

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1. GENERAL INFORMATION

1.1 FOREWORD

The present manual is designed for those who will operate the machine. You will find in it the necessary data for commissioning, maintenance and safety operation of the machine. The experience of the company manufacturer and its experts is considered in the preparation of this manual.

We recommend you to consider with responsibility our recommendations concerning the safety of work. The operations requiring disassembly of machine and electrical components should be performed by authorized and qualified personnel only. Repairs and settings not described in the present manual should not be performed. This manual is prepared by the manufacturer and is an integral part of the machine's delivery. The information contained herein is intended for specialists and is compulsory.

The manual defines the machine's field of application and contains all the information necessary for its proper and safety operation. The permanent and exact observation of the instructions contained in this manual ensure safety of personnel and machine, profitable work as well as long life of the machine itself. For better clarity this manual is divided in separate parts in which are contained the more important subjects.

The contents will allow you to find fast the specific subjects. The important text is printed in bold and is marked by the following symbols:



WARNING

Indicates imminent risks which may cause serious injury to the operator or other persons. Be careful and scrupulously follow the instructions.



CAUTION

A statement advising of the need to take care lest serious consequences result in harm to material items such as the asset or the product.

1.2 MACHINE IDENTIFICATION

There is a identification plate fixed to the machine, containing the manufacturer's data, year of construction, serial number and technical specifications.

1.3 CUSTOMER SERVICE RECOMMENDATIONS

Apply the machine to skilled and authorized technical staff to carry out any operation dealing with parts disassembly. Keep to the instructions contained in this manual for the correct use of the machine.



CAUTION

Only skilled and authorized staff shall use and service the machine after reading this manual. Respect the accident prevention regulations and the general safety and industrial medicine rules.

2. SAFETY PRECAUTIONS

2.1 SAFETY REGULATIONS



WARNING

- Woodworking machine is high speed and high-risk equipment, so operator who is been suitably trained can use the machine for safety production.
- The manufacturer disclaims all responsibilities for damages to persons or things, which might be caused by any failure to comply with the safety regulations.
- The manufacturer disclaims all responsibilities for damages to persons or things, which might be caused by any failure of electrical installation or nonstandard assembly.
- The manufacturer is not responsible for any damage deriving from arbitrary modifications made to the machine.
- It is prohibited to use the machine when under the influence of alcohol, drugs or medication.
- All the operators must be suitably trained for use, adjustment and operation of the machine.
- The operators must carefully read the manual paying particular attention to the warning and safety notes. Furthermore, they must be informed on the dangers associated with use of the machine and the precautions to be taken, and must be instructed to periodically inspect the guards and safety devices.
- Before changing the blade, debugging the trouble, carrying out adjustment, or cleaning work, disconnect the machine from the electric power by setting the main switch to stop to make sure the machine will not being operated wrongly.
- After an initial bedding-in period or many hours of operation, the driving belts may slacken; this causes an increase in the tool stopping time. Immediately tighten them.
- The working area around the machine must be kept always clean and clear, in order to have an immediate and easy access to the switchboard.
- Never insert materials which are different from those which are prescribed for the machine utilization. The material to be machined must not contain any metal parts.
- Never machine pieces which may be too small or too wide it respect to the machine capacity.
- Do not work wood which has evident defects (cracks, knots, metal parts, etc.)
- Never place hands among the moving parts and/or materials.
- Keep the tools tidy and far away from those not authorized persons.
- Never employ cracked nor buckled, neither not correctly reground tools. Nonstandard or blunt tools are forbidden, either. Blade with broken edge or out of shape should not be used.
- Never use the tools beyond the speed limit recommended by the producers.
- Carefully clean the rest surfaces of tools and make sure that they find perfectly horizontally positioned, and with no dents at all.
- Always wear gauntlets when handling the tools.
- Mount the tools in the right machining direction.
- Never start the machine before having correctly installed all the protections. The protection device should be installed before starting the machine. The protection device should not be removed.

- Connect the dust suction hoods to an adequate suction system; suction must always be activated when the machine is switched on.
- Never open doors or protections when the machine or the system is operating.
- Please check if the blade lock well and the cutter shaft has the right direction. The rotating should get up to the stable condition before working.
- Many unpleasant experiences have shown that anybody may wear objects which could cause serious accidents. Therefore, before starting working, take any bracelet, watch or ring off.
- Button the working garment sleeve well around the wrists.
- Take any garment off which, by hanging out, may get tangled in the MOVING UNITS.
- Always wear strong working footwear, as prescribed by the accident-prevention regulations of all countries. Use protection glasses. Use appropriate hearing protection systems (headsets, earplugs, etc.) and dust protection masks.
- Never let unauthorized people repair, service or operate the machine.
- The manufacturer is not responsible for any damage deriving from arbitrary modifications made to the machine.
- Any transport, assembly and dismantling is to be made only by trained staff, who shall have specific skill for the specified operation.
- The operator must never leave the machine unattended during operation.
- During any working cycle break, switch the machine off.
- In case of long working cycle breaks, disconnect the general power supply.
- The operating method to be followed in the event of accident or breakdown, the machine should be turned off immediately and unplug from main power and ask for assistance for the authorized people. If a blockage is likely to occur, the work piece should be move back a little and enable the equipment to be safely unblocked.
- Please remove unnecessary sweeping, chips, in case of accidents.
- Woodworking machine will produce sparks when using with serious fire risks, so please keep the machine surrounding area clean without inflammables and explosives.

2.2 RESIDUAL RISKS

Despite observance of all the safety regulations, and use according to the rules described in this manual, residual risks may still be present, among which the most recurring are:

- contact with tool
- contact with moving parts (belts, pulleys, etc..)
- recoil of the piece or part of it
- accidents due to wood splinters or fragments
- tool insert ejection
- electrocution from contact with live parts
- danger due to incorrect tool installation
- inverse tool rotation due to incorrect electrical connection
- danger due to dust inhalation in case of working without vacuum cleaner.

2.3 SAFETY AND INFORMATION SIGNALS

This signals may be applied on the machine; in some cases they indicate possible danger conditions, in others they serve as indication.

Always take the utmost care.

SAFETY SIGNALS:



Risk of eye injury. Wear eye protection.



Wear hearing protection systems.



Danger of electric shock. Do not access the area when the machine is powered.



Carefully read and understand the manual before using the machine.

INFORMATION SIGNALS:

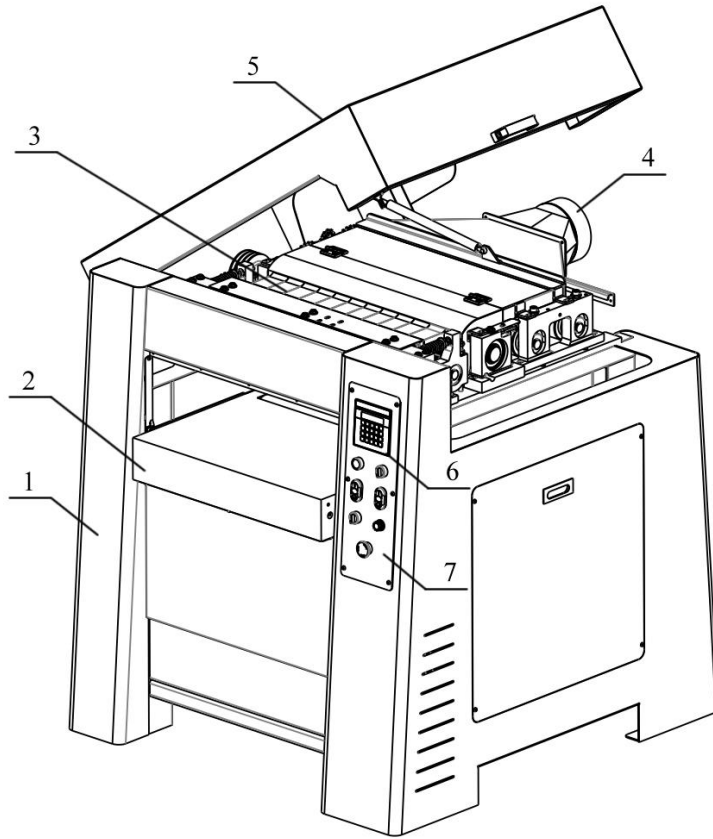
Indicate the technical characteristics, direction of rotation and inclination, block and release, etc.

Carefully following the directions to simplify the use and adjustment of the machine.

The signals are graphically described and do not require further explanation.

3. SPECIFICATIONS

3.1 MAIN COMPONENTS



- 1 - the body
- 2 - pressure planer workbench
- 3 - tool rest component
- 4 - dust hood
- 5 - large shield
- 6 - lift control panel
- 7 - the main control panel

3.2 TECHNICAL SPECIFICATION

Projec	530 Parameters	630 Parameters
Cutting Motor Output	7.5HP-5.5kW	7.5HP-5.5kW (Optional 10HP-7.5kW)
Feeding Motor Output	0.75HP-0.5kW	0.75HP-0.5kW
Lifting Motor Output	0.5HP-0.33kW	0.5HP-0.33kW
Cutter Block Diameter	120mm	120mm
Cutter Block Speed	5500rpm	5500rpm
Variable Feed Speed	4-20m/min	4-20m/min
Max. Width of Cut	530mm	630mm
Minimum cutting length	280mm	280mm
Max. Height of Cut	300mm	300mm
Smallest thickness	5mm	5mm
Max Depth of Cut	8mm	8mm
Quantity of Knives Cutter block	4	4
Overall size	1150*1270*1180 mm	1250*1270*1180 mm
Weight	800 KG	870KG

3.3 ELECTRICAL CONNECTION

- Electrical installation should be carried out by competent, qualified personnel.
- The mains connection should be made using the terminal box.
- Replacement of the power supply cable should only be done by a qualified electrician.



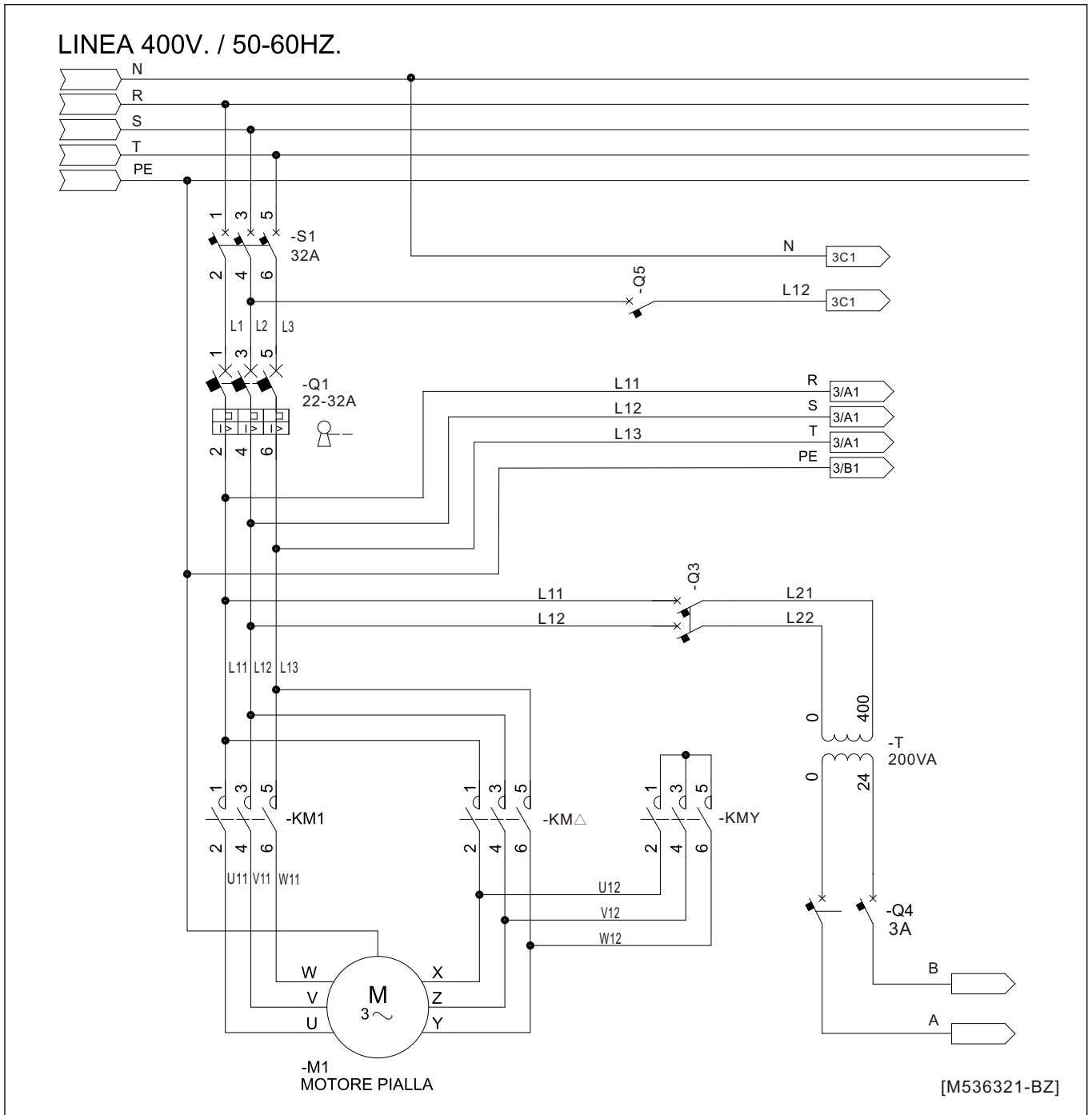
WARNING

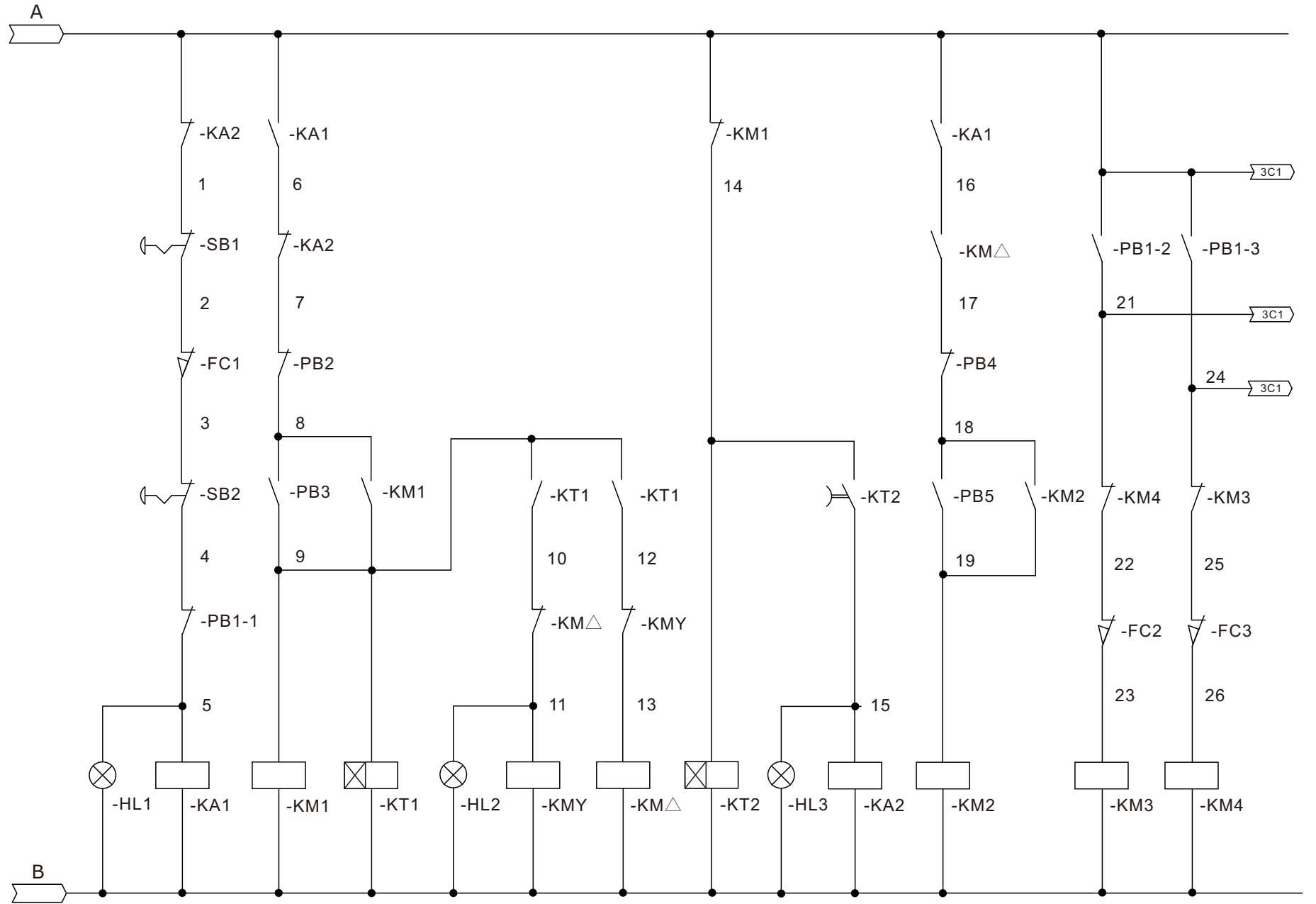
To avoid electrocution or fire, any maintenance or repair to electrical system should be done only by qualified electricians using genuine replacement parts.

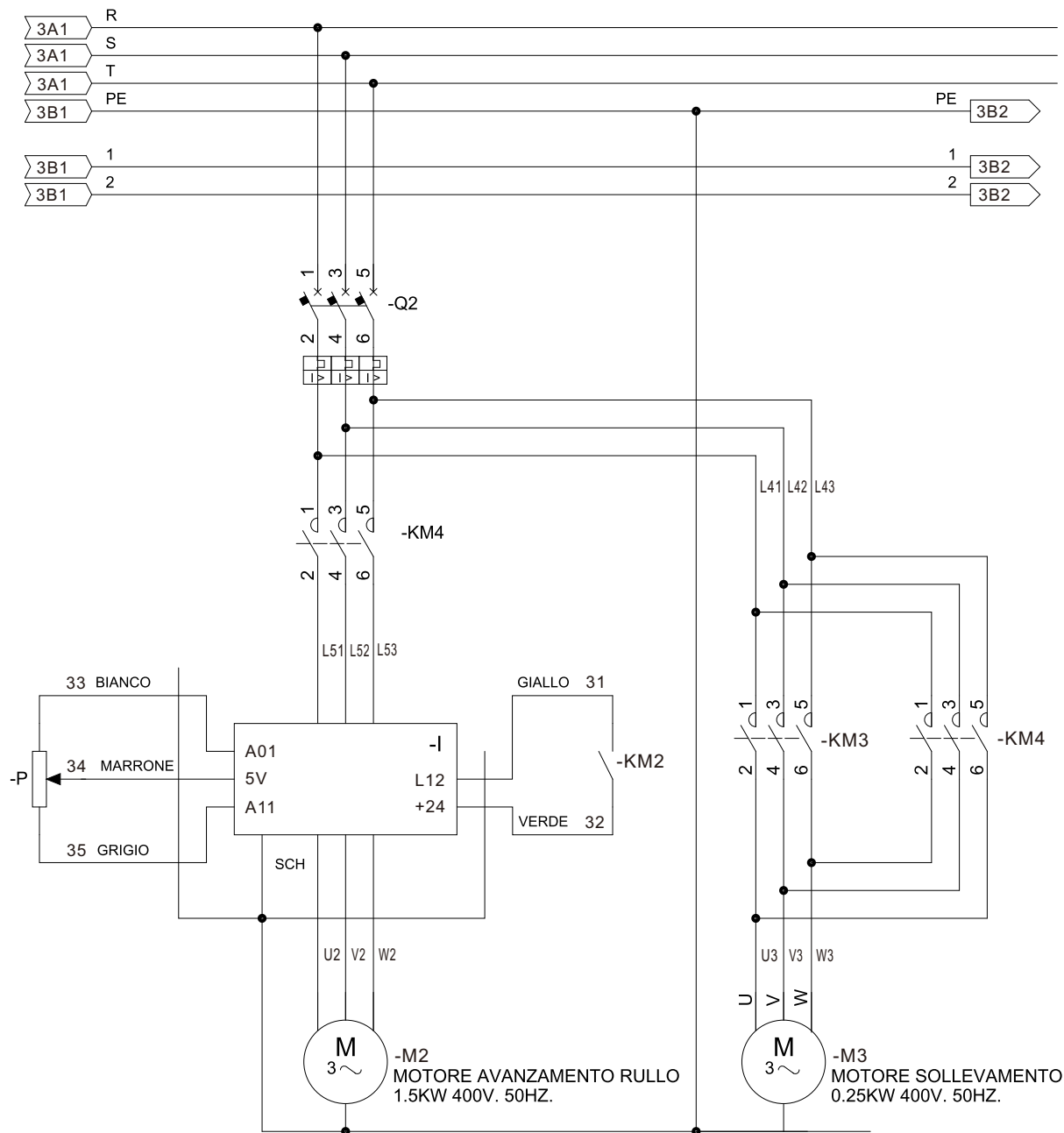


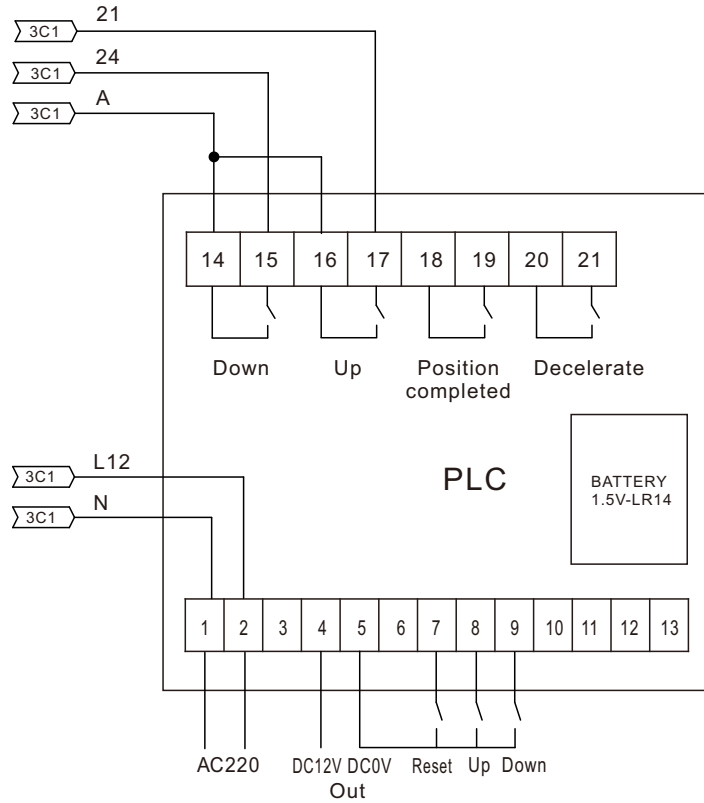
WARNING

Please check the direction of table movement after power on. The table should move upward when you press the button "-" on the control panel. If not, please adjust the phase position of the three phases power supply.

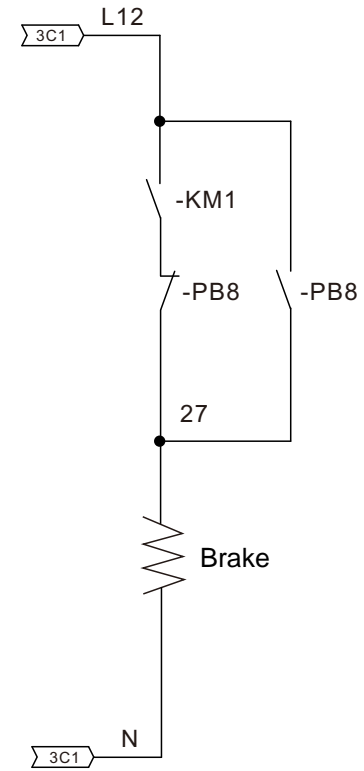








[M536321-BZ]



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3.4 NOISE LEVEL

	No load	Load
Sound Pressure Level	< 80.4dB(A)	< 85.7dB(A) Sound
Power Level	< 98.1dB(A)	< 111dB(A)

Associated uncertainty $K=4\text{dB}$

Measurement made in accordance with EN ISO 3746:1995 and EN ISO 11202:1995

The noise levels measured are emission levels and not necessarily the safe working level. Although there is a correlation between the emission levels and the exposure levels, this cannot be used reliably to determine whether or not further precautions are required. The factors which affect the actual level of operator exposure include the duration of exposure, the ambient characteristics and other sources of emission, for example, the number of machines and other adjacent machining. The permitted exposure values may also vary from country to country. Nevertheless, this information allows the user of the machine to better evaluate the dangers and risks.

Other factors which reduce exposure to noise are:

- correct tool choice
- tool and machine maintenance
- use of hearing protection systems (e.g. headsets, earplugs,...)



WARNING Please always use the hearing protection systems.

3.5 DUST EXTRACTION

The chip and dust aspiration device must ensure a minimal rate of air delivery of 1800 m³/h at a speed of 25-30 m/sec.

The machine is equipped with a shavings collector, which has an end sleeve for connection to the aspirator for the saw-dust and the shavings.

Connect the shavings collector with a tubing of Ø 160 mm to the aspirator for saw-dust and shavings.



WARNING

The dust and chips aspiration device must be switched on simultaneously with the motor of the machine.

4. INSTALLATION



CAUTION

Assembly need to be done by an experienced and trained person.

4.1 CONTENTS OF PACKAGE

- The machine is supplied partly assembled. Prior to use, further assembly is required.
- When unpacking the machine the following components are included for the initial assembly.
- If any parts are missing, do not attempt to assemble the machine; plug in the power cord, or turn the switch on until the missing parts are obtained and properly installed.

Total two carton:
1-Frame assembly
2-dust collector
3-tool presenter

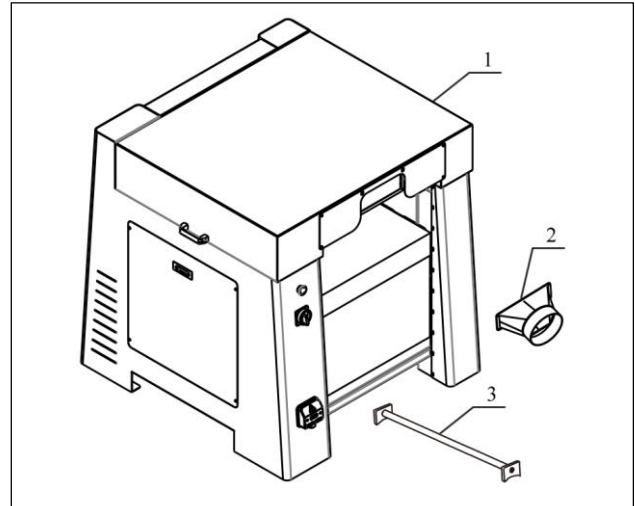


FIG.4.1

4.2 LIFTING AND UNLONADING



WARNING

Lifting and handing should only be carried out by skilled personnel specially trained to execute this kind of operations. During loading and unloading, avoid knocks to prevent damages to persons and things. Make sure no one is standing under the overhung load and/or within the bridge crane working range during machine lifting and handing. Lifting may be carried out by bridge crane or self-propelled lift truck. Before starting the maneuvers, free the machine of all the parts used for transport or Packaging that have remained on the machine. Check that the capacity of the lifting equipment is adequate for the gross weight of the machine indicated Fig.4.2.

If hoisting is carried out with a lift truck, proceed as follows:

- Model 530: adjust the width of the forks to 550mm
- Model 630: adjust the width of the forks to 650mm

-As Fig.4.2. Indicated: Insert forks into the bottom of the frame assembly ensuring that these are wedged against the back of the rear feet.

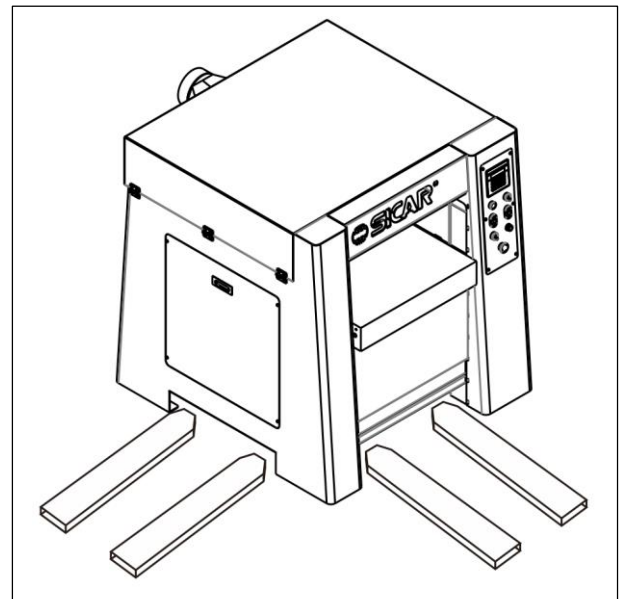


FIG.4.2

4.3 INSTALLATION ZONE CHARACTERISTICS



It is prohibited to install the machine in explosive environments.

Choose a suitable place for the machine taking in mind the possibility to mount extension boards for the smoothing thickener. The place chosen for positioning of the machine should provide for convenient connection to the electric mains and the device for aspiration of the dust and chips.

Provide for suitable lighting (500 lux) that would not blind and avoid the stroboscopic effect.

Check the load capacity of the floor and bear in mind that the machine must be leveled simultaneously on its four supporting points.

Provide for a distance of at least 0.8 m around the machine.

Fixing to the floor

The machine must be fixed to the floor.

- Use bolt/nut A to level the feet to ensure machine is well located.

- Put expansion bores D into ground, use washer/lock washer C and hex nut B to fasten the bolts.

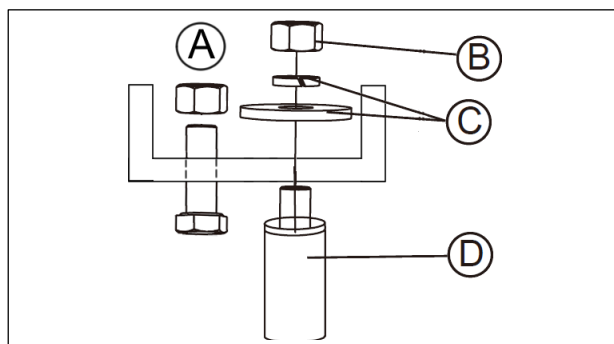


FIG.4.3

4.4 INSTALL SPARE PARTS

Tools Required for Assembly:

-L Wrench 6mm

-Install dust collector 2 to Frame assembly with bolt 3.

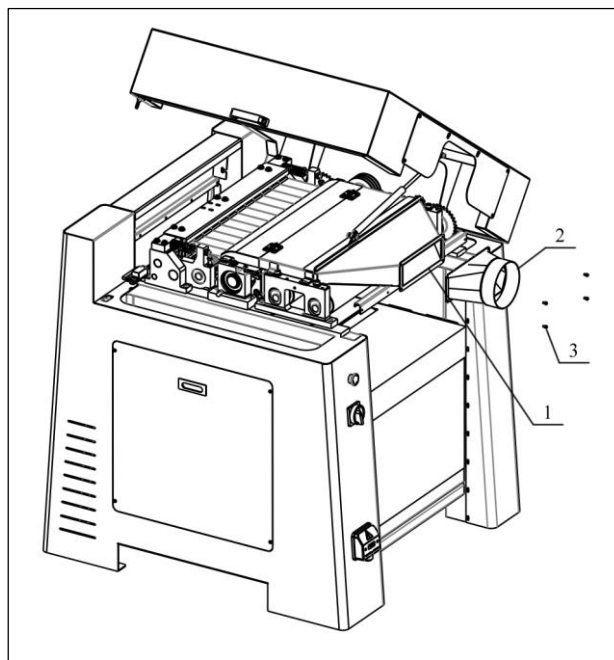


FIG.4.4

5. FITTING AND OPERATING OF MACHINE

5.1 OPERATING OF MACHINE

5.1.1 Dimensions of the pieces

- The maximum size of the elements which can be processed by the thickness machine is 630x 300 mm.
- When processing longer elements use roller supports to keep the element steady and normally fed into the machine.

5.1.2 Disassembly and adjustment of knives to cutter block



WARNING

Before starting assembly, disassembly or adjusting of the knives make sure that the machine can not be operated.

- Switch off the machine from the electric mains.
 - Put the main switch in position "0" and lock it by padlock;
- When disassembling and assembling the knives always use, whenever possible, protection gloves.

- Open the shavings collector A
- Thread out the dust cover B
- Loose the bolt on lock bar.
- Knife will be ejected out automatically
- While assemble knives, use the knife-block C to press knives into cutter block, and then lock the bolts on lock bar.

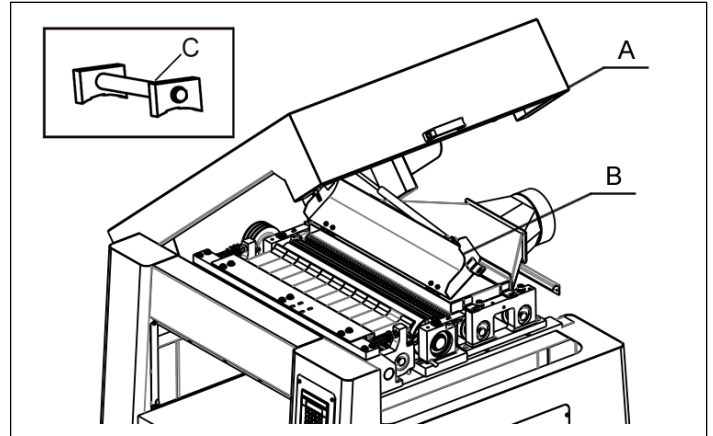


FIG.5.1.2.1

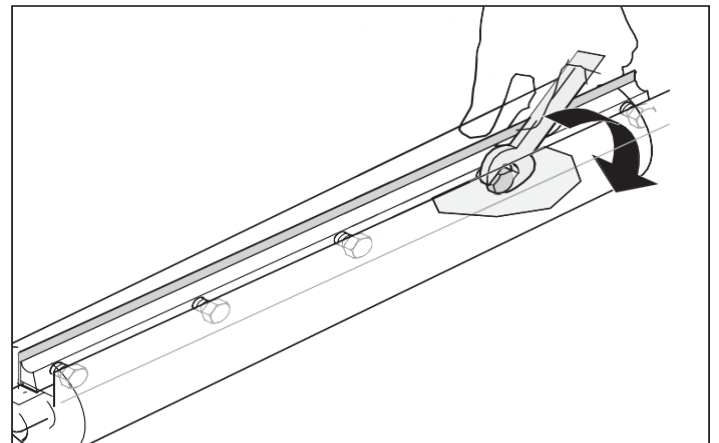


FIG.5.1.2.2

5.1.3 Working on the thickness machine

The thickness control board consist of the below buttons:

- 1 - emergency stop switch
- 2 - brake switch
- 3 - feed speed adjustment knob
- 4 - main motor switch
- 5 - feed motor switch
- 6 - the main power light
- 7 - lift control panel
- 8 - Plc control
- 9 - emergency stop switch
- 10 - total power supply control switch
- 11 - junction box

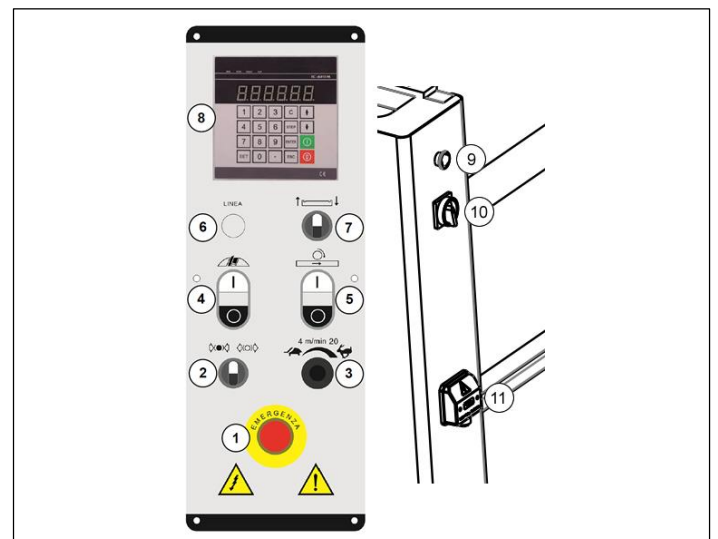


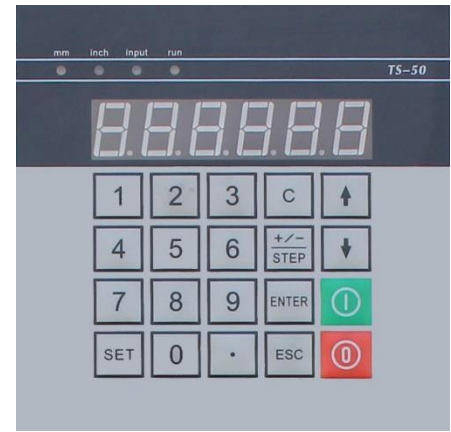





FIG.5.1.3



5.1.4 Thicknesser Cutting Height Operating Instruction



Key	Description
SET	Set the key (set the current value, or the target value, or modify the parameter values, etc.)
C	Clear key
STEP/-	Move the key / value modification minus input key
ENTER	Menu key / confirm key
ESC	Exit / return
↑	Short press: increase the distance of a point moving value Long press: manual control to move forward
↓	Short press: to reduce the distance of a point moving value Long press: manual control to run backward
	Start an automatic positioning
	Stop key



PLC Fast Operating Instruction

Automatic Height operating: Press the button  and Input the figure you want to use, then press the button , the working table will run to set point; during lifting, if the button  is pressed the working table will stop running immediately.

Working table quick lifting: Long press the button  or  will rise or descend the working table automatically at the high speed.

Operating Instruction for correcting dimension: If the thickness of workpiece after cutting is different with the digital readout, please long press the button  until the display start to flash, then input correct figures and long press the button  again for save the setting until the figures stop flashing.

 Replace the battery when display "E08".

5.1.5 PLANER OPERATION

- To feed the workpiece into the machine, assume proper operating position, FIG 5.1.4.1. Stand offset to one side of the feed opening to avoid any kick-back, should it occur. Do not push the lumber once the infeed roller has been engaged. Let the infeed roller move the workpiece into the planer at its own pace.

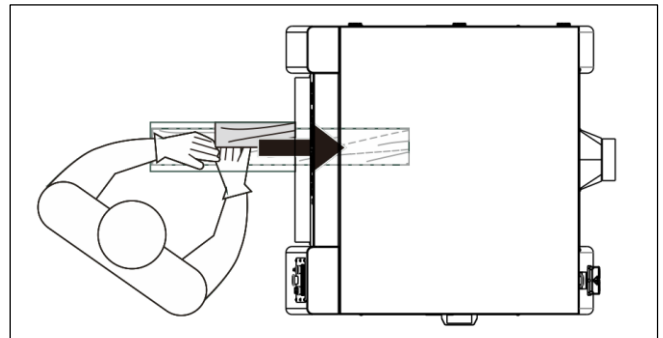


FIG.5.1.4.1

- to remove the workpiece from the machine, position yourself offset to one side of the outfeed opening, FIG 5.1.4.2. Do not pull the lumber as it exits the machine. Let the out-feed roller move the workpiece out of the planer at its own rate, but support the lumber as it extends past the extension rollers, if needed.

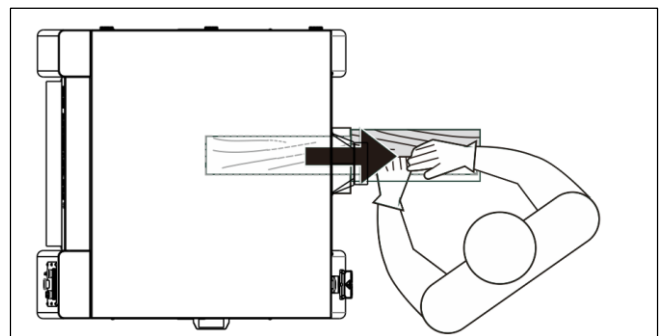


FIG.5.1.4.2



CAUTION

Before processing on the thickness machine the piece must be smoothed (set straight).

The element is placed on the table with the smoothed side on the desk and is pushed to the feeding roller.



CAUTION

- With workpieces having different thickness at the two ends, the thicker end is fed first to avoid jamming
- If adjustment has been made for a chip bigger than 8 mm, the workpiece cannot be fed to the machine because the limiter 8 does not allow for this.
- The removal of a thicker layer can be made with a few passes
- If the workpiece gets jammed and does not move, then the thickness of the chip should be decreased - the table is lowered at about 1 mm. The last chip has to be about 2 mm to get a well machined surface
- The table of the machine has to be cleaned regularly
- The resin should be cleaned with cloth moistened with turpentine

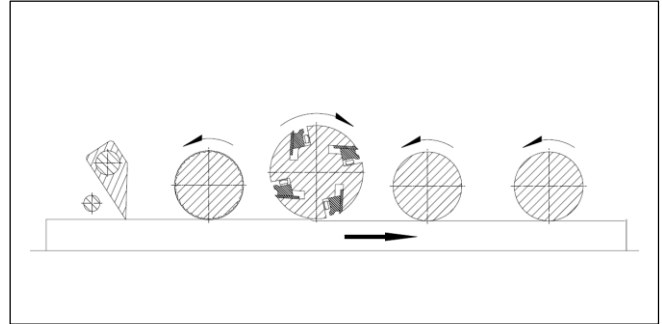


FIG. CAUTION

- Do not coat the table with oil or grease. They soak into the wooden piece and make it unfit for sticking, staining or polishing.
- For workpieces with length bigger than the maximum one, roller supports or table extensions should be used
- Observe the dimensions of the details according to the maintenance manual.
- For working of details with thickness less than 5 mm, a plank worked on the thickness machine can be used. The workpiece is placed on it and it moves together with it thanks to the safety stop as the fig shown.
- The safety stop should not be attached to the plank with nails or other solid fixtures
- Check the workpieces for defects / e.g. nails, free knots, cracks and other objects /
- Avoid working of pieces with a length less than 300 mm, because they cannot be transported well by the machine rollers.

5.2 STARTING



WARNING

Before starting the machine check all the protection systems and gear for functionality. Closely follow the safety instructions given for operating this machine.

Starting the machine is performed as follows:

1. The general power supply control switch 3 is set to "ON" position, the main power indicator light 6, lifting the control panel 5 startup.
2. Lift control panel 5, the worktable is lifted to the proper position.
3. Press the green button switch 2 main motor, main motor.
4. The feeding motor switch to ON position 7, the feed motor start.
5. With the feeding speed adjustment button 8 on the "+" and "-", adjusting the feeding speed.

5.3 STOPPING

Stop operation must be performed in the main motor Y- Δ delta starting

Normal shutdown

The main switch of the motor directly press 2 red button down.

Emergency stop

Press the emergency stop switch 1, or press the material side in the dust near the mouth of the emergency stop button, emergency shutdown.

6. MAINTENANCE

6.1 CLEANING OF MACHINE

The general (complete) cleaning will guarantee long life of the machine and is one of safety facto



WARNING

Before starting any cleaning, adjusting or dismantling of parts from the machine it is necessary to stop it, put a warning sign for the outsiders in the enterprise and lock the cap of the starter with a padlock.

- After each working shift clean thoroughly the machine and all the components, aspirate the dust and the chips by means of the aspiration device and remove all other remainders by compressed air.
- At least once every 6 months or every 500 operating hours remove the side covers in order to get full access for cleaning of the internal components.

6.2 LUBRICATION OF MACHINE

- In order to remove the dust and chips, clean once per 500 hours by means of soft brush all belts.
- Clean thoroughly the machine by strong jet of compressed air and lay a thin layer of oil or grease on all machines mobile parts.
- Protect the belts and pulleys in order to avoid possible soiling by oil or grease.

6.3 CHECKING THE CONDITION OF SOME UNITS AFTER OPERATION

- Before starting any maintenance works on the machine disconnect the electric supply, unplugging it from the mains.

6.4 REPLACEMENT AND DISPOSAL

Should replacement become necessary, the machine parts must be replaced with original components in order to guarantee their efficiency.

The replaced parts must be disposed of in compliance with the laws in force in the country of use.

Component replacement requires specific training and technical skills; for this reason, the above interventions must be carried out by qualified personnel to prevent damage to the machine and risks to the safety of persons.



WARNING

- Do not pull the belts with too much strength in order to prevent damages on the bearings and overheating.
- At least once per month check the tension of the belts and the chain and if necessary, stretch them additionally.
- At every six months it is necessary to check up stretching of the driving belts again.
- The belts must not be stretched much strongly to not overload bearings.
- Much strong stretching leads to lengthening of the belts and its fast wearing out.
- Pollution of the belts with oil, lubricant, solvent, paint etc., must be avoided.
- The driving belts and channels of belt pulleys are clean and dry with soft brush only and woolen or paper towel.
- Never use solvent and water.

7. TROUBLE SHOOTING



WARNING

Before starting any repair works switch off the electric supply of the machine.

The machine has been tested in the production plant and you can freely operate it.
The incorrect and out of function use of the machine may result in damages.

Fault:

The machine does not start.

Reason:

- No voltage in the electric mains.

Repair:

Check whether the power supply is ok

Fault:

The machine stops during operation.

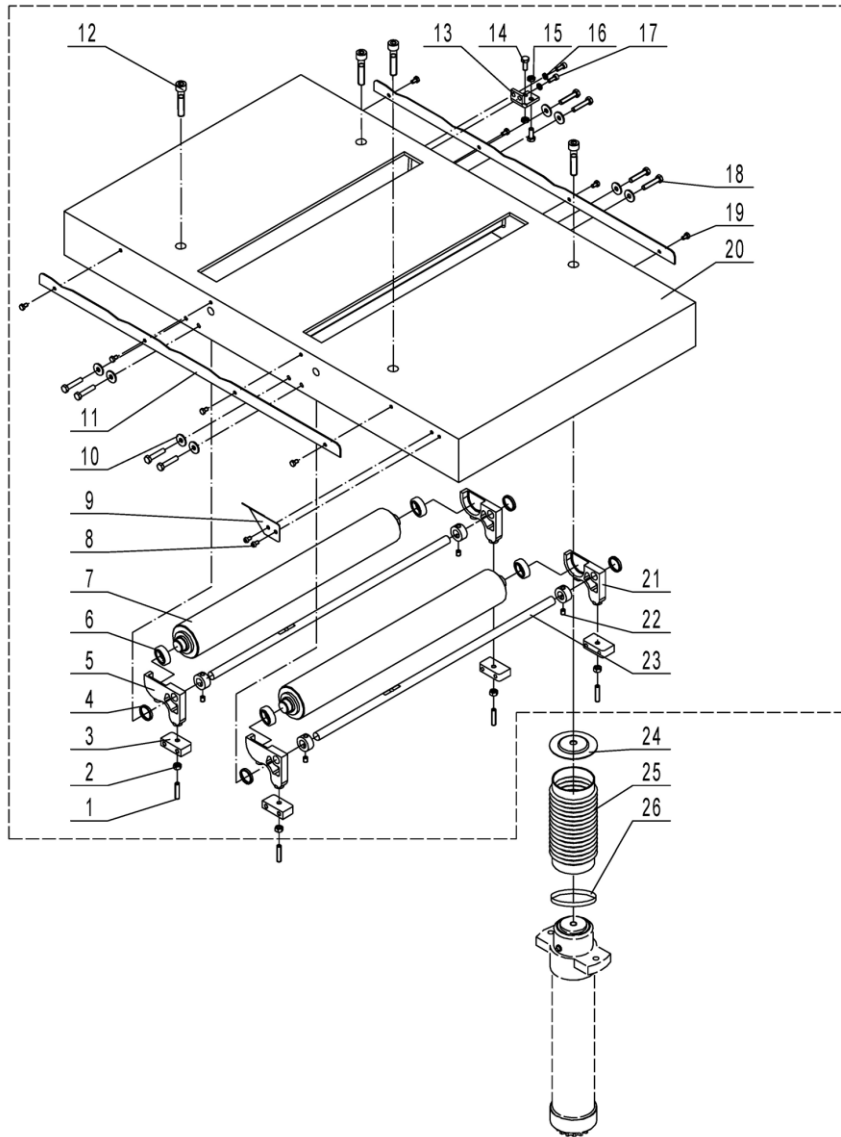
Reason:

- overheating of the motor, its thermo-switch has disconnected the supply (incorrect use of the machine " - overload).
- belt tightened insufficiently.
- worn belts touching the bottom of the grooves of the belt washers.

Repair:

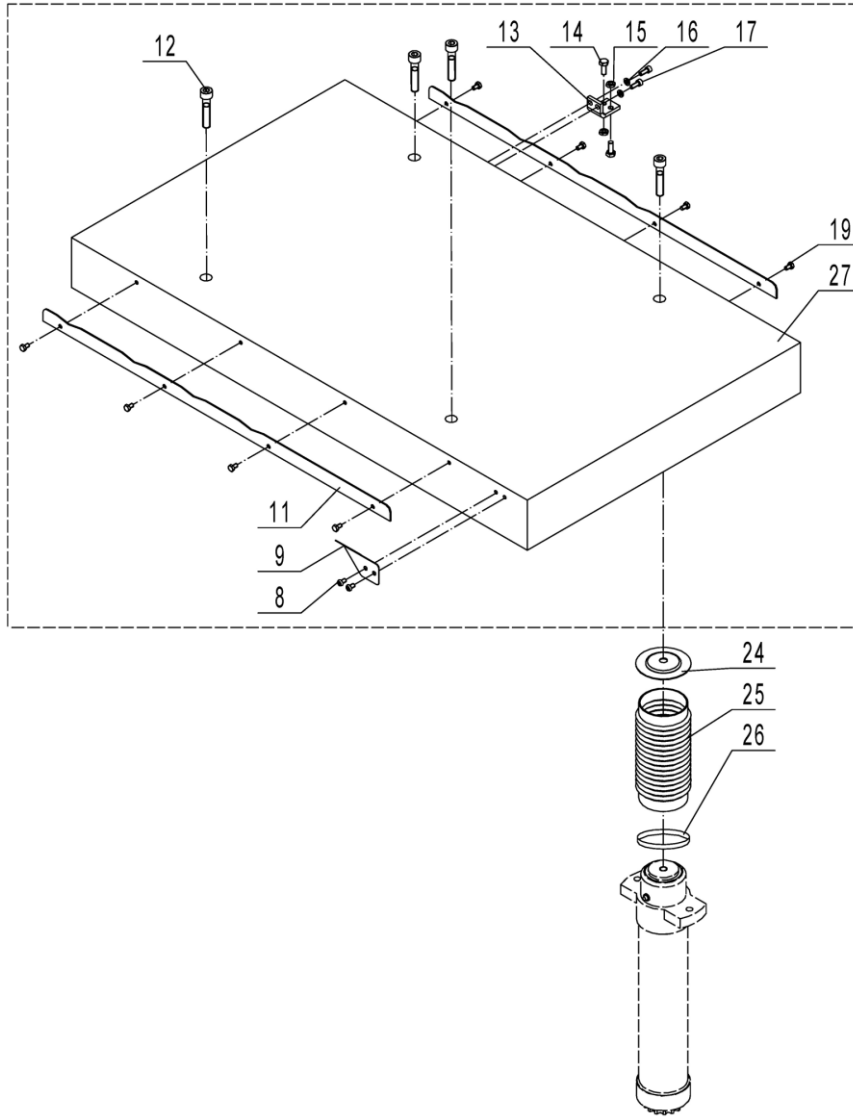
- Switch off completely the machine. Wait the motor to cool down. Operate again the machine by pressing the green knob.
- Pull additionally the belts.
- replace the belts by new ones after you have previously cleaned up the grooves of the belt washers.

Roller table (optional)



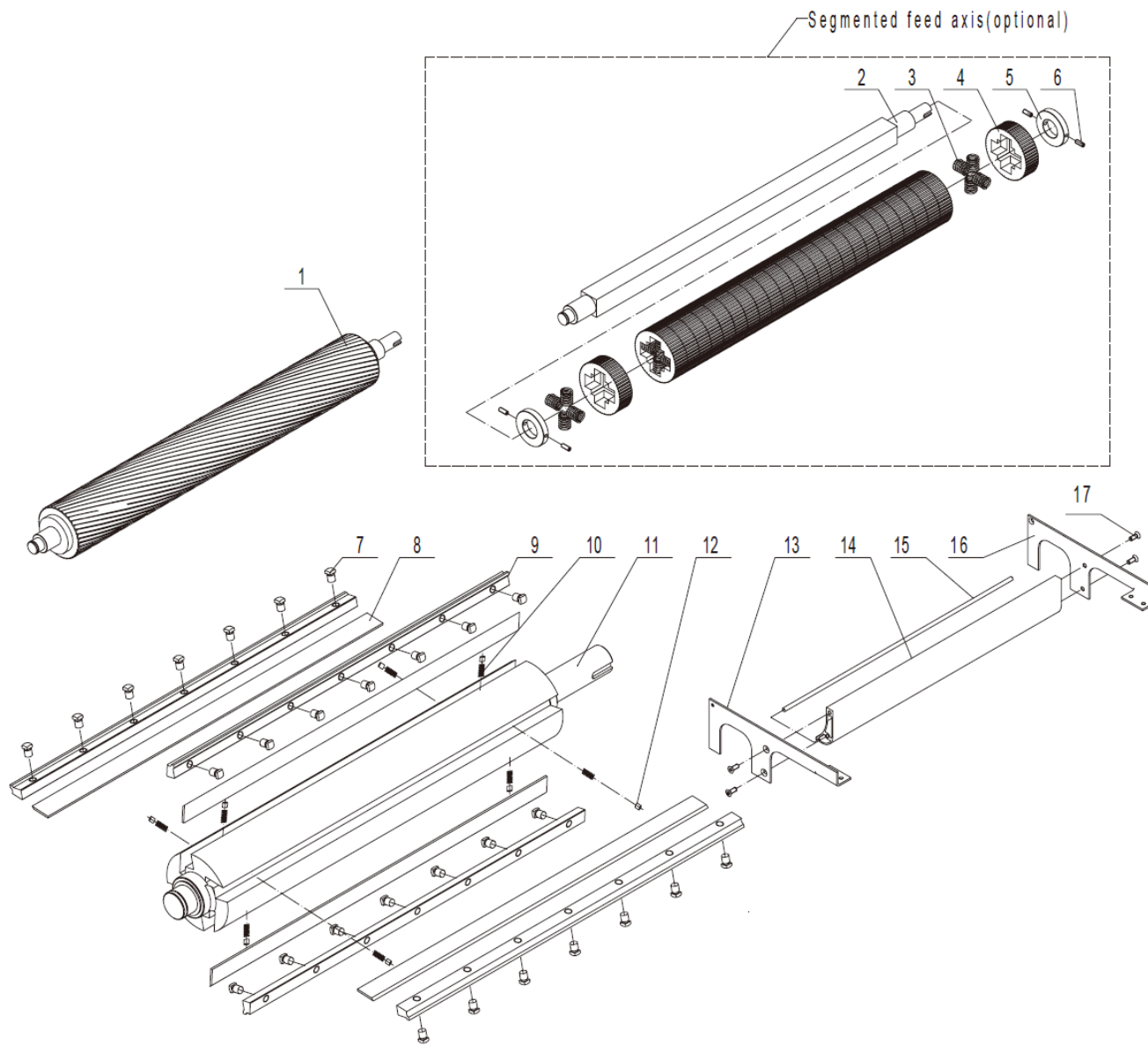
No.	Description	Part No.	QTY.
1	Screw	M8X35GB77B	4
2	Bolt	M8GB6170Z	4
3	Limit block		4
4	baffle		4
5	Right bracket		2
6	Bearing	BRG6005-2ZGB276	4
7	Roller		2
8	Pan-head screw	M6X10GB70D2Z	2
9	Indicator		1
10	Big washer		8
11	Side panel		2
12	Hex. Screw	M12X35GB70B	4
13	Position plate		1
14	Hex. Screw	M8X20GB5781Z	2
15	Bolt	M8GB6172Z	2
16	Flat washer		2
17	Hex. Screw	M6X16GB70Z	2
18	Hex. Bolt	M8X40GB5781Z	8
19	Hex. Bolt	M6X10GB5781Z	8
20	Table		1
21	Left bracket		2
22	Hex. Screw	M8X10GB80B	4
23	shaft		4
24	Mount plate		4
25	Protect tube		4
26	Clip		4
27	Table		1

Table Assembly: 002A

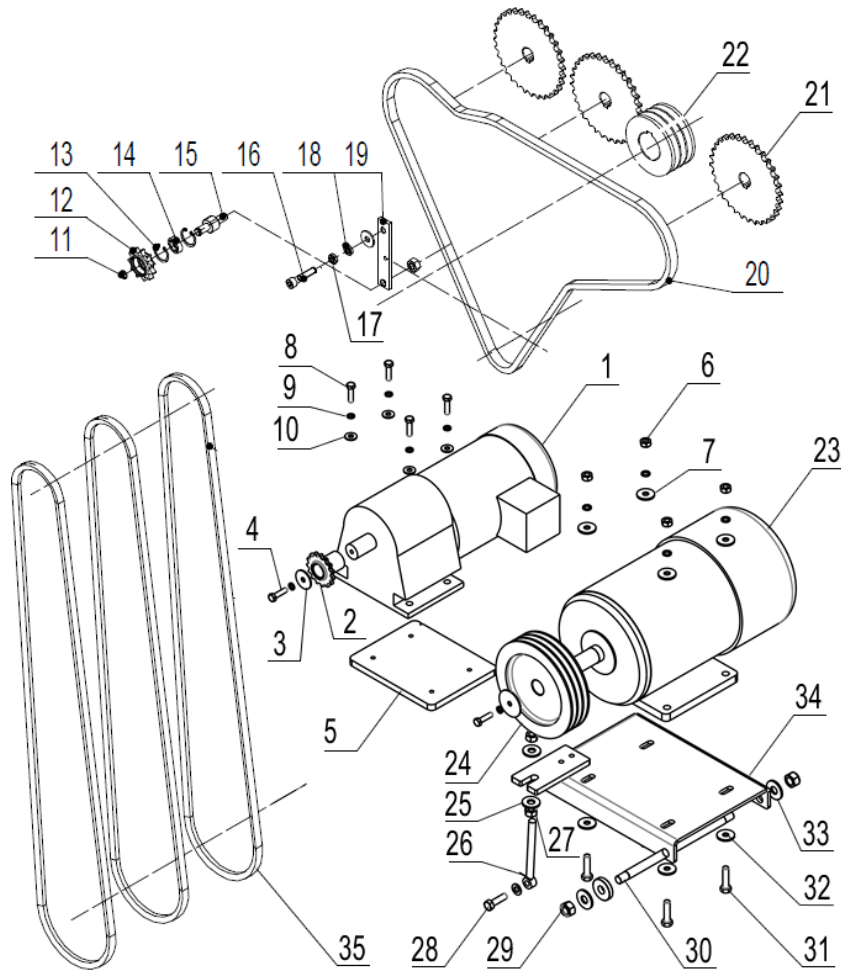


No.	Description	Part No.	QTY.
1	Screw	M8X35GB77B	4
2	Bolt	M8GB6170Z	4
3	Limit block		4
4	baffle		4
5	Right bracket		2
6	Bearing	BRG6005-2ZGB276	4
7	Roller		2
8	Pan-head screw	M6X10GB70D2Z	2
9	Indicator		1
10	Big washer		8
11	Side panel		2
12	Hex. Screw	M12X35GB70B	4
13	Position plate		1
14	Hex. Screw	M8X20GB5781Z	2
15	Bolt	M8GB6172Z	2
16	Flat washer		2
17	Hex. Screw	M6X16GB70Z	2
18	Hex. Bolt	M8X40GB5781Z	8
19	Hex. Bolt	M6X10GB5781Z	8
20	Table		1
21	Left bracket		2
22	Hex. Screw	M8X10GB80B	4
23	shaft		4
24	Mount plate		4
25	Protect tube		4
26	Clip		4
27	Table		1

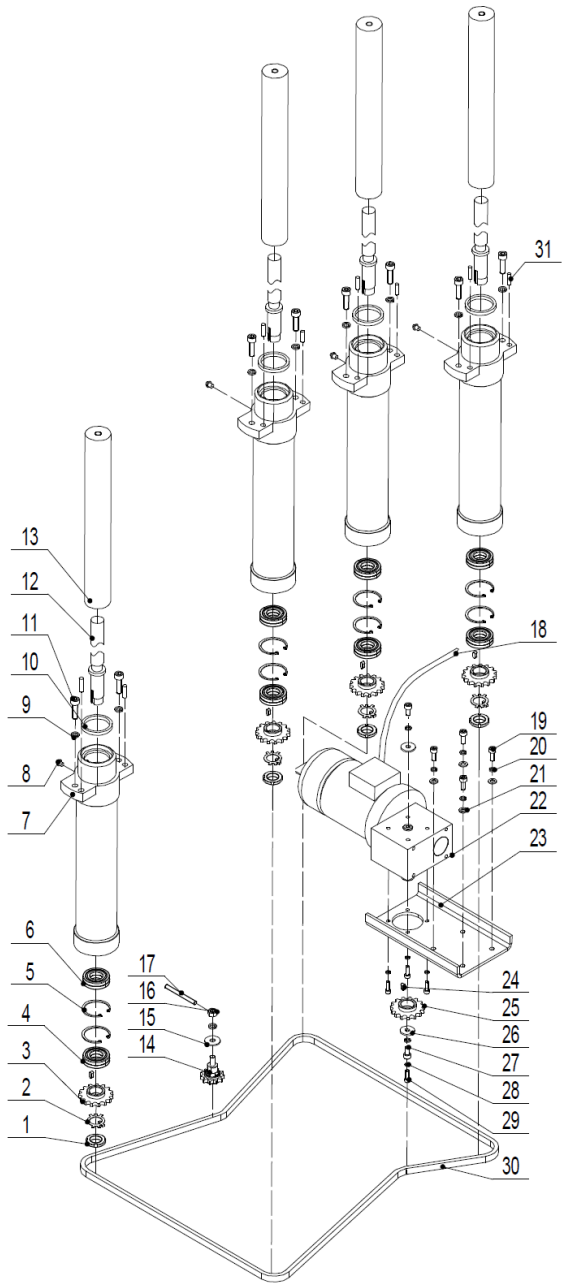
Table Assembly: 002B



No.	Description	Part No.	QTY.
1	Shaft		1
2	Shaft		1
3	Pressure spring		100
4	Infeed wheel		25
5	Position tube		2
6	Hex. Screw	M6X16GB80B	4
7	Square-head bolt		28
8	Knife		4
9	Lock bar		4
10	Spring		8
11	Cutter block		1
12	Pin		8
13	Plate 1		1
14	Rear plate		1
15	Rear plate rod		1
16	Plate 1		1
17	Hex. Screw	M8X16GB70D3Z	4

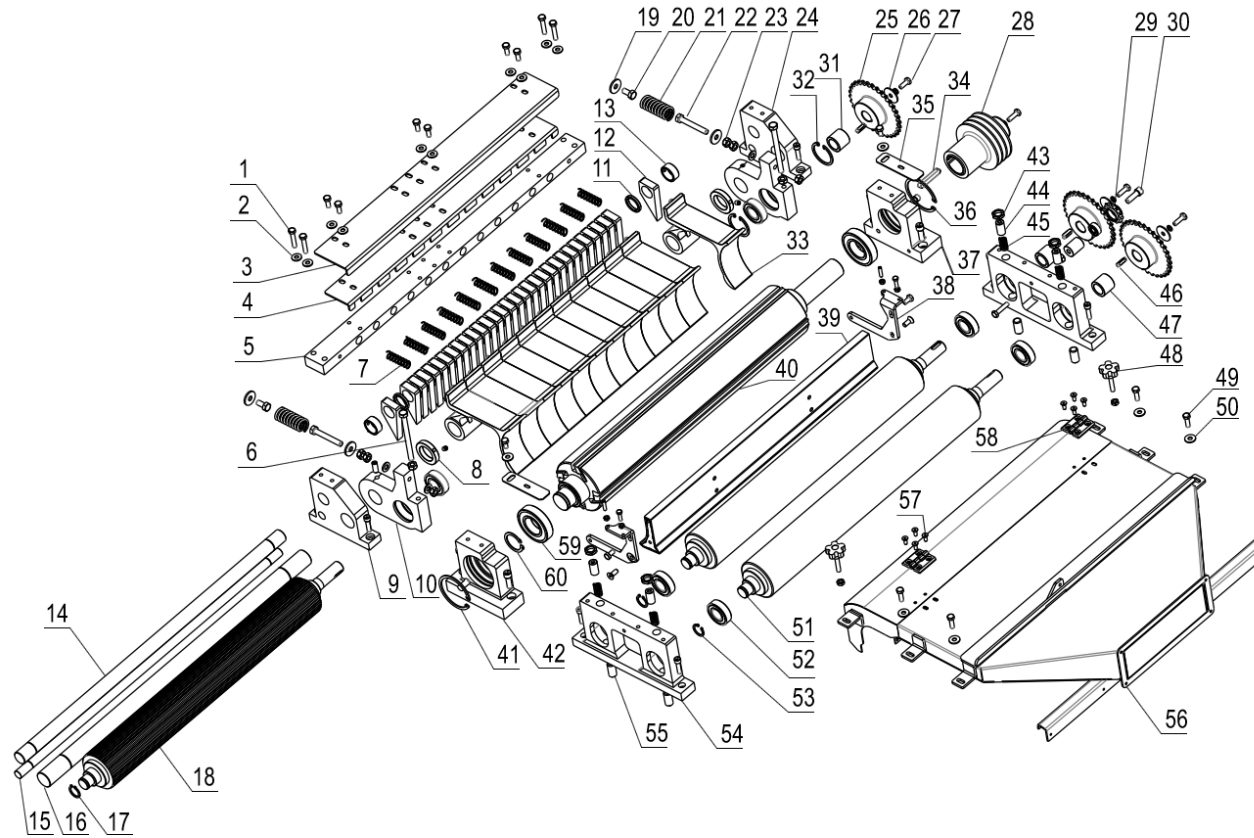


No.	Description	Part No.	QTY.
1	Feeding motor		1
2	Drive sprocket		1
3	Flat pad	8*24	1
4	Hex bolts	M8*25	1
5	Base plate		1
6	Nut	M8	4
7	Flat pad	8*16	4
8	Hex bolts	M8*25	4
9	Spring washer	M8	4
10	Flat pad	8*16	4
11	Retaining ring		1
12	Tension wheel		1
13	Clip		1
14	Bearing	BRG6000-2ZGB276	1
15	Pull rod		1
16	SHCS	M8X40GB70Z	1
17	Spring washer	8	1
18	bolt	M8GB6172Z	1
19	Tension plate		1
20	Chain		1
21	Feeding sprocket		3
22	Planer shaft pulley		1
23	Main motor		1
24	Main motor pulley		1
25	Flat pad	10*30	2
26	Tension bolt	M12	2
27	Nut	M12	2
28	Hex bolts	M8*30	1
29	Nut	M12	2
30	Base rotation axis		1
31	Hex bolts	M8*30	4
32	Flat pad	8*24	4
33	Flat pad	12*24	2
34	Motor mounting		1
35	Belt	3V750	3
Infeed Chain Assembly: 004			



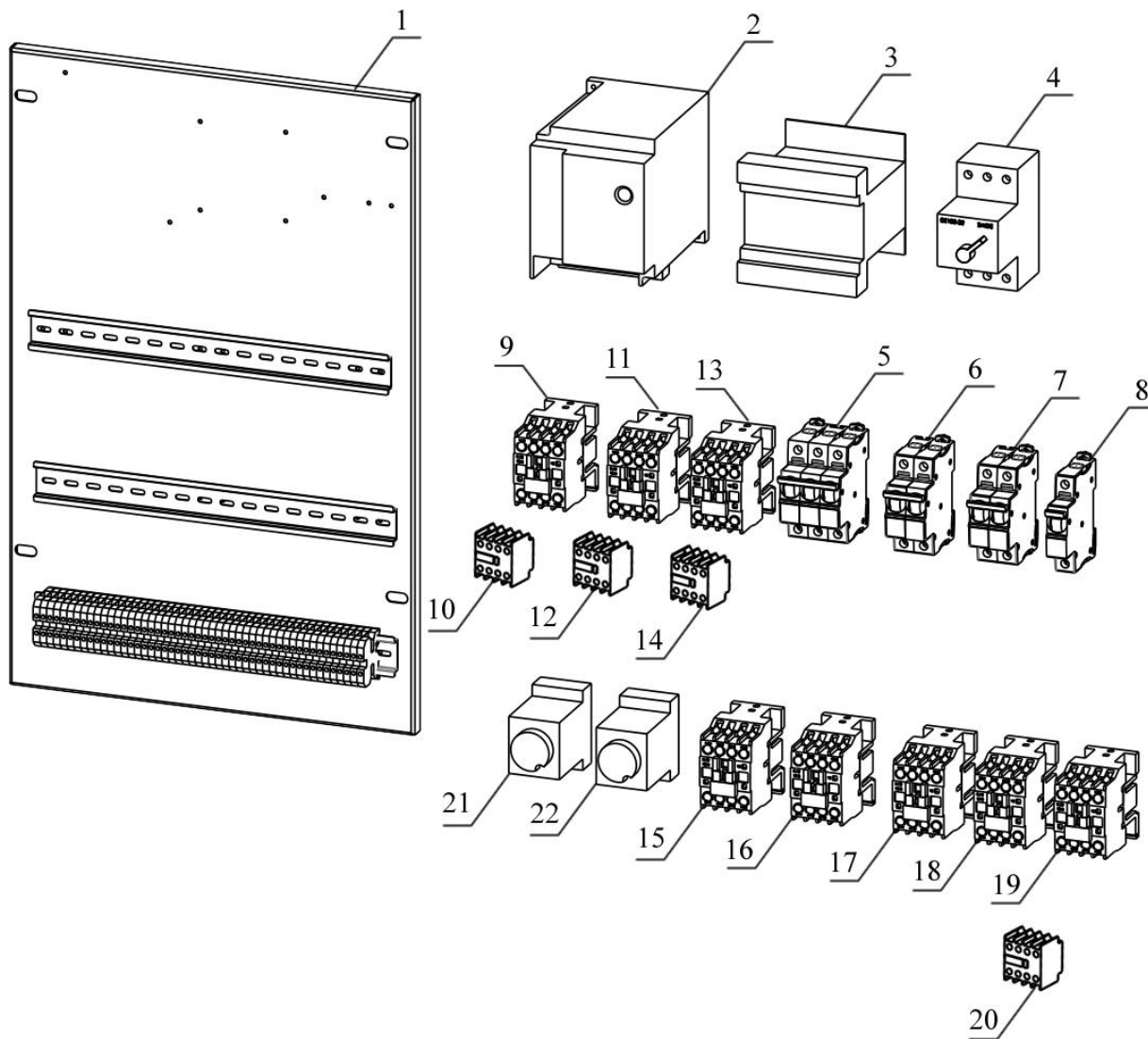
No.	Description	Part No.	QTY.
1	Bolt	M24GB810Z	4
2	Lock washer		4
3	Chain pulley		4
4	Bearing	BRG6205-2RSGB276	4
5	Retaining ring	CLP52GB893D1B	8
6	Bearing	BRG30205GB297	4
7	Tube		4
8	Oil cup	M8X1JB7940D1	4
9	Spring washer		9
10	Dust ring	FB50X60X7GB10708D3	4
11	Hex. screw	M10X35GB70Z	8
12	Threaded rod		4
13	Guide column		4
14	Tension wheel		1
15	Big washer		1
16	Bolt	M10GB6170Z	1
17	Lock washer	M8X80GB77Z	1
18	Motor cable	V14151200-941	1
19	Hex. screw	M8X20GB70Z	4
20	Spring washer		6
21	Flat washer		4
22	Lifting motor		1
23	Motor bracket		1
24	Pin	PLN6X6X14GB1096	5
25	Lifting chain wheel		1
26	Big washer		2
27	Hex. screw	M8X16GB70Z	2
28	Spring washer		6
29	Hex. screw	M6X20GB70D1Z	4
30	Lifting chain		1
31	Taper pin	PIN8X40GB117Z	8

Lifting Chain Assembly: 005



No.	Description	Part No.	QTY.
1	Hex bolts	M8X15	4
2	Flat washer		4
3	Pressure plate		1
4	Spring tension plate		1
5	Spring hole seat		1
6	Hex bolts		2
7	Pressure spring		12
8	Bearing	NSK6205	2
9	Feeding shaft seat		2
10	Feeding shaft		2
11	Spacer		31
12	Bulletproof block		32
13	Spacer		2
14	Bulletproof shaft		1
15	Block shaft		1
16	Press block shaft		1
17	Circlip	D.25	2
18	Feed shaft		1
19	Flat washer	8X24X3	2
20	Hex bolts		2
21	spring		2
22	Hex bolts		2
23	Nut		2
24	Feeding shaft seat		1
25	Feeding sprocket		2
26	Flat washer	8X30X3	1
27	Hex bolts	M8X25	1
28	Planer shaft pulley		1
29	Hex bolts	M8X25	1
30	Hex bolts	M8X25	2
31	Spacer		1
32	Circlip	D.30	2
33	Press block shaft		14
34	Flat key	8X30	1
35	Spring plate		2
36	Circlip	D.30	2
37	Planer shaft seat		1
38	Baffle mounting plate		2
39	Baffle plate		1
40	Planer shaft		1
41	Circlip	D.80	2
42	Planer shaft seat		1
43	Nut	M10	4

Tool Rest: 006



No.	Description	Part No.	QTY.
1	Switchboard backplane		1
2	Frequency converter	Schneider A TV310HU15N4A 1.5KW	1
3	Transformer	BK200VA IN380V-OUT24V 140VA 220V 60VA	1
4	Overload protector	DZ108-32	1
5	Air circuit breaker	3P C32	1
6	Air circuit breaker	2P-C3	1
7	Air circuit breaker	2P-C3	1
8	Air circuit breaker	1P-C16	1
9	AC contactor	CJX2-1801	1
10	Auxiliary contact	LA1 DN 13	1
11	AC contactor	CJX2 1801	1
12	Auxiliary contact	LA1 DN 13	1
13	AC contactor	CJX2-1801	1
14	Auxiliary contact	LA1 DN 13	1
15	AC contactor	CJX2-0910	1
16	AC contactor	CJX2-0901	1
17	AC contactor	CJX2-0901	1
18	AC contactor	CJX2-0901	1
19	AC contactor	CJX2-0901	1
20	Auxiliary contact	LA1 DN 13	1
21	Time Relay	JSZ3(ST3)	1
22	Time Relay	JSZ3(ST3)	1

Electric unit: 007B



Original Instruction
V21.2-202203