METAL CUTTING BAND SAW

MODEL BS-1018T

BS-1018TA

BS-1018TH

Assembly & Operating Instruction

I. SAFETY SUGGESTIONS

1. READ THE INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE.
2. IF YOU ARE NOT THOROUGHLY FAMILIAR WITH THE OPERATION OF HORIZONTAL BANDSAW, OBTAIN ADVICE FROM YOUR SUPERVISOR, INSTRUCTION OR OTHER QUALIFIED PERSON.
3. REMOVE TIE, RINGS, WATCH AND OTHER JEWELRY, AND ROLL UP SLEEVES.
4. ALWAYS WEAR SAFETY GLASS OR A FACE SHIELD
5. MAKE SURE WIRING CORDS AND RECOMMENDED ELECTRICAL CONNECTIONS INSTRUCTIONS ARE FOLLOWED AND THAT MACHINE IS PROPERLY GROUNDED.
6. MAKE ALL ADJUSTMENTS WITH THE POWER OFF.
7. ADJUST AND POSITION THE BLADE GUIDE BEFORE STARTING CUT.
8. MAKE SURE THAT BLADE TENSION IS PROPERLY ADJUSTED BEFORE STARTING CUT.
9. STOP THE BAND SAW BEFORE PUTTING A WORK PIECE IN THE VISE.
10. ALWAYS KEEP HANDS AND FINGERS AWAY FROM THE BLADE WHEN THE MACHINE IS RUNNING.
11. STOP THE MACHINE BEFORE REMOVING CHIPS.
12. ALWAYS HAVE STOCK FIRMLY CLAMPED IN VISE, BEFORE STARTING CUT.
13. DISCONNEC TMACHINE FORM POWER SOURCE WHEN MAKING REPAIRS.
14. BEFORE LEAVING THE MACHINES, MAKE SURE THE WORK AREA IS CLEAN.

II. DAILY CHECK LIST

1. CHECK COOLANT: Low coolant level can cause foaming and high blade temperatures. Dirty or weak coolant can clog pump, cause crooked cuts, low cutting rate and permanent.
2. KEEP VISE SLIDES CLEAN AND OILED.
3. CLEAN CHIPS FROM BLADE WHEELS AND AREAS AROUND WHEELS.
4. SAW GUIDE: Keep saw guide tight. Loose guide will affect sawing accuracy.
5. SAW BLADE: Is saw blade sharp?
6. BLADE SPEED: Is blade speed set correctly for workpiece material and shape?
7. CHECK BLADE TENSION: Particularly after initial cuts with a new blade.

III. SAW BLADE SELECTION

1. Never use a blade so coarse that less than 3 consecutive teeth are engaged in the workpiece at any one time. (Too few teeth will cause teeth to strip out.)
2. Never use a blade finer than required to obtain a satisfactory surface finish or satisfactory flatness. (Too many teeth engaged in the workpiece will prevent attainment of a satisfactory sawing rate; frequently cause premature blade wear; frequently produce “dished” cuts or cuts which are neither square nor parallel.)
3. The Chart which follows is not expected to be exactly correct for all cases. It is intended as a general guide to good sawing practice. Your blade supplier or factory application engineer should be your most reliable source of correct information for operational details of saw blade and their use.

WORK SIZE (Solid bars)	PROBABLE PITCH-TEETH PER INCH		
	BEST	SECOND BEST	THIRD BEST
Less Than 1” Dia. Or Sq.	10		
1” Dia. or 1” Sq.	8	10	6
1 ½” Dia. or 1 ½” Sq.	8	10	6
2” Dia. or 2” Sq.	8	6	4
2 ½” Dia. or 2 ½” Sq.	6	8	4
3” Dia. or 3” Sq.	6	4	3
3 ½” Dia. or 3 ½” Sq.	6	4	3
4” Dia. or 4” Sq.	4	3	6
4 ½” Dia. or 4 ½” Sq.	4	3	6
5” Dia. or 5” Sq.	4	3	6
6” Dia. or 6” Sq.	3	4	6
7” Dia. or 7” Sq.	3	4	6
8” Dia. or 8” Sq.	3	2	4
9” Dia. or 9” Sq.	3	2	4

Notice:

1. When standard wall pipe or tubing or thin wall tubing, channel iron, angles I beam are cut, a 10 pitch saw blade of “wave” set type is frequently used to good advantage. Fewer than 10 teeth per inch of saw will almost never be satisfactory.
2. Tubing or structural with wall thickness or web thickness of ½” or more can usually use an 8 or 6 pitch blade satisfactorily.
3. When rectangular, solid bar is to be sawed, then work should, whenever possible, be loaded with thinnest cross section exposed to the blade teeth. The pitch (or number of teeth per inch of blade) selected must provide engagement of at lease 3 consecutive teeth in the work piece. Should application of this rule not be possible because the thinnest cross section is too thin, the piece must be loaded with the wider dimension exposed to the saw teeth and a coarser blade selected from the listing of recommendations for round and square solid bars.

IV. TRANSPORTATION METHODS

1. ALWAYS KEEP BALANCE WHILE THE MACHINE IS IN TRANSPORTATION

2. DRIVE FORKLIFT SLOWLY AND CAREFULLY.

V. INSTRUCTION

The Horizontal Band Saw is well suited for many user- job shops, tool rooms, maintenance departments, metal fabricators, building trade contractors, machine shops, vocational schools and teacher training colleges.

We suggest you read and understand this manual before setting up, making wiring connections and operating your machine and also that you save it for future reference.

Specification:

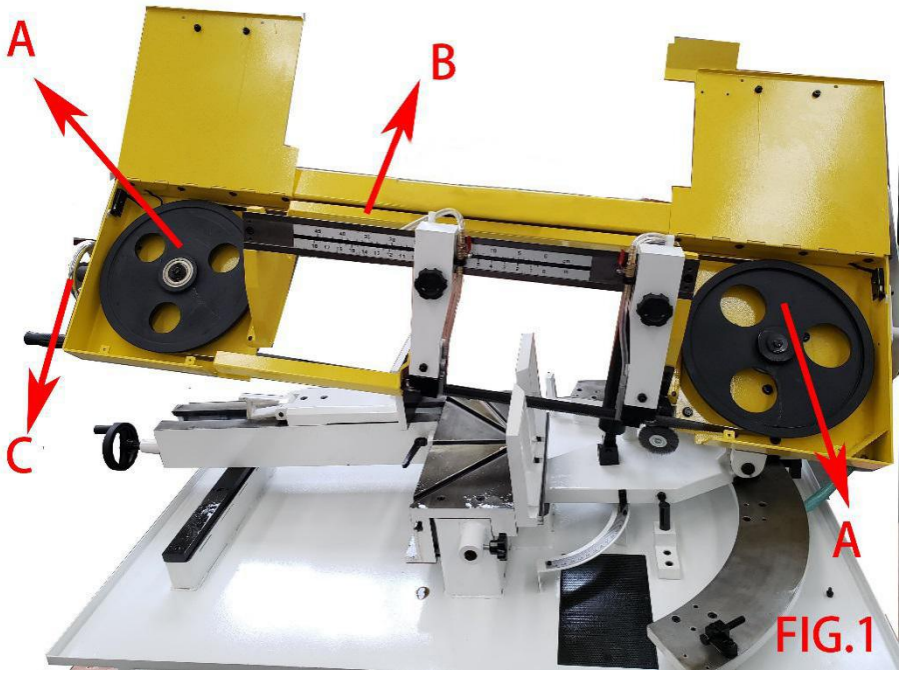
Item No.		388061	388062	388063
Model		BS-1018T	BS-1018TA	BS-1018TH
Capacity	Circular @90°	260mm (10.2”)	260mm (10.2”)	260mm (10.2”)
	Rectangular @90°	260x430mm (10.2”x16.9”)	260x430mm (10.2”x16.9”)	260x430mm (10.2”x16.9”)
	Circular @60°	155mm (6.1”)	155mm (6.1”)	155mm (6.1”)
	Rectangular @60°	125x125mm (5”x5”)	125x125mm (5”x5”)	125x125mm (5”x5”)
	Circular @45°	260mm (10.2”)	260mm (10.2”)	260mm (10.2”)
	Rectangular @45°	Left: 260x130mm (10.2”x5.1”) Right:300x200mm (11.8”x7.9”)	Left: 260x130mm (10.2”x5.1”) Right:300x200mm (11.8”x7.9”)	Left: 260x130mm (10.2”x5.1”) Right:300x200mm (11.8”x7.9”)
Blade speed @ 50Hz		24, 52, 78, 109 MPM	24, 52, 78, 109 MPM	24, 52, 78, 109 MPM
Blade speed @ 60Hz		28, 62, 93, 130 MPM	28, 62, 93, 130 MPM	28, 62, 93, 130 MPM
Blade size		27x0.9x3660 mm	27x0.9x3660 mm	27x0.9x3660 mm
Motor		1.5 kW	1.5 kW	1.5 kW
Drive		Belt	Belt	Belt
Wheel diameter		365mm	365mm	365mm
Coolant tank		8 Liter	8 Liter	8 Liter
Coolant pump		45w	45w	45w
Machine vise above floor		673mm	673mm	673mm
Packing size		212x108x122 cm	212x131x122 cm	212x108x122 cm
N.W./G.W.		466/520 kg	472/565 kg	515/653 kg

VI. OPERATING CONTROLS AND ADJUSTMENTS

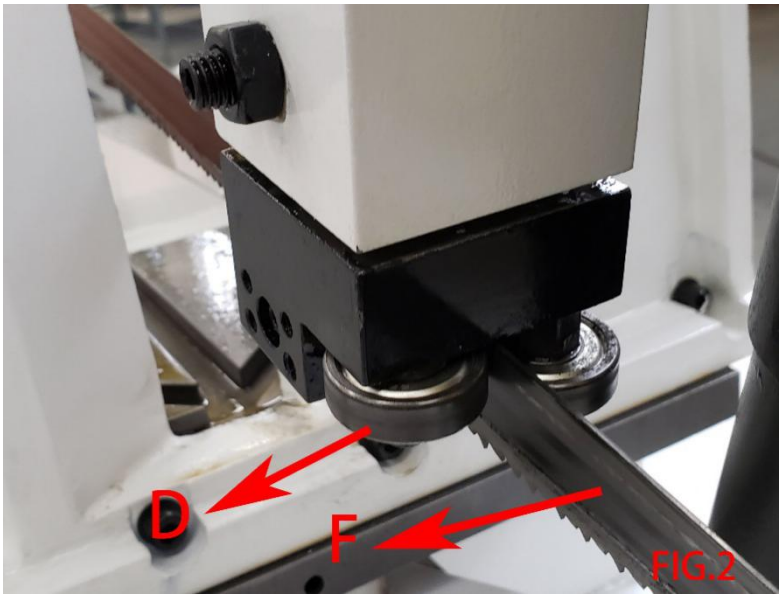
i. REMOVING AND INSTALLING THE BALDE

When your machine was shipped, a blade supplied and assembled to the saw. When selecting a new blade refer to section III. SAW BLADE SELECTION for information. This machine requires a blade 27mm width x 3660mm length.

1. Disconnect the machine from the power source.
2. Raise the saw frame about 6” and close the feed rate lever by turning it clockwise as far as it will go.
3. Open both wheel covers and clean the scrap out of the machine.
4. Release blade tension by turning the blade tension hand wheel (C) Fig.1 counterclockwise.
5. Remove the blade from both wheels and out of each blade guide.
6. Make sure the teeth of the new blade are pointing in the direction of travel. If necessary, turn the blade inside out.
7. Place the blade in place on the wheel (A) and through the upper blade guard (B) Fig. 1. Fig.1 is shown with the wheel covers removed for clarity.



8. Work the blade (F) all the way up into the blade guide roller bearing (D) with the back of the blade against the guide bracket as shown in Fig. 2.



Note: If roller bearings need adjusted refer to the section ADJUSTING BLADE GUIDE ROLLING BEARINGS.

9. Put light tension on the blade and work it on both wheels, as shown in Fig. 3.

MAKE SURE THAT THE BACK OF THE BLADE IS AGAINST THE WHEEL FLANGES OF BOTH WHEELS. THIS IS VERY IMPORTANT.

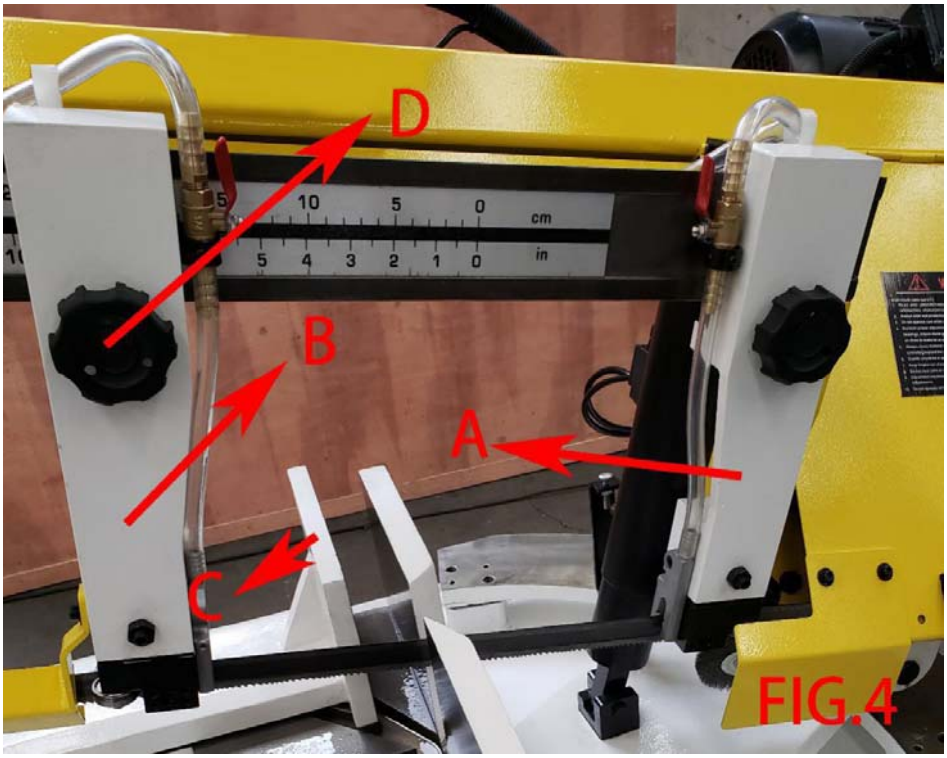
10. When you are sure the back of the blade is against the wheel flanges of both wheels and properly inserted into the guides, finish putting tension on the blade.

11. Jog the power “on” and “off” to be sure the blade is in place and rotating properly. If blade is not rotating properly refer to the section TRACKING THE BLADE.

ii. ADJUSTING BLADE GUIDE BRACKETS

The blade guides should be set as close to the vise jaw as possible. The right blade guide bracket (A) Fig.4, is not adjustable and is set at the factory to clear the right hand vise jaw. The left blade guide bracket (B) can be moved to the left or right depending on the position of left hand vise jaw (C). To move the left blade guide bracket (B), loosen hand knob (D), position blade guide bracket (B) and tighten hand knob (D).

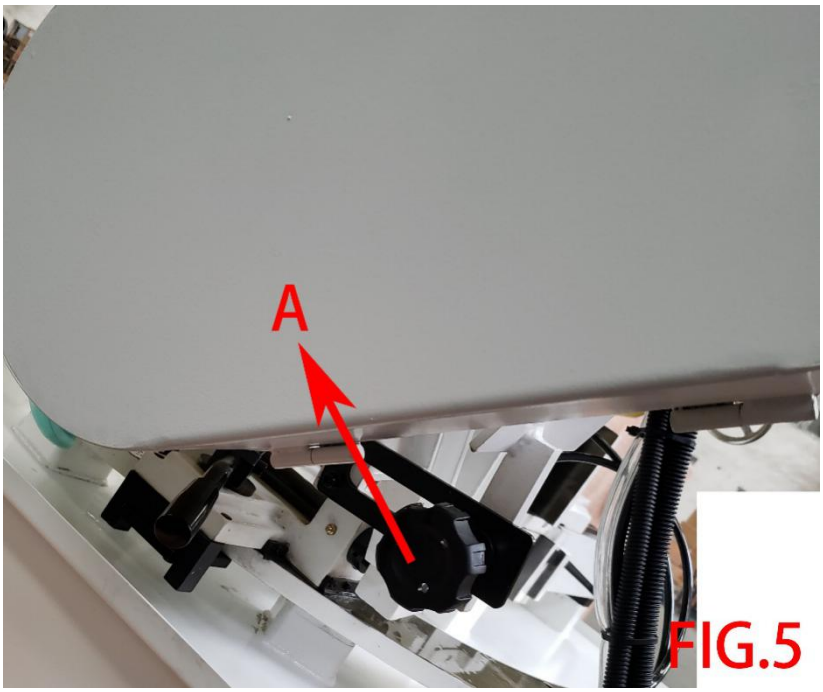
Note: When operating, the right blade guide bracket (A) can be moved as well especially when cutting in 90° to make sure the bracket be moved as close to the vise jaw as possible.



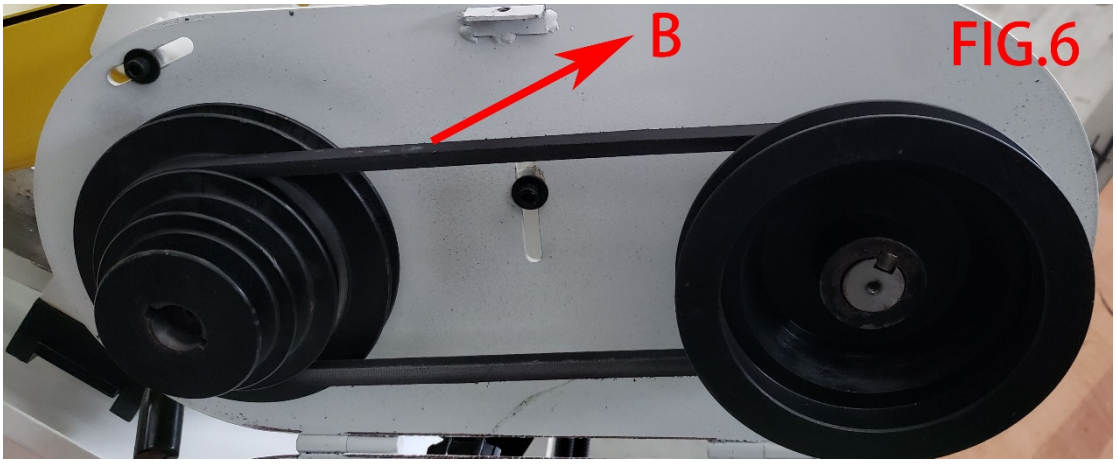
iii.CHANGING SPEEDS

Your machine is provided with a range of four speeds. To change speeds, proceed as follows:

1. Disconnect the machine from the power source.
2. Loosen wing nut and lift up the swing belt and the pulley guard to the front of the machine
3. Release tension on the belt by turning the tension lock knob (A) Fig.5 counterclockwise and lifting the motor swing forward.



4. Shift the belt (B) Fig. 6, to the desired grooves on the pulleys and adjust belt tension by pulling the motor back until correct belt tension is obtained and tighten tension lock knob (A)

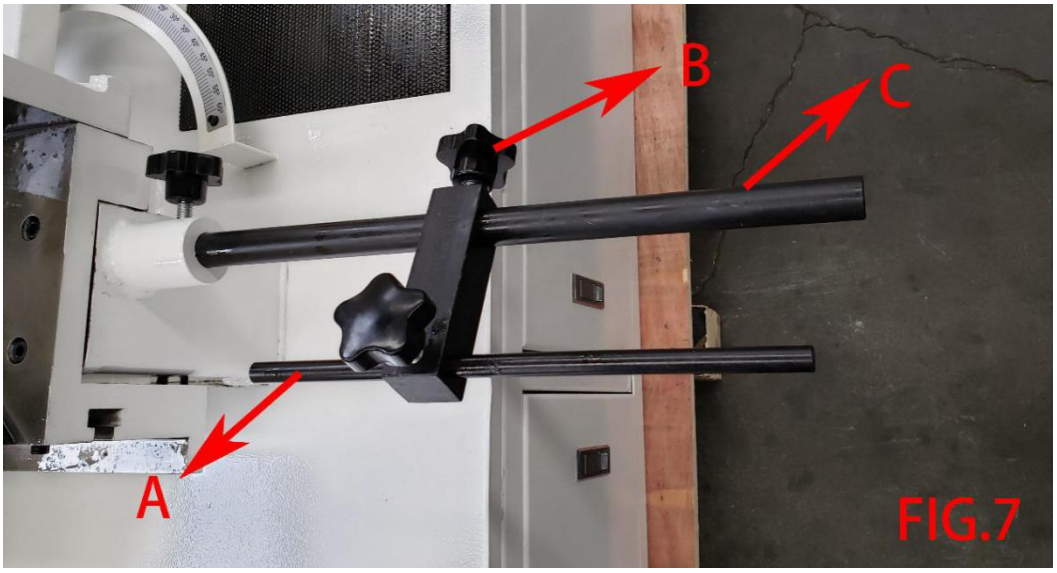


5. Close the belt and pulley guard.

iv. ADJUST STOCK ADVANCE STOP

The Stock Advance Stop is used mainly when more than one piece is to be cut to the same length.

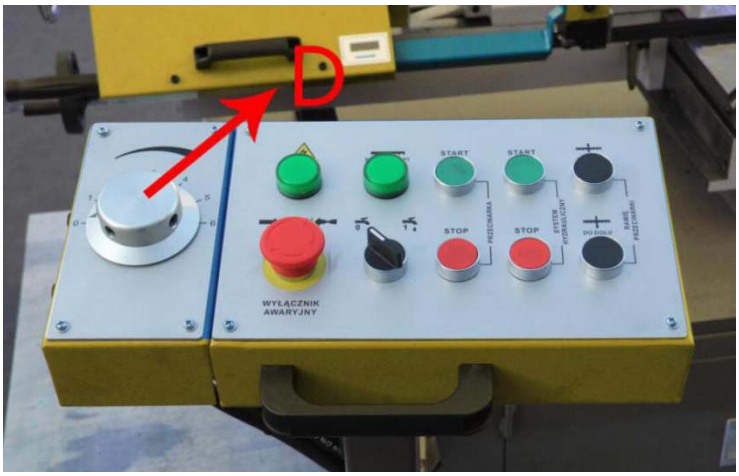
Simply position the stop block (A) FIG. 7, the desire distance away from the blade. The stop may be repositioned by loosening screw (B) and moving the rod (C) accordingly. To move the stop block (A) out of the way simply push it to the down position.



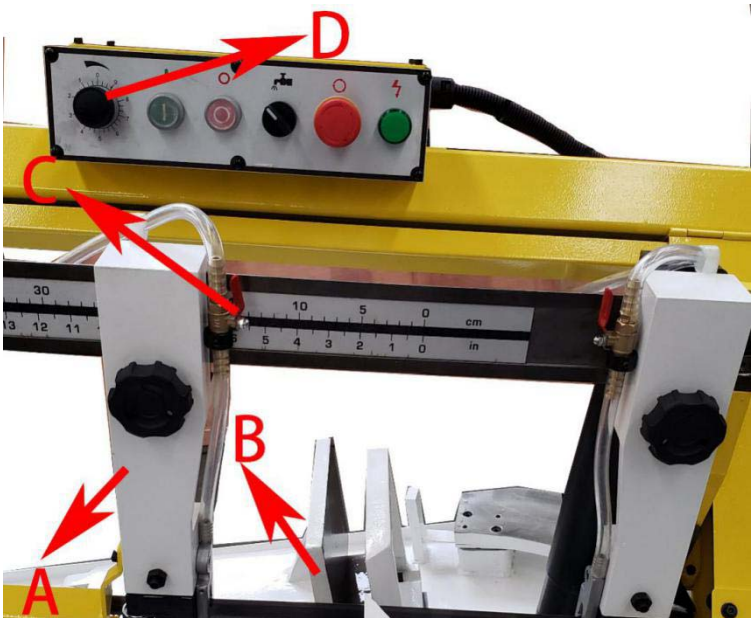
v.SETTING UP THE MACHINE FOR OPERATION

1. Select the proper speed and blade for the type of material you are cutting.
2. Make sure blade tension is adjusted properly.
3. Lift the saw frame up and close the feed rate lever.
4. Place the stock between the vise jaws, set the stock for the desired width of cut and tighten the vise.
5. Make sure the left blade guide bracket (A) is adjusted as close as possible to the left vise jaw (B) Fig. 8
6. Turn the machine on and adjust coolant flow by turning lever (C) Fig. 8.
7. Turn the feed rate lever (D) , counterclockwise until the saw blade begins to lower the desired rate of speed.

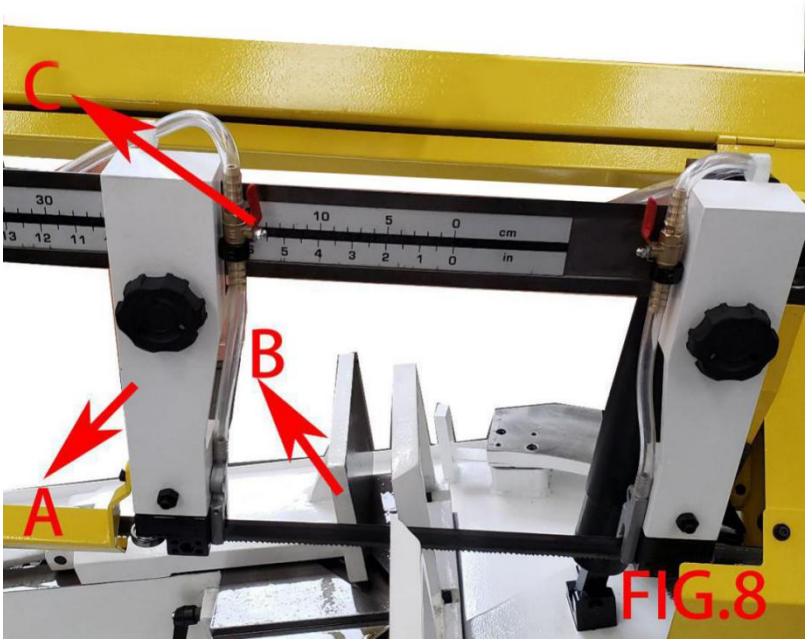
For Model BS-1018TA, BS-1018TH



For Model BS-1018T



8. Proceed to cut throughout the workpiece, as shown in Fig.8. The machine shut off upon completion of cut.



vi. AUTOMATIC SHUT-OFF

The machine and any accessories which are wired into the electrical system are controlled by the start-stop buttons. The machine will automatically shut off when the cut is completed. The switch (A) Fig. 9, for the automatic shut-off contact the top of the support (C) and shuts off the machine.

Lubrication of hydraulic system if it necessary to fill the hydraulic cylinder with oil, proceed as follow:

1. Lift the saw frame little bit (about 15°), pave a block underneath the saw frame to hold it.
2. Loosen jackscrew (B) shown in Fig. 9 counterclockwise, then fill hydraulic oil or equivalent in still it is full. Tighten the screw (B) after fill.

vii. GEAR CASE

After the first 2000 hours of use the gear case should be drained and refilled. Remove drain plug (A) Fig. 10 drain all of the oil out of the gearbox

Remove oil filler plug located underneath the right wheel and fill the gear case with 650ml of multi-function gearbox oil or equivalent.

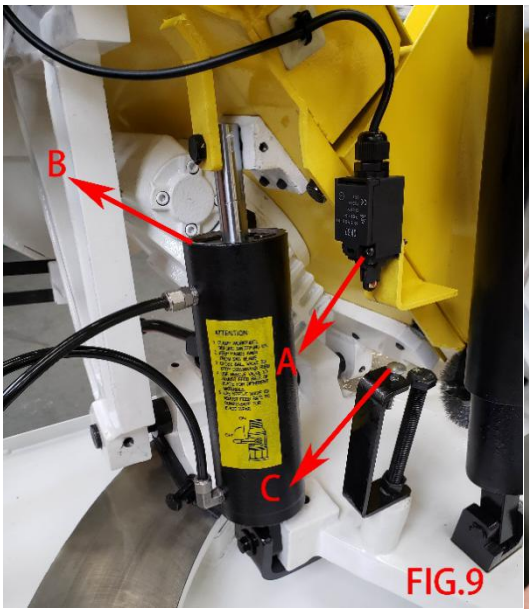


FIG.9

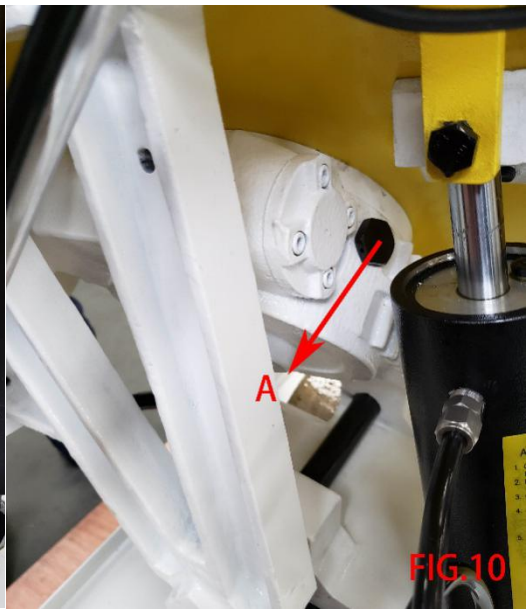


FIG.10

viii. ADJUST BLADE TENSION & BLADE TRACKING ADJUSTMENT

Blade tension has been preset in factory, therefore, by turning handwheel (A) in Fig. 11 clockwise till (B) portion slip then tension for the blade is reached.

Please kind note that one does not to press the handwheel, simply turn it will do. For blade tracking, if the back of the blade is not against the wheel flange properly, loosen the screw (C) in Fig.11, and adjust screw (D) in Fig. 11, until the blade is tracking properly, then tighten screw (C) will do.

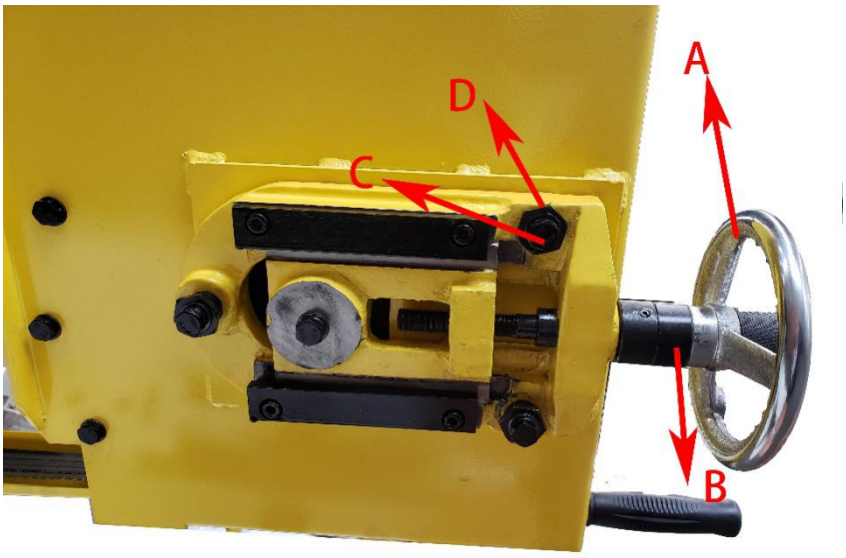
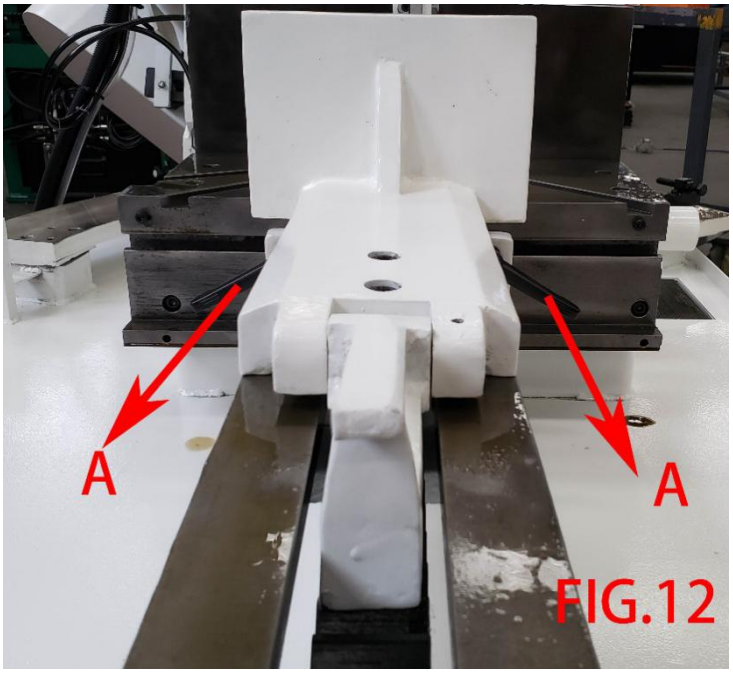


FIG.11

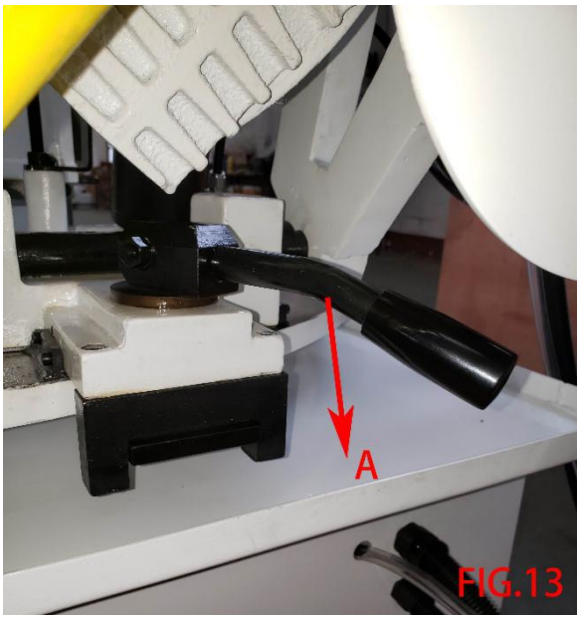
ix.CLAMPING VISE POSITION LOKING LEVER

Because vise can be moved in the direction of workpiece for angle cutting, make sure to tighten both the workpiece levers (A) in Fig. 12, before clamping the workpiece.



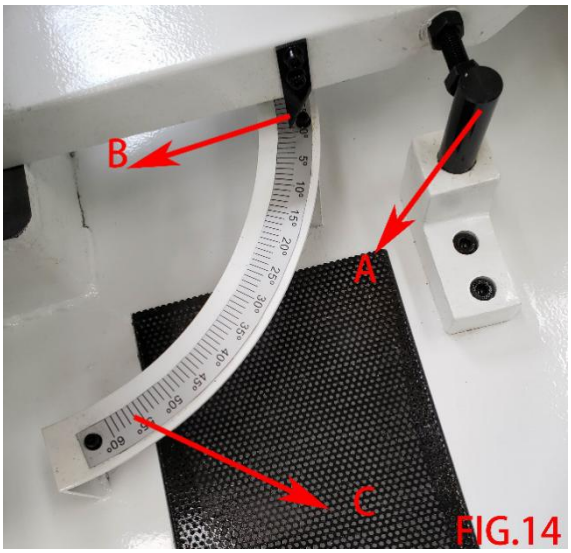
x. FRAME SWIVELING LEVER

Push the lever (A) in Fig. 13, then swivel the saw frame to the angle desired, then pull down the lever (A) to fix the saw frame in position very tight, then tighten the adjusting screw underneath the lever joint.



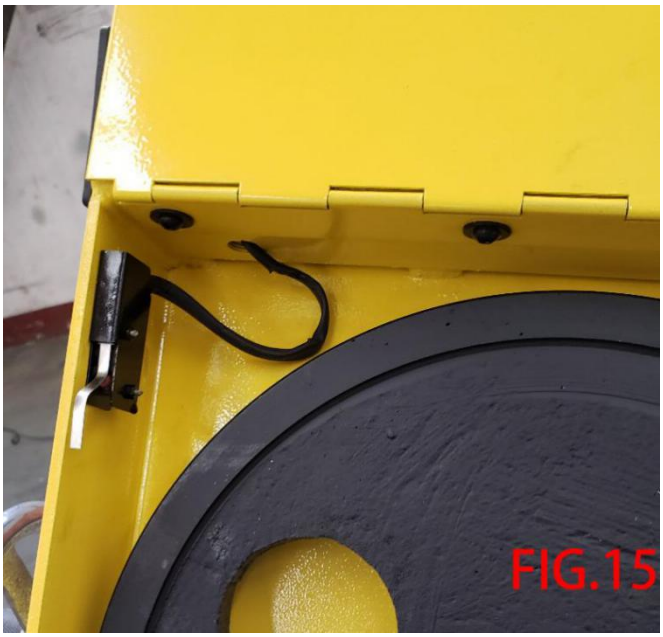
xi. SAW FRAME ANGLE ADJUSTMENT

Upright stopper block (A) in Fig. 14, is measured for 90°, for other angle adjustment, move down the stopper block and use the angle dial ring (C) in Fig. 14, and angle indicator (B) in Fig. 14, to move the saw frame to the angle required.

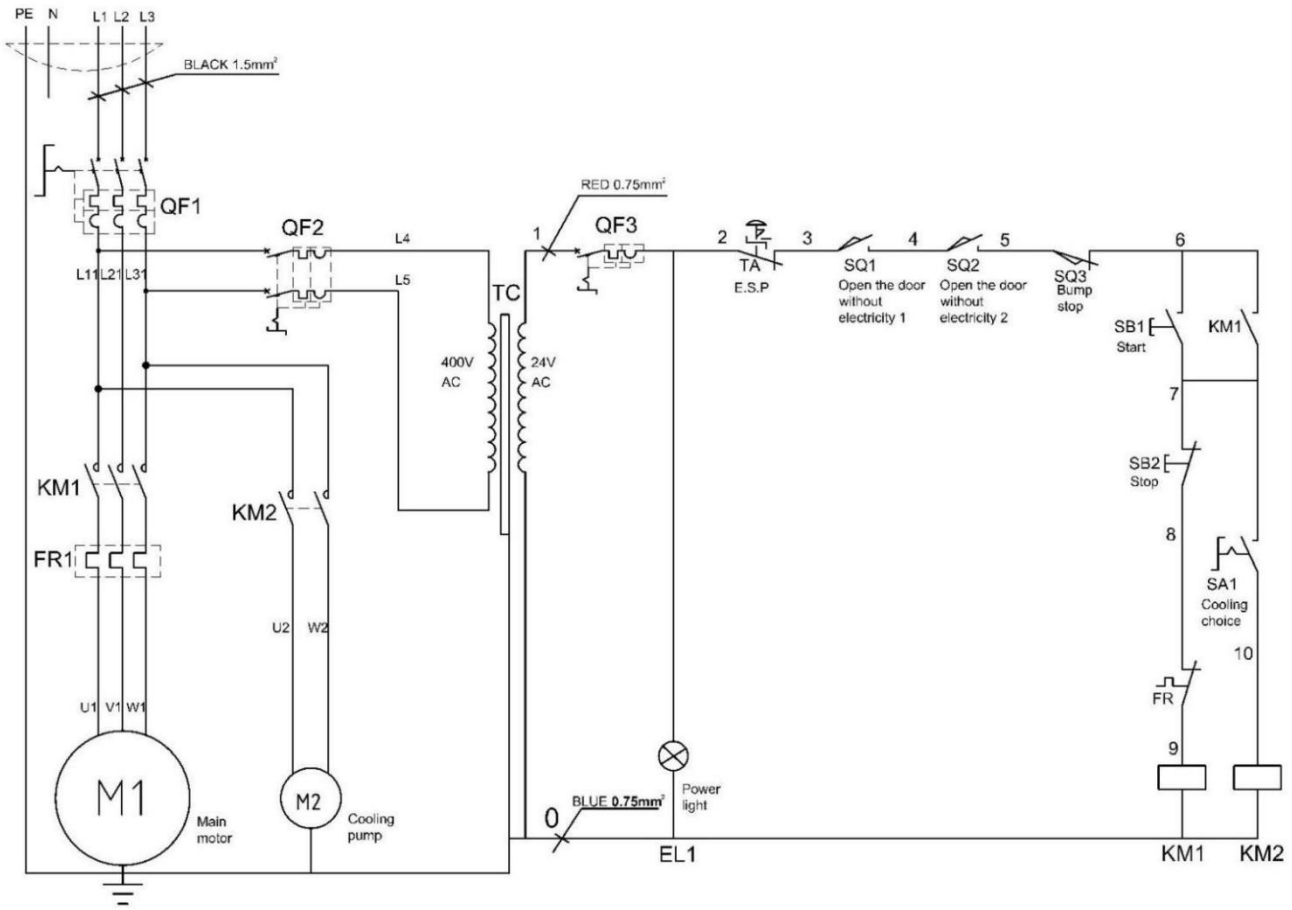


xii. SAFETY DEVICE FOR WHEEL COVERS (CE)

In any case, open the left or right wheel covers during operation will activate the limit switch related to them which will shut-off the machine automatically for safety reason. (see Fig. 15)



Ⅶ. ELECTRICAL DRAWING



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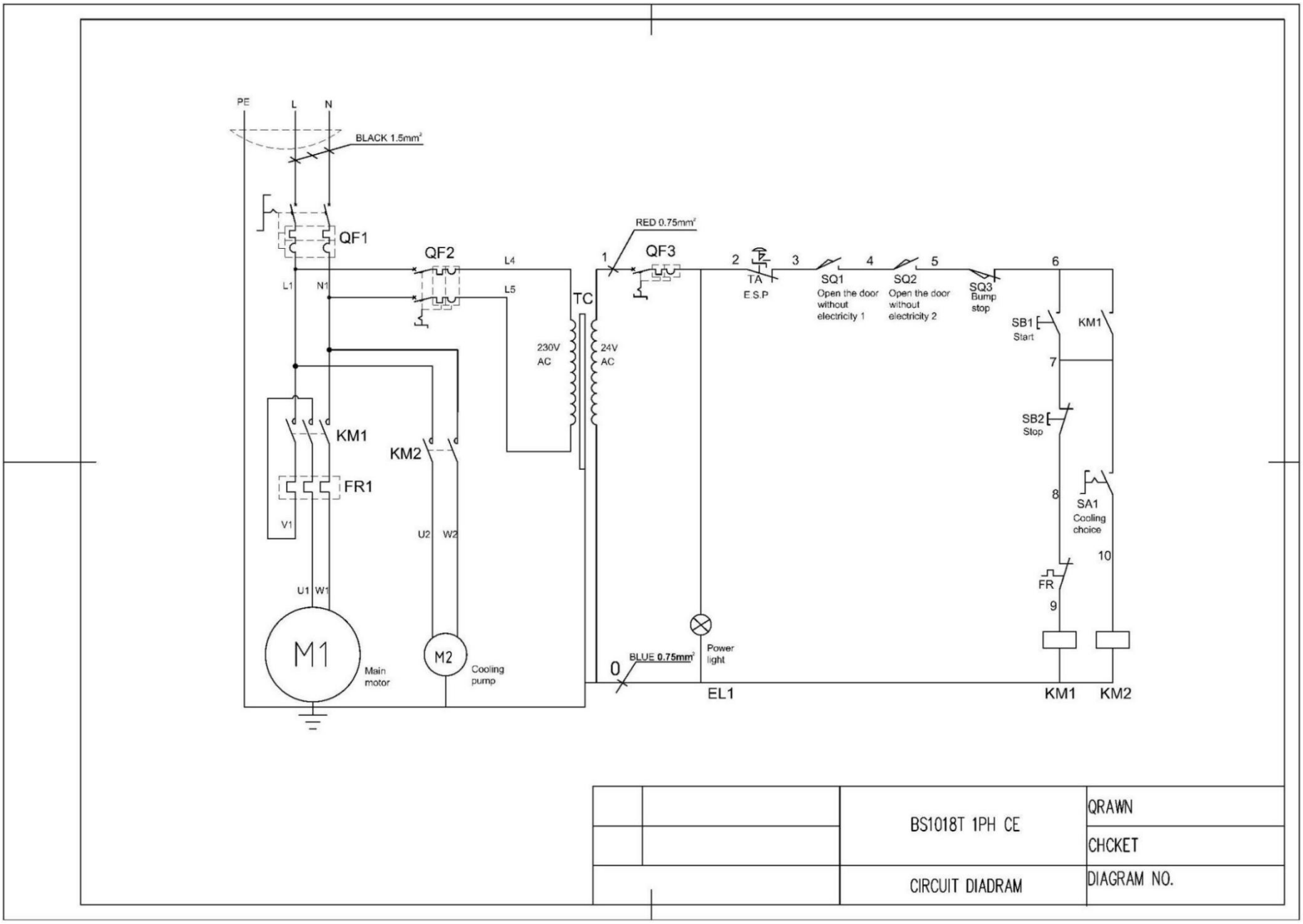
			CHCKET
		CIRCUIT DIADRAM	DIAGRAM NO.



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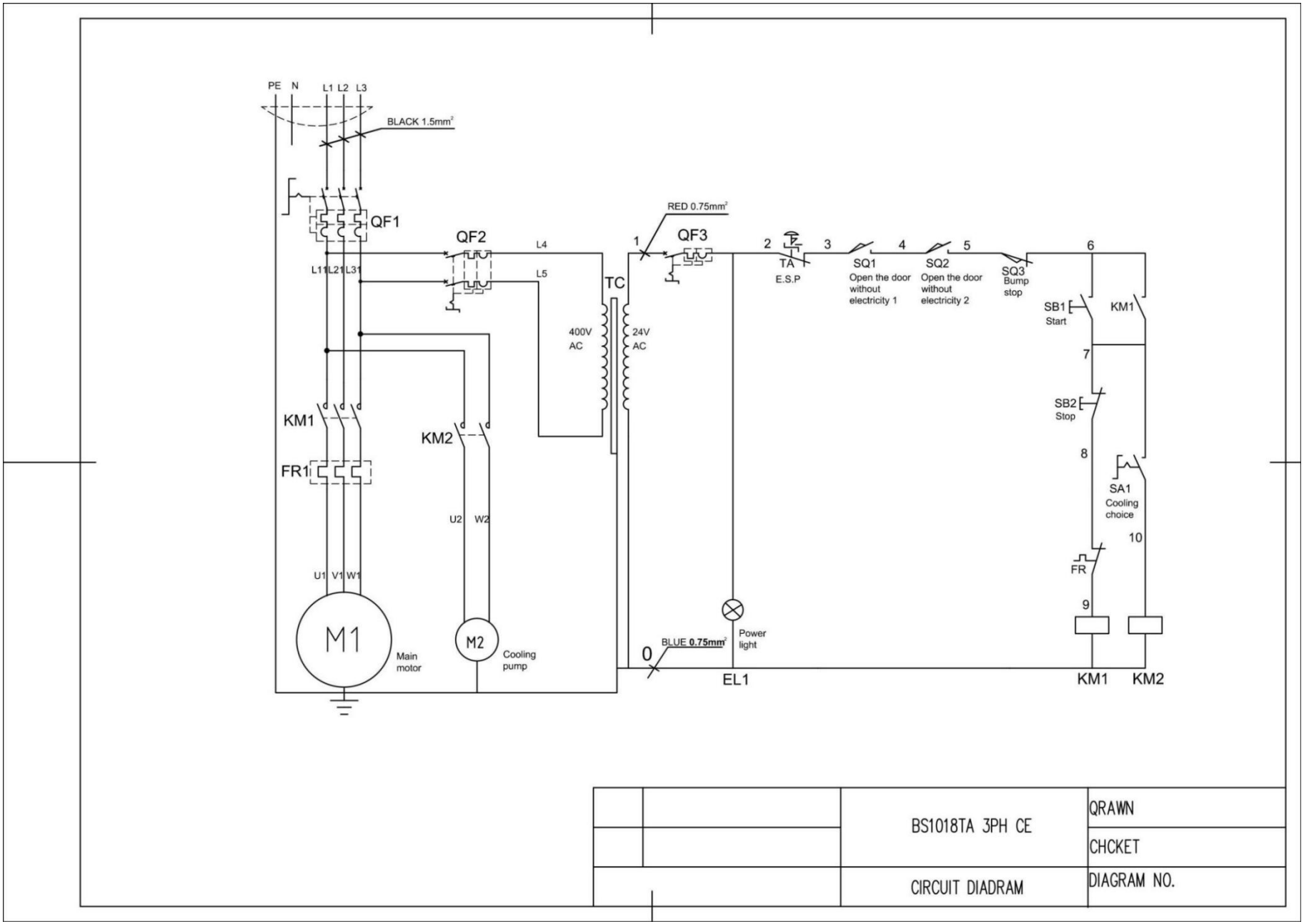

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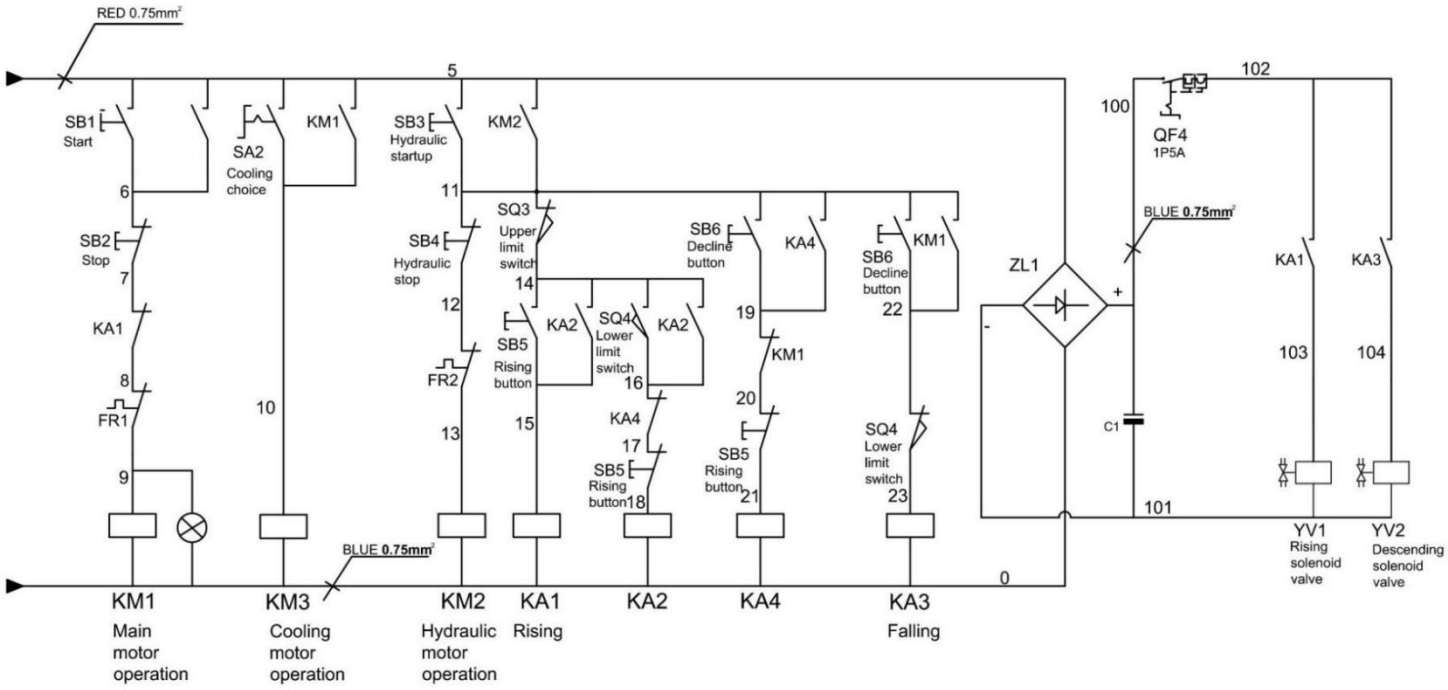

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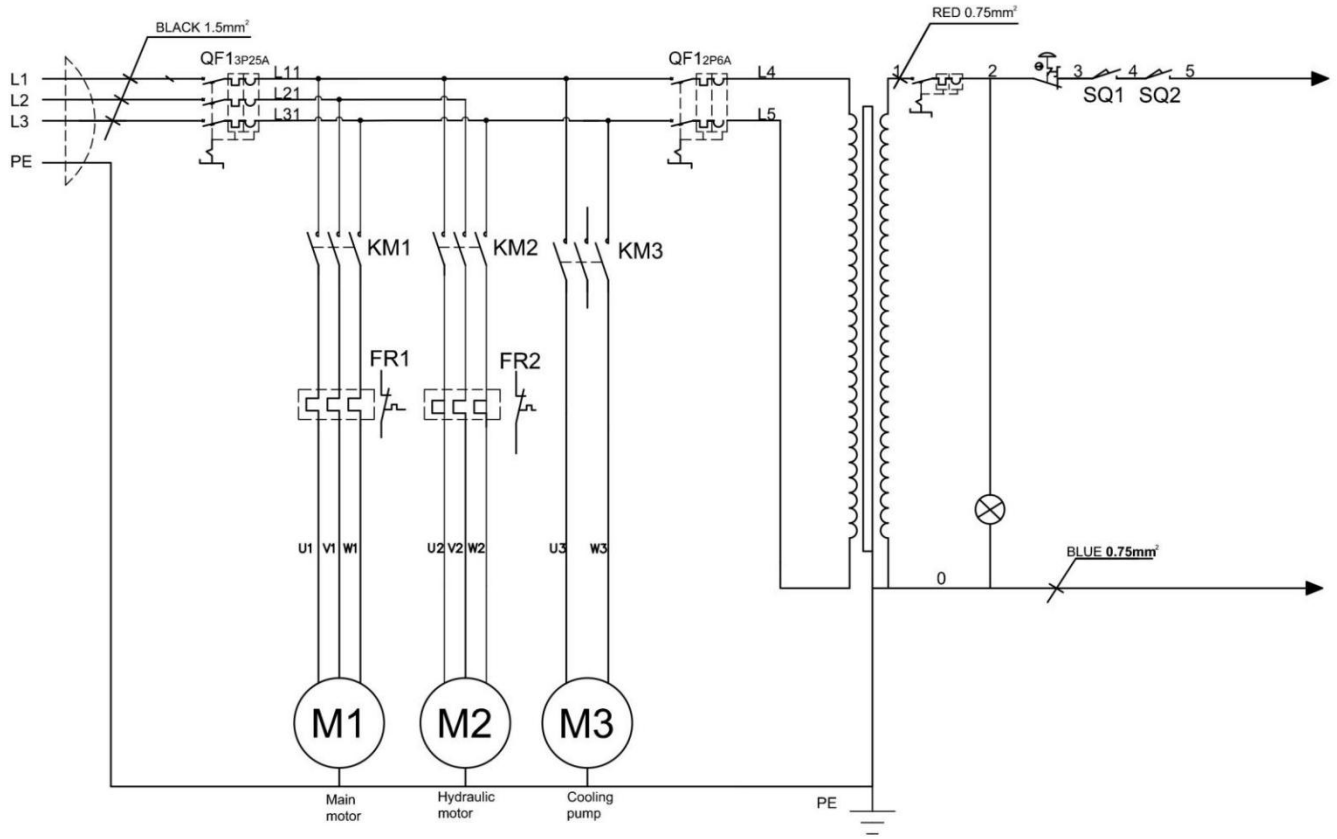

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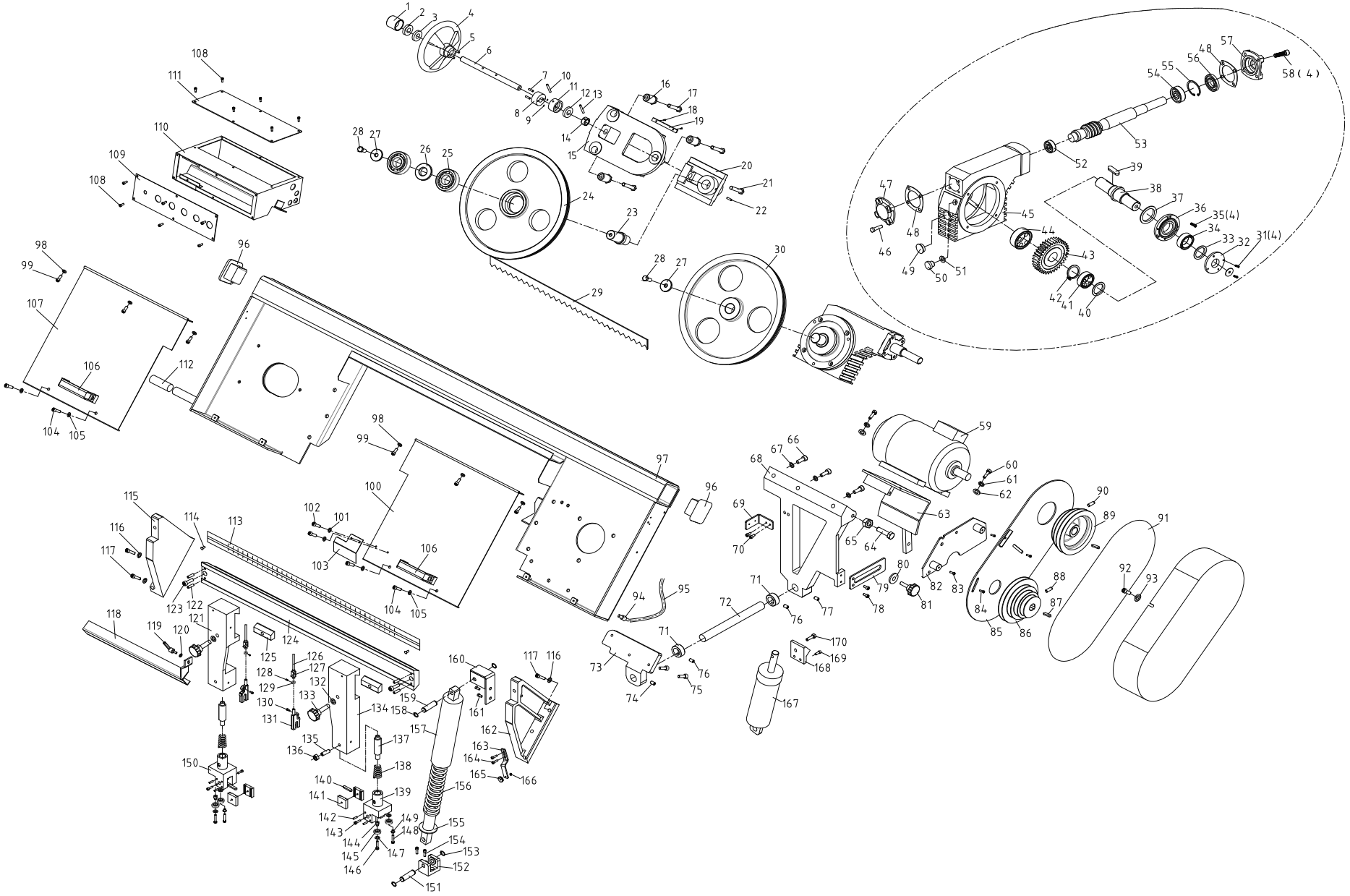
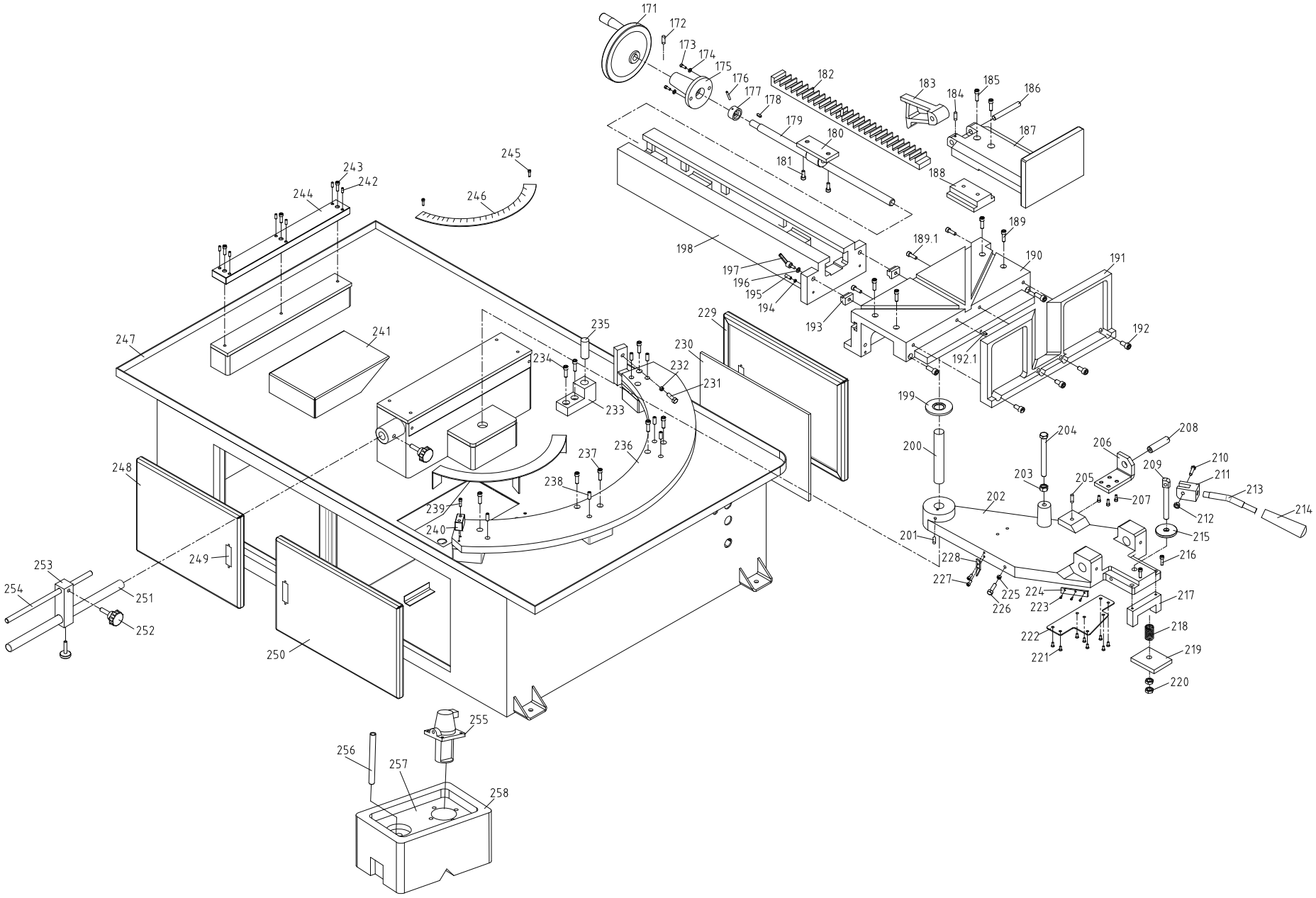
Ⅷ. EXPLOSIVE DRAWING & PART LIST

Drawing for BS-1018T

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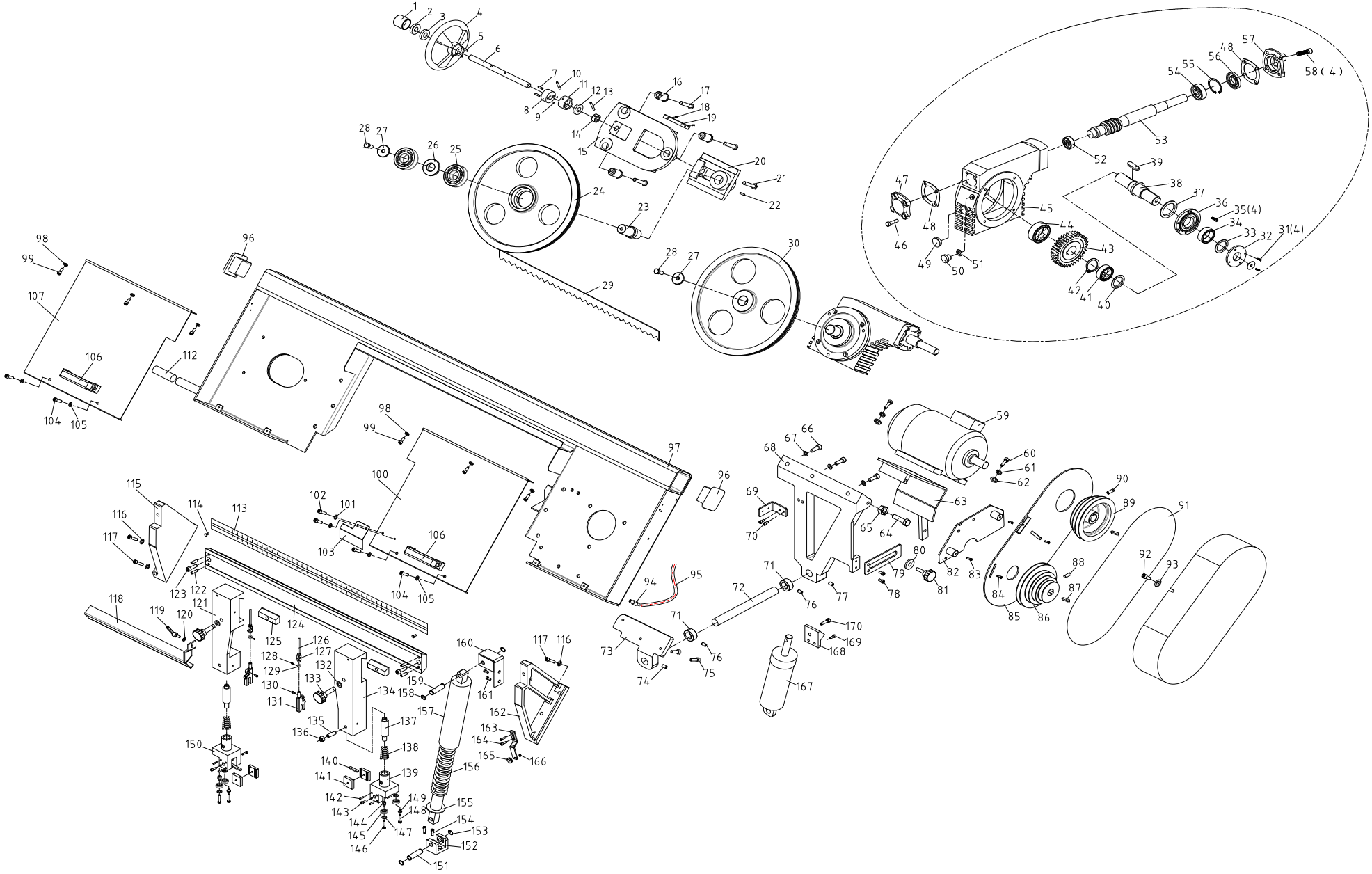
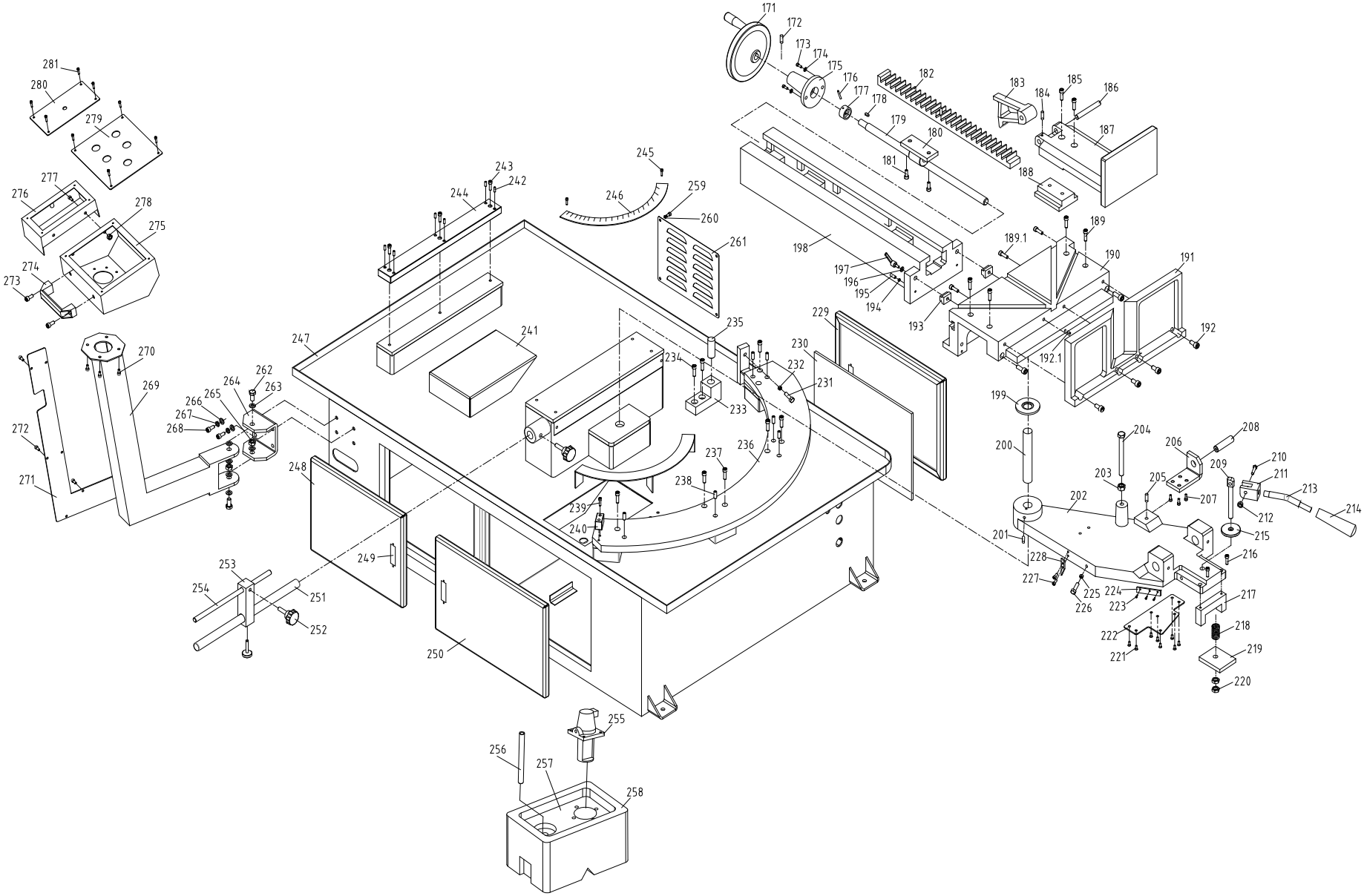
Drawing for BS-1018TA

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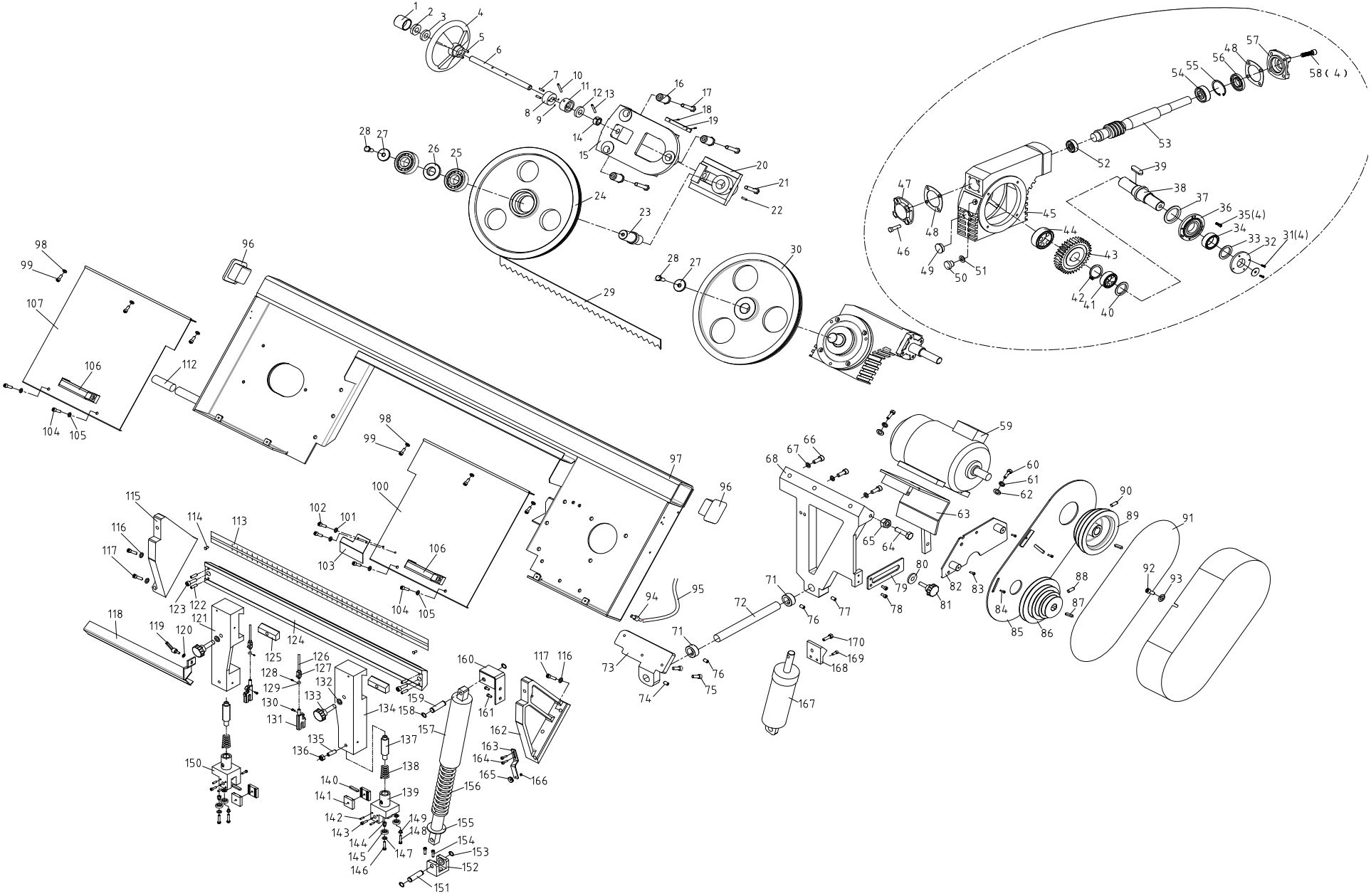
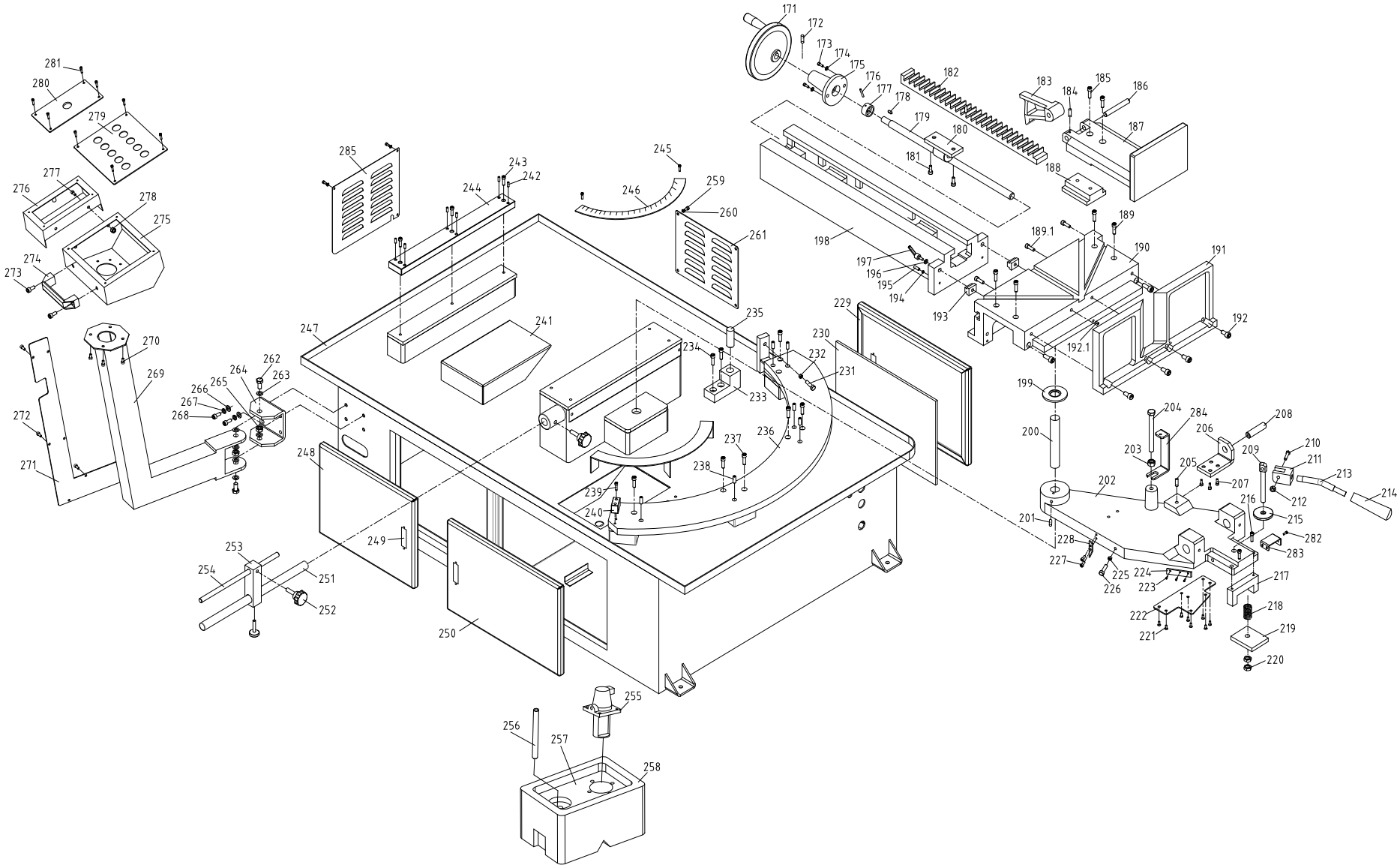
Drawing for BS-1018TH

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Part list for BS-1018T

ITEM NO.	DESC.	QTY		ITEM NO.	DESC.	QTY
1	Adjusting Bush	1		27	Press cover	2
2	Disc Spring	6		28	Bolt M10x25	2
3	Bearing 51103	1		29	Blade	1
4	Hand Wheel	1		30	Drive Wheel	1
5	Spring Pin 5x30	2		31	Screw M5x12	4
6	Adjusting Screw	1		32	Press Cover	1
7	Screw M8x12	2		33	O-ring φ65Xφ2	1
8	Locating sleeve Ⅰ	1		34	Lip Seal φ45Xφ62X8	1
9	Steel Ball Sφ6	2		35	Screw M8x20	4
10	Spring Pin 5x40	1		36	Gear Box Cover	1
11	Locating sleeve Ⅱ	1		37	O-ring φ128Xφ3	1
12	Bearing 51103	1		38	Drive Shaft	1
13	Spring Pin 5x24	1		39	Key 10x50	1
14	Fixed Collar	1		40	Nylon Cushion	1
15	Fixed Seat	1		41	Bearing 30207	1
16	Adjusting Bolt	3		42	Shaft Ring 35	1
17	Bolt M10x55	3		43	Worm Wheel	1
18	Screw M8x16	4		44	Bearing 30206	1
19	Press Plate	2		45	Gear Box	1
20	Sliding Seat	1		46	Screw M6x12	4
21	Bolt M10x35	1		47	Cover	1
22	Screw M8x16	1		48	Washer	2
23	Idle Shaft	1		49	Oil Pointer A10	1
24	Idle Wheel	1		50	Screw	1
25	Bearing 6306-2Z	2		51	O-ring 12.5X1.8	1
26	Spacer bush	1		52	Bearing 6203	1

ITEM NO.	DESC.	QTY		ITEM NO.	DESC.	QTY
53	Worm Shaft	1		79	Belt Tension plate	1
54	Bearing 6206	1		80	Press Cover	1
55	Shaft Ring 30	1		81	Handle M10x25	1
56	Lip Seal φ30Xφ47X7	1		82	Belt Cover plate	1
57	End Cover	1		83	Screw M6x10	3
58	Screw M8x20	4		84	Screw Mx10	2
59	Motor	1		85	Belt Cover	1
60	Bolt M8x25	4		86	Belt Pulley	1
61	Spring Washer 8	4		87	Flat Key 6x50	1
62	Flat Gasket 8	4		88	Screw M8x16	1
63	Stand for motor	1		89	Motor Pulley	1
64	Bolt	2		90	Screw M8x10	1
65	Nut M12	2		91	Belt A-865	1
66	Screw M10x30	3		92	Pan Head Screw M6x8	1
67	Flat Gasket 10	3		93	Flat Gasket 6	1
68	Rear tilted Bracket	1		94	Joint	1
69	Limit switch bracket	1		95	Cooling Pipe	0.8m
70	Screw M6x16	2		96	Tube Cover	2
71	Stop Collar	2		97	Saw Bow	1
72	Rotating Shaft	1		98	Screw	8
73	Front tilted Bracket	1		99	Flat Gasket 6	8
74	Screw M10x12	1		100	Drive Wheel Cover	1
75	Screw M10x25	3		101	Flat Gasket 5	4
76	Screw M6x12	2		102	Screw M5x10	4
77	Screw M10x12	1		103	Brush Backplate	1
78	Screw M6x12	2		104	Screw M6x10	4

ITEM NO.	DESC.	QTY		ITEM NO.	DESC.	QTY
105	Big Flat gasket 6	4		131	Dividing Block	2
106	Handle A120	2		132	Big Flat gasket 10	2
107	Idle Wheel Cover	1		133	Handle φ80×M10×60	2
108	Screw M5x8	12		134	Front Stand	1
109	Control Panel	1		135	Screw M10x30	2
110	Control Box	1		136	Nut M10	2
111	Control Box Cover	1		137	Adjusting Screw	2
112	Handle Grip	1		138	Spring	2
113	Scale	1		139	Guide seat (front)	1
114	Rivet 2x5	2		140	Friction Block	2
115	Rear Bracket	1		141	Clamping Block	4
116	Flat gasket 10	6		142	Screw M6x16	8
117	Screw M10x25	6		143	Screw M6x16	4
118	Blade Backplate	1		144	Eccentric Sleeve Ⅱ	1
119	Adjustable set Handle	1		145	Bearing 6200-2Z	4
120	Flat gasket	1		146	Screw M6x30	2
121	Rear stand	1		147	Big Flat gasket 6	4
122	Screw M8x16	4		148	Screw M6x25	2
123	Screw M10x30	2		149	Eccentric Sleeve Ⅰ	2
124	Slide Rail	1		150	Guide seat (Rear)	1
125	Lock block	2		151	Lower Shaft	1
126	Cooling Pipe	2.5m		152	Lower Bracket	1
127	Switch Valve	2		153	Circlips for shaft 12	2
128	Screw M5x10	2		154	Screw M8x16	2
129	Fixed collar	2		155	Inner support	1
130	Screw M6x12	2		156	Pressure Spring	1

ITEM NO.	DESC.	QTY		ITEM NO.	DESC.	QTY
157	Pressure Spring Cover	1		183	Back Block	1
158	Shaft ring 12	2		184	Screw M5x6	1
159	Upper Shaft	1		185	Screw M10x50	2
160	Upper Bracket	1		186	Fixed Shaft	1
161	Screw M8x12	2		187	Moving Vise	1
162	Front Bracket	1		188	Sliding Block	1
163	Brush Stand	1		189	Screw M8x35	4
164	Screw M6x12	2		189.1	Screw M8x50	5
165	Brush	1		190	Work Table	1
166	Spacer sleeve	1		191	Fixed Vise	1
167	Hydraulic Cylinder	1		192	Screw M8x35	4
168	Upper Bracket for Cylinder	1		192.1	Screw M6x10	1
169	Screw M8x16	2		193	T-block	2
170	Hinge Bolt M10x45	1		194	Copper block	2
171	Hand Wheel	1		195	Screw M6x10	2
172	Screw M6x8	1		196	Flat gasket 10	2
173	Screw M8x35	2		197	Adjustable set Handle	2
174	Flat gasket 8	2		198	Vise Base	1
175	Block cover	1		199	Friction Cushion	1
176	Spring Pin 5x28	1		200	Rotating Shaft	1
177	Fixed collar	1		201	Oil Cup M8x1	3
178	Flat Key 5x15	1		202	Swivel Arm	1
179	Lead Screw	1		203	Nut M12	1
180	Acme Nut	1		204	Bolt M12x130	1
181	Screw M8x16	2		205	Screw M10x12	1
182	Rack	1		206	Cylinder Lower Bracket	1

ITEM NO.	DESC.	QTY		ITEM NO.	DESC.	QTY
207	Screw M8x16	4		233	Limit Bolck	1
208	Lower Shaft	1		234	Screw M8x35	2
209	Lock Shaft	1		235	Limit Shaft	1
210	Screw M8x45	1		236	Sliding seat	1
211	Locking Block	1		237	Screw M8x35	8
212	Nut M8	1		238	Screw M8x20	8
213	Handle Shaft	1		239	Screw M6x30	2
214	Handle Grip	1		240	Limit Block	2
215	Locking Pad	1		241	Filter Mesh Plate	1
216	Screw M6x35	2		242	Screw M6x12	6
217	Block	1		243	Screw M8x35	3
218	Spring	1		244	Base Lining Plate	1
219	Lock plate	1		245	Screw M5x10	2
220	Thin Nut M12	2		246	Scale	1
221	Screw M5x12	8		247	Base	1
222	Friction Plate	1		248	Tool Box Door	1
223	Screw M4x10	6		249	Door Lock	3
224	Chip Clean Plate	2		250	Coolant Door	1
225	Nut M10	1		251	Connection Shaft Ⅰ	1
226	Bolt M10x45	1		252	Handle M10X25	3
227	Screw M5x8	2		253	Connection Block	1
228	Pointer	1		254	Connection Shaft Ⅱ	1
229	Cover for elec. box	1		255	Cooling Pump	1
230	Circuit board	1		256	Coolant Hose	0.5m
231	Bolt M10x35	2		257	Tank Cover	1
232	Nut M10	2		258	Cooling Tank	1

Part list for BS-1018TA, BS-1018TH

ITEM NO.	DESC.	QTY		ITEM NO.	DESC.	QTY
1	Adjusting Bush	1		27	Press cover	2
2	Disc Spring φ31.5Xφ16.3X1.5	6		28	Bolt M10X25	2
3	Bearing 51103	1		29	Blade	1
4	Hand Wheel	1		30	Drive Wheel	1
5	Spring Pin 5X30	2		31	Screw M5X12	4
6	Adjusting Screw	1		32	Press Cover	1
7	Screw M8X12	2		33	O-ring φ65Xφ2	1
8	Locating sleeve Ⅰ	1		34	Lip Seal φ45Xφ62X8	1
9	Steel Ball Sφ6	2		35	Screw M8X20	4
10	Spring Pin 5X40	1		36	Gear Box Cover	1
11	Locating sleeve Ⅱ	1		37	O-ring φ128Xφ3	1
12	Bearing 51103	1		38	Drive Shaft	1
13	Spring Pin 5X24	1		39	Key 10X50	1
14	Fixed Collar	1		40	Nylon Cushion 0.5	1
15	Fixed Seat	1		41	Bearing 30207	1
16	Adjusting Bolt	3		42	Shaft Ring 35	1
17	Bolt M10X55	3		43	Worm Wheel	1
18	Screw M8X16	4		44	Bearing 30206	1
19	Press Plate	2		45	Gear Box	1
20	Sliding Seat	1		46	Screw M6X12	4
21	Bolt M10X35	1		47	Cover	1
22	Screw M8X16	1		48	Washer	2
23	Idle Shaft	1		49	Oil Pointer A10	1
24	Idle Wheel	1		50	Screw	1
25	Bearing 6306-2Z	2		51	O-ring 12.5X1.8	1
26	Spacer bush	1		52	Bearing 6203	1

ITEM NO.	DESC.	QTY		ITEM NO.	DESC.	QTY
53	Worm Shaft	1		77	Screw M10X12	1
54	Bearing 6206	1		78	Screw M6X12	2
55	Shaft Ring 30	1		79	Belt Tension plate	1
56	Lip Seal φ30Xφ47X7	1		80	Press Cover	1
57	End Cover	1		81	Handle M10X25	1
58	Screw M8X20	4		82	Belt Cover plate	1
59	Motor	1		83	Screw M6x10	3
60	Bolt M8X25	4		84	Screw M6x10	2
61	Spring Washer 8	4		85	Belt Cover	1
62	Flat Gasket 8	4		86	Belt Pulley	1
63	Stand for motor	1		87	Flat Key 6X50	1
64	Bolt	2		88	Screw M8X16	1
65	Nut M12	2		89	Motor Pulley	1
66	Screw M10x30	3		90	Screw M8X10	1
67	Flat Gasket 10	3		91	Belt A-880	1
68	Rear tilted Bracket	1		92	Pan Head Screw M6X8	1
69	Limit switch bracket (for BS-1018TA only)	1		93	Flat Gasket 6	45
70	Screw M6x16 (for BS-1018TA only)	2		94	Joint G3/8″-φ7.5	1
71	Stop Collar	2		95	Cooling Pipe φ12Xφ8	0.8 m
72	Rotating Shaft	1		96	Tube Cover	2
73	Front tilted Bracket	1		97	Saw Bow	1
74	Screw M10X12	1		98	Screw	8
75	Screw M10X25	3		99	Flat Gasket 6	8
76	Screw M6X12	2		100	Drive Wheel Cover	1

ITEM NO.	DESC.	QTY		ITEM NO.	DESC.	QTY
101	Flat Gasket 5	4		130	Screw M6x12	2
102	Screw M5x10	4		131	Dividing Block	2
103	Brush Backplate	1		134	Front Stand	1
104	Screw M6x10	4		132	Big Flat gasket 10	2
105	Big Flat gasket 6	4		133	Handle φ80×M10×60	2
106	Handle A120	2		135	Screw M10x30	2
107	Idle Wheel Cover	1		136	Nut M10	2
112	Handle Grip	1		137	Adjusting Screw	2
113	Scale	1		138	Spring	2
114	Rivet 2x5	2		139	Guide seat (front)	1
115	Rear Bracket	1		140	Friction Block	2
116	Flat gasket 10	6		141	Clamping Block	4
117	Screw M10x25	6		142	Screw M6x16	8
118	Blade Backplate	1		143	Screw M6x16	4
119	Adjustable set Handle M6X12	1		144	Eccentric Sleeve Ⅱ	1
120	Flat gasket 6	1		145	Bearing 6200-2Z	4
121	Rear stand	1		146	Screw M6x30	2
122	Screw M8x16	4		147	Big Flat gasket 6	4
123	Screw M10x30	2		148	Screw M6x25	2
124	Slide Rail	1		149	Eccentric Sleeve Ⅰ	2
125	Lock block	2		150	Guide seat (Rear)	1
126	Cooling Pipe φ12Xφ8	2.5m		151	Lower Shaft	1
127	Switch Valve φ9.5	2		152	Lower Bracket	1
128	Screw M5x10	2		153	Circlip for shaft 12	2
129	Fixed collar	2		154	Screw M8x16	2

ITEM NO.	DESC.	QTY		ITEM NO.	DESC.	QTY
155	Inner support	1		181	Screw M8x16	2
156	Pressure Spring	1		182	Rack	1
157	Pressure Spring Cover	1		183	Back Block	1
158	Shaft ring 12	2		184	Screw M5x6	1
159	Upper Shaft	1		185	Screw M10x50	2
160	Upper Bracket	1		186	Fixed Shaft	1
161	Screw M8x12	2		187	Moving Vise	1
162	Front Bracket	1		188	Sliding Block	1
163	Brush Stand	1		189	Screw M8x35	4
164	Screw M6x12	2		189.1	Screw M8x50	5
165	Brush φ75	1		190	Work Table	1
166	Spacer sleeve	1		191	Fixed Vise	1
167	Hydraulic Cylinder	1		192	Screw M8x35	4
168	Upper Bracket for Cylinder	1		192.1	Screw M6x10	1
169	Screw M8x16	2		193	T-block	2
170	Hinge Bolt M10x45	1		194	Copper block	2
171	Hand Wheel φ125Xφ15	1		195	Screw M6x10	2
172	Screw M6x8	1		196	Flat gasket 10	2
173	Screw M8x35	2		197	Adjustable set Handle M10X40	2
174	Flat gasket 8	2		198	Vise Base	1
175	Block cover	1		199	Friction Cushion	1
176	Spring Pin 5x28	1		200	Rotating Shaft	1
177	Fixed collar	1		201	Oil Cup M8x1	3
178	Flat Key 5x15	1		202	Swivel Arm	1
179	Lead Screw	1		203	Nut M12	1
180	Acme Nut	1		204	Bolt M12x130	1

ITEM NO.	DESC.	QTY		ITEM NO.	DESC.	QTY
205	Screw M10x12	1		230	Circuit board	1
206	Cylinder Lower Bracket	1		231	Bolt M10x35	2
207	Screw M8x16	4		232	Nut M10	2
208	Lower Shaft	1		233	Limit Bolck	1
209	Lock Shaft	1		234	Screw M8x35	2
210	Screw M8x45	1		235	Limit Shaft	1
211	Locking Block	1		236	Sliding seat	1
212	Nut M8	1		237	Screw M8x35	8
213	Handle Shaft	1		238	Screw M8x20	8
214	Handle Grip	1		239	Screw M6x30	2
215	Locking Pad	1		240	Limit Block	2
216	Screw M6x35	2		241	Filter Mesh Plate	1
217	Block	1		242	Screw M6x12	6
218	Spring	1		243	Screw M8x35	3
219	Lock plate	1		244	Base Lining Plate	1
220	Thin Nut M12	2		245	Screw M5x10	2
221	Screw M5x12	8		246	Scale	1
222	Friction Plate	1		247	Base	1
223	Screw M4x10	6		248	Tool Box Door	1
224	Chip Clean Plate	2		249	Door Lock MS720-Ⅱ	3
225	Nut M10	1		250	Coolant Door	1
226	Bolt M10x45	1		251	Connection Shaft Ⅰ	1
227	Screw M5x8	2		252	Handle M10X25	3
228	Pointer	1		253	Connection Block	1
229	Cover for elec.box	1		254	Connection Shaft Ⅱ	1

ITEM NO.	DESC.	QTY		ITEM NO.	DESC.	QTY
255	Cooling Pump ZD-130	1		271	Cover	1
256	Coolant Hose φ30Xφ25	0.5m		272	Screw M6X12	8
257	Tank Cover	1		273	Screw M8X20	2
258	Cooling Tank	1		274	Square Handle A120	1
259	Screw M6X12	4		275	Electric Box	1
260	Flat Gasket 6	4		276	Hydraulic Box	1
261	Cover	1		277	Screw M6X12	2
262	Bolt M12X40	2		278	Nut M6	2
263	Flat Gasket 12	6		279	Electric operation Panel	1
264	Fixed Seat	1		280	Control Panel for speed	1
265	Nut M12	2		281	Screw M4X8	8
266	Flat Gasket 8	4		282	Screw M5X10 (for BS-1018TH only)	2
267	Spring Washer 8	4		283	Bracket for rising limit switch (for BS-1018TH only)	1
268	Screw M8X30	4		284	Bracket for lower limit switch (for BS-1018TH only)	1
269	Swinging Arm	1		285	Flat Gasket (for BS-1018TH only)	1
270	Screw M6X12	4				

Note: This manual is only for your reference. Owing to the continuous improvement of the machine, changes maybe made at any time without obligation on notice. And please note the local voltage while operating this electric machine.