

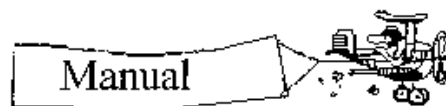


Bandsaw Specialist

Instruction Manual

Model AH-360C

Automatic Horizontal



COSEN MACHINERY INDUSTRIAL CO.,LTD.

NOTICE: Please read this instruction manual carefully to obtain a thorough knowledge of installation, operation and maintenance. Please remember the following: Correctly operate the machine as described in the manual to prevent accident. Do not operate the machine by guesswork. We suggest you always keep manual at hand and refer to it whenever you are not sure of how to perform any procedures for AH-360C.

TECHNICAL ADVICE/ SPARE PARTS

- ☎ Please contact the COSEN-representative in your local area in case you need any technical advice or if you want to order spare parts.



Instruction Manual:

AH-360C Horizontal Bandsaw

Ver. 1 -- Date : 02/17/1996

© 1995 by COSEN CO., LTD./ R&D DIVISION.

110 Ching-Fu Street Hsin-Chu 300, Taiwan, R.O.C.

Tel: 886-3-5332143~5 Fax: 886-3-5348324

No part of this publication may be photocopied or otherwise reproduced without the prior written permission of COSEN CO., LTD.

Specification of the Machine

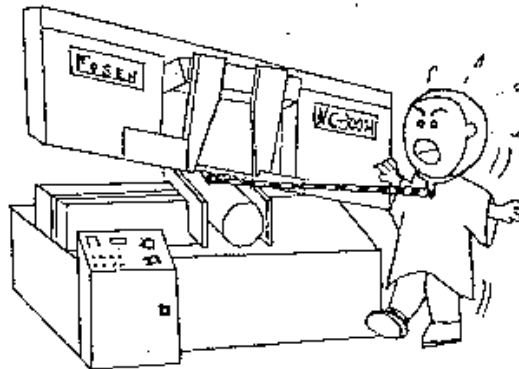
MODEL		AH-360C Automatic Band Saw Machine	
MAX. CAPACITY		●	360mm (14")
		■ (W× H)	310mm × 310mm (12"× 12")
		■ (W× H)	380mm × 350mm (15"× 13.8")
SAW BLADE	SPEED	60 Hz	27,40,54,68,80 m/min. 89,132,178,224,264 fpm
		50 Hz	23,34,45,57,67 m/min 75,112,148,187,220 fpm
	SIZE (W× L× T)	32mm × 4115mm × 1.1mm (1.25"W × 162"L × 0.042"T)	
MOTOR OUTPUT		HYDRAULIC	0.18kW (1/4 HP)
		SAW BLADE	3.75 kW (5 HP)
		COOLANT PUMP	0.1kW (1/8 HP)
		WISE ROLLER	0.18kW (1/4HP)
HYDRAULIC TANK		25L (6.2gal.)	
COOLANT		60 L (15 gal.)	
HEIGHT OF WORK BED		665 mm (26")	
NET WEIGHT		650 kgs (1430lbs)	
GROSS WEIGHT		800 kgs (1760 lbs)	
FLOOR SPACE (L× W× H)		2286× 1194× 1600 mm (90"× 47"× 63")	
SHIPPING SPACE (L×W×H)		2386× 1300× 1700mm (94"× 50.5"× 67")	

* Design & specifications are subject to change without notice

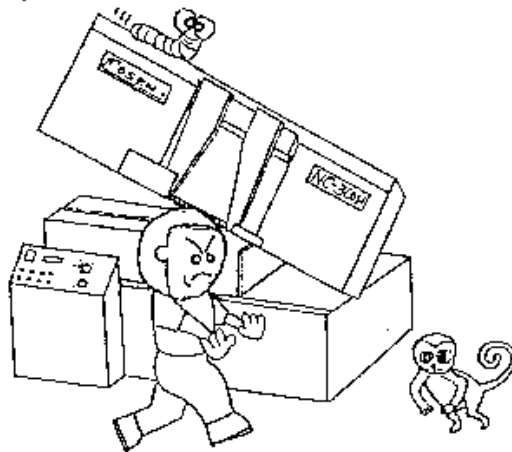
SAFETY RULES

SAFETY RULES

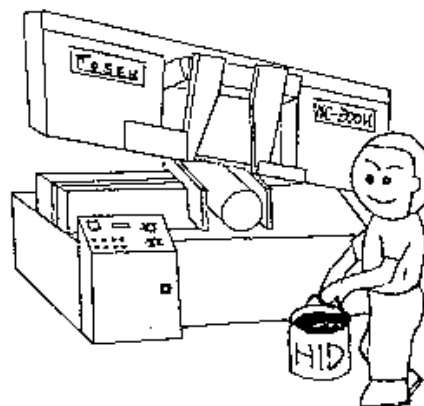
- Never wear gloves, jewelry or loose clothing when operation the machine. It is dangerous if they are caught in the running machine.



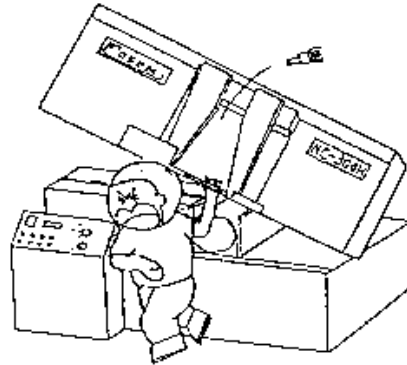
- Be sure to confirm that the area around the machine is cleared of people and obstacles every time before starting the machine or operation.



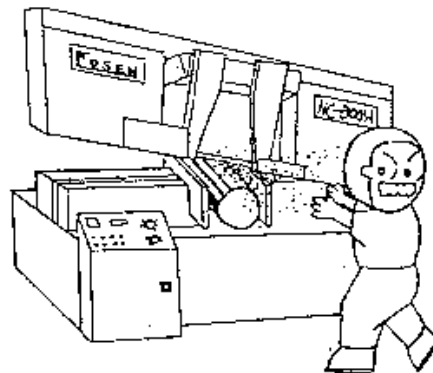
- Use a water-soluble cutting fluid in this machine. Oil-based cutting fluids may emit smoke or catch fire, depending on conditions.



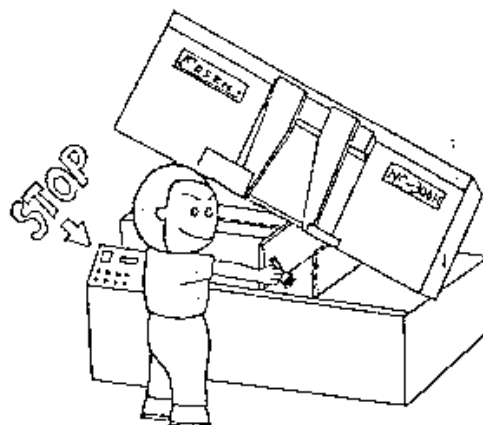
- Never try to adjust the wire brush on the saw blade or to remove chips when the saw blade is running. It is dangerous if your hands or clothing are caught by the running blade.



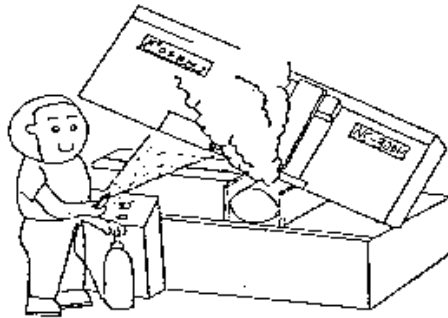
- Never cut carbon or any other material that produces and disperses explosive dust on this machine. Sparks from motors and other machine parts may ignite and explode the air-borne dust. The machine needs special measures for cutting explosive materials.



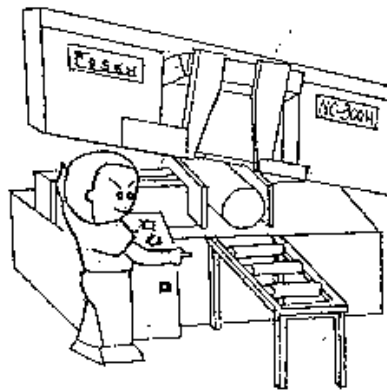
- Stop the saw blade when cleaning the machine. It is dangerous if your hands or clothing are caught by the running blade.



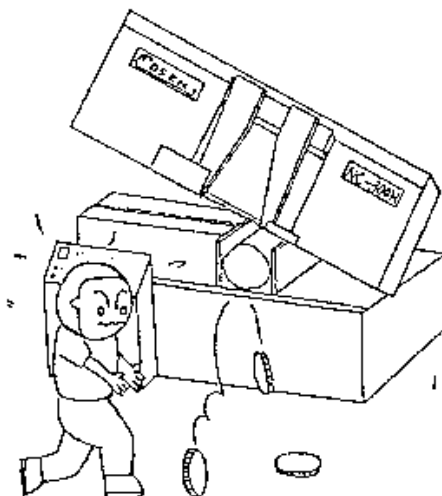
■ Be sure to prohibit any use of fire in the shop, and install a fire extinguisher or other fire control device near the machine when cutting titanium, magnesium, or any other material that produces flammable chips. Never operate the machine unattended when cutting flammable materials.



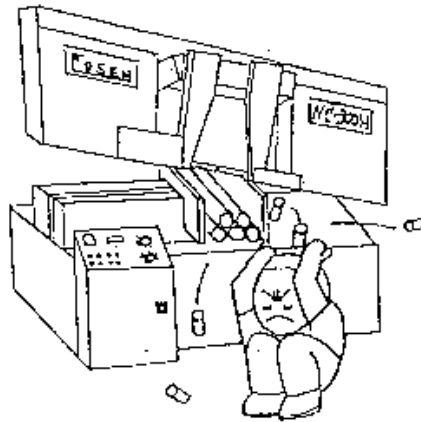
■ Use roller tables on both the front and rear sides of the machine when cutting long work. It is dangerous if work falls off the machine.



■ Take preventative measures when cutting thin or short pieces to keep the cut pieces from falling. It is dangerous if cut pieces fall.



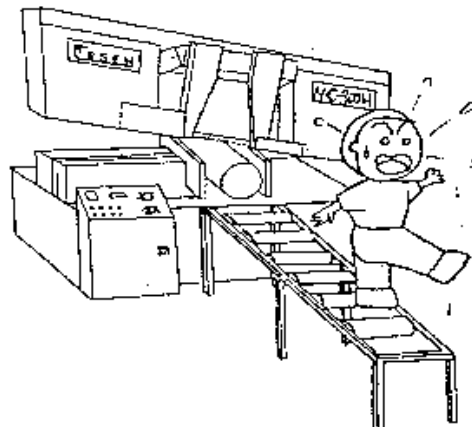
■ Never start the saw blade until you have confirmed that the work is firmly clamped. If the work is not securely clamped by the vise, it may be forced out of the vise during cutting and create a hazardous condition.



■ Never touch the running saw blade. It is dangerous if your hands or clothing are caught by the running blade.



■ Never step or stand on the roller table. It is dangerous if your foot slips on the rollers and you fall.



■ Turn off the shot circuit breaker switch before servicing the machine. Then post a sign to inform people that the machine is under maintenance.

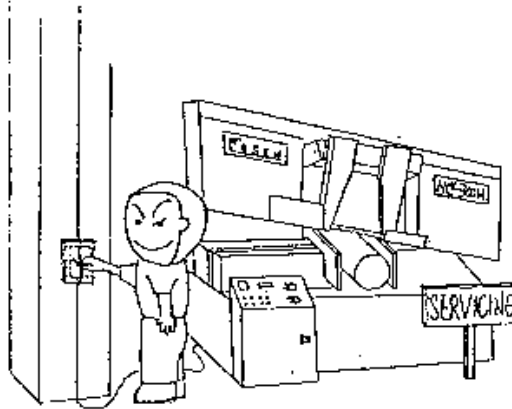


TABLE OF

Contents

Foreward



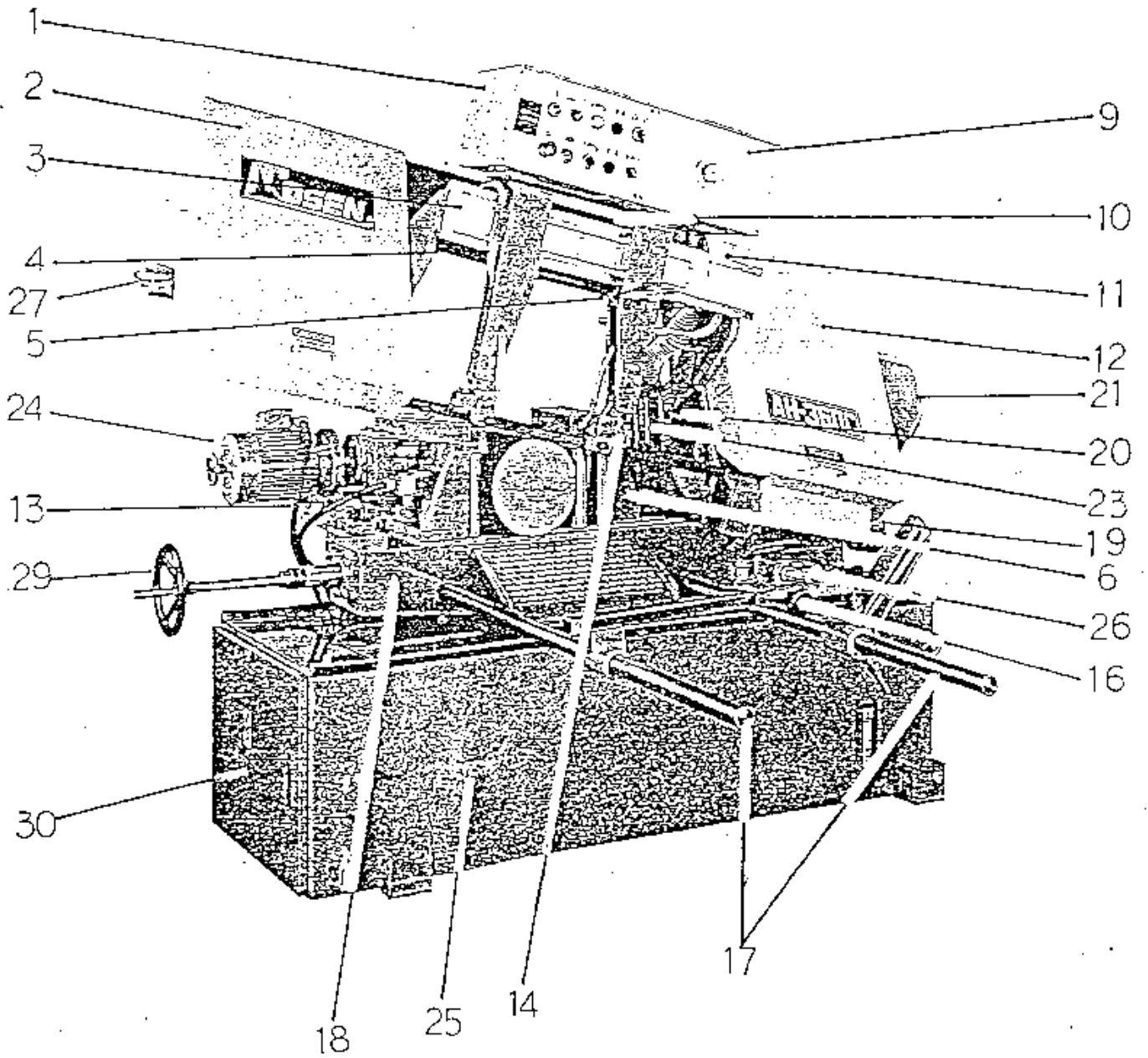
List of Illustrations

List of Tables



PAGE ↓

READ CAREFULLY BEFORE OPERATING MACHINE	1
ATTENTION	1
PLACEMENT	1
I. UNCRATING AND LUBRICATION	1~2
II. CONTROL PANEL	3~4
III. OPERATION FEATURES	5
1. MANUAL OPERATION	5~8
2. SEMI-AUTOMATIC OPERATION	9
3. AUTOMATIC CYCLE	9
IV. PARTIAL FEATURE	10~11
V. MAINTENANCE	12~14
SAWING PROBLEMS AND SOLUTIONS	15
PARTS LIST	16~54
ELECTRIC SYSTEM	55
HYDRAULIC SYSTEM	56



1. Control panel box
2. Idle wheel cover
3. Dovetail slide guide
4. Arm beside idle wheel
5. Arm fixing handle
6. Movable vise jaw
7. Blade guard
8. Pump cover
9. Control panel
10. Saw bow
11. Arm beside drive wheel
12. Drive wheel cover
13. Fixed vise jaw
14. Blade guide roller
15. Blade guard
16. Stopper
17. Depth bar (Length bar)
18. Bed
19. Cover for belt
20. Motor
21. Transmission
22. Saw bow bracket
23. Hydraulic cylinder
24. Feed Motor
25. Basement
26. Limit switch
27. Tension handle
28. Idle wheel tension adjustment slide
29. Vise hand wheel
30. Electric cabinet door

Specification of The Machine

MODEL		Automatic Band Saw Machine	
MAX. CAPACITY		●	360mm (14")
		■ (W×H)	310mm x 310mm (12" x 12")
		■ (W×H)	380mm x 310mm (15" x 12")
SAW BLADE	SPEED	60 Hz	27,40,54,68,80 m/min. 89,132,178,224,264 fpm
		50 Hz	23,34,45,57,67 m/min 75,112,148,187,220 fpm
	SIZE (W×L×T)	34mm x 4115mm 1.1mm	
MOTOR OUTPUT		HYDRAULIC	0.18kW (1/4 HP)
		SAW BLADE	3.75 kW (5 HP)
		COOLANT PUMP	0.1kW (1/8 HP)
		WISE ROLLER	0.2kW (1/4HP)
HYDRAULIC TANK		25L(6.2gal.)	
COOLANT		60 L (15 gal.)	
HEIGHT OF WORK BED		665 mm (26")	
NET WEIGHT		650 kgs (1430lbs)	
GROSS WEIGHT		800 kgs (1760 lbs)	
FLOOR SPACE (L×W×H)		2286×1194×1600 mm (90"×47"×63")	
SHIPPING SPACE (L×W×H)		2386x1300x1700mm (94" x 50.5" x67")	

IMPORTANT NOTICE

★ READ CAREFULLY BEFORE OPERATING MACHINE ★

- 1) For the material infeed roller conveyors must be used that have a minimum length of three quarters of the max. stock length.
- 2) Work stands should only be used for the additional support behind the main roller conveyor.
- 3) Roller conveyors should be equipped by vertical side rollers or support to avoid rolling-off of round material.
- 4) Manual stock infeed should always be carried out from the rear of the machine.

ATTENTION

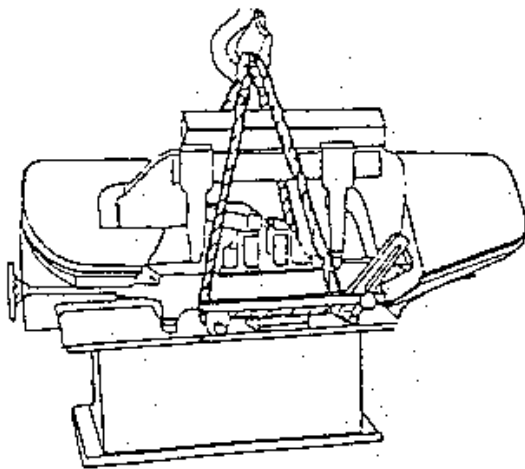
Keep hands clear of Cutting Area! Stop machine for positioning, measuring etc. of stock.

PLACEMENT

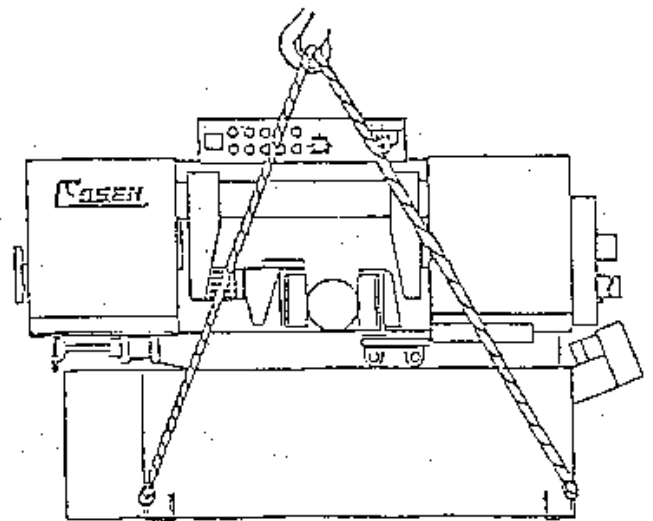
The foundation should be constructed of concrete and must be flat and level. Sufficient space should be provided around the machine to allow for the safe handling of materials, and maintenance operations. Should other machinery be causing vibration or dust near your machine, precautions must be taken to keep your machine absolutely free of such vibration and dust.

I. UNCRATING AND LUBRICATION

- a) After uncrating check thoroughly for transport damages. To place the saw in position, you proceed as shown on drawing, leave wooden support between vice clamps and saw head untied. Not until the saw does not need further transportation the supporting log and the retaining wire may be removed.



300



360

The machine bed must be levelled both in transverse and longitudinal direction and should be bolted rigidly to the level floor by anchor bolts or on shock absorption pads.

Clean saw from dust and anti-rust material. It might be necessary to soak rust protection material with crude oil or turpentine for easier removal.

b) Initial lubricant and oil check

1) Gear: Check on oil level.

2) Feeding gear: also check on oil level glass.

3) Hydraulic system : for the test run a minimum amount of oil has been filled into the hydraulic oil tank. According to enclosed lubricant chart fill the hydraulic tank to mid of oil level glass.

4) Oil quantities: Gear approx.

0.75L = 0.75US.qt = 1.3 British pints

Feeding Gear approx.

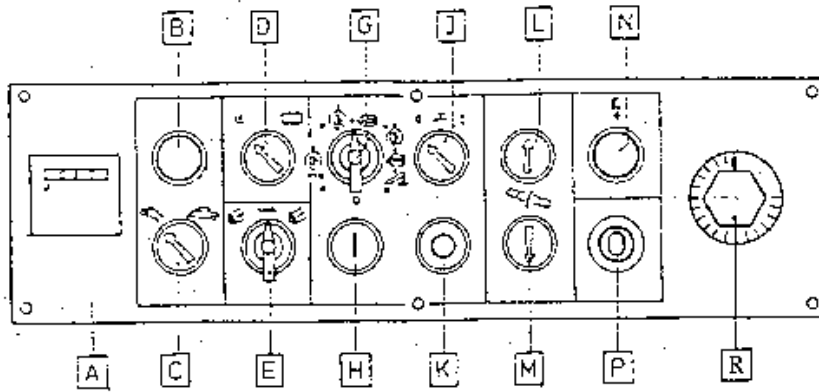
0.6 L = 0.6 US.qt = 1 British pints

Hydraulic Tank approx.


15 L = 4 US.qt = 3.3 British gal

Before putting the machine into operation, grease in conformity with lubricant chart (should the saw have been unused for a period of time, remove oil grease from bearings as otherwise the bearings might get seized).

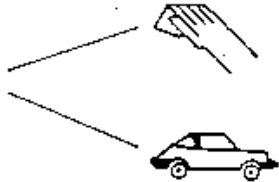
II. CONTROL PANEL



A : This counter is used to preset the number of cuts required on the automatic operation. When the counter reaches the preset number, The machine automatically stops.

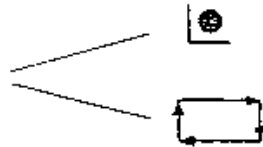
B : Pilot lamp : Illuminates only with selector switch **C** in  position.

C : Selector switch



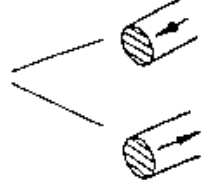
Manual
Automatic

D : Selector switch

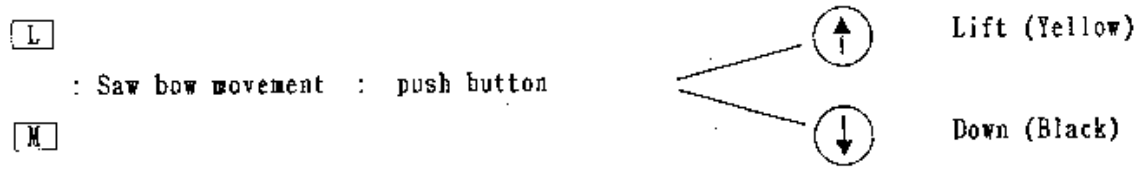
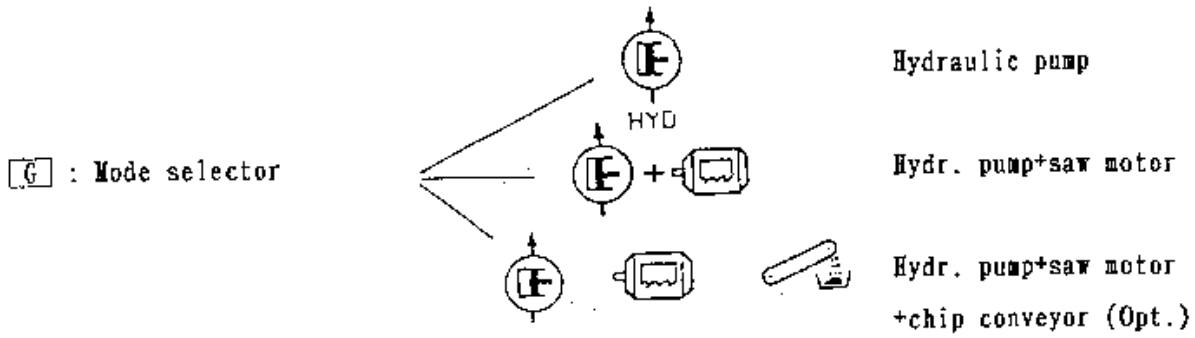


Band chang
Automatic cycle

E : Manual stock feed



Forward
Backward



- [N] : Pilot lamp : Illuminates only when main power on.
- [P] : Emergency stop (reset type)
- [R] : Feed valve


III. OPERATING FEATURES

The COSEN AH-300C / AH-360C offers an automatic cycle, controlled by hydraulic, electric and mechanic devices.

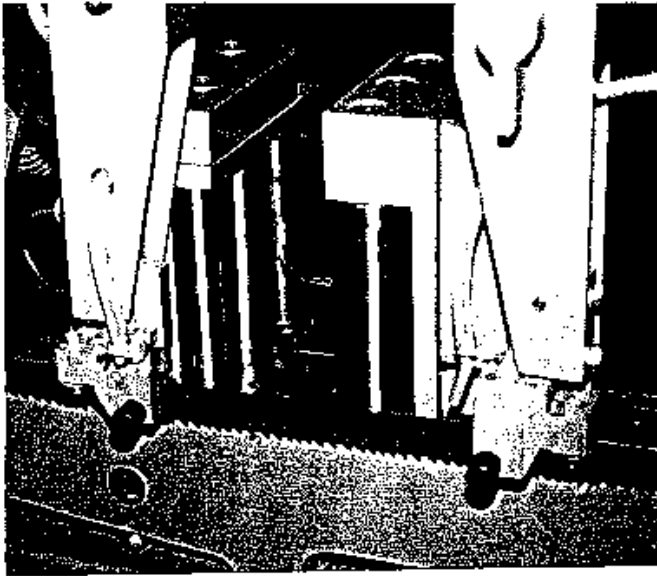
A sensitive hydraulic system controls the lifting and lowering of the saw bow and includes an automatic feed control valve. This unit is activated by the back of saw band itself and is designed to give max. performance and life to the saw band. Its operation is simple and effective. It helps to prevent over-loading of the saw teeth, eliminates clogging and ensures that each and every piece is cut accurately.

The push button control panel is mounted on the top of the saw and there is an extra control cabinet with the electrical controls mounted to a flap out door at the rear lower part of the machine. The AH-300C / AH-360C has each one motor for the saw drive, hydraulic pump and stock feeding.

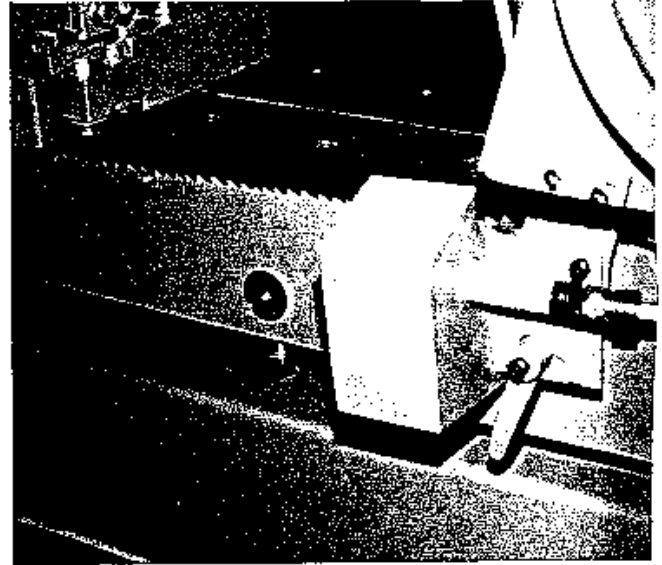
I. MANUAL OPERATION

- A. Select the saw blade best suited for the work-piece to be cut. The size and shape of the work-piece, and the type of material being cut should all be considered when selecting the saw blade to be used.
- B. Place the saw blade onto both the drive and driven wheels using the following procedures:
 - 1) Turn the circuit breaker ON.
 - 2) Depress the power ON button.
 - 3) Turn the auto-manual selector to "  ".
 - 4) Depress the raise button and raise the saw head until the right insert holder completely clears the front fixed vise.
 - 5) For safety, depress Emergency Stop "P".
 - 6) Open both the drive and driven wheel covers.

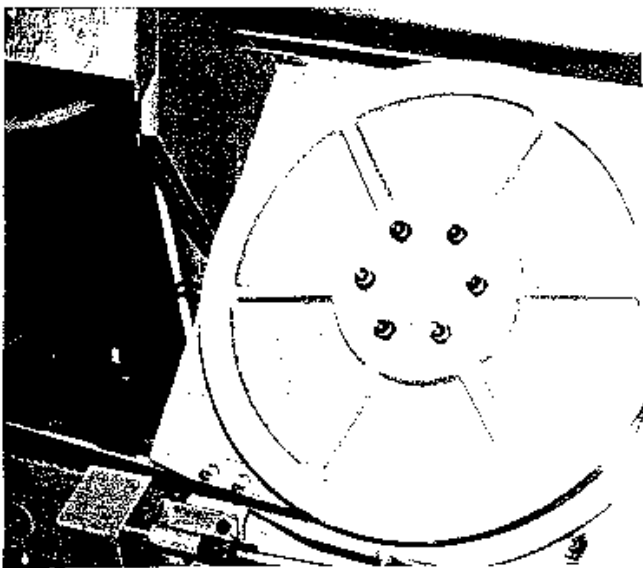
- 7) Loosen both the left and right insert knobs to open the inserts.(Pic.a)
- 8) Turn the tension handle counterclockwise to move the driven wheel toward the drivewheel.
- 9) Lower the wire brush case. (Pic.b)
- 10) Place the saw blade onto both the drive and driven wheels.(Pic.c)
- 11) Insert the saw blade into both the left and right inserts so that the back edge of the saw blade securely touches the back-up rollers of each insert.(Pic.d)



Pic.a



Pic.b



Pic.c



Pic.d

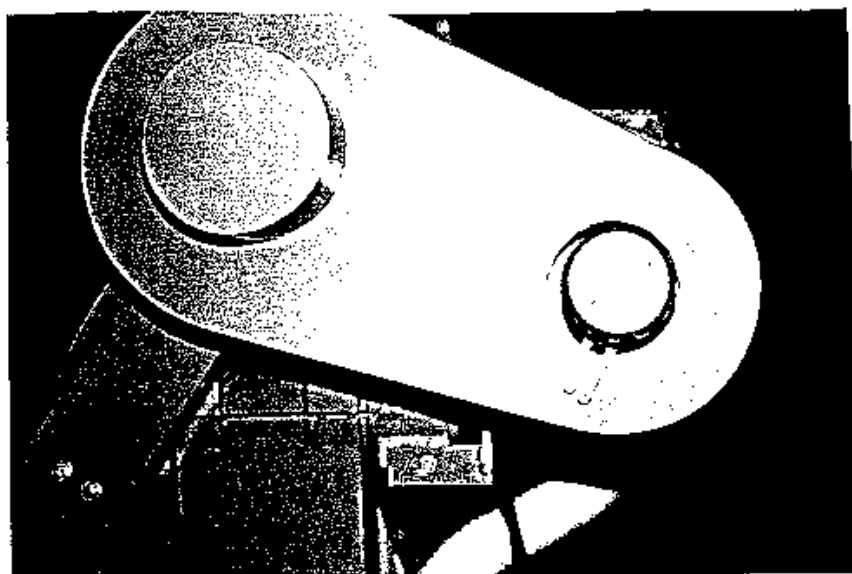
12) Properly position the saw blade on the drive wheel so that the back edge of the saw blade makes secure contact with the flange of the drive wheel. Then engage the blade holder with the blade to prevent its dislocation from the drive wheel.
NOTE: The blade holder will disengage as the saw blade begins rotating.

13) Ensure that the back edge of the saw blade makes contact with the flange of the driven wheel. Turn the tension handle clockwise so that sufficient tension is placed on the saw blade. Proper blade tension is obtained when the knurled collars are engaged.

CAUTION : Ensure that the back edges of the saw blade make contact with the flanges of the drive and driven wheels.

14) Turn the insert knobs clockwise to tighten the inserts.

- C. Close the covers of both the drive wheel and the driven wheel.
- D. Properly position the blade guide according to the diameter (or the width) of the workpiece using the following procedures :
- 1) Turn the left insert knob counterclockwise to loosen the left insert.
 - 2) Loosen the lock handle and manually move the blade guide. Align the indicator of the blade guide with the scale on the guide bar, in accordance with the size of the workpiece.
 - 3) After adjusting the position of the blade guide, tighten the lock handle to lock the blade guide securely.
- CAUTION: When tightening the lock handle, gently swing the lower end of the blade guide alternately to the left and right so that the dovetail is properly aligned.
- E. Adjust the saw blade speed.
- 1) Set the Feed Valve at zero.
 - 2) Set Selector "D" to "Band Change" position.
 - 3) Open Emergency Stop "P".
 - 4) Depress the blade drive button to start the saw blade as the blade begins to rotate the rear vise will automatically move to the backward limit position and clamp the workpiece at that position.
 - 5) Turn the variable speed handwheel to adjust the speed of the saw blade. It is necessary to properly adjust the saw blade speed depending upon the material and shape of the workpiece to be cut. (Pic.e)
- F. Depress the blade drive button. When the blade drive button is depressed, the saw blade motor operates and the saw head also begins to descend for actual cutting. Adjust the cutting fluid flow with the control levers according to the workpiece to be cut.



Pic.e

2. SEMI-AUTOMATIC OPERATION

It might be necessary to use the machine for single cuts without automatic feeding. Selector switch "C" must be set to "Manual" position, the stock either be fed against stop with manual stock feed selector "E" or adjusted to length by manually rotate the handwheel mounted coaxial with the feed motor.

The semi-automatic cycle only assures lifting of saw bow after each cut, down feed of saw bow must be activated by manually depress the push button "M". The saw bow down feed rate is controlled by the feed valve. If one prefer to keep saw bow at lifting position, turn feed valve to "0" setting before lifting saw bow, then depress push button "M" after saw bow has reached the upper limit switch.

Note: Always depress push button "M" to release the lifting pressure in the hydraulic system after saw bow has reached the upper limit switch. When using select or switch "E" to feed the stock, be sure that the saw bow had touched the upper limit switch or the selector switch will not function when turn to "Forward" direction.

3. AUTOMATIC CYCLE

The automatic cycle is recommended starting with four or five equal cuts.

Set switch "C" to "Auto", select or switch "D" to automatic cycle. The end limit switch on the stop bar triggers the down movement of the saw bow. After the cut has been completed, the lower end limit switch will start the lifting of the saw bow, having reached the upper position the upper end limit switch will start the feeding of the stock against the switch of the material stop. At the moment the stock touches against the stock feed end limit switch, the feeding motion will be stopped and the down movement of the saw bow begins. This cycle will be repeated after each cut.

During automatic operation the lamp "B" will indicate that the machine works with automatic cycle.

Proper feed rate of saw bow must be selected from the Feed Valve before operation.

IV. PARTIAL FEATURE

1. Material stop and stock clamping device

- a. Material stop loosen setscrews (located on the bottom of the bed) of the two stop bars, pull out bars until they are flush with the rear machine bed, fasten setscrews, and put stock between roller vice.
- b. Clamping device (roller vice) : tension with hand wheel until the space between the cup springs is reduced by one half approximately, however, the stock diameter also influences the amount of tensioning. This is a matter of experience.
- c. Set selector switch "C" to "Manual".

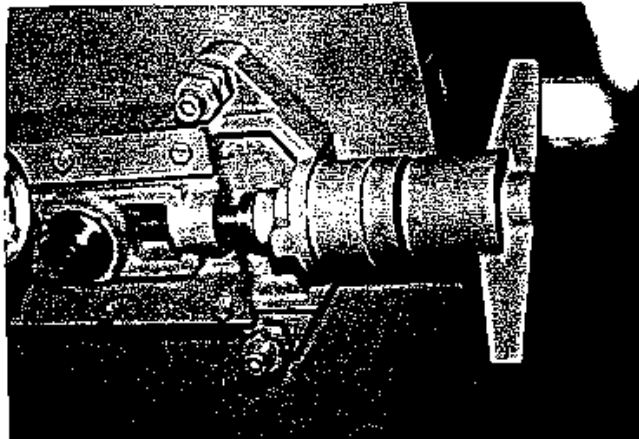
With selector switch "E", jog stock to cut-off length required.



- d. Now push end limit switch onto the material, the pin of the end limit switch mechanism should touch the material at its upper upmost right hand side to ensure that the sawn off piece can fall down freely. Also be sure that all clamping wheels and levers of the stop mechanism are clamped tightly.
- e. The guide arms or guides must never touch the stock but should be set as close as possible to the stock to be sawn. Be sure that the guide arms are clamped tightly to the dovetailed guide rail with the help of the clamping grip.
- f. The upper end limit switch can be adjusted in accordance of stock's height. The adjustment of this switch should guarantee that the up-movement of the saw bow is stopped just above the material.

2. Blade tension device

This device provides for proper blade tension. To provide the saw blade with tension, turn the tension handle clockwise until the knurled collars are engaged. (Pic. f)



Pic. f

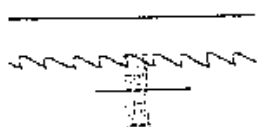
3. Blade drive unit

This unit is designed so that the speed of the saw blade can be varied in five steps of 27, 40, 54, 68 and 80 m/min. (88, 131, 177, 223 and 262 ft/min.) To change the position of the V-belt, open the pulley cover and move the lock lever to the right. After changing the V-belt position, securely lock the motor base by moving the lock lever to the left. Or you can use infinitely variable speed device, speed from 20 to 80 m/min. Refer to page 8 operation.

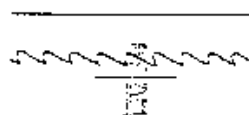
4. Wheel cleaning brush

Adjust the position of the wire brush using the following procedures:

- a) Loosen the lock lever for the wire brush case.
- b) Manually move the wire brush case so that the wire brush makes proper contact with the saw blade.



[PROPER]



[IMPROPER]

- c) Tighten the lock lever.

V. MAINTENANCE

Daily :

- A) Remove chips from upper blade guard and between feeding roller. Clean movable parts of end limit switch and the space around the saw wheels.
- B) Check the hydraulic oil level, adding oil as necessary.

Weekly :

- A) Saw guide rollers, saw guide inserts and wheel brush must be checked.
 - 1. Guide rollers :
Clean with a brush, defective guide rollers must be replaced immediately, also replace worn out trust rollers. Adjust Feed valve to position "0" , then check easy up and down movement of bolt. For lubrication of this bolt use oil, do not take grease which may harden and create multifunction of this bolt.
 - 2. Guide inserts :
The carbide face of the inserts should always be in good order, it might be necessary to regrind the guide inserts or to replace them from time to time.
 - 3. Blade cleaning brush :
If set too close to the saw band, the brush will wear quickly. However be sure that the brush cleans the saw teeth thoroughly. Worn out brushes must be replaced immediately.
- B) Check amount of coolant liquid as there is a constant loss of coolant during productive cutting (protection sheets above coolant tank can be removed). For refilling be sure to mix coolant conforming to recommendation of the coolant supplier, do not fill in pure water only.

Monthly :

- A) Clean coolant tank, check and clean coolant suction filter.
- B) Clean insides of pulleys, check V-belt.
- C) On the feeding device check chain for correct tension. Take off cover unscrew the setscrew located on the front of the vice housing, then adjust the eccentric bolt with a pin for proper tensioning of the chain.
- D) Clean feeding rollers with crude oil.
- E) Clean the rims of the saw wheels carrying the saw band.

Miscellaneous




- A) Electrical system of the machine needs no maintenance.
- B) Should the machine be operated out of doors or in rooms without heating, do not forget to add an antifreezing solution to the coolant in winter and according to the instruction of the coolant supplier.

Rule of the Thumb:




- The thinner the stock, the finer the saw pitch
- The thicker the stock, the coarser the saw pitch
- The more difficult the stock, the finer the saw pitch
- The softer the material, the coarser the saw pitch

At least three teeth always must be in contact with the material being cut.




Solid stock:

up to 25 mm	-	1"	8-10 TPI			
25-100 mm	-	1"-4"	6- 8 TPI			
100-250 mm	-	4-10"	3- 4 TPI			

Structurals:

up to 10 mm	-	3/8"	10- 8 TPI			
10-20 mm	-	3/8-3/4"	8-10 TPI			
above 20 mm	-	3/4"	6- 8 TPI			

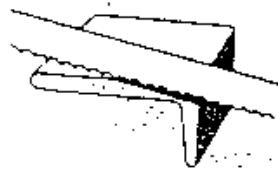
Solid:

up to 20 mm	-	3/4"	8-10 TPI			
20-80 mm	-	3/4-3.1/4"	2- 8 TPI			
above 80 mm	-	3.1/4"	4- 6 TPI			

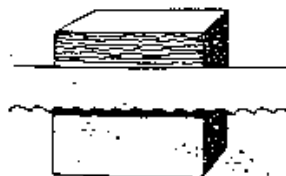
(per unit)

Sawing Practices:

Correct



Several teeth contact work



Coarse teeth clear chips freely



Three or more teeth on cutting wall

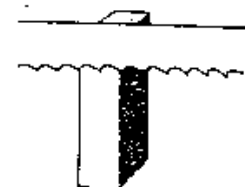
Incorrect



Teeth strike sharp edge



Teeth too fine for large solids



Coarse teeth rip on thin wall

Tooth Forms:



Standard (precision)



Skip-a-tooth



CLAW-tooth

Standard:

This tooth design is most often used for general metal cutting, available with a saw pitch of 4-22 TPI, for cutting of solid stock and structurals, cutting of steel, cast iron, hard non-ferrous metals – smooth surface finish.

Skip tooth:

Designed for cutting soft sticky materials that have a tendency to clog. The teeth are spaced further apart and the gullet is deeper to give large chip-clearance. Suitable for sawing larger stock diameter – good surface finish.

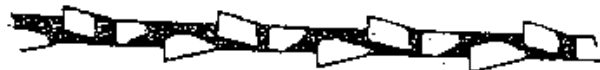
Claw tooth:

For cutting of larger stock of ferrous and non-ferrous metals, for faster cutting – coarse surface finish.

Saw set:

Standard (Raker):

for general purpose metal cutting applications



Wave set:

recommended for cutting light sections in metals such as sheet, tubing and smaller solids, generally used on fine pitch blades.



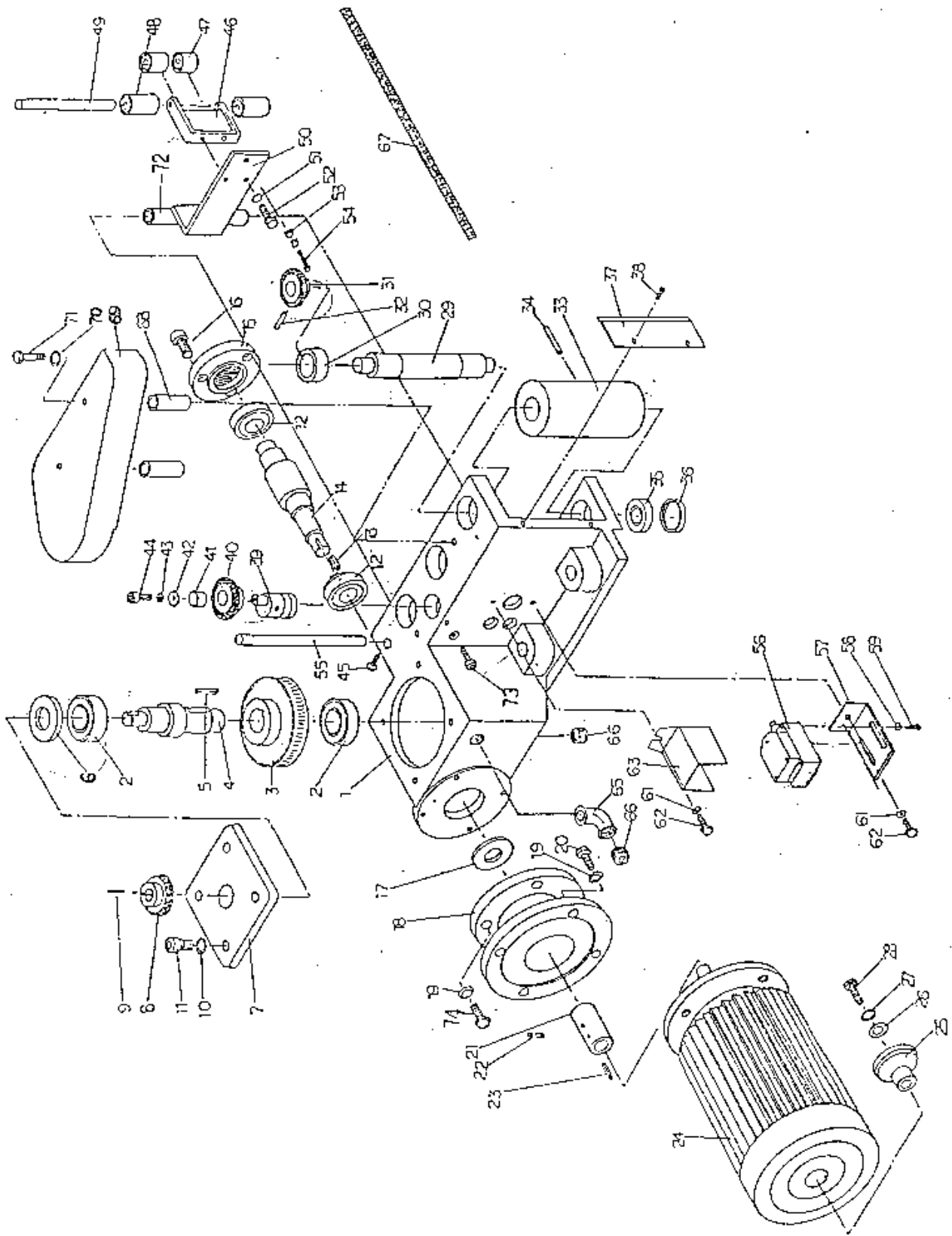
Alternative set:

the teeth are set alternatively right and left, this type of set is generally used to give faster cutting of soft steels, aluminium, etc.



SAWING PROBLEMS AND SOLUTIONS

—Vibration during cutting —Failure to cut —Short life of saw blade —Curved cutting —Broken blade						
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Use of blade with incorrect pitch	Use blade with correct pitch suited to workpiece width
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Failure to break-in saw blade	Perform break-in operation
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>			Excessive saw blade speed	Reduce speed
			<input type="checkbox"/>	<input type="checkbox"/>	Insufficient saw blade speed	Increase speed
<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Excessive saw head descending speed	Reduce speed
<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>		Insufficient saw head descending speed	Increase speed
		<input type="checkbox"/>	<input type="checkbox"/>		Insufficient saw blade tension	Increase tension
<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Wire brush improperly positioned	Relocate
<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>		Blade improperly clamped by insert	Check and correct
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Improperly clamped workpiece	Check and correct
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Excessively hard material surface	Soften material surface
		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Excessive cutting rate	Reduce cutting rate
	<input type="checkbox"/>	<input type="checkbox"/>			Non-annealed workpiece	Reduce with suitable workpiece
<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Insufficient or lean cutting fluid	Add fluid or replace
<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Vibration near machine	Relocate machine
		<input type="checkbox"/>	<input type="checkbox"/>		Non-water soluble cutting fluid used	Replace
<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>		Air in cylinder	Bleed air
<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>	Broken back-up roller	Replace
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Use of non-specified saw blade	Replace
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Fluctuation of line voltage	Stabilize
<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>		Adjustable blade guide too far from workpiece	Bring blade guide close to workpiece
<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Loose blade guide	Tighten
		<input type="checkbox"/>		<input type="checkbox"/>	Blue or purple saw chips	Reduce cutting rate
<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>	Accumulation of chips at inserts	Clean
	<input type="checkbox"/>				Reverse positioning of blade on machine	Reinstall
<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>		Workpieces not bundled properly	Re-bundle
<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>	Back edge of blade touching wheel flange	Adjust wheel to obtain clearance
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>			Workpiece of insufficient diameter	Use other machine, suited for diameter of workpiece
	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Saw blade teeth worn	Replace



1. ROLLER FEED VICE

CHART 1 ROLLER FEED VISE

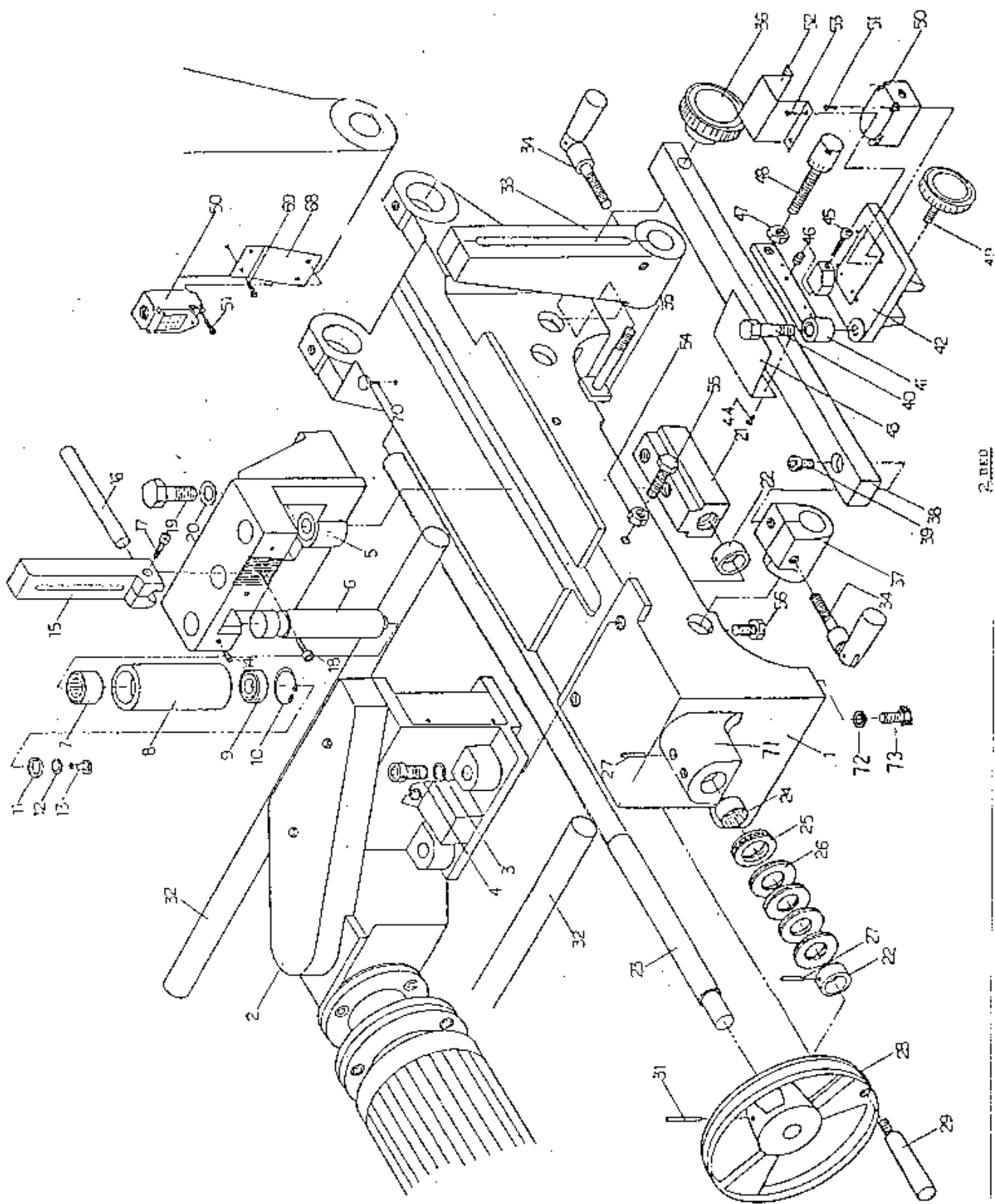
NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	Q'TY
1-1	AHR-1014	feed roller housing	固定虎鉗		1
1-2	PP-14130	bearing	軸承	6205	2
1-3	ACA-1037	worm gear	蝸輪		1
1-4	ACA-1041	worm gear shaft	蝸輪軸		1
1-5		key	方鍵	7*7*15L	1
1-6	PP-51030	oil seal	油封	25*40*8	1
1-7	ACA-1038	gear box cover	蝸輪蓋		1
1-8	ACA-1030	sprocket	主動鏈輪		1
1-9		key	方鍵	6*6*15L	1
1-10		lock washer	彈簧華司	M8	4
1-11		screw	外六角螺絲	M8*20L	4
1-12	PP-14610	bearing	軸承	4T-30204	2
1-13		key	方鍵	5*5*15L	1
1-14	ACA-1039	worm	蝸桿		1
1-15	ACA-1040	end cover	蝸桿蓋		1
1-16		screw	內六角螺絲	M10*15L	3
1-17	PP-51010	oil seal	油封	20*47*8	1
1-18	ACA-1033	adapter	連接凸緣		1
1-19		lock washer	彈簧華司	M10	8
1-20		screw	內六角螺絲	M10*20L	4
1-21	ACA-1034	coupling	接軸套		1
1-22		set screw	止付螺絲	M5*5L	1
1-23		key	方鍵	5*5*15L	1
1-24	PP-31351	motor	馬達	1/2HP,6P	1
1-25	ACA-1035	handwheel	微調手輪		1
1-26	ACA-1036	bushing	微調手輪軸套		1
1-27		lock washer	彈簧華司	M8	1
1-28		screw	內六角螺絲	M8*30L	1
1-29	AHR-1027	roller shaft	固定虎鉗滾輪軸		1
1-30	PP-14070	bearing	軸承	HK-2820	3
1-31	ACA-1031	sprocket	從動鏈輪		3
1-32		pin	斜度銷	φ 2*25L	3
1-33	AHR-1026	roller ,drive	固定虎鉗滾輪		3
1-34		pin	彈簧銷	φ 6*60L	3
1-35	PP-14251	bearing	軸承	6003ZZ	3
1-36	ACA-1027	washer	固定虎鉗墊圈		3
1-37	AHR-1036	chip wiper	滾輪側蓋		1
1-38		screw	平頭十字螺絲	M5*10L	2
1-39	ACA-1026	adjusting cam shaft	鏈輪調整桿		1
1-40	ACA-1032	sprocket	調整手輪		1
1-41	PP-14020	bearing	軸承	HK-1210	1
1-42		washer	平面華司	1/4"	1
1-43		lock washer	彈簧華司	1/4"	1
1-44		screw	外六角螺絲	1/4*3/4"	1
1-45		screw	外六角螺絲	M8*16L	2
1-46	AHR-1009	bracket	送料開關U型架		1

AH-360C

CHART 1 ROLLER FEED VICE

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
1-47	ACA-1022	roller (a)	長滾輪		3
1-48	AHR1011	roller (b)	送料開關長滾輪		1
1-49	AHR-1012	shaft	U型架活動軸		1
1-50	ACA-1019	rock arm	送料開關固定板		1
1-51		lock washer	彈簧華司	M6	2
1-52		screw	內六角螺絲	M6*15L	2
1-53		nut	螺母	M6	2
1-54		screw	外六角螺絲	M6*20L	1
1-55	AHR-1024	pivot	送料開關軸		1
1-56	PP-90010	limit switch	極限開關	TZ-5101	1
1-57	ACA-1024	bracket	送料電器座板		1
1-58		lock washer	平面華司	M6	2
1-59		screw	內六角螺絲	M6*10L	2
1-60					
1-61		lock washer	彈簧華司	M6	2
1-62		screw	內六角螺絲	M6*10L	2
1-63	ACA-1025	limit switch guard	送料電器遮板		1
1-64					
1-65		elbow joint	內外牙彎頭	1/2*1/2"	1
1-66		cap	塞頭	PT 1/2	2
1-67	PP-19010	chain	鏈條	RS 40*2.5R	1
1-68	ACA-1029	spacer	護蓋墊圈		2
1-69	ACA-1028	chain guard	鏈輪護蓋		1
1-70		lock washer	鎖緊華司	M8	2
1-71		screw	外六角螺絲	M8*55L	2
1-72	AHR-1013-1	bushing	送料開關軸套		1
1-73		screw	內六角螺絲	M8*20L	1
1-74		screw	外六角螺絲	3/8*3/4"	4
1-75					
1-76					
1-77					
1-78					
1-79					
1-80					
1-81					
1-82					
1-83					
1-84					
1-85					
1-86					
1-87					
1-88					
1-89					
1-90					
1-91					
1-92					

AH-360C



2 BED

CHART 2 BED

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
2-1	AHR-1004	bed	床面		1
2-2	AHR-00010	rooler feed vise	固定虎鉗組		1
2-3		lock washer	彈簧華司	M16	2
2-4		bolt	內六角螺絲	M16*50L	2
2-5	AHR-1006	movable vise casting	活動虎鉗本體		1
2-6	AHR-1008	shaft	活動虎鉗滾輪軸		3
2-7	PP-14090	needle bearing	軸承	HK-3520	3
2-8	AHR-1007	roller	活動虎鉗滾輪		3
2-9	PP-14252	bearing	軸承	6004ZZ	3
2-10		retainer	扣環	R42	3
2-11		washer	平面華司	M6	3
2-12		lock washer	彈簧華司	M6	3
2-13		screw	丸頭螺絲	M6*16L	3
2-14		set screw	止付螺絲	M8*20L	3
2-15	ACB-1015M	nesting fixture	材料下壓固定塊		1
2-16	ACA-1046A,B	pressing bar	長短材料下壓桿		1
2-17		screw	內六角螺絲	M8*35L	1
2-18		screw	內六角螺絲	M8*40L	1
2-19		bolt	外六角螺絲	M16/55L	2
2-20		lock washer	彈簧華司	M16	2
2-21	AHR-1015-1	lead screw nut	虎鉗滑塊		1
2-22	AHR-1025	collar	導螺桿固定圈		2
2-23	ACB-1016	vise lead screw	導螺桿		1
2-24	PP-13140	needle bearing	乾式軸承	2520	2
2-25	PP-14410	thrust bearing	軸承	AS/MPP 2542	1
2-26	ACA-1049	disk spring	碟形彈簧	DIA -25	8
2-27		spring pin	彈簧銷	φ 6*35L	2
2-28	PP-52031	handwheel	手輪	8"	1
2-29	PP-52030	handle	手輪柄		1
2-30					
2-31		set screw	內六角螺絲	M8*12L	1
2-32	AHR-3001	depth bar (length bar)	定寸桿		2
2-33	AHR-3003A	adapter ,right	大調整座		1
2-34	ACA-1059A	fastening bolt	調整座固定螺絲		2
2-35	ACA-1058	stud	調整手輪桿		1
2-36	PP-52050	knob	調整手輪		1
2-37	AHR-3002	adapter left	小調整座		1
2-38	AHR-3004	cross slide	定寸開關座滑板		1
2-39		screw	內六角螺絲	M12*25L	1
2-40	ACA-1067M	pivot bolt	開關板軸		1
2-41	ACA-1062M	rocker	定寸開關擋板		1
2-42	ACA-1060M	carriage	定寸開關滑板		1
2-43	ACA-1065	cover	定寸開關護蓋		1
2-44		screw	丸頭螺絲	M5*12L	2
2-45		screw	內六角螺絲	M10*45L	1
2-46	ACA-1063	spring	定寸擋板彈簧		1

AH-360C

CHART 2 BED

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
2-47		nut	螺帽		1
2-48	ACA-1061M	micro-adjust bolt	定寸調整桿		1
2-49	PP-53040	fastening bolt	鎖緊螺絲		1
2-50	PP-90010	limit switch	限動開關	WLD-TZ-5101	2
2-51		screw	丸頭螺絲	M5*30L	6
2-52	ACA-1066	cover	定寸開關遮蓋		1
2-53		screw	丸頭螺絲	M5*12L	4
2-54		nut	螺帽	M12	4
2-55		screw	外六角螺絲	M12*30L	2
2-56		bolt	外六角螺絲	M12*20L	3
2-57					
2-58					
2-59					
2-60					
2-61					
2-62					
2-63					
2-64					
2-65					
2-66					
2-67					
2-68	AHR-2051	bracket	下降控制器座板		1
2-69		screw	內六角螺絲	1/4-20UNC*3/8	2
2-70	SJY-1144	screw	擋板螺絲		1
2-71	AHR-1044	vise lead screw seat	導螺桿座	5/8*1 1/2"	1
2-72		spring washer	彈簧華司	3/8*2"	4
2-73		screw	外六角螺絲		4
2-74					
2-75					
2-76					
2-77					
2-78					
2-79					
2-80					
2-81					
2-82					
2-83					
2-84					
2-85					
2-86					
2-87					
2-88					
2-89					
2-90					
2-91					
2-92					

AH-360C

CHART 3

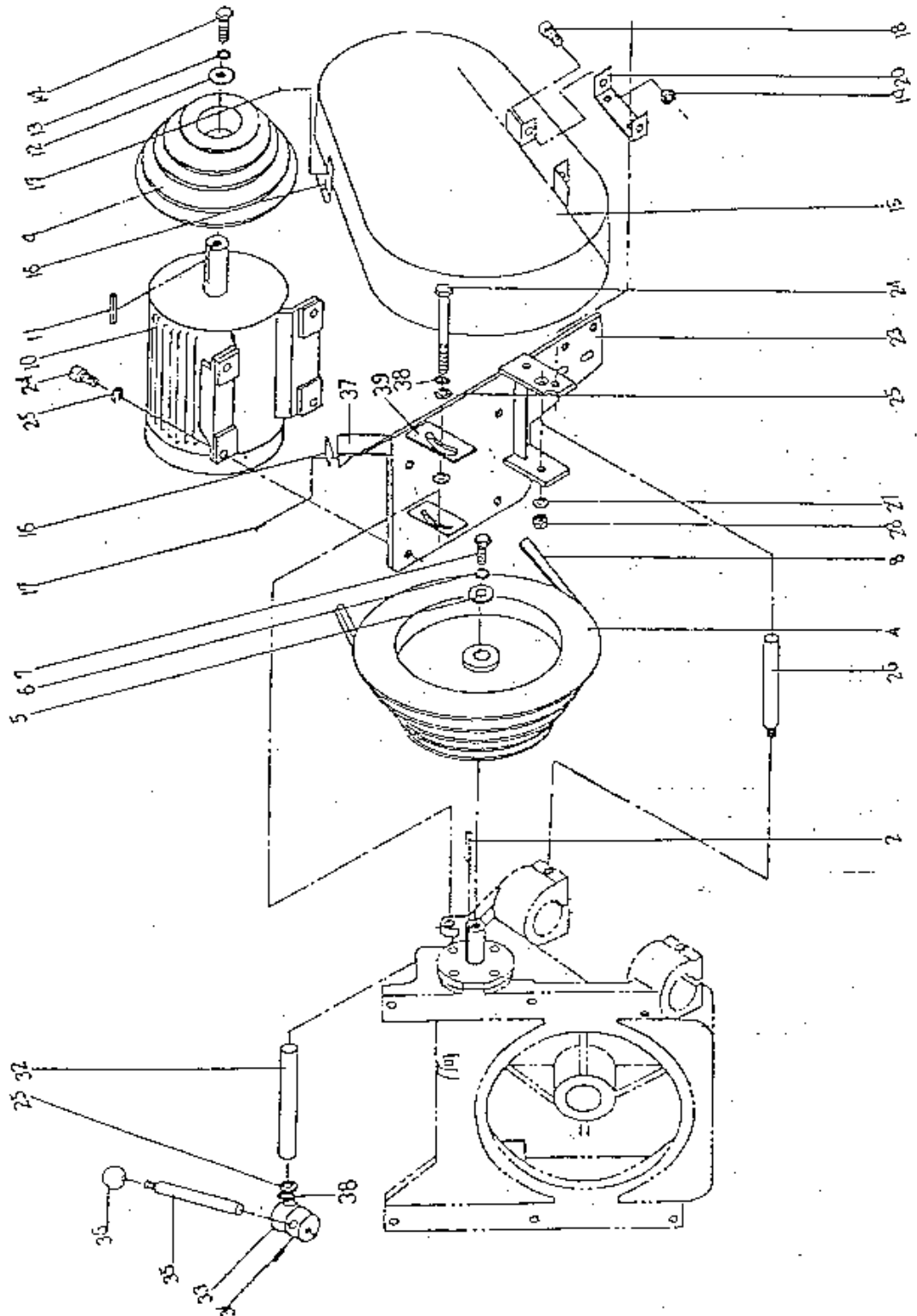


CHART 3 DRIVE WHEEL

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	Q'TY
3-1					
3-2		key	方鍵	7*7*50L	1
3-3					
3-4	AHR-2021	reducer pulley	減速機普利		
3-5	AHA-0525	washer	墊圈		
3-6		spring washer	彈簧華司	M10	1
3-7		screw	內六角螺絲	M10*50L	1
3-8	PP-56288	belt	皮帶	B49	1
3-9	AHR-2022	motor pulley	馬達普利		1
3-10	PP-31081	motor	馬達	SHP	1
3-11		key	方鍵	7*8*30L	1
3-12	AHA-0525	washer	墊圈		1
3-13		spring washer	彈簧華司	M10	1
3-14		screw	內六角螺絲	M10*25L	1
3-15	AHR-2023,A	pulley cover	普利護蓋		1
3-16	PP-52090	lock plate	蓋扣		1
3-17		screw	平面十字螺絲	M5*16L	4
3-18		screw	內六角螺絲	M5*12L	2
3-19		nut	螺帽	M5	2
3-20	AHR-2025	bracket	護蓋耳		1
3-21					
3-22					
3-23	AHR-2027	motor base plate	馬達底板		1
3-24		bolt	外六角螺絲	M10*30L	5
3-25		spring washer	彈簧華司	M10	6
3-26	AHA-0515	bar	馬達活動軸		1
3-27		spring washer	彈簧華司	M12	1
3-28		nut	螺帽	M12	1
3-29					
3-30					
3-31					
3-32	AHA-0526	shaft	馬達定位軸		1
3-33	AHA-0543	fixed nut	固定螺母		1
3-34					
3-35	AHA-0544	handle	馬達定位把手		1
3-36	PP-52040	ball	塑膠球	3/8"	1
3-37	AHC-0511	bracket	普利護蓋耳		1
3-38		washer	平面華司	M10	2
3-39	AHA-0510B	bracket	馬達底板耳		2
3-40					
3-41					
3-42					
3-43					
3-44					
3-45					
3-46					

AH-360C

CHART 4

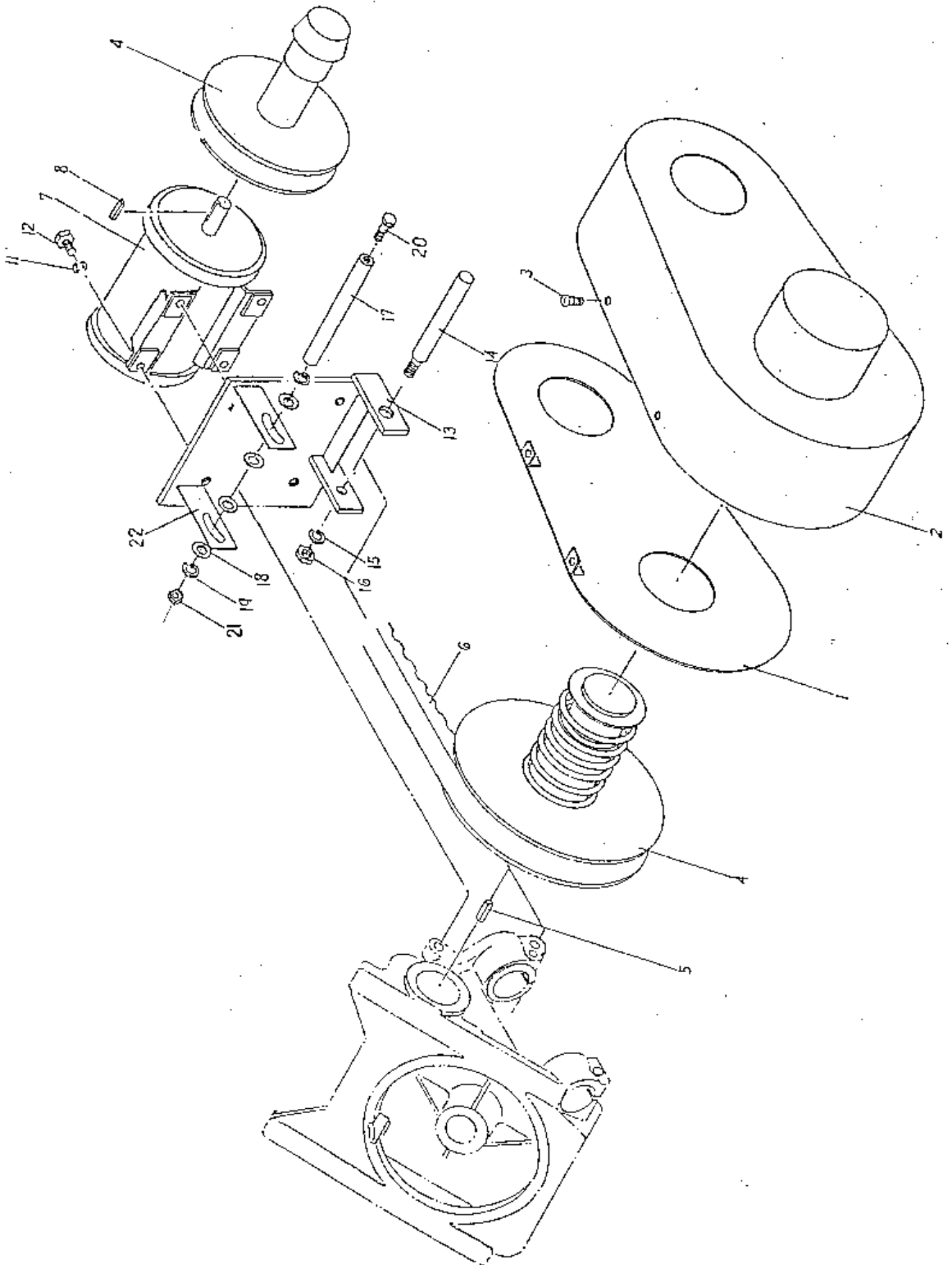


CHART 4 DRIVE MOTOR

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	Q'TY
4-1	AHA-0540B	rear cover	普利護蓋板(二)		1
4-2	AHA-0541B	pulley cover	普利護蓋		1
4-3		screw	丸頭螺絲	M6*10L	4
4-4	PP-16229C	idle pulley	無段變速器		1
4-5		key	方鍵	7*7*50L	1
4-6	PP-56028	belt	皮帶	1922V-386	1
4-7		motor	馬達	5HP	1
4-8		key	方鍵	7*8*50L	1
4-9					
4-10					
4-11		spring washer	彈簧華司	M10	4
4-12		bolt	外六角螺絲	M10*25L	4
4-13	AHR-2027	motor base plate	馬達底板		1
4-14	AHA-0515	hinge shaft	馬達活動軸		1
4-15		spring washer	彈簧華司	M12	1
4-16		nut	螺帽	M12	1
4-17	AHA-0526	set pipe	馬達定位軸		1
4-18		washer	平面華司	M10	2
4-19		spring washer	彈簧華司	M10	2
4-20		bolt	外六角螺絲	M10*30L	1
4-21		nut	螺母	M10	1
4-22	AHA-0510B	bracket	馬達底板耳		2
4-23					
4-24					
4-25					
4-26					
4-27					
4-28					
4-29					
4-30					
4-31					
4-32					
4-33					
4-34					
4-35					
4-36					
4-37					
4-38					
4-39					
4-40					
4-41					
4-42					
4-43					
4-44					
4-45					
4-46					

AH-360C

CHART 5

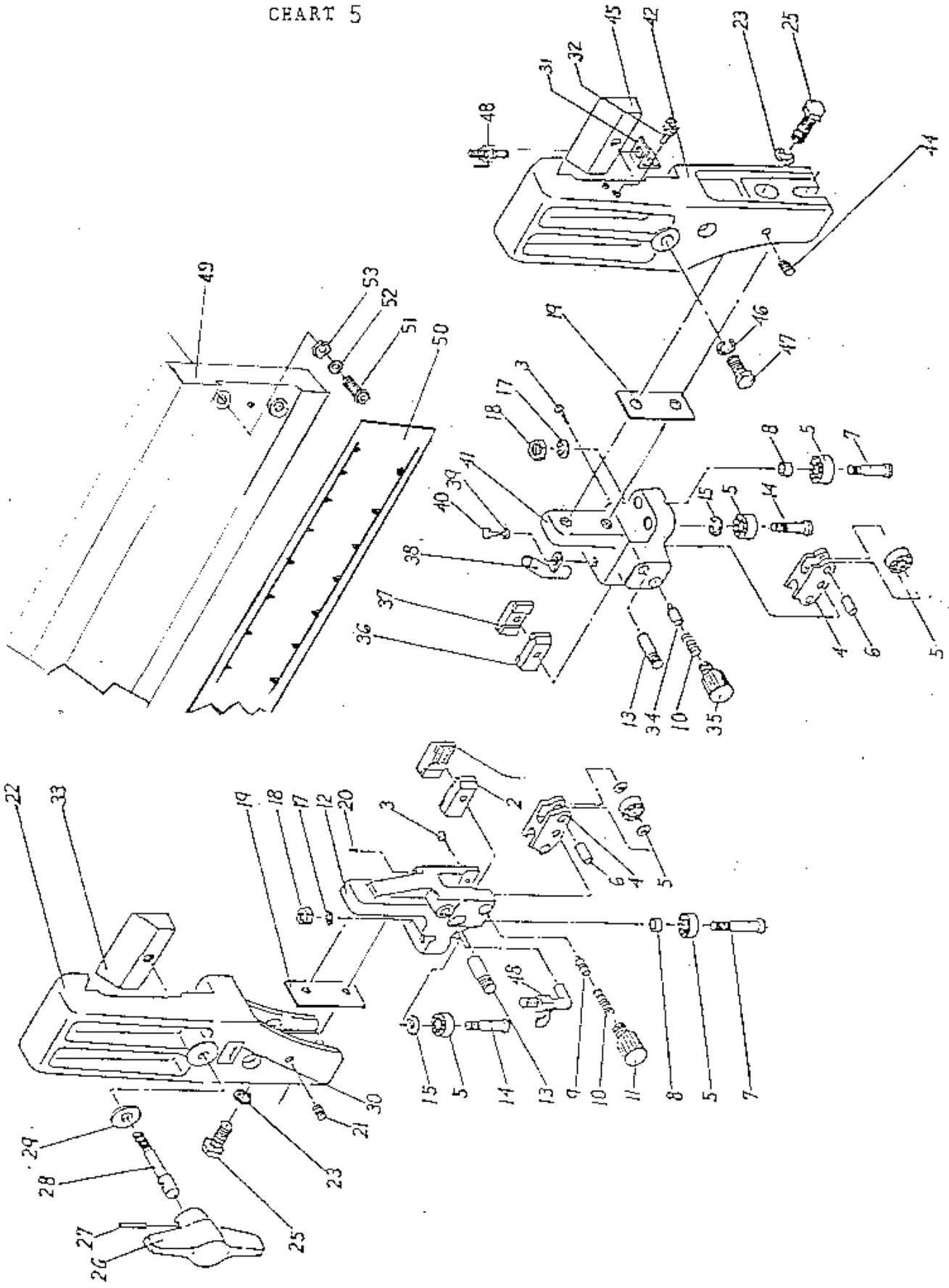


CHART 5 GUIDE BRACKET ASSEMBLY

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
5-1	AHA-0701B	left fixed insert	左固定錫鋼片		1
5-2	AHA-0702B	left movable insert	左活動錫鋼片		1
5-3		socket hd.bolt	內六角螺絲	M6*20L	2
5-4	AHA-0704	bearing holder	下壓軸承座		2
5-5	PP-14270	radial ball bearing	軸承	6200VV	8
5-6	AHA-0706B	straight pin	下壓軸承銷		4
5-7	AHA-0707B	roller pin (rear)	後導輪軸		2
5-8	AHA-0708B	collar	導輪墊圈		2
5-9	AHA-0709	left fitting	左簧塞		1
5-10	AHA-0710	spring	錫鋼片彈簧		2
5-11	AHA-0711	left insert knob	左調整螺絲		1
5-12	AHA-0712B	left insert holder	左導輪座		1
5-13	AHA-0713-1	straight pin	軸承座固定軸		2
5-14	AHA-0707C	roller pin (front)	前導輪軸		2
5-15		snap ring	平面華司	M10	2
5-16					
5-17		spring washer	彈簧華司	M10	4
5-18		nut	螺帽	M10	4
5-19	AHA-0719	plain washer	導輪座墊片		2
5-20		screw	止付螺絲	M6*6L	1
5-21		screw	止付螺絲	M10*16L	4
5-22	AHR-2005	left guide bracket	左鋸臂		1
5-23		spring washer	彈簧華司	M12	4
5-24					
5-25		bolt	外六角螺絲	M12*40L	4
5-26	AHA-0726	handle	鋸臂把手		1
5-27		spring pin	彈簧銷	φ5*32L	1
5-28	AHA-0728	lock bolt	鋸臂固定栓		1
5-29		washer	彈簧華司	M12	1
5-30	PP-61005	caution mark	鋸片方向牌		2
5-31	MJA-2041	coolant valve bracket	水龍頭座板		1
5-32		screw	內六角螺絲	M5*10L	2
5-33	AHA-0737	slide tip	鋸臂固定塊		1
5-34	AHA-0741	right fitting	右簧塞		1
5-35	AHA-0742	right insert knob	右調整螺絲		1
5-36	AHA-0743B	right movable insert	右活動錫鋼片		1
5-37	AHA-0744B	right fixed insert	右固定錫鋼片		1
5-38	AHA-0745	coolant nozzle	冷卻水噴嘴		1
5-39		spring washer	彈簧華司	M5	1
5-40		bolt	內六角螺絲	M5*10L	1
5-41	AHA-0748B	right insert holder	右導輪座		1
5-42	AHR-2006	right guide bracket	右鋸臂		1
5-43					
5-44		set screw	止付螺絲	M10*16L	4
5-45	AHA-0737	slide tip	鋸臂固定塊		1
5-46		spring washer	彈簧華司	M12	1

AH-360C

CHART 5 GUIDE BRACKET ASSEMBLY

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
5-47		bolt	外六角螺絲	M12*75L	1
5-48	PP-43132	coolant valve	開關閥	1/8"	2
5-49	AHR-2002	guide bar	鋸臂滑板		1
5-50	AHR-2030	name plate	鋸臂滑板銘牌		1
5-51	AHR-2004	adjusting bolt	滑板調整螺絲		4
5-52		spring washer	彈簧華司	M12	4
5-53		nut	螺母	M12	4
5-54		set screw	止付螺絲	M8*25L	8
5-55					
5-56					
5-57					
5-58					
5-59					
5-60					
5-61					
5-62					
5-63					
5-64					
5-65					
5-66					
5-67					
5-68					
5-69					
5-70					
5-71					
5-72					
5-73					
5-74					
5-75					
5-76					
5-77					
5-78					
5-79					
5-80					
5-81					
5-82					
5-83					
5-84					
5-85					
5-86					
5-87					
5-88					
5-89					
5-90					
5-91					
5-92					

AH-360C

CHART 6

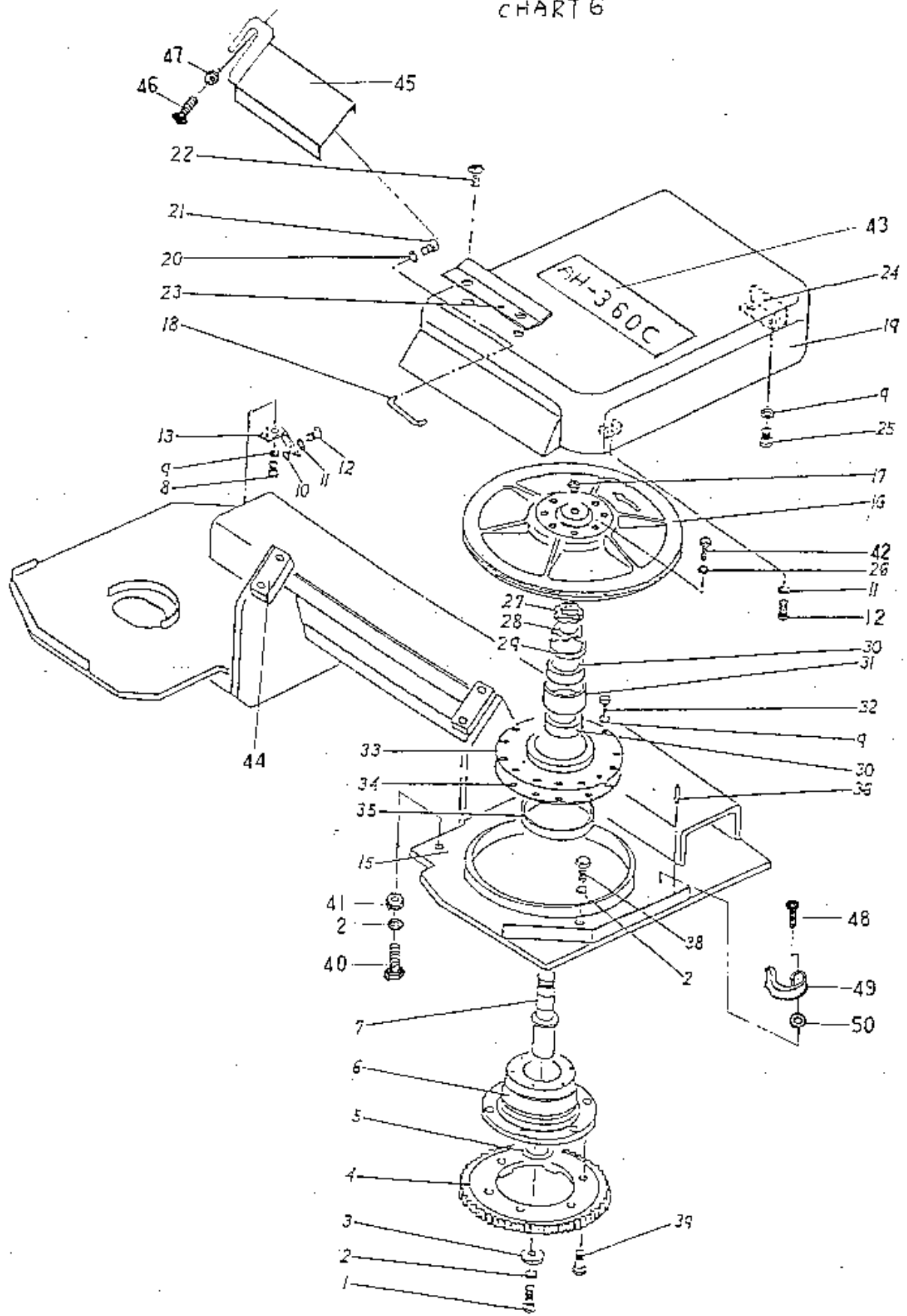


CHART 6 DRIVE WHEEL ASSEMBLY

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
6-1		bolt	內六角螺絲	M12*35L	1
6-2		spring washer	彈簧華司	M12	4
6-3	AHA-0403	washer	下輪鎖緊墊圈		1
6-4	AHA-0404	worm wheel	蝸輪		1
6-5	AHA-0405	spacer	銅片墊圈		1
6-6	AHA-0406	housing	蝸輪固定座		1
6-7	AHA-0407	wheel shaft	下輪軸		1
6-8		bolt	外六角螺絲	M6*20L	4
6-9		spring washer	彈簧華司	M6	22
6-10					
6-11	AHA-0434	rubber washer	橡皮墊圈		4
6-12		bolt	丸頭螺絲	M4*12L	4
6-13	AHA-0413	cover step	蓋板		2
6-14					
6-15	AHR-2001A	saw bow	弓鋸頭		1
6-16	AHR-2008	drive wheel	下輪		1
6-17		grease nipple	油嘴	1/16"	1
6-18	PP-52080	handle	輪箱把手		1
6-19	AHR-2009	housing cover (right)	下輪箱蓋		1
6-20		spring washer	彈簧華司	M5	4
6-21		screw	丸頭螺絲	M5*8L	2
6-22		screw	大丸頭螺絲	M5*6L	2
6-23		saw blade cover plate	滑板鋸片護蓋		1
6-24					
6-25		screw	外六角螺絲	M6*12L	4
6-26		spring washer	彈簧華司	M12	6
6-27	PP-14908	toothed nut	固定螺母	AN-08	1
6-28	PP-14958	toothed washer	止動環	AW08	1
6-29	AHA-0429	adjust collar	調整環		1
6-30	PP-14693	taper collar bearing	滾錐軸承	32208	2
6-31	AHA-0431	distance collar	軸承墊圈		1
6-32		screw	內六角螺絲	M6*10L	14
6-33	AHA-0433	cover	油封固定盤		1
6-34	AHA-0454	rubber packing	橡皮墊圈		1
6-35	PP-51090	oil seal	油封	130*160*14	1
6-36		spring pin	彈簧銷	φ5*60L	1
6-37					
6-38		bolt	外六角螺絲	M12*25L	6
6-39		bolt	內六角螺絲	M10*45L	2
6-40	AHA-0309	fixed bolt	固定螺栓		2
6-41		nut	螺母	M12	6
6-42		screw	外六角螺絲	M12*40L	1
6-43	AHR-2046	name plate	機型銘牌		2
6-44	AHR-2003	bracket	鋸臂滑板固定塊		1
6-45	AHR-2042-CE	cover	鋸片護蓋		1
6-46		screw	大丸頭螺絲	M6*16L	1

AH-360C

CHART 6 DRIVE WHEEL ASSEMBLY

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
6-47		nut	螺母	M6	1
6-48		screw	內六角螺絲	M6*60L	1
6-49	AHA-0414	plate	鋸片安裝板		1
6-50	AHA-0210B	washer	浪形板活動圈		1
6-51					
6-52					
6-53					
6-54					
6-55					
6-56					
6-57					
6-58					
6-59					
6-60					
6-61					
6-62					
6-63					
6-64					
6-65					
6-66					
6-67					
6-68					
6-69					
6-70					
6-71					
6-72					
6-73					
6-74					
6-75					
6-76					
6-77					
6-78					
6-79					
6-80					
6-81					
6-82					
6-83					
6-84					
6-85					
6-86					
6-87					
6-88					
6-89					
6-90					
6-91					
6-92					

AH-360C

CHART 7

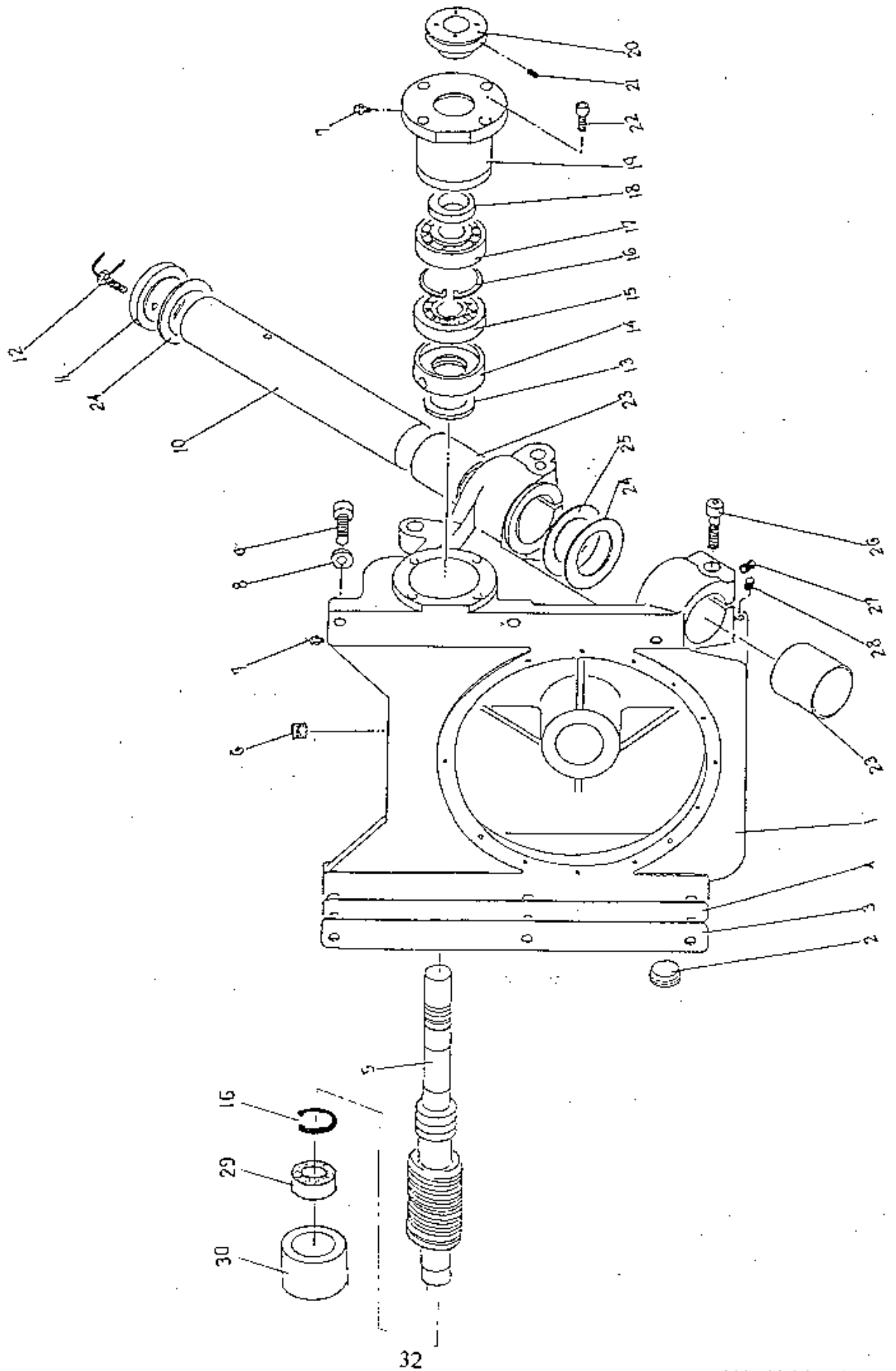


CHART 7 REDUCER ASSEMBLY

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
7-1	AHC-0301	hinge bracket	減速機本體		1
7-2	PP-21050	oil level gauge	油鏡	3/4	1
7-3		hinge bracket shim		0.5t	1
7-4		hinge bracket shim		1t	1
7-5	AHA-0305	worm	蝸桿		1
7-6		soc.hd.plug	塞頭	PT 1/2"	1
7-7		grease nipple	油嘴	1/16"	2
7-8		spring washer	彈簧華司	M12	3
7-9		bolt	內六角螺絲	M12*35L	3
7-10	AHA-0310	hinge pin	關節軸		1
7-11	AHA-0311	cap	關節軸蓋		1
7-12		bolt	外六角螺絲	M8*25L	2
7-13	PP-51080	oil seal	油封	E9	1
7-14	AHA-0314	bearing support	軸承座蓋		1
7-15	PP-14652	taper collar bearing	軸承	30306D	1
7-16		snap ring	扣環	R62	2
7-17	PP-14691	taper collar bearing	軸承	32206	1
7-18	PP-51070	oil seal	油封	V-38505	1
7-19	AHA-0319	bearing case	軸承座		1
7-20	AHA-0320	wire brush pulley	鋼刷普利		1
7-21		set screw	止付螺絲	M5*8L	2
7-22		soc.hd.bolt	內六角螺絲	M8*20L	4
7-23	PP-13250	du bushing	乾式軸承	MB 5060	2
7-24	AHA-0324	teflin washer	鐵弗龍墊圈		3
7-25	AHA-0325	thrust bearing enndle washe	平面墊圈		2
7-26		soc.hd.bolt	內六角螺絲	M12*40L	2
7-27		set screw	止付螺絲	M6*8L	2
7-28		soc.hd.plug	塞頭	PT 1/2"	1
7-29	PP-14131	ball bearing	軸承	6206Z	1
7-30	AHA-0326	bracket	軸承座		1
7-31					
7-32					
7-33					
7-34					
7-35					
7-36					
7-37					
7-38					
7-39					
7-40					
7-41					
7-42					
7-43					
7-44					
7-45					
7-46					

AH-360C

CHART 8

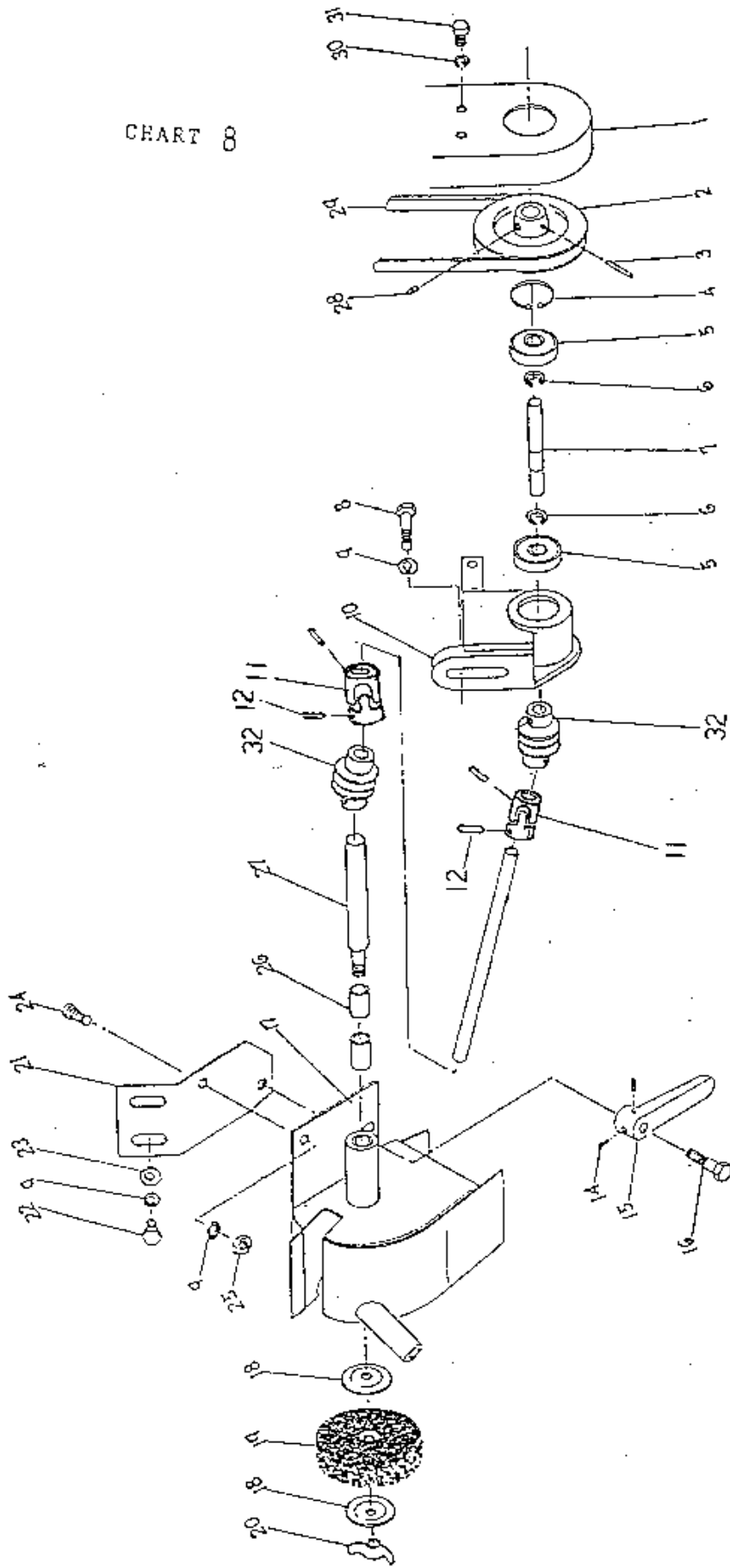


CHART 8 WIRE BRUSH ASSEMBLY

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
8-1	AHA-1201	pulley cover	鋼刷普利護蓋		1
8-2	AHA-1202	brush pulley	鋼刷普利		1
8-3		spring pin	彈簧銷	φ 4*25L	1
8-4		snap ring	扣環	R32	1
8-5	PP-14272	bearing	軸承	6201V	2
8-6		snap ring	扣環	S12	2
8-7	AHA-1207	pulley shaft	皮帶輪軸		1
8-8		bolt	外六角螺絲	M8*40L	2
8-9		washer	彈簧華司	M8	7
8-10	AHA-1211	bearing bracket	軸承座		1
8-11	PP-15010	universal joint	萬向接頭	12M/M	2
8-12					
8-13	AHA-1215	shaft	鋼刷傳動軸		1
8-14		set screw	止付螺絲	M5*6L	2
8-15	AHA-1217	lock lever	鋼刷調整桿		1
8-16		bolt	外六角螺絲	M8*35L	1
8-17	AHR-2034	brush cover	鋼刷護蓋		1
8-18		brush support	平面華司	S/16	2
8-19	PP-58002	wire brush	鋼刷	90*8MM	1
8-20		disk screw head	螺母	M8	1
8-21	AHR-2033	brush bracket	護蓋固定板		1
8-22		bolt	外六角螺絲	M8*15L	2
8-23		washer	平面華司	M8	2
8-24		screw	外六角螺絲	M8*16L	2
8-25		nut	螺母	M8	1
8-26	PP-13025	du bush	乾式軸承	MB 1215	2
8-27	AHB-0519	brush shaft	鋼刷軸		1
8-28		set screw	止付螺絲	M6*6L	1
8-29	PP-56512	v belt	皮帶	M39	1
8-30		spring washer	彈簧華司	M6	2
8-31		screw	外六角螺絲	M6*16L	2
8-32	PP-15012	dust seal	萬向接頭防塵套		2
8-33					
8-34					
8-35					
8-36					
8-37					
8-38					
8-39					
8-40					
8-41					
8-42					
8-43					
8-44					
8-45					
8-46					

AH-360C

CHART 9

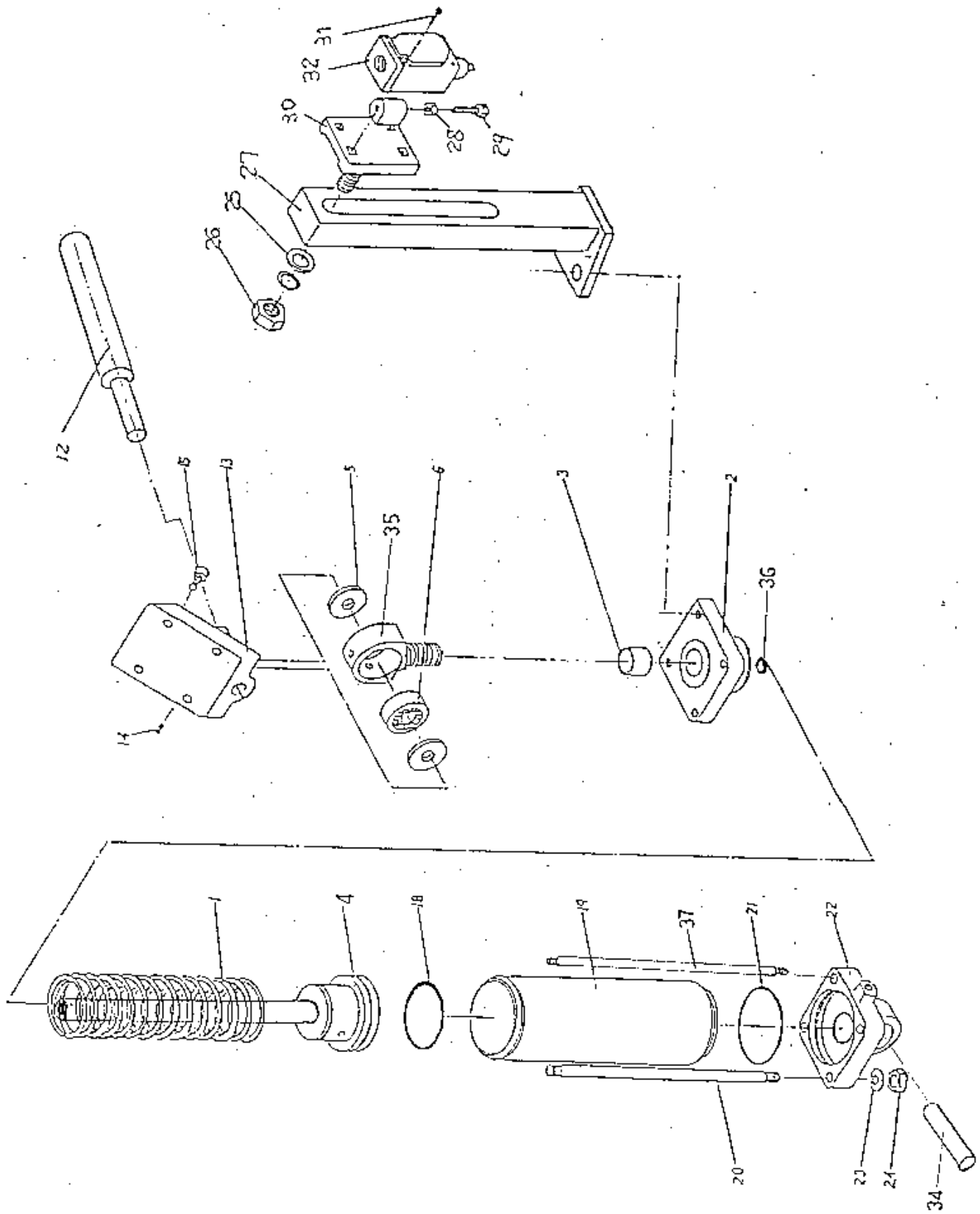


CHART 9 HEAD CYLINDER ASSEMBLY

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
9-1	AHR-2018	spring	鋸弓油壓缸彈簧		1
9-2	AHA-1102	upper cylinder cap	前蓋		1
9-3	PP-13190	du bushing	乾式軸承	MB3015	1
9-4	AHR-2017	piston rod	活塞及桿		1
9-5	AHA-1105	bearing holder	橡膠墊圈		2
9-6	PP-14510	bearing	軸承	2303	1
9-7					
9-8					
9-9					
9-10					
9-11					
9-12	AHR-2038	hinge shaft	油壓缸插銷		1
9-13	ACD-1113	upper cylinder holder	油壓缸頂座		1
9-14		set screw	止付螺絲	M6*10L	1
9-15		socket hd.bolt	內六角螺絲	M10*25L	4
9-16					
9-17					
9-18	PP-59170	o-ring	O型環	P70	1
9-19	AHR-2019	cylinder	缸筒		1
9-20	AHR-2020	tie-rod bolt	連桿		2
9-21	PP-59600	o-ring	O型環	G85	1
9-22	AHA-1122	under cylinder cap	後蓋		1
9-23		spring washer	彈簧華司	M12	4
9-24		nut	螺帽	M12	4
9-25		washer	平面華司	M16	1
9-26	ACA-2053M	nut	滑座固定螺帽		1
9-27	AHR-2037	height setting slide	限動開關滑板		1
9-28		nut	螺帽	M8	2
9-29		screw	外六角螺絲	M8*30L	1
9-30	SJY-1131	carriage	限動開關滑座		1
9-31		screw	丸頭螺絲	M5*30L	4
9-32	PP-90020	limit switch	限動開關	TZ 5101	1
9-33		screw	外六角螺絲	M8*75L	1
9-34	AGB-70304B	pin	油壓缸插銷		1
9-35	PP-14480	link bearing	連桿軸承	POS-18	1
9-36		o-ring	O型環	P30	1
9-37	AHR-2020A	tie-rod bolt	連桿		2
9-38					
9-39					
9-40					
9-41					
9-42					
9-43					
9-44					
9-45					
9-46					

AH-360C

10 BASE ASSEMBLY

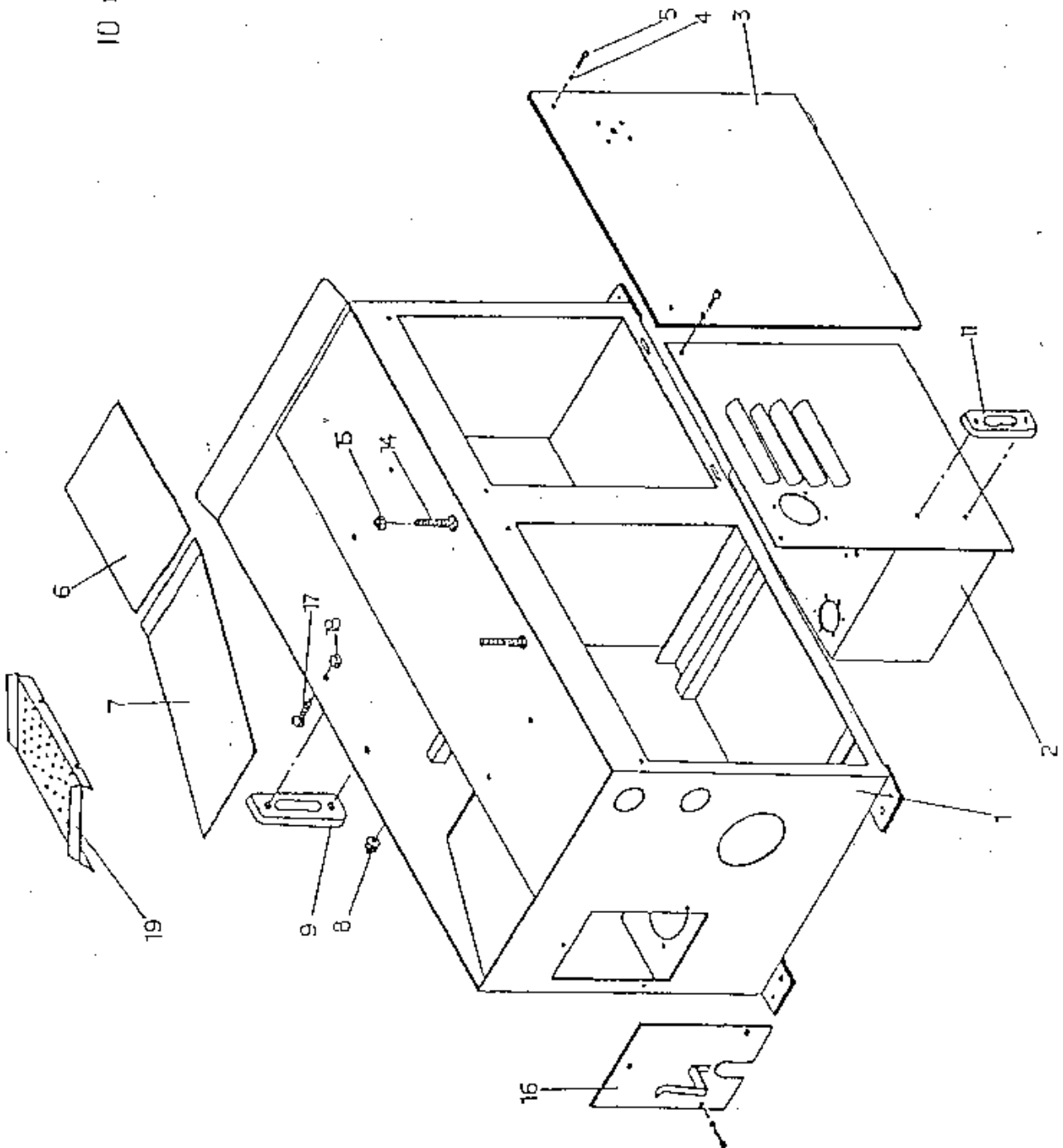
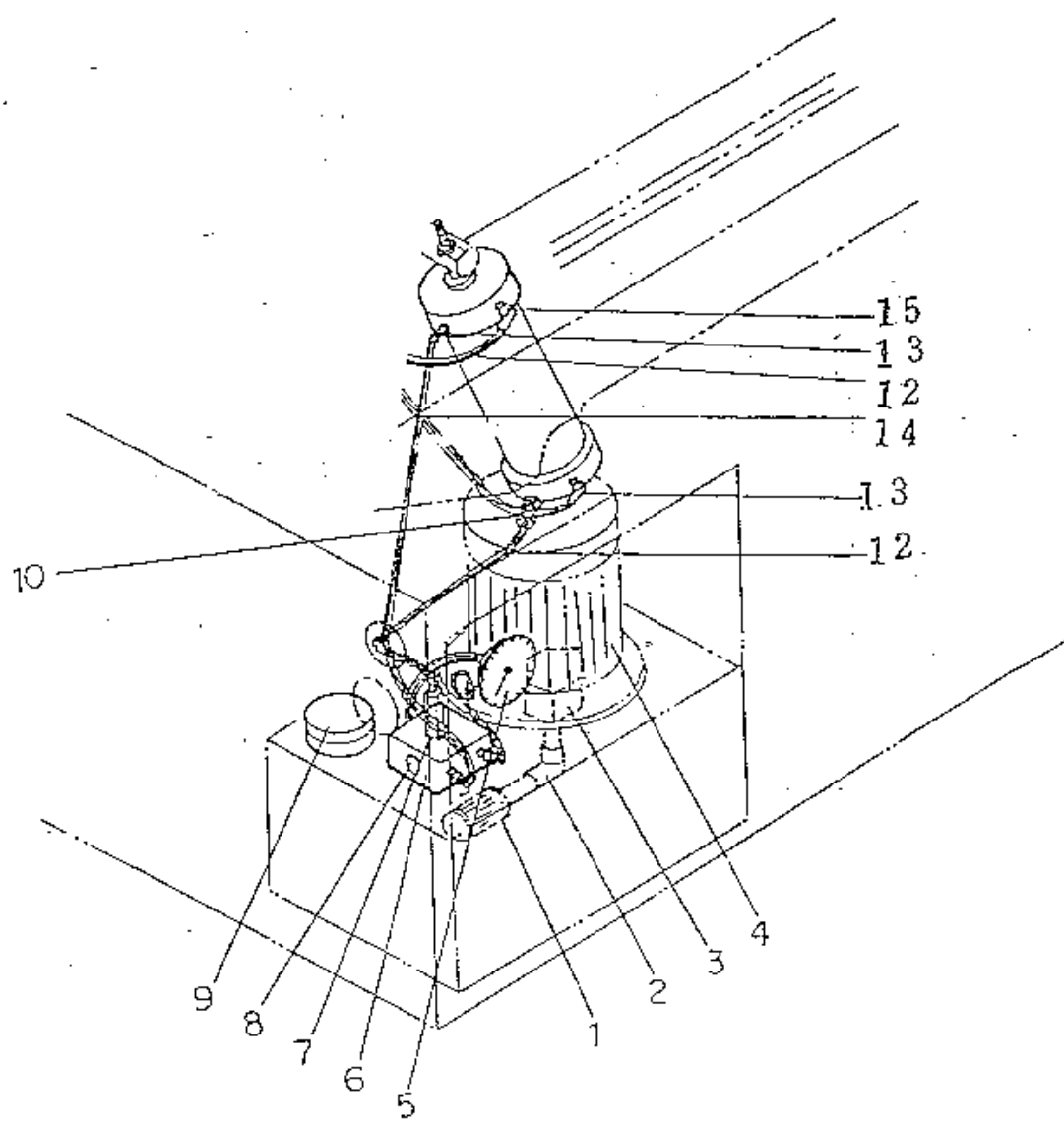


CHART 10 BASE ASSEMBLY

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
10-1	AHR-1001A	base	底座		1
10-2	AHR-1041	hydraulic oil tank	油壓箱		1
10-3		electric cabinet door	電器門		1
10-4		washer	彈簧華司		8
10-5		screw	內六角螺絲	M6*25L	8
10-6		filter plate (a)	集水斜板		1
10-7		filter plate (b)	集水斜板		1
10-8		coolant drain plug	塞頭	PT 1/2	1
10-9	PP-21040	coolant level gauge	油面計	7"	1
10-10					
10-11	PP-21030	oil level gauge	油面計	3"	1
10-12					
10-13					
10-14		bolt	外六角螺絲	M16*100L	2
10-15		nut	螺帽	M16	4
10-16	ACA-1003	hose hanger	泵浦邊蓋		1
10-17		screw	外六角螺絲	M10*32L	2
10-18		nut	螺帽	M10	6
10-19	AHR-1045	off-cut extracing plate	下料斜板		1
10-20					
10-21					
10-22					
10-23					
10-24					
10-25					
10-26					
10-27					
10-28					
10-29					
10-30					
10-31					
10-32					
10-33					
10-34					
10-35					
10-36					
10-37					
10-38					
10-39					
10-40					
10-41					
10-42					
10-43					
10-44					
10-45					
10-46					

AH-360C

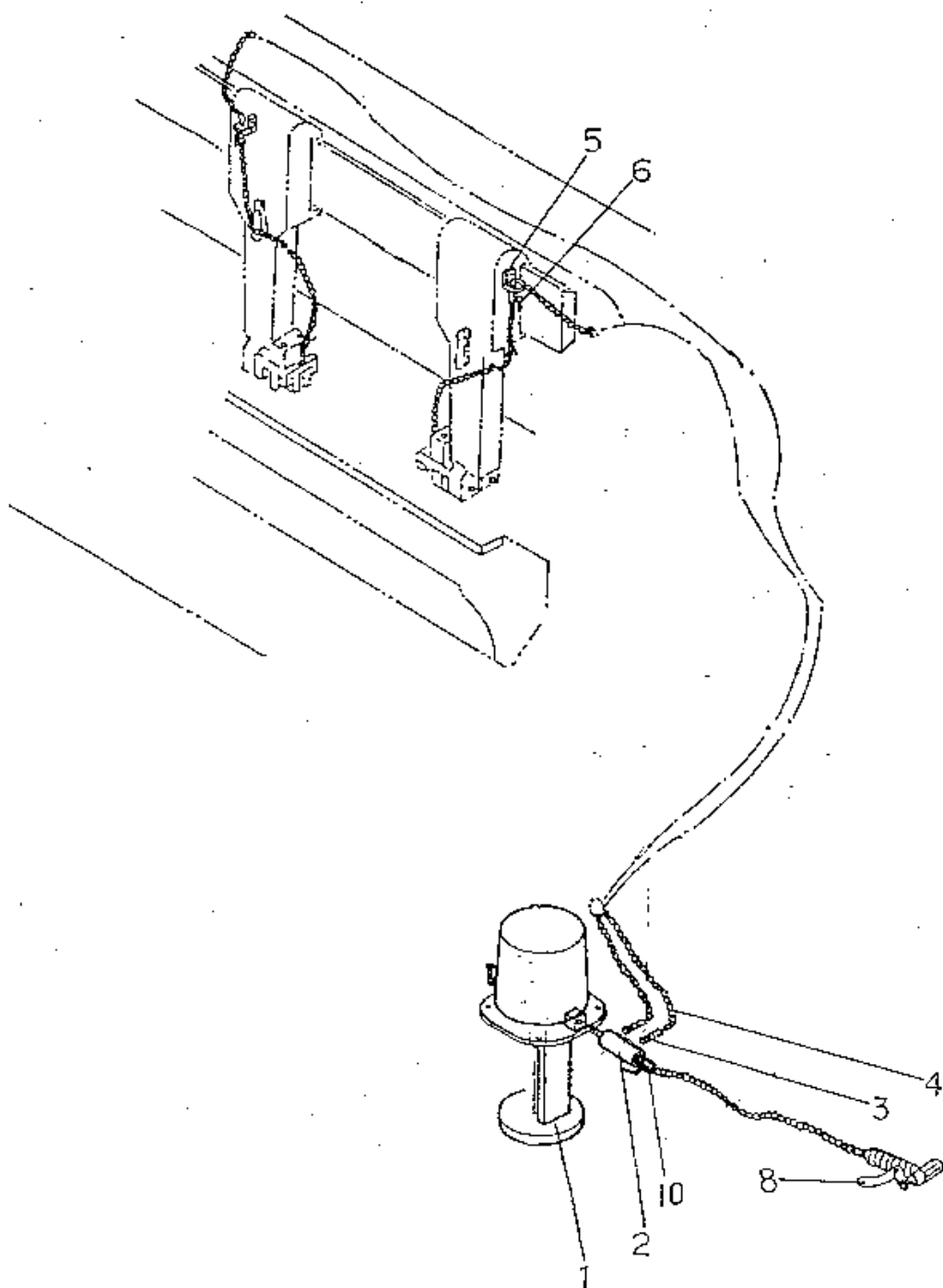


11 HYDRAULIC SYSTEM

CHART 11 HYDRAULIC SYSTEM

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
11-1	PP-43330	filter	濾油網	PS-04	1
11-2		elbow	內外牙彎頭	PT 1/2	1
11-3	PP-32202	oil pump	油壓泵浦	RSP-205A	1
11-4	PP-31311	motor	油壓馬達	1/4HP-4P	1
11-5	PP-43310	pressure gauge	壓力表	50KG	1
11-6	ACA-1008	oil distributing block	油路板		1
11-7	PP-43110	check valve	止回閥	3/8"	1
11-8	ACA-10100	pressure adjustor	洩壓閥整組		1
11-9	PP-43320	oil inlet	注油器		1
11-10	PP-43601	solenoid valve	電磁閥		1
11-11					
11-12		vinyl hose	油管	1/4"	2
11-13		elbow	彎接頭	1/4"	2
11-14		vinyl hose	油管	1/4"	2
11-15		hose connector	彎接頭	1/4"	4
11-16					
11-17					
11-18					
11-19					
11-20					
11-21					
11-22					
11-23					
11-24					
11-25					
11-26					
11-27					
11-28					
11-29					
11-30					
11-31					
11-32					
11-33					
11-34					
11-35					
11-36					
11-37					
11-38					
11-39					
11-40					
11-41					
11-42					
11-43					
11-44					
11-45					
11-46					

AH-360C

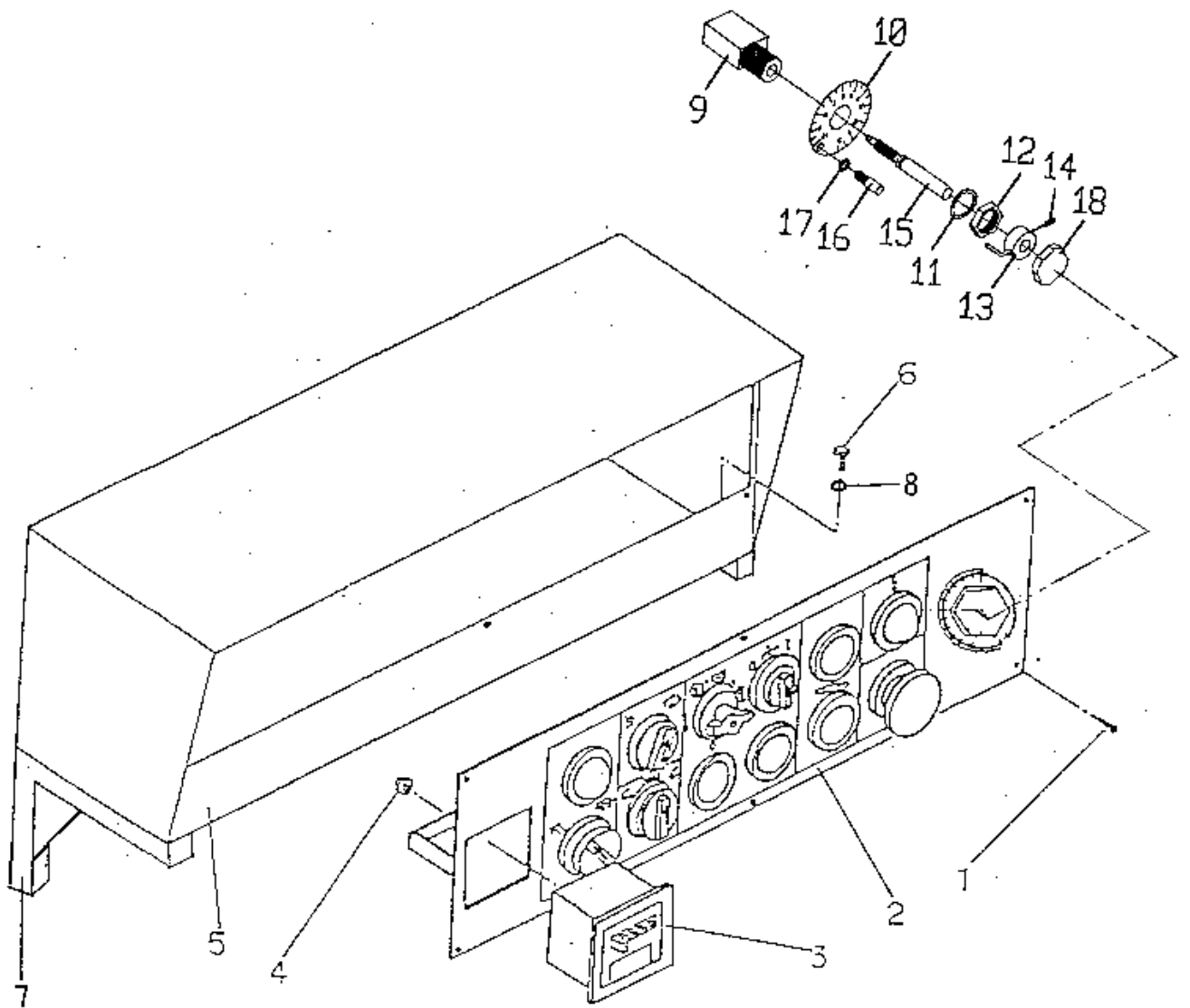


12 COLLANT SYSTEM

CHART 12 COOLANT SYSTEM

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
12-1	PP-32081	pump	浸水泵浦	1/8HP*210L	1
12-2	ACA-1004	3-way cock	泵浦接頭		1
12-3		fitting	固定塊水管接頭		2
12-4		hose	水管	1/4*3000L	2
12-5	MJA-2041	bracket	水龍頭座板		1
12-6	PP-43132	valve	開關閥	1/8"	2
12-7					
12-8	AHA-1313	nozzle ,hand	噴嘴		1
12-9		sanp ring	扣環	A12	1
12-10	PP-43135	valve	開關閥		1
12-11					
12-12					
12-13					
12-14					
12-15					
12-16					
12-17					
12-18					
12-19					
12-20					
12-21					
12-22					
12-23					
12-24					
12-25					
12-26					
12-27					
12-28					
12-29					
12-30					
12-31					
12-32					
12-33					
12-34					
12-35					
12-36					
12-37					
12-38					
12-39					
12-40					
12-41					
12-42					
12-43					
12-44					
12-45					
12-46					

AH-360C

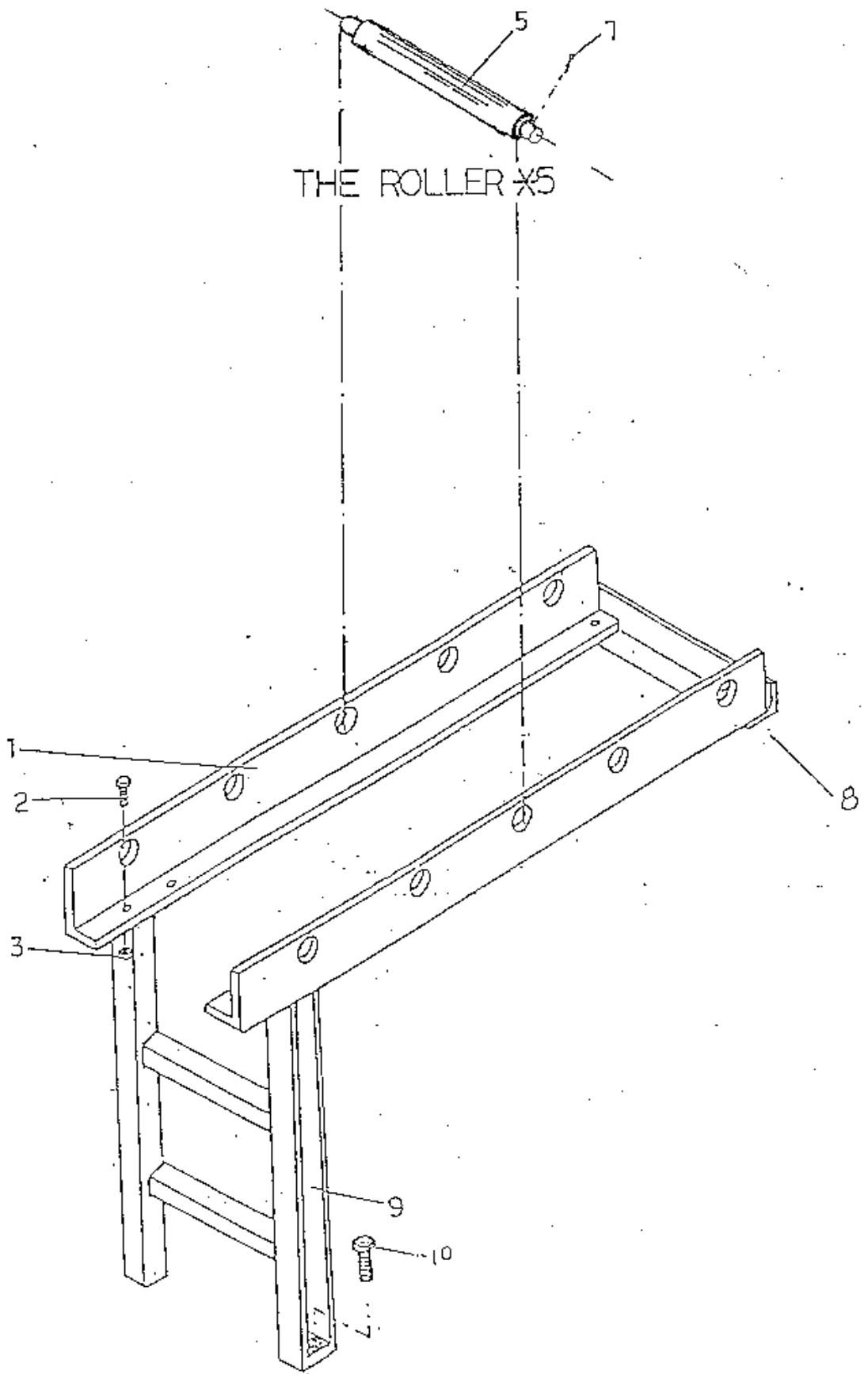


13. CONTROL PANEL.

CHART 13 CONTROL PANEL

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
13-1		screw	丸頭螺絲	M4*10L	6
13-2	ACA-2078	control panel	控制面板		1
13-3	PP-90410	piecc counter	計數器		1
13-4					
13-5	ACD-2002	control box	電器控制箱		1
13-6		screw	外六角螺絲	M6*10L	4
13-7	AHR-2024	bracket	控制箱固定板		2
13-8		spring washer	彈簧華司	M6	4
13-9	ACA-2063-1	feed rate valve block	流量閥本體		1
13-10	PP-61005	feed rate gauge dial	刻度牌		1
13-11		washer	平面華司	M16	1
13-12	MJA-4010	nut	六角螺母	M16	1
13-13	MJA-4007	pointer	指針及座		1
13-14		screw	丸頭螺絲	3/16*3/8"	1
13-15	ACA-2063-2	flow regulator	流量調整桿		1
13-16	SJY-2108	shaft	指針擋桿		1
13-17		nut	螺母		1
13-18					
13-19					
13-20					
13-21					
13-22					
13-23					
13-24					
13-25					
13-26					
13-27					
13-28					
13-29					
13-30					
13-31					
13-32					
13-33					
13-34					
13-35					
13-36					
13-37					
13-38					
13-39					
13-40					
13-41					
13-42					
13-43					
13-44					
13-45					
13-46					

AH-360C



14 ROLLER TABLE

CHART 14 ROLLER TABLE

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
14-1	ACA-1073	roller table	滾輪送料架		2
14-2		bolt	外六角螺絲	M10*25L	4
14-3		nut	螺帽	M10	4
14-4					
14-5	AHR-4003A	roller	滾輪		5
14-6					
14-7		pin	開口銷	5/32*1 1/4"	10
14-8	AHR-4001	support angle	送料架支板		1
14-9	AHR-4002A	table support	腳架		1
14-10		adjusting screw	外六角螺絲	M20*70L	2
14-11		nut	螺母	M20	2
14-12					
14-13					
14-14					
14-15					
14-16					
14-17					
14-18					
14-19					
14-20					
14-21					
14-22					
14-23					
14-24					
14-25					
14-26					
14-27					
14-28					
14-29					
14-30					
14-31					
14-32					
14-33					
14-34					
14-35					
14-36					
14-37					
14-38					
14-39					
14-40					
14-41					
14-42					
14-43					
14-44					
14-45					
14-46					

AH-360C

CHART 15

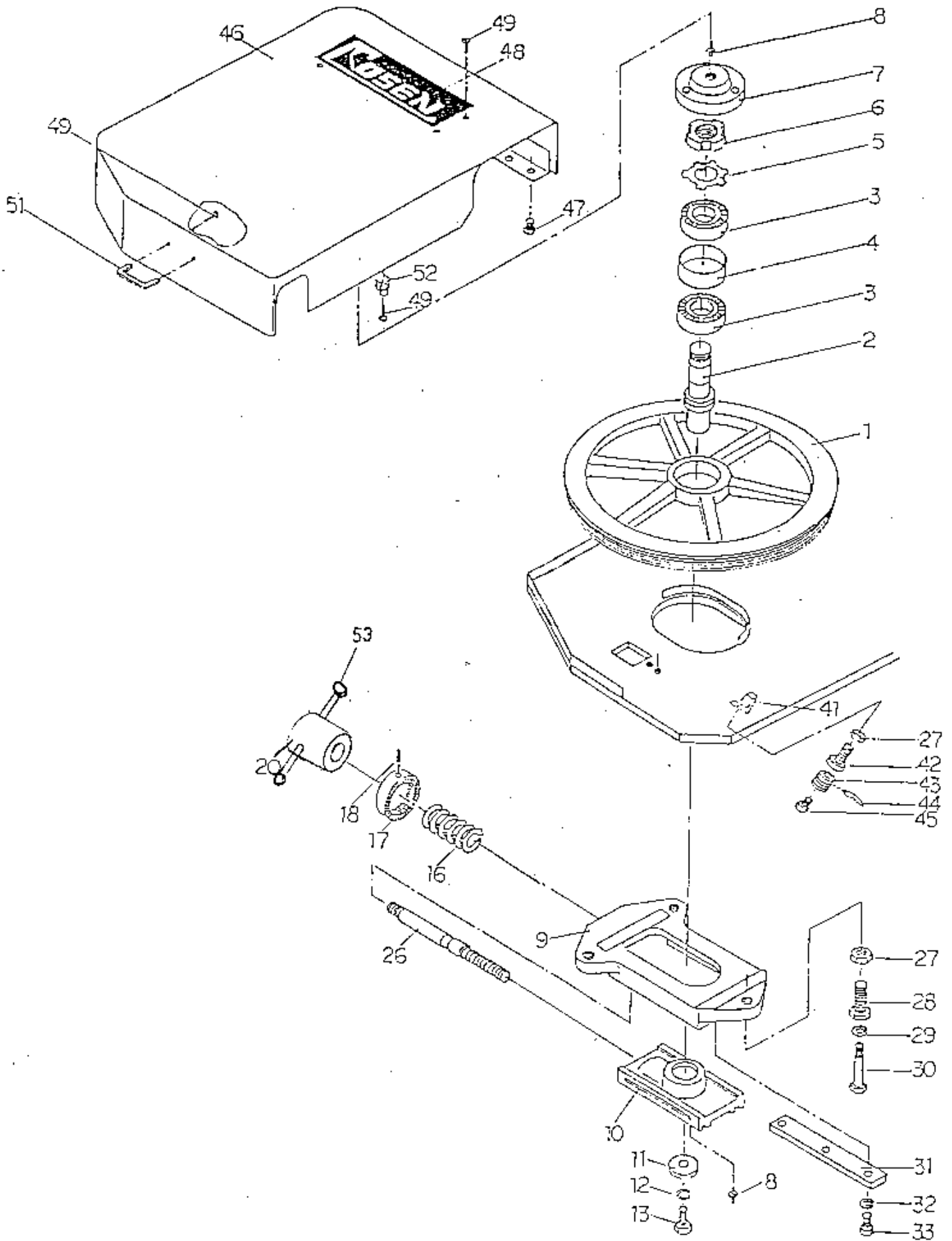


CHART 15 IDLE WHEEL ASSEMBLY

NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
15-1	AHR-2007	idle wheel	上輪		1
15-2	AHA-0635	wheel shaft	上輪軸		1
15-3	PP-14613	taper roller bearing	滾錐軸承	30207	2
15-4	AHA-0637	bearing collar	上輪軸承墊圈		1
15-5	PP-14957	toothed washer	止動環	AW07	1
15-6	PP-14907	toothed nut	固定螺母	AN07	1
15-7	SHA-04140	wheel shaft cover	上輪軸蓋		2
15-8		grease nipple	油嘴	1/16"	1
15-9	AHR-2055	tension body	張力調整滑座		1
15-10	AHR-2056	slide piece	張力調整滑板		1
15-11	AHA-0407	washer	下輪鎖緊墊圈		1
15-12		spring washer	彈簧華司	M12	1
15-13		bolt	內六角螺絲	M12*35L	1
15-14					
15-15					
15-16	PP-57500	spring	蝶形彈簧	40*20.4*2.25	8
15-17	AHR-2057	tension handle set ring	張力把手調整指示環		1
15-18		set screw	止付螺絲	M5*5L	1
15-19					
15-20	AHR-2053	tension handle	張力把手		1
15-21					
15-22					
15-23					
15-24					
15-25					
15-26	AHR-2054	shaft	張力螺桿		1
15-27	AHA-0611	nut	張力調整螺母		3
15-28	AHA-0610	adjusting screw	張力調整螺絲		3
15-29		spring washer	彈簧華司	M12	3
15-30		bolt	外六角螺絲	M12*80L	3
15-31	AHA-0603	guide plate	導板壓條		2
15-32		spring washer	彈簧華司	M8	6
15-33		screw	外六角螺絲	M8*25L	6
15-34					
15-35					
15-36					
15-37					
15-38					
15-39					
15-40					
15-41	AHC-0452	bracket (saw bow)	鋸弓定位板		1
15-42	AHA-0631	bolt	定位螺絲		1
15-43	AHA-0629	spring	緩衝彈簧		1
15-44	AHA-0630	spring plate	墊圈		1
15-45		screw	內六角螺絲	M6*12L	1
15-46	AHR-2009	housing cover (L)	上輪箱蓋		1

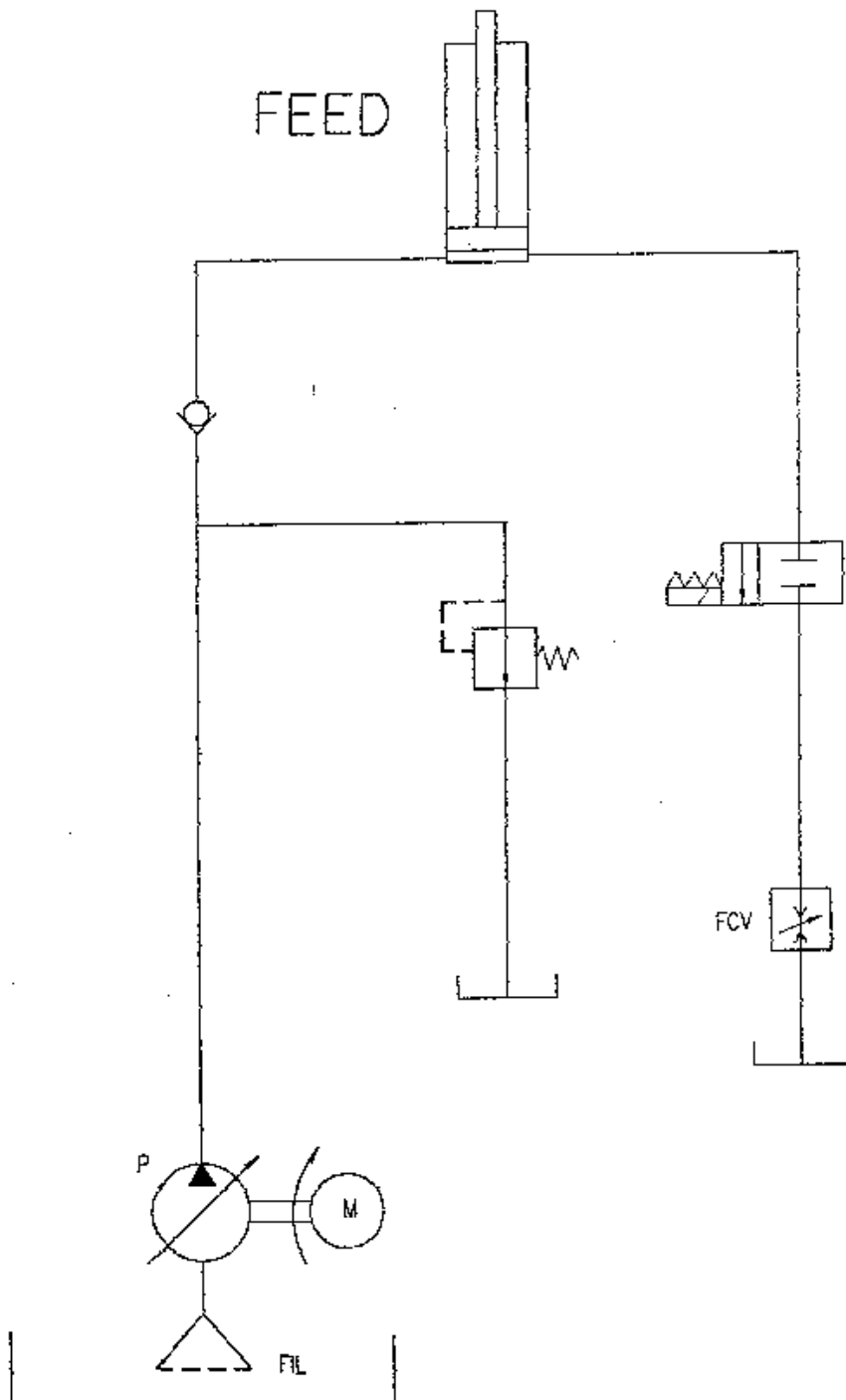
AH-360C

CHART 15 IDLE WHEEL ASSEMBLY

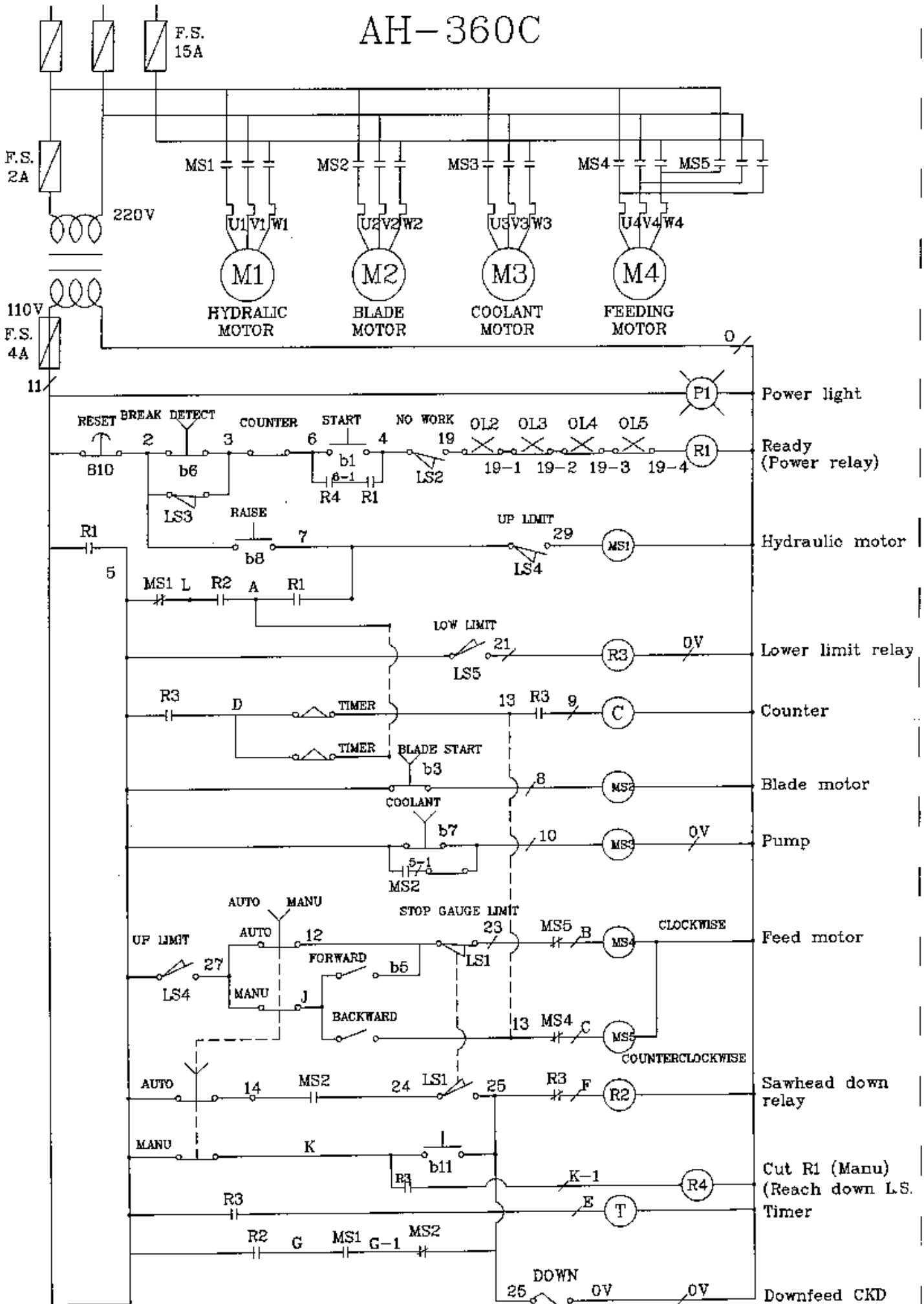
NO.	PART NO.	PART NAME	PART NAME IN CHINESE	PART SPEC.	QTY
15-47		pan hd.mach screw	外六角螺絲	M6*12L	4
15-48	AHA-0666	name plate	COSEN 銘牌		1
15-49		pan hd.mach screw	丸頭螺絲	M4*12L	8
15-50					
15-51	PP-52080	bracket (housing cover	輪箱把手		2
15-52	AHA-0434	washer	橡皮墊圈		2
15-53	PP-52040	ball	塑膠球	3/8"	2
15-54					
15-55					
15-56					
15-57					
15-58					
15-59					
15-60					
15-61					
15-62					
15-63					
15-64					
15-65					
15-66					
15-67					
15-68					
15-69					
15-70					
15-71					
15-72					
15-73					
15-74					
15-75					
15-76					
15-77					
15-78					
15-79					
15-80					
15-81					
15-82					
15-83					
15-84					
15-85					
15-86					
15-87					
15-88					
15-89					
15-90					
15-91					
15-92					

AH-360C

HYDRAULIC DIAGRAM FOR AH-1010JAY
AH-260C
AH-300C
AH-360C



AH-360C





GET A FREE CATALOG JUST FOR EXPRESSING YOUR OPINION!

Help us improve our manual and machine. Please complete this form, pull out this page and send it in today. The address is on the reverse side.

Machine Type of Instruction Manual	
Print Number	

Name		Company	
Department		Telephone	
Address		City	State
Zip		Country	

1. How would you rate the overall quality of this machine?

- Excellent
- Very Good
- Good
- Fair
- Below Average
- Poor

2. What were the things you liked most about the instruction manual?(Check all that apply)

- Pace
- Format
- Writing Style
- Table of Contents
- Illustrations
- Type Style

- Cover
- Depth of Coverage
- Fast Track Notes

3. How did you decide to buy this machine?

- Recommended by friend
- Recommended by store personnel
- Manufacturer reputation
- Read advertisement in _____
- Other _____

4. What is your level of experience with the subject covered for machine?

- Beginner
- Intermediate
- Advanced

5. How long have you been using a machine?

years _____

months _____

6. What kind of optional accessories do you plan to buy? (Check all that apply)

- Additional saw blade
- Roller table
- Multi-vises clamping
- Vise pressure regulator
- Infinitely variable blade speed device
- Additional wire brushes
- Chip conveyor
- Hydraulic clamping device(double side type)

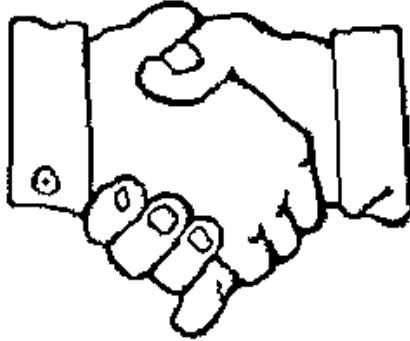
7. On what machine-related subject(s) would you like to see more instruction?

Section	Improve

8. Do you have any other comments about this machine?

Machine Parts	Improve

✂ Please cut the line here.



PLEASE FOLD, SEAL, AND MAIL TO COSEN

Stamp

To:

COSEN CO., LTD.

Customer Service Department
110 Ching-Fu Street
Hsin-Chu 300
Taiwan, R.O.C.



COSEN MACHINERY INDUSTRIAL CO., LTD.

110, CHING-FU STREET, HSIN-CHU, TAIWAN, R. O. C.

TEL 886-3-5332143-5.

FAX 886-3-5348324

e-mail coscn@ms9.hinet.net