

TABLE OF CONTENTS

GENERAL

Specifications	1
Schematics	2
Installation	3

OPERATION

Control Switch	4
Variable Speed Adjustment	4
Blade Speed	4
Installation of Blade	5
Angle Adjustment For Working Table	5
Blade Shear	6
Saw Guide Holder	6
Post	7
Blade Tracking	7

WELDING BLADES

Welding Operation	10
Annealing Operation	10
Special Caution For Operation	11

MAINTENANCE OF MACHINE

Standard Accessories	12
Electric Schematic and parts List	13

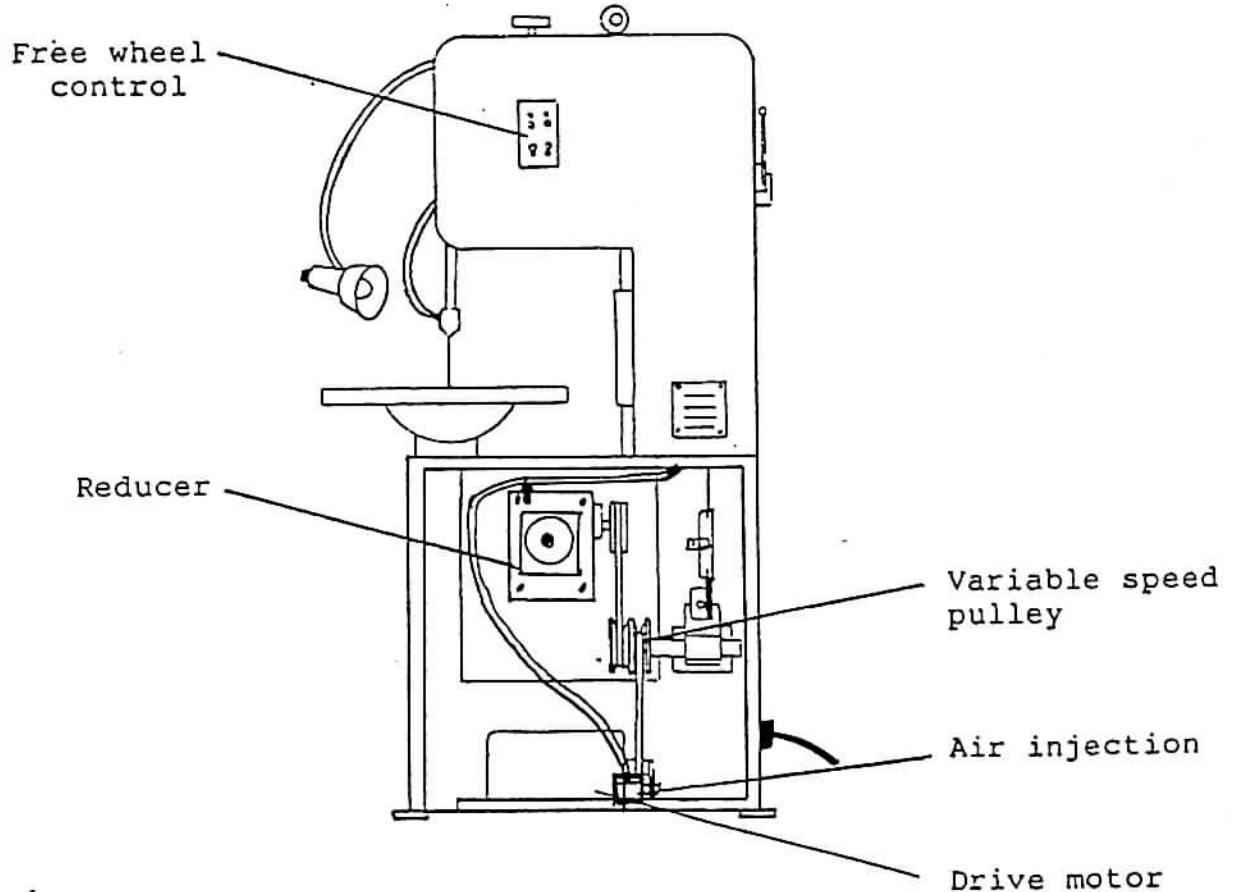
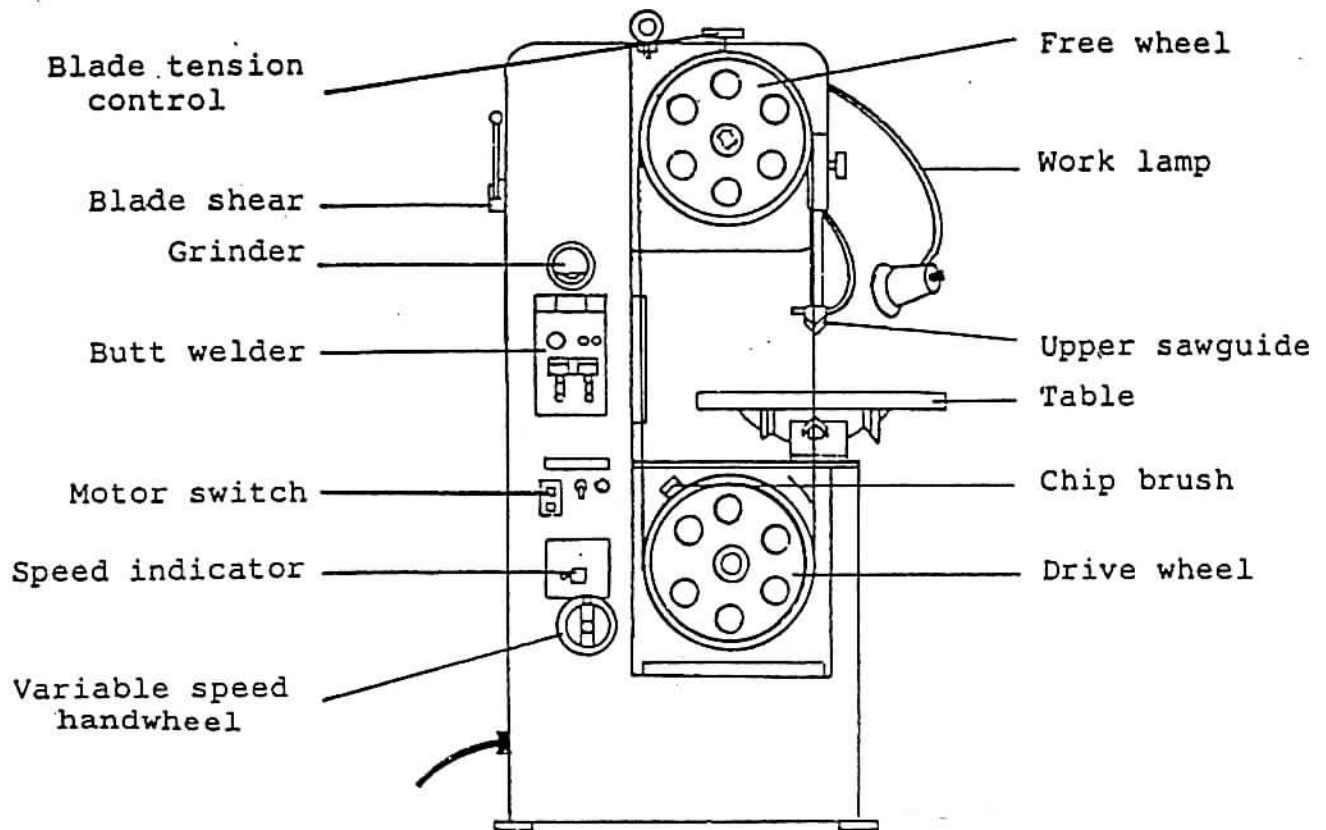
PARTS LISTS

Free Wheel Assembly	15
Post and Upper Sawguide Assembly	17
Table and Under Sawguide Assembly	19
Drive Assembly	21
Variable Speed Pulley Assembly	24
Welder Assembly	26
Machine Body Assembly	29

SPECIFICATIONS

MODELS	VB-300	KB-36	VB-450
CAPACITY - blade to column - max. work height	310mm ($12\frac{3}{16}$ in) 175mm ($6\frac{7}{8}$ in)	355mm (14 in) 230mm ($9\frac{1}{16}$ in)	455mm ($17\frac{5}{16}$ in) 255mm ($10\frac{1}{16}$ in)
TABLE - size - tilts, 4 ways - height from floor	500x400mm $19\frac{1}{2} \times 15\frac{3}{4}$ in 15° 890mm ($35\frac{1}{32}$ in)	500x400mm $19\frac{1}{2} \times 15\frac{3}{4}$ in 15° 960mm ($37\frac{13}{16}$ in)	600x500mm $23\frac{1}{2} \times 19\frac{1}{2}$ in 15° 935mm ($36\frac{13}{16}$ in)
SPEEDS - infinitely variable - 60 cycles - 50 //	20-90M/min (65-295 fpm)	20-90M/min (65-295 fpm)	25-115M/min (85-375 fpm)
WHEEL DIA.	320mm ($12\frac{1}{2}$ in)	360mm (14 in)	460mm (18 in)
BLADES - length - max. width	2520mm ($99\frac{1}{4}$ in) 13mm ($\frac{1}{2}$ in)	2840mm ($111\frac{13}{16}$ in) 16mm ($\frac{5}{8}$ in)	3490mm ($137\frac{3}{8}$ in) 16mm ($\frac{5}{8}$ in)
DRIVE MOTOR	0.4KW ($\frac{1}{2}$ HP)	0.75KW (1 HP)	0.75 KW (1 HP)
BUTT WELDER CAPACITY	2.0KVA 3-13mm ($1/8$ - $1/2$ in)	2.4 KVA 3-16mm ($1/8$ - $5/8$ in)	2.4KVA 3-16mm ($1/8$ - $5/8$ in)
FLOOR SPACE - front to rear - left to right	470mm ($18\frac{1}{2}$ in) 835mm ($32\frac{7}{8}$ in)	480mm ($18\frac{7}{8}$ in) 885mm ($34\frac{7}{8}$ in)	545mm ($21\frac{1}{2}$ in) 1060mm ($41\frac{3}{4}$ in)
HEIGHT	1560mm ($61\frac{13}{32}$ in)	1735mm ($68\frac{5}{16}$ in)	1900mm ($74\frac{13}{16}$ in)
NET WEIGHT	225 KGS (496 lbs)	250 KGS (551 lbs)	300 KGS (882 lbs)
GROSS WEIGHT	285 KGS (628 lbs)	310 KGS (683 lbs)	370 KGS (1146 lbs)

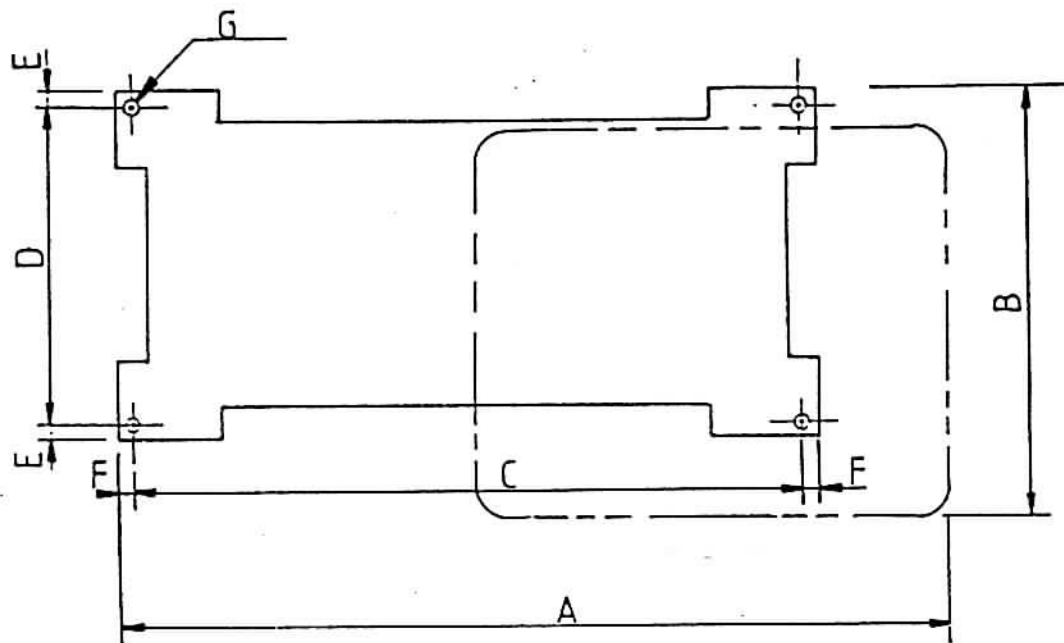
SCHEMATICS



INSTALLATION

Using a crane, fork lift, or other device, hoist the machine at the top Eye Bolt and carefully move it into place. Proceed carefully to avoid damage or overturn.

Foundation bolt layout is shown in the following figures.



VB-300

Item	A	B	C	D	E	F	G
mm	835	470	700	285	35	20	M12xP1.75
inch	32 $\frac{7}{8}$	18 $\frac{1}{2}$	27 $\frac{9}{16}$	11 $\frac{7}{32}$	1 $\frac{3}{8}$	$\frac{25}{32}$	

KB-36

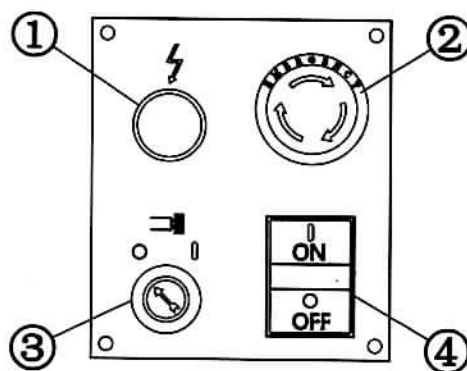
Item	A	B	C	D	E	F	G
mm	885	480	750	290	35	20	M12xP1.75
inch	34 $\frac{7}{8}$	18 $\frac{7}{8}$	29 $\frac{1}{2}$	11 $\frac{7}{16}$	1 $\frac{3}{8}$	$\frac{25}{32}$	

VB-450

Item	A	B	C	D	E	F	G
mm	1060	545	850	400	20	20	M12xP1.75
inch	41 $\frac{3}{4}$	21 $\frac{1}{2}$	33 $\frac{1}{2}$	15 $\frac{3}{4}$	$\frac{25}{32}$	$\frac{25}{32}$	

OPERATION

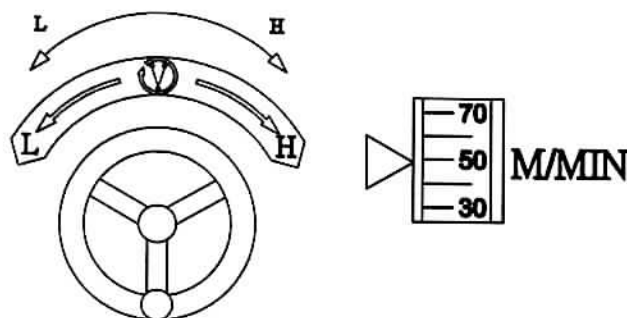
CONTROL SWITCH:



- ①: This is a white lamp which will be lighting when the power is turned on, otherwise being off.
- ②: a. For emergent stop.
b. All power is switched off once pressed.
c. To restore operation by releasing the emergency button.
d. Other power switch must be turned on for operation.
- ③: a. Turn on the sander, the lamp will be lighting white while turning on, take care to operate.
b. To turn off the sander, the lamp will be off.
c. Wearing safety goggle to protect eyes when operation.
- ④: a. To turn on the saw belt, the lamp will be lighting while turning on, take care to operate.
b. To turn off the saw belt, the lamp will be off whiling turning off.
c. Wearing safety goggle to protect eyes.

VARIABLE SPEED ADJUSTMENT:

The speed change of saw belt is performed by section-free way, as the illustration: turning clockwise increases speed, counter-clockwise decreases. View the speed display when adjusting, until desired speed can be reached. Refer to the speed list of saw belt for better efficiency.



BLADE SPEED :

The speed Indicator Dial in front of handwheel. There are The British and Metric system of measurement. The British system bases on feet per minute, the Metric system bases on meters per minute.

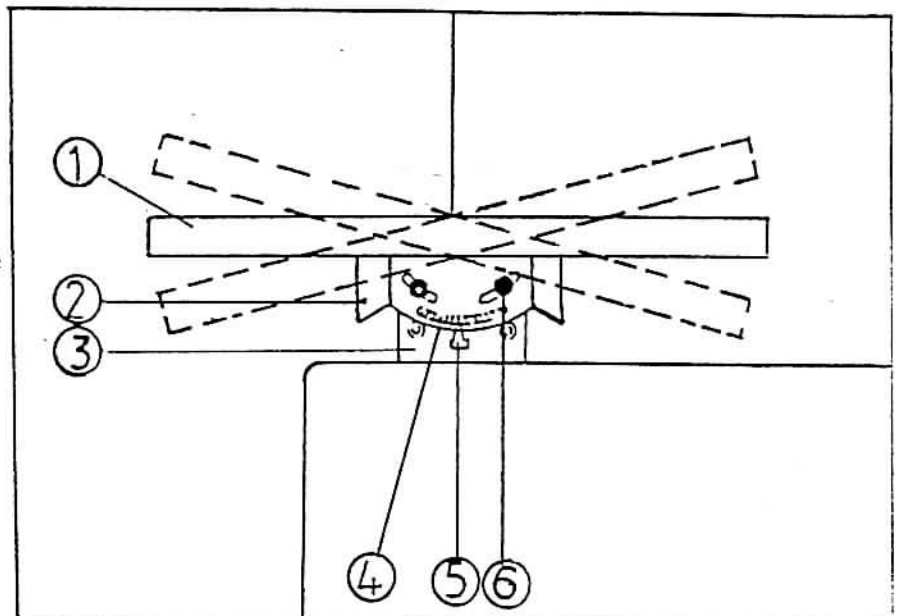
INSTALLATION OF BLADE

1. Open the door of free and drive Wheel case.
2. Turn saw blade tension handwheel to lower in free Wheel.
3. Using gloves, slip the saw blade through the table slot, between the blade guides and over the wheels.
4. Turn the regulating handwheel for saw blade tensity to raise the free Wheel and tighten the saw blade.
5. The less width of blade, the less tensity the saw blade shall be. In general, the best tensity is to push the saw blade with the thumb 2-5mm to left if the distance between table and saw guide inserts is 100 mm.

ANGLE ADJUSTMENT FOR WORKING TABLE

Index No. Description

1. Woking Table
2. Turning Rack
3. Table Bed
4. Scale
5. Indicating Needle
6. Fastening Screw

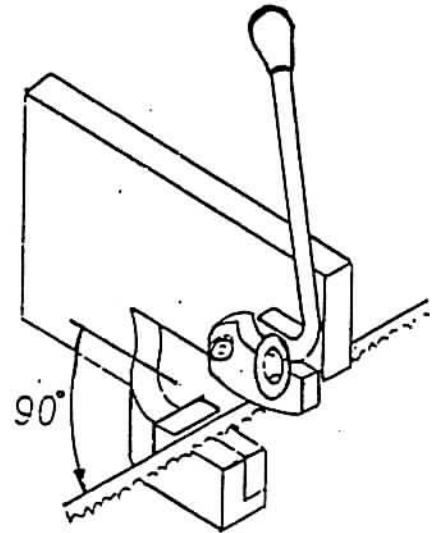


Procedure

Loosen the Fastening Screw and adjust the angle. The adjustment can be done according to the Indicating Needle. Fasten the Fastening Screw when the needed angle is adjusted.

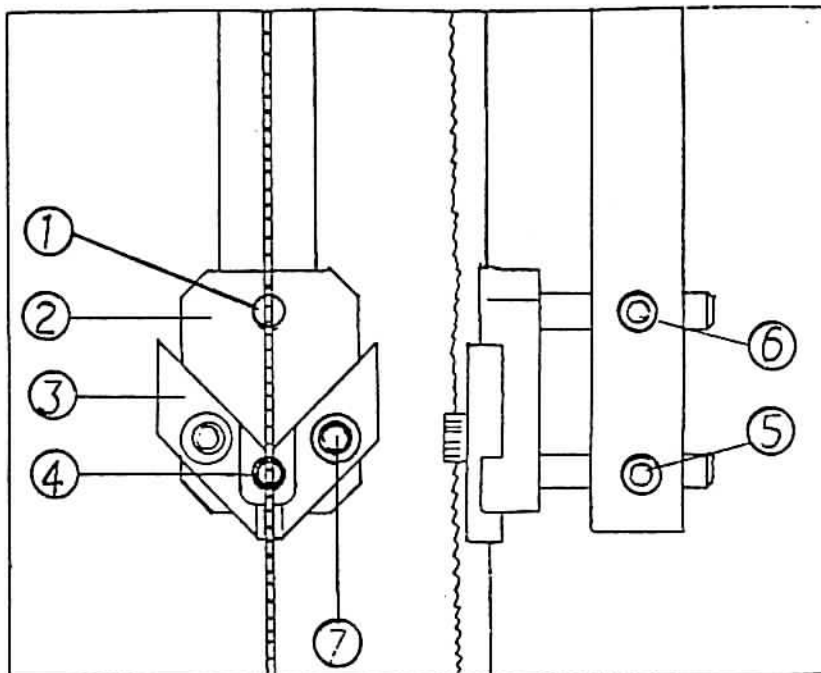
BLADE SHEAR

Measure the length of blade, Cut the saw blade as illustration. The blade must be square with blade shear.



SAW GUIDE HOLDER

Index No.	Description
1	Support Bar
2	Saw Guide Holder
3	Insert
4	Back Up Support
5	Back Up Support Fastening Screw
6	Support Bar Fastening Screw
7	Insert Fastening Screw



Procedure

1. Before operation examine and make sure that the saw blade is accurately installed inside the Inserts of upper and lower of Saw Guide Holders.
2. Examine the space between saw blade and Inserts. The Inserts cannot clamp the saw blade too tight nor too loose. The space allows it passing through exactly.
3. When the saw blade cannot move, (Inserts clamp too tight), loosen the Insert Fastening Screw and regulate the Inserts.
4. Saw blade has to run smoothly in Saw Guide Holder and wheels before sawing and cutting.
5. Loosen the Fastening Screw of Support Bar and Back Up Support both upper and lower for replacement of wider or narrower saw blade. Adjust Support Bar forward or backward to the suitable position. Fasten the screw again.

POST

1. Post functions to support saw blade. Thus the tension of saw blade is kept regularly no matter the thickness of working piece.
2. Loosen Post Holder Screw to adjust its position according to the thickness of working piece.
3. After the position is fixed, lock the Post Holder Screw.

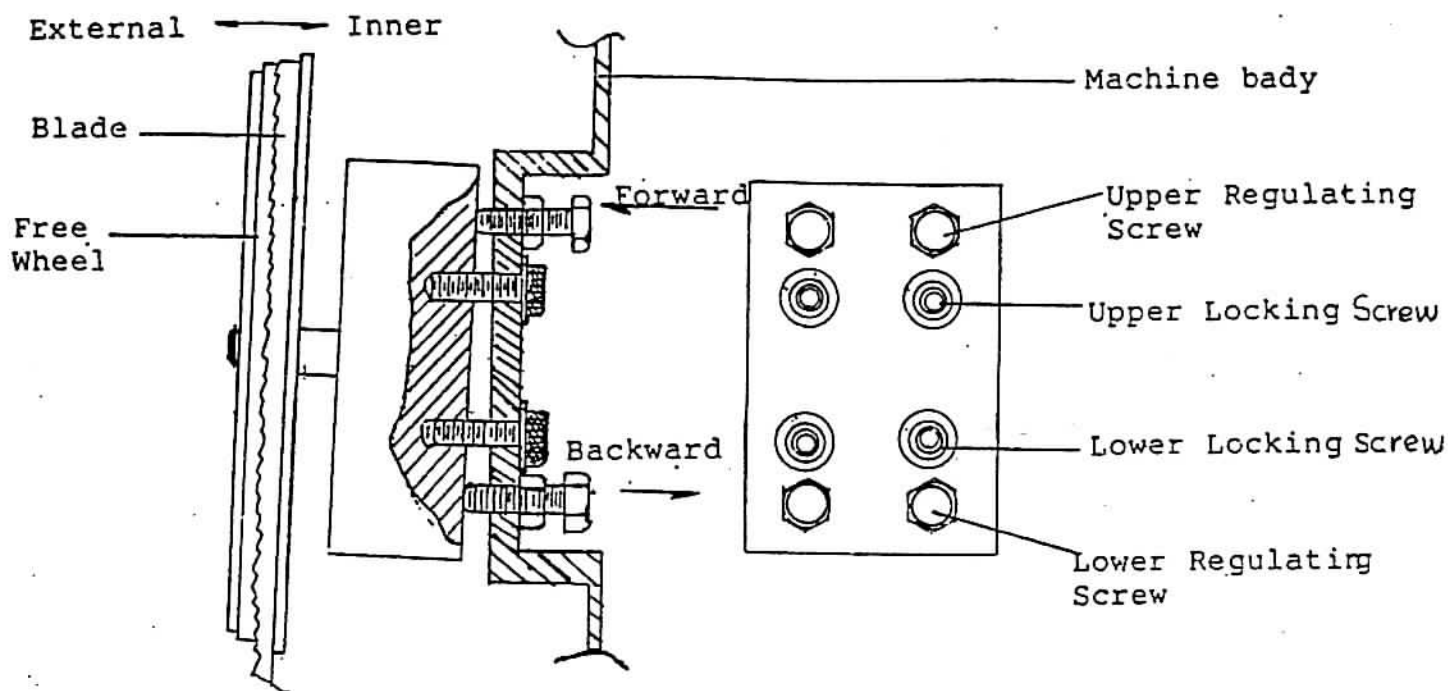
BLADE TRACKING

The blade wheels (free and idle wheels) have been adjusted at the factory. It is not always necessary to re-adjust blade tracking when using different size saw blades.

1. Push "START" button and observe that the blade rub just touches the flange of the blade wheel, If not, the free wheel must be adjusted.
2. The free wheel tilt adjustment is located on the back side of saw head. Loosen the four Upper and Lower Locking Screws, clockwise rotation of the Lower Regulating Screws cause the saw blade to run toward the blade wheel face. When correct tracking has been established, tighten the four Lock Screws.
3. If during running saw blade operation, the saw blade runs in

gradually, and thus causes noise when the blade rub with flange of blade wheel, stop the running. Loosen the four Upper and Lower Locking Screws. Release the nuts of Upper Locking Screws and drive the screw clockwise. When the Upper Regulating Screws move forward for a few paces, lock other screws and nuts.

- 4.. If your machine is KV-60 or KV-100, adjust the idle wheel accordingly.
5. Close the door of case.



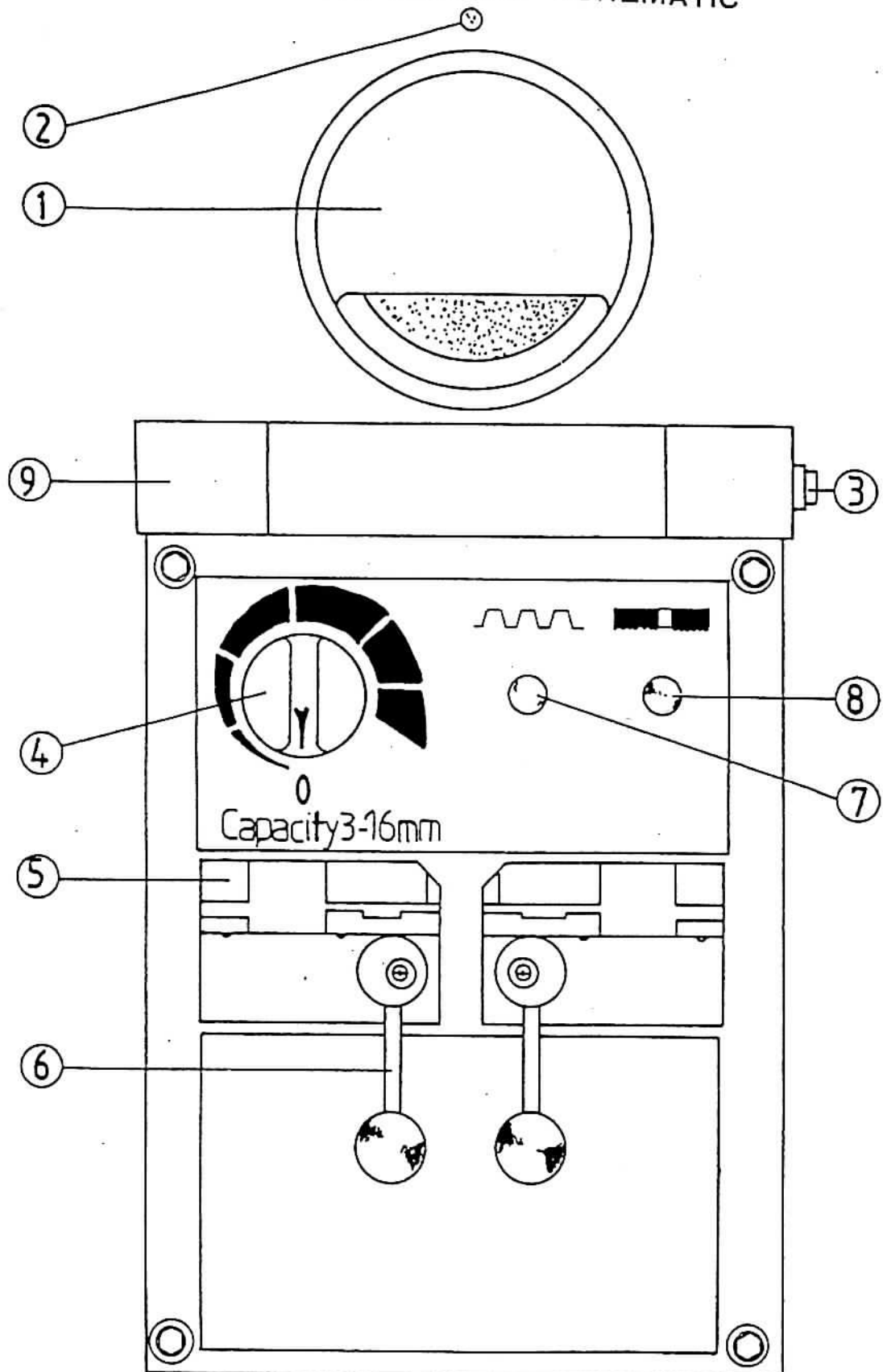
WELDING BLADES

Your machine is equipped with a resistance butt welder (See the figure in next page), with blade shear and grinder. The blade shear is provided for cutting blade to proper length and for cutting ends of blade square.

The blade grinder is used to grind flash from the welding and obtain proper thickness of the blade at welding.

To understand how to weld correctly you must understand how the welder operates.

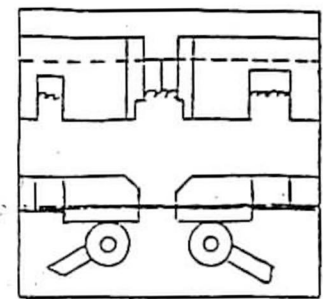
BUTT WELDER SCHEMATIC



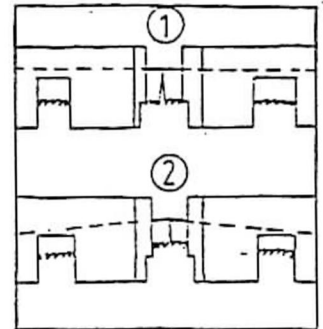
INDEX NO.	DESCRIPTION	INDEX NO.	DESCRIPTION
1	GRINDER	6	JAW CLAMPING HANDLES
2	GRINDER PILOT LIGHT	7	ANNEALING PUSH BUTTON
3	WELDING LIGHT SWITCH	8	WELDING PUSH BUTTON
4	UPSET FORCE SELECTOR	9	LAMP SHADE
5	BLADE JAWS		

WELDING OPERATION

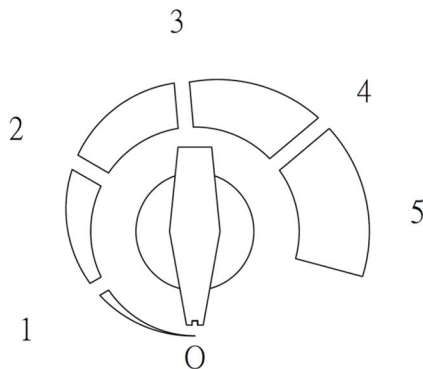
1. Clean the welder pole jaws.
2. Cut blade to proper length.
3. Be sure ends to be welded are square.
(See figure in right)
4. Set the "Upset Force Selector" at "0".
5. Align and fix both ends of saw blade between both electrodes which are at the center of two pole jaws.
6. Adjust the "Upset Force Selector" to proper position according to the width of saw blade. (The relative position which the width of saw blade is equivalent to the sign.)



CORRECT WAY



INCORRECT WAY



ITEM	BLADE WELDING PRESSURE ADJUSTMENT
1	Section 0-1 for blade width of 3-6mm
2	Section 1-2 for blade width of 6-8mm
3	Section 2-3 for blade width of 8-10mm
4	Section 3-4 for blade width of 13-16mm
5	Section 4-5 for blade width of 16-20mm
7	Temper Button
8	Welding Button

CAUTION

DO NOT OPERATE

WITHOUT EYE PROTECTION

7. Push the upper right Welding Button. Never release until the fire is extinguished and circuit broken.
8. Loosen the saw blade and return the "Upset Force Selector" to "0".

ANNEALING OPERATION

1. When the welding is finished, saw blade should be locked again to the front wide part of pole jaws. At this time, annealing should be situated at the intermediate position of pole jaws.
2. Push the Annealing Push Button, release it until the saw blade turn into orange color (750°C-780°C). Repeat the process 2-3 times.
3. After annealing, the saw blade must be dressed to remove excess metal or flash from the weld, Grind the welded area to the same thickness as the rest of saw blade.

4. Again welded blade is locked to pole jaw, annealing should be repeated by the same way as article 2. But in this case it must be operated at little lower temperature than article 2 case.

SPECIAL CAUTION FOR OPERATION

1. This welder is designed for band saw blade welding only. It must not be used on non-ferrous metals.
2. Blade must be cleaned of all dirt, oil, scale and oxide before welding.
3. The pole jaws of the welder must be kept clean.
4. When the pole jaws are uneven, adjust, grinding or replace it with a new one is required. Never hammer it.
5. Turn off power supply when the grinding wheel is not employed.
6. Turn off the welding lamp during annealing in order to examine the change of colors of saw blade.

MAINTENANCE OF MACHINE

Open the rear cover and inspect the following parts every week.

NO. Inspecting Item

1. If the variable speed pulley runs freely?
2. If the air way of the air injection is blinded?
3. If the oil level of Reducer is too low?
4. If the grease is supplied at the shaft of variable speed pulley?

NO. Trouble-Shooting

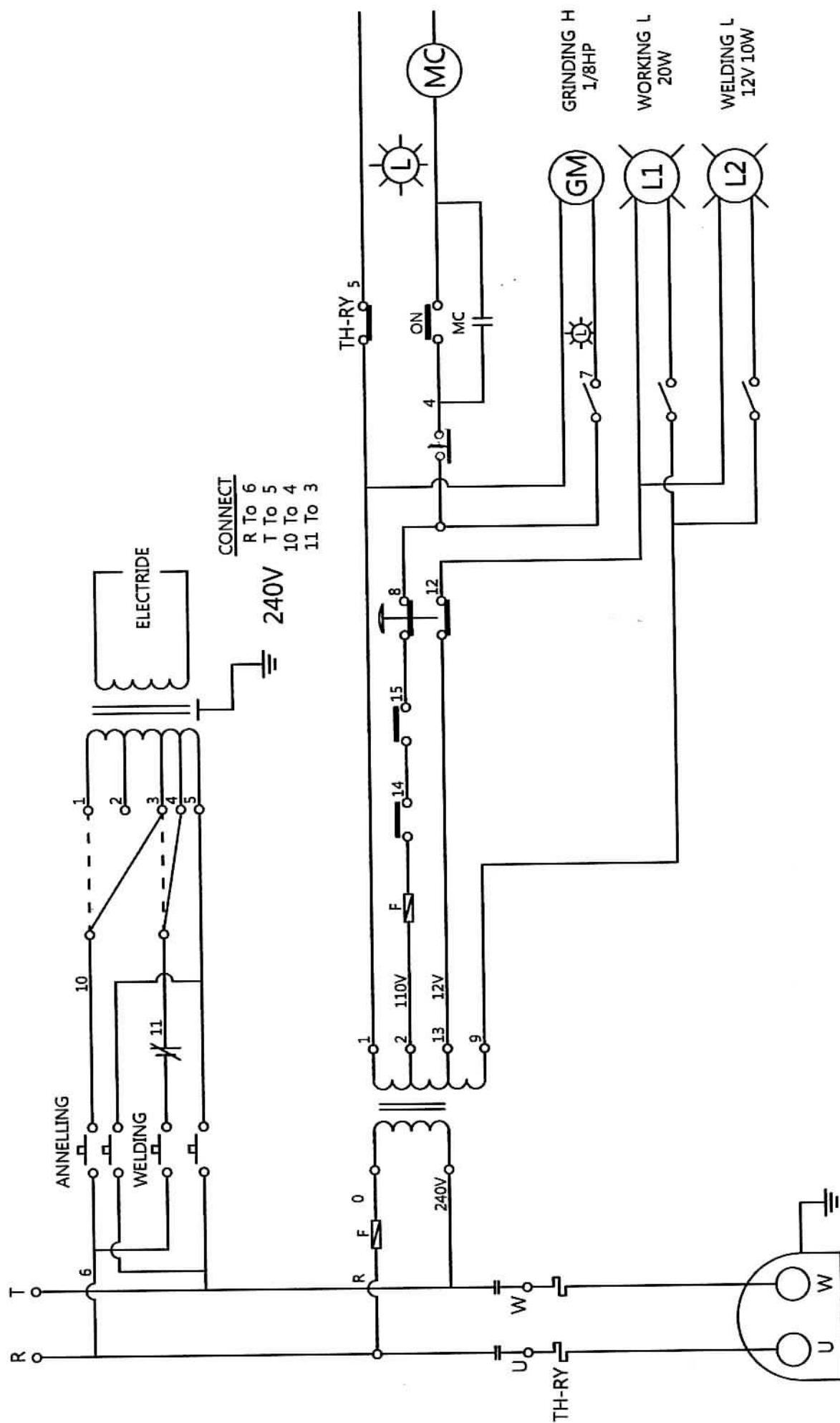
1. Please inspect and lock the screw of variable speed pulley. Little vibration and noise is normal.
2. Clear the blinding with an air compressor.
3. Replace or make up with "Shell Tellus Oil 69". It should be done that change the lubricate oil once in 6 months.
4. Apply grease (Shell Alvania Grease 2) with a grease gun until it shows up at the space between variable speed pulley and shaft.

STANDARD ACCESSORIES

1. Small Tool Set —

Grease Gun		1 pc.
Double Head Spanner	10 x 12	1 pc.
- do -	12 x 10	1 pc.
Screw Driver +		1 pc.
- do -	-	1 pc.
Soc. Hd. Screw Spanner	4mm	1 pc.
- do -	5mm	1 pc.
- do -	6mm	1 pc.
- do -	8mm	1 pc.
2. Saw Blade Ready For Use 1 pc.
3. Working Lamp 1 set
4. Low Voltage Control Circuits 1 set

240V.



415V

Diagram illustrating a 415V electrical system configuration, showing power distribution and control components.

Power Sources and Transformers:

- 415V Transformer (Primary: 415V, Secondary: 208V, 110V, 12V)
- 208V Transformer (Primary: 208V, Secondary: 110V, 12V)

Control and Protection Components:

- TH-RY 5 (Thermal Relay)
- MC (Motor Control)
- ON (On/Off Switch)
- MC (Motor Control)
- TH-RY 5 (Thermal Relay)
- TH-RY 5 (Thermal Relay)

Load Components:

- GRINDING H 1/8HP
- WORKING L 20W
- WELDING L 12V 10W
- GM (Generator Motor)
- L1 (Lamp)
- L2 (Lamp)

Wiring and Connections:

- Wiring connects the 415V supply to the 415V transformer primary.
- Wiring connects the 208V secondary to the 208V transformer primary.
- Wiring connects the 110V secondary to the 110V transformer primary.
- Wiring connects the 12V secondary to the 12V transformer primary.
- Wiring connects the 208V transformer secondary to the 208V transformer primary.
- Wiring connects the 110V transformer secondary to the 110V transformer primary.
- Wiring connects the 12V transformer secondary to the 12V transformer primary.
- Wiring connects the 415V transformer secondary to the 415V transformer primary.
- Wiring connects the 208V transformer secondary to the 208V transformer primary.
- Wiring connects the 110V transformer secondary to the 110V transformer primary.
- Wiring connects the 12V transformer secondary to the 12V transformer primary.

Terminal Connections:

- Terminal 1: R To 6
- Terminal 2: T To 5
- Terminal 3: 10 To 4
- Terminal 4: 11 To 3
- Terminal 5: 11 To 3
- Terminal 6: R To 6
- Terminal 7: T To 5
- Terminal 8: 10 To 4
- Terminal 9: 11 To 3
- Terminal 10: 11 To 3
- Terminal 11: 11 To 3
- Terminal 12: 11 To 3
- Terminal 13: 11 To 3
- Terminal 14: 11 To 3
- Terminal 15: 11 To 3

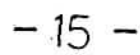
Wiring Diagram Details:

- The diagram shows a complex wiring arrangement connecting the power sources, transformers, control components, and load components.
- Key components include the 415V transformer, 208V transformer, TH-RY 5 thermal relay, MC motor control, ON switch, MC motor control, TH-RY 5 thermal relay, TH-RY 5 thermal relay, GRINDING H 1/8HP, WORKING L 20W, WELDING L 12V 10W, GM generator motor, L1 lamp, and L2 lamp.
- The diagram includes a table of connections for the transformer and a table of connections for the motor.

ELECTRICAL PARTS LIST

INDEX NO.	DESCRIPTION	UNIT'S PER. ASS'Y
E01	Transformer (welder) Capacity 2.4 KVA	1
E02	Transformer (control) Capacity 200VA	1
E03	Push Button Switch	1
E04	Grinder Motor 1/8 HP	1
E05	Working light 0W	1
E06	Welding light 5W	1
E07	Snap Switch	2
E08	One point switch for welding light	1
E09	Micro switch	3
E10	Blade Drive Motor (VB-300 1/2HP, KB-36,45 1HP)	1
E11	Grinder Lamp	1

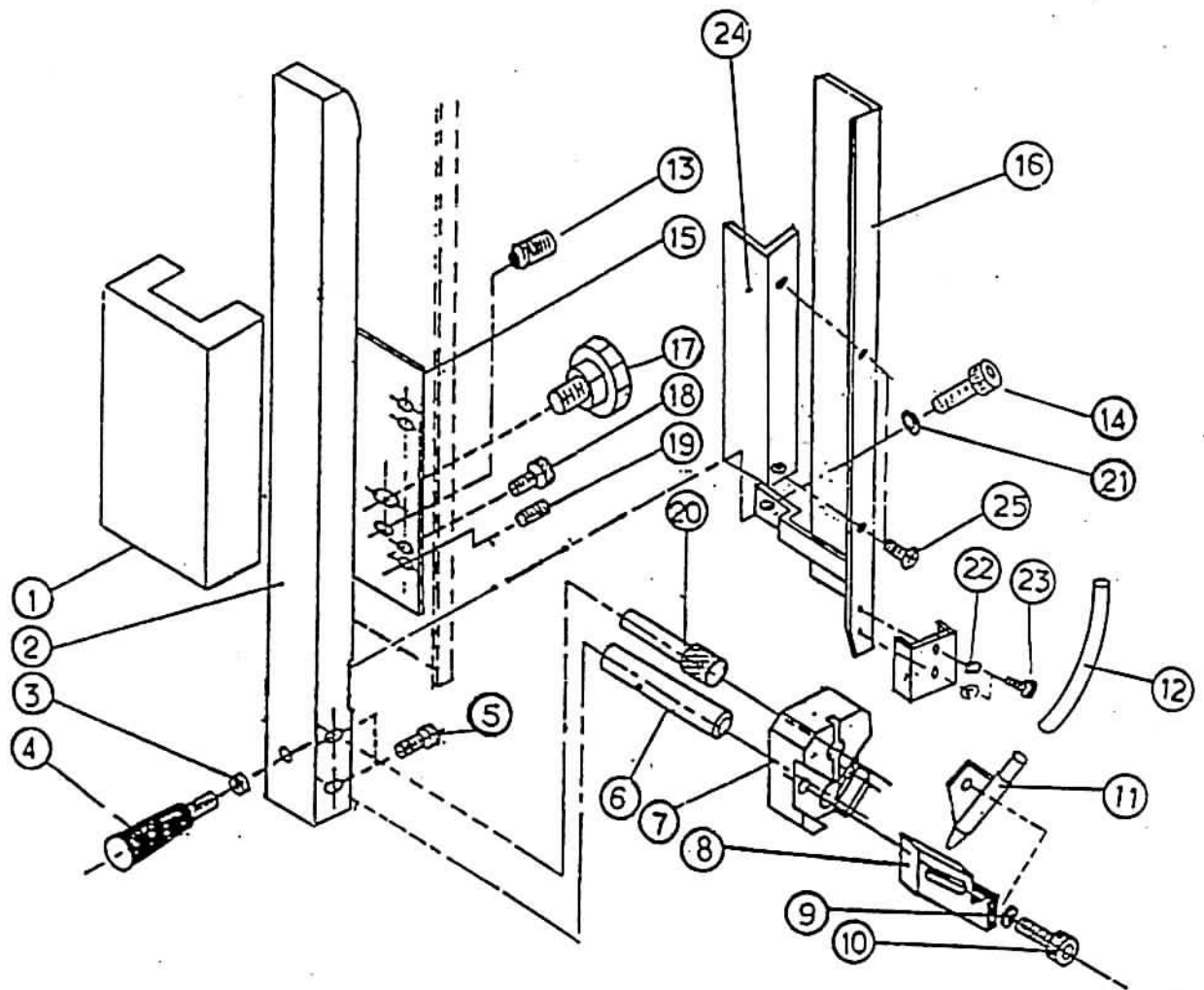
FREE WHEEL ASSEMBLY



FREE WHEEL ASSEMBLY

INDEX NO.	PARTS NO.	DESCRIPTION	Q'TY
1	(VB-300 ,450)	Rubber Tire	1
2		Bearing 6203ZZ	2
3		C-Snap Ring S-15	1
4	B-30301 (VB-300)	Free Wheel	1
	B-36301 (KB-36)		
	B-45301 (VB-450)		
5		Hex. Hd. Screw M8x1.25x20	10
6		Spring Washer 5/16"	10
7	B-36311	Plate	2
8	B-36306 (VB-300)	Sliding Block	1
	B-45304 (VB-450)		
9	B-36312	Plate	2
10	B-36305	Sliding Block Guide	1
11		Nut M8x1.25	4
12		Hex. Hd. Screw M8x1.25x30	4
13	B-36313	Sliding Block Guide Washer	4
14		Soc. Hd. Screw M8x1.25x30	4
15	B-36307 (VB-300)	Tension Screw	1
	B-45305 (VB-450)		
16	B-36310 (VB-300)	Spring	1
	V-40307 (VB-450)		
17		Handle	1
18		Lock Screw M8x1.25x10	1

POST AND UPPER SAWGUIDE ASSEMBLY



POST and UPPER SAWGUIDE ASSEMBLY

INDEX NO.	PARTS NO.	DESCRIPTION	Q'TY
1	B-36202 (VB-300) V-40202 (VB-450)	Post Guide	1
2	B-36201 (VB-300) V-40201 (VB-450)	Post	1
3		Spring Washer 5/16"	1
4		Handle	1
5		Socket Hd. Screw M6x15	2
6	B-36206 (VB-300) V-40207 (VB-450)	Back Up Support	1
7	B-36204 (VB-300) V-40204 (VB-450)	Upper Insert Holder	1
8	B-36205 (VB-300) V-40205 (VB-450)	Insert	2
9		Spring Washer 1/4"	2
10		Soc. Hd. Screw M6x20 (KB-30,36) M6x25 (KB-45)	2
11	B-36208	Nozzle	1
12		Hose	1
13		Steel Ball Adjust Screw	1
14	(VB-300) (VB-450)	Soc. Hd. Screw M6x1.0x12 Soc. Hd. Screw M6x1.0x12	1 2
15	B-36203 (VB-300) V-40203 (VB-450)	Post Guide Washer	1
16	B-36209 (VB-300) V-40209 (VB-450)	Protector Cover	1
17		Handle	1
18		Soc. Hd. Screw M6x30	4
19		Lock Screw M8x15	4
20	B-36207 (VB-300) V-40208 (VB-450)	Support Bar	1
21		Washer 1/4"	1
22		Washer 3/16"	2
23		Soc. Hd. Screw M5x0.8x8	2
24		Blade Cover	1
25		+Rd. Hd. Screw M5x0.8x8	2

TABLE and UNDER SAWGUIDE ASSEMBLY

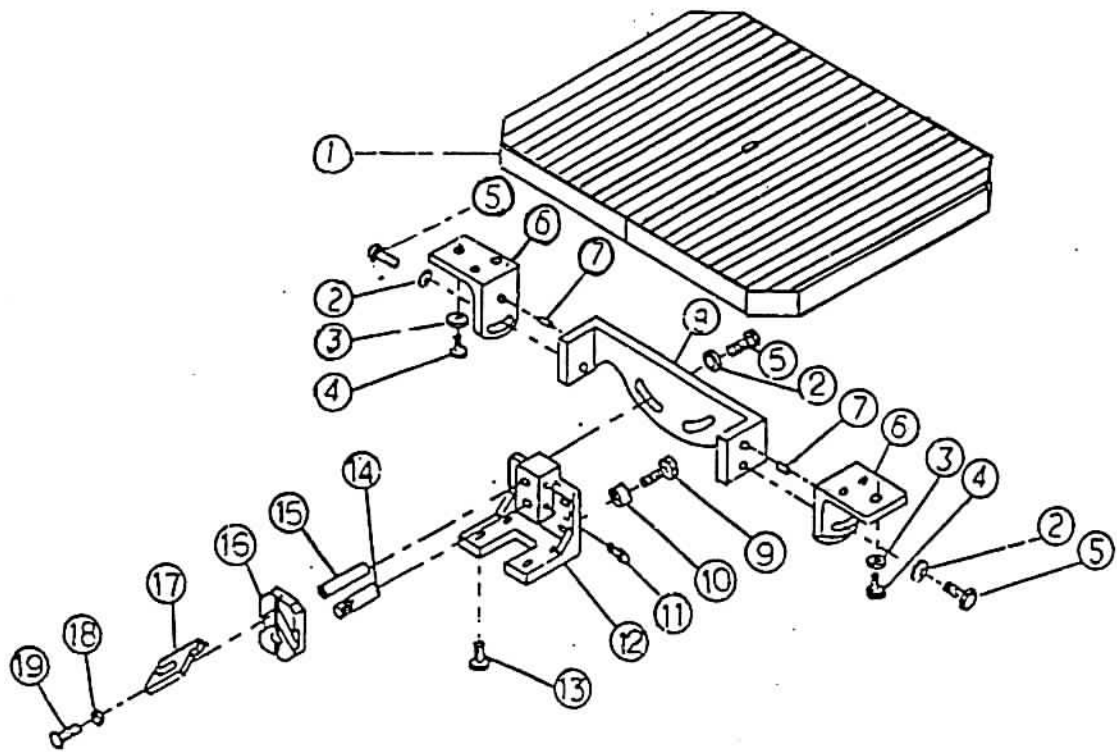
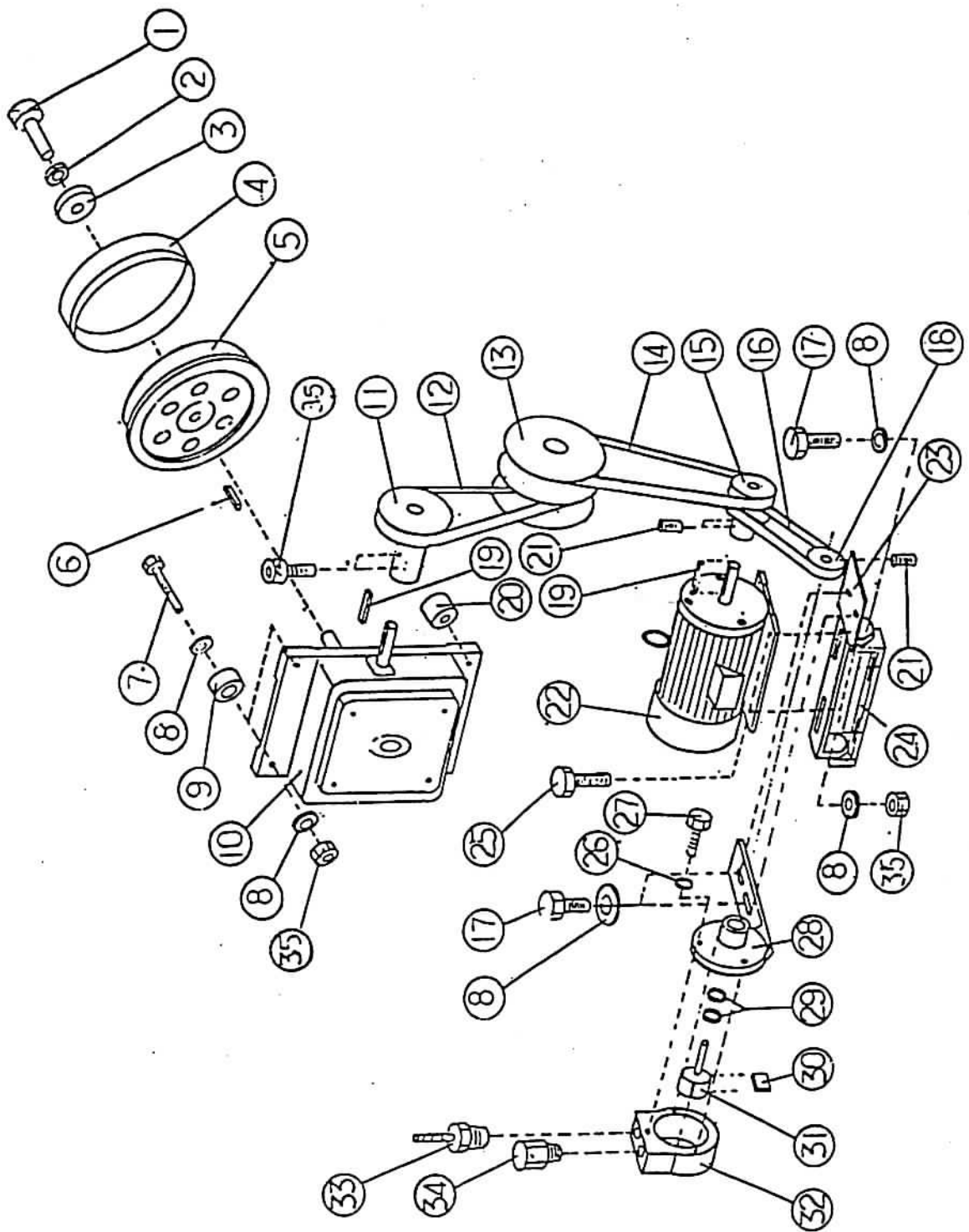


TABLE AND UNDER SAWGUIDE ASSEMBLY.

INDEX NO.	PARTS NO.	DESCRIPTION	Q'TY
1	B-36401 (VB-300)	TABLE	1
.	V-40401 (VB-450)	TABLE	1
2.	B-36409	WASHER	4
3.		WASHER 3/8"	4 (KB-45) 6PCS
4.		HEX.HD. SCREW M10x30	4 "
5.		HEX.HD.SCREW M10x50	4
6.	B-36402 /V-40402(VB-450)	BRACKET	2
7.	B-36407	PIN	2
8.	B-36403	BRACKET	1
9.	B-36405	SCREW	2
10.	B-36406	ROLLER	2
11.		SOC.HD.SCREW M6x25	2
12.	B-36404	TABLE BED	1
13.		HEX.HD.SCREW M10x25	4
14. (VB-300)	B-36207 /V-40208(VB-450)	SUPPORT BAR	1
15.	B-36206 /V-40207(VB-450)	BACK UP SUPPORT	1
16.	B-36204 /V-40205(VB-450)	UNDER INSERT HOLDER	1
17.	B-36205 /V-40206(VB-450)	INSERT	2
18.		SPRING WASHER 1/4"	2
19.		SOC.HD.SCREW M6x1.0x25	2

DRIVE ASSEMBLY



DRIVE ASSEMBLY

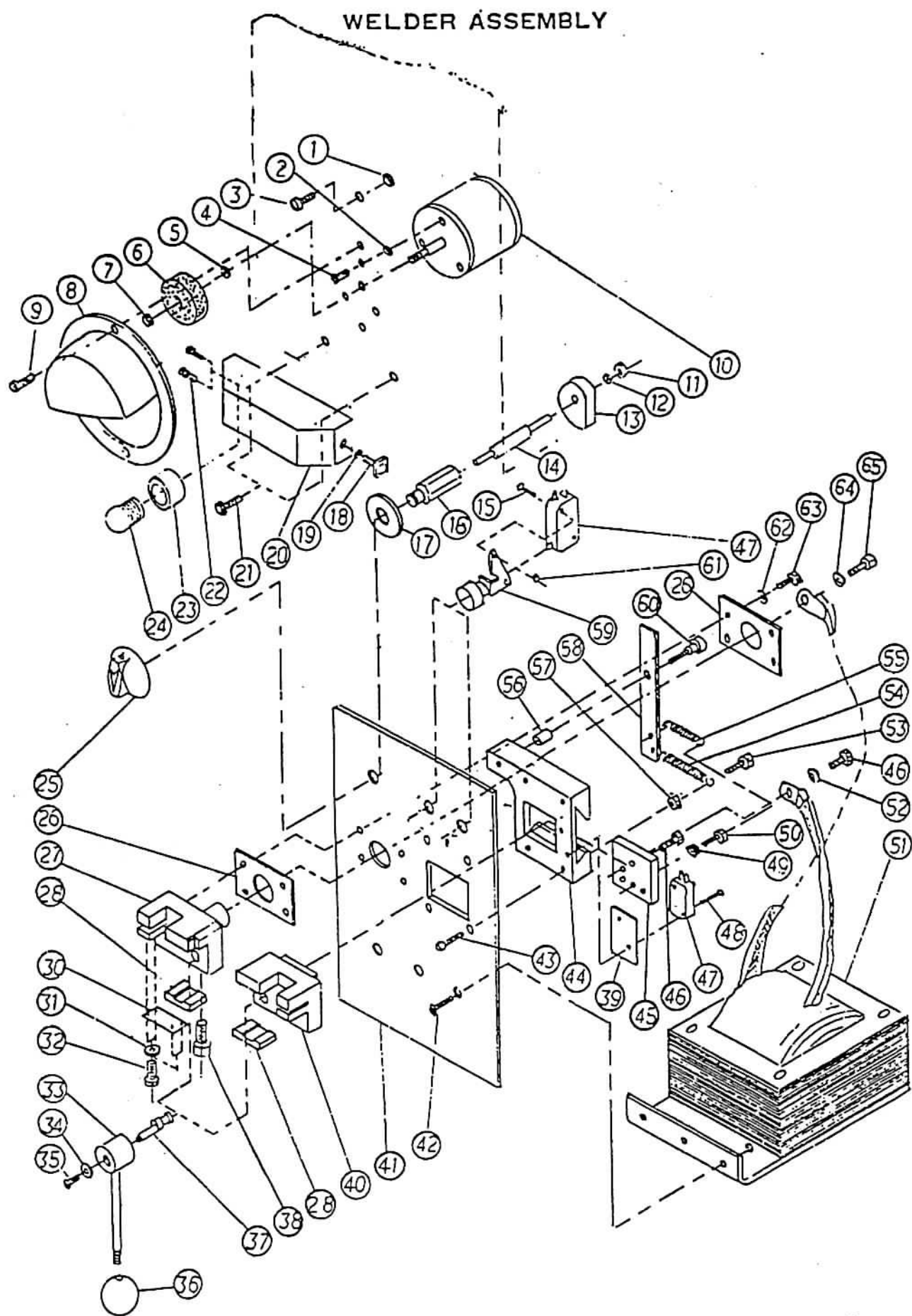
INDEX NO	PART NO	DESCRIPTION	Q'TY
1.		Socket Hd. screw M8x30	1
2.		Spring washer 3/8"	1
3.	B-36304	Spindle cover	1
4.	(VB-300)	Rubber	1
	(VB-36)		
	(VB-450)		
5.	B-30302(VB-300)	Drive wheel	1
	B-36302(KB-36)		
	B-45302(VB-450)		
6.		Key 7x7x25	1
7.		Hex, Hd screw M8x1.25x45	4
8.		Washer 3/8"	14
9.	B-36513-2(VB-300)	Reducer washer	2
	B-36513-3(VB-450)	Reducer washer	2
10.		Reducer	1
11.	B-36514 (VB-300)	Reducer pulley	1
12.	B-45517 (VB-450)	V-BELT A-29	1
13.		Variable speed pulley ass'y	1
14.	(VB-300)	V-BELT A-28	1
	(VB-450)	V-BELT A-29	1
15.	B-36516	Motor pulley	1
16.		V-BELT A-17	1
17.		Hex. Hd screw M8x1.25x20	4
18.	B-36601	Air induction pulley	1
19.		Key 5x5x35	1
20.	B-36513-1	Reducer washer	2
21.		Soc. Hd screw M8x1.25x10	3
22.	(VB-300)	Motor 1/2HP	1
	(VB-450)	Motor 1HP	
23.	B-36515-2	Air injection bracket	1
24.	B-36515-1	Motor bracket	2
25.		Hex. Hd screw M8x1.25x30	2
26.		Spring washer 1/4"	3

INDEX NO.	PART NO	DESCRIPTION	Q"TY
27.		Hex.Hd screw M6x1.0x25	3
28.	B-36602	Air injection seat	1
29.		Bearing 6201 ZZ	2
30.	B-36605	Air injection leaf	2
31.	B-36604	Air injection shaft	1
32.	B-36603	Air injection body	1
33.	B-36606	Air out put hose nipple screw	1
34.	B-36607	Air in put hose nipple screw	1
35.		Nut M8x1.25	6

VARIABLE SPEED PULLEY ASSEMBLY

INDEX NO.	PART NO.	DESCRIPTION	Q'TY
1	B-36501	FIXED FLANCE	2
2	B-36502	MOVABLE FLANCE	1
3	B-36511(VB-300)	SHAFT	1
	B-45511(VB-450)	SHAFT	1
4		OIL RING P-19	2
5	B-36518	COPPER SLEEVE SET	2
6	B-36503	BEARING SLEEVE	1
7		GREASE NIPPLE 1/8"PT	1
8		NUT M12x1.75	4
9		WASHER 1/2"	4
10		SPRING WASHER	2
11	B-36510	LEAD SCREW SLEEVE	1
12		NUT 5/8"-11NC	2
13	B-36509	VARIABLE SPEED SLIDING BLOCK	1
14		NUT 5/8"-18UNC	1
15	B-36507	KNUCKLE ARM	1
16	B-36508	VARIABLE FEED ROD	1
17		WASHER 3/8"	1
18		SOC.HD SCREW M8x1.25x15	1
19		PIN Ø3x21	1
20		SOC.HD SCREW M6x1.0x10	2
21		SOC.HD SCREW M8x1.25x20	1
22		HEX.HD SCREW M12x1.25x60	1
23		SPRING WASHER 1/2"	1
24	B-36506	SEAT	1
25	B-36505	LEAD SCREW	1
26		SOC.HD.SCREW M8x1.25x10	1
27		HANDLE WHEEL	1
28		HANDLE	1
29		HANDLE SHAFT	1
30		COPPER SLEEVE	2

WELDER ASSEMBLY

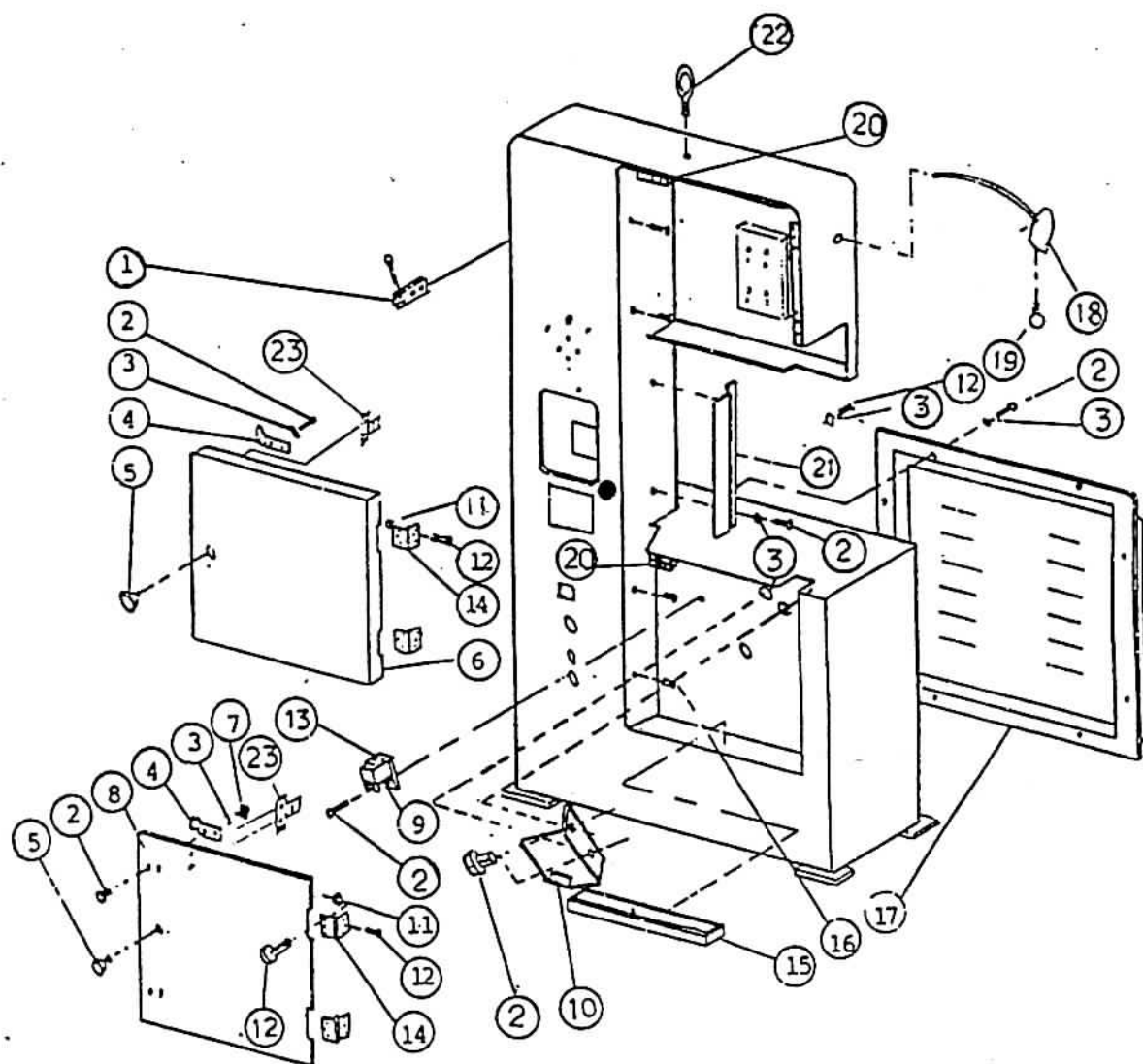


WELDER ASSEMBLY

INDEX NO.	PARTS NO.	DESCRIPTION	Q'TY
1		Nut M8 .	1
2		Washer 1/4"	4
3		Pilot Light	1
4		+ Round Hd. Scr. M6 x 1.0x15	4
5		Washer 5/16"	2
6		Grinding Wheel	1
7		Nut M6 x 1.0	1
8	B-36120	Protector Cover	1
9		+ Flat Hd. Screw M5 x 0.8x12	2
10		Grind Motor 1/8HP	1
11		Nut M.6 x 1.0	1
12		Spring Washer 1/4"	1
13	W-16115	Cam	1
14	W-16111	Shaft	1
15		+ Round Hd. Scr. M3 x 0.5x12	4
16	W-16116	Tube	1
17		Washer 1/2"	1
18		One Point Switch	1
19		Nut M12	1
20	W-16101	Lamp Shade	1
21		Hex. Hd. Screw M6 x 1.0 x 15	2
22		+ Round Hd. Scr. M3 x 0.5x10	2
23		Lamp Hd.	1
24		Lamp 5W 110V or 24V	1
25		Pressure Knob	1
26	W-16112	Insulating plate	2
27	W-16104	Fixed Pole Jaw	1
28	W-16107	Lower Fixed Block	2
30	W-16108	Connect Plate	2
31		Spring Washer 1/8"	8
32		+ Round Hd. Scr. M3 x 0.5x5	8
33	W-16109	Tight Handle (left)	1
	W-16110	Tight Handle (right)	1

34		Washer 3/16"	2
35		+ Round Hd. Scr. M4x0.7x10	2
36		Plastic Ball	2
37	W-16111	Eccentric shaft	2
38		Rd. Hd. Screw M5x0.8x10	2
39		Insulating Plate 20 x 35 x 0.5	1
40	W-16103	Slide Pole Jaw	1
41	W-16102	Pannel	1
42		+ Flat Hd. Scr. M6 x 1.0x8	3
43		+ Flat Hd. Scr. M6 x 1.0x10	4
44	W-16105	Slide Track	1
45	W-16106	Slide Block	1
46		Rd. Hd. Screw M6 x 1.0x10	4
47		Micro Switch V-1A	4
48		+ Round Hd. Scr. M3x0.5x15	2
49		Nut M6x1.0	1
50		Rd. Hd. Screw M6 x 1.0x15	1
51		Transformer 2.4KVA	1
52		Washer 1/4"	1
53		Rd. Hd. Screw M6 x 1.0x15	1
54		Tension Spring $\phi 1 \times \phi 10 \times 30$	1
55		Tension Spring $\phi 1 \times \phi 10 \times 20$	1
56	W-16120	Spacer	1
57		Nut M6	1
58	W-16118	Spring lever	1
59		Push Button Switch	2
60	W-16117	Screw	1
61		Nut M3 x 0.5	4
62		Washer 1/4"	4
63		RD. Hd. Screw M6 x 1.0x12	4
64		Washer 1/4"	1
65		RD. Hd. Screw M6 x 1.0x10	1

MACHINE BODY ASSEMBLY



MACHINE BODY ASSEMBLY

INDEX NO.	PARTS NO.	DESCRIPTION	Q'TY
1	B-36140	Blade Shear	1
2		+Rd. Hd. Scr. M6x1.0x10 (VB-450)	19
		-do- (VB-300)	17
3		Washer 1/4" (VB-450)	19
		-do- (VB-300)	17
4	B-36115	Snap Catch (VB-450)	4
		-do- (VB-300)	3
5		Holder	2
6	B-36111	Upper Door (KB-36)	1
	B-30111	(VB-300)	1
	B-45111	(VB-450)	1
7		Nut M6x1.0	4
8	B-30112	Lower Door (VB-300)	1
	B-36112	(KB-36)	1
	B-45112	(VB-450)	1
9		Chip Brush	1
10	B-36116	Chip Plate	2
11		Nut M6x1.0	12
12		+Rd. Hd. Screw M5x0.8x10	24
13	B-36117	Chip Brush Holder	1
14		Hinge (VB-300)	4
		(VB-450)	4
15	B-36118	Chip Box (VB-300, 450)	1
16		+Rd. Hd. Screw M4x0.7x10	4
17	B-30113	Rear Cover (VB-300)	1
	B-36113	(KB-36)	1
	B-45113	(VB-450)	1
18		Working Lamp	1
19		Lamp 60W 110V/24V	1
20		Safety Door Switch	1
21	B-36119	Blade Protection (VB-300)	1
	B-45119	Blade Protection (VB-450)	1
22		HANGER	1
23		Safety Door Switch Plate	1