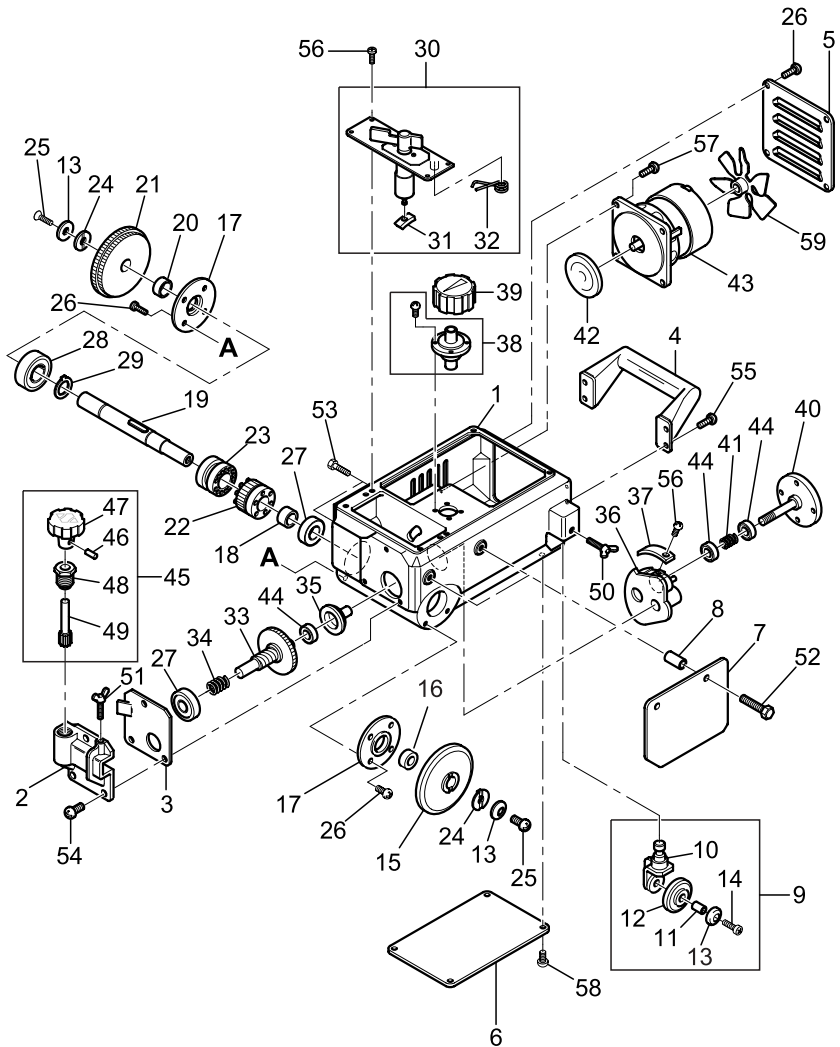


9 Parts list

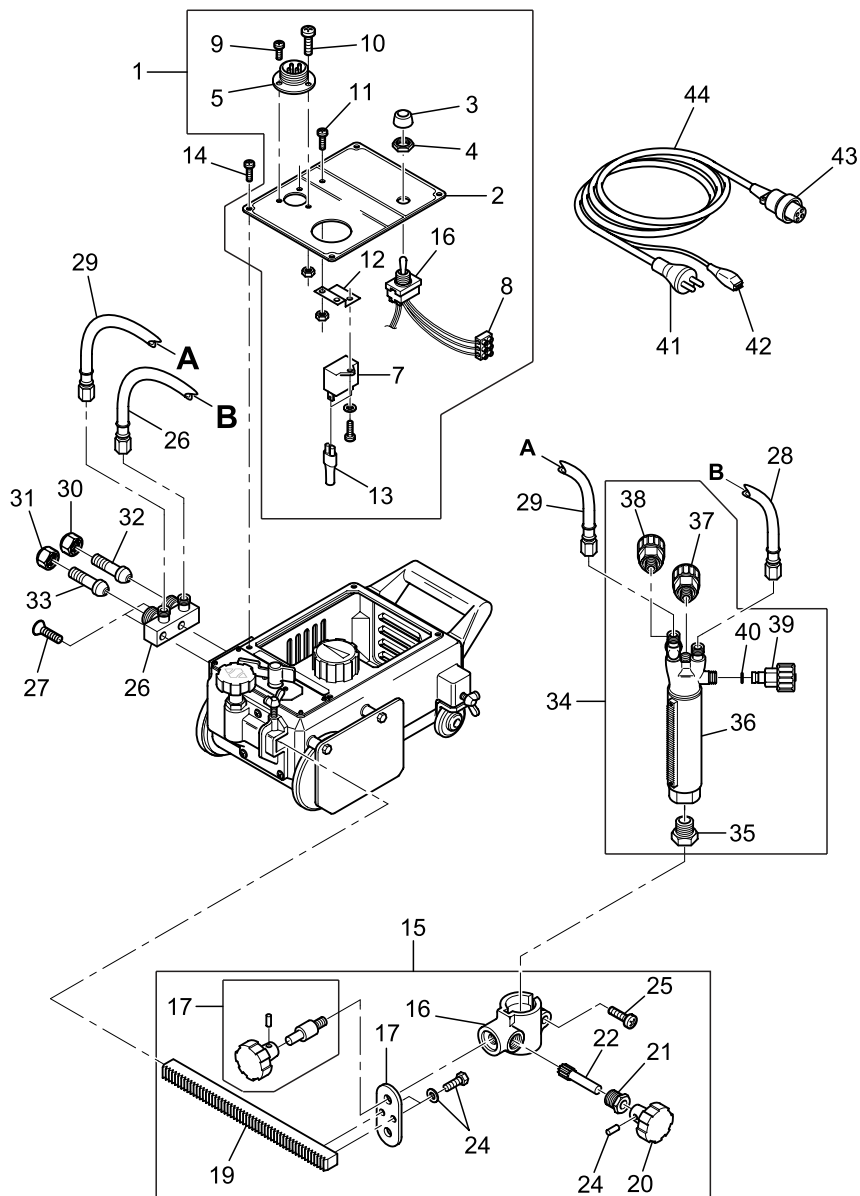
9.1 Main units



Main units				
Item no.	Description	Q'ty	Stock no.	Remarks
1	Case	1	31802	
2	Cross feed holder	1	31803	
3	Cross feed liner	1	31804	
4	Handle	1	31805	
5	Fan cover	1	31806	
6	Bottom plate	1	31807	
7	Heat shield	1	31808	
8	Heat shield collar	1	31809	
9	Idle wheel unit	1	31810	
10	Idle wheel bracket	1	31811	
11	Roller shaft	1	31812	
12	Roller	1	30213	
13	Washer	1	30814	
14	Screw	1	222.004.333	SM-5x25
15	Idle wheel	1	31813	
16	Collar (A)	1	31814	
17	Bearing retainer	2	31815	
18	Collar (B)	1	31816	
19	Drive wheel shaft	1	31817	with key
20	Collar (C)	1	31818	
21	Drive wheel	1	31819	
22	Worm wheel	1	30247	
23	Clutch	1	30246	
24	Washer	2	30242	
25	Screw	2	222.004.331	SM-5x15
26	Screw	12	222.004.719	SP-5x8
27	Bearing	2	31836	6300ZZ
28	Bearing	1	30819	6302ZZ
29	Stop ring	1	222.004.579	STW-15
30	Clutch lever assy.	1	31820	
31	Slider	1	30265	
32	Clutch spring	1	31821	
33	Worm shaft assy.	1	31822	
34	Worm spring	1	31823	
35	Speed adjusting shaft	1	31824	
36	Speed adjusting bracket	1	31825	
37	Rack	1	31826	
38	Speed adjusting handle	1	31827	
39	Speed adjusting knob	1	31828	

Main units				
Item no.	Description	Q'ty	Stock no.	Remarks
40	Speed adjusting cone assembly	1	31860	
41	Cone spring	1	31829	
42	Motor disk	1	31868	
43	Motor	1	31830	100V-120
	Motor	1	31832	200V-220
	Motor	1	31833	230V-240
	Motor	1	31831	42V
44	Bearing	3	30269	608ZZ
45	Cross feed pinion unit	1	31835	
46	Spring pin	1	222.004.591	PR-2,5x16
47	Handle (Ø 40)	1	30223	
48	Pinion metal	1	30318	
49	Pinion	1	30319	
50	Wing bolt	1	222.004.695	BS-6x15
51	Wing bolt	1	222.004.696	BS-6x25
52	Hexagon bolt	2	222.004.130	BH-6x30
53	Hexagon bolt	2	222.004.150	BH-6x18
54	Screw	3	222.004.788	SP-6x14
55	Screw	4	222.104.694	SP-5x15 with.spring washer
56	Screw	10	222.004.705	SP-4x10
57	Screw	4	222.004.739	SP-4x15
58	Screw	8	222.004.704	SP-4x8
59	Motor Fan	1	30289	with screw

9.2 Electrical, gas and torch slide holder units

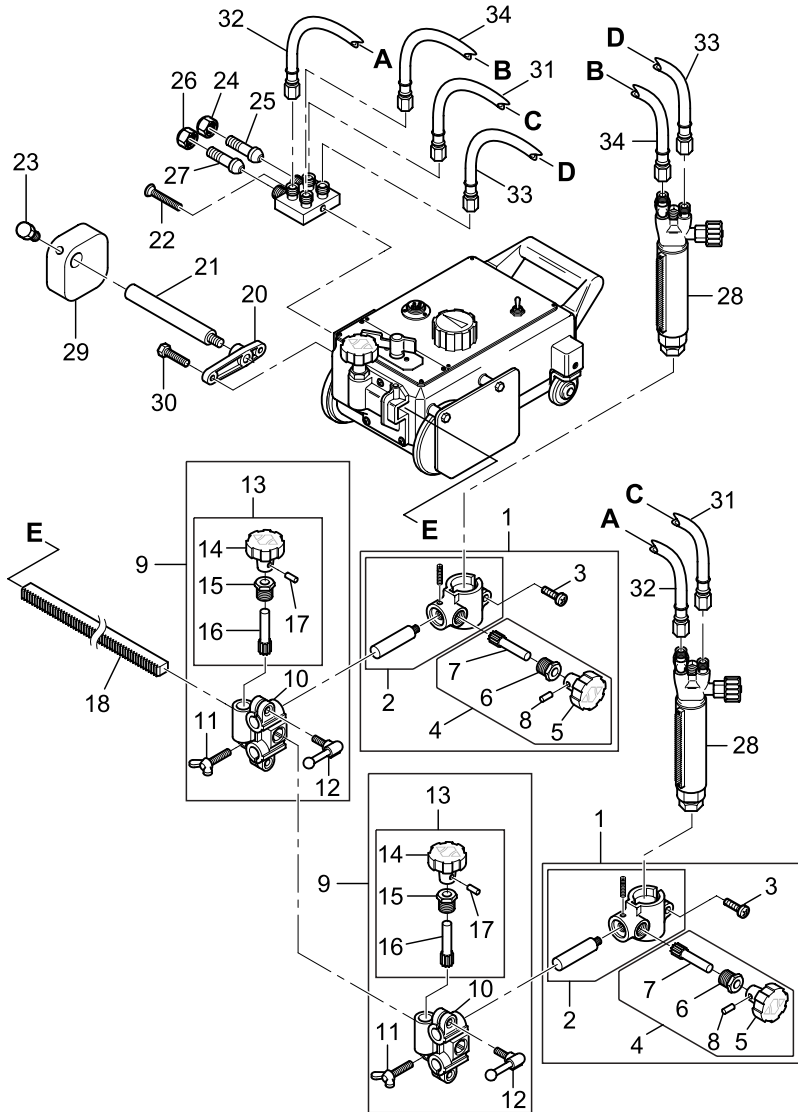


Electrical, gas and torch slide holder units

Item no.	Description	Q'ty	Stock no.	Remarks
1	Panel assembly	1	31894	100V-120V
	Panel assembly	1	31895	300V-240V
	Panel assembly	1	31898	42V
2	Panel	1	31837	
3	Cap for dust protector	1	32431	
4	Nut for dust protector	1	35017	
5	Metal socket	1	30273	3P
	Metal socket	1	30274	4P
6	Switch	1	30283	100V-120V
	Switch	1	31859	200V-240V-42V
7	Condenser	1	35207	100V
	Condenser	1	35208	120V
	Condenser	1	35219	200V-220V
	Condenser	1	35209	230V-240V
	Condenser	1	35210	42V
8	Terminal	1	31841	100V-120V 3P
	Terminal	1	30656	200V-240V 4P
9	Screw	2	222.004.327	SM-3x6
10	Screw	1	222.004.328	SM-3x8
	Nut	1	222.004.407	
11	Screw	2	222.004.702	SR-3x6
	Nut	2	222.004.407	
12	Condenser fixing plate	1	32389	
13	Terminal	2	35211	
14	Screw	4	222.004.704	SP-4x8
15	Torch holder assembly	1	31801	
16	Torch holder	1	31842	
17	Torch holder fixing plate	1	31843	
18	Holder fixing handle	1	31844	
19	Rack bar	1	31845	
20	Handle (Ø40)	1	30223	
21	Pinion metal	1	30909	
22	Pinion	1	30910	
23	Spring pin	1	222.004.591	PR-2,5x16
24	Hexagon bolt	2	222.104.696	SP-5x14 with WS
25	Screw	1	222.004.725	SP-6x25
26	Distributor	1	31873	
27	Screw	2	222.004.333	SM-5x25
28	Hose for oxygen	1	30305	
29	Hose for gas	1	30307	M-12x600

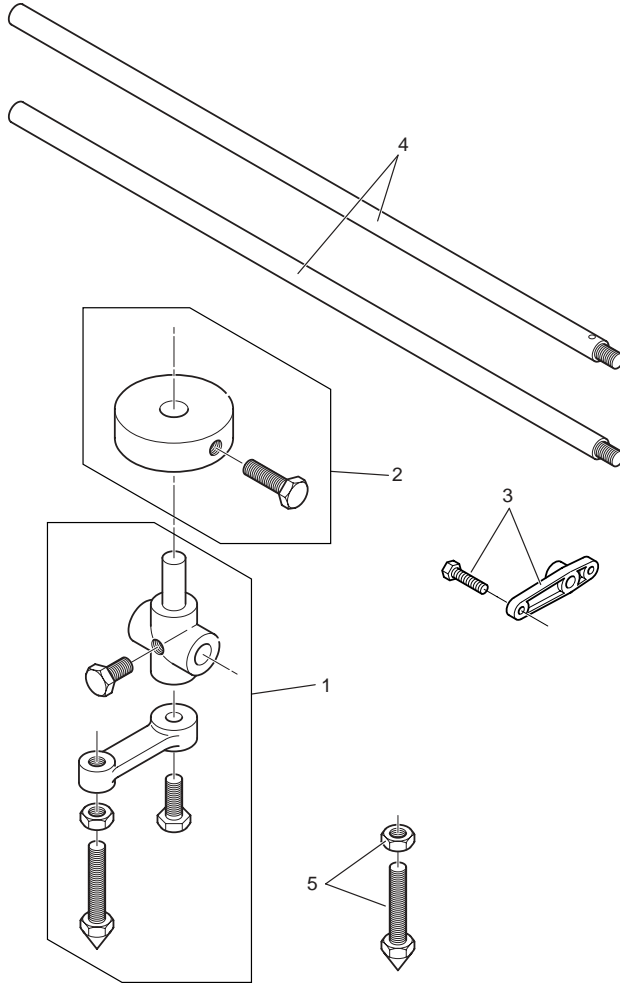
Electrical, gas and torch slide holder units				
Item no.	Description	Q'ty	Stock no.	Remarks
30	Nut for oxygen	1	15001	
	Nut for oxygen	1	15056	
31	Nut for gas	1	222.003.533	R3/8
32	Hose connector (ox)	1	222.003.582	
33	Hose connector (gas)	1	15004	
34	Torch	1	10055	
35	Tip fixing nut	1	05020	
36	Rack for Beetle	1	10056	
37	Valve for preheat oxygen	1	15358	
38	Valve for gas	1	15356	
39	Valve for jet oxygen	1	15401	
40	O-ring	1	05026	
41	Rubber plug	1	SV004	230V-240V
	Metal plug	1	31295	100V
43	Metal plug	1	30275	3P
	Metal plug	1	30276	4P
44	Cabtyre cord assembly	1	30201	110V 3P
	Cabtyre cord assembly	1	35201	4P

9.3 Two torch unit



Two torch unit				
Item no.	Description	Q'ty	Stock no.	Remarks
1	Torch holder	2	31848	
2	Torch holder	2	31856	
3	Screw	1	222.004.725	SP-6x25
4	Torch up/down handle	2	30908	
5	Handle Ø 40)	2	30223	
6	Pinion metal	2	30909	
7	Pinion	2	30910	
8	Spring pin	2	222.004.591	PR-2,x16
9	Torch cross feed holder	2	31849	
10	Cross feed holder	2	31857	
11	Wing bolt	2	31877	
12	Crank handle	2	30313	
13	Cross feed pinion unit	2	31835	
14	Handle (Ø 40)	2	30223	
15	Pinion metal	2	30318	
16	Pinion	2	30319	
17	Spring pin	2	222.004.591	PR-2,5x16
18	Rack bar	1	31850	
19	Distributor	1	31876	
20	Fitting	1	31854	
21	Weight supporter	1	31855	
22	Screw	2	222.004.334	SM-5x55
23	Hexagon bolt	1	222.004.124	BH-10x35
24	Nut for oxygen	1	222.003.533	
25	Hose connector (oxy)	1	222.003.582	
26	Nut for gas	1	15002	
27	Hose connector (gas)	1	15004	
28	Torch	2	10055	
29	Weight	1	30381	
30	Hexagon bolt	2	222.004.011	BH-6x40
31	Hose for oxygen	1	30324	
33	Hose for oxygen	1	30303	
	Hose for oxygen	1	30305	
34	Hose for gas	1	30307	M12x600 left

9.4 Circle cutting attachment



Circle cutting attachment

Item no.	Description	Q'ty	Stock no.	Remarks
1	Circle cutting arm ass'y	1	60030441	
2	Weight	1	60030381	
3	Fitting	1	60031854	
4	Bar	1	60030385	
5	Pivot pin	1	60030384	

9.5 Additional rail

Additional rail				
Item no.	Description	Q'ty	Stock no.	Remarks
1	Rail	1	60030400	1800 mm (Standard)

10 Cutting Data

102 HC (Standard Speed) for Acetylene

Plate thickness (mm)	Tip size	Cutting speed (mm/min)	Oxygen pressure (kg/cm ²)		Fuel gas pressure (kg/cm ²)	Kerf width (mm)
			Cutting	Preheat		
3	0	680	1.5	1.5	0.2	1
6	0	610	2	2	0.2	1.3
10	0	560	2	2	0.2	1.5
12.5	1	530	2.5	2.5	0.2	1.8
19	2	460	3	3	0.2	2
25	2	430	3	3	0.2	2
38	3	355	3	3	0.2	2.3

102-D7 (High Speed) for Acetylene

Plate thickness (mm)	Tip size	Cutting speed (mm/min)	Oxygen pressure (kg/cm ²)		Fuel gas pressure (kg/cm ²)	Kerf width (mm)
			Cutting	Preheat		
3	00	800	7	1.5	0.2	0.8
6	0	740	7	2	0.2	1
10	0	680	7	2	0.2	1
12.5	1	630	7	2.5	0.2	1
19	2	560	7	3	0.25	1.5
25	2	510	7	3	0.25	1.8
38	3	460	7	3	0.25	2

Note:

- 1 All pressures are torch inlet pressures
- 2 Oxygen purity is minimum of 99.7%, propane is minimum of JIS Grade 3.
- 3 Depending on the surface condition of the steel plate (scale, paint) either increase the fuel gas pressure or decrease cutting speed. Also, when precision cutting is required, adjust all data.

106 HC (Standard Speed) for Propane

Plate thickness (mm)	Tip size	Cutting speed (mm/min)	Oxygen pressure (kg/cm ²)		Fuel gas pressure (kg/cm ²)	Kerf width (mm)
			Cutting	Preheat		
3	00	680	1.5	1.5	0.2	1
6	0	610	2	2	0.2	1.3
10	0	560	2	2	0.2	1.5
12.5	1	530	2.5	2.5	0.2	1.8
19	2	460	3	3	0.25	2
25	2	430	3	3	0.25	2
38	3	355	3	3	0.25	2.3

106-D7 (High Speed) for Propane

Plate thickness (mm)	Tip size	Cutting speed (mm/min)	Oxygen pressure (kg/cm ²)		Fuel gas pressure (kg/cm ²)	Kerf width (mm)
			Cutting	Preheat		
3	00	800	7	1.5	0.2	0.8
6	0	740	7	2	0.2	1
10	0	680	7	2	0.2	1.3
12.5	1	630	7	2.5	0.2	1.3
19	2	560	7	3	0.2	1.5
25	2	510	7	3	0.2	1.8
38	3	460	7	3	0.2	2

Note:

- 1 All pressures are torch inlet pressures
- 2 Oxygen purity is minimum of 99.7%, propane is minimum of JIS Grade 3.
- 3 Depending on the surface condition of the steel plate (scale, paint) either increase the fuel gas pressure or decrease cutting speed. Also, when precision cutting is required, adjust all data.