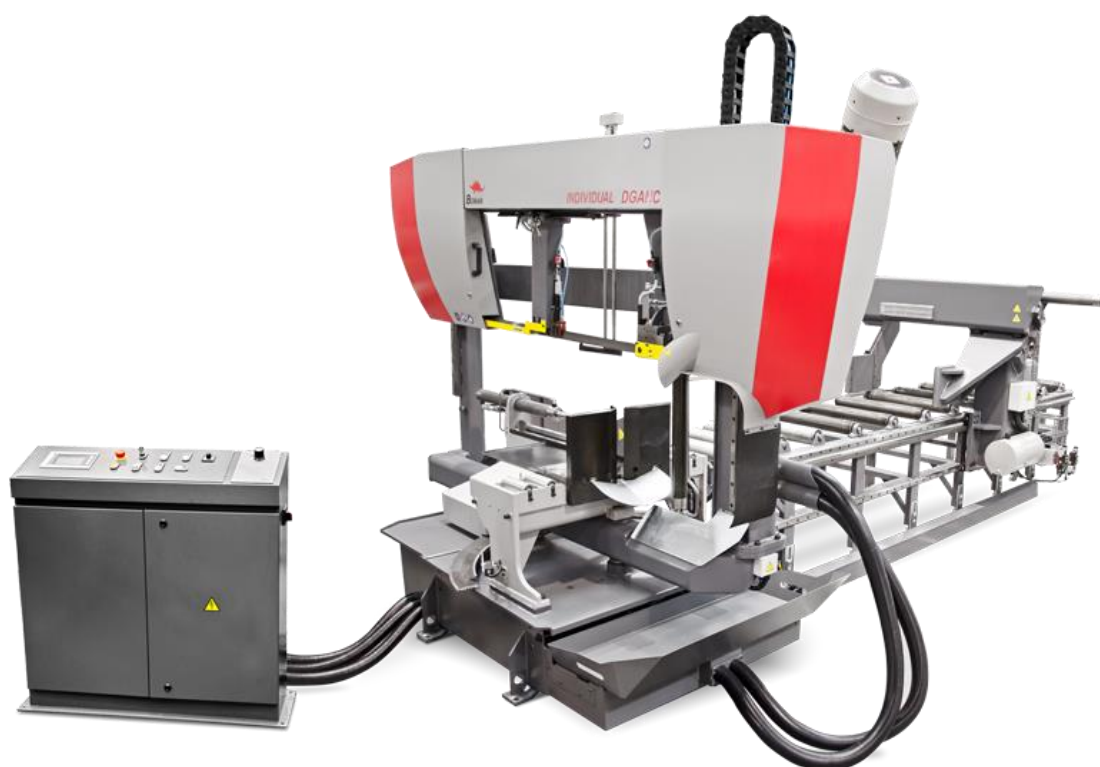




Individual 620.460 DGANC 2300

Operating instructions

Book 1

Before transporting and using the machine,
please read the instructions thoroughly!

Service and information

Your BOMAR dealer:

Direct BOMAR contact:

BOMAR spol. s r.o.
Těžební 1236/1
62700 Brno
Czech Republic, EU

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www: <http://www.bomar.cz>

We are available:

Mondays to Fridays

7⁰⁰ – 16⁰⁰

Version:

2.15 / Nov. 2022
rev. 1

BOMAR, spol. s r.o. © – Subject to modifications and amendments.

EC/EU Declaration of Conformity

1) 2) We:

BOMAR, spol. s r.o.

Těžební 1236/1

627 00 Brno, Czech Republic

Id. No: 48908827

declare herewith

that the following designated device based on its conception and construction as well as the design launched by us meets the relevant basic safety requirements of the decrees of the government.

This statement applies exclusively to the machine device in conditions in which it was brought to the market. It does not apply to parts subsequently added by the end user or to modifications performed subsequently by the end user.

In the event of any device modification not approved by us this declaration shall lose its validity

Name: **Band Saw**

Type : **Individual 620.460 DGANC**

Serial number: **0 – 10 000**

Manufacturer **BOMAR, spol. s r.o., Těžební 1236/1, 627 00 Brno**

Product data

Determination: for cross dividing and cutting of rolled and towed bars and profiles made of steel, stainless steel, non-ferrous metals and plastics

Description: Stand, table, cutting unit with the saw band and drive, clamping device, cooling system, el. switch board with control panel.

Pneumatic **NO** ☒ **YES** ☐ Hydraulic **NO** ☐ **YES** ☐ Control system **NO** ☐ **YES** ☒

Technical data: Cutting rate 20–120 m.min-1
Cutting angle -60° to 60°
Characteristic cutting range 620 x 460 mm

Documentation:

Technical documentation for this machine device was elaborated in compliance with Government regulation no. 176/2008, Annex 7, part A.

The device meets relevant requirements of the given directives: **2006/42/EC**

2014/30/EU

The applied harmonized standards, National standards and technical specifications:

ČSN EN ISO 12100:2011	ČSN EN ISO 16093:2018	ČSN EN ISO 13857:2021
+ Opr.1:2020 + Opr.2 :2021		
ČSN EN ISO 4413:2011		ČSN EN 60204 -1 ed.3:2019
ČSN EN 55011 ed.4:2017	ČSN EN 61000-6-2 ed.4:2019	ČSN EN 61000-6-4 ed.2:2007
+ A1: 2017+ A11:2020 + A2:2020		+ A1: 2011 + Z1:2011

The product is safe on condition of the common and determined usage.

The conformity judging was performed according to §12, art..3a), of the Law no. 22/1997 Coll. as amended.

BOMAR, spol. s r.o.
Těžební 1236/1, 627 00 Brno
Czech Republic
IČO: 48908827
DIČ: CZ48908827



Alfred Pichlmann, Managing Director

Brno, 14.7.2022

Point of issue, datum

Name and function of the responsible subject, signature

1) Name, address and identification number of the subject issuing the conformity declaration (producer of importer)

2) Person authorized to complete the technical documentation

!

If the equipment is installed without safety equipment offered by BOMAR, spol. s ro or its agents and used by the customer (or buyer) then EC declaration loses validity.
EC Declaration of conformity is valid only if customer (buyer) installed the BOMAR safety equipment with the machine or with some other with equivalent safety device in accordance with current applicable regulations and standards.
All machine elements and components that were built into the device by BOMAR, spol. s ro have been declared "identical" to a safety device, as offered by BOMAR, spol. s ro or its agents.

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This manual consists from two books.

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1. **Bezpečnostní pokyny / Sicherheitshinweise / Safety notes**

The operating instructions must be read by the person, who keeps in touch with the machine before transportation, installation, using, servicing, reparation, stocking or removal!

Attention!

The operating instructions must be available at the machine! Keep the operating instructions in good condition!

The operating instructions include relevant information. The operator must familiarise himself with the install and operation, safety notes and machine servicing, because reliability and service life must be reached. The operating instructions must avoid risks, which are linked to work on the machine. Before transporting and using of the machine, please read the instructions thoroughly!

1.1. Machine determination

The band saw **Individual 620.460 DGANC** is determined for cutting and shortening of rolled bars and drawn bars and profiles from steels, stainless steels, non-ferrous metals and plastics **with cutting angle from -60° to 60°**.

Combustible materials are excepted for cutting! Any other usage and operation outside this range are unauthorized and the manufacturer/supplier does not accept any responsibility for any damages resulting from such misuse. **The operator has full responsibility!**

The machine is equipped with safety and protective guarding for operator and machine protection. Nevertheless, this safety and protective guarding cannot prevent injury. Service personnel must read this chapter and comprehend it, before he starts to work on the machine. **Always keep instructions about work safety!** Service personnel must take into account other aspects of the risk, which refer to the ambient conditions and the material.

1.2. Protective suit and personal safety

Wear tight fitting overalls! Loose fitting clothes may be caught with machine parts and cause serious injury.

Wear protective gloves! Material cuts and saw band have sharp edges and may cause serious injuries.

Attention!

Gloves you can use only at working material replacement (saw band)! The machine and accessories must be inactive!

If the machine is running, you must not wear gloves! It is dangerous, because some parts of the machine can catch gloves!

Wear protective shoes with non-skid soles! The unsuitable shoes may cause balance loss and following injury. Falling work pieces may cause serious injuries too.

Wear protective goggles! Chips and cooling liquid may damage your eyes.

Always wear ear protections! Most of the machines emit up to 80 dB and may damage your hearing.

Do not wear jewellery and always tie back long hair! Moving machine parts can catch jewellery or loose hair and may cause serious injuries.

Operate the machine only when you are fit enough to work. Illnesses or injuries diminish concentration.

Avoid machine work, which may compromise the safety of you and your colleagues!

Attention!

Consider the safety signs on the machine. Do not remove or damage them! Keep these labels still

1.3. Safety notes for machine operator

Attention!

**Machine can be operated by person older than 18 years!
Machine can be operated only person physically and mentally fit for this activity**

Machine can be operated only by one person.

Machine operator is responsible for presence of other persons by the machine.

The person, which is controlling the machine using control equipments of the machine (control panel or another control equipment) mustn't oneself or with help of another persons manipulate with the machine or with the cutted or another way processed material.

**Keep instructions and orders about work safety!
Read the operating instructions, before you start to work on the machine! Keep the operating instructions in good condition!**

Close covers before the machine starting and check, if the covers are not damaged. Damaged covers must be repaired or changed. Do not start the machine, if the cover is removed! Check, if the electric cables are not damaged.

Attention!

Do not connect the machine to electricity if the door or any covers are removed. Do not touch the high voltage electrical equipment (transformers, motors, terminals

- Check that the power cables are not damaged.
- Do not hold the material for clamping to the vice and for cutting!
- Do not operate with the buttons and the switches on the control panel, when you have gloves!
- For machine starting take care, that there is nobody in the working area of the machine (it means in the working area of the vice, the saw band, the saw arm etc.).
- In no circumstances touch the rotating elements.
- Work on the machine only when the machine is in good condition!
- Check at least once in a shift, if the machine is not damaged. If the machine is damaged, you must bring the machine in order and you must inform your superior!

- Keep your working area clean!
- Ensure sufficient lighting in the working area.
- Take off the spilt water or the oil from the floor and dry it.
- Do not touch the cooling liquid with bare hands!
- Do not set the nozzle of the cooling liquid, when the machine is started on!
- Do not remove the chips from the working area of the machine, when the machine is started on!
- Do not use the compressed air for the machine cleaning or for the chips removing!
- Use the protective instruments for chips removal!

1.4. Safety notes for the servicing and repairs

Switch off the main switch and lock it, before you start service work! If you have the Practix type of machine, disconnect it from electrical network. This way you eliminate a possibility of starting the machine accidentally.

Take care when manipulating the frequency converter. It is still energized for 20 minutes after machine shutdown.

Always adhere to the safety instructions!

Only an authorized professional can carry out the servicing and repairs.

For parts replacement, use only those, which are identical with the originals. Otherwise, there is possibility of health hazard.

Use only recommended types of hydraulic oils, oils and lubricants!

Do not remove or lock the limit switches or any other safety equipment!

Attention!

Only a qualified professional can carry out the servicing and repairs of the electrical equipment! Take special care during the work with electrical equipment. High voltage shock can have fatal consequences! Always follow the work safety instructions! Otherwise, there is possibility of heavy injury!

Any use of the saw, accessories or machine parts other than that intended by BOMAR, spol. s r.o. company is not permitted. The guarantee on this product will be lost afterward and BOMAR, spol. s r.o. takes no responsibility for damage caused.

Do not turn the machine on if all covers are not in place

1.4.1. Safety notes for the servicing and repairs on hydraulic unit

Compliance with the principles of cleanliness is basic requirement for trouble-free operation of hydraulic equipment. Hydraulic components are products made with high accuracy, and any contamination leads to a reduction lifetime or even malfunction. The consequences are very difficult to remove and expensive.

Always use clean tools. Parts and fasteners, which are part of a hydraulic circuit, never put away the dirty surface. The best cleaning agent is crepe paper, because the fibers of the cleaning cloths can also cause malfunction.

Protective cap from the threaded chamber remove just before the assembly of the unit.

Hoses and pipes before mounting flush with gasoline or other cleaning agent and blow compressed air.

All fittings must be properly tightened. However, do not raw power.

1.5. Safety instructions for laser radiation sources

Laser radiation sources may be used on the machine.

Warning signs and information about the corresponding laser class are placed near each laser source.

It is forbidden to look into the laser beams!

Depending on the design and optional equipment of the saw, laser radiation sources can be located in particular:

- on the saw feeder
- before the main vice of the band saw
- on a safety fence (laser barrier)
- on the section line projection device



Commonly used laser safety classes:

1 (laser barriers)

1M (laser barriers)

3R (Laser-Liner)

Attention!

It is necessary for correct functionality of a laser to regularly check the patency of the laser ray on the sensor and to clean the laser from impurities (clean rag + spirit) after each shift. Be careful during the cleaning in order the laser was not been scratched and broken!.

1.6. Safety notes for Swarf conveyor (optional accessories)

Swarf conveyor is an optional accessory of the machine, this article is valid just for the machine which is equipped with this device.



When the machine is switched swarf conveyor only operate using the control panel (see Chapter 3. Machine control)

Attention!

It is forbidden to enter the swarf conveyor area if the saw is in operation. All maintenance and other works on the swarf conveyor could be done only on equipment which has been

1.7. Safety notes for the cooling

Attention!

- *When handling cooling agents always wear hazardous fluid-proof gloves!*
- *Wear protective goggles!*
- *Cooling liquid can get in contact with your eyes and may cause permanent severe injuries*

1.7.1. Instructions for first help

1. Pull off and safely remove polluted, soaked clothing.
2. For breathing, go out in the fresh air or look for first aid treatment.
3. Wash with water or use crèmes for contact with the skin.
4. Flush with water for eyes and look for first aid treatment.
5. For swallowing, drink a lot of water and induce vomiting. Look for medical help.

1.8. Safety machine accessories

Enhanced risk!

*Do not come into or intervene in the cutting area.
Otherwise, there is possibility of heavy injury.*

The machine is equipped with safety accessories. It protects the operator from injuries and the machine before damage. The safety accessories are blocking accessories, emergency switches and covers. Check once in a week the function of the safety accessories. If the safety accessories are functionless, you must stop work and repair or change the safety accessories.

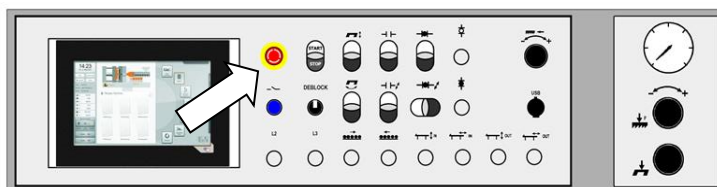
1.8.1. Emergency Stop Switch

Emergency Stop Switch is used for emergency switching – off the machine in case defect or health hazard. By pressing **Emergency Stop Switch** will immediately stop all dangerous machine movements.

If any damages or fault appears, immediately press **Emergency Stop Switch**!

It is possible to release the pressed button by twisting of the upper part of the button.

The **Emergency Stop Switch** is placed at the control panel of the machine.



1.8.2. Protected space around saw - Protective fencing

The protective fencing prevents persons from entry and intervention in the device working area during the working cycle.

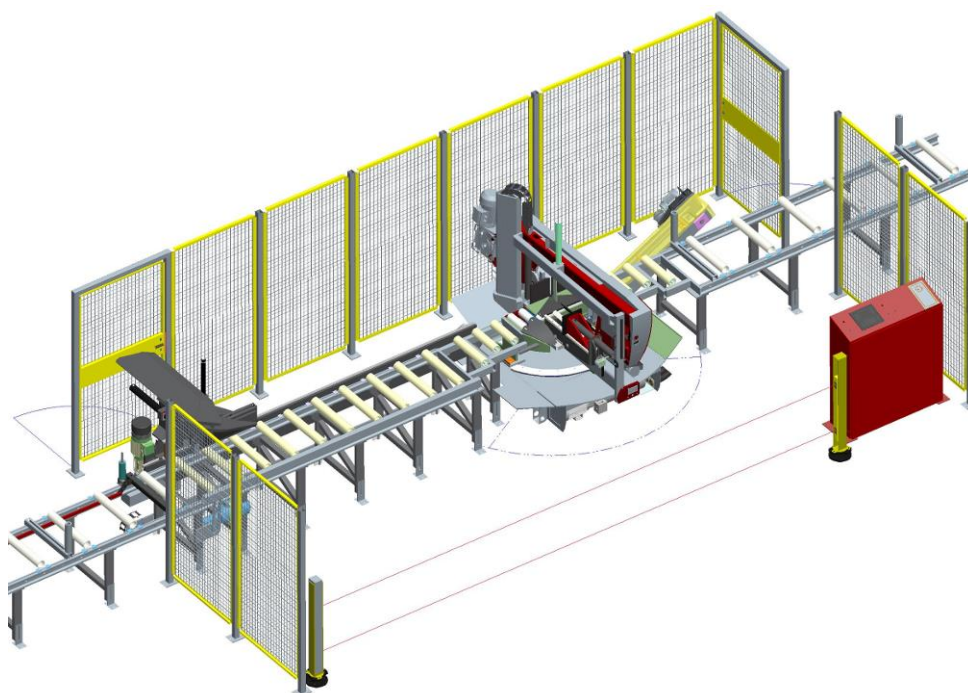
Caution!

The equipment operation can only be safe with the safety protective fencing according to EN ISO 13857!

Do not put the equipment in operation without the safety fencing according to EN ISO 13857!

If the equipment is operated without the safety fencing according to EN ISO 13857, the submitted EC Declaration of Conformity expires!

Proposal of the safety fence



Machinery space should be protected by a fence to a height of 2000 mm. + laser barrier.

1.8.3. Arm covers

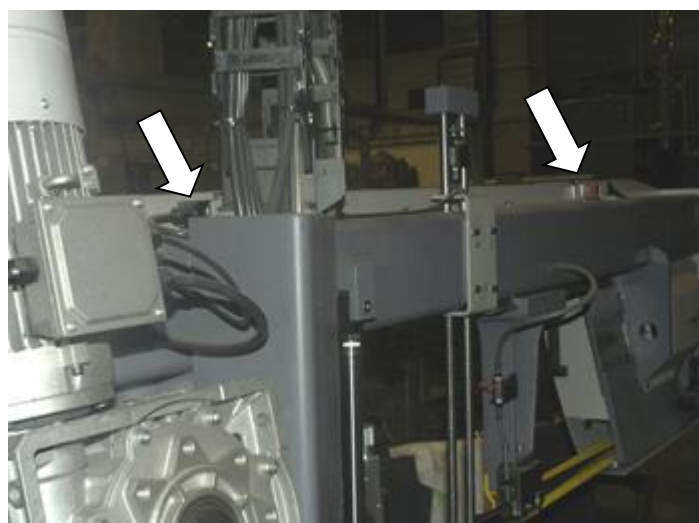
Left cover – It covers tightening wheel. If the cover is opened during operation, the limit switch is opened and the band saw is stopped. The band saw is not possible start in set mode.

Right cover – It covers driving wheel. If the cover is opened during operation, the limit switch is opened and the band saw is stopped. The band saw is not possible start in set mode.

Central cover – It covers band saw.



The band saw is stated to the operation, when the covers is closed!

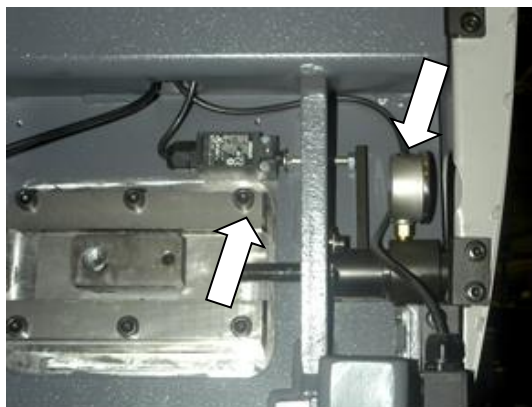


Two limit switches on saw arm control if covers are open or not.

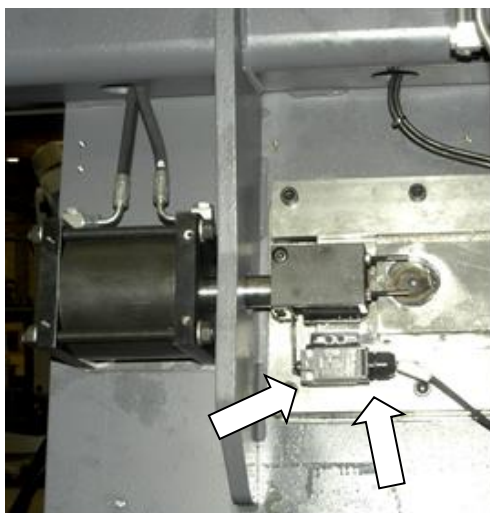
1.8.4. Saw band stretching and rupture inspection

This device checks the saw band stretching and causes immediate machine shut – down in the event the band ruptures.

Mechanical saw band tensioning



Hydraulical saw band tensioning



The device contains limit switch. Check the stretching carefully and periodically – eventually adjust.

1.8.5. Band saw covers

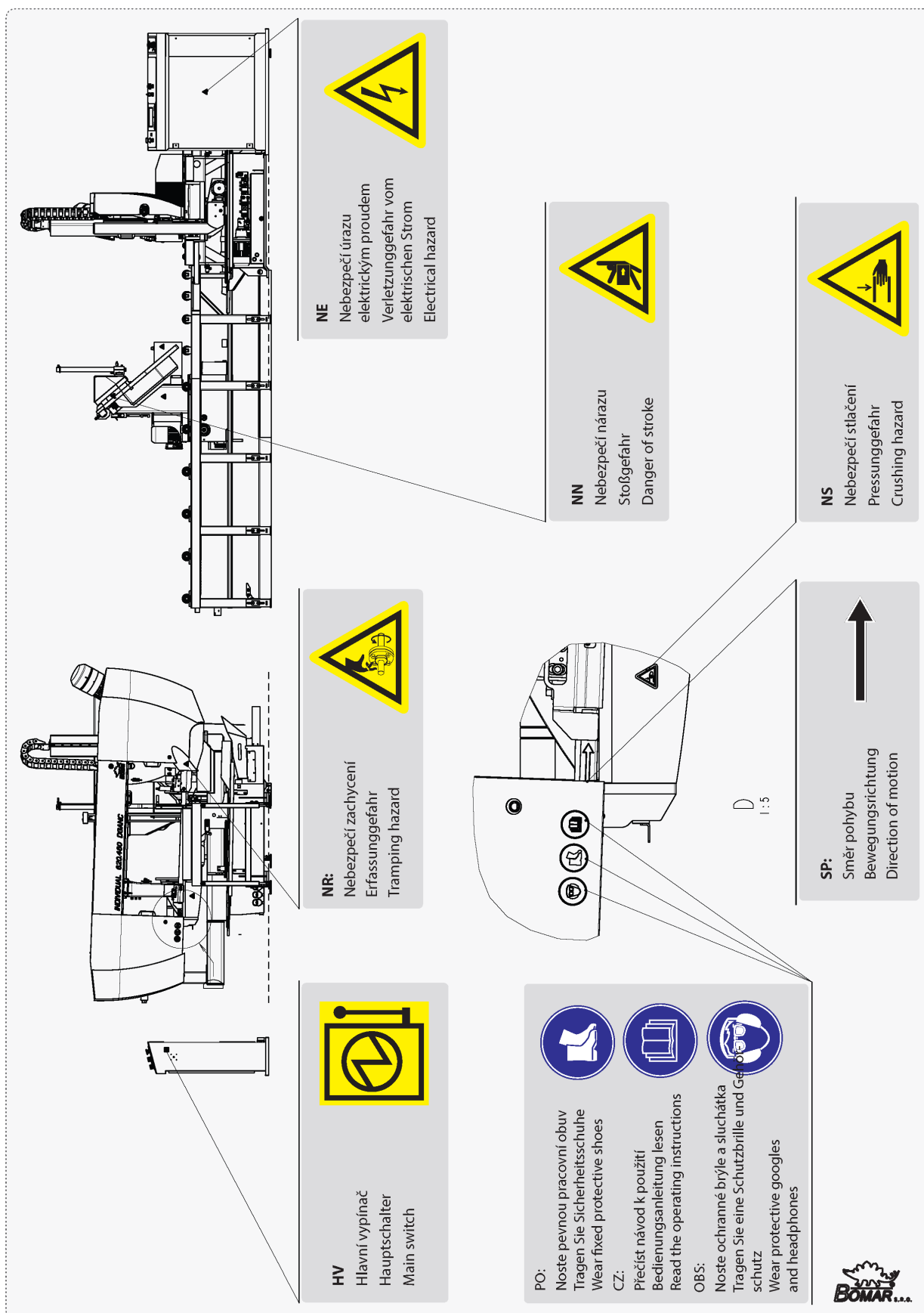
These covers protect the visible area of the saw band from guiding cubes to the frame.



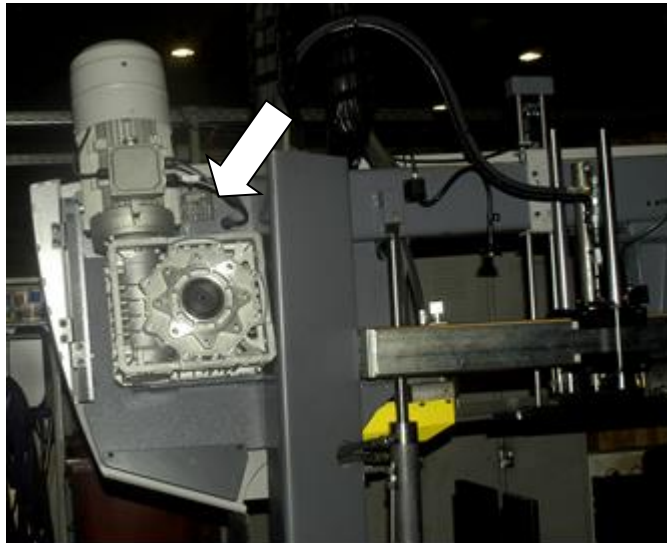


Never switch on the saw band driver if some from these covers is not mounted!

1.9. Umístění bezpečnostních značek / Verteilung der Sicherheitszeichen / Position of safety symbols



- 1.10. Umístění štítku stroje /
Maschinenschild position /
Position of machine label



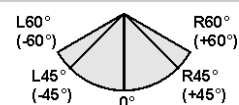
The saw label is located on the arm of the saw, between the column and the belt drive.

2. **Dokumentace stroje / Documentation der Maschinen / Machine documentation**

2.1. Technická data / Technische Daten / Technical data

Hmotnost stroje / Maschinengewicht / Machine weight:	
• Hmotnost / Gewicht / Weight	3100 kg
Rozměry stroje / Maschinengröße / Machine size :	
• Délka / Länge / Length	5100 mm
• Šířka / Breite / Width	3000 mm
• Výška / Höhe / Height	2350 mm
Elektrické vybavení / Elektrische Ausrüstung / Electrical equipment:	
• Napájení / Versorgungsspannung / Supply voltage	~3× 400 V / 50 Hz, TN-S
• Příkon / Gesamtschlosswert / Total Input	7 kW
• Max. jistění / Max. Vorschaltssicherung / Max. Fuse	25 A
• Krytí / Schutzart / Protection	IP 54
Akustický tlak / Schalldruckpegel / Acoustic pressure:	
• Individual 620.460 DGANC	$L_{Aeq} = 76,3$ dB
Pohon – pilový pás / Atrieb – Sägeband / Drive – saw band:	
• Typ / Typ / Type	1LA7113-4AA11 IE2, 4P, B5, Vel. 112 91.001.117
• Napájení / Versorgungsspannung / Supply voltage	~ 3×400 V, 50 Hz
• Výkon / Leistung / Output	4 kW
• Jmenovité otáčky / Motornenndrehzahl / Nominal speed	1420 m.min ⁻¹
Pohon – podavač / Atrieb – Vorschub / Drive – feeder:	
• Typ / Typ / Type	G500-B240, 4P, Vel. 80
• Napájení / Versorgungsspannung / Supply voltage	99.003.014
převodovka s motorem / Getriebe mit Motor / Gearbox with engine	~ 3×400 V, 50 Hz
• Výkon / Leistung / Output	1,1 kW
• Jmenovité otáčky / Motornenndrehzahl / Nominal speed	1420 m.min ⁻¹
Hydraulické zařízení / Hydraulikeinrichtung / Hydraulic equipment:	
Pásová pila / Bandsäge / Band saw	92.001.077 (FMW)
• Typ / Typ / Type	S001-137-2, PPM-ACO, 48/0, 6kW/300/1500- PG1/2,5-TM20-CB03-FR
• Výkon / Leistung / Output	0,48 / 0,6 kW
• Tlak / Druck / Pressure	4,5 MPa
Podavač / Vorschub / Feeder:	92.001.072 (28486100)
• Typ / Typ / Type	SMA03-25/SP.0-S11.0-H15LS.0-xxx/02400
• Výkon / Leistung / Output	0,55/0,37 kW
• Tlak / Druck / Pressure	5 MPa
Chladicí zařízení / Kühlung / Cooling equipment:	
• Typ / Typ / Type	41POMPA70120 + 22FILTRO-PA 91.020.032
• Obsah nádrže / Volumen vom Kühlmittel / Capacity	35 dm ³
• MICRONISER	na přání / möglich / optional
Rozměr pásu / Sägebanddimension / Band size:	
	6100×41×1,3 mm
Řezná rychlost / Schnittgeschwindigkeit / Cutting speed:	
	20–120 m/min.
Jeden Zdvih / Vorschublänge Einfachhub / One Upstroak:	
	2300 mm
Max. Délka podání / Max. Vorschublänge / Max. feeding length:	
	9999 mm
Délka nejkratšího zbytku / Die Länge der kürzesten Rest / Length of shortest rest:	
	220 mm / 0°

Řezné rozsaHy / Schnittbereiche / Cutting size:



0°	Ø450 mm	620×450 mm	620×450 mm	450×450 mm
45° R	Ø420 mm	420×420 mm	410×450 mm	420×420 mm
45° L	Ø420 mm	440×300 mm	420×450 mm	420×420 mm
60° R	Ø275 mm	280×390 mm	270×450 mm	275×275 mm
60° L	Ø300 mm	300×450 mm	300×450 mm	300×300 mm

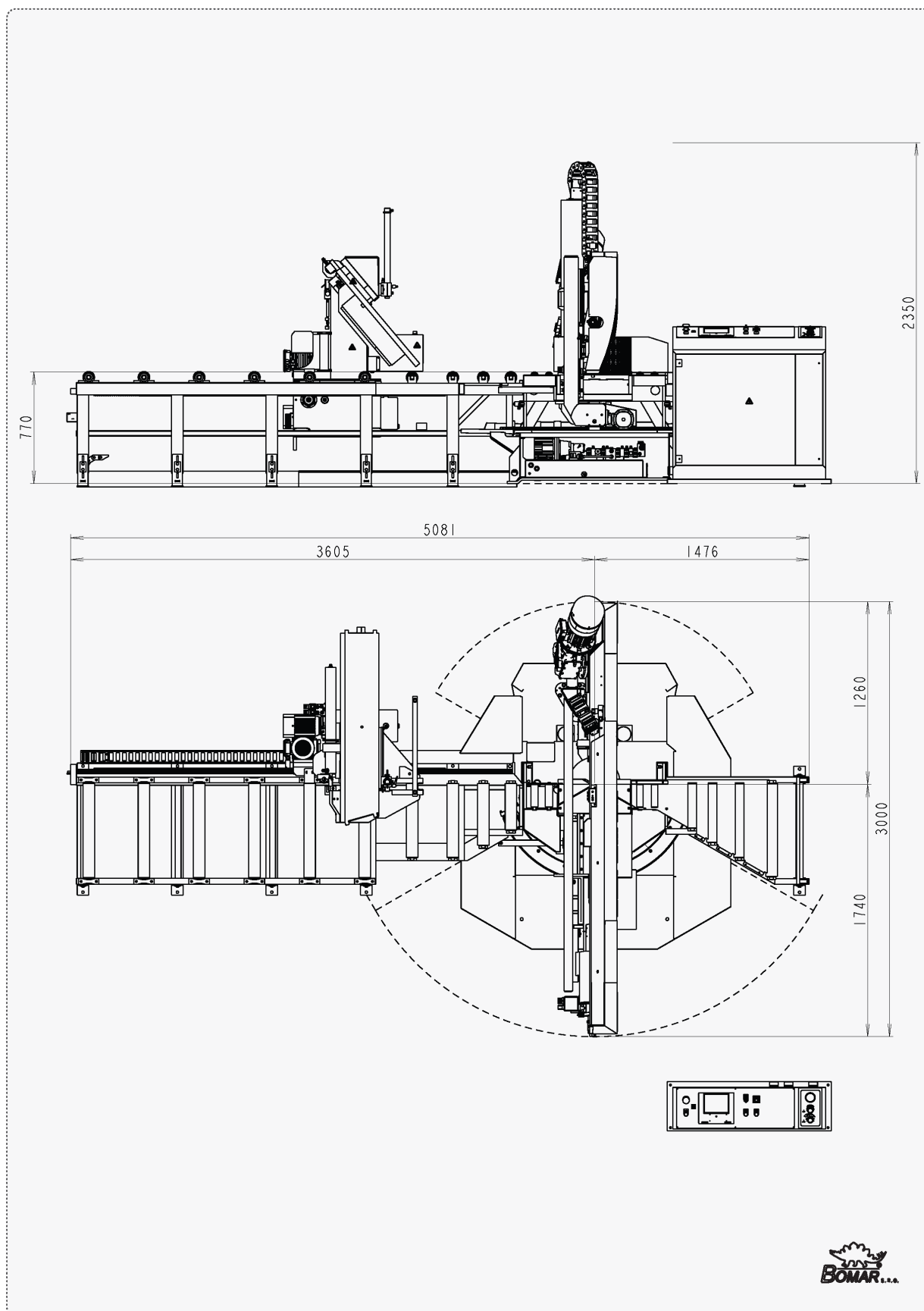
Warning:

If the material detection device is installed on machine maximal workpiece height is 10 mm shorter.

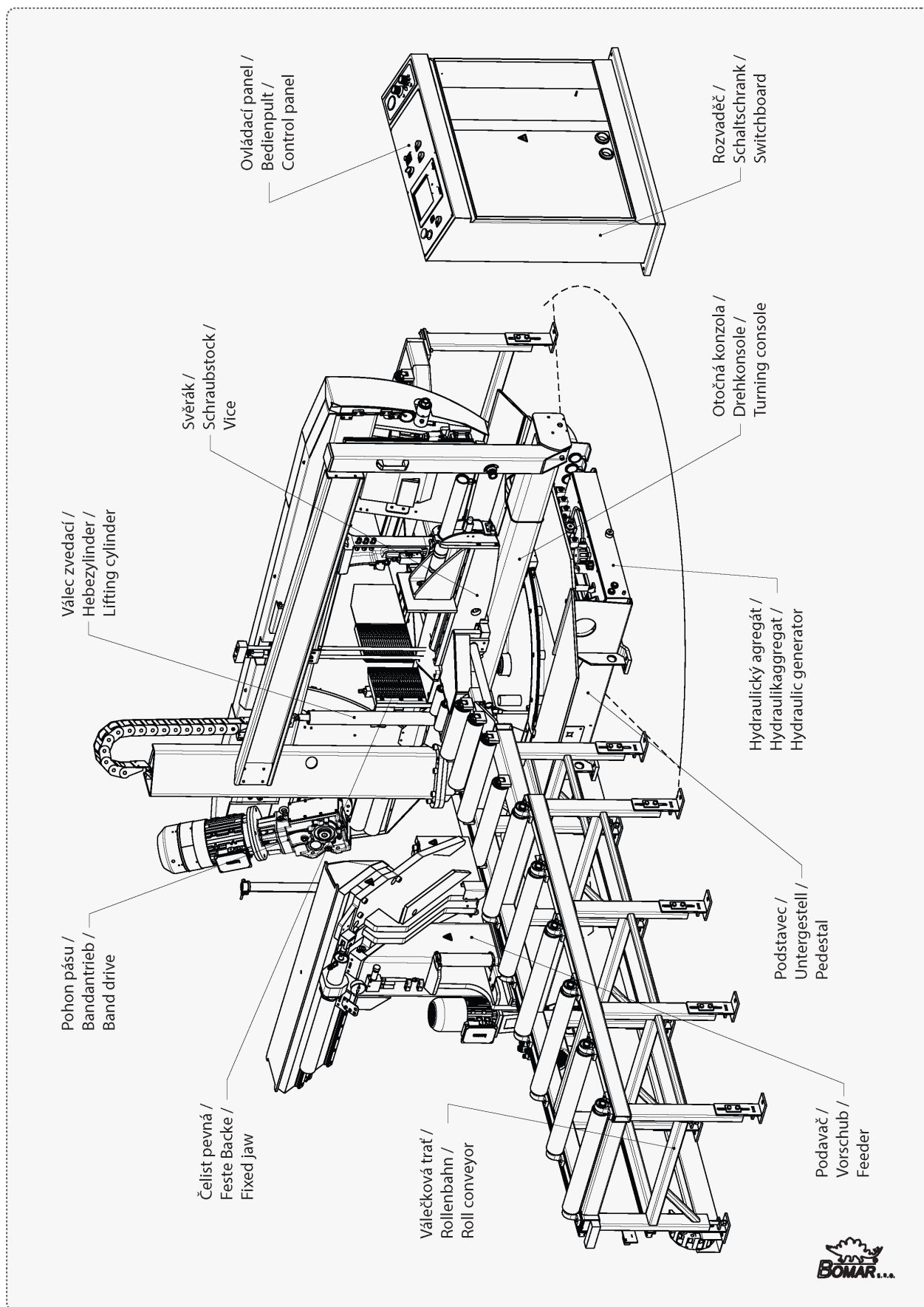
Acoustic pressure level:

The equivalent level of the acoustic pressure A (noise) in the position of the operator is $L_{Aeqv} = 76,3$ dB. The values are indicating the emission levels and may not present safety working levels. Among the factors, which influence the real values of the operator exposure, are properties of the workshop room, cut material and used saw bands – which may significantly influence the exposure levels

2.2. Rozměrové schéma / Aufstellzeichnung /
Installation diagram – Individual 620.460 DGANC



2.3. Popis / Beschreibung / Description



2.4. Transportation and stocking

2.4.1. Conditions for transportation and stocking

Keep recommendations for the manufacturers for transportation and stocking! If the recommendations are not kept, damage can occur to the machine.

- Don't use a forklift truck for handling the machine, if you do not have license for it!
- Don't move under suspended loads! Fault in lifting device may cause serious injury.
- Keep a safe distance from the machine during the transport.
- Temperature of the air from -25°C to 55°C , for a *short term* (max. 24 hours) temperature of the air until 70°C
- Do not expose the machine to radiation (for example microwave radiation, ultraviolet radiation, laser radiation, x-ray radiation). Radiation can cause problems with the machine function and deteriorating condition of the isolation.
- Take measures, to prevent damage by dampness, by vibrations and by shakes.

2.4.2. Transport and stocking preparations

Close the vice and thoroughly oil all blank surfaces.

Lower the saw frame to the lowest position.

Make sure to empty the machine of all traces of the cooling agent.

Fasten all loose parts securely to the machine.

Attach the machine weight labels to at least five visible areas

Pack and wrap the control desk securely to avoid damage during transport.

Fix the stickers stating the minimum approximate machine weight to at least five well visible places.

2.4.3. Transport and stocking

Handle the machine only with the hand pallet truck or the forklift truck!

Position the forklift forks according to the marks



Make sure that the the forklift truck has sufficient capacity.

Make sure that the van or the trailer had sufficient capacity.

The machine must be properly secured during transport, to not tip over or fall from the transport vehicle.

Screw on the palette to the floor of the van or the trailer.

Be careful that the machine is not damaged during transportation.

It is forbidden to handle the machine any other way (for example by, lifting by the saw frame of the band saw), than it is written in this operating instructions, the machine can be damaged!

Store the machine only under the conditions specified in this manual to prevent damage to the machine

2.5. Activation

2.5.1. Machine working conditions

Keep the conditions of the manufacturer for machine operating! If recommendations are not kept, damage can occur to the machine.

The manufacturer warrants the correct function of the machine for these conditions:

- At temperature air from **10°C to 40°C**, the temperature average during 24 hours must **not exceed over 35°C**.
- At relative dampness of the air in the extend from 30% to 95% (not concentrate)
- Altitude lower than 1000 metres.

Attention!

If the ambient temperature drops below 15 ° C is required before operating the machine to have switch on hydraulic unit around 10 minutes and then made several motion few times (for example, in manual mode) by all hydraulic cylinders. The reason is to heat hydraulic oil to the operating temperature for proper function of the pressure switches (and choke).

- Do not expose the machine to the radiation (for example microwave radiation, ultra-violet radiation, laser radiation, x-ray radiation). Radiation can cause problems with the machine function and deteriorating condition of the isolation.

2.6. Band saw unpacking and assembling

Attention!

Switch off the main switch and lock it, before you start assembly! Otherwise, there is possibility of hazardous machine starting.

Remove the packing from the machine and unpack all parts.

If the hydraulic unit is outside the machine (the machine only connected hoses and cables), it needs to be placed and mounted on a solid basis (floors, etc.). The mounting holes are used on the bottom (bases) of the tank.

2.6.1. Machine installing and levelling

Check the floor supporting capacity before machine installing. If the floor capacity does not agree with requirements, you must prepare the necessary base for the machine.

Minimal requirement:

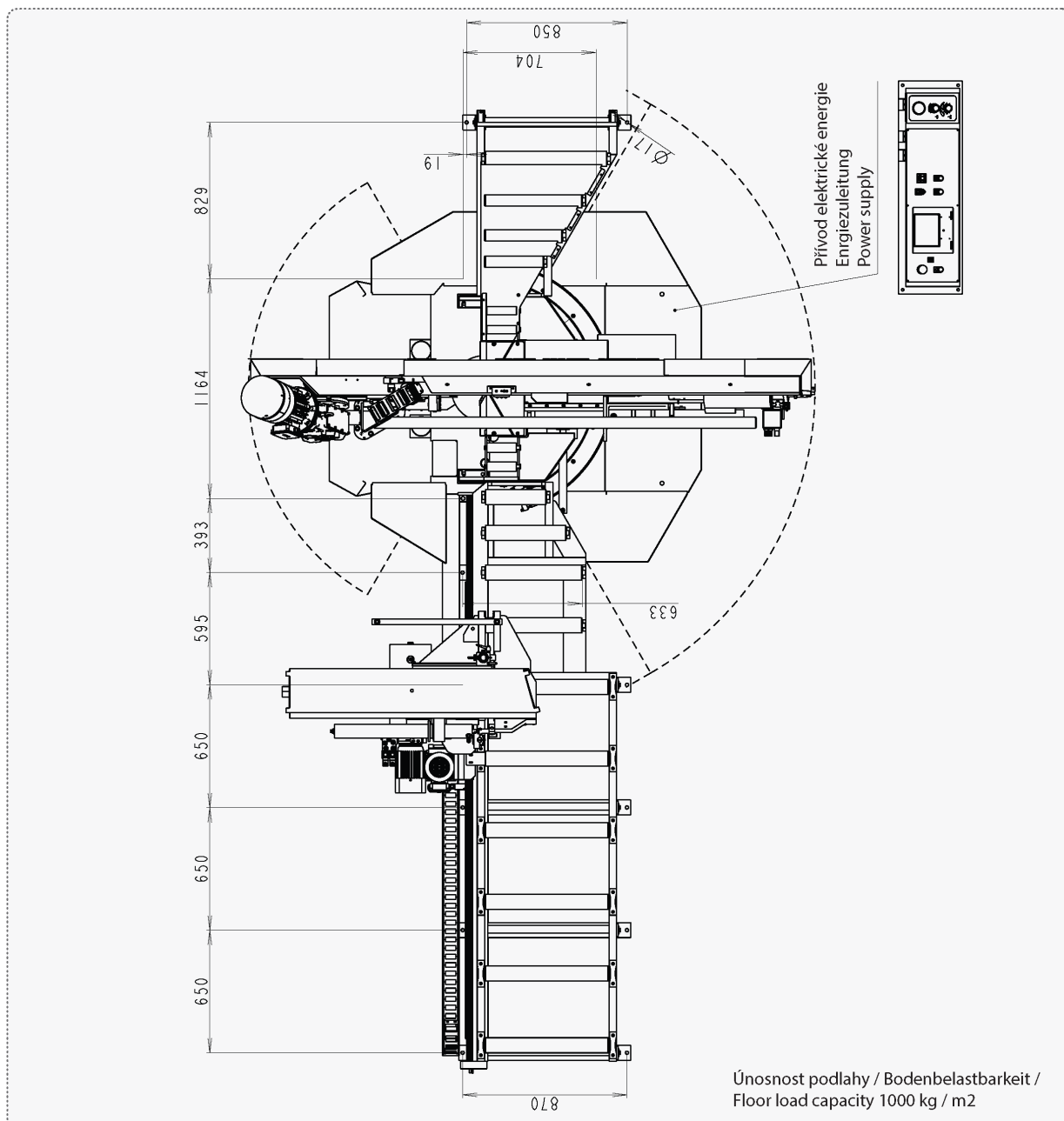
machine weight – Individual 620.460 DGANC – 3100 kg

+ weight of accessories

+ maximum weight of material

- The machine must be levelled at the horizontal position. All feet of the machine must touch with the floor after levelling
- The machine must be levelled by means of the calibrated spirit level. Spirit level is put on the vice area. Set the roller conveyors according to the spirit level.
- For machine levelling, take care that there is sufficient available space for operation, repair work, servicing of the machine and handling the material..
- The machine including appended parts and accessories must be visible from the place of operation.

2.6.2. Kotevní plan / Verankerungsplan / Grounding plan



Kotvicí materiál / Verankerungsmaterial / Grouding material

- 16 × Chemická hmoždina / Chemische Dübel / Chemical plug – $\varnothing 17$ mm
- Vrtáno do hloubky / In die Tiefe gebohrt / Drilled to – 140 mm
- Šrouby / Schraube / Screws – 16 x M16

- Šrouby podložit deskami o min. rozměrech P10×100-100
- Die Schrauben mit Platten mit Minimal Dimensionen P10×100-100
- Screw must be bottomed with plates (min. dimensions P10×100-100)

Požadavky na rovinnost podlahy / Anforderungen an die Bodenebenheit / Requirements for floor flatness

± 10 mm / 1 m

2.6.3. First run of the power pack

Before the first run check:

- The direction of the Pump, while run the power pack for max. 2seconds.
- The cooling fan of the motor has to rotate in the same direction as the arrow on the top of the motor cowling indicates.
- In case of wrong rotational direction, the electrical phase in the connection box is to be changed. This check is required after every disconnection from the power source
- Wiring matches with electrical and hydraulic diagrams
- the electric motors (pump and cooler) are properly connected and have the prescribed rotation
- the hydraulic accumulator with nitrogen gas to the specified value
- aux. elements work right (thermometer, level gauge, heater)

First run (Attention – working pressure on securing valve is set by producer in accoring the hydraulic diagram):

- In the short intervals activate an electric pump
- check for leaks and noise
- Bleed the hydraulic circuit
- if possible, test the circuit function with minimum load
- test the electrical equipment
- during operation monitor measuring equipment, noise, height and temperature of oil in the tank
- During this time a careful bleeding off for the whole hydraulic system is necessary. In case there is no bleeder port, the power pack will bleed itself after a while via the air breather on the tank or the return line filter.
- After multiple start-up.

2.6.4. Filling the reservoir with hydraulic oil

Oil regulations and recommendations of the manufacturer in the technical documentation (appendix) are to be carefully observed. For standard power packs we recommend the oiltype OH-HM32 (DIN 51524) of all known oil manufacturers.

Power packs have to be filled up with clean, pre-filtered oil! The purity of the hydraulic fluid must correspond to the class 10 NAS 1638 (reachable with filter $\beta_{=75}$)!

Filling from container, such as barrels, buckets, etc. is not recommended or permitted!

The maximum oil level will be shown on the upper marking at the dipstick or the sight level glass. Overfilling has to be prevent. The maximum filling rate of 15 l/min shouldn't be exceed.

Oil type	Kinematic viscosity ν in mm^2/s in relationship to the fluid temperatur					Freezing point
	0°C	20°C	40°C	60°C	80°C	°C
OH-HM 32	220	100	32	15	7	-40
OH-HV 32	180	67	32	17	11	-40

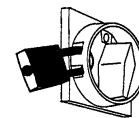
2.7. Electrical connection

Attention!

Only a qualified professional must carry out the servicing and repairs of the electric equipment! Take special care during work with electrical equipment. High voltage shock can have fatal consequences! Always keep notes about work safety.

Electrical parameters of the machine:

- Service voltage: ~ 3×400 V, 50 Hz, TN-S
- Total input: 7 kW
- Max. fuse: 25 A



Note:

Values of the cross section of the conductor and the rated current can be found in the regulations.

Before connecting switch off the main switch of the power supply circuit for the machine and ensure dry place when doing connecting works!

Service voltage must agree with the line voltage! Crosscut of the supply line must respond with rated current for max. machine load.

Note:

The socket with the fork can be used only at the machines with the rated current less than 16 A and total input less than 3 kVA.

The supply is equipped with a 16 A terminal for connection to the power supply tension.

In case the machine is connected with a direct connection, an extra main switch must be added which can be locked in zero position.

Attention!

In this case the extra switch on the electrical line becomes the primary switch and the main switch on the machine has only a secondary

2.7.1. Check the direction of the saw band



After the machine has been successfully connected, briefly switch on the machine and put the driving engine of the band in the running position. The direction must be in accordance with the arrow direction on the saw band cover. In case the direction of the saw band does not match, two phases at the terminal strip must be switched.

2.7.2. Check machine connection into electrical network



Attention!

When you connect the machine to the electrical network secure a correct connection of all phases!

THE HYDRAULIC AGGREGATE ENGINE MUST NOT BE OPERATED IN REVERSED DIRECTION FOR MORE THEN 10 SECONDS!!!



2.7.3. Filling of the cooling system

Prepare the mixture of the water and the cooling liquid. Keep the concentration specified by manufacturer. Shift away the cover from the drainage hole. Fill the mixture of the water and the cooling liquid to the tank of the cooling system. Area of the tank for the cooling liquid is discovered from the chapter *Technical data*.

Let the drainage hole opened and with the sieve during operation, because it secures the right work of the cooling system. Filling the tank with the cooling liquid, take care that the liquid does not drip out of the tank and the tank does not overflowed.

Note:

If machine is equiped with microniser, fill microniser with prescribed cooling liquid. This made the Microniser ready for use.

2.7.4. Connecting to the compressed air supply

Connect the machine to the compressed air supply by means of the screw G1/4 on the manifold period according to the picture.



Compressed air for Microniser must satisfy conditions:

- Roughly cleaned and partly dry
- $p_{\min} = 0,4 \text{ MPa}$
- $p_{\max} = 0,6 \text{ MPa}$
- Flow - 50 l/min.

2.8. Check machine function

Check, if the machine or some parts of the machine were not damaged during transport.

Check, if covers are installed and functional. Check by means of the Tenzomat if the saw band is correctly stretched. If it is necessary, you can stretch the saw band according to chapter *Selection and replacement of the saw band*. Values of the saw band stretching are on the Tenzomat. Switch on the main switch and check the motors and systems (saw band drive, hydraulic pump, cooling pump, chips conveyor).

Open and close the main vice. Turn the saw frame of the band saw from one outer position to other outer position. Raise the saw frame to the top position and drop the saw frame to the lowest position.

Start the machine with the cooling pump and let it run without load until the cooling system will be filled with cooling liquid. As soon as the cooling liquid starts to escape from the nozzles of the cooling system, the cooling system is ready for the operation.

Carry one cycle of cutting without material. Check, if the machine runs with no irregularities. If all machine functions are right, the machine is ready for operation..

2.9. Machine disposal after lifetime

Blown out all service fluids (cooling liquid, hydraulic oil) into designated reservoir.
 Dismantle machine into separate parts and dispose them in accordance with valid directives.

Packaging material Also dispose in accordance with valid directives.

Packaging and machine parts that contain secondary raw materials can be recycled.

2.10. Saw band

Refit the saw band cover only after you have installed and tightened the saw band.

2.10.1. Saw band size

6100×41×1,3 mm



2.10.2. Selection of the saw band tooth system

The manufacturers provide the saw bands with constant and variable tooth system.
 The important factor for selection of the tooth system is length of the cutting canal with respect to the size of the product

BOMAR for recommended Variable tooth system for band saw.

1. *Constant tooth system* – the saw band has parallel tooth pitch all over length. This way is suitable for cutting of solid material.
2. *Variable tooth system* – tooth pitch is variable. Variable tooth system is used for profiled materials and bundle cutting. Variable tooth pitch lowers vibration of the saw band, increases service life of the saw band and quality of the cutting area.

In tables, there are advised type of the tooth system depending on sizes and form of the cutting material.

Footnotes:

Z_pZ – teeth number on one inch S – tooth with zero angle of the teeth K – tooth with positive angle of the teeth

Examples of the tooth system marking:

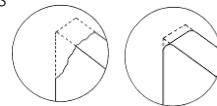
32 S – number „32“ means 32 teeth on one inch (that means constant tooth system), letter „S“ marks teeth with zero angle of the tooth.

4–6 K – number „4–6“ means 4 till 6 teeth on one inch (that means variable tooth system); letter „K“ marks teeth with positive angle of the teeth.

2.10.3. Saw band running-in

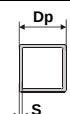
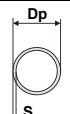
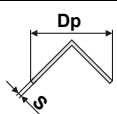
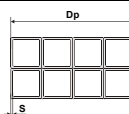
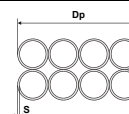
Running-in: Cut the material with the frame lowering reduced to 50% only. When vibrations occur increase or decrease the band speed.

When cutting small pieces run the band until approximately 300 cm² of material has been cut. When cutting large pieces run the band for 15 minutes approximately. When the band has been run, increase the lowering-speed to normal speed. The running in of the saw band avoids micro-breaks on the cutting edges of new saw band ensuing from first excessive stress. This would decrease service life substantially. The optimal running in of the saw band produces ideal rounded cutting edges and therefore the conditions for an optimal service life.

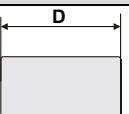
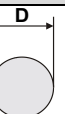
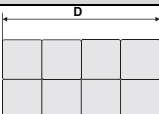
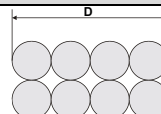


Note: Run regrounding saw bands too.

2.10.4. Tables for teeth selection

SHAPED MATERIAL ($D_p, S = \text{mm}$)						
						
Note: Table shows tooth system selection for cutting one piece of the profile. For cutting of more pieces of the profiles (bundle), you must think of the size of the wall as double size of the wall of one profile (that means, size „S“ equates to 2×S). In table, there are tooth systems constant and variable.						
Size of the wall S [mm]	Tooth system (Z_pZ) Outer diameter of the profile D_p [mm]					
	20	40	60	80	100	120
2	32 S	24 S	18 S	18 S	14 S	14 S
3	24 S	18 S	14 S	14 S	10–14 S	10–14 S
4	24 S	14 S	10–14 S	10–14 S	8–12 S	8–12 S
5	18 S	10–14 S	10–14 S	8–12 S	6–10 S	6–10 S
6	18 S	10–14 S	8–12 S	8–12 S	6–10 S	6–10 S
8	14 S	8–12 S	6–10 S	6–10 S	5–8 S	5–8 S
10	-	6–10 S	6–10 S	5–8 S	5–8 S	5–8 S
12	-	6–10 S	5–8 S	5–8 S	4–6 K	4–6 K
15	-	5–8 S	5–8 S	4–6 K	4–6 K	4–6 K
20	-	-	4–6 K	4–6 K	4–6 K	3–4 K
30	-	-	-	3–4 K	3–4 K	3–4 K
50	-	-	-	-	-	3–4 K

Size of the wall S [mm]	Tooth system (Z_pZ) Outer diameter of the profile D_p [mm]					
	150	200	300	500	750	1000
2	10–14 S	10–14 S	8–12 S	6–10 S	5–8 S	5–8 S
3	8–12 S	8–12 S	6–10 S	5–8 S	4–6 K	4–6 K
4	6–10 S	6–10 S	5–8 S	4–6 K	4–6 K	4–6 K
5	6–10 S	5–8 S	4–6 K	4–6 K	4–6 K	3–4 K
6	5–8 S	5–8 S	4–6 K	4–6 K	3–4 K	3–4 K
8	5–8 S	4–6 K	4–6 K	3–4 K	3–4 K	3–4 K
10	4–6 K	4–6 K	4–6 K	3–4 K	3–4 K	2–3 K
12	4–6 K	4–6 K	3–4 K	3–4 K	2–3 K	2–3 K
15	4–6 K	3–4 K	3–4 K	2–3 K	2–3 K	2–3 K
20	3–4 K	3–4 K	2–3 K	2–3 K	2–3 K	2–3 K
30	3–4 K	2–3 K	2–3 K	2–3 K	1,4–2 K	1,4–2 K
50	2–3 K	2–3 K	2–3 K	1,4–2 K	1,4–2 K	1,4–2 K
75	-	2–3 K	1,4–2 K	1,4–2 K	1,4–2 K	0,75–1,25 K
100	-	-	1,4–2 K	0,75–1,25 K	0,75–1,25 K	0,75–1,25 K
150	-	-	-	0,75–1,25 K	0,75–1,25 K	0,75–1,25 K
200	-	-	-	0,75–1,25 K	0,75–1,25 K	0,75–1,25 K

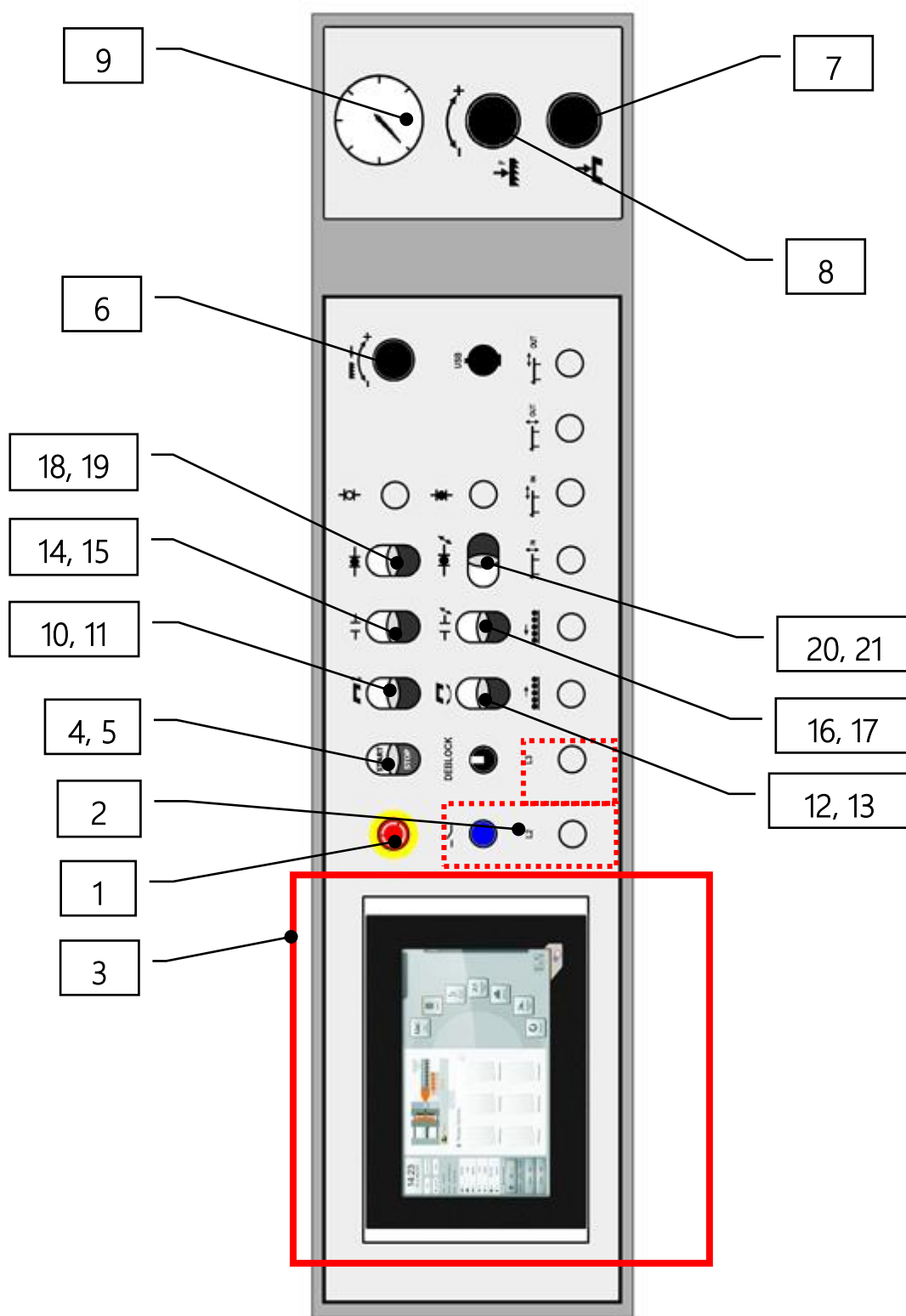
SOLID MATERIAL ($D = \text{mm}$)						
						
Constant tooth system			Variable tooth system			
length of the cut D		tooth system (Z_pZ)	length of the cut D		tooth system (Z_pZ)	
to 3 mm		32	to 30 mm		10 –14	
to 6 mm		24	20–50 mm		8–12	
to 10 mm		18	25–60 mm		6–10	
to 15 mm		14	35–80 mm		5–8	
15–30 mm		10	50–100 mm		4–6	
30–50 mm		8	70–120 mm		4–5	
50–80 mm		6	80–150 mm		3–4	
80–120 mm		4	120–350 mm		2–3	
120–200 mm		3	250–600 mm		1,4–2	
200–400 mm		2	500–3000 mm		0,75–1,25	
300–800 mm		1,25				
700–3000 mm		0,75				

In spite of the proposals above, consider your supplier's recommendations and ask him for professional advice although the manufacturers often recommend their own saw bands to you.

3. **Ovládání stroje / Bedienung der Maschine / Machine control**

3.1. Control panel

3.1.1. Standard control buttons



1	Emergency Stop Switch Immediately stops the machine in emergency
2	Safety circuits Buttons switch on the safety circuits of the machine If the machine is installed without peripheries, just one button for safety zone of the band saw and the feeder is installed. Installation of buttons L2 and L3 depends on the equipment of the machine – optional accessory.
3	Touch screen When working with the machine all of the necessary information the operator needs to control it is shown on the display.
4	START Starts automatic/semiautomatic mode
5	STOP Stops automatic/semiautomatic mode
6	Frequency converter Frequency converter sets the speed of saw band in the range of 20-120m.min ⁻¹
7	Regulation valve Regulation valve sets the lowering speed of the frame into the cut. The speed is limited by the adjustment of the pressure regulation in the cut on the guiding cubes. Note: If the throttle valve is closed too tightly, the valve seat may be damaged and may start to leak. Tighten the valve lightly. <i>sedlo ventilu, což způsobí jeho průsak. Dotahujte proto ventil vždy jen zlehka.</i>
8	Regulation of pressure into cut Regulation valve sets pressure into cut. Note: If the throttle valve is closed too tightly, the valve seat may be damaged and may start to leak. Tighten the valve lightly.
9	Manometer Shows value of pressure into cut
10, 11	Saw arm vertical movements Pushing these buttons moves the saw arm upward and downward. To move the arm, the button must be kept pushed. Pushing the both keys together with allows rapid move. (if the saw band isn't in material)
12, 13	Saw arm rotations Pushing these buttons rotates the arm leftwards (negative angles) and rightwards (positive angles). To move the arm, the button must be kept pushed.
14, 15	Clamping/ opening the main vice To move the jaw, the button must be kept pushed.
16, 17	Main vice table leftward / rightward Pushing these button moves the vice table rightwards or leftwards. During movement, the button need not be kept pushed. The button function is only active if the machine is not referenced. If the machine is referenced, the vice is moving fully automatically according to the saw position.

18, 19

Clamping/ opening the feeder vice

To move the jaw, the button must be kept pushed.

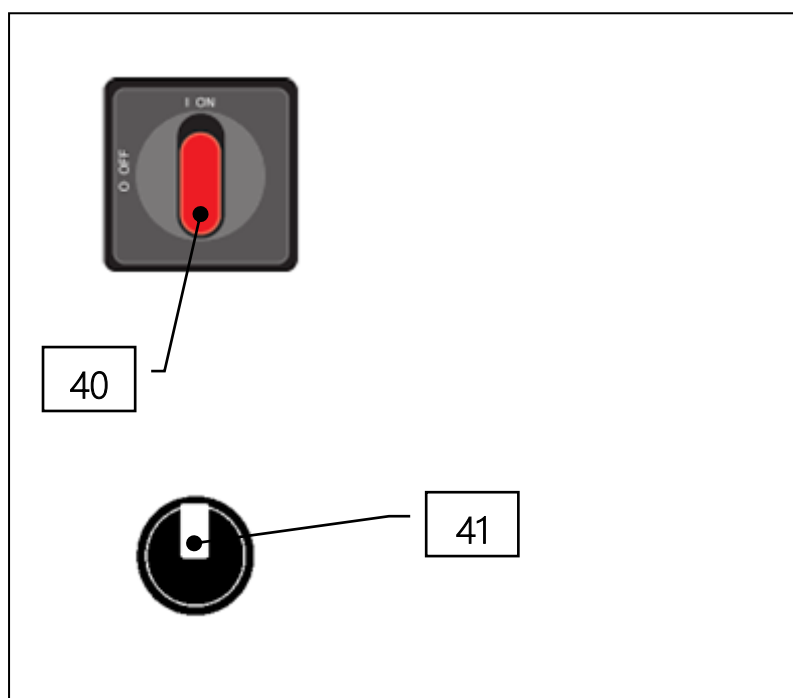
20, 21

Movements of the feeder cart

Pushing these button moves the the feeder cart towards the band saw or away from the band saw..

During movement, the button **need not** be kept pushed.

3.1.2. Controls on the side of the control panel



40

Main switch

41

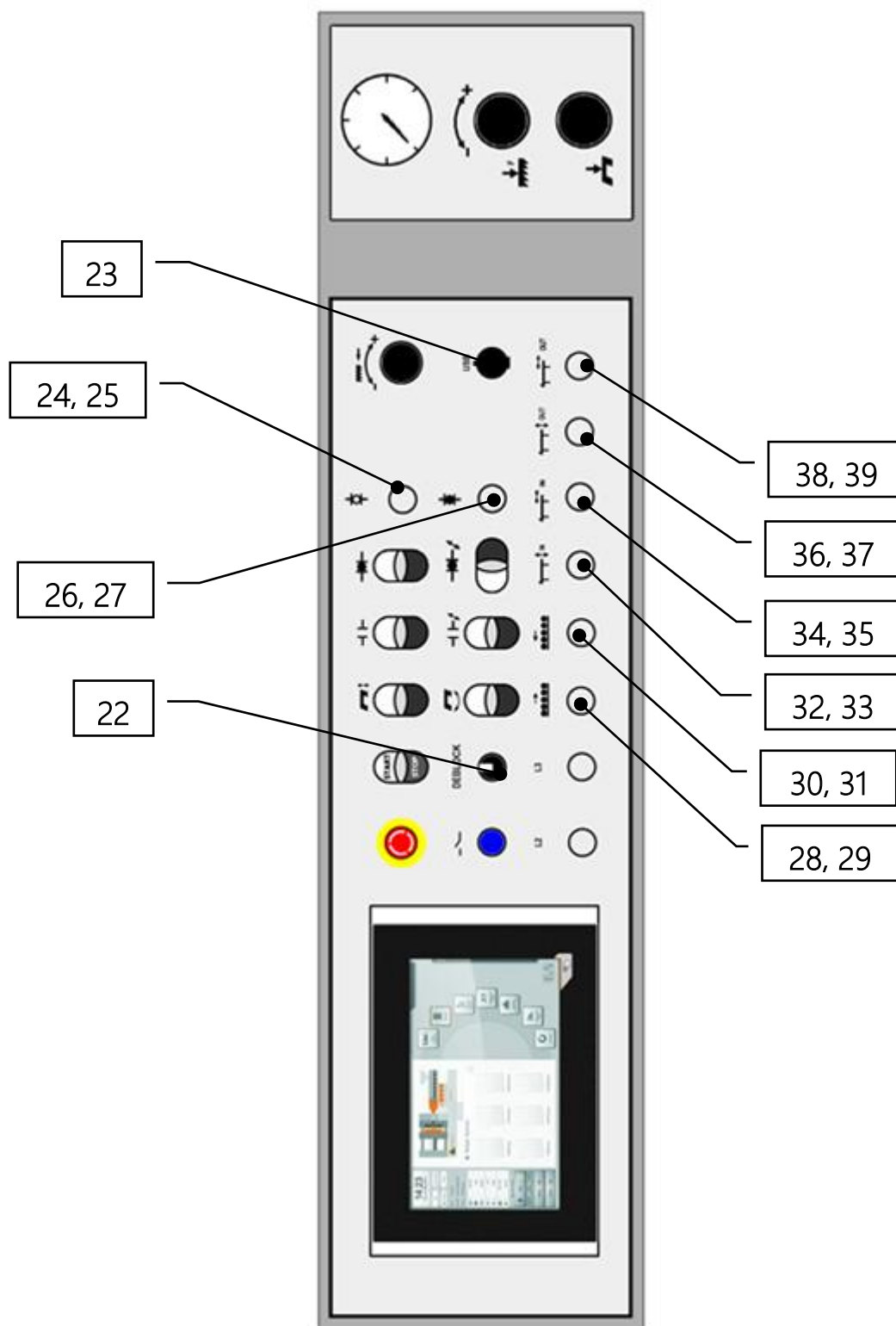
Laserliner (optional accessories)

- switch on / off

3.1.3. Control buttons for optional accessories

Note:

Installation of these buttons at the control panel depends on the installation of relevant optional accessory.

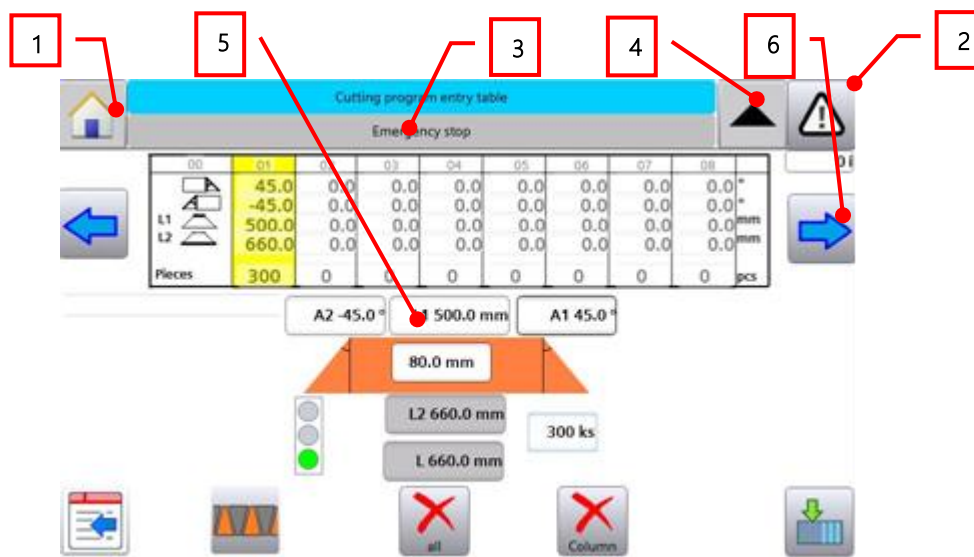


22	Deblock – for hydraulic saw band tensioning (optional accessory) Using this button, it is possible to put the machine in the DEBLOCK state. In DEBLOCK state only the hydraulic unit of the saw is active and only the buttons on the control panel for hydraulic belt tensioning are active.
23	USB port (optional accessory) Can be used for load/save cutting data
24, 25	Clamping/ opening the upper clamping at the main vice To move the jaw, the button must be kept pushed. Upper clamping is an optional accessory.
26, 27	Clamping/ opening the upper clamping at the feeder vice To move the jaw, the button must be kept pushed. Upper clamping is an optional accessory.
28, 29	Control of movements of rollers of the input roller track (optional accessory - if a track is installed)
30, 31	Control of movements of rollers of the output roller track (optional accessory - if a track is installed)
32, 33	Control of movements of arms of the input cross feeders Arms upwards / downwards (optional accessory - if the crossfeeders are installed)
34, 35	Control of movements of chains of the input cross feeders - Chains to the roller track / out from the roller track (optional accessory - if the crossfeeders are installed)
36, 37	Control of movements of arms of the output cross feeders Arms upwards / downwards (optional accessory - if the crossfeeders are installed)
38, 39	Control of movements of chains of the output cross feeders - Chains to the roller track / out from the roller track (optional accessory - if the crossfeeders are installed)

3.2. Machine control elements

3.2.1. The basic description of the screens of the control software

Pay increased attention when operating the touch panel. Make your selection by slightly touching the display with a bare finger or stylus designed for touch screen control. By no means use sharp objects or other tools!



(Picture for information only)

Meaning of icons on the touch screens:

1 – return to the main screen

2 – icon indicating errors – if this icon is lit on the display , an error has occurred on the machine. By touching the icon, you can hide the error message and activate control screens..

3 – selected menu name

4 – return to the nearest higher screen in the hierarchy

5 – parameter setting window

Touching of the parameter filling window activates a keyboard which appears on the display.

6 – browsing between screens at the same hierarchical level (e.g., if parameter control or setting is divided into several screens or if there are more elements controlled or more units to set service parameters)

The individual options on the touch screen can be chosen by **direct touch on the pertinent icon**.

To fill in numeric values or letters, the parameter setting window is used – see, for example, No. 5.

If the window is coloured, it is active for entry of parameters.

3.2.2. Main screen of the control software, machine modes

It is possible to initialize the main screen using the selection  from any screen of control software.

The main screen of the control software shows the basic menu for selection of working modes, setting modes and machine referencing modes.

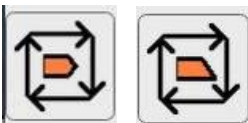


Working modes:

- **Manual mode** – used to control the individual machine functions manually

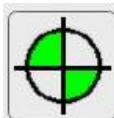


- **Semiautomatic mode** – used to execute one cut according to the given conditions (accessible from the manual mode)
- **Automatic mode** – used to execute the entire cutting cycle automatically according to the recipe entered



Referencing mode:

- **Referencing** – used to reference the machine – that is, after setting the machine in the operating state.



Setting modes:

- **Service** – used to set the machine parameters



- **Recipes** – used to set the recipes for the course of the automatic mode



3.3. Complete working cycle of the machine

The complete working cycle of the machine consists of the following steps:

1. Switching on the machine and safety circuits (see chapter "Switching on the machine and safety circuits")
2. Referencing the machine (see chapter "Machine referencing")
3. Setting service parameters (see chapter "Setting service parameters")
4. Adjusting the band saw (see chapter "Adjusting the band saw")
5. Executing
 - the cut in the semiautomatic mode (see chapter "Semiautomatic mode")
 - or
 - the cutting cycle in the automatic mode (see chapter "Automatic mode" and the "Recipes" chapter)
6. Executing another cut or cutting cycle, or end of cutting and switching the machine off

Manual control of the individual machine elements – see chapter "Manual mode".

3.4. Starting the machine and safety circuits



1. Turn the main switch into position 1 –ON.
The main switch is located on the side of the switchboard at the material input side (left side in respect to the control panel).
2. Switch on the safety circuit of the saw. The safety circuit will run a check on all safety switches.
Switching on of the safety circuit of the saw is signalized with orange light at the button for the safety circuits swiching on.



Unless the safety circuits have been activated, no mode of the machine can be started.

3.5. Machine referencing

Caution !

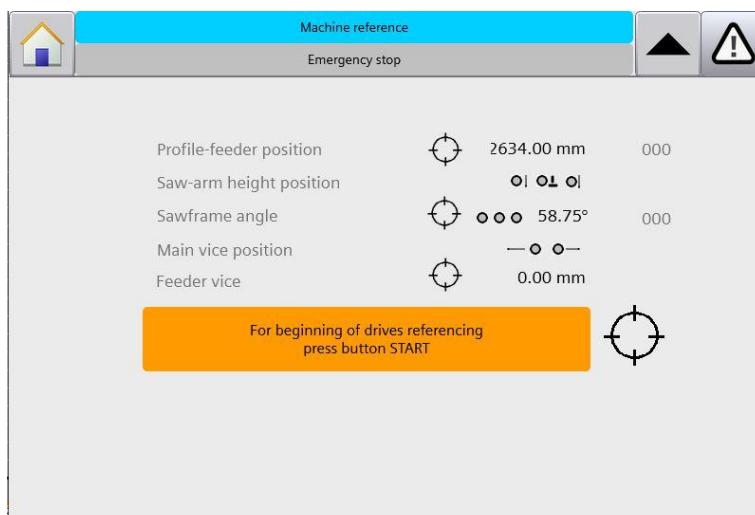
Before starting the referencing, remove all material from the saw and feeder. Do not reference the machine, if there is any material clamped in any of the vices..

If a material is laid on the feeder track, open the feeder vice sufficiently in the manual mode before starting the referencing, so that the material is not caught by it..

1. In the main screen of the control menu, choose the Referencing option.



2. This screen appears to display the referencing process:

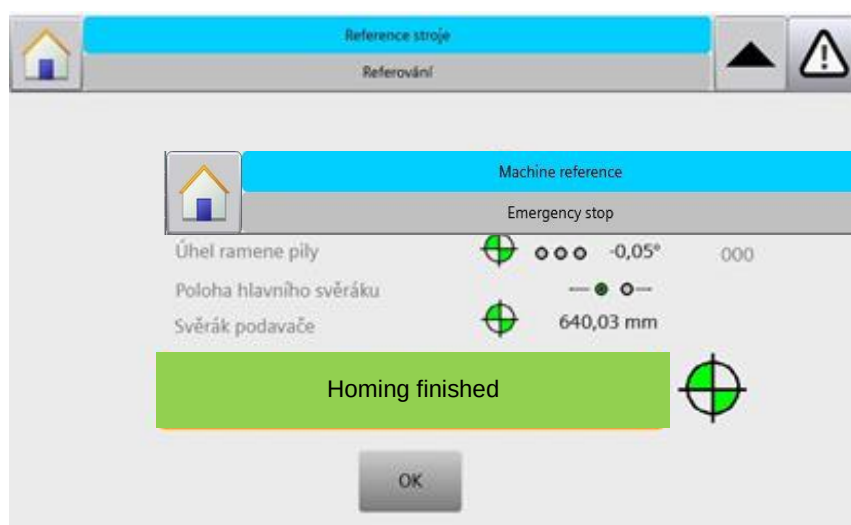


Position	Function
OK	Exit the screen
For beginning of drives referencing press button START	Instructions for the next procedure.

3. By pushing the "START" button, start the referencing process.

Referencing will be executed as a sequence of movements of the individual saw units which will be set from the current positions to their reference ones.

Successful end of referencing is indicated by a notice on the control panel display



If referencing of any unit fails, first check the state of the reference position limit switch and the switching counterpart.

3.6. Manual mode

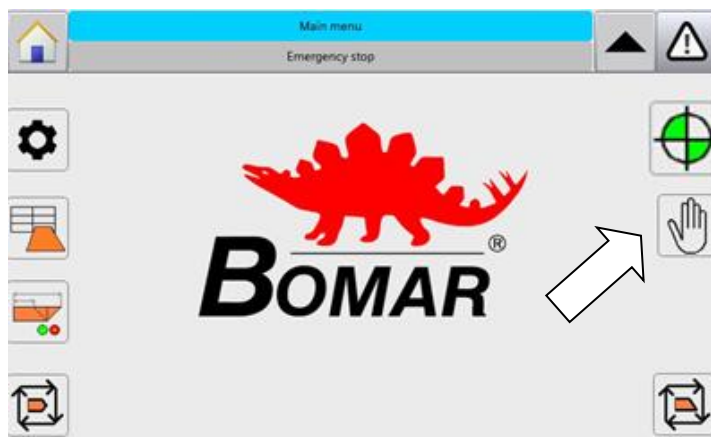
The manual mode is intended for manual control of the individual machine elements.

Caution!

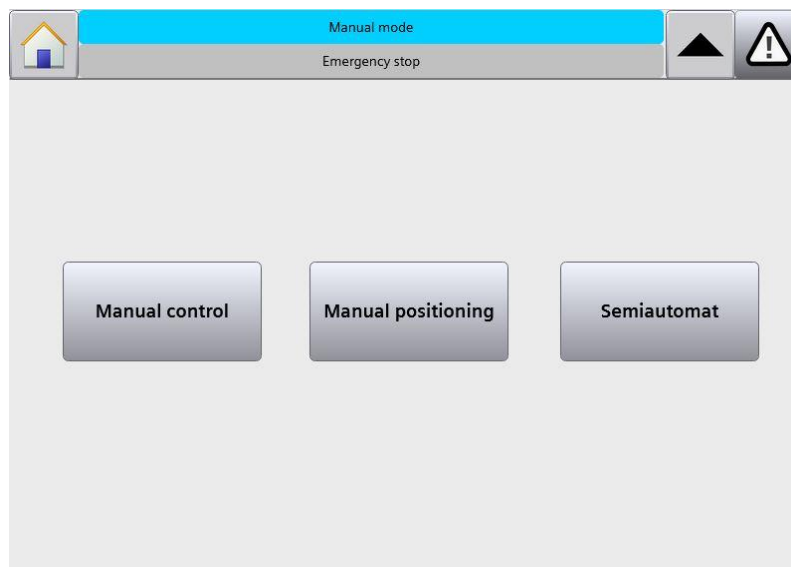
Pay increased attention when moving the material towards the saw, there is the risk of collisions particularly during manual operation!

3.6.1. Initiating manual mode

1. To switch the machine into the manual mode, choose the **manual mode** option on the main screen.

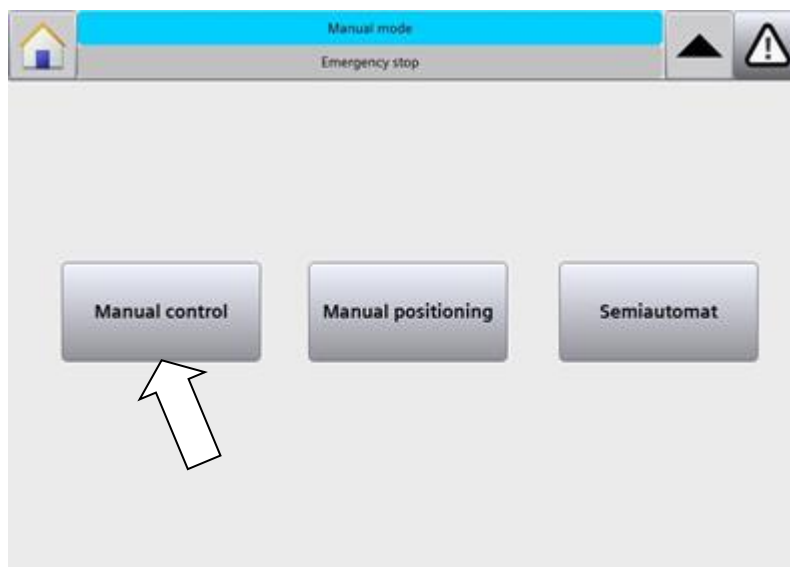


2. A screen will appear with options for manual and semi-automatic control of the saw:
 - „Manual control” – to control the saw functions
 - „Manual positioning” – to set the arm to the required angle and to feed the material with the feeder to the required length
 - „Semiautomat” – to control the saw in the semiautomatic mode

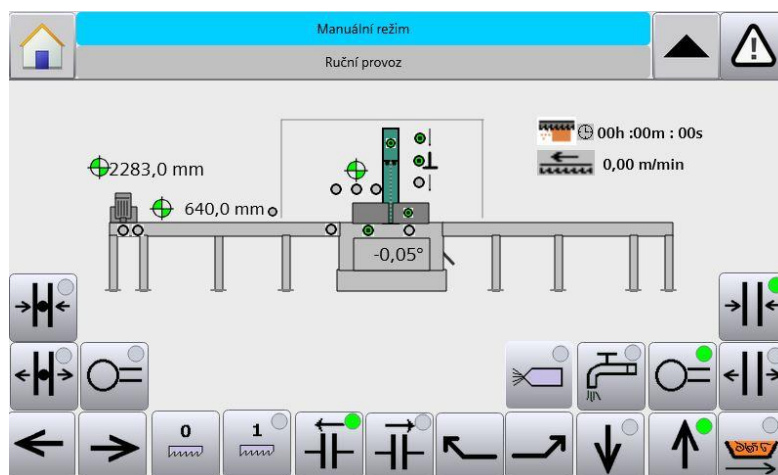


3.6.2. Manual control

1. On the screen with options for manual and semi-automatic operation of the saw: select the option "Manual control"

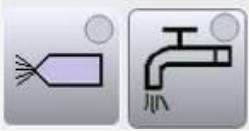


2. The following screen is used for manual control of the saw:



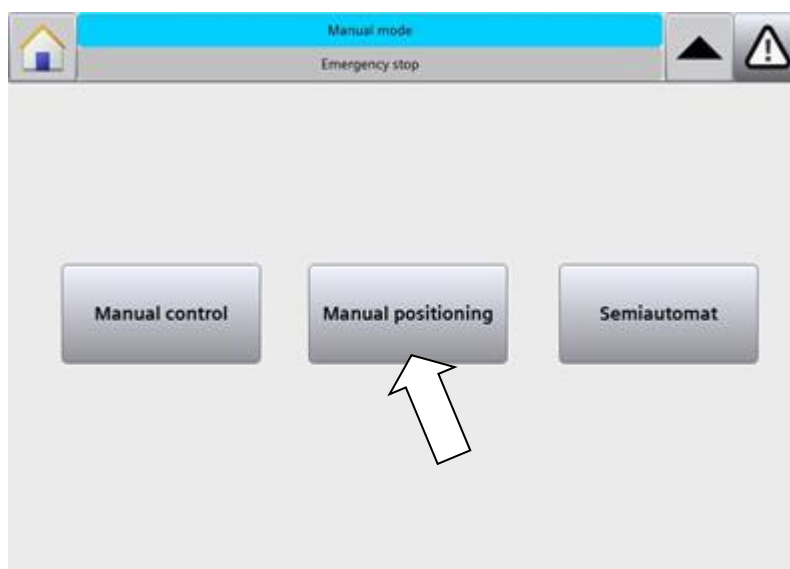
Position	Function
	Open / close the feeder vice Vice clamping is indicated by lighting the green lamp at the icon. 
	Feeder movement from / to the saw

Position	Function
	Main vice open / close Vice clamping is indicated by lighting the green lamp at the icon. 
	Vice table movement Setting of the vice table to the end position is indicated by lighting the green lamp at the pertinent icon.
	Arm upward movement. The button must be pushed continually for the movement time. If the button is released, the movement stops. Arm downward movement The button must be pushed continually for the movement time. If the button is released, the movement stops.
	Arm rotation by a positive angle (counter-clockwise round the rotation axis) Arm rotation by a negative angle (clockwise round the rotation axis)
	Rotate the saw band Rotation of the saw band is indicated by lighting the green lamp at the icon.
	Stop the band motor

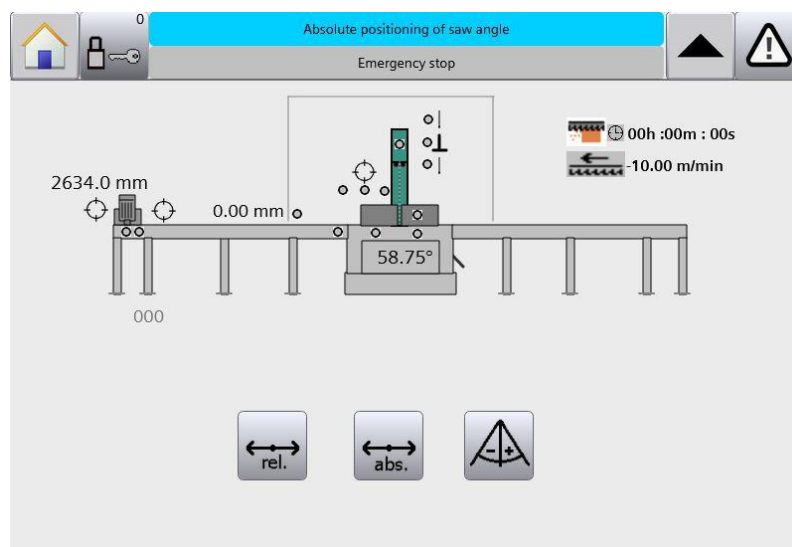
	Selection of cooling method You can choose the cooling methods by repeatedly pushing.  - liquid cooling  - Micronizer / Microbox (optional accessories)
---	--

3.6.3. Manual positioning

1. On the screen with options for manual and semi-automatic control of the saw: select the option "Manual positioning"



2. A screen will appear with options for manually positioning the saw's moving units:



3.6.3.1. Turning the saw arm

In the semiautomatic mode, you can swivel the arm by the given angle.

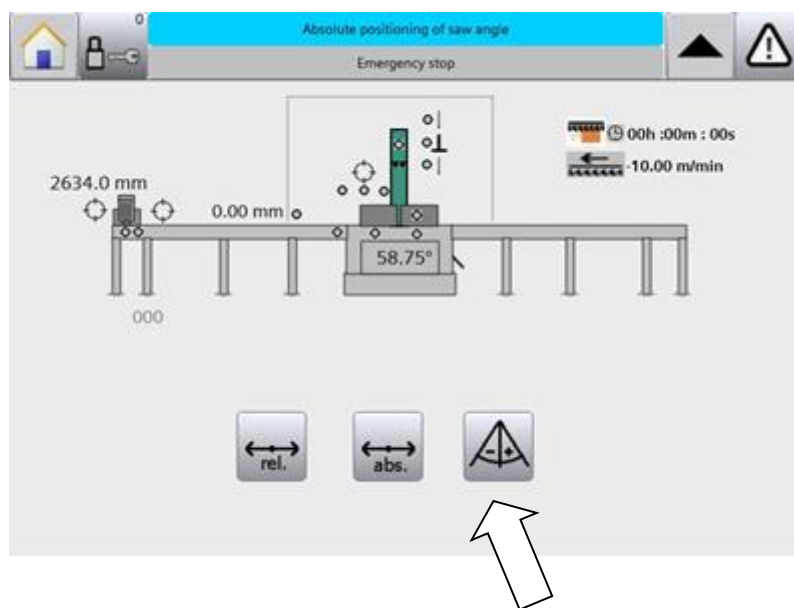
The arm cannot be turned, unless the machine is referenced.

1. In the manual mode, move the saw arm all the way up.

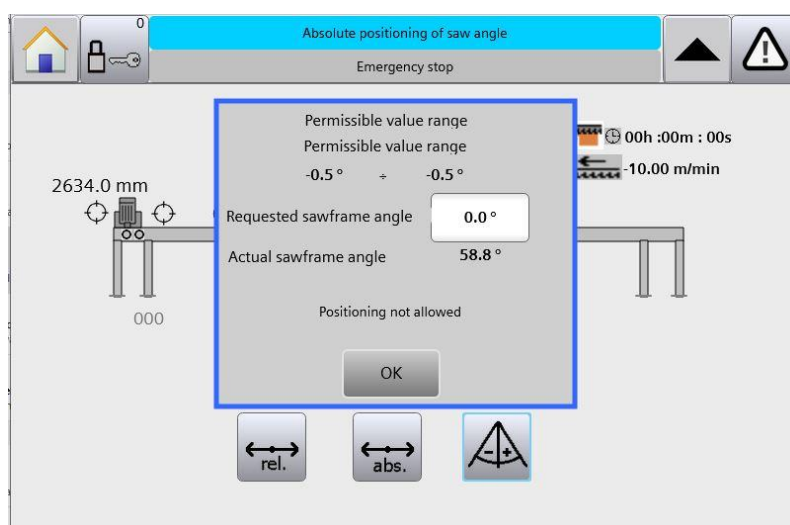
Attention!

If the arm stays in the lower position, there is a risk of of the arm colliding with the vice, the feeder or possibly with other parts of the machine or colliding with the inserted material!

2. Choose the option for setting the arm rotation angle.

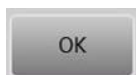


3. The screen appears for setting the arm rotation angle and the START button starts flashing.



Position	Function
Requested sawframe angle 0.0 °	Okno pro zadání požadovaného úhlu natočení ramene. The entered values must be within the range of allowed values, which are mentioned above the input field: Permissible value range -0.5 ° ÷ -0.5 ° The range of allowed values changes according to the current setting of the machine's moving units.
OK	Return to the previous screen

- In the parameter entry window in the screen for setting the arm rotation angle, enter the required arm rotation angle.



- Confirm the entry with the OK icon
- Push the START button
- After you push the START button the saw arm is automatically adjusted to the requested position

Attention!

If a cut follows, it is necessary to manually adjust the vise table so that the rotated arm does not collide with the misplaced vice!

3.6.3.2. Setting the feeder position

The feeder position cannot be adjusted if the machine is not referenced.

Attention!

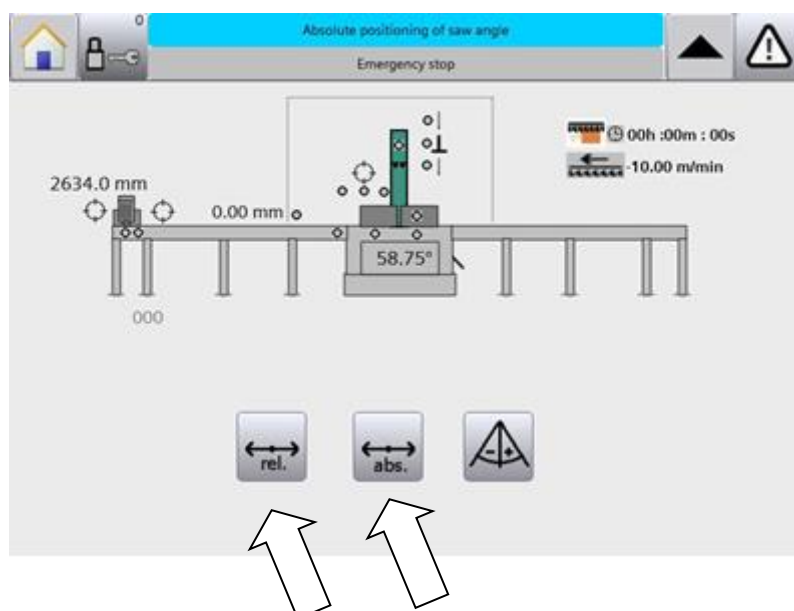
Size of burr and unevenness of the material face has an effect on the precision of the length loaded by the feeder!

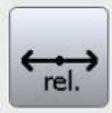
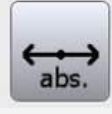
1. In the manual mode, move the saw arm all the way up.

Attention!

If the arm stays in the lower position, there is a risk of the feeder colliding with the arm!.

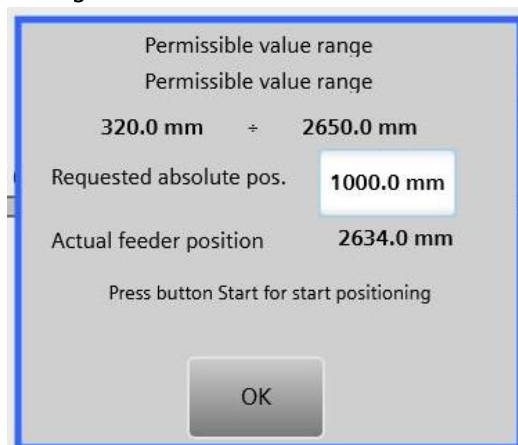
2. Choose one of the two possible options for length loading and the START button starts flashing.



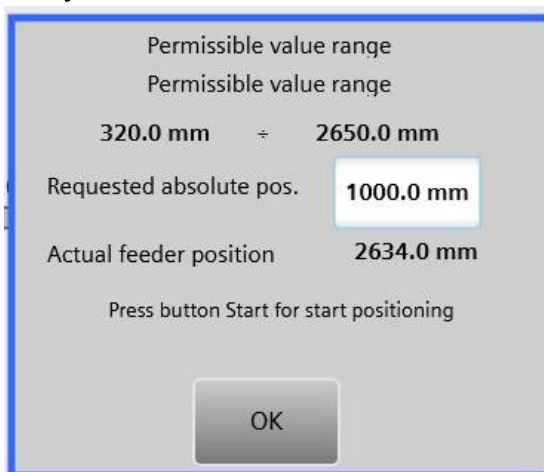
Position	Function
	Relative position setting The specified length will be measured from the current position of the feeder If the entered value is positive, the feeder will move away from the saw If the entered value is negative, the feeder will move towards the saw.
	Absolute position adjustment The entered length will be measured from the saw band. The entered value is always positive.

3. The window appears which serves for entry of the required feeder position

Relative position setting



Absolute position adjustment



4. Enter the required value in the window for setting position of the feeder.
5. Push the START button to start moving of the feeder.
6. After pressing the START button, the feeder moves to the specified position.

If you use the feeder to load material under the saw band, observe the following instructions:

Caution!

Before the loading starts, the main vice must be opened sufficiently so that the material loaded does not collide with the vice jaw!

Caution!

Upper clamping can only be used at zero turning of the arm.

3.6.4. Cutting execution in semiautomatic mode

Attention!

Pay extra attention to the mutual position of the moving units of the machine and the position of the material before cutting, there is a risk of collisions during the cut!

1. In the manual mode, move the saw arm all the way up.
2. In the manual mode, open the saw vice and feeder vice sufficiently with regard to the width of the material loaded.
3. Turn the arm to the required angle.

Turning the arm to the required angle - see chapter "Turning the saw arm".

4. Insert material

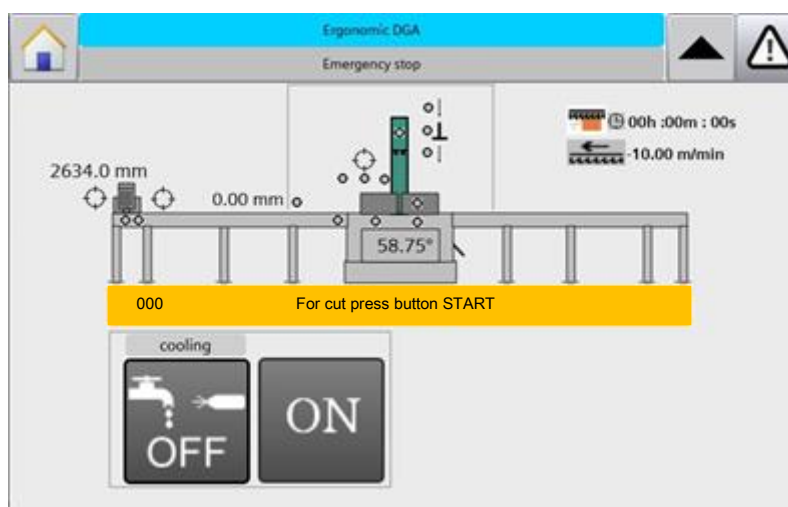
The material can be loaded

- with a manually controlled feeder – to the estimated length.
- with an automatically controlled feeder to the given length – see "Setting the feeder position"

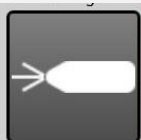
5. After feeding, the material must be clamped with the main vice using manual control.
6. On the screen with options for manual and semi-automatic control of the saw: select the option "Semiautomat"



7. The screen appears for setting of conditions for the semiautomatic cut



Set the cooling method on this screen:

Position	Function
Cooling	
	Cooling method You can choose the cooling methods by repeatedly pushing.
	 - liquid cooling
	 - Micronizer cooling*
	 - without cooling

Position	Function
	Selection of the position of the arm after the cut, in which the cooling will be turned off Pushing repeatedly, you can choose between the arm positions after cut
	 - After cutting, the arm remains at the bottom and the cooling is switched off
	 - After cutting, the arm moves up and the cooling is switched off
	 - cooling continues even after the end of the cut (regardless of arm position)

* The option is only functional for a machine with the given equipment

8. Setting of the arm starting position above the material to start cutting

As standard, the machine is equipped with a device for detection of the arm position above the material. In the automatic mode, the arm runs up above the material to the height given by the equipment setting (for details, see the chapter Equipment for detection of the arm position above the material).

9. By means of the potentiometer on the saw control panel, set the required cutting speed

10. By means of the valve on the saw control panel, set the speed of the arm descent to cut

11. By pushing the START button on the control panel, start cutting.

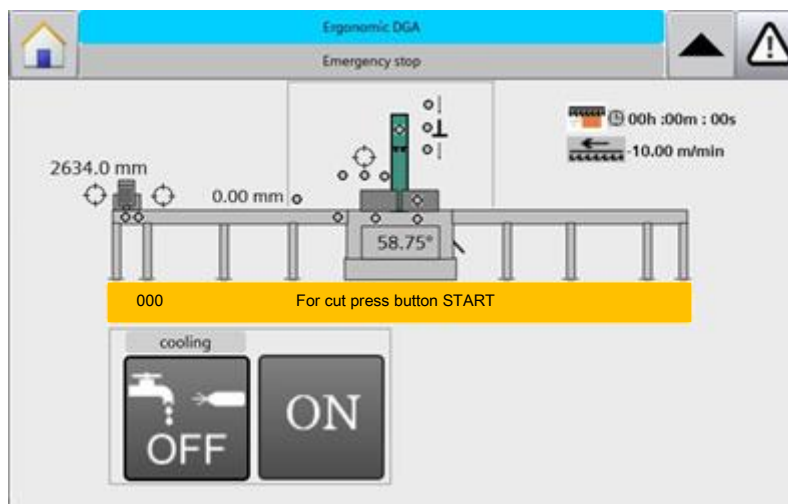
12. After pushing START:

- If the vice is in a wrong position with regard to the set arm rotation speed, it moves to the correct position automatically.
- If a material is clamped in the vice, it will automatically be released before the vice is moved, and then clamped again.
- The saw band starts up and the arm starts feeding to cut.
- While the arm is descending to cut or even during cutting, you can adjust the saw band speed and speed of arm descent to cut by means of the control elements on the machine control panel.
- On the control panel display, a screen appears with information on the cutting process.

Note:

If the conditions for a safe cut are not met, a message will appear and the cut cannot be started.

Check if the machine is referenced, if the material is clamped, if there is a risk of collision of some units.



13. After cutting in the semiautomatic mode is completed:

- The arm automatically returns to the position from which the cut was started or remains in the cut – according to the choice made in the screen for Basic setting or according to the choice made in the last automatic mode
- Completion of cutting in the semiautomatic mode is indicated by a message on the control panel display that the cut has been completed.

14. Remove the cut-off. Now you can repeat the entire procedure.

3.6.5. Semiautomatic sequence interruption

3.6.5.1. With the STOP button

1 push - interruption of the executed sequence of the „pause” type

This interruption is only possible if the cut has not been started.

After the Start button is pushed, the interrupted sequence (material loading to the given length, arm rotation to the given angle) is resumed from the interruption place.

2 pushes – complete stop and finish of the sequence or cut executed

If cutting was started in the semiautomatic mode, the machine does not respond to 1 push; only after the 2nd push of the STOP button, the cut is stopped.

Double-push of the STOP button can also be used to finish another sequence started in the semiautomatic mode.

The interrupted sequence cannot be resumed; it must be restarted from the beginning.

3.6.5.2. With the Emergency Stop Switch

In emergency cases, push the **Emergency Stop Switch** on the control panel.

1 push - interruption of safety circuits

- complete stop and finish of the sequence executed

The interrupted sequence cannot be resumed; the safety circuits must be switched on again and the interrupted sequence restarted from the beginning.

3.6.5.3. Interruption of safety circuits

The interrupted sequence cannot be resumed; you must restart the safety circuits and start the interrupted sequence again from the beginning.

3.7. Automatic mode

3.7.1. Cutting execution in automatic mode

Caution!

*Short pieces which the feeder cannot feed to the main vice cannot be cut in the automatic mode!
Imminent risk of collisions!*

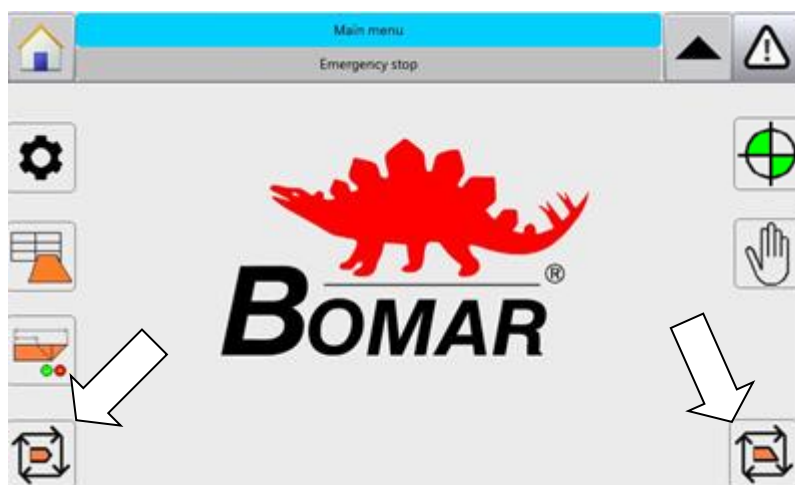
Caution!

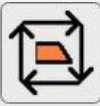
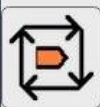
Size of burr and unevenness of the material face has an effect on the precision of the length loaded by the feeder!

1. Check, if necessary, set the current recipe.

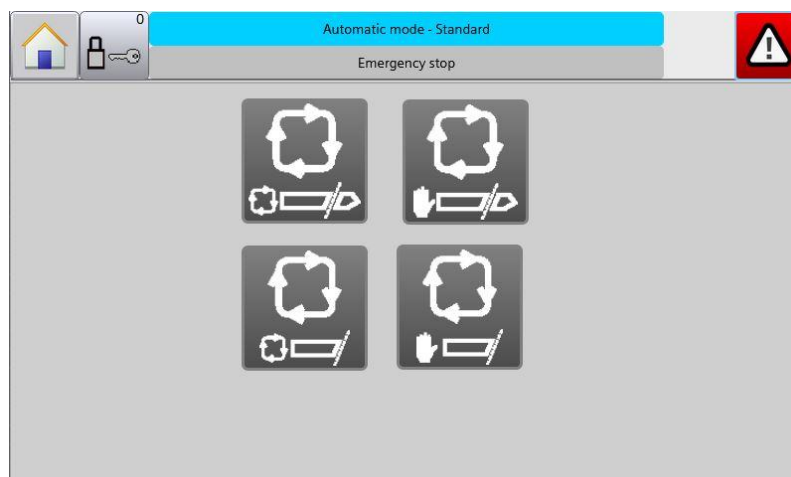
Working with recipes is described in the "Recipes" chapter.

2. On the main screen of the control software, select the appropriate option for automatic mode according to the type of recipe set.



Position	Function
	Cutting cycle for cutting a single angle
	Cutting cycle for cutting multiple angles

3. This screen appears with options for the material loading and cutting in



Position	Function
	Automatic material loading with cut-in - the material is loaded under the saw band automatically - the cut-in length is set automatically according to the entered cut-in length (for the setting, see below) - after cut-in, the automatic cycle is started automatically according to the given recipe - if an external loading system is installed, other pieces are loaded automatically and cut or not cut in according to the setting – see below
	Manual loading of the material with cut-in - the first piece is loaded under the saw band manually - the cut-in length set manually (by estimation or measurement) - after cut-in, the automatic cycle is started automatically according to the given recipe - if an external loading system is installed, other pieces are loaded automatically and cut or not cut in according to the setting – see below

Position	Function
	Automatic material loading without cut-in - Material is loaded under the saw band automatically - The first piece length is set automatically – according to the cut length set in the recipe - After loading, the automatic cycle is started automatically according to the preset recipe - If an external loading system is installed, other pieces are loaded automatically and not cut in
	Manual loading of the material without cut-in This mode is only used: - if the automatic cycle has been interrupted and the operator wants to resume it - If an automatic cycle has been completed and the operator wants to continue in cutting the residual material, according to a different setting of the automatic cycle, however To continue in the interrupted cycle or cutting the same material without the necessity of cut-in, it is always necessary that the operator does not open the vices! (Spontaneous release if the hydraulics are switched off is not detrimental.).

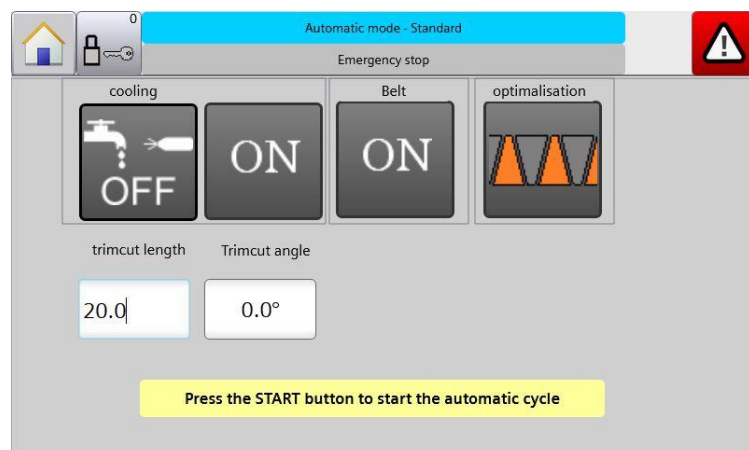
4. If the previous automatic cycle was not completely completed, a screen will appear asking if the operator wants to continue the incomplete automatic cycle



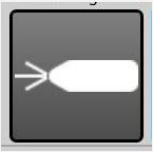
Select the desired option on this screen.

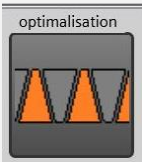
Also see the chapter about interrupting the automatic cycle for more information.

5. After making the previous selections, the screen for starting the automatic cycle will appear



When this screen appears, the START button starts flashing.

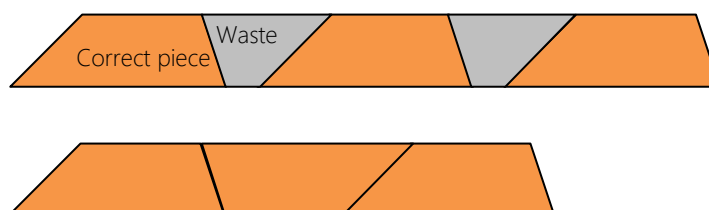
Position	Function
Cooling	
	Cooling method You can choose the cooling methods by repeatedly pushing.  - liquid cooling
	
	
	 - Micronizer cooling*  - without cooling
	Selection of the position of the arm after the cut, in which the cooling will be turned off Pushing repeatedly, you can choose between the arm positions after cut  - After cutting, the arm remains at the bottom and the cooling is switched off
	
	
	 - After cutting, the arm moves up and the cooling is switched off  - cooling continues even after the end of the cut (regardless of arm position)

Position	Function
Saw band	
	Selection of the saw band switch-off method By repeated touch, you can choose the methods saw band switch-off.
	 - switch-off if the arm is down  - switch-off if the arm is up
trimcut length Trimcut angle 20.0 0.0°	Field for entering the required cutting parameters  If the automatic guidance with cut-in option was selected, enter the desired cut in parameters. If you want to execute straight cut-in, enter the angle = 0°
	Option to activate/deactivate the cut optimization function Press repeatedly to choose whether the option will be: - inactive  - active 

* The option is only functional for a machine with the given equipment

Optimization of a cut

If the material section is symmetric, it is suitable to choose the cutting variant with minimum remnant. If pieces with different angles are cut, the angle sequence will alternately rotate so that there is no waste between the pieces. This variant cannot be used if the cut material section is not symmetric (e.g., L-angle section).



Attention!

During optimization, the shape will not be turned in a way which would prevent its cutting (for example, due to violation of the conditions of safe clamping, etc.)!

6. Setting of the arm starting position above the material to start the cut

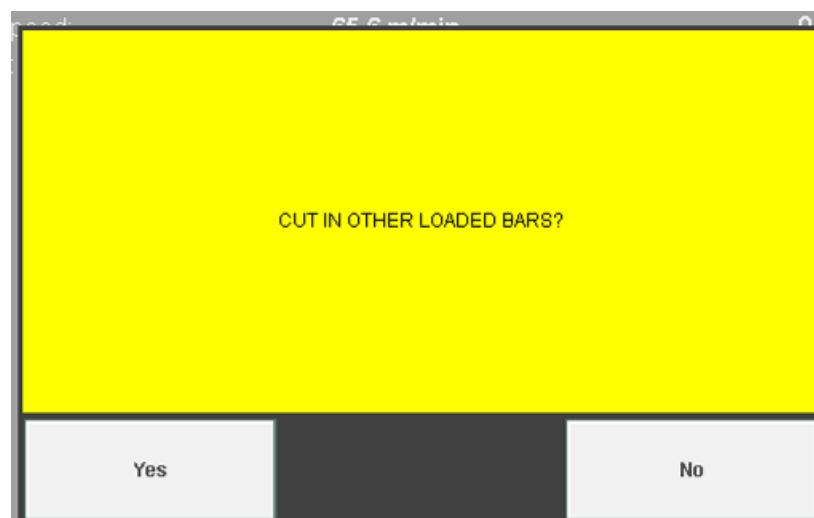
As standard, the machine is equipped with a device for detection of the arm position above the material. In the automatic mode, the arm runs up above the material to the height given by the equipment setting (for details, see chapter Equipment for detection of the arm position above the material).

7. By means of the potentiometer on the saw control panel, set the required cutting speed

8. By means of the valve on the saw control panel, set the speed of the arm descent to cut

9. Push the START button and start the automatic cycle

10. If material loading with cut-in has been selected, the operator is asked before the automatic cycle starts whether the other bars should be cut in as well:

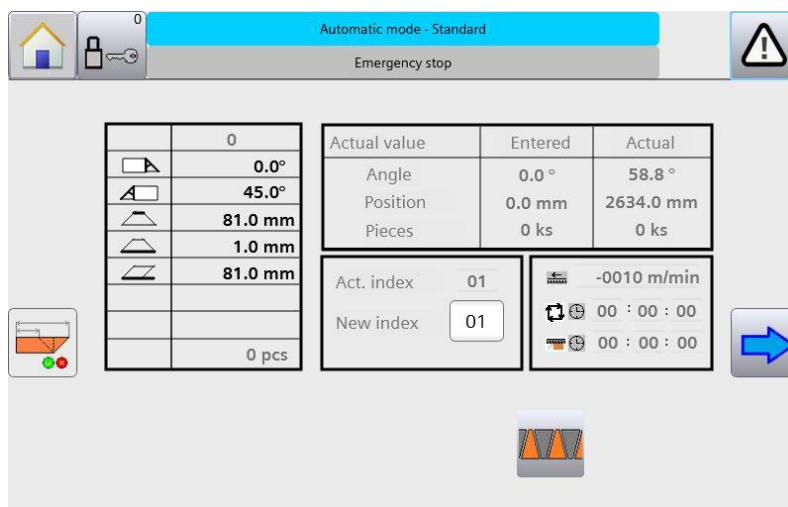


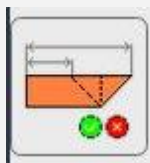
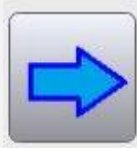
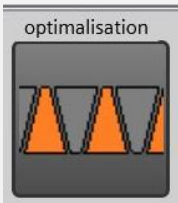
YES – each of the bars in the given automatic mode will be cut according to inserted parameters (see the screen for cut-in parameters setting)

NO – only the 1st bar in the cycle will be cut in; the other bars will be without cut-in

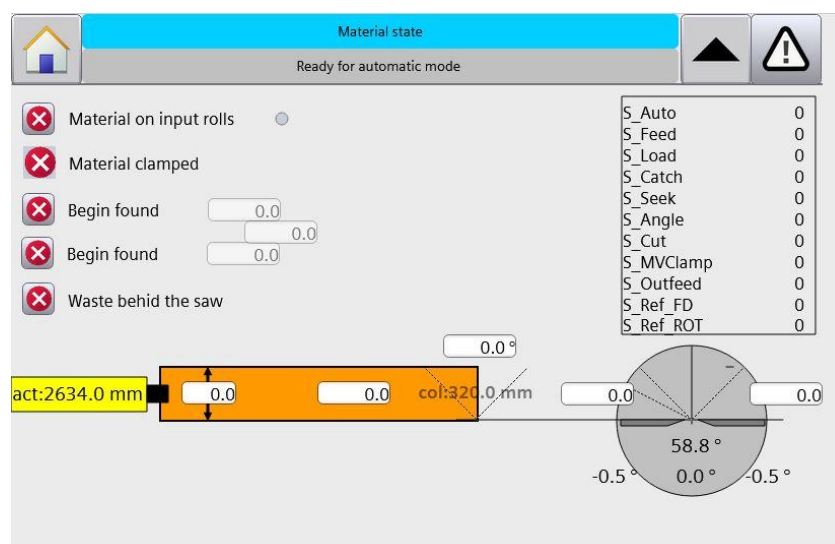
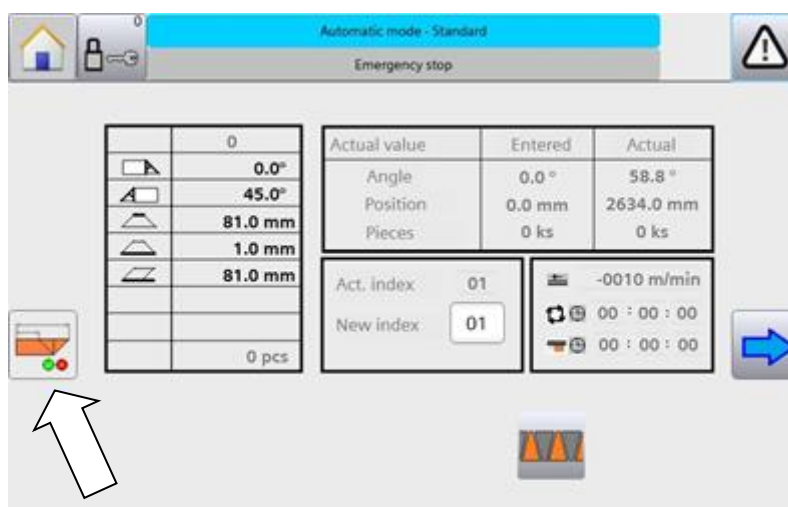
The choice is only valid if an input loading system is installed before the saw, continually loading on the feeder track more bars subsequently. If no input loading system is installed, the YES/NO choice is irrelevant because only one bar at a time is always loaded on the feeder track.

11. After the START button is pushed and the automatic cycle starts, a screen appears, showing the automatic cycle process



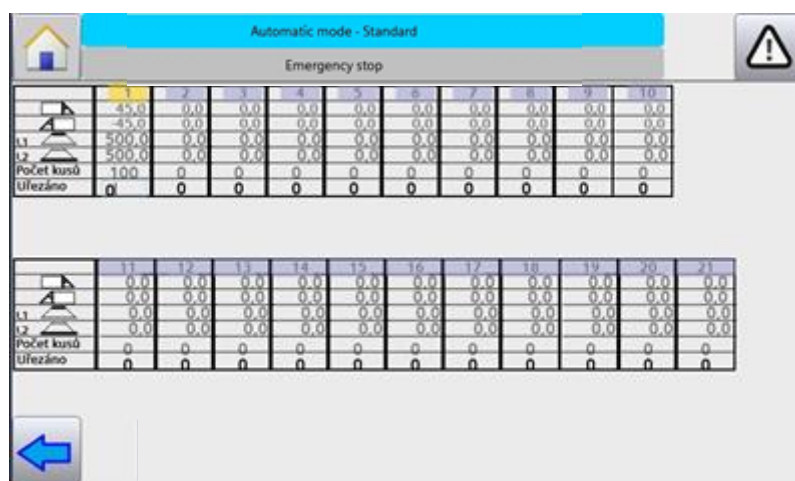
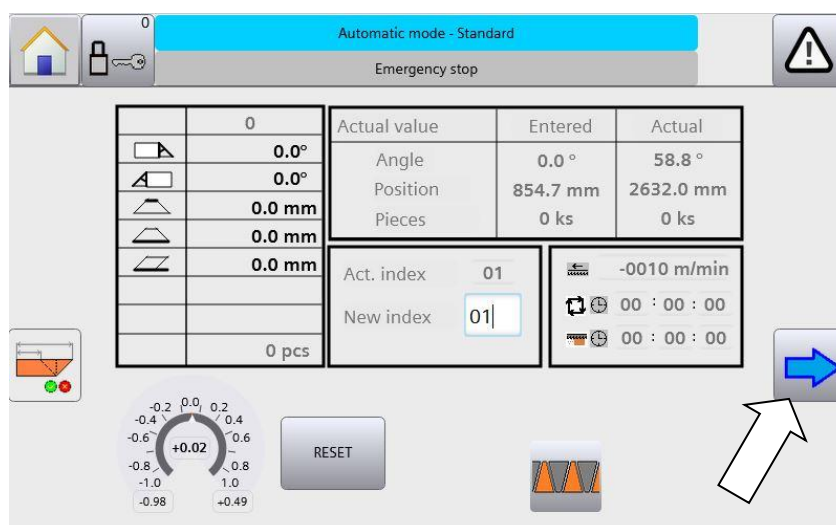
Position	Function
	Option for the material position display After you push the "Material" option in the screen showing the automatic cycle process, a screen showing the material position appears.
	Option for viewing the current order state After you push the "Job status" option in the screen showing the automatic cycle process, a screen showing the current order state appears.
optimisation 	Option to activate/deactivate the cut optimization function Press repeatedly to choose whether the option will be: - inactive  - active 

The screen showing the material position



Position	Function
322,0 mm 2304,9 mm 1961,0 mm 0,0 act:2283,0 mm 0,0 col:320,0 mm Continuous 0,0 -0,1° 0,0° -60,0° 60,0°	Parameters for service purposes Do not change these parameters without consulting with the manufacturer!

Screen showing the current order state



Position	Function
	Return to the screen showing the automatic cycle process

12. Automatic cycle process after pushing the START button

While the arm is descending to cut or even during cutting, you can modify the:

- saw band speed
- speed of the arm descent to cut

by means of control elements on the machine control panel..

• Automatic cycle with automatic material loading and cut-in

After setting of the automatic cycle and its start with the START button:

- a) After you push the START button, the feeder moves to find the material front with the laser beam. After the material front has been found, the feeder clamps the material and loads it to the saw **to the given cut-in length**.

It is assumed that in the mode of automatic loading to the saw the face of the loaded material is straight.

- b) After the given material length has been loaded, the material is automatically clamped by the main vice and cut in.
- c) After the first piece has been cut in, the automatic cycle further proceeds according to the settings of the recipe loaded.

Firstly, the piece from the first checked nonzero line of the recipe will be cut.

The cycle continues stepwise with all of the checked nonzero lines of the recipe (for the cut in pieces with an identical cut-in length).

If an inlet loading system (such as a conveyer) is installed, the other pieces are cut in as well according to the option for cut-in of other bars – see above.

- **Automatic cycle with automatic material loading without cut-in**

After setting of the automatic cycle and its start with the START button:

- a) After you push the START button, the feeder moves to find the material front with the laser beam. After the material front has been found, the feeder clamps the material and loads it to the saw **to the given length for the finished part**.

It is assumed that in the mode of automatic loading to the saw the face of the loaded material is straight.

- b) clamped by the main vice and the piece from the first checked nonzero line of the recipe will be cut first.

The cycle continues stepwise with all of the checked nonzero lines of the recipe.

- **Automatic cycle with manual material loading with cut-in m**

Cautionr!

When manually loading the material with the feeder, pay increased attention to prevent collision between the material loaded and the main vice jaw. The main vice must be opened sufficiently!

After setting of the automatic cycle and its start with the START button:

- a) The arm turns to the set cut-in angle.
- b) The operator is asked to insert the material.

**Insert material
into feeders vice.**

Press button START when ready.

The material must be inserted in the area of the feeding vice jaws so that it can be detected by the sensor laser beam.

At the same time, the inserted material face must be far enough from the main vice so that the feeder is able to detect the material face with the laser beam.

- c) The operator confirms insertion of the material by pushing the START button.
- d) By means of the manually controlled buttons on the control panel, the operator transfers the material under the saw band, in which the cut-in length is defined.
- e) After loading the material under the saw band, push again the "START" button – cut-in will be started at the manually loaded material length.
- f) After cut-in, the cycle continues automatically according to the settings in the loaded recipe.

Firstly, the piece from the first checked nonzero line of the recipe will be cut.

The cycle continues stepwise with all of the checked nonzero lines of the recipe (for the cut in pieces with an identical cut-in length).

If an inlet loading system (such as a conveyer) is installed, the other pieces are cut in as well according to the option for cut-in of other bars – see above. To cut-in of bars fed by the inlet loading system, the parameters apply, entered in the screen for manual loading with cut-in.

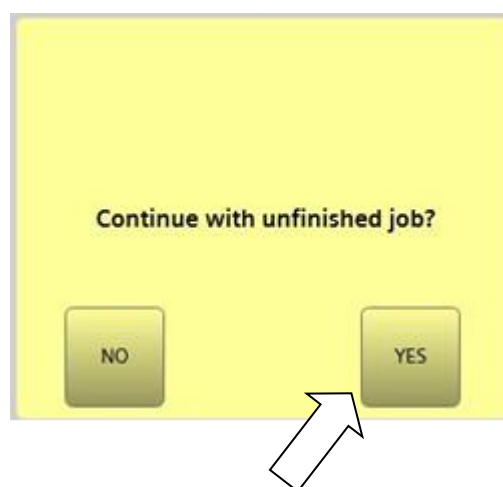
- **Automatic cycle with manual material loading without cut-in**

This mode is only used if the automatic cycle has been interrupted, not all of the pieces have been cut and the operator wants to resume the started cycle.

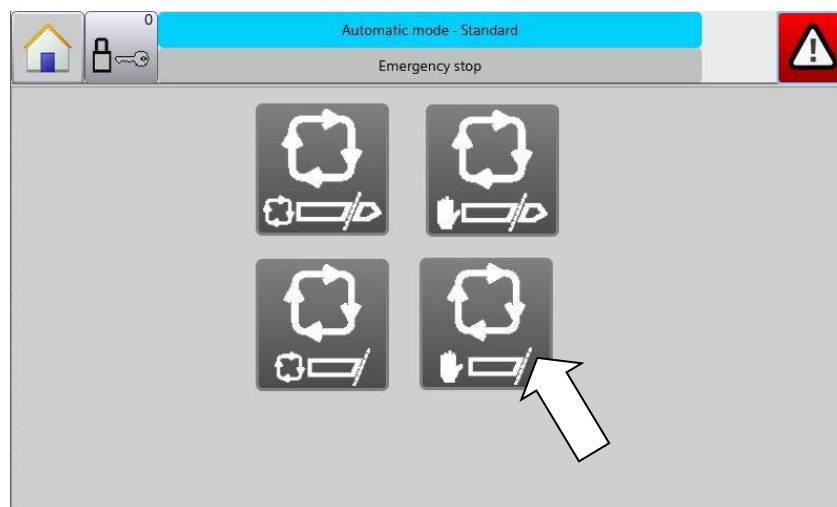
It is necessary for this mode that the material remains initiated (that is, the operator should not open the vices after the automatic cycle interruption).

- a) After the automatic cycle has been interrupted, the operator is asked whether to continue with the unfinished task:

To resume the started cycle, it is necessary to choose "Yes"



- b) After selection, the display shows a screen for selection of cut-in, in which the operator should choose **manual loading without cut-in**



- c) The operator goes through the setting of the automatic cycle up to the screen for starting the automatic cycle.
- d) Push START to initiate the automatic cycle – the cycle will proceed from the point at which it was interrupted.

NOTICE:

If the operator opened the vices after interruption of the automatic cycle and the machine lost information on the material, the machine will show a **message about losing the information about the material** after the START button is pushed to resume the cycle:

Under these circumstances, the cycle cannot be resumed; confirm the message and start the cycle again.

13. After completion of the cycle:
 - The arm automatically returns to the position at which the cut started
 - Finish of the cycle is announced on the display.
14. Remove the cut-off.
15. Now you can repeat the entire procedure.

3.7.2. Automatic cycle interruption

3.7.2.1. Procedure at the automatic cycle interruption (not „Pause“) if not all of the pieces have been cut through according to the task (recipe) set

1. After the automatic cycle interruption other than “Pause”, if not all of the pieces according to the task (recipe) set have been cut through by the moment when the automatic cycle was stopped; a screen appears with options for finishing the unfinished task or resuming the unfinished task.



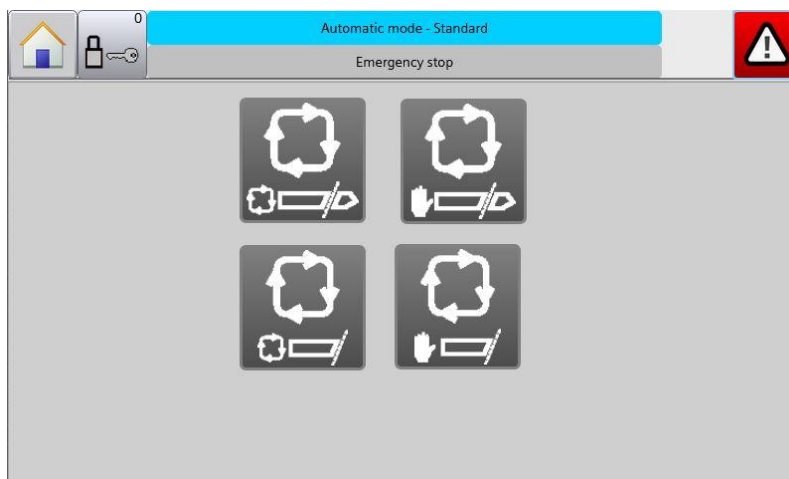
If you choose “Yes”

- the cycle can proceed from the point of interruption and the information on the number of cut pieces is kept.

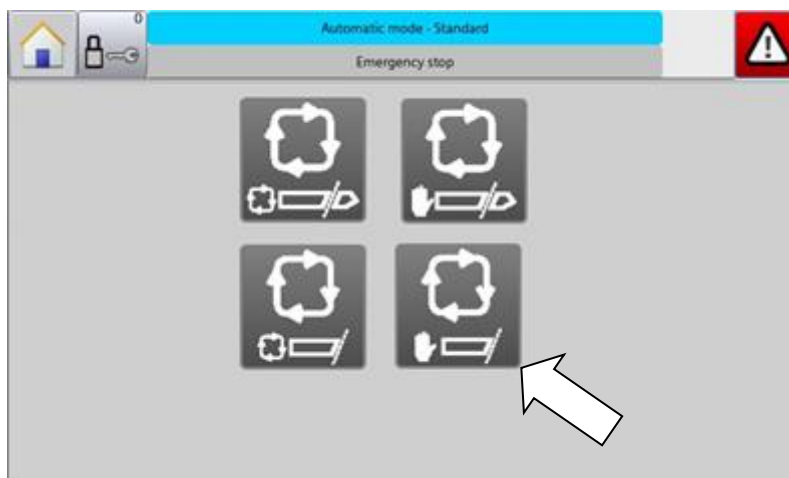
If you choose “No”

- the cycle can proceed from the point of interruption, but the information on the number of cut pieces is reset

2. If you choose Yes/No on the previous screen, a screen appears for starting the automatic cycle



3. If you want to resume the interrupted cycle, you should choose the option for the mode of manual loading without cut-in in this screen



Further, see the Automatic cycle with manual loading without cut-in.

In the mode of Automatic cycle with manual loading without cut-in, it is also possible to modify the recipe continuation.

If you do not want to resume the interrupted cycle, you can start another cycle in the screen for the automatic cycle start, move to another mode or switch off the machine.

4. Automatic cycle interruption with the STOP button

1 push - cycle interruption of the „Pause” type

This interruption is only possible if the cut has not been started.

After you push the Start button, the interrupted cycle will proceed from the point of interruption.

2 pushes – automatic cycle interruption

If the cut has been started, the machine does not respond to 1 push; the cut will be stopped only after the 2nd push of the STOP button.

Double push of the STOP button can also be used to interrupt the automatic cycle at any other phase.

After double push of the STOP button, if not all of the pieces have been cut through in the unfinished task, proceed according to the procedure above.

3.7.2.2. Automatic cycle interruption with the Emergency Stop Switch

In emergency cases, push the Emergency Stop Switch button on the control panel.

- 1 push - interruption of safety circuits
 - automatic cycle interruption
1. Switch on the safety circuits again.
 2. If not all of the pieces have been cut through in the unfinished task, follow the procedure above.

3.7.2.3. Interruption of safety circuits

- Before the machine is restarted, the safety circuits must be switched on.
- Further, see the "Procedure of interruption (not the "Pause") of the automatic cycle if not all of the parts have been cut according to the given task (recipe)

3.7.2.4. Error

An error occurs during the automatic cycle and an error message appears on the control panel display.

- **To resume the interrupted cycle:**

1. Remove the cause of the error.
2. Confirm the error message.
3. If not all of the pieces have been cut through in the unfinished task, and if it is enabled, follow the above procedure.

If the screen for resuming the unfinished task does not appear after you have removed the error, you must start the cycle again.

3.8. Recipes

3.8.1. Creation of a new recipe and modification of an existing recipe

- A new recipe can be created:
 - Po vymazání dat z aktuálně načtené receptury
 - nebo na základě úpravy aktuálně načtené receptury – that is, by creating a modified version of an existing recipe and saving this modified version under a different name.

- **Attention!**

If you do not save the modified or newly entered task (recipe), the data entered will be lost the moment when you load another recipe.

The created recipe can be saved in the machine's memory or in an external memory - see below.

- One recipe can only be entered for one material width.

If you cut more widths, you must gradually create and load a special recipe for every width.

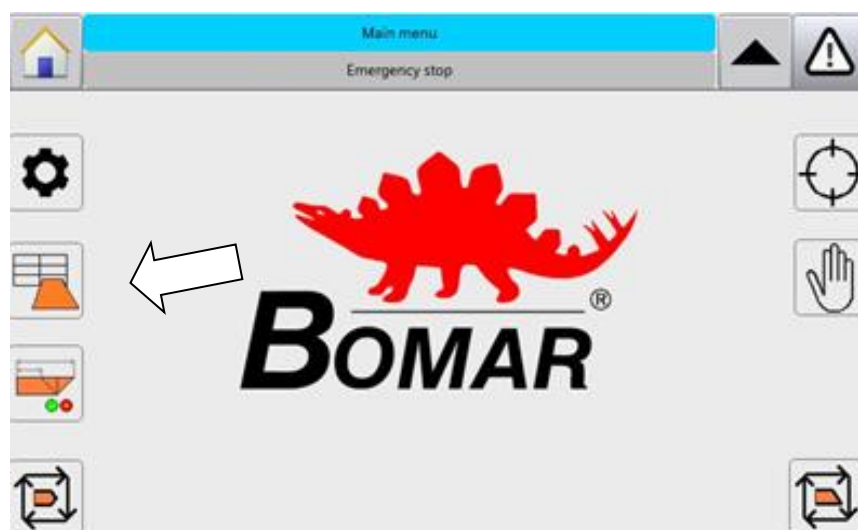
- In the recipe setting menu, you can set up to **21 columns**, each line corresponding to a series of pieces of the same shape, cut in sequence.
- The automatic cycle always starts with the first checked nonzero line of the recipe, and proceeds stepwise by all of the following nonzero lines checked.

3.8.2. Procedure for creation (modification) of a recipe for cutting a single angles

1. On the main screen of the control software, select the option for automatic cycle for cutting a single angle.



2. Then press the option to enter the recipe:

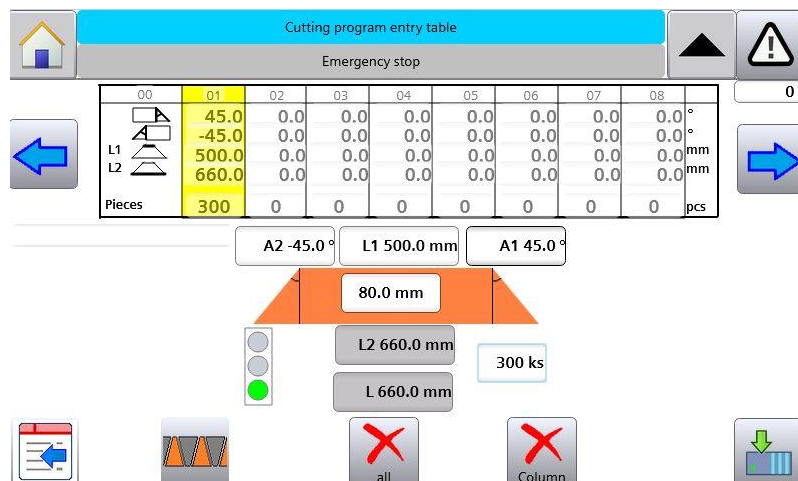


3. This screen appears for setting of a new recipe or modification of an existing one – loaded recipe in the following form:

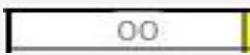
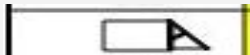
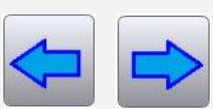
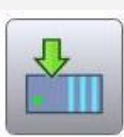
Adjust either the currently loaded recipe on this screen or load a new recipe using



selection – see the procedure described in the section in the chapter about loading a saved recipe.

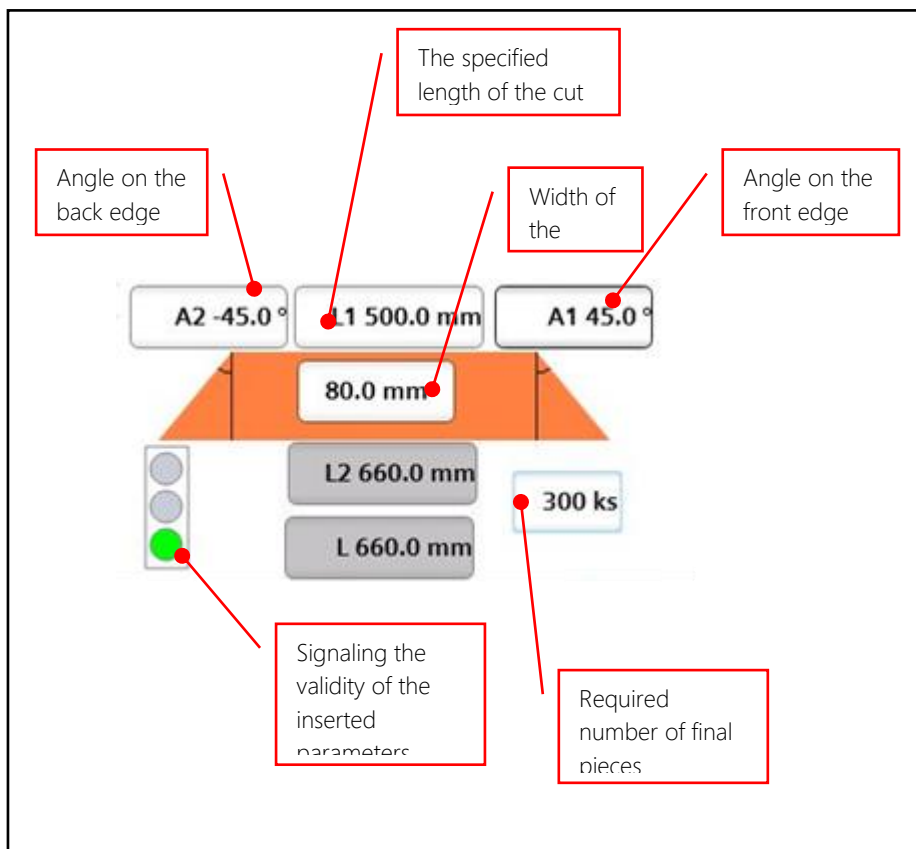


	00	01	02	03	04	05	06	07	08
		45.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0°
		-45.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0°
L1		500.0	0.0	0.0	0.0	0.0	0.0	0.0	mm
L2		660.0	0.0	0.0	0.0	0.0	0.0	0.0	mm
Pieces		300	0	0	0	0	0	0	pcs

Position	Function
	The number of the column
	Angle at the front edge
	Angle at the back edge
	Cut piece length
	Cut piece length
	Required number of final pieces
	Browsing between columns
	Activation of the written recipe When this option is pressed: - the data that are currently written in the recipe will be loaded as the current recipe for the automatic cycle - and the initial screen with options for the material loading and cutting in.

Position	Function
	Access to the menu for saving / loading the entered recipe
	Option to activate/deactivate the cut optimization function Press repeatedly to choose whether the option will be:
- inactive 	
- active 	
	Delete data in the marked column
	Delete the whole content of the recipe

Insertion of the parameters of the final pieces in the listed column



Signaling the validity of the inserted parameters

	The entered data are invalid – the piece cannot be cut
	The desired number of pieces has not been inserted
	The entered data are valid

The entered parameters are copied to the appropriate highlighted column in the recipe table at the top of the screen.

00	01
	45.0
	-45.0
L1 	500.0
L2 	660.0
Pieces	300

4. Activate or save the created recipe for cutting simple angles

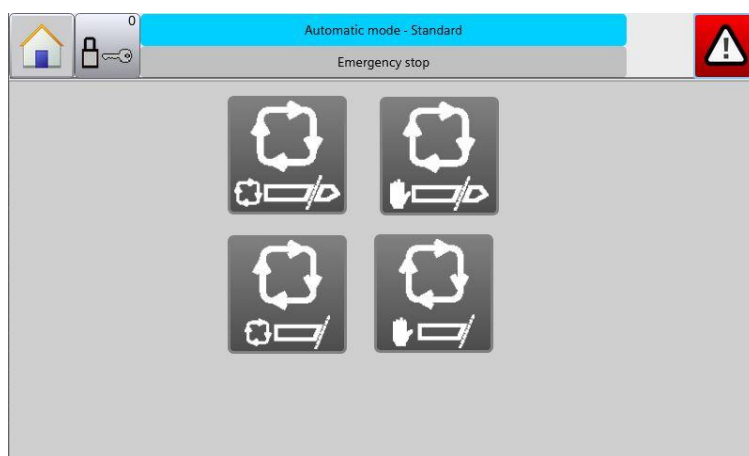
Activation

If you want to use a currently modified or newly created recipe to control the automatic cycle you are preparing, it is necessary to activate the saved recipe by



selecting the selection !

After this selection is pushed, the screen appears with options for the material loading and cutting in



Saving



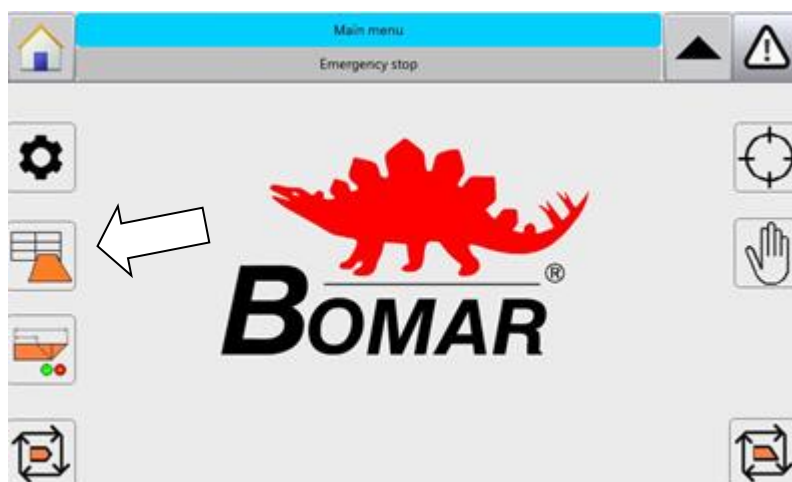
Press icon and follow the chapter " Saving/ loading recipes "

3.8.3. Procedure for creation (modification) a recipe for for cutting multiple angles

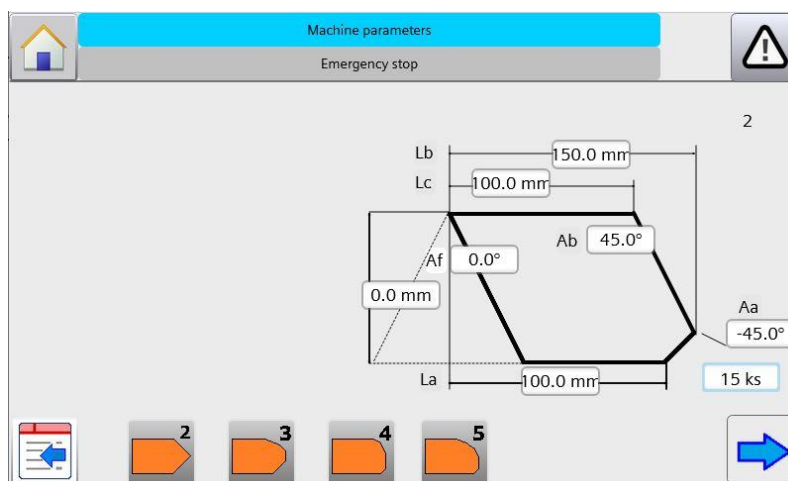
1. On the main screen of the control software, select the option for automatic cycle for cutting multiple angles.

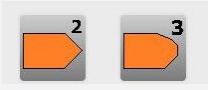
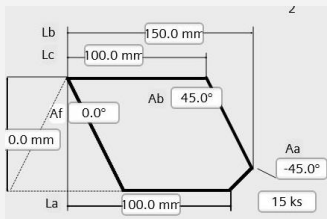


2. Then press the option to enter the recipe:



3. This screen will appear for entering a new recipe or for editing an existing - loaded - recipe in the following form:



Position	Function
	Choose the appropriate shape according to the desired shape of the final pieces
	Insertion of the parameters of the final pieces Enter the required parameters to the active fields
	Access to the menu for saving / loading the entered recipe
	Activation of the written recipe When this option is pressed: - the data that are currently written in the recipe will be loaded as the current recipe for the automatic cycle - and the initial screen with options for the material loading and cutting in.

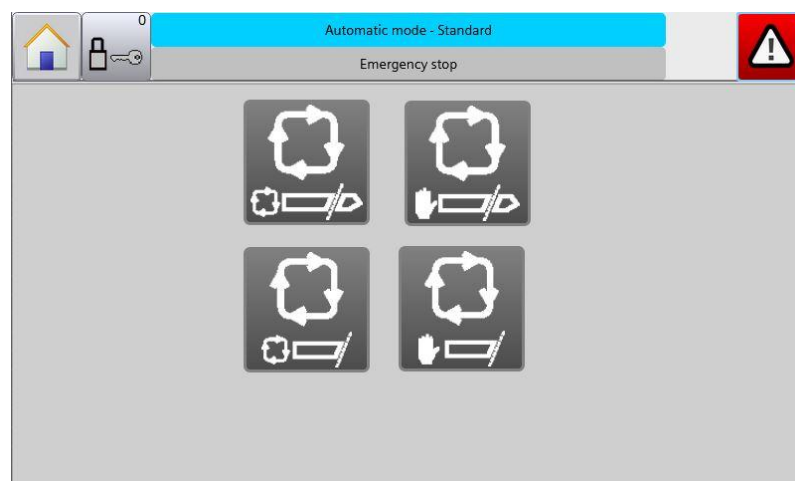
4. Activate or save the created recipe for cutting multiple angles

5. *Activation*

If you want to use a currently modified or newly created recipe to control the automatic cycle you are preparing, it is necessary to activate the saved recipe by

selecting the selection  !

After this selection is pushed, the screen appears with options for the material loading and cutting in



Saving

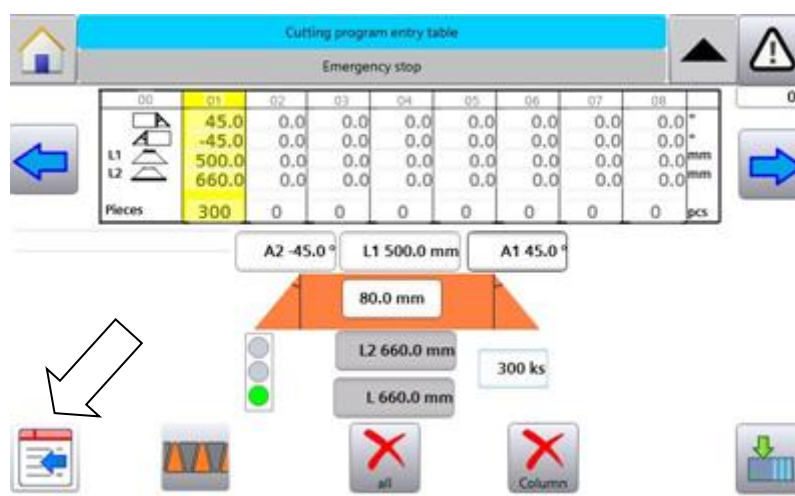


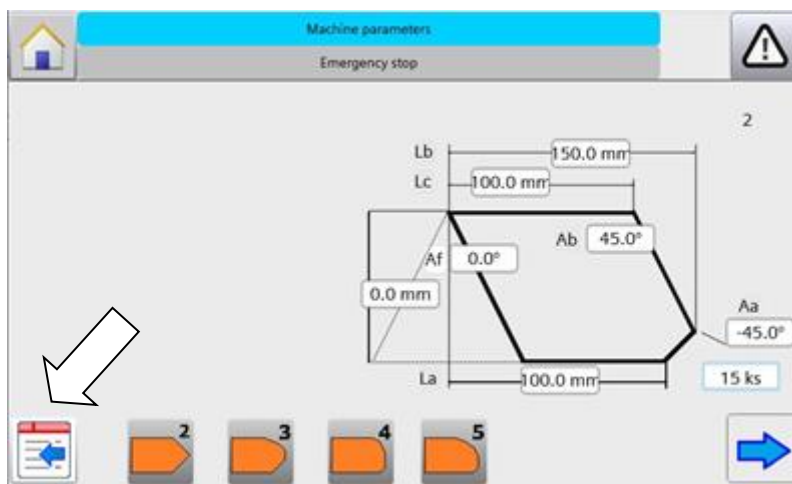
Press icon and follow the chapter "Saving/ loading recipes"

3.8.4. **Saving / loading recipes**

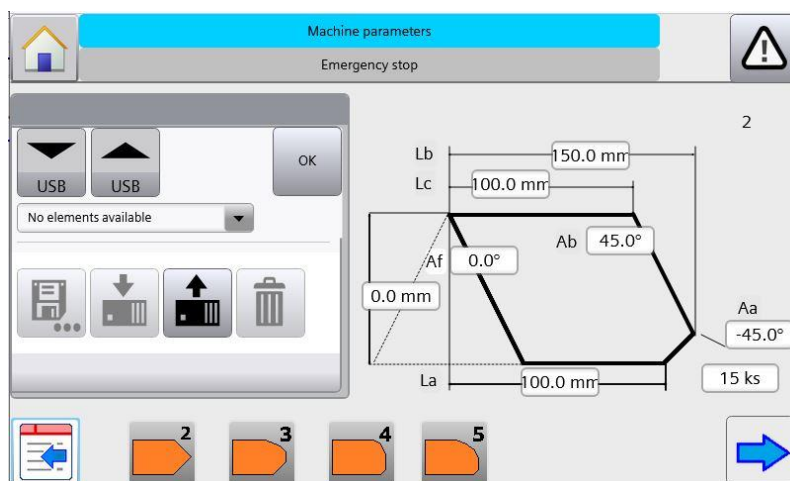
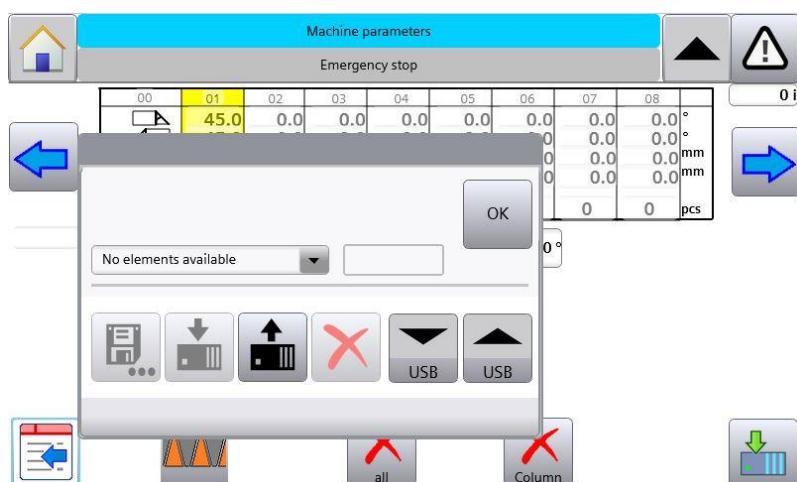
If the created (modified) recipe is not saved, the entered data will be deleted when another recipe is loaded.

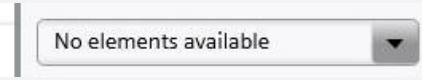
1. Compile a recipe by the procedure described in the chapter on the recipe creation.
2. On the created recipe screen, choose the option for working with recipe files:





3. A field appears for saving and loading recipes



Position	Function
	Return to the previous screen
	List of files A drop-down menu with a list of files that are stored in the given memory
	Save the new file
	Load a recipe from the machine memory Choose required file from the list of files.
	Save a recipe to the machine memory After choosing this option, the user will be asked if he wants to save the file under a new name or if he wants to overwrite one of the already saved files. A window with an input field will be activated for entering a new name. If the user wants to overwrite a saved file, he selects the appropriate file in the file list.
 	Delete the selected file Selects the appropriate file in the file list.
	Load a recipe from USB Choose required file from the list of files
	Save a recipe to USB After choosing this option, the user will be asked if he wants to save the file under a new name or if he wants to overwrite one of the already saved files. A window with an input field will be activated for entering a new name. If the user wants to overwrite a saved file, he selects the appropriate file in the file list.

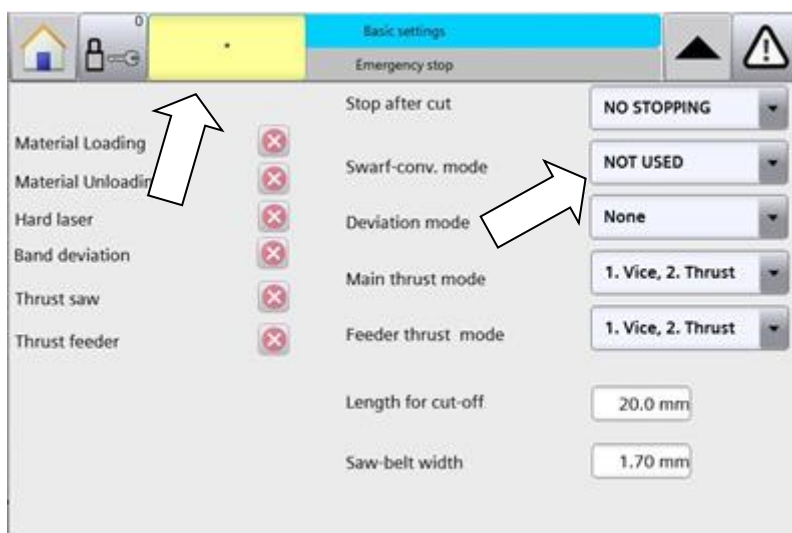
4. Základní nastavení a Nastavení servisních parametrů/ Grundeinstellungen und Einstellung der Serviceparameter/ Basic setting and Setting of service parameters

4.1. Passwords for basic settings and insertion of service parameters

In the individual screens, it is only possible to set the parameters which are coloured immediately or after the password at the certain hierarchical level is entered. Parameters the boxes of which remain uncoloured can only be set at a higher hierarchical level.

Hierarchic level	Password
1	1234
2	3467
3	2468
4	135248

When touching any of the input fields that are not active, the user is prompted to enter a password which protects the field modification.

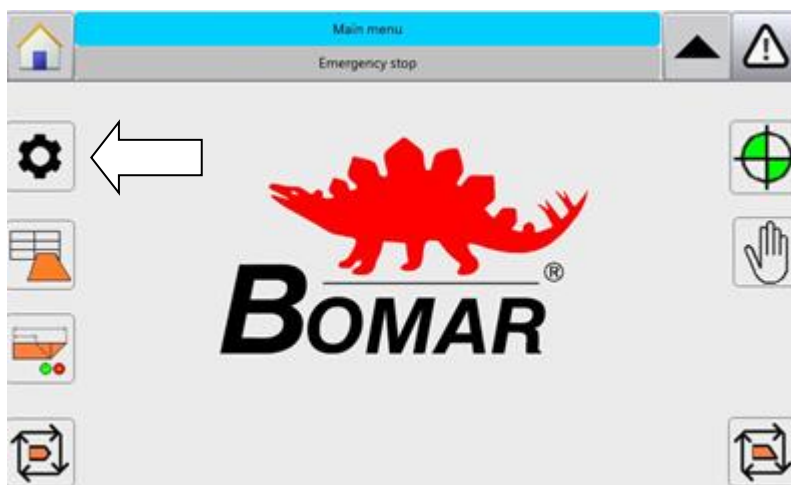


After entering the password, information about the level of the entered password appears.

If the given field can be edited under the password at the specified level, the inactive field will be activated and you can make the edits.

4.2. Entering the menu for basic settings and setting service parameters

1. Choose the option for setting of service parameters in the main screen of the control software



2. This screen appears for menu – settings.

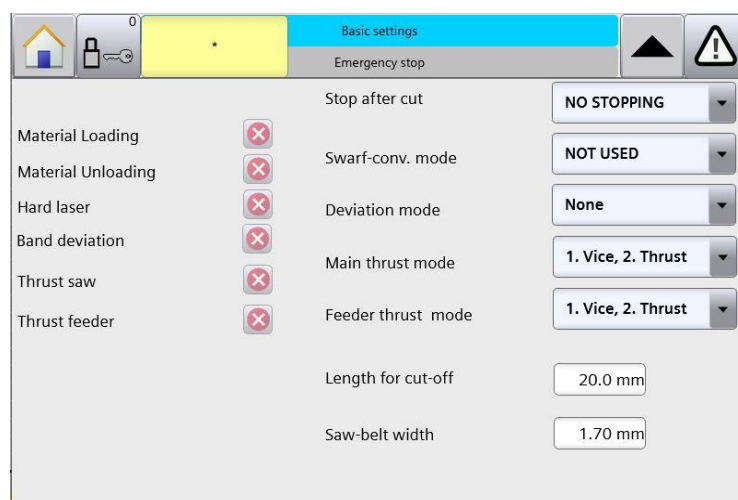
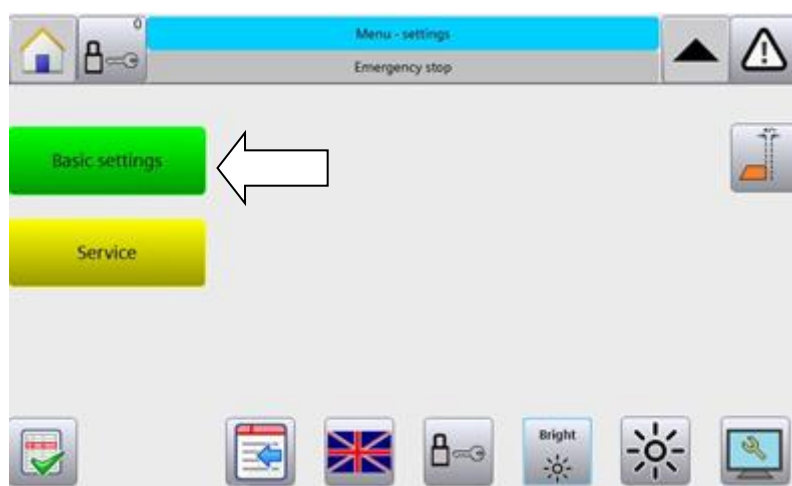


Position	Function
	Icon to enter the alarm archive screen
	After pressing this icon, a screen for saving / loading recipes will appear
	Language selection - by repeatedly pressing the icon, it is possible to go through all the variants available on the machine
	Enter your password

Position	Function
	Darken the panel
	Lighten the panel
	Switching to the service menu of the panel (turn off visualization)
	Entering the Belt Correction Wizard

4.3. Basic settings

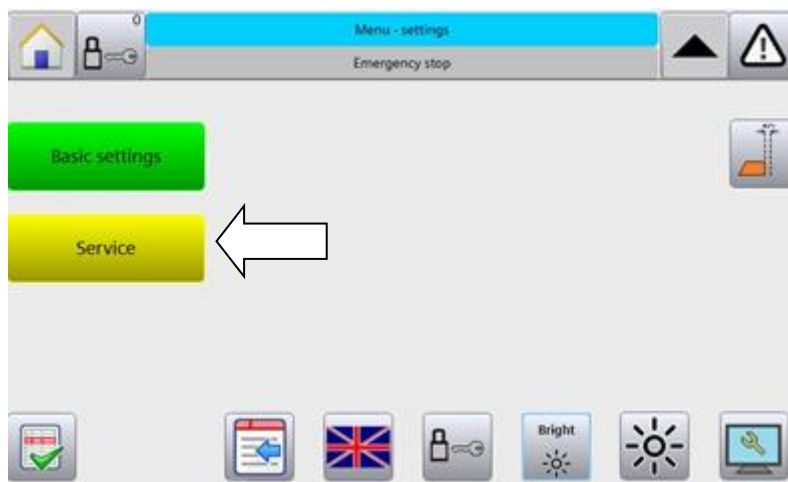
1. Choose the section „Basic settings“ at this screen



2. Touch the field in which you want to change setting and insert the password for activation of this field
3. Make requested settings in the active field

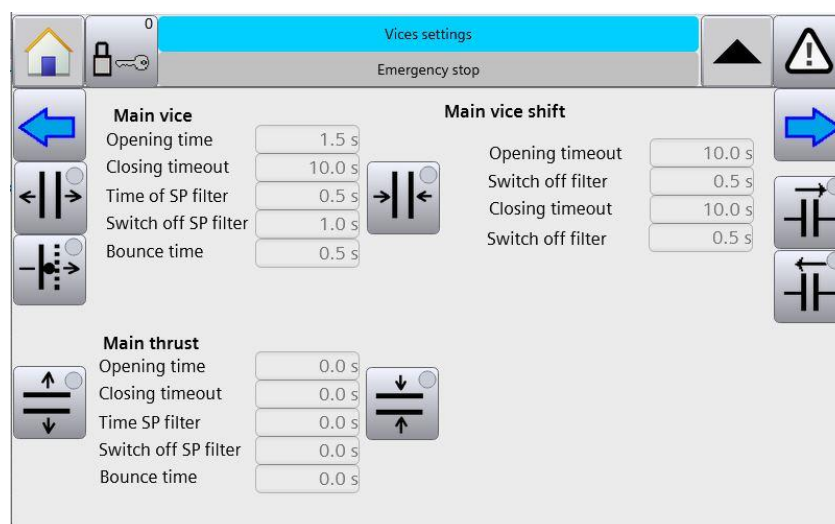
4.4. Settin of service parameters

1. On this screen choose parameter Service

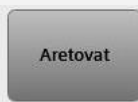


You can browse between screens using the arrows.

4.4.1. Setting the service parameters of the feeder vice



Position	Function
Opening timeout	If after this time it is not signaled that the vice is open, the machine will report an error.
Closing timeout	If after this time it is not signaled that the vice is closed, the machine will report an error.
Closing filter	The time delay after which it is detected that the vice is clamped.
Switch off filter	The time delay after which it is detected that the vice is opened.
Bounce time	The duration of the vce bounce off

Position	Function
Vice measurement	
Vice width measurement Sensor resolution Reference value Feeder vice open position Reference value	Parameters for measuring the vise Do not change the set values without consulting the manufacturer!
	Vice bounce-off
	Release vice
	Clamp vice
	Aretation of the vise

Základní nastavení a Servisní parametry/
 Grundeinstellungen und Serviceparameter/
 Basic setting and Service parameters

4.4.2. Setting the service parameters of the feeder




Feeder parameters




Emergency stop

←

SW limit - 320.0 mm

v



350.0 mm/s

0.0 mm/s

→

Referencing 2632.0 mm

v



400.0 mm/s

SW limit + 2650.0 mm

v



50.0 mm/s

v jog

100.0 mm/s

v min

6.0 mm/s

a

500.0 mm/s²

Sensor resolution

0.025007510

6.0 mm

0.10 mm

0.10 mm

v max

460.0 mm/s

Reference - mode

Reference switch

Laser - saw distance

1055.0 mm

Length of outfeed

250.0 mm

Laser - vice distance

47.5 mm

Vice width

307.0 mm

Min. feeder pos. for load material

1200.0 mm

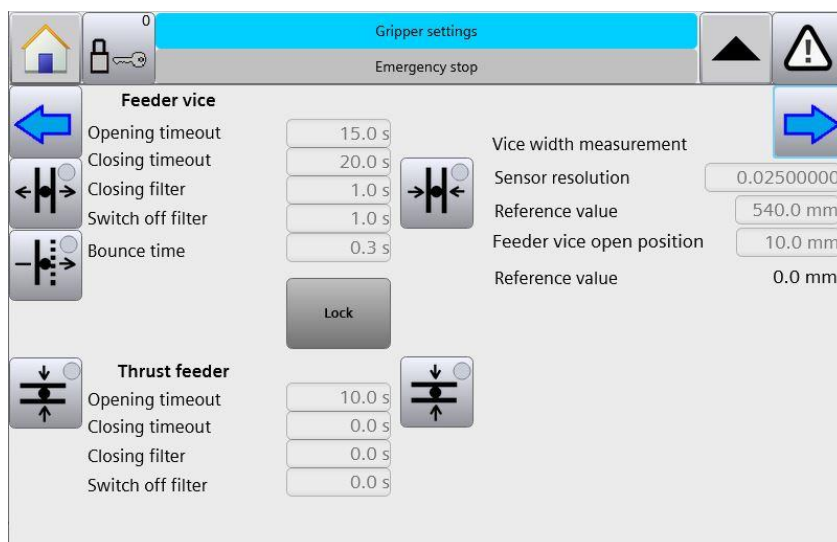
Brake delay

200.0 ms

Unbrake

Position	Function
SW limit - 320,0 mm Referenční 2634,0 mm SW limit + 2650,0 mm	- Setting of minimum allowed unit position - Unit reference position - Maximum allowed unit position
v  350,0 mm/s v  400,0 mm/s v  50,0 mm/s v jog 100,0 mm/s v min 10,0 mm/s	Setting of positioning speed parameters - Speed in manual mode - Accelerated speed for automatic movements - Speed for automatic movements - Travel speed if the machine is not referenced - Maximum speed
a 500,0 mm/s ²	Setting of unit movement acceleration
Sensor resolution 0.025007510  6.0 mm  0.10 mm  0.10 mm v max 460.0 mm/s	Parameters for sensor resolution Do not change the set values without consulting the manufacturer!
Laser – saw distance	The distance of the laser beam on the saw from the nearest edge of the main vice
Length of outfeed	Length which is pushed out after the cut
Laser – vice distance	The distance of the laser beam on the feeder from the nearest edge of the feeder vice
Vice width	Vice width = vice jaw width
Min. feeder pos. for load material	Position to which the feeder moves to clamp the material in the automatic mode with automatic material loading.

4.4.3. Setting the service parameters of the sawvice



Feeder vice

- Opening timeout: 15.0 s
- Closing timeout: 20.0 s
- Closing filter: 1.0 s
- Switch off filter: 1.0 s
- Bounce time: 0.3 s

Thrust feeder

- Opening timeout: 10.0 s
- Closing timeout: 0.0 s
- Closing filter: 0.0 s
- Switch off filter: 0.0 s

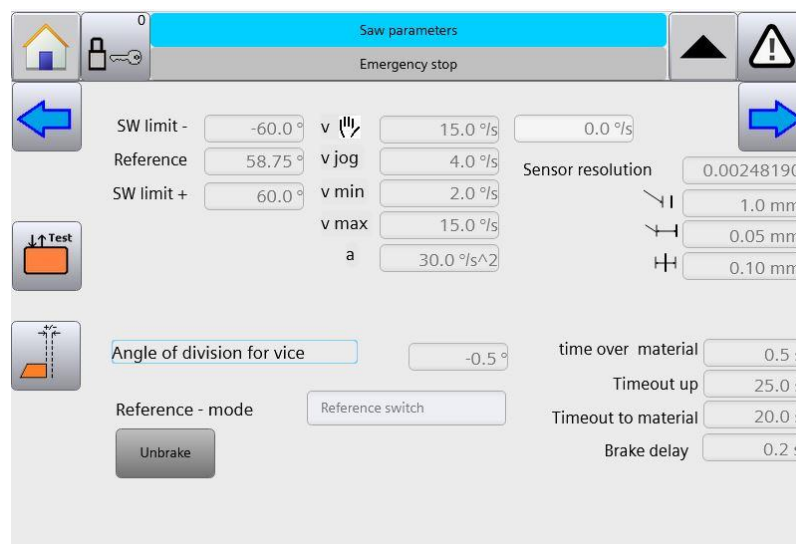
Vice width measurement

- Sensor resolution: 0.02500000
- Reference value: 540.0 mm
- Feeder vice open position: 10.0 mm
- Reference value: 0.0 mm

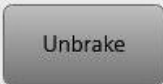
Position	Function
Opening time	Time for opening the vice
Closing timeout	If after this time it is not signaled that the vice is closed, the machine will report an error.
Time of SP filter	The time delay after which it is detected that the vice is clamped.
Switch off SP filter	The time delay after which it is detected that the vice is opened.
Bounce time	The duration of the vce bounce off
Main vice shift	
Main vice shift Opening timeout Switch off filter Closing timeout Switch off filter	Parameters for main vice shift Do not change the set values without consulting the manufacturer!
	Vice bounce-off
	Release vice
	Clamp vice

Position	Function
	Main vice table shift

4.4.4. Setting the service parameters of the saw



Position	Function
SW limit - -60.0 Reference 58.75 SW limit + 60.0	- Setting of minimum allowed unit position - Unit reference position - Maximum allowed unit position
v  15,0 %s v jog 4,0 %s v min 2,0 %s v max 15,0 %s	Setting of positioning speed parameters - Speed in the manual mode - Accelerated speed of automatic movements - Speed of automatic movements - Travel speed if the machine is not referenced - Minimum speed
a 500,0 mm/s^2	Setting of unit movement acceleration
Sensor resolution 0.00248190 ☒ 1.0 mm ☐ 0.05 mm ☐ 0.10 mm	Parameters for sensor resolution Do not change the set values without consulting the manufacturer!
Angle of division for vice -0.5	Limit angle for adjusting the vice table

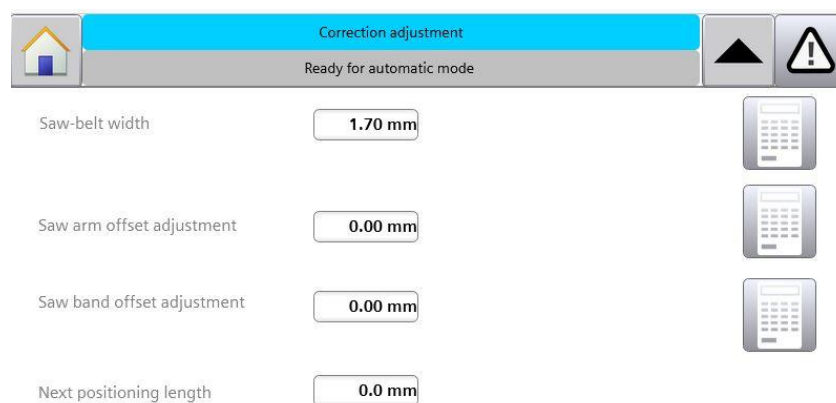
Position	Function
Time over material	Time for the arm to return to the starting position above the material – if the position is not reached after this time, the machine will report an error.
Timeout up	If after this time it is not signaled that the unit reached the position, the machine will report an error.
Timeout to material	If after this time it is not signaled that the unit reached the position, the machine will report an error.
	Stepping of cutting
	This icon will run a simulation of the section for testing purposes. The arm will only reach over the material, it will not start the cut.
	Unbraking the unit

4.4.4.1. Band correction guide (Wizard)

The band correction guide can be started in the screen „Menu - settings“.



The menu enables setting of parameters for the band width correction, band axis offset correction and correction for the arm axis offset.



Position	Function
Saw belt width	Insert real saw band width
Saw arm offset adjustment 0.00 mm Saw band offset adjustment 0.00 mm Next positioning length 0.0 mm	Currently saved values
	Option to enter to the screen for calculation of correction

- Band width correction (Cut-through correction)



Position	Function
Requested	Required piece length Enter the required (set) piece length
Measured	Real piece length Enter the real (measured) piece length
	Option for correction calculation After entering the lengths, push to calculate the correction.
	Confirmation and saving - confirmation and saving of the correction calculation result displayed as a valid value

To perform the off-cut correction:

1. Cut 1 test piece of the material from one bar of the required length with both faces cut at the angle of 0°
 2. Measure the real length of the piece cut off.
 3. Enter the required and really measured length of the test piece in the pertinent entry boxes in the screen for off-cut correction.
 4. Push the option for correction calculation; the machine will determine the off-cut value.
 5. The calculated off-cut value is displayed in the "Band width" box.
 6. If you agree to the result displayed, confirm it; and the value will be saved in the machine memory. At the same time, it will appear in the box on the right of the confirmation option.
- Band offset correction (Band deviation correction)



Position	Function
	Real piece length Enter the real (measured) piece length
	Option for correction calculation After entering the lengths, push to calculate the correction.
	Confirmation and saving - confirmation and saving of the correction calculation result displayed as a valid value

To perform the band-offset correction:

1. Cut 2 test pieces of the material from one bar, with the faces at the angles:

0° and - 45° (1st piece)

-45° and 0° (2nd piece)

- in conformity with the illustration in the screen for the band offset correction.

2. Measure the real lengths of both pieces – in conformity with the illustration in the screen for the band offset correction.

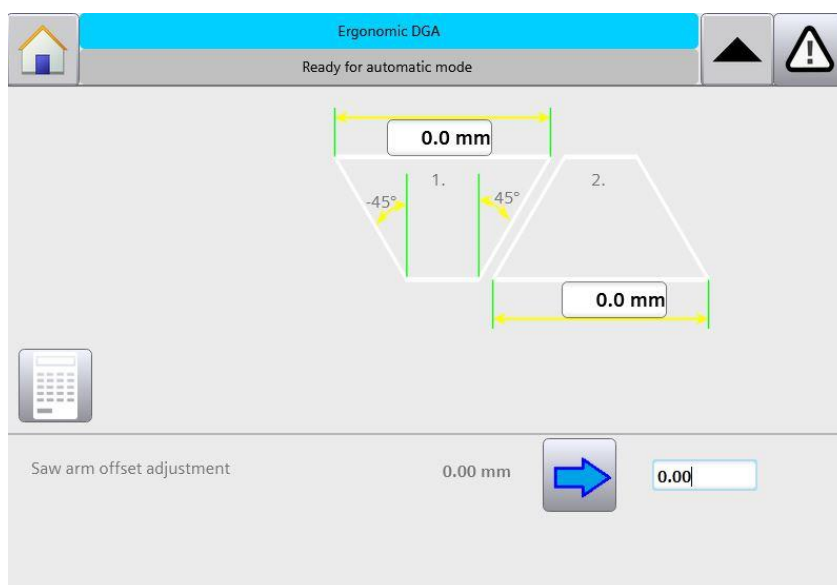
The measured values should be symmetrically distributed around the required value (e.g., if the required value is 100 mm, the resultant measured values should be approx. 95 mm and 105 mm).

If the measured values are not symmetrical, the band deviation correction may have been executed incorrectly; therefore, check and, if necessary, correct the band deviation correction.

If the band deviation correction is correct and the resultant deviations are not symmetrical, consult the manufacturer.

3. If both the resultant deviations are symmetrical, enter both of the lengths measured in the pertinent entry boxes in the screen for off-cut correction.
4. Choose the calculation option; the machine will determine the off-cut value.
5. The calculated off-cut value is displayed in the "Band width" box.
6. If you agree to the result displayed, confirm it; and the value will be saved in the machine memory. At the same time, it will appear in the box on the right of the confirmation option.

- Arm axis offset (Arm deviation)



Position	Function
	Real piece length Enter the real (measured) piece length
	Option for correction calculation After entering the lengths, push to calculate the correction.
	Confirmation and saving - confirmation and saving of the correction calculation result displayed as a valid value

To perform the arm axis-offset correction:

1. Cut 2 test pieces of the material from one bar, with the faces at the angles:
+45° and - 45° (1st piece)
-45° and +45° (2nd piece)
- identically to the illustration in the screen for the band offset correction..
2. Measure the real lengths of both pieces – identically to the illustration in the screen for the band offset correction.
3. The measured values should be symmetrically distributed around the required value (e.g., if the required value is 100 mm, the resultant measured values should be approx. 95 mm and 105 mm).
4. If the measured values are not symmetrical, this may have been caused by inaccurate material dimensions. Cut and evaluate material samples with accurate dimensions.

If the material dimensions are accurate, the band deviation correction may have been executed incorrectly; therefore, check and, if necessary, correct the band deviation correction.

If the material dimensions and band offset corrections are all right, but the resultant deviations are not symmetrical, consult the manufacturer.

5. If both the resultant deviations are symmetrical, enter both of the lengths measured in the pertinent entry boxes in the screen for off-cut correction.
6. Choose the calculation option; the machine will determine the off-cut value.
7. The calculated off-cut value is displayed in the "Band width" box.

If you agree to the result displayed, confirm it; and the value will be saved in the machine memory. At the same time, it will appear in the box on the right of the confirmation option.

5. **Seřízení stroje/ Einstellen der Bandsäge Machine setting/**

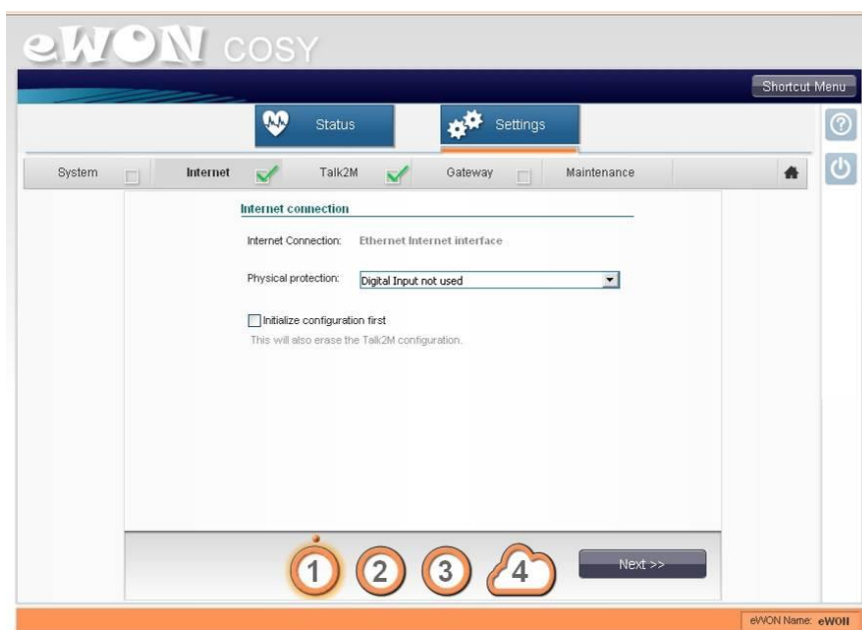
5.1. Remote control (optional accessories)

5.1.1. Connection for remote control - requests:

The speed of internet connection has to be at least 2 MB/s.

5.1.2. Setting of Ewon Router COSY

1. Connect private Laptop to one of the LAN port of our EWON router.
2. Set the IP address of laptop's network card to 192.168.77.100 (forbidden to use addresses 192.168.77.1– 99).
3. Open internet browser and write address 192.168.77.10 to address line.
4. Main screen appears -> Click on Settings and set user: adm and password: adm.
5. Click on folder Internet. Physical protection has to be set to **Digital Input not used**.



6. Click Next button and configure your WAN IP address according your internet provider.



7. Click Next and execute Test of internet connection. If test passed internet connection should be set properly.

Note: You can test it by connecting the ethernet cable to your laptop with same setting of network card like eWON has and you suppose to be able browse on internet.

8. After that click on Talk2M folder and choose Register with ACTIVATION KEY .



9. To column write the activation key from e-mail and click Next.
10. Execute Test. If test passed the setting is completed and we can test it from our site.

5.2. Set off the sleep mode oft he display

The sleep mode can be set on the display. That means - if no touch is made on the display for a longer time, then after the time which was preset as a waiting period for switching of the touch screen into sleep mode, the display will be automatically switched to Sleep Mode - thus the preset background will be displayed on the touch screen.

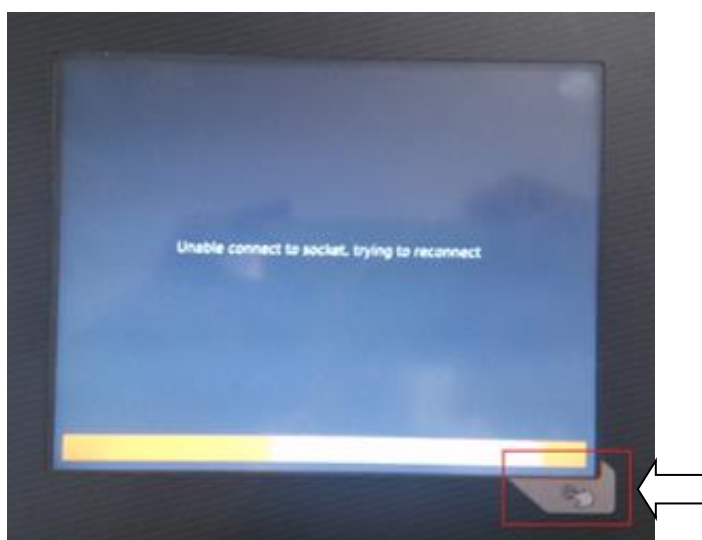
The display that was switched to the sleep mode can then be revived by a touch.

These parameters were adjusted for the sleep mode of the display by the producer:

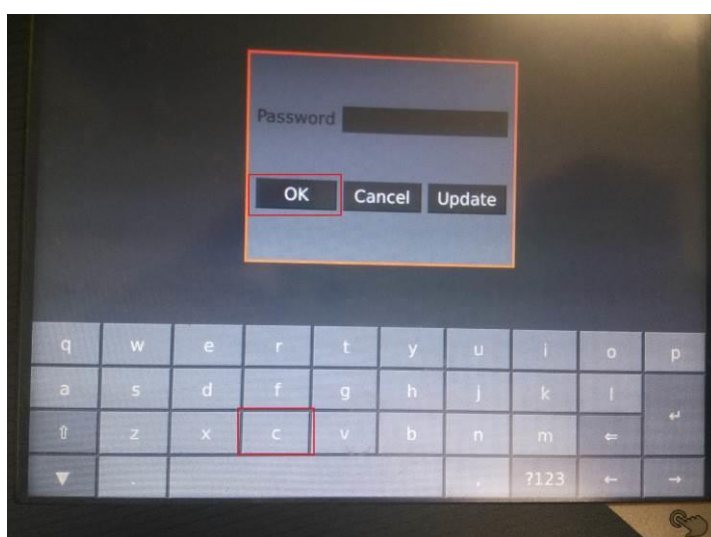
- Sleep Mode - active
- the time period for waiting before switching the display to the sleep mode – 30 min.
- standard image for the sleep mode is a black background

If you want to change the parameters which were preset by the producer follow these instruction:

1. Press the the button for the display setting and keep it pushed for a few seconds

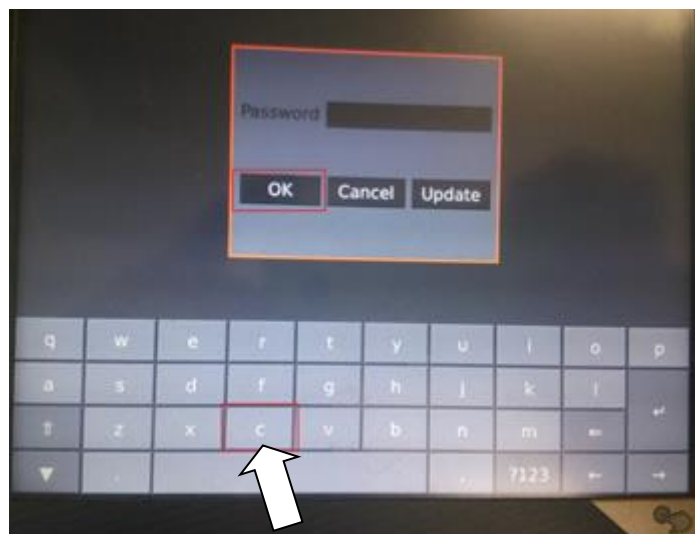


2. The keyboard and the appeal for the password insertion appear.

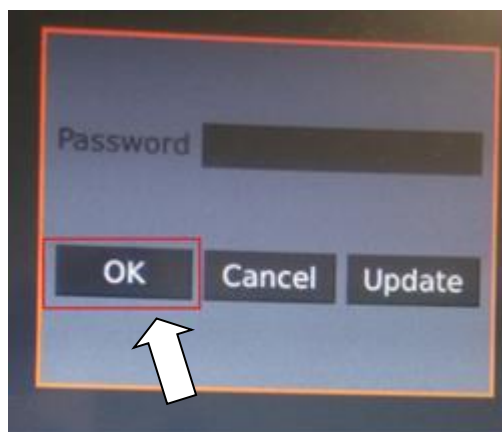


3. Insert the password - into the field for the password insertion

The password is: c



4. Confirm the inserted password with the selection OK.



5. The screen with the menu for control of the display appears. Choose the selection „Screen” on this screen and the menu with offers for display setting appears.



6. It is possible to change the time period for waiting for display sleep mode in the field „Screensaver“. The period can be changed using symbols .



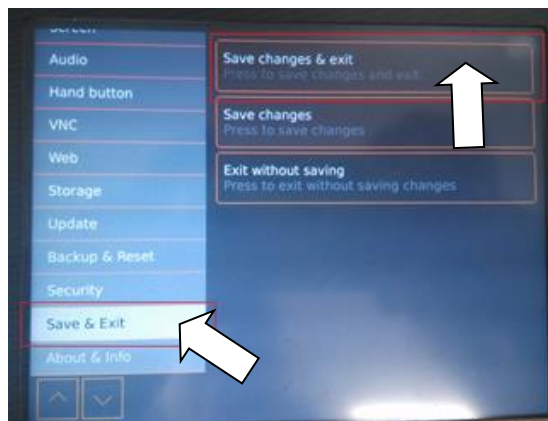
The set time is displayed next to the symbols  and it can be changed in the range of 0-60min.



7. After the time period is set, check if the selection for switching of the display to the sleep mode is checked.



8. Pro uložení nastavení spánkového režimu displeje zvolte volbu „Save & Exit“ a ve zobrazeném menu zvolte „Save changes & Exit“.
9. To save the selections for switching of the display to the sleep mode choose the selection „Save & Exit“ and then choose „Save changes & Exit“ in the next displayed menu.

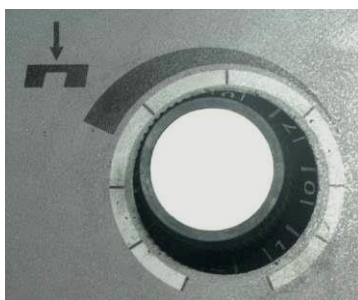


The adjusted selections will be saved and the display will be switched to the sleep mode.

5.3. Machine setting

5.3.1. Setting of the frame lowering speed

Frame lowering speed is set by valve on the control panel.



- Turn clockwise to decrease frame lowering speed.
- Turn counterclockwise to increase frame lowering speed.

Note:

If the throttle valve is closed too tightly, the valve seat may be damaged and may start to leak. Tighten the valve lightly.

5.3.2. Setting of the cutting speed

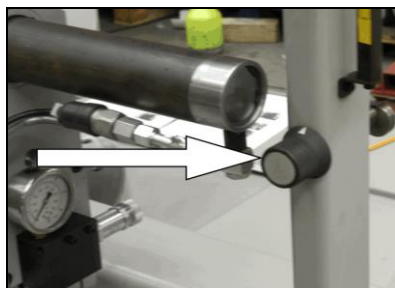


The speed of the saw band can be gradually adjusted from 20 to 120 m.min⁻¹. Set the speed as follows:

- Set the switch of the frequency changer on the control panel (position **6**) to required speed. The band speed is displayed during *semiautomatic cycle*.

5.3.3. Frame bottom stop position setting

The bottom stop position of the frame limits the lowest position of the frame. This position must be checked once per month. In case of wrong setting the vice may be cut or the material is not cut completely.



Setting of frame bottom stop position is made by adjustable eccentric on the frame beam.

5.3.4. Setting of optimum distance of the guiding cubes

In order to maintain stable cut and sufficient precision, it is necessary to place the left guiding cube as close to the cut material as possible.

1. Switch off the hydraulics.
2. Release guiding listel lever.

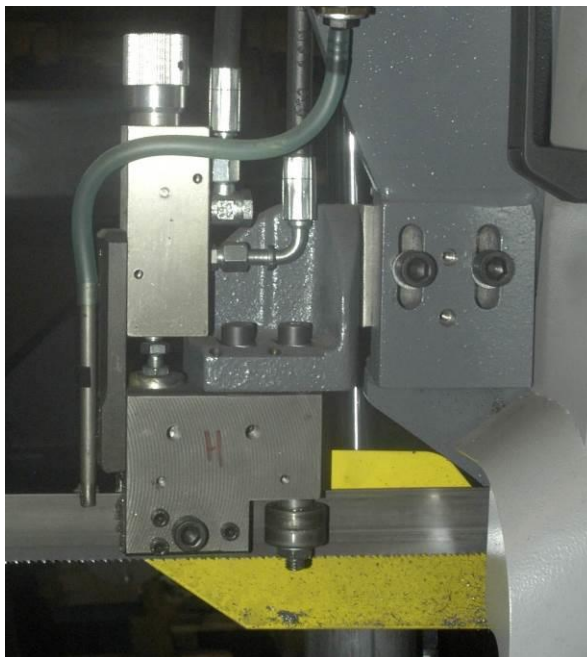


3. Move left part of the guiding so the edge of the left guiding cube is as close to the cut material as possible.
4. Tighten the levers and check position of the guiding cube.

During adjustment pay increased attention to prevent collision of the device for setting of the arm lifting (fast feed brake) with the cube at cutting!

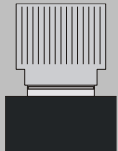
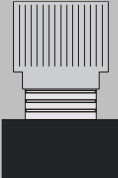
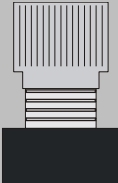
5.3.5. Pressure adjusting to the cut

The band saw ergonomic 320.250 DGH is equipped with cutting pressure regulation on the right guiding cube.



Pressure setting is performed with regulation wheel on the guiding cube..

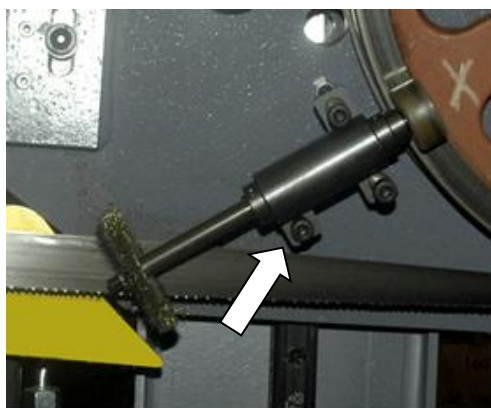
Downfeed	Description
<i>downfeed pressure is bigger</i>	Screw on the wheel
<i>downfeed pressure is smaller</i>	Screw off the wheel

	One visible neck Solid material over Ø200 mm.
	Two visible necks Solid material to Ø80 - Ø200 mm.
	Three visible necks Pipes and shaped material with surface from 10 - 15 mm. I - shaped material from 200 - 280 mm. Solid material to Ø80 mm.
	Four visible necks Pipes and shapes material with surface to 10 mm. I - shaped material to 200 mm .

5.3.6. Brush setting

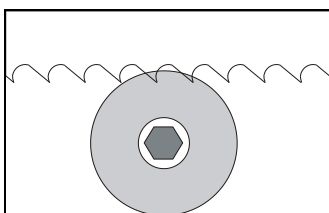
The brush for chip removal from the saw band influences cutting durability, saw band lifetime and wheels lifetime, hard metal guides and finally the cut accuracy. **Brush adjustment must be checked every shift.**

1. Open the cover of the band arm



2. Adjust the position of brush to the saw band by turning the adjusting screw(see arrow) of the brush.

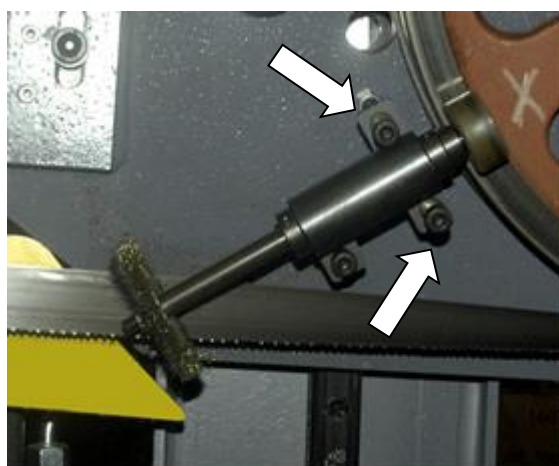
The brush must touch with teeth of the saw band.



Attention!

*The brush **must not** touch the bottom of the saw teeth!*

3. In case, that the brush is not turned right (driving wheel of the brush slips on the driving wheel of the saw band), push by means of the screws (see arrows) driving wheel of the brush to the driving wheel of the saw band.



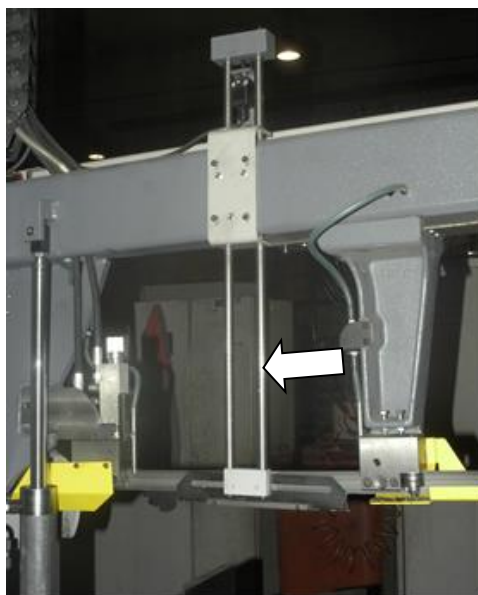
Attention!

The screw must not be tightened with heavy force, because driving wheel of the brush can be damaged or the lifetime of the bearings of the driving wheel of the band can be lowered!

Mount the brush cover back to its place / close saw arm cover

5.3.7. Device detecting the arm position above the material

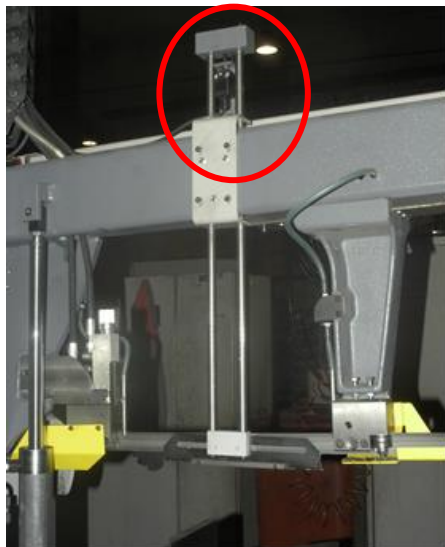
The device is installed on the machine to detect the arm position above the material.



The device is used to adjust the arm lifting:

1. Before the first cut, lift the arm to the uppermost position.
2. Insert a material into the vice
3. If the arm is lowered to cut from a sufficient height above the material, the fast feed can be enabled automatically or manually.

4. If the device arm gets into contact with the material, the limit switch is activated and the arm movement slows down automatically to the preset speed of the arm feed to cut..



5. Then, in the automatic cycle, the arm is lifted only to the height above the material until the limit switch is reactivated.

The device is also used to control the arm lowering to cut:

1. After starting the cut, the arm moves with fast feed.
2. If the device arm touches the material, the speed is switched from fast feed to the preset speed of the arm lowering to cut..

The device has been adjusted by the manufacturer, do not interfere with the adjustment!

Regularly check the free running of equipment and keep sliding surfaces of guiding rods clean and lubricated!

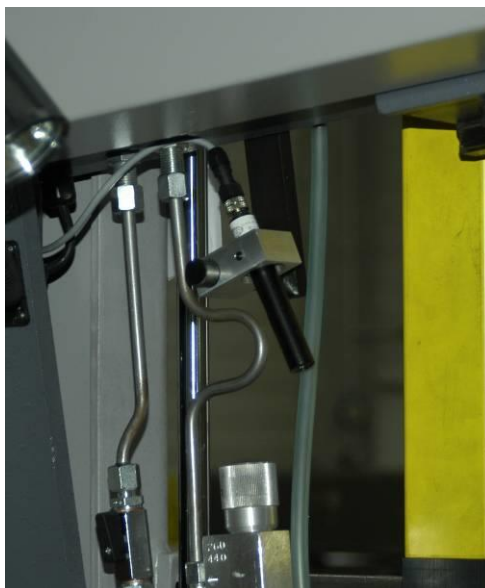
In the event that the arm does not fall into the cut, check the status of the device, especially if it is not released limit switch or bent guide rod.

In case of a fault, contact the manufacturer!

5.3.8. Laserliner – optional accessory

The device is used to ascertain exact position of the material cut before cutting.

The cut is indicated by the laser beam projected on the surface of the prepared material..



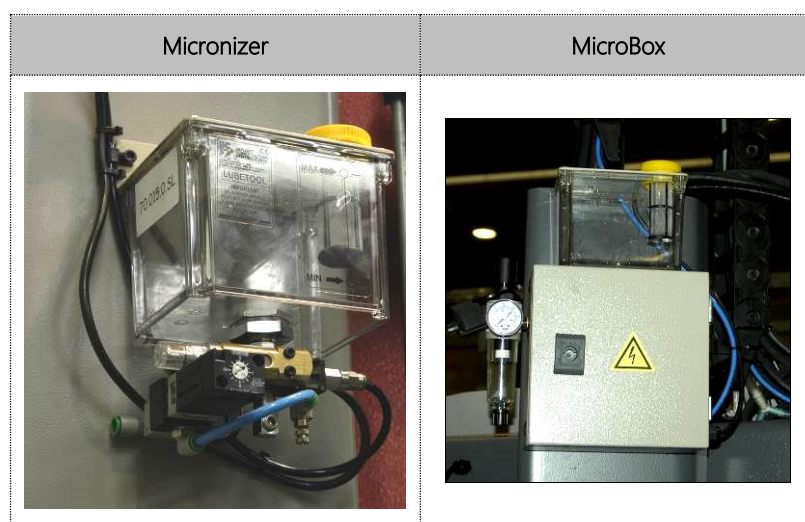
The switch for Laserliner is located on the control panel..

5.3.9. Mikroniser and MicroBox) – mist lubrication

The placement of a Microniser at the machine is pursuant to this photo

Next photos are for illustrative purposes only.

Microniser and MicroBOX are devices used to create a lubricating oil mist in precise doses of oil and air mixture, which is then applied directly to the saw band.



The device serves for ideal cooling and lubrication of the cutting blade when closed profiles are cut, and helps to maximize ease of cut.

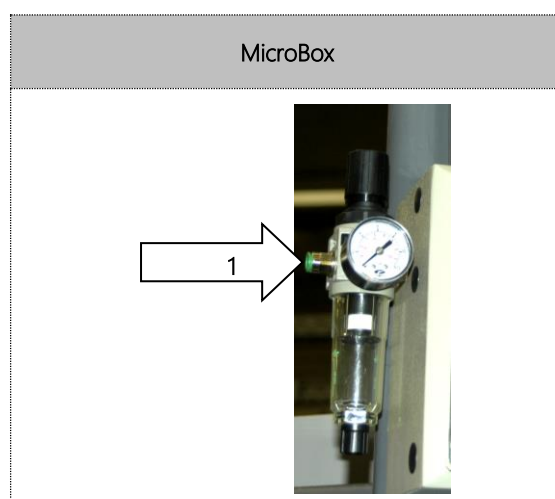
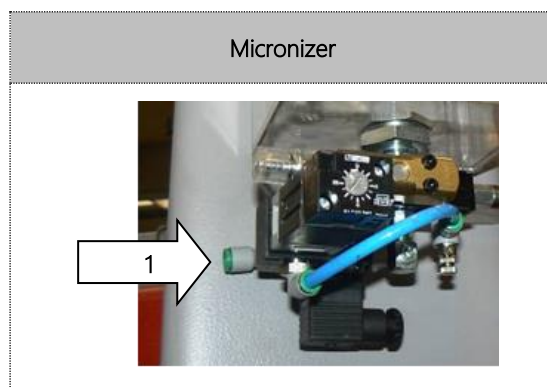


There is no leakage of coolant outside the work area of the saw when a profile material is cut.

The device is suitable for all Bomar saws.

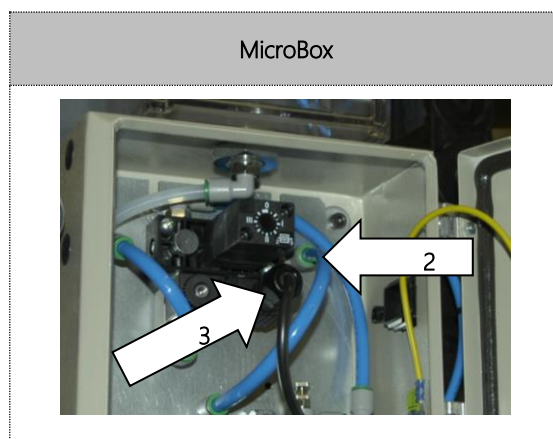
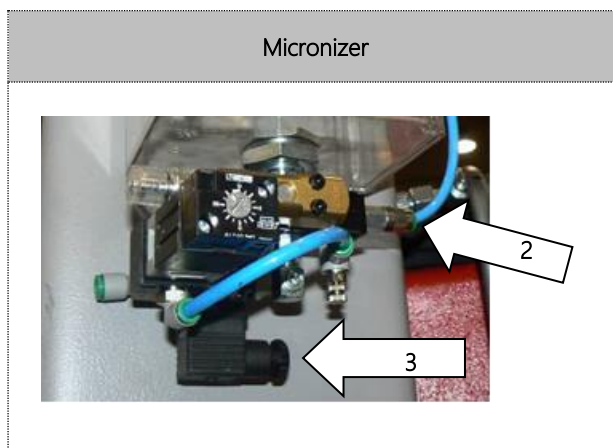
.Microniser setting:

1. For proper function of the Microniser pressured air (in the range of 0.5 to 0.5 MPa (5-6 bar)) must supplied from the pneumatic system (dry, clean, free of particles) see - arrow 1

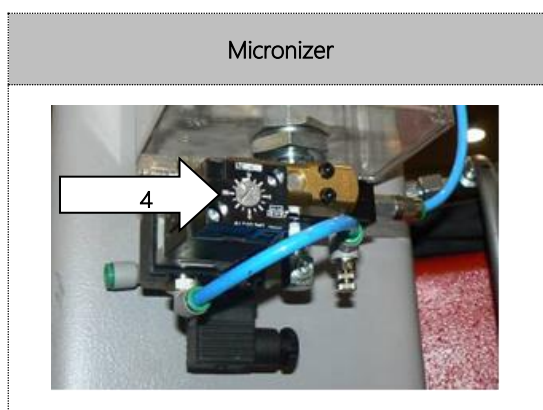


2. Arrow **2** - shows the output of the cooling medium (air + oil).

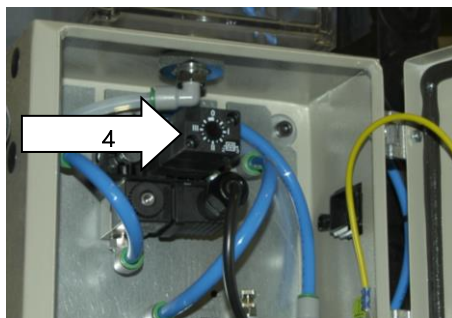
Arrow **3** - shows the inlet for the power supply cable.



3. Set the interval of cutting oil dispersion on the Micronizer- **arrow 4** (3-20 pulses / min.). Adjust this interval to the parameters of the saw band and cut material.

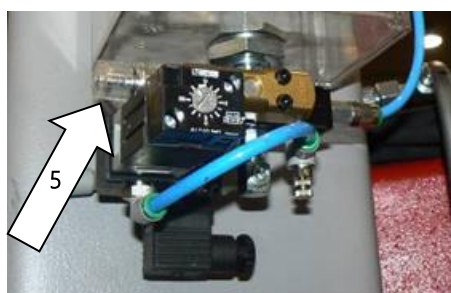


MicroBox

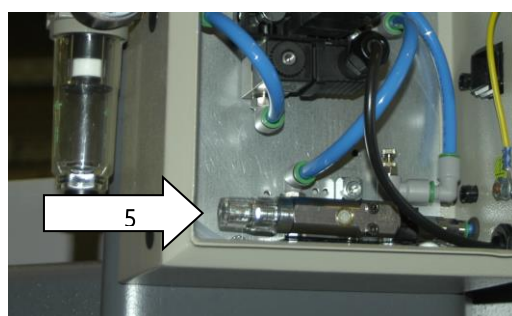


4. Adjust the amount of oil with a regulator - arrow 5

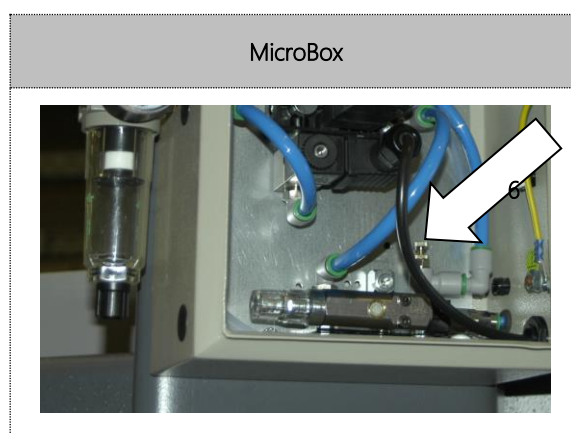
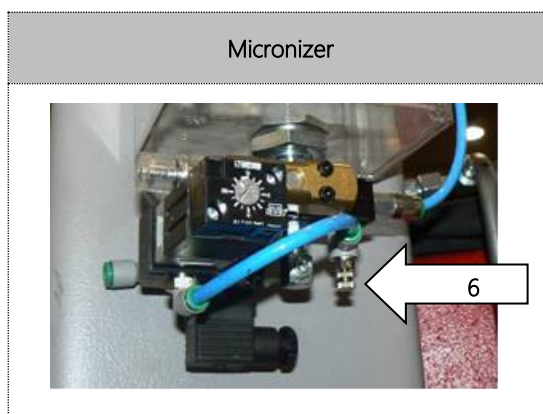
Micronizer



MicroBox



5. Setting the air quantity using another regulator - arrow 6



6. Switching on / off of the Microniser is depends on the control system of the machine it is installed on. See chapter "Machine control".

Recommended cutting oils for Micronisation:

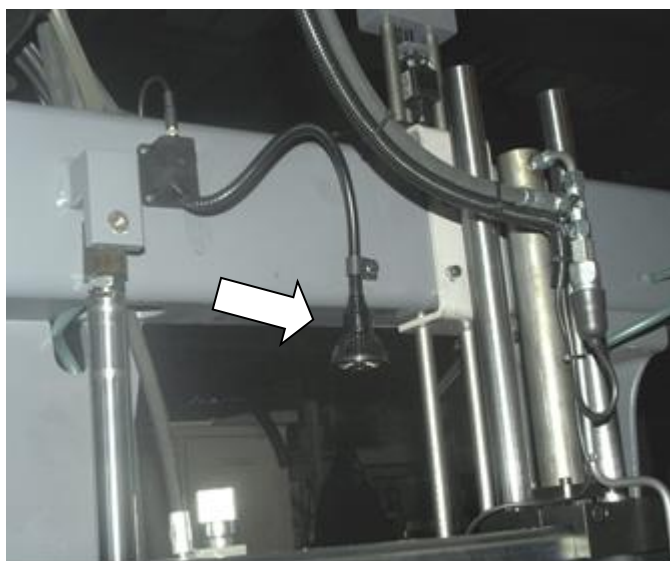
Manufacturer	Cutting oil
Biona	Biocut
Paramo	Paramo cut 22

Featured are cutting oils with viscosity class 22.I

Adding of the coolant is possible after removing the filling cap. After the filing is finished the cap must be screwed in again.

Package Includes: a tank with regulators, connection 6m hose, diffuser.

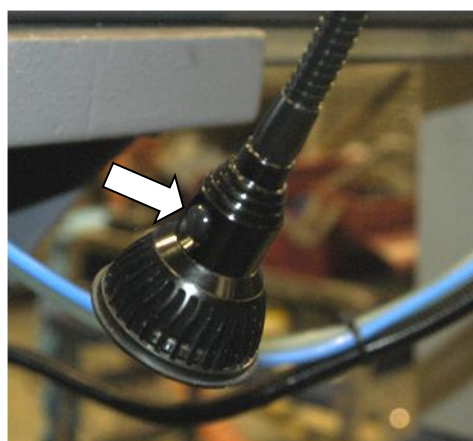
5.3.10. Halogen lighting of working area (optional accessory)



Light the working area of the machine with natural light and helps to facilitate cutting with a band saw.

Proper lighting in your work area greatly enhances ergonomics machines

Turn on and off light switch is made directly to the halogen light.



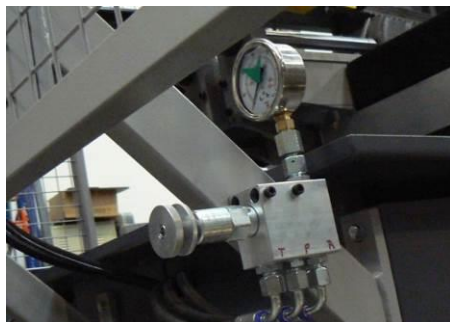
Design lighting unit meets IP54 - Protection against water jets.

Technical data halogen light :

Supply voltage	230 V
Lenght flexible arm	300 mm
average	Ø 5,5 mm
lenght	80 mm

5.3.11. Device for regulation of clamping pressure (optional accessory)

The hydraulic pressure device is determined for pressure setting on the main vice and feed vise.

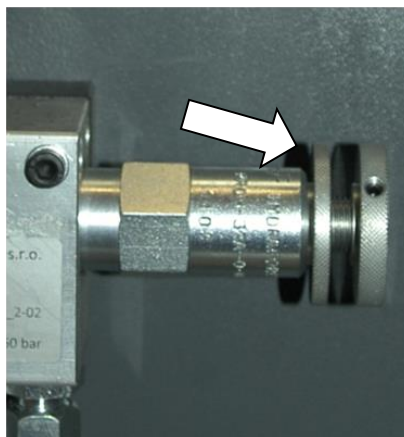


Warning !

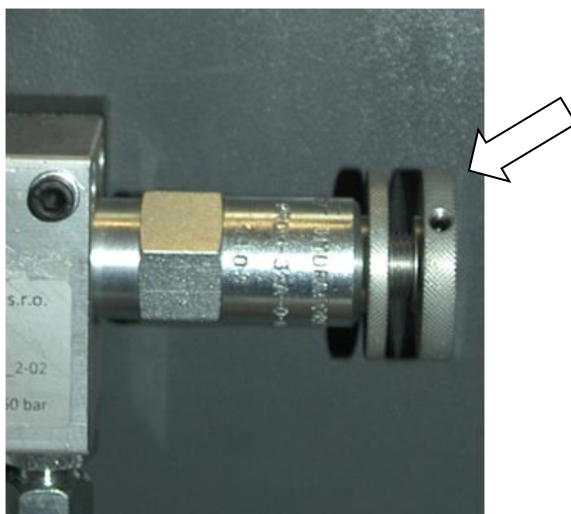
*Because the hydraulic pressure equipment pressure **2,2 – 4 MPa**, loosen the screws with caution!*

Instruction for adjustment of clamping pressure

1. Release the locknut of the control screw at the pressure valve



2. Adjust the clamping pressure to the required value using the control screw.



- When turning the pressure valve *clockwise the pressure increases*.
- When turning the pressure valve *counterclockwise lowers the pressure*.

The indicator at the manometer at the device for clamping pressure adjustment indicates the set value.

The recommended pressure value is between the values defined through the green arrows at the manometer at the device for controlling of the clamping pressure.



3. Tighten the locknut of the control screw at the pressure valve.

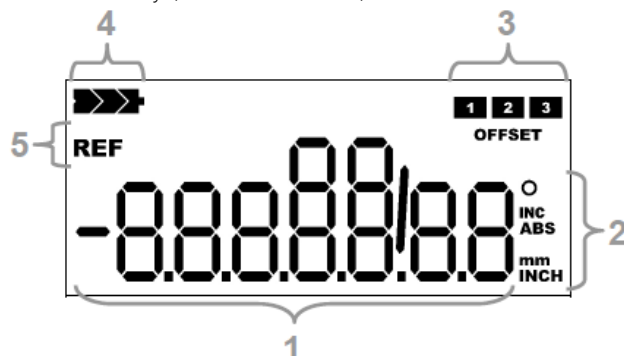
Attention:

It isn't necessary to adjust the hydraulic pressure of the whole saw in order to adjust the clamping pressure

5.3.12. Electronic measuring device (optional accessories)

Zero position setting

Push the Incr/Abs key (even several times) until "0" is shown on the display.



Digital measuring adjustment

Position	Description
1	Current position
2	Unit, measuring mode
3	Active additional constant (* key)
4	Battery status
5	Reference record shall be made – after the apparatus is switched on.

Description of key functions:

Key	Stop mode	Setting mode
	Basic key	Entering parameters (3 sec) Saving parameters and returning (3 sec)
	Reference recording (P09 value)	-
	Change of displaying in inches	Selection of following decade
	Absolute and incremental measuring	Change of active decade o +1
	Selection of additional constant	Change of sign

Description of key functions at measuring initialisation:

Key	Description
	Induces calibration of the apparatus when it is switched on (battery inserted).

Key	Description
	Induces calibration of the apparatus and sets default values when the apparatus is switched on.

Description of digital measuring parameters:

Parameter	Description	Default value
P01 A	Measuring configuration: A = 0: positive direction of measuring A = 1: negative direction of measuring	0
P02 A	Measuring unit: A = 0: mm / symbol "mm" A = 1: inch / symbol "Inch" A = 2: mm / symbol "m" A = 3: mm / symbol "°" A = 4: mm / no symbol	0
P03 A	Decimal point (0...4) > only for mm	2
P05 ABC	Key blocking: A: "Set" key (0 = active / 1 = inactive) B: "Incr/Abs" key (0 = active / 1 = inactive) C: "°" key (0 = active / 1 = inactive)	000
P08	Correction factor (0.0001...9.9999)	1.0000
P09	Reference (-9999999 ... +9999999)	0
P10	Additional constant 1 (-9999999 ... +9999999)	0
P11	Additional constant 2 (-9999999 ... +9999999)	0
P12	Additional constant 3 (-9999999 ... +9999999)	0
P13 A	Configuration of additional constants (0...3) A = 0: inactive (cannot be selected) A = 1: Additional constant 1 active A = 2: Additional constants 1 & 2 active A = 3: Additional constants 1 & 2 & 3 active	3
P90	No function	0
P99	Displaying firmware version	x.xx

5.3.13. Speed adjustment of the arm lowering (optional accessory)

The current speed of vertical movement of the arm is displayed on a digital display which is mounted on the saw arm.

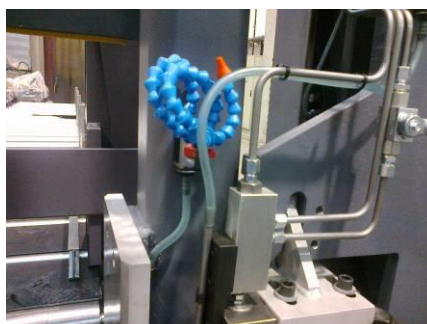


The measuring unit is set by the manufacture.

5.3.14. Third cooling inflow (optional accessory)

Flexible coolant supply allows to bring the coolant to the desired location.

Third, easily routable and adjustable coolant supply with nozzle ensures sufficient lubrication and cooling of the strip in the middle of the cut material



Particularly suitable for cutting materials with a larger average, where the opening of the guide blocks larger blade and prevents proper lubrication and cooling of the entire length of the cut

For normal cutting off the third coolant inflow may be easily disconnected by closure



When adjusting the nozzle, pay increased attention that the inlet hose does not stand in the way of the saw band.

The third coolant inflow get in the package complete package including all jumpers and hoses - just connect to existing cooling divorce

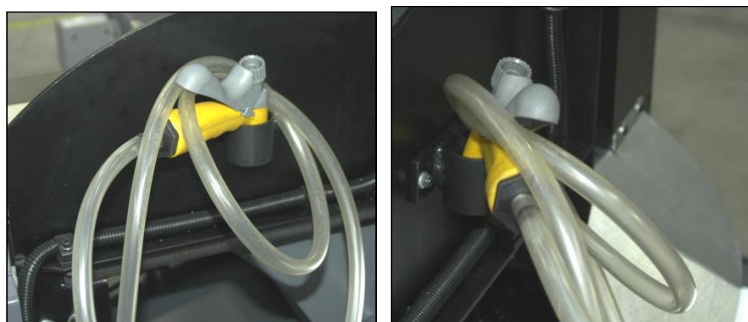
Complete package includes: flexible hose (length 600 mm), shunt valve, inlet plastic hose (depending on the type of machine - min. 1m), interconnection schedule, holderto the machine screws (2xM5), transformer and wiring.



5.3.15. Tool cleaning machines from chips after cutting. - optional accessory

The tool can be used for cleaning of a machine from chips which were produced during cutting proces.

As a cleaning liquid is used coolant which spouts from the nozzle of the „gun“ when its handle is pushed down.



With custom pump (min. capacity 16 l / min.) The coolant gets into the rinsing pistol with the trigger lever.

Sufficient pressure to the chips and debris were eliminated from the bearing surfaces of the base material and the saw.

Gun cleaning machine from the chip is supplied with a sufficient supply hose for easy handling (diameter of 12/8 mm).

Package includes:.

1. Ergonomic handle allows easy handling of the gun during cleaning machine.



2. Brass adjustable nozzle allows for smooth width rinse stream.



3. Valve for setting maximum coolant flow



4. Also included is a convenient holder for postponement gun after use



5. Connecting part equipped with a transparent tube with a connecting part for coupling the cleaning pistol to the pump.



6. Transparent inlet hose to couple the pistol to the connecting part.



Suitable for machine brand Bomar

5.4. Material insertion

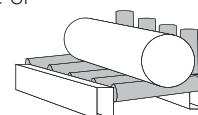
- Never walk under a suspended load!
- Never climb onto the gravity-roller conveyor!
- Do not hold the material for clamping material to the vice! The vice can cause injury!

5.4.1. Handling agent selection

- Use the strong handling agents to lift and transfer the material!
- Handle with the material only with the lift truck or use the suspension strands and the crane!
- Do not use the lift truck or crane in case that you do not have the license to handle with it!

5.4.2. Insertion

Insert material to the vice and ensure that the material cannot move in the vice or fall from the vice after the clamping. If you cut long pieces of the material (for example rod, tube), you must use the roller conveyors for material shifting to the band saw. Contact Bomar for more information about roller conveyors



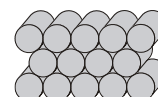
Make sure the conveyor is long enough and the material cannot tip off the conveyor.

Be especially careful with round materials that it always stays on two vertical rollers and that it cannot fall off the conveyor!

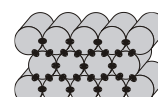
5.4.3. Bundle material cutting

If you want to cut the material in the bundle, there are suggestions for the positioning of bundles

Round material bundle: Take care especially with round material that the bars are put according to the picture. If the bars are put differently, you may have problems with movement.

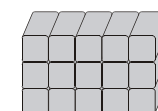


Always weld the material at the rear end of the bundle to secure it from moving.



Before welding always, switch the machine off at the main switch! The magnetic fields, which often occur during welding, may damage the controls!

Square material bundle:



Attention:

Not all material shapes are suitable for bundle cuts. Keep the recommendation of your supplier of the saw bands for material insertion to the bundle.

5.4.4. Hydraulic fixture bundles (Top clamping - auxiliary vice) – optional accessories

To better maintain the workpiece in the vise we recommend using of **hydraulic fixture bundles** of material. That is not part of the standard equipment, optional accessories only. It is suitable especially in the case of uneven cutting material.



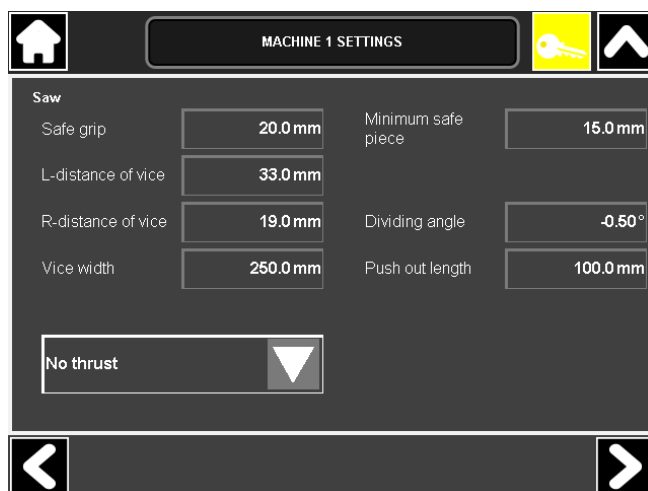
In manual mode it is possible to control the top clamping manually – by means of buttons at control panel.

In automatic cycle the jaws are controlled automatically.

The process of clamping of horizontal and vertical vices is in accordance with preset which was made in service parameters:



- Screen no.1



Pos.	Function
Pull-down menu (hierarchical level 1)	
No thrust	Upper thrust disabling
1.Vice 2. Thrust	First the main vice is clamped, then the thrust.
1. Thrust 2. Vice	First the upper thrust is clamped, then the main vice.
If the upper thrust is installed on both the feeder and the main vice, the option applies to both of the thrusts simultaneously.	

6. **Údržba stroje / Wartung / Machine service**

6.1. Saw band installation and dismantling

6.1.1. Saw band dismantling – mechanical saw band stretching

1. Lift the saw arm to maximum position.
2. Disconnect the machine from electricity, it secures, that the machine can't be switched on randomly.

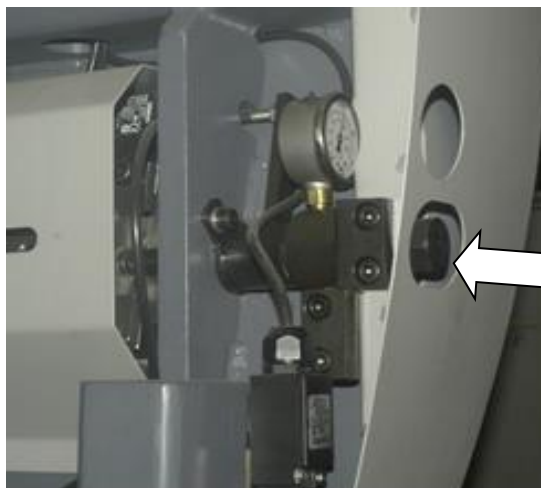


3. Open all three covers on the saw arm.





4. Dismantle left protective covers of the band. Covers are fastened by screws.
5. Release the screw holding the brush. Turn the brush to the side.



6. Turn by stretching star to the left side, release saw band stretching and pull down the saw band from the wheels.
7. Pull down the band from the wheels.
8. Pull up the saw band from the guiding cubes.

6.1.2. Saw band dismantling – hydraulic saw band stretching

1. Switch switcher DEBLOCK into position „1“ – this turns off safety circuit and the button ons for the saw band tensioning arms are active.



2. Raise the arm to the top position with a third button.



3. Open all three covers on the saw arm.





4. Dismantle left protective cover of the band. Cover is fastened by screws.
5. Release the screw holding the brush. Turn the brush to the side



6. Use the buttons on saw arm to loosen the saw belt.
7. Pull down the band from the wheels.
8. Pull up the saw band from the guiding cubes.

6.1.3. Saw band installation

1. Prior to installation, clean all track wheels, guide cubes and inner side of the arm thoroughly of all traces of chips and dirt. *Keep in mind the teeth direction when installing the saw band.*
2. Insert new saw band in the guide cubes. Make sure the saw band runs between both guide rollers and it is pushed all the way to the top.
3. Put the saw band on both guide wheels. Make sure that the saw band ridge fits tightly to the wheel rim. Then push the saw band as far back as possible.
4. Stretch the saw band by means of the screw, that the band did not falls from wheels.

If the machine is equipped with a hydraulic tensioning belt, stretch belt with buttons.

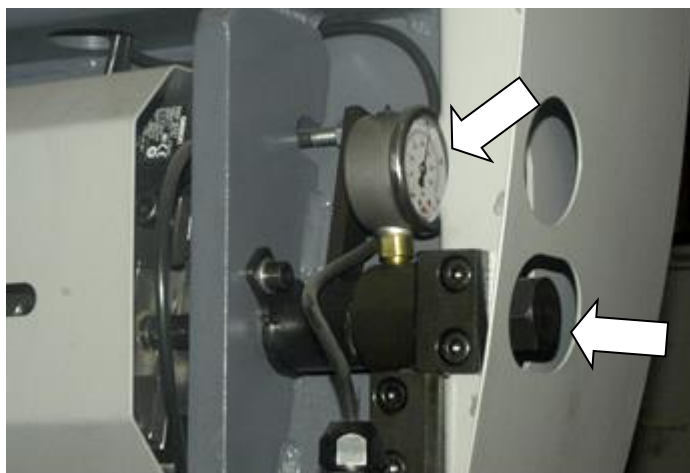
5. Install yellow protective cover of the band.
6. Move the brush to the saw band. Tighten the securing screw.
7. Close the covers of both driving wheels.
8. When machine is equipped with Hydraulic belt tension Turn ON the safety circuit. Also swich DEBLOCK key into position "0".
9. Saw band installation is finished.

6.2. Saw band stretching and inspection

Right saw band stretching is one of the most important criteria's, which influents accuracy and saw band service life. Stretch the saw bands according to the selected saw band and the band saw. Keep the recommendation of your manufacturer.

6.2.1. Mechanical saw band stretching

- Switch on the hydraulic aggregate after the saw band installation check the saw band stretching on the manometer .



- Use the screw to stretch the saw band until it is stretched to the recommended value.

If the saw band is tightened correctly, the pressure gauge pointer is on the green arrow in the scale.



6.2.2. Hydraulic tensioning of the saw band

If the band saw is equipped with hydraulic tightening of the saw band, the band tightening value is adjusted by the manufacturer directly.

Push the button (see arrow) until the sawband isn't stretched.



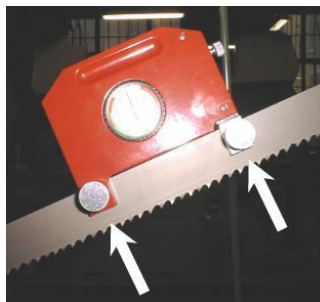
6.2.3. Tenzomat (optional accessory)

Tenzomat is used for checking saw band tension.

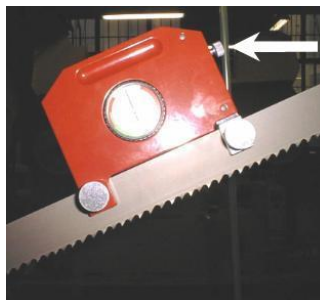
Principle of Tenzomat is founded on measuring extension saw band for tension

Instruction for using:

1. Put the saw band put onto the wheels of saw and slightly stretch it.
2. Release tightening screws of Tenzomat. Put Tenzomat onto saw band, saw band must run clips. Take care that saw band does not sit onto a bottom cut in the clips. Between saw band and bottom of clips must be gap 1–3 mm. Tighten tightening screws of Tenzomat.



3. Turning with adjusting screw onto moving vice of Tenzomat, adjust indicator. Pointer indicator must point onto zero. The saw band stretch by means of stretching equipment of saw and indicator point value, which is in extent advised values.



4. Release tightening screws of Tenzomat. Get down Tenzomat from the saw band.

Stretch the saw bands according to the selected saw band and the band saw. Keep the recommendation of your manufacturer

Pilový pás Sägeband Saw band	Napětí pilového pásu Sägebandspannung Blade tension	Napětí pilového pásu PSI (pro Tenzomat) Sägebandspannung PSI (für Tenzomat) Blade tension PSI (for Tenzomat)
20 x 0,9 mm	160 N.mm ⁻²	23 500
27 x 0,9 mm	180 N.mm ⁻²	26 500
34 x 1,1 mm	210 N.mm ⁻²	30 500
41 x 1,3 mm	240 N.mm ⁻²	35 000
54 x 1,3 mm	240 N.mm ⁻²	35 000
54 x 1,6 mm	280 N.mm ⁻²	40 600
67 x 1,6 mm	290 N.mm ⁻²	42 000
80 x 1,6 mm	300 N.mm ⁻²	43 500

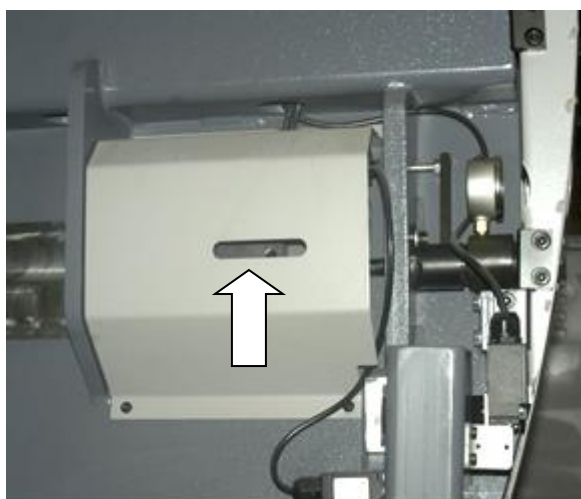
6.3. Adjusting of the saw band run

6.3.1. Saw band inspection

Check the saw band in the guiding cubes and on the wheels

1. Check, if the saw band is right in the guiding cubes..
2. Switch on the saw band drive and then after 10 seconds switch off saw band drive. If the saw band drive is not possible to switch on, set the limit switch of the saw band stretching.
3. Switch off the main switch.
4. Open cover(s) of the wheels and check position of the saw band on the both wheels..
 - If the distance between backside of the saw band and the offset wheel is **1 mm**, setting is right..
 - If the distance is bigger than **1 mm**, or the saw band is on the offset of the wheel, set the saw band.
5. Close cover of the saw band.

6.3.2. Saw band run setting



Saw band run is set with screw (arrow) in the stretching cube on the saw arm. Right distance rear part of the saw band from wheel rim is **1 – 3 mm**.

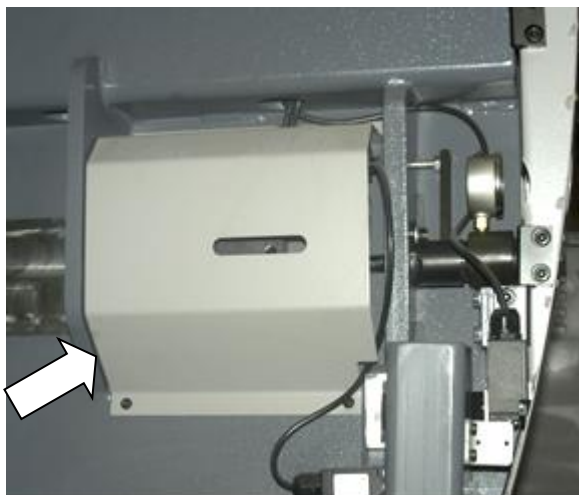
- Turn with the screw to the right, the saw band is closer to the stretching wheel rim.
- Turn with the screw to the left, the saw band is far from the stretching wheel rim

Check saw band run adjustment again.

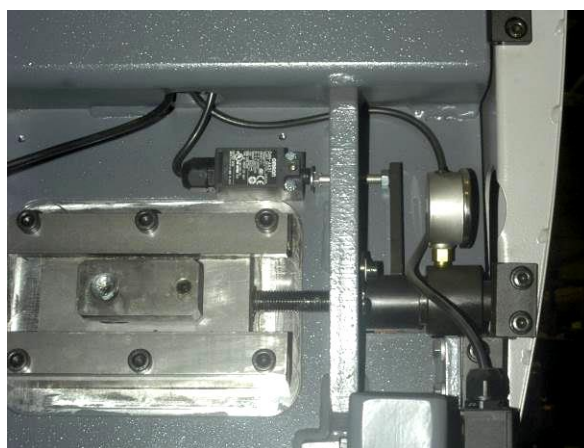
6.4. Adjusting of the limit switch of the saw band stretching

After the saw band is replaced, the saw band stretching must be checked. If the limit switch is not adjusted correctly, the band is stretched too little or too much. The machine can be damaged.

1. Dismantle the protective cover.

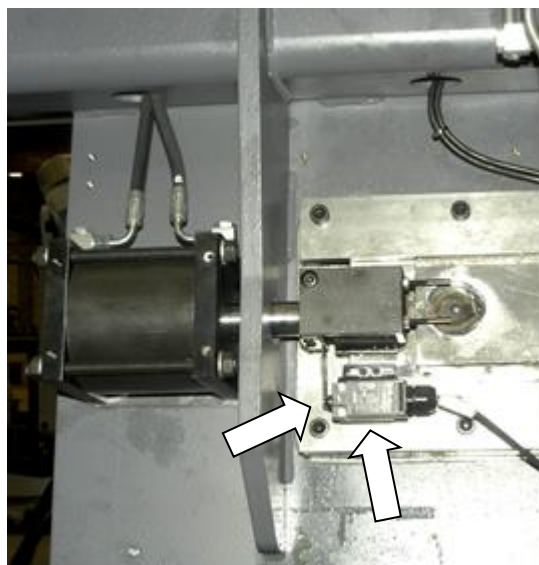


Mechanical saw band stretching



2. Tighten the saw band by means of the TENZOMAT on the optimal value (table is on the Tenzomat).
 - If the drive engine is switched on, but it is not running, turn with the screw clockwise, until the engine begins run..
 - If the drive engine is possible switched on, turn with the screw anticlockwise, until the engine is stopped and then turn with the screw clockwise, until the engine begins run.
3. Mantle the protective cover back.

Hydraulic saw band stretching



2. Switch on the hydraulic unit. When the hydraulic unit is switched on, there is a short period for automatic tightening of the saw band.

Try to run the saw band drive two times during this period:

- at first immediately after hydraulic unit switching on

If the limit switch is set correctly then when the saw band drive is switched immediately after hydraulic unit switching on - **low value of the saw band tension causes that the limit switch is not in contact with its counterpart and it is not possible to switch on the saw band drive** (– so it couldn't be possible to switch the saw band drive until the saw band isn't tensioned properly)

- next after a about 30 seconds

If the limit switch is set correctly then when the saw band is switched after the period which is necessary for automatic saw band tightening - **the proper saw band tension causes that the limit switch is in contact with its counterpart and it is possible to switch on the saw band drive**

CAUTION!

In the event that the limit switch is not responding properly during the tests, first check:

- whether the machine is in the state DEBLOCK (if the machine is equipped with this mode)
- whether the saw band isn't damaged

Eventually check the condition of the limit switch, the condition of the saw hydraulic unit and whether the saw band is tensioned properly - eg. using TENZOMAT

According to recognized findings:

- repeat tensioning of the saw band when the machine is in DEBLOCK
- replace the saw band
- or contact an authorized service

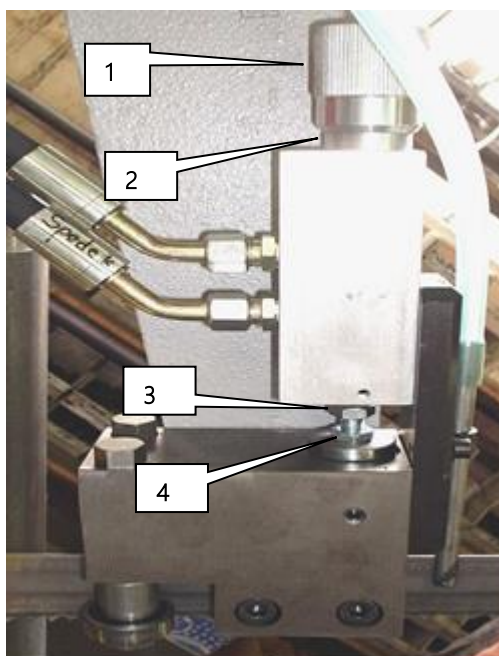
6.5. Adjusting of the device for control of thrust to cut

The device is factory set.

Correct setting of the device effects cutting quality, smooth run of the machine and life of the saw band.

Caution! Do not interfere in the settings of this device without a serious reason and if not trained properly!

1. Run the arm to the upper position
2. Loosen the locking nut /Pos.4/ on the screw
3. Set two visible recesses /Pos. 2/ with the adjusting knob /Pos.1/ on the adjustment cube
4. Slightly loosen the stop screw /Pos.3/ as far as the adjustment cube stop so that the adjustment cube needle, and thus also the entire valve, is closed apparently.
5. Turn the key on the control panel to the "manual" position "
6. Open the throttle valve of the arm as much as possible or by a single turn – according to the machine type
7. Push the "arm downward" button. The arm must stop /the stop valve is still out/
8. Start to loosen the screw /Pos.3/ slowly until you achieve the optimum speed; see Table No.1
9. After achieving this speed, lock the screw again with the locking nut /Pos.4 /
10. Having finished the adjustment settings, test the arm downward speed with the saw band running



- If the arm descent speed corresponds to the table values, the settings are finished.

BELT [mm]	SPEED [m/min]
27	0.3

Otherwise repeat the entire procedure.

6.6. Cooling agents and chips disposal

The quality of the cooling agent will deteriorate due to:	If the solution is too weak:	If the solution is too strong:
• use of contaminated water • impurity • outside oil contamination (hydraulics, gears) • high operating temperatures • lack of air circulation • wrong concentration	• corrosion protection is diminished • lubrication decreases • microbial attack is more likely	• the cooling ability is decreased • foam behaviour increases • emulsions stability deteriorates • sticky residue develops

6.6.1. Coolant device inspection

The state of the cooling agent has significant influence on the cutting quality and on the operational life of the machine. Lifetime of the cooling liquid is 1 year, after this time we recommend change the cooling liquid. This time is dependent on the degree of pollution cooling liquid (especially with oils) and on the other factors.

Check level of the cooling liquid and function of the pump periodically!

Note:

If the state of the cooling liquid is not satisfactory, the cooling liquid must be changed.

Check the state of the cooling agent according to the following table:

Testing	Interval	Method	Condition	Precaution
Liquid level	daily	visually	too low	after concentration check, refill with water or emulsion
Concentration	daily	refractometer densimeter	too high too low	refill water refill base emulsion
Smell	daily	by sense of smell	unpleasant smell	good ventilation, add biocides or renew coolant

Contamination	daily	by sense of smell	visible oil leaks, sludge fungi	surface cleaning, fix leaks, add biocides or fungicides, or coolant renewal after added system cleanser*
Corrosion-protection	when necessary	visually chip test Herbert-test	insufficient corrosion protection	test stability, if necessary – increase concentration or pH value
Stability	when necessary	refractometer	oiling	add concentrate, enquiries to supplier
Foam reaction	when necessary	shaking test	too much foam, foam disperses too slowly	avoid aeration, increase water hardness, ix with defoamer

* According to manufacturers' instructions

6.6.2. Chips disposal

Chips resulting from cutting operations must be disposed of in accordance with the relevant regulations.

- Let the chips drip excess fluid!.
- Fill a watertight container with the chips! Be careful that the container does not leak, because even after a long dripping time, they still contain coolant residue.
- *Place the container into the care of a disposal company equipped for the disposal of chips contaminated with cooling liquid.* In case the machine is equipped with micro-spray installation, the chips must also be handed over to a disposal company.

6.7. Hydraulic, Greases and oils

6.7.1. Gearbox oils

In gearboxes, oil is used for the whole lifetime of the gearbox. We recommend replacing of the filling oil in case of repair.

Attention:

When replacing, use oils recommended by BOMAR or oils, which has comparable parameters from the other manufacturers.

Do not forget, that mineral and synthetic oils must not be mixed!

Use oils with specification DIN 51517 in the gearboxes. Select the viscosity grade ISO VG according to the original oil fill.

Recommended oils and quantity according to the type of the band saw

Band saw	Gearbox oil	Capacity
Individual 620.460 DGANC	Shell Tivela S 320	3,3 l
Swarf conveyor	Shell Tivela S 320	0,075 l

Comparative table of the gearbox oils

Manufacturer	Viscosity grade		
	ISO VG 100	ISO VG 220	ISO VG 320
BP	Energol GR-XP 100	Energol GR-XP 220	Energol GR-XP 320
Castrol	Alpha SP 100	Alpha SP 220	

	Alpha MW 100	Alpha MW 220	
Elf	Reductelf SP 100	Reductelf SP 220 Reductelf Synthese 220	Reductelf SP 320
Esso	Spartan EP 100	Spartan EP 220	Spartan EP 320
Mobil	Mobilgear 627	Mobilgear SHC 220 Mobilgear 630	Mobilgear 632
ÖMV		PG 220	
Paramo	PP 7	Paramo CLP 220	Paramo CLP 320
Shell	Shell Omala 100	Shell Omala 220 Shell Tivela S 220	Shell Omala 320 Shell Tivela S 320
Total	Carter EP 100	Carter EP 220	Carter EP 320

6.7.2. Lubricant greases

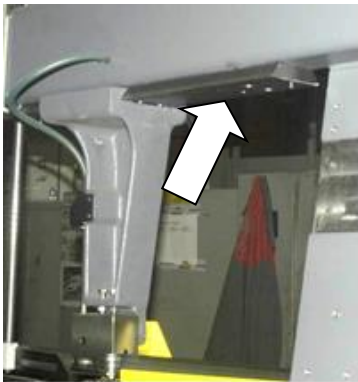
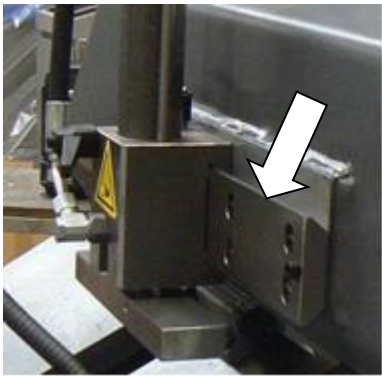
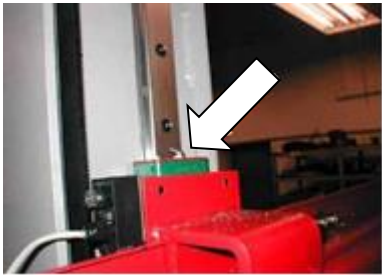
We recommend using lithium based saponified grease, class NGLI-2 for lubrication. Different greases are mixable, if their oil bases and consistence type are identical.

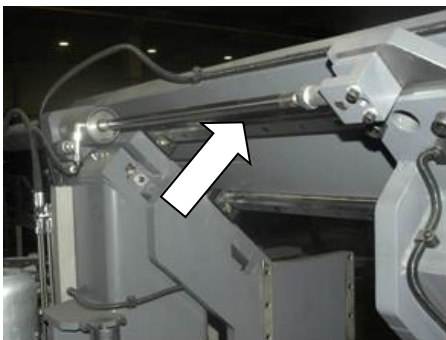
Comparative table of the lubricant greases:

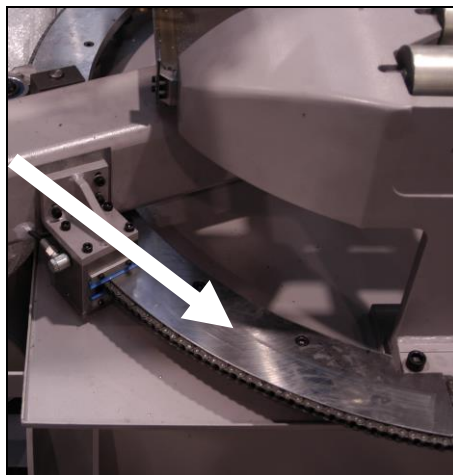
Manufacturer	Type of the lubricant grease
BP	Energrease LS - EP
DEA	Paragon EP1
Esso	FETT EGL 3144
	Beacon EP 1
	Beacon EP 2
FINA	FINA LICAL M12
Klüber	Microlube GB0
	Staburags NBU8EP
	Isoflex Spezial
Optimol	Optimol Longtime PD 0, PD1, PD2
Shell Aseol AG	ASEOL Litea EP 806-077
Texaco	Multifak EP1

6.7.3. Lubrication

There are several placing on the machine, which are necessary to grease periodically. It secures the right function of the machine.

Points for lubrication	Lubrication
	The guiding cubes leading Grease with oil from both sides once a week.
	Feeder top camping leading Grease with oil from both sides once a three months.
 	The linear guiding of the saw arm Lubricate with grease once a three months (see chapter Lubricant greases). Use 3–5g grease on the every carriage of the linear guiding. Use the grease gun to the lubrication. Drive 3–5 times whole line of the linear guiding during lubrication.

Points for lubrication	Lubrication
	The linear guiding for feeder jaws Lubricate with grease once a three months (see chapter Lubricant greases). Use 3–5g grease on the every carriage of the linear guiding. Use the grease gun to the lubrication. Drive 3–5 times whole line of the linear guiding during lubrication.
	Linear guiding for feeder movement Lubricate with grease once a three months (see chapter Lubricant greases). Use 3–5g grease on the every carriage of the linear guiding. Use the grease gun to the lubrication. Drive 3–5 times whole line of the linear guiding during lubrication.
	Main vice leading Lubricate with grease once a three months (see chapter Lubricant greases). Use 3–5g grease on the every carriage of the linear guiding. Use the grease gun to the lubrication. Drive 3–5 times whole line of the linear guiding during lubrication.



Do not grease! Hydraulic brake will be ineffective.

6.7.4. Hydraulic oils

Replace the hydraulic oil once a year, because the oil can deteriorate its properties and cause problems the hydraulic equipment. If the hydraulic system is equipped with filter (2SF 56/48-0,063), replace the filter too.

Note:

When replacing, use oils recommended by BOMAR or oils, which has comparable parameters from the other manufacturers. Do not forget, that mineral and synthetic oils may not be mixed!

Use oils with specification DIN 51524-HLP, ISO 6743-4 and viscosity grade ISO VG 32 in hydraulic aggregates. Hydraulic oils quantity – see chapter **Hydraulic oil level check**.

Comparative table of the hydraulic oils

Manufacturer	Type	Manufacturer	Type
Agip	Oso 32	Ina	Hidraol 32 HD
Aral	Vitam GF 32	Klüber	Lamora HLP 32
Avia	Avilub RSL 32	Hungary	Hidrokomol P 32
Benzina	OH-HM 32	Mobil	Mobil DTE 25
BP	Energol HLP 32	ÖMV	HLP 32
Bulgaria	MX-M/32	Poland	Hydrol 30
Castrol	Hyspin AWS 32	Rumania	H 32 EP
Čepro	Mogul HM 32	Russia	IGP 30
DEA	Astron HLP 4hy6	Shell	Tellus Oil 32
Elf	Elfolna 32	Sun	Sunvis 832 WR
Esso	Nuto H 32	Texaco	Rando HD B 32
Fam	HD 5040	Valvoline	Ultramax AW 32
Fina	Hydran 32		

6.7.5. Hydraulic unit service

After 50 hours working time, or the latest 3 month after the first run, the first service should be carried out. This includes:

- checking off all screws and connections, fixing points, tubes and hoses for leakage
- Check hydraulic oil level
- During time of duty the oil temperature shouldn't exceed 60-70°C
- check function of signaling components (thermometer, level gauge, dirty filter indicator)
- Check the adjustment of working pressure

To realise a high reliability of the power pack, the manufacturer lays down following inspection intervals

Interval	daily	weekly	monthly	three monthly	six monthly	annually
Hydraulic fluid						
Level	-	•	-	-	-	-
Temperature	-	•	-	-	-	-
Condition	-	-	•	-	-	-
Change interval	-	-	-	-	-	•
Filter						
Change interval	-	-	-	-	-	-
Other checks						
External Leakages	•	-	-	-	-	-
Contamination	•	-	-	-	-	-
Damages	•	•	-	-	-	-
Noise-(level)	•	-	-	-	-	-
Gauges	-	-	•	-	-	-

Check the oil in the hydraulic system:

- Saw



- Feeder



Pull up the gauge and check the state of the oil. The oil level must be situated between water-glas.

Fill the hydraulic oil, if it is necessary. Use always the filter (10 μm or better) when you fill the oil. You avoid impurities penetration to the hydraulic system and troubles in hydraulic system.

6.7.6. Manometers

Pressure in saw hydraulic unit



Pressure in main vice – manometer is placed on main vice (optional accessory)

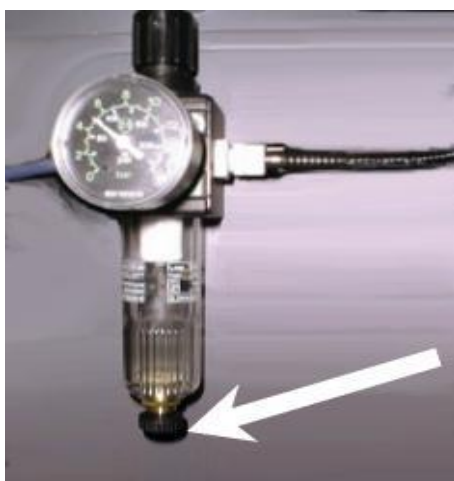


Saw blade tensioning mechanical – placed on saw arm. (optional accessory)



6.8. Pressure system servicing

Filter of the pressure system is necessary to clean periodically, that means drain sediments and impurities from the reservoir.



Close the pressure air supply. Screw off the screw and let to drain sediments to the reservoir. Screw on the screw again.

WARNING!

There is the pressure 0,5 – 0,6 MPa in the pressure system, therefore you must release the screw very carefully!!

6.9. Machine cleaning

Clean the machine from the cooling liquid and impurities after every shift stopping. Conserve the guiding surfaces, mainly.

- Clamping jaws guiding of the vice.
- The guiding of the feeder.
- Loading surface of the vice.
- Vice guiding
- Brush

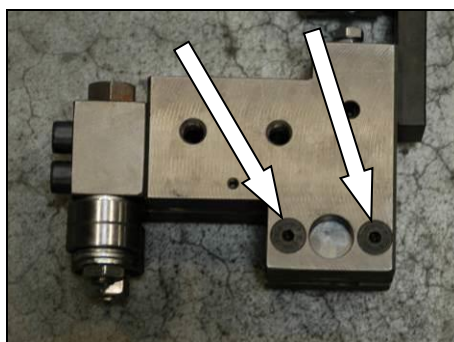
6.10. Worn pieces replacement

6.10.1. Pushing bearing replacement

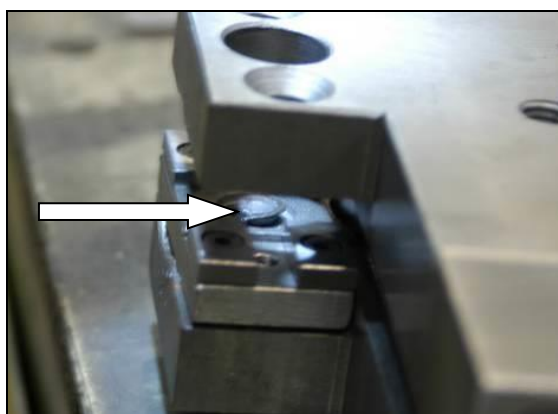
If it is impossible to adjust the bundle gripping assembly and the pushing bearing is worn, it needs to be replaced



1. Dismantle the saw band.
2. Disconnect the hose from the cooling agent eventually unmount microniser.
3. Unmount guiding cube from holder on saw.



4. Loosen the 2 clamp screws solid carbide guides and remove them..
5. Remove fixed hardmetal.



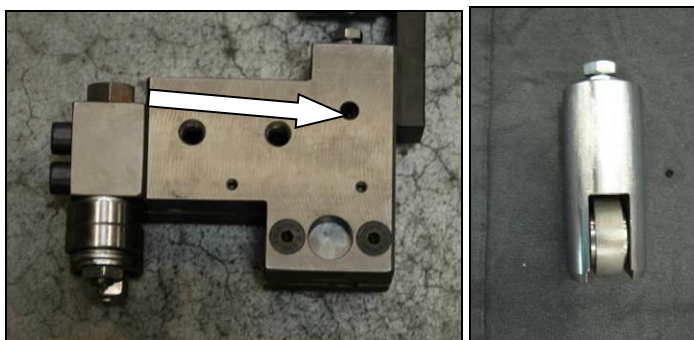
6. Remove retaining ring. Then unmount adjusting screw.



7. Remove other three screws.



8. Carefully remove the hardmetal. Remove disc springs.



9. Loosen the mounting worm (allen wrench no. 3). Remove the pivot with bearing from the guiding cube.



10. Insert the pivot to the vice.

Attention:

The vice has aluminium jaws, eventually, there has to be an aluminium agent to protect the pivot from damage.

11. Remove the bearing pivot from the bearing holder by means of the swager.



12. Remove the worn bearing and other damaged parts.
13. Fasten the holder to the vice.
14. Insert the bearing and washers and return the pivot to its original place.
15. Place the assembled piston guide cube. Piston must move freely in a guiding cube.
16. Worm screw defines the operation of the piston (piston has a slot in which is the worm). Tighten the worm, but with a minimum clearance to the piston could move.

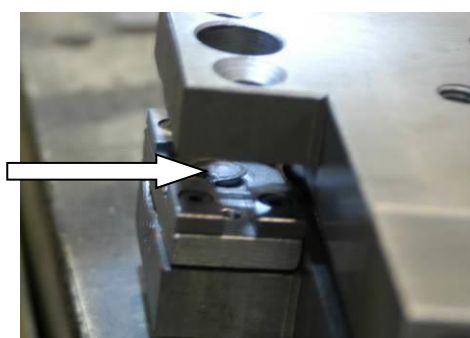


17. Insert the disc springs. The number of disc springs must match the number of dismantled springs. Disc springs are folded against each other 1 to 1 Odd plate spring is near the harmetal carbide.





18. Insert the new hard metal guide. **Attention, Do not lose disc springs.** Ensure proper position of carbide guides – holes for 3 stop screws must be in the same position as the holes in a guiding cube.
19. Insert and tighten central screw.



20. Insert the retaining ring on central screw.
21. Insert 3 stop screw around central screw.



22. Insert fixed hardmetal guiding and mount hard metal with two screws.



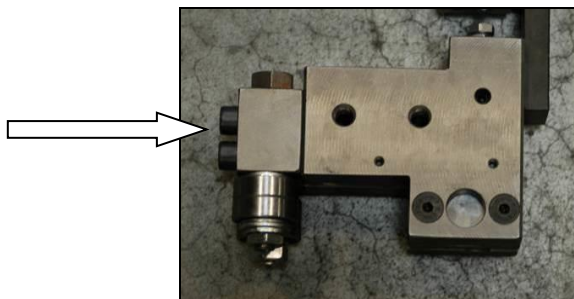
23. Using a short piece of the blade used on the machine, adjust the width of the gap between the guides. Loosen the central screw. Set the gap by central adjusting screw. Belt guides must walk freely without large and will also not scrub.

6.10.2. Saw band guiding pulleys replacement

Attention:

Guiding pulleys must be replaced together on both guiding cubes!

If the saw band is not sufficiently guided by guiding pulleys or if the pulleys are obviously worn, the pulleys should be replaced.



1. Release 2 screws. Dismantle the guiding cube of the saw band.

Attention:

Mark both eccentrics placing and components on the eccentric! Eccentrics must not be replaced with each other!



2. Tighten the guiding cube to the vice and dismantle both eccentrics with bearings following way.
3. Screw off nuts from eccentrics.
4. Remove eccentrics from bearings by means of the swager.



5. Change all bearings and other worn parts.

Attention:

Do not replace the eccentrics placing in the cube.

6. Install eccentrics to the cubes. Install components on both eccentrics in given order. Put bearings by means of the preparation on eccentrics.



7. Screw on nuts on both eccentrics and tighten them.



8. Insert the saw band to the guiding cube (cca 15 – 20 cm). Secure the movable hard metal guide with scotch so, that the saw band is pressed with guides and it is possible to move with saw band

Optimal distance between the band and the pulley is 0,05 mm.

9. Set the eccentrics by means of the wrenches, the saw band must run in the centre. Guide pulleys must not press too much on the band, but must spin freely during the band run
10. Tighten nuts on both eccentrics.
11. Remove the testing piece of saw band from the cube lead. Install the guiding cube on the machine.

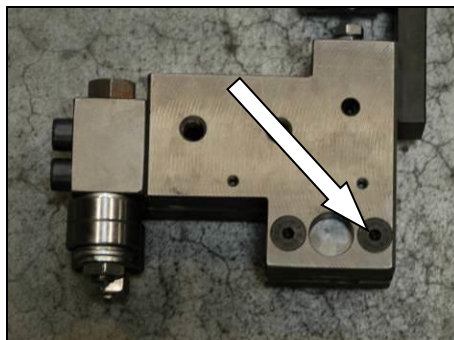
6.10.3. Hard metal guides replacement

ATTENTION!

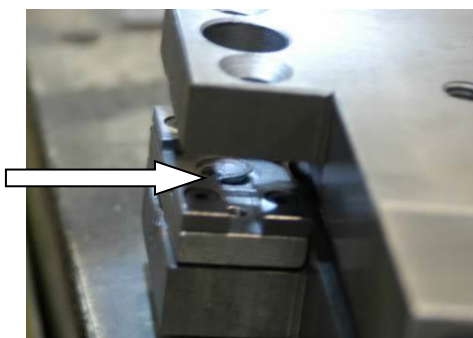
Hard metal guides must be replaced together on both guiding cubes!!

If the hard metal guides cannot be adjusted, they have to be replaced

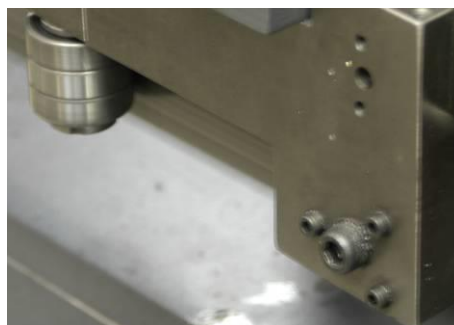
1. Dismantle the saw band.
2. Disconnect the hose from the cooling agent eventually unmount microniser.
3. Unmount guiding cube from holder on saw.



4. Loosen the 2 clamp screws solid carbide guides and remove them..
5. Remove fixed hardmetal.



6. Remove retaining ring. Then unmount adjusting screw.



7. Remove other three screws. .



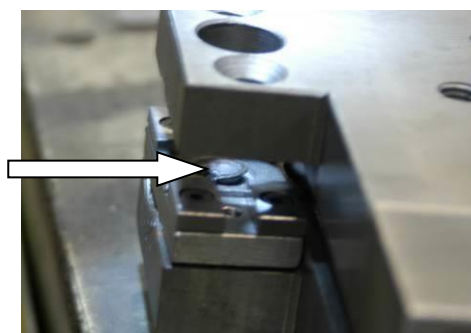
8. Carefully remove the hardmetal. *Pozor, nesmí dojít ke ztrátě talířových pružin.*



9. The number of disc springs must match the number of dismantled springs. Disc springs are folded against each other 1 to 1 Odd plate spring is near the harmetal carbide.



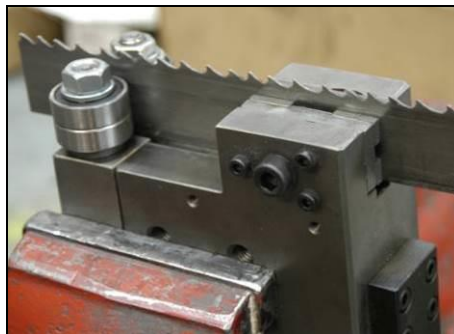
10. Insert the new hard metal guide. **Attention, Do not lose disc springs.** Ensure proper position of carbide guides – holes for 3 stop screws must be in the same position as the holes in a guiding cube.
11. Insert and tighten central screw.



12. Insert the retaining ring on central screw.
13. Insert three stop screw around central screw.



14. Insert fixed hardmetal guiding and mount hard metal with two screws.

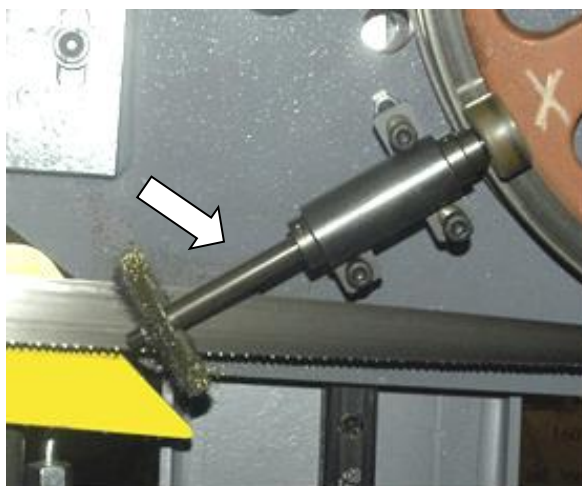


15. Using a short piece of the blade used on the machine, adjust the width of the gap between the guides. Loosen the central screw. Set the gap by central adjusting screw. Belt guides must walk freely without large and will also not scrub.

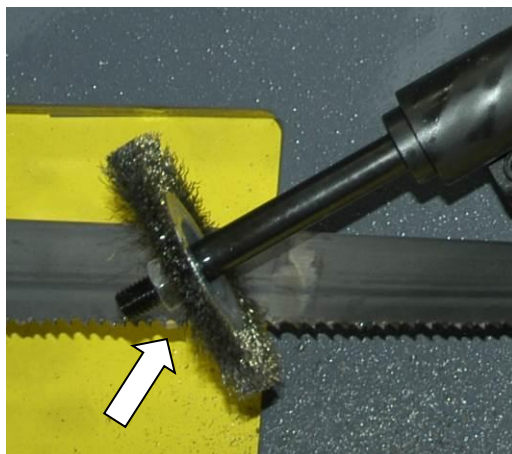
6.11. Round brush replacement

If the chip removing brush is not able to fulfil its function, it has to be replaced.

1. Dismount the cover of the brush. / Open the cover of the band arm



2. Hold shaft of the brush by wrench.



3. Release the nut on the brush, replace worn brush on the new brush, screw on the nut.
4. Adjust the brush to the saw band
5. Mount the brush cover back to its place / close saw arm cover

7. **Závady / Störungen / Troubleshooting**

7.1. Mechanical problems

Problem	Possible causes	Repair
1. Slanting cut	- Wrongly adjusted hard metal guides.	Set according to the chapter „Servicing and adjustment“
	- Worn hard metal guides.	Replace to the chapter „Worn pieces replacement“
	- Wrongly adjusted cubes of the saw band guiding.	Set according to the chapter „Servicing and adjustment“
	- Worn bearings of the saw band guiding.	Replace according to the chapter „Worn pieces replacement“
	- Wrongly adjusted swarf brush.	Set according to the chapter „Servicing and adjustment“
	- Worn swarf brush.	Replace according to the chapter „Worn pieces replacement“
	- Insufficient saw band stretching.	Rise the saw band stretching and set the limit switch.
	- Wrongly chosen tooth system of the saw band.	Replace the saw band and keep the instructions of manufacturer on new saw band choice.
	- Worn saw band.	Replace the saw band.
	- Wrongly balanced roller conveyor.	Set the roller conveyor.
	- Dirty feeding board.	Cleanse the feeding board from debris, chip and residue material.
	- Guiding arm and guiding cube are loosened.	Clamp the guiding arm.
	- Guiding arm and cube are too far from the material.	Set the guiding cube to the material.
	- Too fast cutting rate.	Lower the material feeding speed.
2. The cut is not cut upon desired angle	- Unexpected oscillation in material quality.	Set the cut and feeding speed to the relevant material.
	- Securing lever is loosened.	Check the securing lever efficiency and carry out its adjustment according to chapter „Servicing and adjustment“.
	- Set angle does not match the cut angle.	Check the angle adjustment with a protractor and possibly set it according to chapter „Servicing and adjustment“.
	- Insufficient saw band stretching.	Stretch the saw band and set the limit switch according to chapter „Servicing and adjustment“.
	- Guiding arm and guiding cube are loosened.	Fasten the guiding arm and the cube.
3. Short lifetime of the saw band	- Dirt between material and clamping jaw.	Cleanse the material and mating jaw.
	- Insufficient saw band stretching.	Raise the tightening of the saw band set the scanner of saw band tightening according to chapter „Servicing and adjustment“.
	- Worn swarf brush.	Check the swarf brush condition and replace it in case of excessive use as described in chapter „Worn pieces replacement“
	- Wrongly adjusted swarf brush.	Check swarf brush adjustment, set it according to chapter „Servicing and adjustment“

Problem	Possible causes	Repair
	- Over stretched saw band	Lower stretching of the saw band and set the limit switch of the saw band stretching according to chapter „Servicing and adjustment“
	- Wrongly adjusted hard metal guides.	Check the adjustment of the hard metal guides and carry out adjustment as described in chapter „Servicing and adjustment“
	- Worn hard metal guides of the saw band.	Check the condition of the hard metal guide and if it is too worn, replace hard metal guides according to chapter „Worn pieces replacement“
	- Worn saw band guide bearings.	Check guiding bearings and if you notice some sort of excessive damage, replace them according to chapter „Worn pieces replacement“
	- Wrongly adjusted guiding cubes of the saw band.	Set guiding cube according to chapter „Servicing and adjustment“
	- Wrongly adjusted down feed and saw band speed.	Adjust the feeding and speed of a saw band according to values published by saw band manufacturer.
	- Different material quality.	Adjust feeding and speed of a saw band according to desired material (try cut-test).
	- Low-class saw band	Replace the saw band (contact your local accessory supplier for more information)
	- Wrongly chosen saw band tooth system.	Replace the saw band and keep instructions of the manufacturer on the choice.
	- Wrongly adjusted tracking.	Check the space between top of a saw band and driving wheel. Perhaps adjust the tracking as described in chapter „Servicing and adjustment“
4. Insufficient cut output.	- Worn saw band.	Replace the saw band and keep instructions of the manufacturer on the choice.
	- Wrong saw band tooth system.	Replace the saw band and keep instructions of the manufacturer on the choice.
	- Wrongly set down feed and speed of a saw band.	Set feed and speed of a saw band according to values published by saw band manufacturer.
5. The cut is not finished.	- Wrongly adjusted lower stop point of the saw frame.	Check lower limit switch and screw.
	- Stop point surface is messed-up.	Cleanse stop point surface of the limit switch from debris and residue material.
6. By choke is not possible turn	- Metal clamps between valve and panel.	Clamps must be removed and put on the shaft O-Ring about 10x2 mm.
	- Metal clams are in body of valve.	Valve must be cleared or changed.
7. Saw band drive cannot be started.	- Pressure switch is adjusted wrong.	Set the pressure switch according to chapter „Servicing and adjustment“
	- Pressure switch is defective.	Replace defective parts of the pressure switch.
8. The saw bands are cracked.	- In stretching wheel is wrong adjusting geometry.	Adjust distance band from recess wheel c.2 mm according to operating instructions.
	- Hard metal plates of circuit saw band are not adjusting.	Hard metal plates of circuit saw band must be adjusting according to operating instructions.
	- Guiding cubes are not adjusting (bearings + hard metal circuit)	Guiding cubes must be adjusting (bearings + hard metal circuit) according to operating

Problem	Possible causes	Repair
		instructions.
	- Bearings of guiding cubes are used (rolling elements are damaged or outside ring of bearing has conical form).	Bearings of guiding cubes must be replaced. Bearings must be adjusting according to operating instructions.
9. Damage tooth system of the saw band	- In gripping the lifting cylinder is backlash.	
	- Squeezed pin upper or downer holder of the lifting cylinder.	Exchange complete upper or downer holder of lifting cylinder.
10. The saw is cut downing.	- Geometry of hardmetal guiding cubes is wrong adjusted.	Hardmetal guiding cubes must be adjusted.
	- Bearings of guiding cubes are used.	Bearings of guiding cubes must be replaced.
11. Cleansing of the saw band is not functional.	- Elastic wheel of the brush drive is worn-down.	Elastic wheel of the brush must be changed.
	- Knurling of the driving wheel is worn-down.	Driving wheel must be changed.
	- The shaft of the brush drive is rusted.	The shaft of the brush must be cleaned and oiled.
	- The brush position and the brush cover is adjusted wrong – with the brush cannot be turned.	The brush cover must be posed, in order to the brush can be turned.
12. The saw arm periodically rise and fall during the cut; this cause short lifetime of the saw band.	- Backlash in driving wheel lodgement on the shaft.	Change the driving shaft for a long one, new bearings, distance ring, new driving wheel, spring, two covers on the forehead of the shaft + screws.
	- Worn channel for spring.	

7.2. Electric and hydraulic problems

Problem	Possible causes	Repair
1. Machine is not possible start.	- In socket is not voltage	Line voltage must be checked.
	- Transfer relay is closed (thermal protector)	Each FA relay must be checked.
	- Limit switch of saw band stretching, cover of frame or cover of saw band is not started.	Check of saw band stretching and covers closing.
2. When cut is finished, the frame is not raising.	- Bottom limit switch is adjusted wrong.	Bottom limit switch must be adjusted according to chapter ADJUSTING.
	- In hydraulic (pneumatic) ring is error. HYTOS (BOSCH) is not acting to frame uplift.	Function of magnetic valve must be checked, valve must be closed, voltage of clamps and inductor must be checked.
3. Electric motor and pump are without voltage. Between contactor and thermal protector is not voltage.	- Wrong contactor.	Replace contactor of engine.

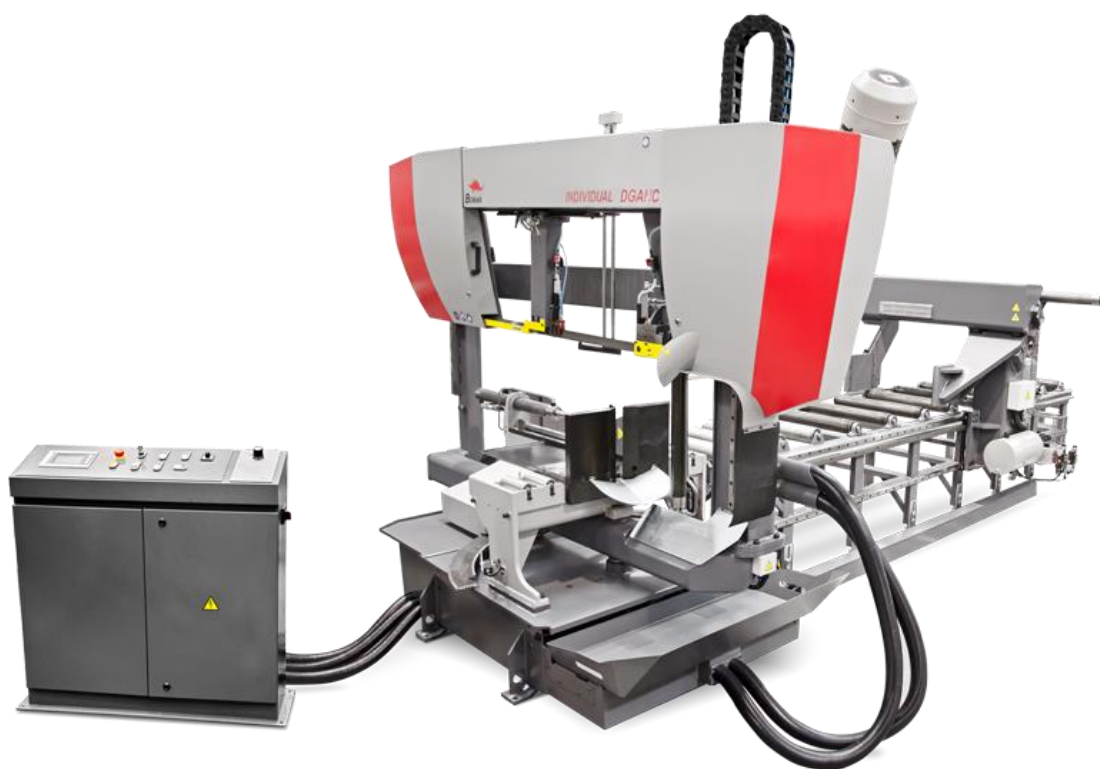
Problem	Possible causes	Repair
4. The indicator of speed saw band is not functional.	- Sensor of speed is not adjusted.	Sensor of speed must be adjusted.
	- Defective display	The display must be changed.
	- Wrong sensor – diode of indicator speed is not light.	Sensor must be changed and adjusted.
5. Protector is switched off from engine hydraulic aggregate MA3 sometimes.	- Into hydraulic system is high working pressure.	Service engineer must reduce the pressure in hydraulic system.
6. The hydraulic aggregate cannot be started	Auxiliary contact on thermo-relay FA1 is defective.	Replace the defective contact on motor starter FA1.
7. Hydraulic aggregate is switched on but the saw arm or the main vice is not functional	- Wrong connection of electrical supply. The electrical phases are connected conversely.	The phases must be switched. Only service engineer can do this.
8. Cooling is not active	Lack of cooling agent.	Fill the tank with cooling agent.
	- Thermal relay is defective	Change the thermal relay
	- Input hosepipe is broken or obstructed.	Check the cooling circuit and perhaps cleanse cooling system.
	- Cooling pump protection is defective	Check the protection of cooling pump if need change it.
	- Cooling pump is defective.	Replace the cooling pump.

7.3. Hydraulic problems

Problem	Possible causes	Repair
1. Hydrogenerator not supplying oil	• reverse rotation	Check the connections of each phase. Reconnect properly connection of the electrical phases.
	• shortage of oil in the tank	Add hydraulic oil
	• Oil viscosity does not correspond prescribed viscosity value	Change hydraulic oil.
	• Hydrogenerator malfunction	Call service
	• Wrong power supply connection.	Check the connections of each phase. Reconnect properly connection of the electrical phases.
2. Hydraulic oil contains bubbles	• Hydraulic circuit is not adequately deaerated	Make deaeration of hydraulic circuit.
	• Low oil level	Add hydraulic oil

	• the pump shaft seals damaged	Call service
3. Increased mechanical noise	• damaged joint drive	Call service
	• damaged or destroyed motor bearings	Call service
	• air intake	Check for leaks.
4. Low pressure, pump supplies oil	• problem in the safety valve	Wrong settings. Check the settings and adjust the safety valve.
	• pump wear	Call service
	• external or internal leakage	Call service
5. Hydrogenerator is seized	• damage by solid particles in oil	Make oil filtration, or call the service.
	• non-prescribed oil	Change hydraulic oil.
	• wrong type of oil	Change hydraulic oil.
	• exceeding the life of the pump	Call service
6. Overheating oil	• cooler malfunction	Check the cooler function or call service.
	• wear the pump, the energy is converted into heat	Call service
7. Hydraulic valve can not be readjusted	• electromagnet has no signal (voltage) - interrupted supply lines	Check again.
	• Electromagnet coil burnt	Replace coil – Call service.
	• spool valve sticking	Replace valve – Call service

Series Individual Automatic



Individual 620.460 DGANC 2300

Operating instructions

Book 2

Before transporting and using the machine,
please read the instructions thoroughly!

Seriové číslo / Serien Nummer / Serial Number _____

Service and information

Your BOMAR dealer:

Direct BOMAR contact:

BOMAR spol. s r.o.
Těžební 1236/1
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Czech Republic, EU

telefon: +420 – 533 426 100
fax: +420 – 533 426 109
e-mail: info@bomar.cz
www: <http://www.bomar.cz>

We are available:

Mondays to Fridays

7⁰⁰ – 16⁰⁰

Version:

2.15 / Nov. 2022
rev. 1

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- 9.10. Konzola otočná / Drehkonsole / Turnable consol..... Chyba! Záložka není definována.
- 9.11. Kusovník / Stückliste / Piece list – Konzola otočná / Drehkonsole /
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- 9.12. Snímač magnet. / Magnetsensor / Magnetic sensor..... Chyba! Záložka není definována.
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- 9.19. Rameno / Sägerahmen / Saw arm..... Chyba! Záložka není definována.
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- 9.21. Rameno / Sägerahmen / Saw arm..... Chyba! Záložka není definována.
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- 9.23. Kartáč / Bürste / Brush..... Chyba! Záložka není definována.
- 9.24. Kusovník / Stückliste / Piece list – Kartáč / Bürste / Brush..... Chyba! Záložka není definována.
- 9.25. Kolečko / Wheel/ Rolle..... Chyba! Záložka není definována.
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- 9.27. Držák / Holder / Halter..... Chyba! Záložka není definována.
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- 9.35. Vedení pásu / Sägebandführung / Belt guide..... Chyba! Záložka není definována.
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- 9.65. Regulace tl. svěráku / Schraubstock druckregelung / Vice pressure regulation.....Chyba! Záložka není definována.
- 9.66. Element válečkový / Roller element / RollenelementChyba! Záložka není definována.
- 9.67. Kusovník / Stückliste / Piece list – Element válečkový / Roller element / Rollenelement.....Chyba! Záložka není definována.
- 9.68. Odměřování / Measuring / GehrungsmessungChyba! Záložka není definována.
- 9.69. Pohon / Drive / Antrieb.....Chyba! Záložka není definována.
- 9.70. Kusovník / Stückliste / Piece list – Pohon / Drive / AntriebChyba! Záložka není definována.
- 9.71. Váleček / Rolle / Cylinder.....Chyba! Záložka není definována.
- 9.72. Kusovník / Stückliste / Piece list – Váleček / Rolle / CylinderChyba! Záložka není definována.
- 9.73. Upínání horní / Spannvorrichtung Oben / Top clampChyba! Záložka není definována.
- 9.74. Válec upínací / Spannzyylinder / Fixing cylinderChyba! Záložka není definována.
- 9.75. Kusovník / Stückliste / Piece list – Válec upínací / Spannzyylinder / Fixing cylinder.....Chyba! Záložka není definována.
- 9.76. Válec pomocný / Hylfszylinder / Aux. cylinderChyba! Záložka není definována.
- 9.77. Kusovník / Stückliste / Piece list – Válec pomocný / Hylfszylinder / Aux. cylinder.....Chyba! Záložka není definována.
- 9.78. Trať / Bahn / TrackChyba! Záložka není definována.
- 9.79. Kusovník / Stückliste / Piece list – Trať / Bahn / TrackChyba! Záložka není definována.
- 9.80. Válec / Zylinder / Roller.....Chyba! Záložka není definována.
- 9.81. Váleček / Rolle / Cylinder.....Chyba! Záložka není definována.
- 9.82. Váleček / Rolle / Cylinder.....Chyba! Záložka není definována.
- 9.83. Váleček / Rolle / Cylinder.....Chyba! Záložka není definována.
- 9.84. Noha / Leg / Ständer.....Chyba! Záložka není definována.
- 9.85. Díl propojovací / Connecting part / VerbindungsteilChyba! Záložka není definována.
- 9.86. Váleček / Rolle / Cylinder.....Chyba! Záložka není definována.
- 9.87. Váleček / Rolle / Cylinder.....Chyba! Záložka není definována.
- 9.88. Váleček / Rolle / Cylinder.....Chyba! Záložka není definována.

- 9.89. Váleček / Rolle / Cylinder Chyba! Záložka není definována.
- 9.90. Válec zvedací / Hebezyylinder / Lifting cylinder Chyba! Záložka není definována.
- 9.91. Kusovník / Stückliste / Piece list – Válec zvedací / Hebezyylinder / Lifting cylinder Chyba! Záložka není definována.
- 9.92. Noha dopravníku / Ständer des Förderers / Feeder Leg Chyba! Záložka není definována.
- 9.93. Doraz / Anschlag / Stop piece Chyba! Záložka není definována.
- 9.94. Kusovník / Stückliste / Piece list – Doraz / Anschlag / Stop piece Chyba! Záložka není definována.
- 9.95. Volitelné příslušenství / Optional accessories Chyba! Záložka není definována.
- 9.95.1. Upínání horní / Top clam / Spannvorrichtung oben Chyba! Záložka není definována.
- 9.95.2. Napínání / Tensioning / Spannung Chyba! Záložka není definována.
- 9.95.3. Kusovník / Stückliste / Piece list – Napínání / Tensioning / Spannung. Chyba! Záložka není definována.
- 9.95.4. Vynašeč třískový / Chip extractor / Spanabführung Chyba! Záložka není definována.
- 9.95.5. Kusovník / Stückliste / Piece list – Vynašeč třískový / Chip extractor / Spanabführung Chyba! Záložka není definována.
- 9.95.6. Laser – ukazovátko / Laser / Laser Chyba! Záložka není definována.
- 9.95.7. Laser – ukazovátko / Laser / Laser Chyba! Záložka není definována.
- 9.95.8. Kontrola vychýlení pásu / Bandsaw deflection control / Band Ausschlagkontrolle Chyba! Záložka není definována.
- 9.95.9. Kusovník / Stückliste / Piece list – Kontrola vychýlení pásu / Bandsaw deflection control / Band Ausschlagkontrolle Chyba! Záložka není definována.
- 9.95.10. Odměřování / Measuring / Gehungsmessung Chyba! Záložka není definována.
- 9.95.11. Kusovník / Stückliste / Piece list – Odměřování / Measuring / Gehungsmessung Chyba! Záložka není definována.

8. **Schémata / Schemas / Schematics**

8.1. Elektrické schema / Elektroschema / Wiring diagrams

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Individual 620.460 DGA

ES-101.481-201/202-V4.1

Wiring diagram

3x400V + PE, 50Hz



Bomar, spol. s r.o.
Těžební 1236/1
627 00 Brno
Czech republic

 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Sroj/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Úvodní strana / Home page / Einstiegssseite Start page Startseite	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-201/202-V4.1 Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz Zpracováno/Processed /Hat verarbeitet: 01.11.2022
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=REPORT/7	Plán konektoru =SCHE-X13	01.11.2022
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Kusovník artiklů / Parts list / Stückliste

Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednávací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-BM1	Bezpečnostní relé 24VDC, 3NO/1NC Safety relay 24VDC, 3NO/1NC Sicherheitsrelais 24VDC, 3NO/1NC	ABB.2TLA010040R0000	ABB	91.051.076	1	=SCHE/8.6
=SCHE-FA1	Motorový spouštěč - 0.4A Motor starter - 0.4A Motorstarter - 0.4A	MS116-0,4	ABB	91.045.017	1	=SCHE/3.5
=SCHE-FA1	Pomocné kontakty - 1xNO+1xNC Auxiliary contacts - 1xNO+1xNC Hilfskontakte - 1xNO+1xNC	HKF1-11	ABB	91.046.002	1	=SCHE/3.5
=SCHE-FA2	Motorový spouštěč - 2.5A Motor starter - 2.5A Motorstarter - 2.5A	MS116-2,5	ABB	91.045.021	1	=SCHE/3.1
=SCHE-FA2	Pomocné kontakty - 1xNO+1xNC Auxiliary contacts - 1xNO+1xNC Hilfskontakte - 1xNO+1xNC	HKF1-11	ABB	91.046.002	1	=SCHE/3.1
=SCHE-FA3	Motorový spouštěč - 1A Motor starter - 1A Motorstarter - 1A	MS116-1,00	ABB	91.045.019	1	=SCHE/4.1
=SCHE-FA3	Pomocné kontakty - 1xNO+1xNC Auxiliary contacts - 1xNO+1xNC Hilfskontakte - 1xNO+1xNC	HKF1-11	ABB	91.046.002	1	=SCHE/4.1
=SCHE-FA4	Motorový spouštěč - 1.6A Motor starter - 1.6A Motorstarter - 1.6A	MS116-1,6	ABB	91.045.020	1	=SCHE/4.5
=SCHE-FA4	Pomocné kontakty - 1xNO+1xNC Auxiliary contacts - 1xNO+1xNC Hilfskontakte - 1xNO+1xNC	HKF1-11	ABB	91.046.002	1	=SCHE/4.5
=SCHE-FU3	Pojistkový odpojovač E-90 - 1P Fuse disconnecter E-90 - 1P Sicherungstrenner E90 - 1P	E 91/32	ABB	91.241.012	1	=SCHE/2.7
=SCHE-KM1	Minisvkač 4kW/400V Minicontactor 4kW/400V Minischutz 4kW/400V	B65-30-01-1.7-71	ABB	91.040.049	1	=SCHE/23.2
=SCHE-KM2A	Stýkač 5,5kW/400V Contactor 5.5kW/400V Schütz 5.5kW/400V	AF12-30-01-11	ABB	91.040.051	1	=SCHE/17.2

The manufacturer reserves right to use an equivalent replacement device.

=DOKU/2.a

 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Strojí/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste		Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-2017/02-V4.1		List/Page/ Seite: 3
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Kusovník artiklů / Parts list / Stückliste

Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednáací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-KM2A	Mechanické blokování Mechanical interlock unit Mechanische Interlockeinheit	VM4	ABB	91.041.045	1	=SCHE/17.2
=SCHE-KM2B	Stýkač 5,5kW/400V Contactor 5,5kW/400V Schütz 5,5kW/400V	AF12-30-01-11	ABB	91.040.051	1	=SCHE/17.3
=SCHE-KM2B	Pomocný kontakt - 1xNO Auxiliary contact - 1xNO Hilfskontakt - 1xNO	CA4-10	ABB	91.041.044	2	=SCHE/17.3
=SCHE-KM3	Ministýkač 4kW/400V Minicontactor 4kW/400V Minischütz 4kW/400V	B65-30-01-1.7-71	ABB	91.040.049	1	=SCHE/23.4
=SCHE-KM4A	Stýkač 5,5kW/400V Contactor 5,5kW/400V Schütz 5,5kW/400V	AF12-30-01-11	ABB	91.040.051	1	=SCHE/17.4
=SCHE-KM4B	Stýkač 5,5kW/400V Contactor 5,5kW/400V Schütz 5,5kW/400V	AF12-30-01-11	ABB	91.040.051	1	=SCHE/17.5
=SCHE-KM4B	Pomocný kontakt - 1xNO Auxiliary contact - 1xNO Hilfskontakt - 1xNO	CA4-10	ABB	91.041.044	2	=SCHE/17.5
=SCHE-KM4B	Mechanické blokování Mechanical interlock unit Mechanische Interlockeinheit	VM4	ABB	91.041.045	1	=SCHE/17.5
=SCHE-KM11	Stýkač 7,5kW/400V Contactor 7,5kW/400V Schütz 7,5kW/400V	AF16-30-10-11	ABB	91.040.056	1	=SCHE/8.7
=SCHE-KM11	Pomocný kontakt - 1xNC Auxiliary contact - 1xNC Hilfskontakt - 1 xNC	CA4-01	ABB	91.041.043	1	=SCHE/8.7
=SCHE-KM12	Stýkač 7,5kW/400V Contactor 7,5kW/400V Schütz 7,5kW/400V	AF16-30-10-11	ABB	91.040.056	1	=SCHE/8.8
=SCHE-KM12	Pomocný kontakt - 1xNC Auxiliary contact - 1xNC Hilfskontakt - 1 xNC	CA4-01	ABB	91.041.043	1	=SCHE/8.8

The manufacturer reserves right to use an equivalent replacement device.

 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Stroj/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-201702-V4.1	
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Kusovník artiklů / Parts list / Stückliste

Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednávací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-PA3	Pojistkový odpínač pro válcové vložky - 3P Switch fuse for the cylinder inserts - 3P Schalter Sicherung für den Zylinderreinsätze - 3P	E93/32	ABB	91.241.014	1	=SCHE/7.1
=SCHE-PA4	Pojistkový odpínač pro válcové vložky - 3P Switch fuse for the cylinder inserts - 3P Schalter Sicherung für den Zylinderreinsätze - 3P	E93/32	ABB	91.241.014	1	=SCHE/2.0
=SCHE-QS1	3 pólový odpínač, 25A Disconnecter - 3P, 25A Trennschalter - 3P, 25A	OT25FT3	ABB	91.170.016	1	=SCHE/1.0
=SCHE-QS1	Kryt svorek Terminal shroud Klemmenabdeckung	OTS40T3	ABB	91.170.017	1	=SCHE/1.0
=SCHE-QS1	Rukojeť odpínače - černá Handle switch - black Griffschalter - schwarz	OHBS2RJ	ABB	91.180.015	1	=SCHE/1.0
=SCHE-RE5	Patice pro relé Relay socket Relaissockel	CR-PSS	ABB	91.051.048	1	=SCHE/22.1
=SCHE-ZD1	Napájecí zdroj - 3x400VAC/24VDC, 20A Power supply - 3x400VAC/24VDC, 20A Energieversorgung - 3x400VAC/24VDC, 20A	CP-T 24/20.0	ABB	91.085.031	1	=SCHE/2.1
=SCHE-SP1	Hydraulický tlakový spínač 20-50bar Hydraulic pressure switch 20-50bar Hydraulische Druckschalter 20-50 bar	166415031059	ARGO HYTOS	92.201.003	1	=SCHE/19.5
=SCHE-SP2	Hydraulický tlakový spínač 20-50bar Hydraulic pressure switch 20-50bar Hydraulische Druckschalter 20-50 bar	166415031059	ARGO HYTOS	92.201.003	1	=SCHE/26.1
=SCHE-SP3	Hydraulický tlakový spínač 20-50bar Hydraulic pressure switch 20-50bar Hydraulische Druckschalter 20-50 bar	166415031059	ARGO HYTOS	92.201.003	1	=SCHE/26.3
=SCHE-SP4	Hydraulický tlakový spínač 20-50bar Hydraulic pressure switch 20-50bar Hydraulische Druckschalter 20-50 bar	166415031059	ARGO HYTOS	92.201.003	1	=SCHE/20.7
=SCHE-BQ1	Indukční snímač vzdálenosti Inductive proximity sensor Induktive Näherungssensor	BAW R06AC-UAF20B-EP03	BALLUFF	91.172.016	1	=SCHE/15.3

The manufacturer reserves right to use an equivalent replacement device.

 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Strojí/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-201702-V4.1 Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz Zpracováno/Processed /Hat verarbeitet: 01.11.2022 Datum/Date/Datum:	List/Page/ Seite: 3.b List/Page/ Seite: 53
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Kusovník artiklů / Parts list / Stückliste

Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednáací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-SQ1	Koncový spínač - 1NC+1NO, M20, pomalý Limit switch - 1NC+1NO, M20, slow Endschalter - 1NC+1NO, M20, langsam	D4N-4A32	OMRON	91.173.010	1	=SCHE/13.7
=SCHE-SQ7	Koncový spínač - 1NO Limit switch - 1NO Endschalter - 1NO	BNS 819-99-D-13-S80	BALLUFF	91.173.016	1	=SCHE/14.4
=SCHE-SQ14	Indukční snímač - Sn=1,5mm Inductive sensors - Sn = 1,5 mm Induktive Sensoren - Sn = 1,5 mm	JPS 30D 081.5 PNOFC	BALLUFF	91.172.009	1	=SCHE/26.2
=SCHE-SQ15	Indukční snímač - Sn=1,5mm Inductive sensors - Sn = 1,5 mm Induktive Sensoren - Sn = 1,5 mm	JPS 30D 081.5 PNOFC	BALLUFF	91.172.009	1	=SCHE/26.4
=SCHE-M3	Asynchronní motor 3x230/400V, 50Hz, 0,25kW Asynchronous motor 3x230 / 400V, 50Hz, 0.25 kW Asynchronmotor 3x230 / 400V, 50Hz, 0.25 kW	BN71A4	BONFIGLIOLI	91.001.255	1	=SCHE/4.1
=SCHE-M6	Asynchronní motor - 3x230/400V, 50Hz, 0,37kW Asynchronous motor - 3x230 / 400V, 50Hz 0.37kW Asynchronmotor - 3x230 / 400V, 50Hz 0.37kW	BN71B4	BONFIGLIOLI	91.001.106	1	=SCHE/6.1
=SCHE-SQ8	Kabel ke snímači s přímým konektorem M8 Sensor cable with a straight connector M8 Sensorkabel mit einem geraden Stecker M8	CF08SB-6	CREATIVE TECHNIK	91.142.003	1	=SCHE/19.3
=SCHE-SQ14	Kabel ke snímači s přímým konektorem M8 Sensor cable with a straight connector M8 Sensorkabel mit einem geraden Stecker M8	CF08SB-6	CREATIVE TECHNIK	91.142.003	1	=SCHE/26.2
=SCHE-H1	Maják - základna Lighthouse - Base Leuchtturm - Basis	SL7-CB-100	EATON	91.063.058	1	=SCHE/23.3
=SCHE-H1	Maják - žlutý Lighthouse - yellow Leuchtturm - gelb	SL7-L-Y	EATON	91.063.059	1	=SCHE/23.3
=SCHE-H1	Žárovka 24V Lamp 24V Lampe 24V	SL7-L24	EATON	91.063.061	1	=SCHE/23.3
=SCHE-H2	Signálka LED zelená na adaptér Green light for Eaton adapter Grünes Licht für Eaton-Adapter	M22-LED-G	EATON	91.061.023	1	=SCHE/17.6

The manufacturer reserves right to use an equivalent replacement device.

3.b

 BOMAR, s.r.o. Těšební 1236/1 CZ 627 00, Brno	Srovnání stroje / Machine: Individual 620.460 DGA	Název stránky / Name page / Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-201702-V4.1 Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz Zpracováno/Processed /Hat verarbeitet: 01.11.2022	List/Paper: 3.c
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Kusovník artiklů / Parts list / Stückliste

Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednávací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-H10-510	Signálka LED bílá na adaptér White LED light for adapter Weißes LED-Licht für Adapter	M22-LED-W	EATON	91.061.034	1	=SCHE/9.7
=SCHE-H510	Signálka LED bílá na adaptér White LED light for adapter Weißes LED-Licht für Adapter	M22-LED-W	EATON	91.061.034	1	=SCHE/8.6
=SCHE-OP2	Krabice - 3 díry Box - 3 holes Box - 3 Löcher	M22-13 IP66	EATON	91.190.052	1	=SCHE/29.1
=SCHE-OP2-SB10	Hlavice tlačítka - černá Head button - black Kopfstaste - schwarz	M22-D-S	EATON	91.060.035	1	=SCHE/29.3
=SCHE-OP2-SB10	Hmatník tlačítka - šipka Pushbutton fingerboard - arrow Druckknopf Griffbrett - Pfeil	M22-XD-S-X7	EATON	91.062.002	1	=SCHE/29.3
=SCHE-OP2-SB10	Kontaktní blok - 1NO; do krabičky Contact block - 1NO; to box Hilfskontakt 1NO; zu Box	M22-KC10	EATON	91.061.030	2	=SCHE/29.3
=SCHE-OP2-SB11	Hlavice tlačítka - černá Head button - black Kopfstaste - schwarz	M22-D-S	EATON	91.060.035	1	=SCHE/29.5
=SCHE-OP2-SB11	Hmatník tlačítka - šipka Pushbutton fingerboard - arrow Druckknopf Griffbrett - Pfeil	M22-XD-S-X7	EATON	91.062.002	1	=SCHE/29.5
=SCHE-OP2-SB11	Kontaktní blok - 1NO; do krabičky Contact block - 1NO; to box Hilfskontakt 1NO; zu Box	M22-KC10	EATON	91.061.030	2	=SCHE/29.5
=SCHE-OP2-SB12	Hlavice tlačítka - černá Head button - black Kopfstaste - schwarz	M22-D-S	EATON	91.060.035	1	=SCHE/29.6
=SCHE-OP2-SB12	Hmatník tlačítka - šipka Pushbutton fingerboard - arrow Druckknopf Griffbrett - Pfeil	M22-XD-S-X7	EATON	91.062.002	1	=SCHE/29.6
=SCHE-OP2-SB12	Kontaktní blok - 1NO; do krabičky Contact block - 1NO; to box Hilfskontakt 1NO; zu Box	M22-KC10	EATON	91.061.030	2	=SCHE/29.6

The manufacturer reserves right to use an equivalent replacement device.

 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Strojí/Machine/Maschine: Individual 620.460 DGA	Název stránky/Page/Name der Seite: Kusovník artiklů / Parts list / Artikelstückliste		Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-2017/02-V4.1		List/Page/ Seite: 3.d
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=SCHE-SA2	Hlavice 2 polohového přepínače, klíček Head 2-position switch, key Head 2-Positionsschalter, Schlüssel	M22-WRS2	EATON	91.060.070	1	=SCHE/8.2
=SCHE-SA2	Upevňovací adaptér + 1NO Attaching adapter + 1NO Montageadapter + 1NO	M22-AK10	EATON	91.061.021	1	=SCHE/8.2
=SCHE-SA2	Kontaktní blok - 1NC; na panel Contact block - 1NC; on the panel Kontaktblock - 1NC; auf dem panel	M22-K01	EATON	91.061.024	2	=SCHE/8.2
=SCHE-SA4	Přepínač 2 polohy Switch 2 positions Schalter 2 Positionen	M22 - WKV	EATON	91.060.037	1	=SCHE/28.3
=SCHE-SA4	Upevňovací adaptér + 1NO Attaching adapter + 1NO Montageadapter + 1NO	M22-AK10	EATON	91.061.021	1	=SCHE/28.3
=SCHE-SA4	Nosič štítků Moeller Moeller label holder Moeller Etikettenhalter	M22S-ST-X	EATON	91.062.009	1	=SCHE/28.3
=SCHE-SB1	Hlavice dvoutlačítka bílá/černá start/stop Double button head white/black start/stop Doppelrundkopf weiß/schwarz Start/Stop	M22-DDL-WS-GB1/GB0	EATON	91.060.034	1	=SCHE/14.2
=SCHE-SB1	Upevňovací adaptér + 1NO Attaching adapter + 1NO Montageadapter + 1NO	M22-AK10	EATON	91.061.021	1	=SCHE/14.2
=SCHE-SB2	Kontaktní blok - 1NO; na panel Contact block - 1NO; on the panel Kontaktblock - 1NO; auf dem panel	M22-K10	EATON	91.061.022	1	=SCHE/14.3
=SCHE-SB3	Upevňovací adaptér + 1NO Attaching adapter + 1NO Montageadapter + 1NO	M22-AK10	EATON	91.061.021	1	=SCHE/14.5
=SCHE-SB3	Hlavice dvoutlačítka bílá/černá Double button head white/black Doppelknopfkopf weiß/schwarz	M22-DDL-WS	EATON	91.060.033	1	=SCHE/14.5
=SCHE-SB4	Hlavice dvoutlačítka bílá/černá Double button head white/black Doppelrundkopf weiß / schwarz, Freil Schließen / Öffnen	M22-DDL-WS-*	EATON	91.060.055	1	=SCHE/14.5

The manufacturer reserves right to use an equivalent replacement device.

3.d

 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Strojí/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-201702-V4.1 Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz Zpracováno/Processed /Hat verarbeitet: 01.11.2022	List/Page/ Seite: 3.e
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=SCHE-SB4	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/14.5
=SCHE-SB5	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/20.2
=SCHE-SB5	Hlavice dvoutlačítka bílá/černá Double button head white/black Doppelknopfkopf weiß/schwarz	M22-DDL-WS	EATON	91.060.033	1	=SCHE/20.2
=SCHE-SB6	Hlavice dvoutlačítka bílá/černá, zavřít/otevřít Double button head white/black, arrow close/open Doppelrundkopf weiß / schwarz, Pfeil Schließen / Öffnen	M22-DDL-WS*	EATON	91.060.055	1	=SCHE/20.3
=SCHE-SB6	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/20.3
=SCHE-SB7	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/20.3
=SCHE-SB7	Hlavice dvoutlačítka bílá/černá Double button head white/black Doppelknopfkopf weiß/schwarz	M22-DDL-WS	EATON	91.060.033	1	=SCHE/20.3
=SCHE-SB8	Kontaktní blok - INO; na panel Contact block - INO; on the panel Kontaktblock - INO; auf dem panel	M22-K10	EATON	91.061.022	1	=SCHE/20.4
=SCHE-SB9	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/21.1
=SCHE-SB9	Hlavice dvoutlačítka bílá/černá Double button head white/black Doppelknopfkopf weiß/schwarz	M22-DDL-WS	EATON	91.060.033	1	=SCHE/21.1
=SCHE-SB10	Hlavice dvoutlačítka bílá/černá, zavřít/otevřít Double button head white/black, arrow close/open Doppelrundkopf weiß / schwarz, Pfeil Schließen / Öffnen	M22-DDL-WS*	EATON	91.060.055	1	=SCHE/21.2
=SCHE-SB10	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/21.2

The manufacturer reserves right to use an equivalent replacement device.

BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Stroj/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-2017/02-V4.1		Úč./Page/
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Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednávací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-SB10.510	Kontaktní blok - INO; na panel Contact block - INO; on the panel Kontaktblock - INO; auf dem panel	M22-K10	EATON	91.061.022	1	=SCHE/9.3
=SCHE-SB11	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/21.3
=SCHE-SB11	Hlavice dvoutlačítka bílá/černá Double button head white/black Doppelknopfkopf weiß/schwarz	M22-DDL-WS	EATON	91.060.033	1	=SCHE/21.3
=SCHE-SB12	Kontaktní blok - INO; na panel Contact block - INO; on the panel Kontaktblock - INO; auf dem panel	M22-K10	EATON	91.061.022	1	=SCHE/21.3
=SCHE-SB13	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/21.4
=SCHE-SB13	Hlavice dvoutlačítka bílá/černá Double button head white/black Doppelknopfkopf weiß/schwarz	M22-DDL-WS	EATON	91.060.033	1	=SCHE/21.4
=SCHE-SB14	Kontaktní blok - INO; na panel Contact block - INO; on the panel Kontaktblock - INO; auf dem panel	M22-K10	EATON	91.061.022	1	=SCHE/21.5
=SCHE-SB15	Hlavice dvoutlačítka bílá/černá, zavřít/otevřít Double button head white/black, arrow close/open Doppelknopfkopf weiß / schwarz, Pfeil Schließen / Öffnen	M22-DDL-WS-*	EATON	91.060.055	1	=SCHE/26.4
=SCHE-SB15	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/26.4
=SCHE-SB16	Hlavice dvoutlačítka bílá/černá, zavřít/otevřít Double button head white/black, arrow close/open Doppelknopfkopf weiß / schwarz, Pfeil Schließen / Öffnen	M22-DDL-WS-*	EATON	91.060.055	1	=SCHE/26.5
=SCHE-SB16	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/26.5
=SCHE-SB17	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/26.6

The manufacturer reserves right to use an equivalent replacement device.

3.f

 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Stroj/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-2017/02-V4.1		List/Page/
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Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednávací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-SB17	Hlavice dvoutlačítka bílá/černá Double button head white/black Doppelknopfkopf weiß/schwarz	M22-DDL-WS	EATON	91.060.033	1	=SCHE/26.6
=SCHE-SB18	Hlavice dvoutlačítka bílá/černá, zavřít/otevřít Double button head white/black, arrow close/open Doppelknopfkopf weiß/schwarz, Pfeil Schließen / Öffnen	M22-DDL-WS-*	EATON	91.060.055	1	=SCHE/26.7
=SCHE-SB18	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/26.7
=SCHE-SB510	Hlavice prosvětleného tlačítka modrá Blue transparent switch Blau transparent Schalter	M22-DL-B	EATON	91.060.132	1	=SCHE/8.7
=SCHE-SB510	Upevňovací adaptér + INO Attaching adapter + INO Montageadapter + INO	M22-AK10	EATON	91.061.021	1	=SCHE/8.7
=SCHE-ENC1	Lineární inkrementální snímač - 10-30VDC/10-30VDC, 8 m, volné Linear Encoder - 10-30VDC / 10-30VDC, 1,5 m, open Linear-Encoder - 10-30VDC / 10-30VDC	LMIX2-026-08.0-1-00-L	ELGO	92.270.018	1	=SCHE/13.1
=SCHE-ENC1	Magnetická páska Magnetic tape Magnetband	MB20.50	ELGO	91.271.002	1	=SCHE/13.1
=SCHE-ENC2	Lineární inkrementální snímač - 10-30VDC/10-30VDC, 8 m, volné Linear Encoder - 10-30VDC / 10-30VDC, 1,5 m, open Linear-Encoder - 10-30VDC / 10-30VDC	LMIX2-026-08.0-1-00-L	ELGO	92.270.018	1	=SCHE/13.3
=SCHE-ENC2	Magnetická páska Magnetic tape Magnetband	MB20.50	ELGO	91.271.002	1	=SCHE/13.3
=SCHE-ENC3	Lineární inkrementální snímač - 10-30VDC/10-30VDC, 8 m, volné Linear Encoder - 10-30VDC / 10-30VDC, 1,5 m, open Linear-Encoder - 10-30VDC / 10-30VDC	LMIX2-026-08.0-1-00-L	ELGO	92.270.018	1	=SCHE/13.5
=SCHE-ENC3	Magnetická páska Magnetic tape Magnetband	MB20.50	ELGO	91.271.002	1	=SCHE/13.5
=SCHE-FU2	Pojistka trubičková - 2A/250V, pomalá, 5x20 Tube fuse - 2A/250V, slow, 5x20 Rohrsicherung - 2A / 250V, langsam, 5x20	T2A/250V	ESKA	91.230.001	1	=SCHE/2.5

The manufacturer reserves right to use an equivalent replacement device.

3.9

 BOMAR, s.r.o. Těšební 1236/1 CZ 627 00, Brno	Strojí/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-201702-V4.1 Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz Zpracováno/Processed /Hat verarbeitet: 01.11.2022	List/Page/ Seite: 3.9 List/Page/ Seite: 53

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=SCHE-FU4	Pojistka trubičková - 2A/250V, pomalá, 5x20 Tube fuse - 2A/250V, slow, 5x20 Rohrsicherung - 2A / 250V, langsam, 5x20	T2A/250V	ESKA	91.230.001	1	=SCHE/2.8
=SCHE-FU5	Pojistka trubičková - 2A/250V, pomalá, 5x20 Tube fuse - 2A/250V, slow, 5x20 Rohrsicherung - 2A / 250V, langsam, 5x20	T2A/250V	ESKA	91.230.001	1	=SCHE/2.9
=SCHE-FU7	Pojistka trubičková - 200mA/250V, pomalá, 5x20 Tube fuse - 200mA/250V, slow, 5x20 Rohrsicherung - 160mA / 250V, langsam, 5x20	T200mA/250V	ESKA	91.230.037	1	=SCHE/28.1
=SCHE-FU8	Pojistka trubičková - 200mA/250V, pomalá, 5x20 Tube fuse - 200mA/250V, slow, 5x20 Rohrsicherung - 160mA / 250V, langsam, 5x20	T200mA/250V	ESKA	91.230.037	1	=SCHE/28.3
=SCHE-+OP1-PR1	Potenciometr 4k7 Potentiometer 4k7 Potentiometer 4k7	TP195 4k7/N20A	Elektronické součástky CZ, a.s	91.283.015	1	=SCHE/7.3
=SCHE-M1	Čerpadlo 3x230/400V, 50Hz, 120W Pump 3x230 / 400V, 50Hz, 120W Pumpe 3x230 / 400V, 50Hz, 120W	4COA4-14HP1	EmP s.r.o.	91.020.016	1	=SCHE/3.5
=SCHE-RE5	Relé s nuceně vedenými kontakty Relays with forced contacts Relais mit erzwungenen Kontakten	FIN 50.12.9.024.1000	FINDER	91.051.075	1	=SCHE/22.1
=SCHE-HV2A	Ventilový konektor, LED Valve Plug, LED Ventilanschluss, LED	VCAFA0322-LED	Finecables Co.,Ltd.	93.017.077	1	=SCHE/24.1
=SCHE-+OP1-PR1	Hlavice potenciometru - 24mm Head of potentiometer 24mm Leiter Potentiometer 24mm	S8877 BLK	GES-ELECTRONICS, a.s.	91.060.063	1	=SCHE/7.3
=SCHE-D5	Dioda 800V 3A Diode 800V 3A Diode 800V 3A	BY399 DO201	GM-electronics	91.280.009	1	=SCHE/22.4
=SCHE-LP2	Laser Laser Laser	Laser 24AC/DC	HOFMAN SYSTEMS s.r.o.	91.100.109	1	=SCHE/28.4
=SCHE-SB501	Total stop - hlavice + 2xNC Emergency-stop - button + 2xNC Not-Aus-Plz - Taster + 2xNC	YW1B-V4E02R	IDEC	91.060.084	1	=SCHE/8.5

The manufacturer reserves right to use an equivalent replacement device.

3.h

 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Srovnání stroje/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-201702-V4.1 Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz Zpracováno/Processed /Hat verarbeitet: 01.11.2022	List/Page/ Seite: 3.1
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Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednávací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-LQ1A	Jednocestná světelná závora - přijímač; M12-konektor; 0,3 m Through-beam sensor receiver; M12-male; 0,3 m Einweglichtschranke Empfänger; M12-male; 0,3 m	IFM.O6E701	IFM electronic	91.401.030	1	=SCHE/18.5
=SCHE-LQ1B	Jednocestná světelná závora - vysílač; M12-konektor; 0,3 m Through-beam sensor transmitter; M12-male; 0,3 m Einweglichtschranke Sender; M12-male; 0,3 m	IFM.O6S701	IFM electronic	91.401.031	1	=SCHE/18.6
=SCHE-LQ2A	Jednocestná světelná závora - přijímač; M12-konektor; 0,3 m Through-beam sensor receiver; M12-male; 0,3 m Einweglichtschranke Empfänger; M12-male; 0,3 m	IFM.O6E701	IFM electronic	91.401.030	1	=SCHE/20.5
=SCHE-LQ2B	Jednocestná světelná závora - vysílač; M12-konektor; 0,3 m Through-beam sensor transmitter; M12-male; 0,3 m Einweglichtschranke Sender; M12-male; 0,3 m	IFM.O6S701	IFM electronic	91.401.031	1	=SCHE/20.6
=SCHE-SQ10.10	Bezpečnostní koncový spínač - 2xNC Safety Limit Switch - 2x NC Sicherheitsendschalter - 2x NC	QKS8	KEDU	91.173.012	1	=SCHE/8.2
=SCHE-SQ21	Bezpečnostní koncový spínač - 2xNC Safety Limit Switch - 2x NC Sicherheitsendschalter - 2x NC	QKS8	KEDU	91.173.012	1	=SCHE/8.5
=SCHE-SQ22	Bezpečnostní koncový spínač - 2xNC Safety Limit Switch - 2x NC Sicherheitsendschalter - 2x NC	QKS8	KEDU	91.173.012	1	=SCHE/8.5
=SCHE-HV2A	PG9 - černá BS-22 PG9 - black BS-22 PG9 - schwarz BS-22	PG 9	KV components s.r.o.	91.070.002	1	=SCHE/24.1
=SCHE-FU3	Pojistka válcová - 10A, 10x38, pomalá Tube fuse - 10A, 10x38, slow Rohrsicherung - 10A, 10x38, langsam	PV10 10A aM	OEZ	91.230.041	1	=SCHE/2.7
=SCHE-PA1	Pojistkový odpínač pro válcové vložky E90- 1P, vel. 10 Switch fuse for the cylinder inserts E90- 1P, size 10 Schalter Sicherung für den Zylindereinsätze E90- 1P, Größe 10	E91/32	OEZ	91.241.012	1	=SCHE/5.1
=SCHE-PA1	Pojistka válcová - 20A, 10x38, rychlá Tube fuse - 20A, 10x38, fast Rohrsicherung - 20A, 10x38, schnell	PV10 20A gG	OEZ	91.230.038	1	=SCHE/5.1
=SCHE-PA2	Pojistkový odpínač pro válcové vložky E90- 1P, vel. 10 Switch fuse for the cylinder inserts E90- 1P, size 10 Schalter Sicherung für den Zylindereinsätze E90- 1P, Größe 10	E91/32	OEZ	91.241.012	1	=SCHE/6.1

The manufacturer reserves right to use an equivalent replacement device.

3.i	 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Stroj/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-2017/02-V4.1			Úč./Page/Seite: 3.i
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Kusovník artiklů / Parts list / Stückliste

Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednáací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-PA2	Pojistka válcová - 10A, 10x38, rychlá Tube fuse - 10A, 10x38, fast Rohrsicherung - 10A, 10x38, schnell	PV10 10A gG	OEZ	91.231.008	2	=SCHE/6.1
=SCHE-PA3	Pojistka válcová - 20A, 10x38, rychlá Tube fuse - 20A, 10x38, fast Rohrsicherung - 20A, 10x38, schnell	PV10 20A gG	OEZ	91.230.038	3	=SCHE/7.1
=SCHE-PA4	Pojistka válcová - 2A, 10x38, rychlá Tube fuse - 2A, 10x38, fast Rohrsicherung - 2A, 10x38, schnell	PV10 2A gG	OEZ	91.230.034	3	=SCHE/2.0
=SCHE-SQ2	Koncový spínač - 1NC+1NO, M20, pomalý Limit switch - 1NC+1NO, M20, slow Endschalter - 1NC+1NO, M20, langsam	D4N-4A32	OMRON	91.173.010	1	=SCHE/13.8
=SCHE-SQ3	Koncový spínač - 1NC+1NO, M20, pomalý Limit switch - 1NC+1NO, M20, slow Endschalter - 1NC+1NO, M20, langsam	D4N-4A32	OMRON	91.173.010	1	=SCHE/14.2
=SCHE-SQ13	Koncový spínač - 1NC+1NO Limit switch - 1NC+1NO Endschalter - 1NC+1NO	D4N-4A31	OMRON	91.173.007	1	=SCHE/20.1
=SCHE-SQ4	Koncový spínač - 1NO + 1NC, kladka, pomalá akce Limit switch - 1NO + 1NC, pulley, slow action Endschalter - 1NO + 1NC, rolle, langsame Einwirkung	FR 605-M2	PIZZATO	91.173.009	1	=SCHE/18.7
=SCHE-SQ5	Koncový spínač - 1NO + 1NC, kladka, pomalá akce Limit switch - 1NO + 1NC, pulley, slow action Endschalter - 1NO + 1NC, rolle, langsame Einwirkung	FR 605-M2	PIZZATO	91.173.009	1	=SCHE/18.8
=SCHE-SQ6	Koncový spínač - 1NO + 1NC Limit switch - 1NO + 1NC Endschalter - 1NO + 1NC	FK 3301-M1	PIZZATO	91.173.015	1	=SCHE/19.1
=SCHE-SQ10	Koncový spínač - 1NO + 1NC Limit switch - 1NO + 1NC Endschalter - 1NO + 1NC	FK 3301-M1	PIZZATO	91.173.015	1	=SCHE/19.4
=SCHE-SQ11	Koncový spínač - 1NO + 1NC Limit switch - 1NO + 1NC Endschalter - 1NO + 1NC	FR 555-M2	PIZZATO	91.173.018	1	=SCHE/19.6
=SCHE-SQ12	Koncový spínač - 1NO + 1NC Limit switch - 1NO + 1NC Endschalter - 1NO + 1NC	FR 555-M2	PIZZATO	91.173.018	1	=SCHE/19.7

The manufacturer reserves right to use an equivalent replacement device.

3.j	 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Stroj/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-2017/02-V4.1 Napájení/Power supply/Einspeisung: 3~400V + PE, 50Hz Zpracováno/Processed /Hat verarbeitet: 01.11.2022	List/Page/ Seite: 3.k
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Kusovník artiklů / Parts list / Stückliste

Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednávací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-BM10.10	Bezpečnostní spínací přístroj Safety switch Sicherheitsschalter	SICK.1085343	SICK	91.051.071	1	=SCHE/9.6
=SCHE-BM10.11	Bezpečnostní spínací přístroj Safety switch Sicherheitsschalter	SICK.1085343	SICK	91.051.071	1	=SCHE/10.6
=SCHE-SQ8	Induktivní senzor - 2mm, NO, 24V DC, 200mA, M8 Induktive sensor - 2mm NO, 24VDC, 200 mA, M8 Induktive Sensor - 2mm NO, 24VDC, 200 mA, M8	IME08-02BPSZT0S	SICK	91.172.033	1	=SCHE/19.3
=SCHE-SQ9	Induktivní senzor - 2mm, NO, 24V DC, 200mA, M8 Induktive sensor - 2mm NO, 24VDC, 200 mA, M8 Induktive Sensor - 2mm NO, 24VDC, 200 mA, M8	IME08-02BPSZT0S	SICK	91.172.033	1	=SCHE/19.3
=SCHE-SZ10.10A	Víceprisková bezpečnostní světelná závora - přijímač Safety multi-beam light curtain - receiver Sicherheits-Mehrstrahl - Lichtvorhang - Empfänger	M40E-025030RR0	SICK	91.401.009	1	=SCHE/9.3
=SCHE-SZ10.10A	Kabel s přímým konektorem M12, 8pin Cable with straight connector M12, 8pin Kabel mit geradem Stecker M12, 8pin	DOL-127SG15ME25KM0	SICK	91.142.015	1	=SCHE/9.3
=SCHE-SZ10.10B	Víceprisková bezpečnostní světelná závora - vysílač Safety multi-beam light curtain - transmitter Sicherheits-Mehrstrahl - Lichtvorhang - Sender	M40S-025010AR0	SICK	91.401.008	1	=SCHE/9.0
=SCHE-SZ10.10B	Kabel s přímým konektorem M12, 8pin Cable with straight connector M12, 8pin Kabel mit geradem Stecker M12, 8pin	DOL-127SG15ME25KM0	SICK	91.142.015	1	=SCHE/9.0
=SCHE-SZ10.11A	Víceprisková bezpečnostní světelná závora - přijímač Safety multi-beam light curtain - receiver Sicherheits-Mehrstrahl - Lichtvorhang - Empfänger	M40E-025030RR0	SICK	91.401.009	1	=SCHE/10.3
=SCHE-SZ10.11A	Kabel s přímým konektorem M12, 8pin Cable with straight connector M12, 8pin Kabel mit geradem Stecker M12, 8pin	DOL-127SG15ME25KM0	SICK	91.142.015	1	=SCHE/10.3
=SCHE-SZ10.11B	Víceprisková bezpečnostní světelná závora - vysílač Safety multi-beam light curtain - transmitter Sicherheits-Mehrstrahl - Lichtvorhang - Sender	M40S-025010AR0	SICK	91.401.008	1	=SCHE/10.0
=SCHE-SZ10.11B	Kabel s přímým konektorem M12, 8pin Cable with straight connector M12, 8pin Kabel mit geradem Stecker M12, 8pin	DOL-127SG15ME25KM0	SICK	91.142.015	1	=SCHE/10.0

The manufacturer reserves right to use an equivalent replacement device.

3.k



BOMAR, s.r.o.

Těžební 1236/1

CZ 627 00, Brno

Stroj/Machine/Maschine:

Individual 620.460 DGA

Název stránky/Name page/Name seiten:

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Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednávací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-A1.1.1	SIMATIC S7-1200, CPU 1215C, COMPACT CPU SIMATIC S7-1200, CPU 1215C, COMPACT CPU SIMATIC S7-1200, CPU 1215C, COMPACT CPU	6ES7215-1AG40-0XB0	SIE	91.995.892	1	=SCHE/27.1
=SCHE-A1.7.1	SIMATIC S7-1200, DIGITAL OUTPUT SM 1222, 16 DO SIMATIC S7-1200, DIGITAL OUTPUT SM 1222, 16 DO SIMATIC S7-1200, DIGITAL OUTPUT SM 1222, 16 DO	6ES7222-1BH32-0XB0	SIE	91.995.941	1	=SCHE/24.0
=SCHE-FM3	SINAMICS V20 3AC380-480V, POWER 4KW SINAMICS V20 3AC380-480V, POWER 4KW SINAMICS V20 3AC380-480V, POWER 4KW	6ES7221-1BH32-0XB0	SIE	91.012.221	1	=SCHE/7.1
=SCHE-A1.5.1	SIMATIC S7-1200, SM 1221, 16 DI SIMATIC S7-1200, SM 1221, 16 DI SIMATIC S7-1200, SM 1221, 16 DI	6ES7221-1BH32-0XB0	SIEMENS	91.995.893	1	=SCHE/18.0
=SCHE-A1.5.2	SIMATIC S7-1200, DIGITAL I/O SM 1223, 16DI / 16DO SIMATIC S7-1200, DIGITAL I/O SM 1223, 16DI / 16DO SIMATIC S7-1200, DIGITAL I/O SM 1223, 16DI / 16DO	6ES7223-1PL32-0XB0	SIEMENS	91.995.942	1	=SCHE/20.0
=SCHE-A1.5.3	SIMATIC S7-1200, SM 1221, 16 DI SIMATIC S7-1200, SM 1221, 16 DI SIMATIC S7-1200, SM 1221, 16 DI	6ES7221-1BH32-0XB0	SIEMENS	91.995.893	1	=SCHE/26.0
=SCHE-FM1	SINAMICS V20 1 AC 200-240 V, POWER 1.1 kW SINAMICS V20 1 AC 200-240 V, POWER 1.1 kW SINAMICS V20 1 AC 200-240 V, POWER 1.1 kW	6ES7221-1BH32-0XB0	SIEMENS	91.012.220	1	=SCHE/5.1
=SCHE-FM2	SINAMICS V20 1AC200-240V, POWER 0.37KW SINAMICS V20 1AC200-240V, POWER 0.37KW SINAMICS V20 1AC200-240V, POWER 0.37KW	6ES7221-1BH32-0XB0	SIEMENS	91.012.219	1	=SCHE/6.1
=SCHE-HM11	SIMATIC HMI MTP700 COMFORT SIMATIC HMI KTP700 COMFORT SIMATIC HMI KTP700 COMFORT	6ES7221-1BH32-0XB0	SIEMENS	91.995.940	1	=SCHE/11.0
=SCHE-M8	Ventilátor 24VDC, 5W Fan 24VDC, 5W Fan 24VDC, 5W	EEC0252B1-A99	SUNON	91.015.139	1	=SCHE/22.3
=SCHE-+OP1-PR1	Svorka rychloupínací Fastconnect clamp Fast Connect Klemm	WAGO 224-112	WAGO	91.250.009	3	=SCHE/7.3
=SCHE-LP1	LED lamp LED lamp LED-Lampe	FL-T-24-1X3W	WIDECO	91.100.115	1	=SCHE/28.1

The manufacturer reserves right to use an equivalent replacement device.

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 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Stroj/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente.: ES-101.481-201202-V4.1 Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz Zpracováno/Processed /Hat verarbeitet: 01.11.2022	Účt./Page/ Seite: 3.1 Účt./Page/ Seite: 53
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Kusovník artiklů / Parts list / Stückliste

Označení přístroje Device identification Geräteidentifikation	Typ přístroje Device description Gerätebeschreibung	Objednávací číslo Type number Typennummer	Výrobce Manufacturer Hersteller	Skladové číslo Part number Lagernummer	Množství Quantity Menge	Umístění Location Stelle
=SCHE-FU2	Svorka pojistková Fuse terminal Sicherungsklemme	WK4/THS5U	WIELAND	91.251.102	1	=SCHE/2.5
=SCHE-FU4	Svorka pojistková Fuse terminal Sicherungsklemme	WK4/THS5U	WIELAND	91.251.102	1	=SCHE/2.8
=SCHE-FU5	Svorka pojistková Fuse terminal Sicherungsklemme	WK4/THS5U	WIELAND	91.251.102	1	=SCHE/2.9
=SCHE-FU7	Svorka pojistková Fuse terminal Sicherungsklemme	WK4/THS5U	WIELAND	91.251.102	1	=SCHE/28.1
=SCHE-FU8	Svorka pojistková Fuse terminal Sicherungsklemme	WK4/THS5U	WIELAND	91.251.102	1	=SCHE/28.3
=SCHE-RT10.7	Modem-router eWON COSY 131, WAN Modem-router eWON COSY 131, WAN Modem-router eWON COSY 131, WAN	EC61330	eWON	91.990.034	1	=SCHE/28.5

The manufacturer reserves right to use an equivalent replacement device.

	BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Srovnání/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: Kusovník artiklů / Parts list / Artikelstückliste	Číslo dok./Doc.No./Anzahl der Dokumente.: ES-101-481-2017/202-V4.1 Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz Zpracováno/Processed /Hat verarbeitet: 01.11.2022	Stránka/Page: 3.n List/Page: 53
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BOMAR, s.r.o.
Těžební 1236/1
CZ 627 00, Brno

Stroj/Machine/Maschine:
Individual 620.460 DGA

Název stránky/Name page/Namen seiten:
Plán konektoru =SCHE-X11 Plug diagram =SCHE-X11 Steckerplan =SCHE-X11

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Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz
Zpracoval/Processed /Hk verarbeitet: Datum/Date/Datum: 02.02.2022

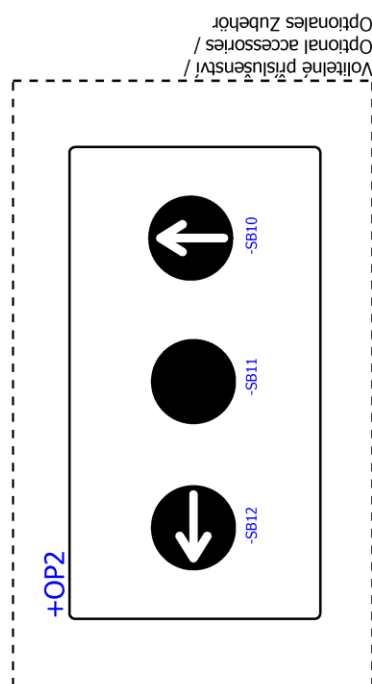
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Konektor Connector Stecker	Cíl konektoru Connector target Stecker Ziel	Kontakt Contact Kontakt	Cíl zásuvek Outlet target Outlet-Ziel	Stránka / sloupec Page / Column Seite / Spalte
=SCHE-X11				
	-M5:U1	1	-FM1:U	/5.1
	-M5:V1	2	-FM1:V	/5.1
	-M5:W1	3	-FM1:W	/5.2
	-M5:PE	4	-FM1:PE2	/5.2
		5	-FM1:PE2	/5.2

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Plán konektoru Connector plan Stecker Zeitplan									
Konektor Connector Stecker		Cíl konektoru Connector target Stecker Ziel		Kontakt Contact Kontakt		Cíl zásuvek Outlet target Outlet-Ziel		Stránka / sloupec Page / Column Seite / Spalte	
=SCHE-X13									
		--+R2-XC1:100		1		--+R1-XC1:100		/2.3	
		--+R2-XC2:200		2		--+R1-XC2:200		/2.5	
		-SP4:14		3		241		/20.7	
		--+R1-XC5:333		4		--+R2-XC5:333		/24.6	
		--+R1-XC5:334		5		--+R2-XC5:334		/24.7	
		--+R1-XC5:335		6		--+R2-XC5:335		/25.1	
		--+R1-XC5:336		7		--+R2-XC5:336		/25.2	
		--+R1-XC5:337		8		--+R2-XC5:337		/25.3	
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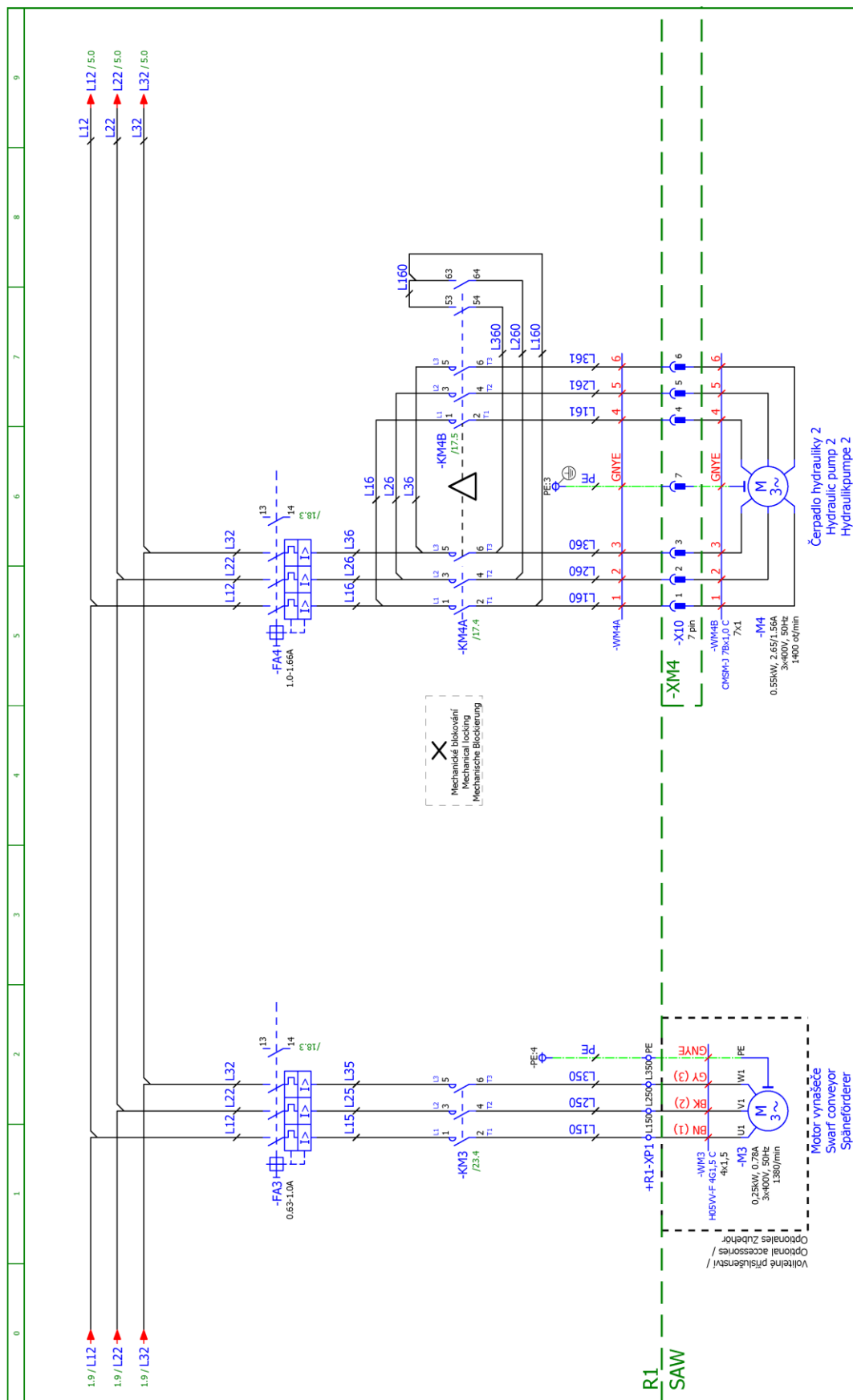
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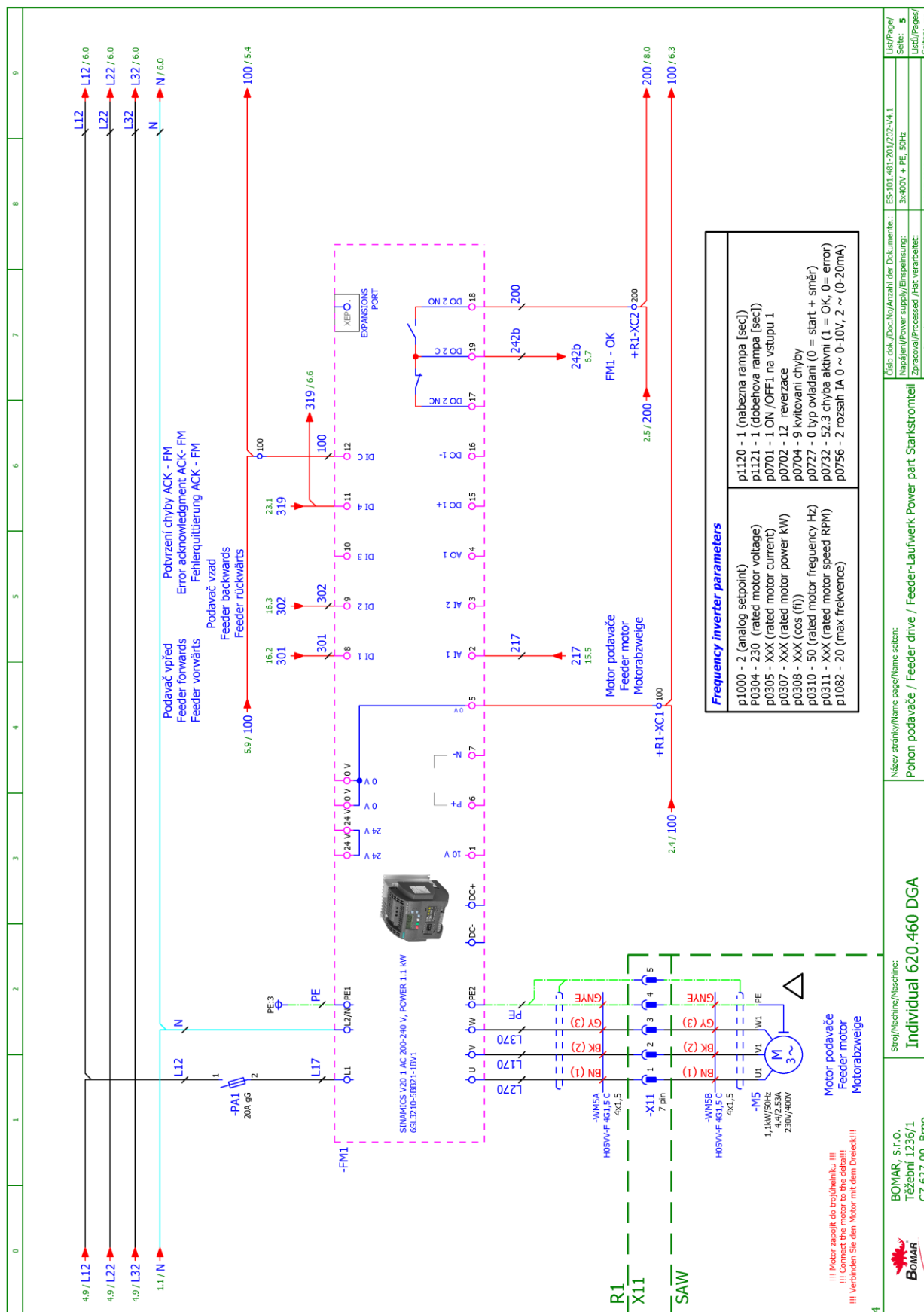




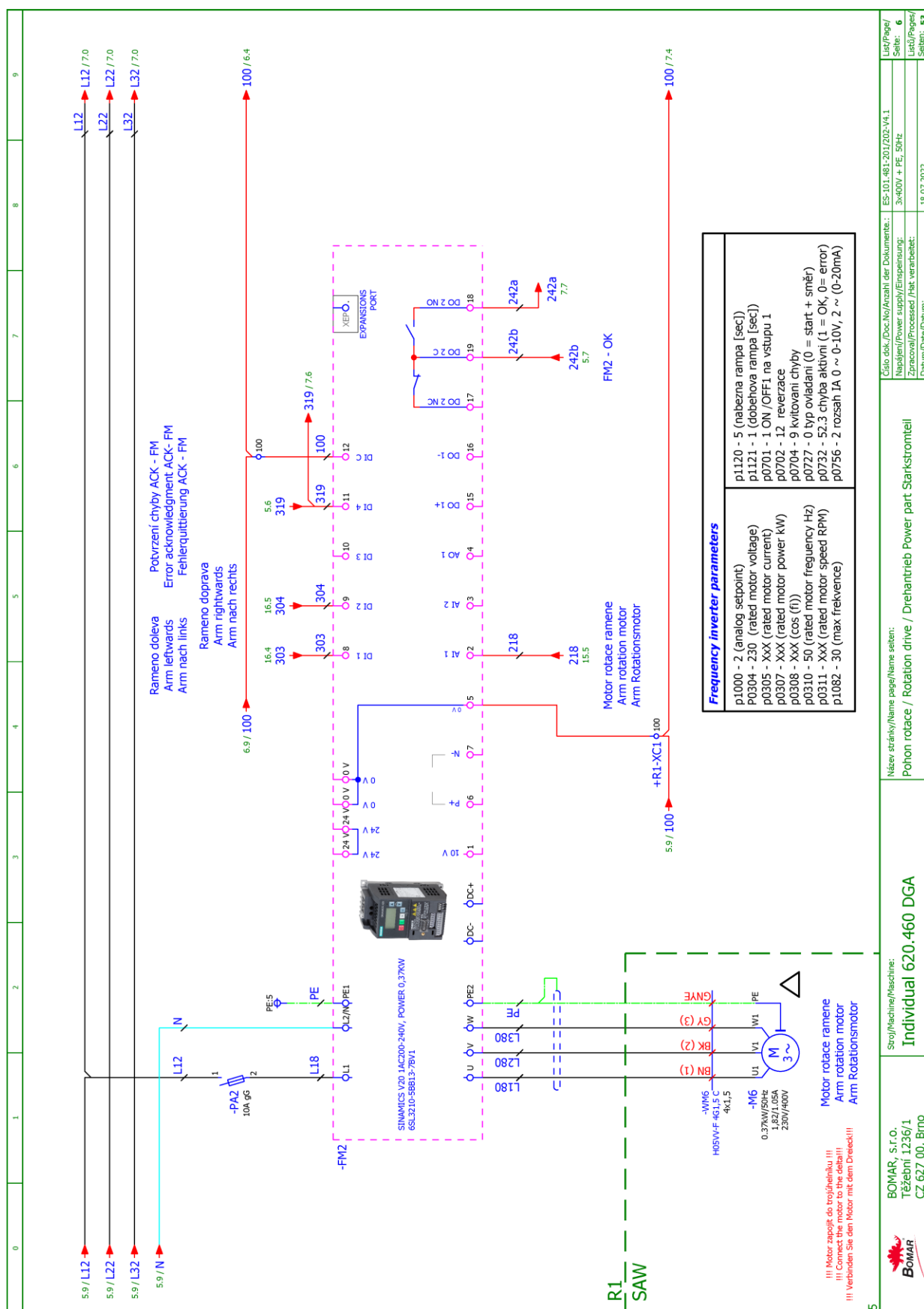




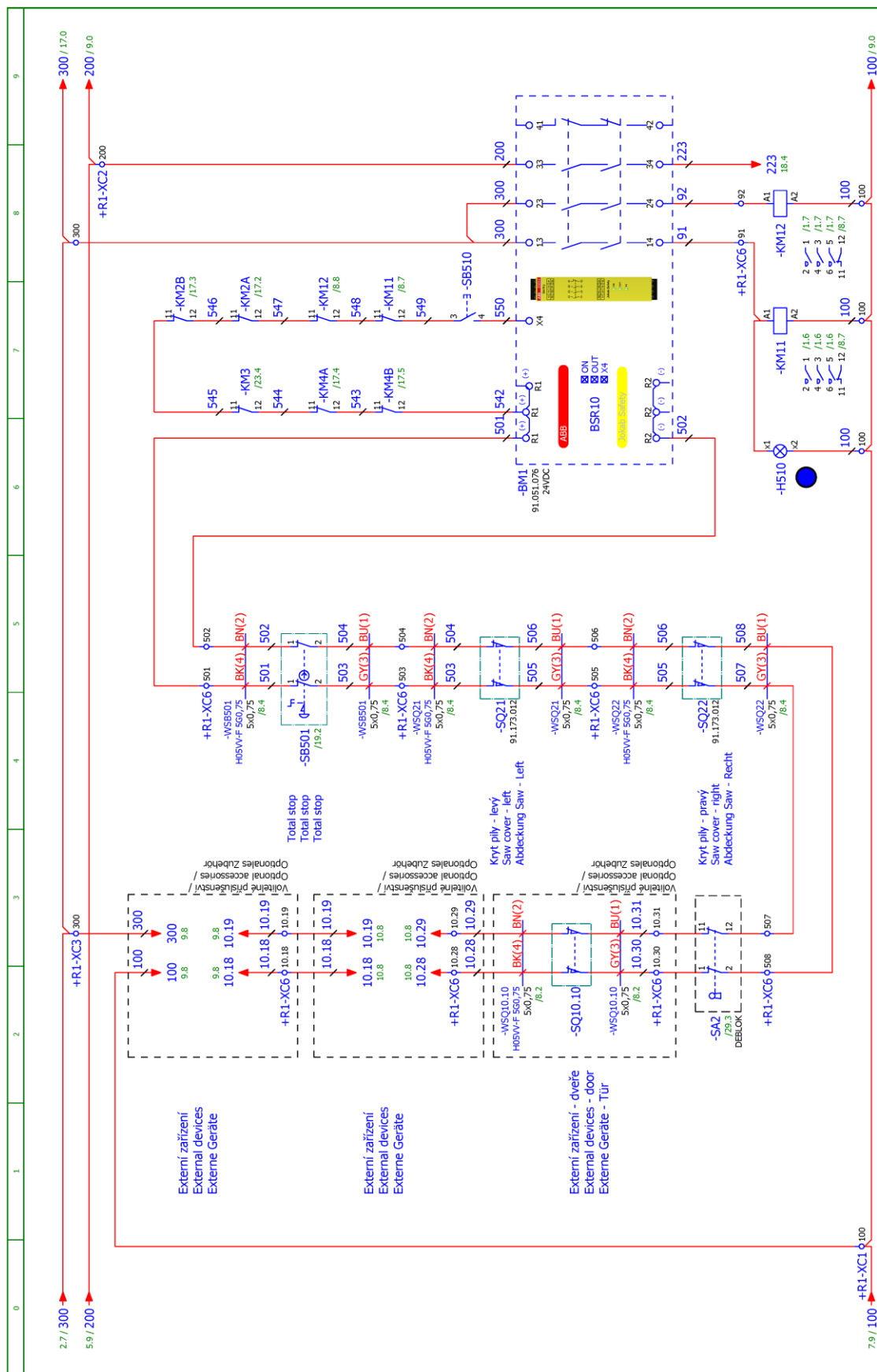




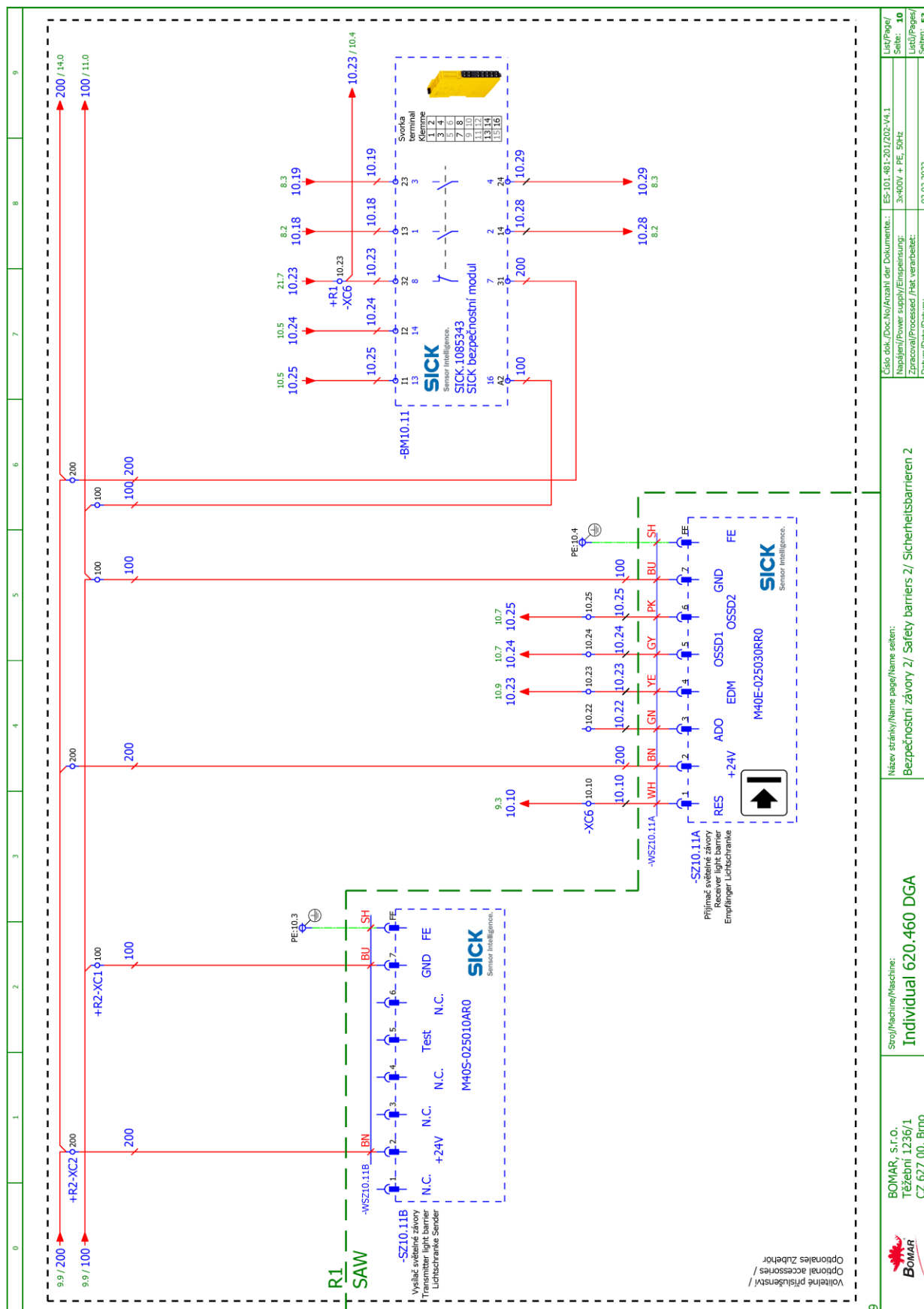
BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Název stránky/Name page/Name seiten: Pohon podavače / Feeder drive / Feeder-Laufwerk Power part Starkstromteil		Číslo dok./Doc.No./Anzahl der Dokumente: ES-101-481-201202-V4.1
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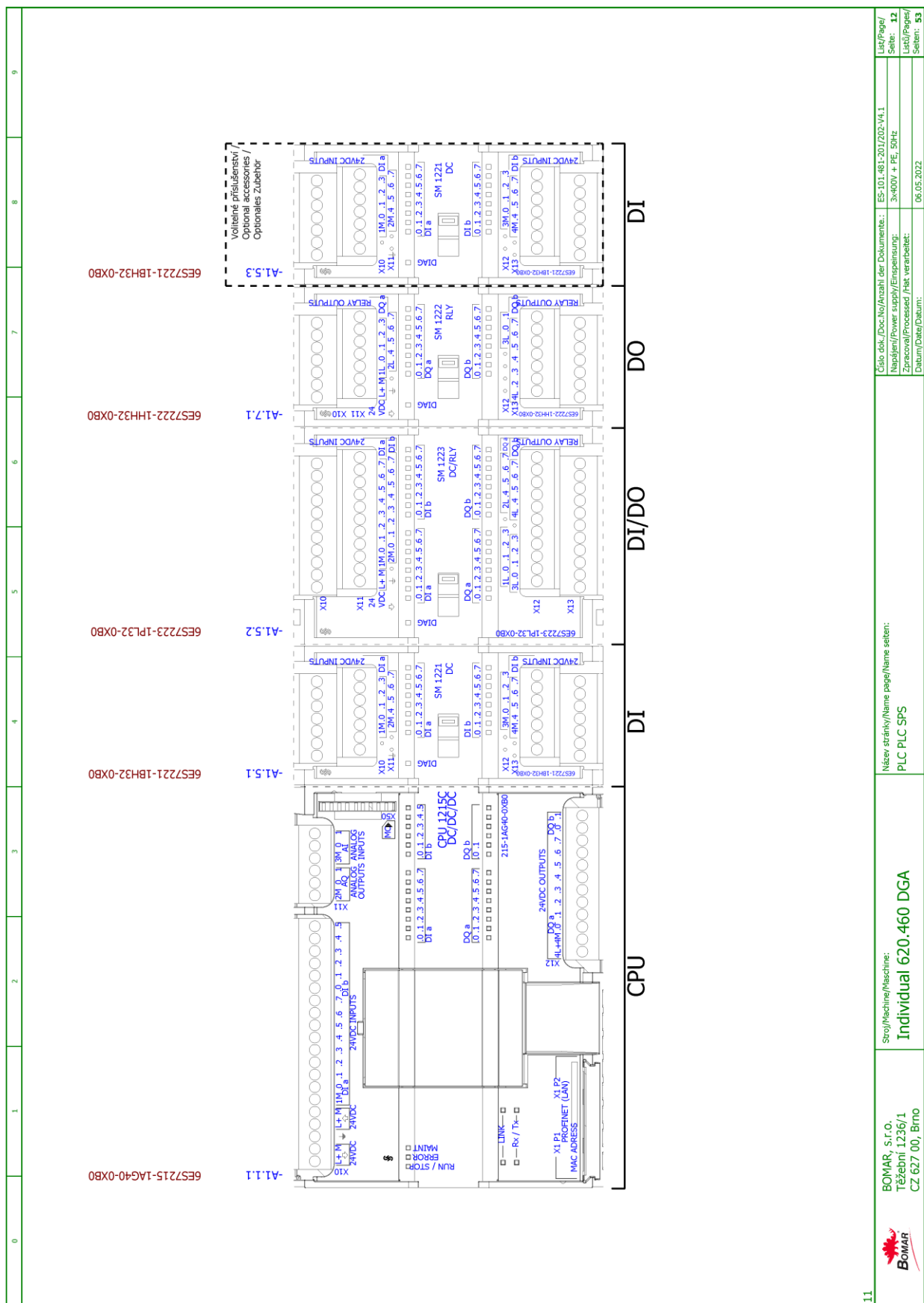


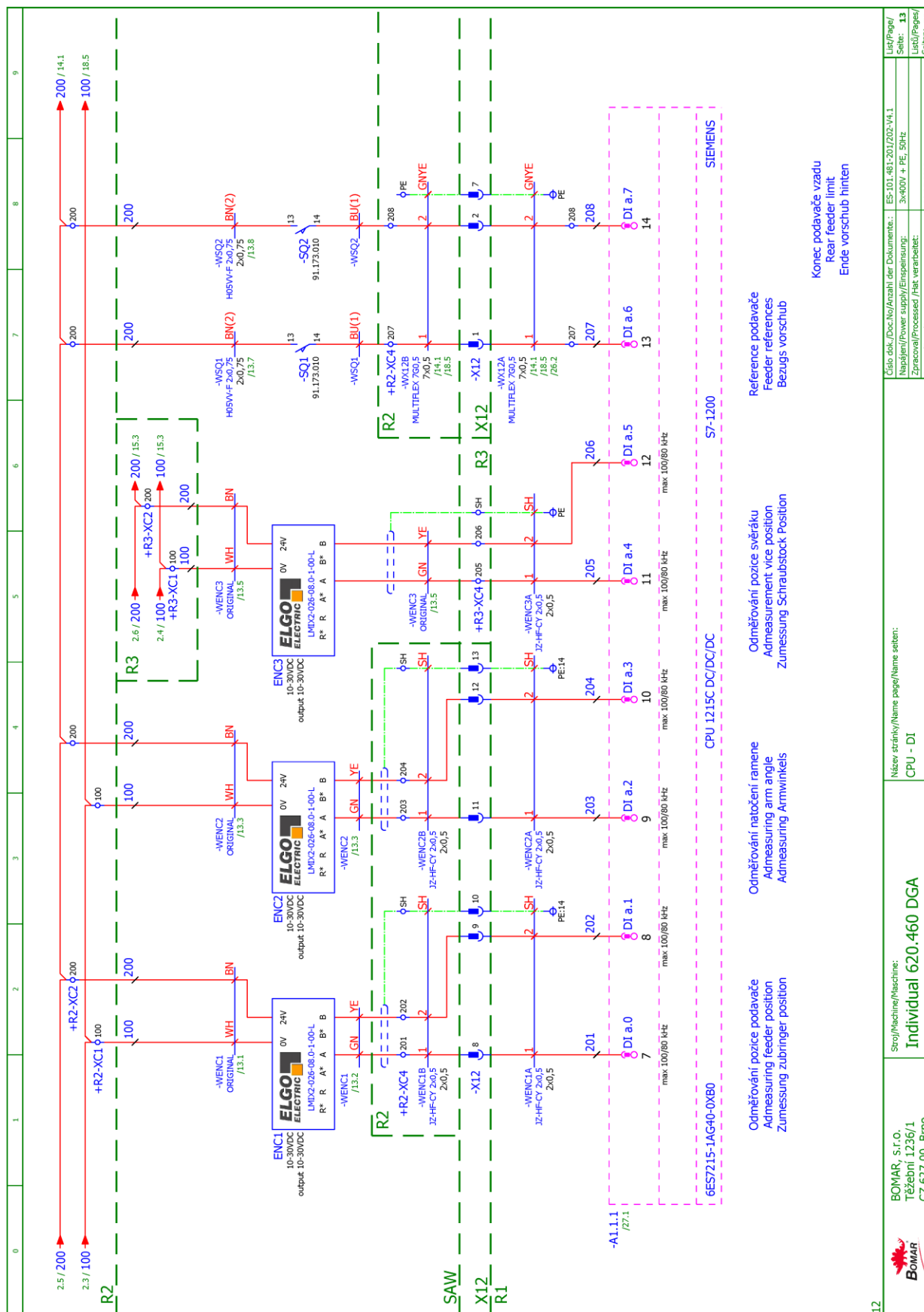




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Konec podavače vrazdu
Rear feeder limit
Ende vorschub hinten

Reference podavače
Feeder references
Bezugs vorschub

Odměrování natožení ramene
Admeasuring arm angle
Zumessung Schraubstock Position

Odměrování pozice svěřáku
Admeasuring vice position
Zumessung Schraubstock Position

Odměrování pozice podavače
Admeasuring feeder position
Zumessung zubringer position

12

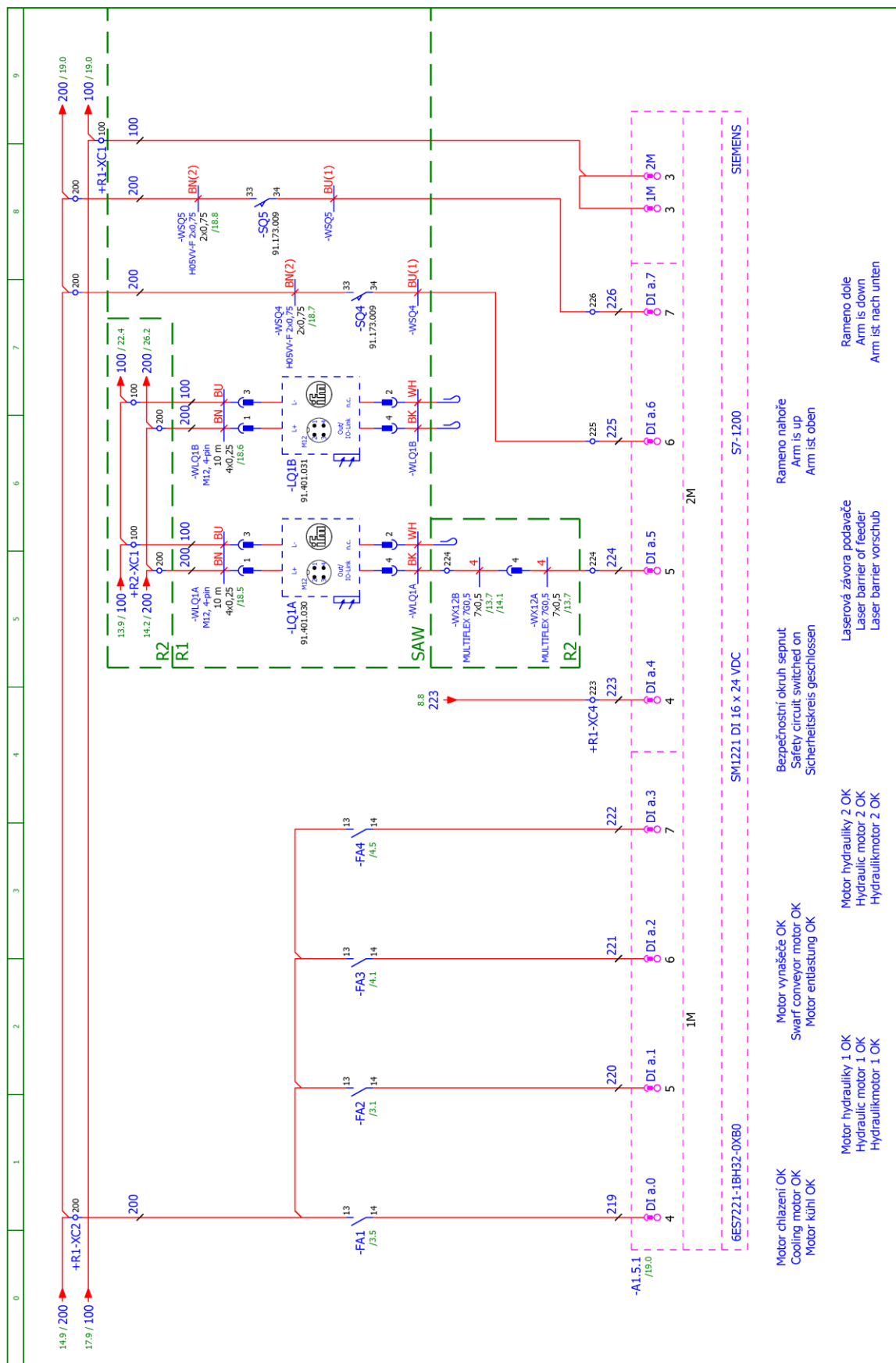
	Stroj/Machine/Maschine:		Název stránky/Name page/Name seiten:		Číslo dok./Doc.No./Anzahl der Dokumenten:	
	Individual 620.460 DGA		CPU - DI		ES-101.481-2017/202-V4.1	
					Napájení/Power supply/Einspeisung:	
					3x400V + PE, 50Hz	
				Zpracování/Processed /Fakt verarbeitet:		
				Datum/Date/Datum:	09.05.2022	
				List(Pages)/	13	
				List(Pages)/	53	
				List(Pages)/	53	





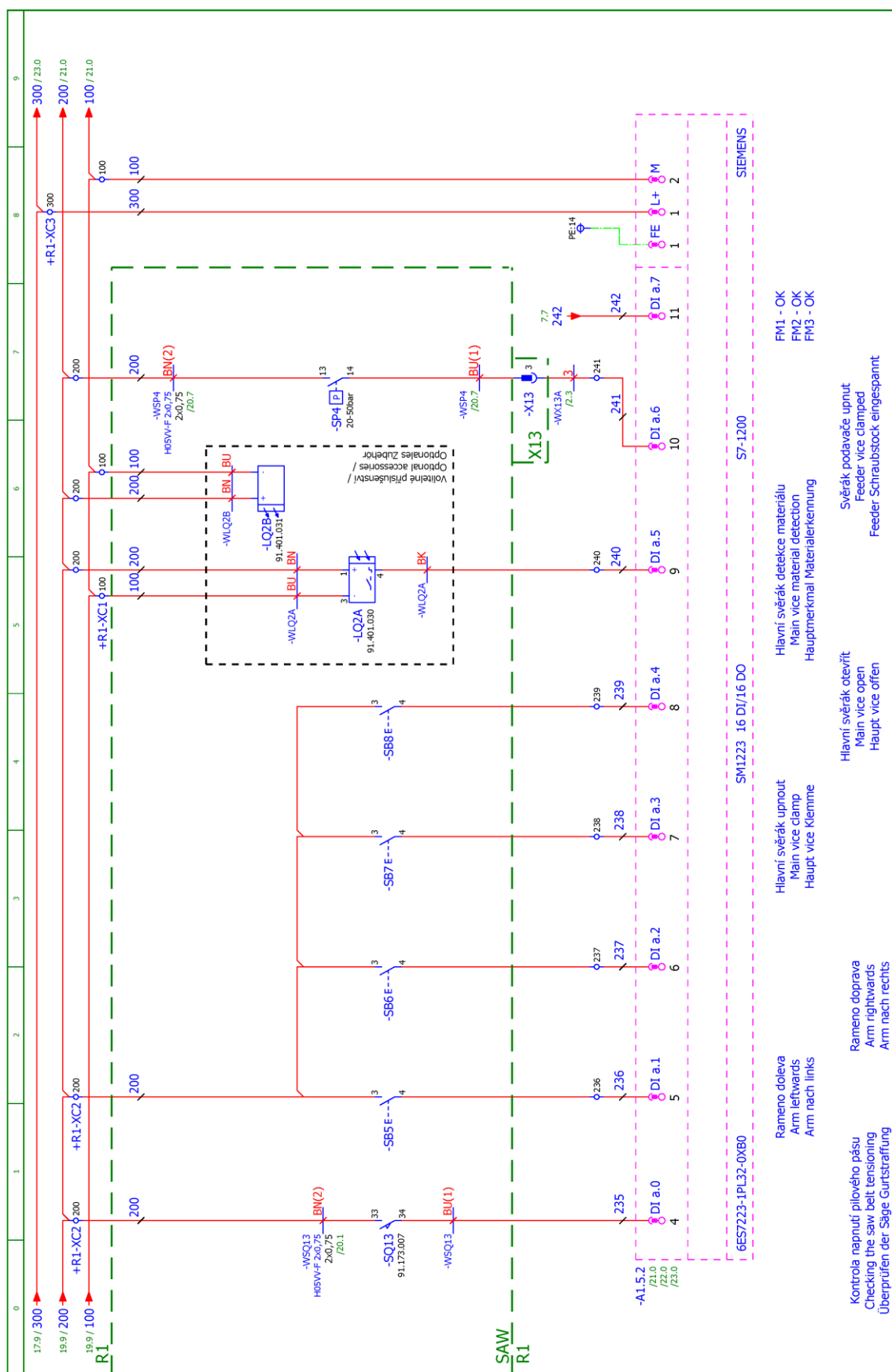




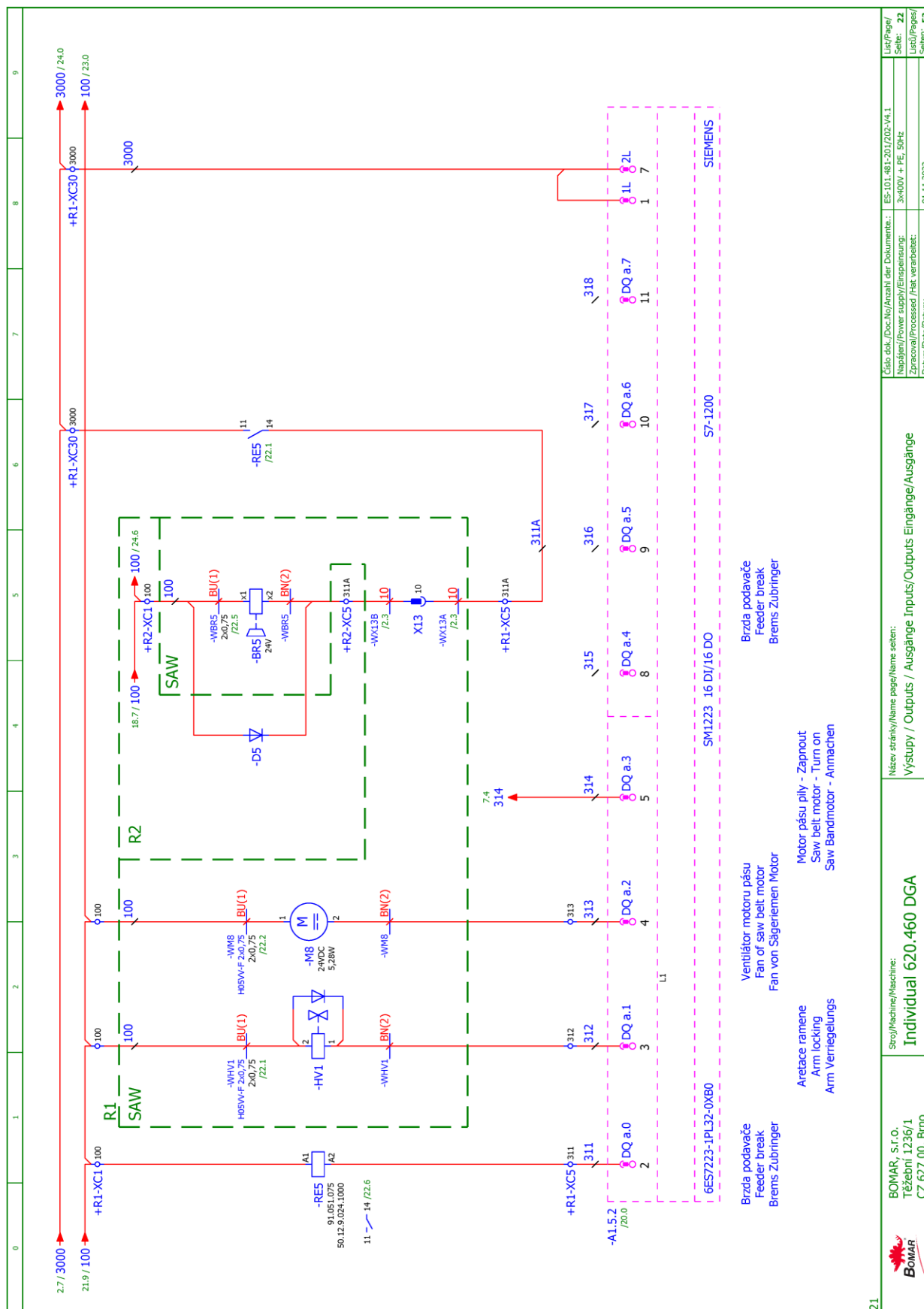


	Srojl/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: DI	Číslo dok./Doc.No./Anzahl der Dokumente: ES-101.481-2017/02-V4.1 Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz Zpracováno/Processed /Hat verarbeitet: 01.11.2022 List/Page/ Seite: 18 List/Page/ Seite: 53
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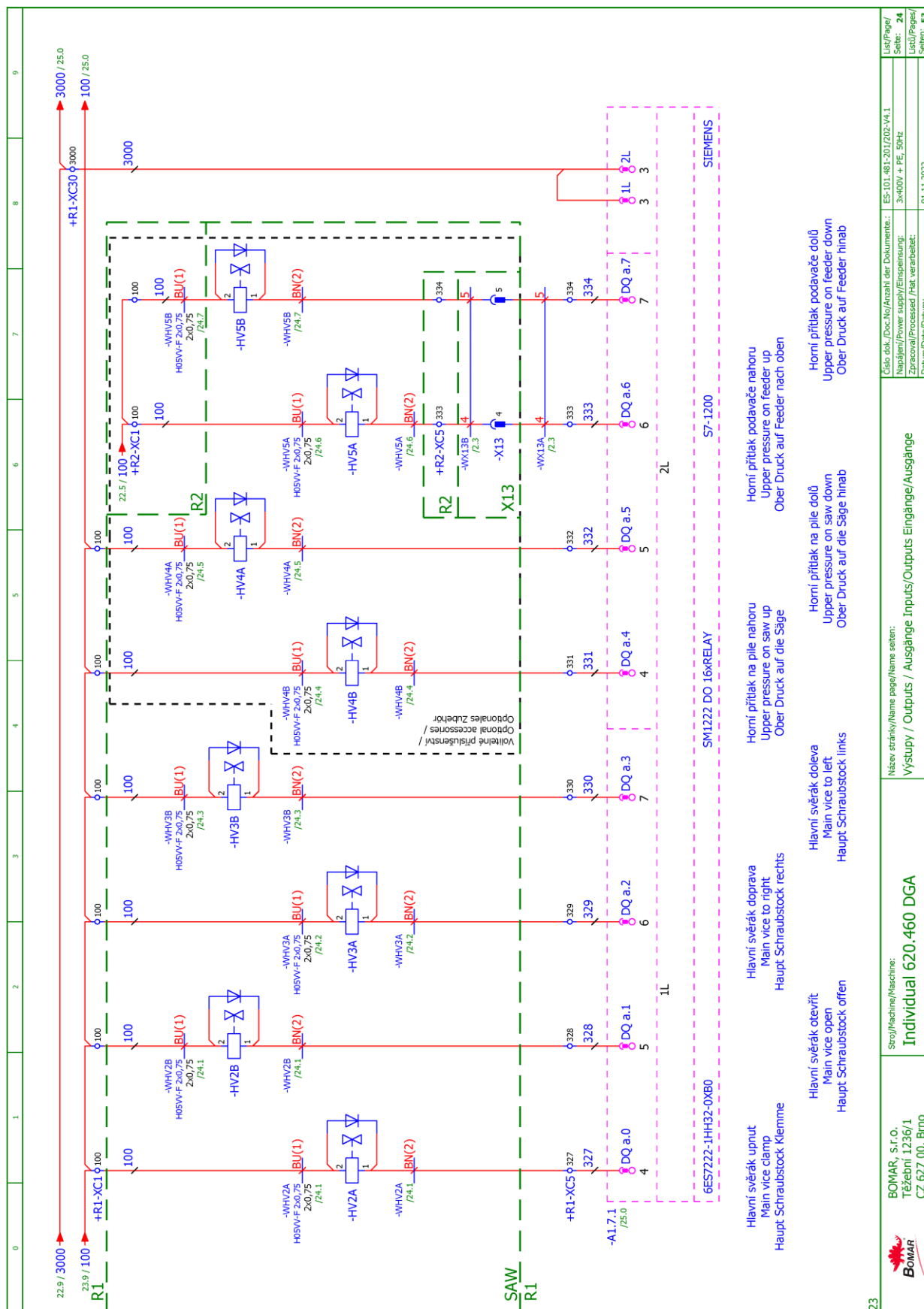




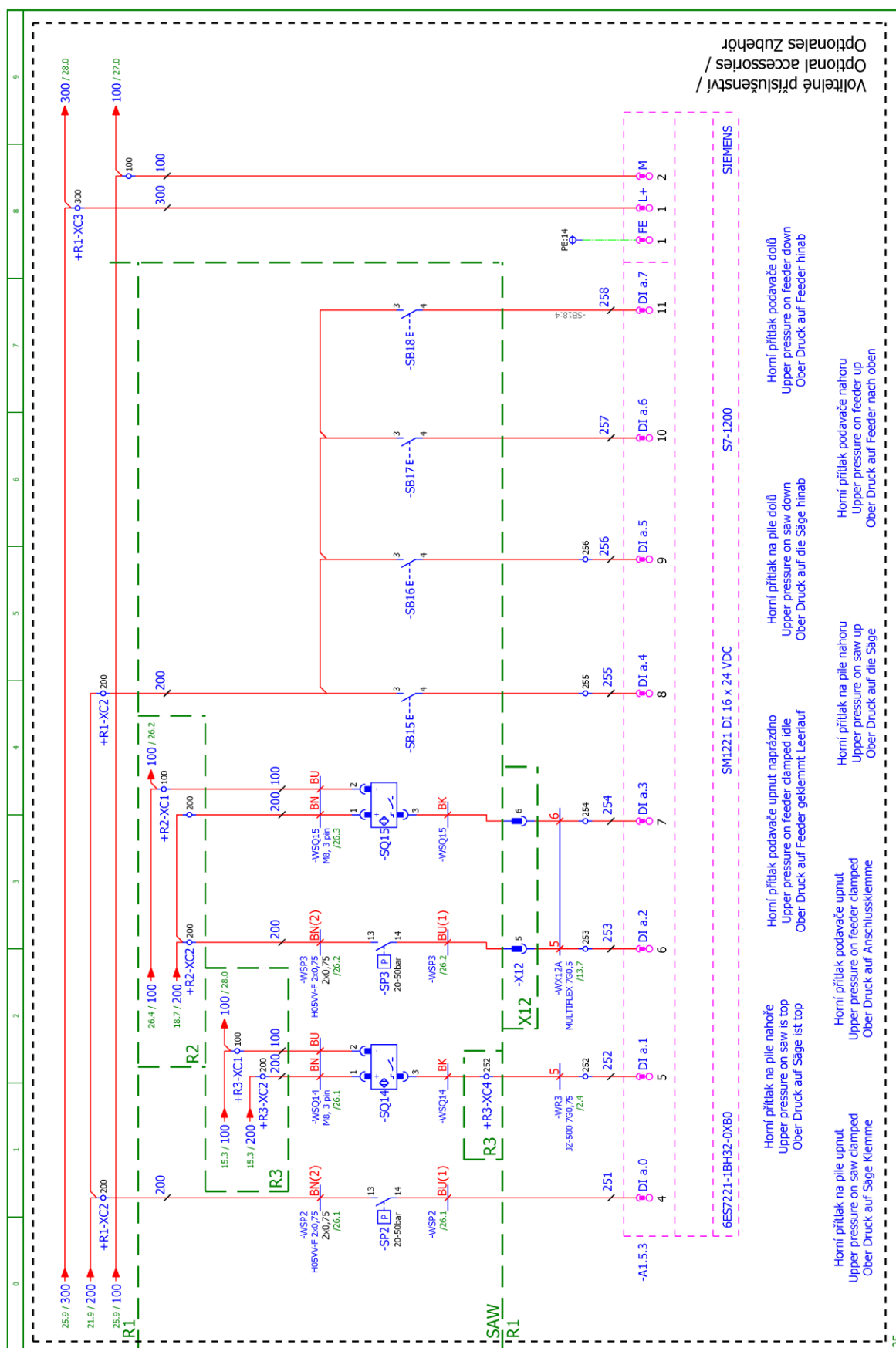




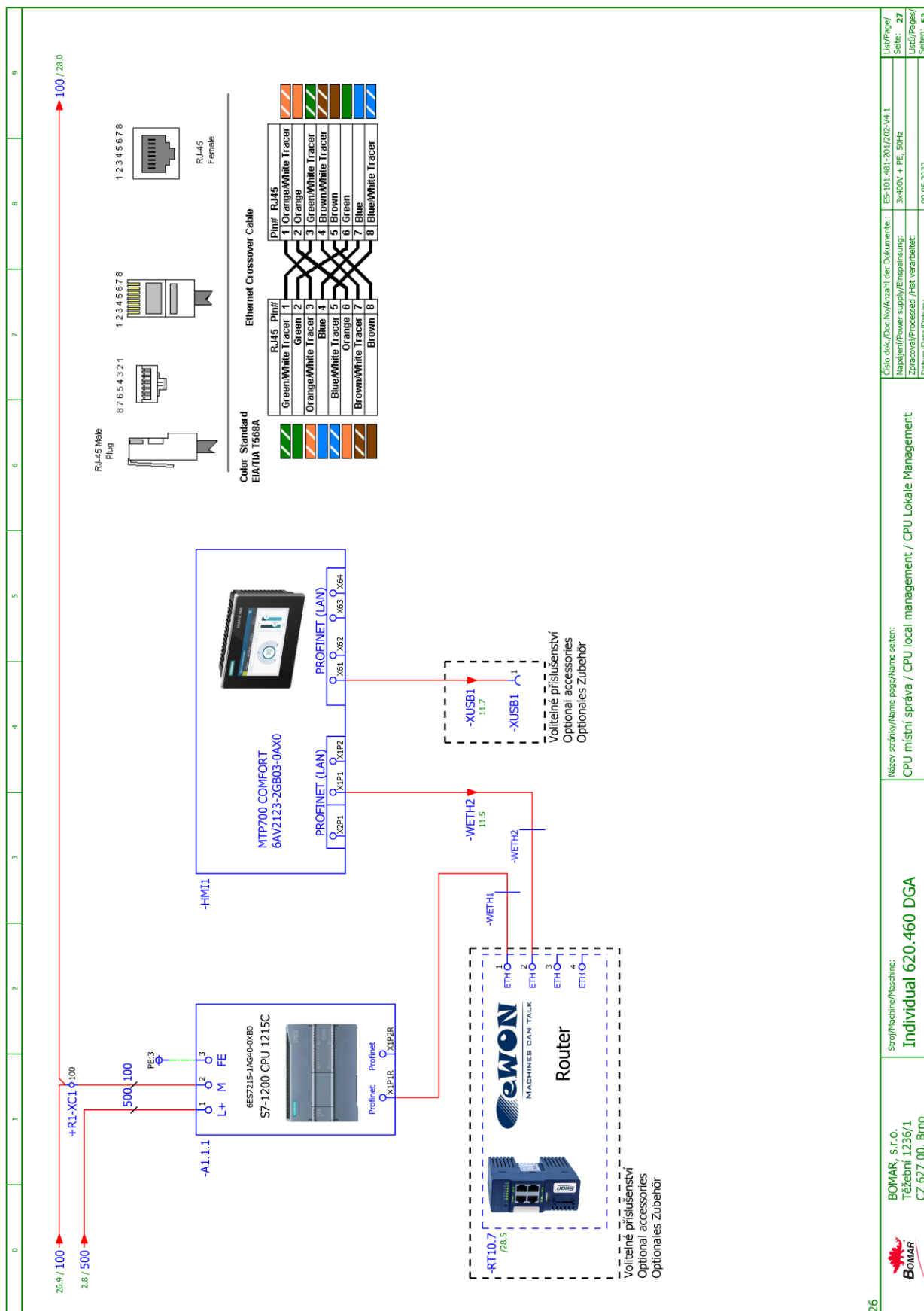




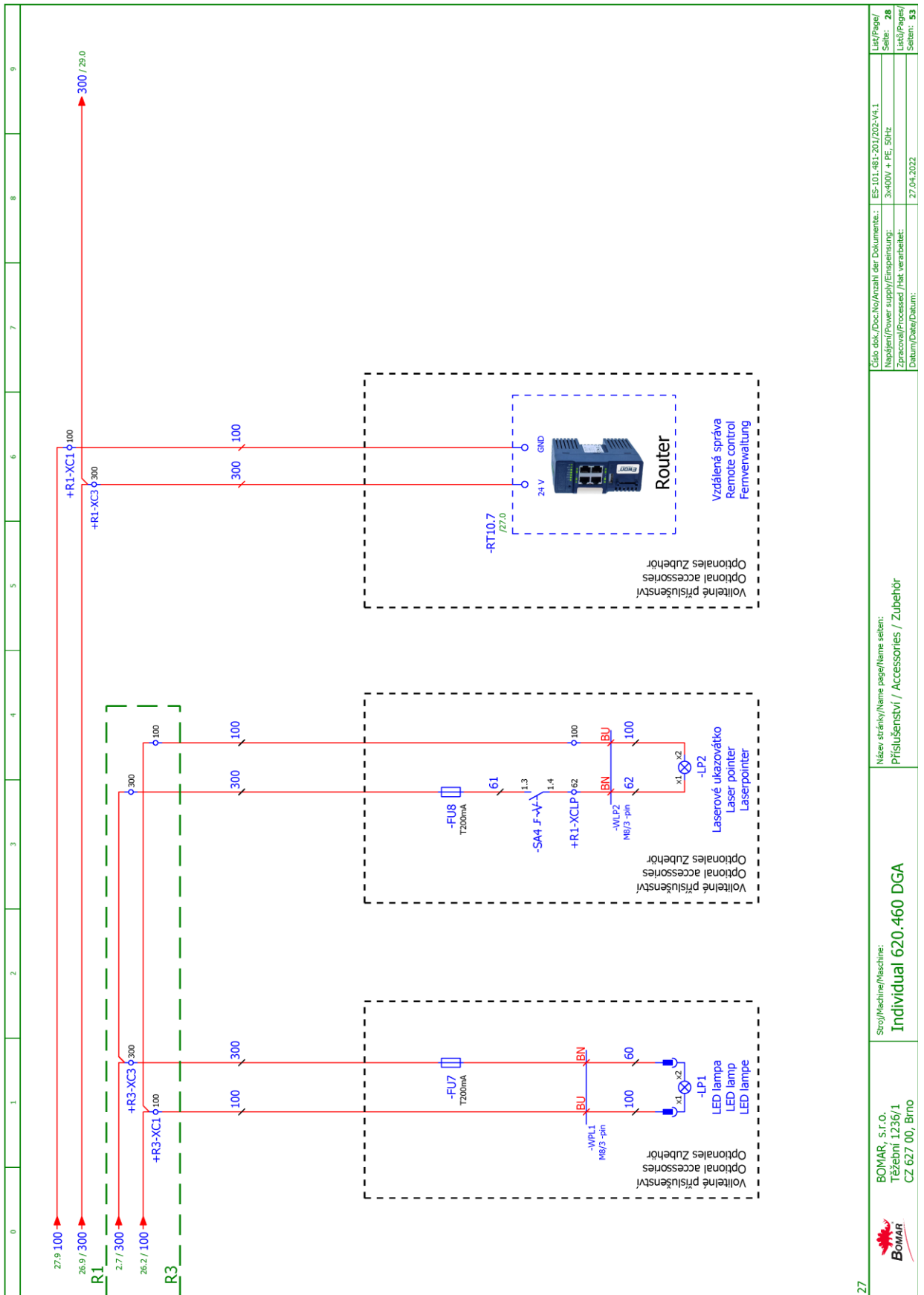




 BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Stroj/Machine/Machine: Individual 620.460 DGA	Název stránky/Name page/Name sheet: Vstupy / Inputs Eingänge Inputs/Outputs Eingänge	Číslo dok./Doc.No./Anzahl der Dokumente.: ES-101_461-201/202-V4.1	List/Page/
			Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz Zpracování/Processed /Nat. verarbeitet: Datum/Date/Datum: 27.04.2022	Seite: 26 List/Page/
				Seiten: 53



	BOMAR, s.r.o. Těžební 1236/1 CZ 627 00, Brno	Srojl/Machine/Maschine: Individual 620.460 DGA	Název stránky/Name page/Name seiten: CPU místní správa / CPU local management / CPU Lokale Management	Číslo soub./Doc.No./Anzahl der Dokumente: ES-101-481-201702-V4.1	Napájení/Power supply/Einspeisung: 3x400V + PE, 50Hz	Zpracováno/Processed /Hat verarbeitet: 09.05.2022	List/Page/ Seite: 27 List/Page/ Seite: 53
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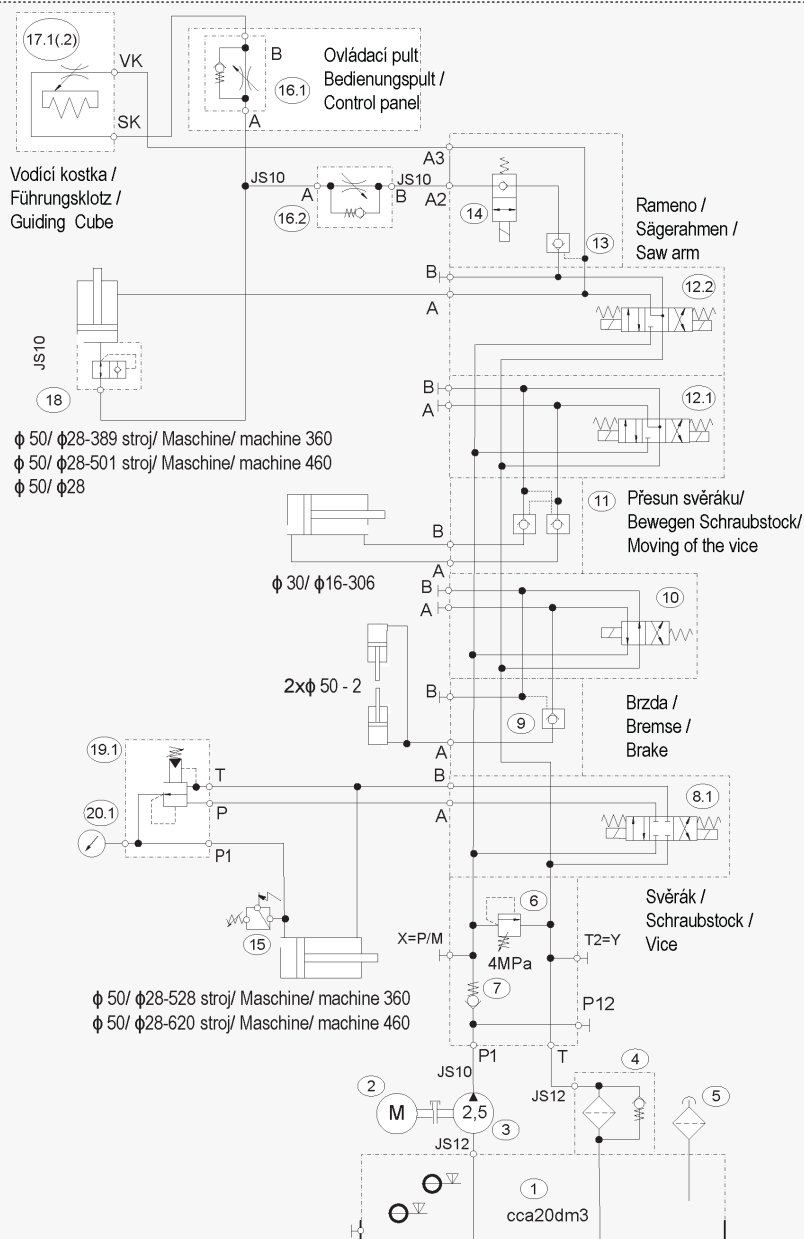




8.2. Hydraulické schéma / Hydraulisches Schéma / Hydraulic diagram

8.2.1. Pila / Bansasäge / Bandsaw

Schémat
Schemas
Schematics



Typ / Type / Type

Individual 360 DGH / DGANC, Individual 460 DGH/ DGANC

Hydraulický agregát / Hydroaggregat / Hydro aggregat

92.001.077 (FMW), S001-137-2, PPM-AC0, 48/0, 6kW/300/1500-PG1/2,5-TM20-CB03-FR

Neuvedené světlosti / Unerwähnt Lichtbreite / Unlisted inside diameters

JS6

Výstupní šroubení / Ausgangsschraubung / Output screwing

G1/4"

205.Y316-500
„NEW“ INDIVIDUAL 360 DGH / DGANC
„NEW“ INDIVIDUAL 460 DGH / DGANC
30.1.2015

Pmax

4,5 MPa

Q

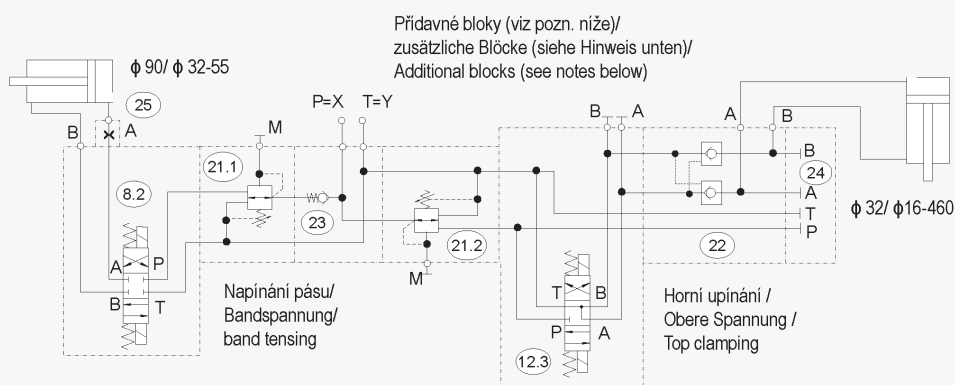
3,3 / 6,6 dm³/min

n

1500 / 3000 rpm

P

0,48 / 0,6 kW



Regulace tlaku svěráku (19+20) - volitelné vybavení /Spandruckregulierung (19+20) - Optionalzubehör/
Vice pressure regulation (19+20) optional accessories

Přídavné okruhy (volitelné vybavení) / Hilfschaltung (Optionalzubehör)/ Auxiliary circuits (optional accessories),
Znázorněna připojovací místa hadic X,Y/ Schlauchverbindungsstellen X, Y sind gezeigt/ Hose connection points X,X are shown

Blok/ Block 92.153.082 - Napínání pásu/ Sägebandspannung / Saw band tensing - dohromady/ zusammen/ together
Blok/ Block 92.153.087 - Horní upínání /Obere Spannung / Top clamping - samostatně/ selbständig/ independently

Pro el. síť/ für Strom Netz/ for electricity network 3x230V zaměnit el. motor za/ ersetzen Sie den Elektromotor für /
replace the electric motor with 92.001.139

U stroje velikosti 460 jsou 2 vodící regulační kostky (poz. 14) paralelně propojené a mají hydraulický přítlak do řezu.

Redukční ventil (19.2+20.2) je na ovládacím pultu, napojen pomocí přípojek X,Y.

/ Die Maschinengröße 460 sind zwei Führungs und Regelungswürfel (poz.14) parallel verbunden ist und einen Hydraulikschrittdruck haben .
Reduktionsventil (19.2+20.2) auf dem Bedienfeld ist, verbunden über die Anschlüsse X, Y /

The machine size 460 has 2 regulation and guiding cubes (pos.14) which are parallelly connected and which has hydraulic press to cut. T
hrottle valve (19.2+20.2) is placed at control panel and connected with connections X,Y.

Typ / Type / Type

Individual 360 DGH / DGANC, Individual 460 DGH/ DGANC

Hydraulický agregát / Hydroaggregat / Hydro aggregat

92.001.077 (FMW), S001-137-2, PPM-AC0, 48/0, 6kW/300/1500-PG1/2,5-TM20-CB03-FR

Neuvedené světlosti / Unerwähnt Lichtbreite / Unlisted inside diameters

JS6

Výstupní šroubení / Ausgangschraubung / Output screwing

G1/4"

205.Y316-500
„NEW“ INDIVIDUAL 360 DGH / DGANC
„NEW“ INDIVIDUAL 460 DGH / DGANC
30.1.2015

Pmax	4,5 MPa
Q	3,3 / 6,6 dm ³ /min
n	1500 / 3000 rpm
P	0,48 / 0,6 kW

Poz.	Název položky/Bezeichnung/Item		Ks/menge/pcs.
1	Nádrž / Behälter / Tank	TM 13,5/S 20 dm ³	1
2	Elektromotor / Elektromotor / Electromotor	0,48/0,6 kW, 400/230 V/50 Hz, 2/4 poly/ poles	1
3	Hydrogenerátor / Hydraulikgenerator / Hydrogenerator	10A2, 5X053G 2,5/cm ³ /ot	1
4	Zpětný filtr / Filter / Filter	MPF0301AG1 + Vložka / Einlage / Inset MF0301P10	1
5	Nalévací zátka / Einfüllspund / Fill stopper	CPT-MD-FA/1"	1
6	Přepouštěcí ventil / Bypassventil / By pass valve	MO-020/32 4MPa	1
7	Jednosměrný ventil / Einwegventil / One-way valve	CV08-20-0-N-4 V205-007-1-01	1
8	Rozvaděč / Verteilungsventil / Distributor	DVE03-S01-B4-C24/20/T1-M1	2/1
9	Hydraulický zámek / Hydraulisches Schloß / Hydraulic lock	PC08-30-0-N	1
10	Rozvaděč / Verteilungsventil / Distributor	DVE03-S12-B4-C24/20/T1-M1	1
11	Hydraulický zámek / Hydraulisches Schloß / Hydraulic lock	DC08-40-0-N-25	1
12	Rozvaděč / Verteilungsventil / Distributor	DVE03-S04-Bx-C24/20/T1-M1	3/2
13	Hydraulický zámek / Hydraulisches Schloß / Hydraulic lock	PC08-30-0-N	1
14	Ventil / Ventil / Valve	SV08-20-0-N-24EG	1
15	Tlakový spínač / Druckschalter / Pressure switch	0166415031059 20-50 bar SUCO	1
16	Škrťací ventil / Drosselventil / Throttle-valve	VS01-04/R2,5-OS 92.152.001	2
17	Kostka regulace / Regulationklotz / Regulation cube		2/1
18	Ventil pojistný / Sicherungsventil / Retaining valve	VPNH 1/4", s=0,8mm 92..151.001	1
19	Redukční ventil / Reduktionsventil / Control valve	VRN1-06/RV-6,3 92.154.001	2/1/0
20	Manometr / Manometer / Manometer	Ø68 S, 0-6 MPa	2/1/0
21	Redukční ventil / Reduktionsventil / Control valve	PR08-32A-0-N-6	2/0
22	Hydraulický zámek / Hydraulisches Schloß / Hydraulic lock	DC08-40-0-N-25	1/0
23	Jednosměrný ventil / Einwegventil / One-way valve	RS05-10/0,3	1/0
24	Deska / Desk / Desk	PD1-RPEK N809_022_1	1/0
25	Tryska / Düse / Nozzle	Ø1mm	1/0

8.2.2. Podavač / Vorschub / Feeder

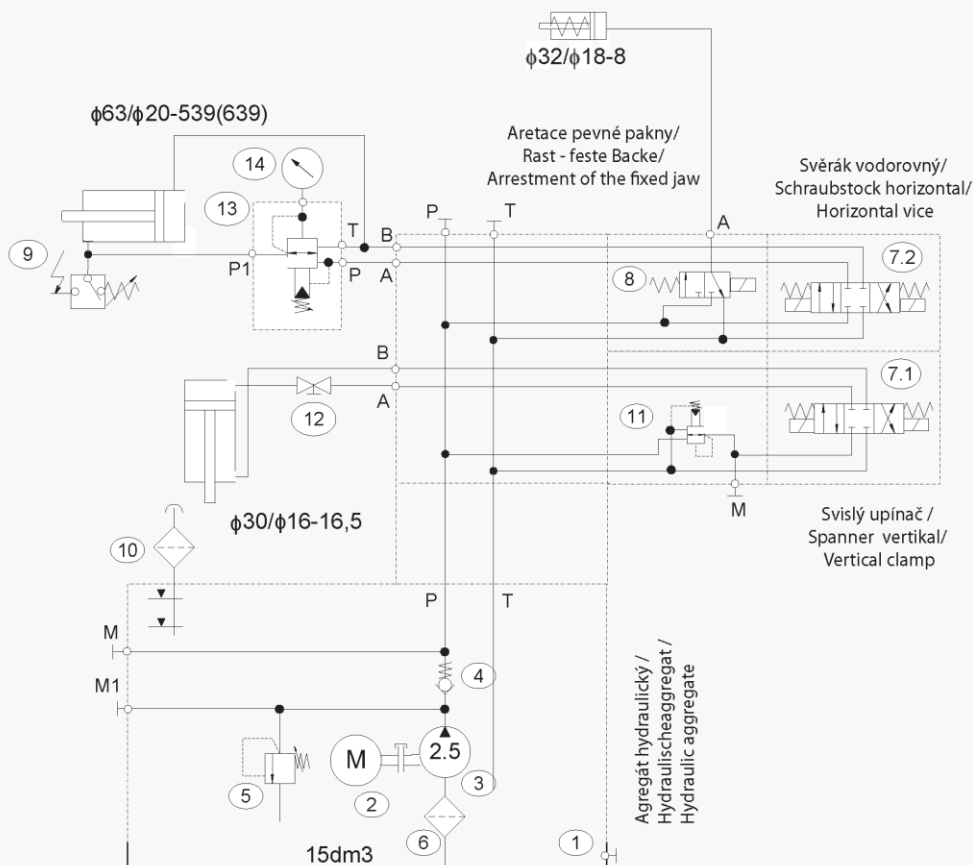


Schéma
Schemas
Schematics

Zdvih válce v závorkách platí pro stroje velikosti 460/ Die Zylinderhub in Klammern sind für Maschinentyp 460/
The stroke of the cylinder which is written in parentheses is valid for machines of the type 460 only

Regulátor (prvky 13+14) - volitelné vybavení /Regler (Elemente 13+14) - Optionalzubehör/
Regulator (elements 13+14) - optional accessory

Pro el. síť / für Strom Netz/ for electricity network 3x230V zaměnit el. motor za/ ersetzen Sie den Elektromotor für /
replace the electric motor with 92.001.179

Typ / Type / Type

Podavač/ Feeder/ Vorschub - Individual 360 DGANC, Individual 460 DGANC

Hydraulický agregát / Hydroaggregat / Hydro aggregat

92.001.072 (28486100) SMA03-25/SP.0-S11.0-H15LS.0-xxxx/02400

- MODIFIKACE TYPU/ MODIFICATION: 870-1394 / 731-0504

Neuvedené světlosti / Unerwähnt Lichtbreite / Unlisted inside diameters

JS6

Výstupní šroubení / Ausgangsschraubung / Output screwing

G1/4"

205.W316-000
PODAVAC (TIN7)
360 DGANC
460 DGANC
6.3.2012

P _{max}	5 MPa
Q	6,6 / 3,3 dm ³ /min
n	2800 / 1400 rpm
P	0,55 / 0,37 kW

Poz.	Název položky		ks
Pos.	Bezeichnung		Menge
Pos.	Item		Pcs.
1	Nádrž / Behälter / Tank	N17 TM, 307507891002 (750/7891) 15 dm ³	1
2	Elektromotor / Elektromotor / Electromotor	TM80-2/4S, 0,55/0,37 kW, 400/230 V/50 Hz	1
3	Hydrogenerátor / Hydraulikgenerator / Hydrogenerator	P2-2,5L.66017 2,5 cm ³ /rpm	1
4	Jednosměrný ventil / Einwegventil / One-way valve	VJ01-06/SG-1	1
5	Přepouštěcí ventil / Bypassventil / By pass valve	VPP2-04/S-6 5 MPa	1
6	Sací filtr / Filter / Suction filter	2SF56/48-0,063 63 µm	1
7	Rozvaděč / Verteilungsventil / Distributor	RPE3-043Z11/02400E1K1 92.101.010	2
8	Rozvaděč / Verteilungsventil / Distributor	SD2E-A3/S2D25	1
9	Tlakový spínač / Druckschalter / Pressure switch	0166415031059 20–50 bar	2
10	Nalévací zátka / Einfüllspund / Fill stopper	L1.0406-51	1
11	Redukční ventil / Reduktionsventil / Control valve	VRP-04-PS/6,3 92.154.003	1
12	Kulový ventil / Kugelventil / Globe valve	99.260.004	1
13	Redukční ventil / Reduktionsventil / Control valve	VRN2-06/S-6R 92.154.008	1/0
14	Manometr / Manometer / Manometer	Ø68 S, 0–6 MPa Glycerin	1/0

Attention!

The saw arm must always be in the down position after finishing work and resting or during longer intervals between cuts or at night. Otherwise there is a risk of damage to the hydraulic part of the saw arm.

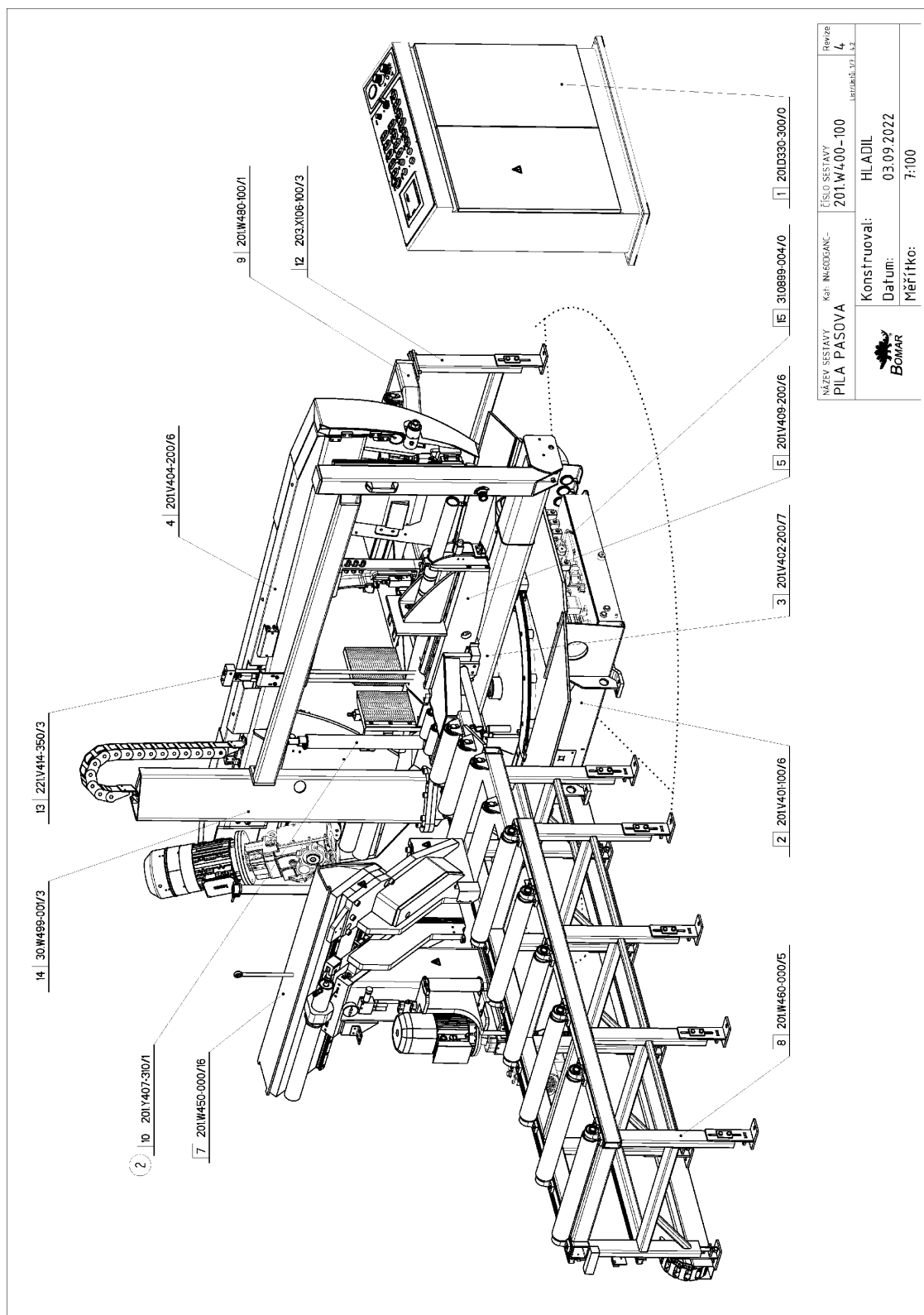
All material must be removed from the saw area. (Risk of damage to the saw blade)

9. **Výkresy sestav pro objednání náhradních dílů / Zeichnungen für Bestellung der Ersatzteile / Drawing assemblies for spare parts order**

- Při objednávání náhradních dílů vždy uvádějte: typ stroje (např. Individual 620.460 DGANC) , výrobní číslo (např. 125) a rok výroby (např. 1999).
- In die Bestellung der Ersatzteile führen Sie immer an: Maschinentyp (z. B. Individual 620.460 DGANC), Serien Nr. (z. B. 125) und Baujahr (z. B. 1999).

- For spare parts order, you must always to allege: type of machine (for example Individual 620.460 DGANC), serial number (for example 125, see cover page) and year of construction (for example 1999).

9.1. Individual 620.460 DGANC



Reviz	4
Verz	1.5
Objekt	201W400-100
Objekt	201W400-100
Konstruktor	HLADIL
Datum	03.09.2022
Měřtko	7:100

9.2. Kusovník / Stückliste / Piece list – Individual 620.460 DGANC

NAZEV SESTAVY		ČÍSLO SESTAVY		REVIZE			
PILA PASOVA		201.W400-100		4			
Poz.	Objednáací číslo	Verze	Název CZ	Name EN	Name DE	Polotovár	Ks.
1	201.D330-300	0	ROZVADEC	DISTRIBUTOR	VERTEILER		1
2	201.V401-100	6	PODSTAVEC	BASE	UNTERSATZ		1
3	201.V402-200	7	KONZOLA OTOCNA	PIVOT BRACKET	DREHKONSOLE		1
4	201.V404-200	6	RAHENO	BEAM	RAHMEN		1
5	201.V409-200	6	SVERAK	VICE	SCHRAUBSTOCK		1
7	201.W450-000	16	PODAVAC	FEEDER	VORSCHUB		1
8	201.W460-000	5	TRAT	TRACK	BAHN		1
9	201.W480-100	1	DIL. PROPOJIVACI	CONNECTING PART	VERBUNDUNGSTEIL		1
10	201.Y407-310	2	VALEC ZVEDACI	LIFTING CYLINDER	HEBEZYLINDER		1
12	203.X106-100	3	NOHA DOPRAVNÍKU	CONVEYOR LEG	STÄNDER DES FÖRDERERS		1
13	221.V414-350	3	DORAZ	STOP PIECE	ANSCHLAG		1
14	30.W499-001	3	STITEK	LABEL	SCHILD		1
15	31.0899-004	0	SAMOLEPKA	STICKER	AUFKLEBER	zelená šipka malá 25 X 12 mm	1
17	99.900.039	0	SAMOLEPKA	STICKER	AUFKLEBER	NS Nebezpečí sřaření	3
18	99.900.041	0	SAMOLEPKA	STICKER	AUFKLEBER	NN Nebezpečí nřazu	2
19	99.900.043	0	SAMOLEPKA	STICKER	AUFKLEBER	NZ Nebezpečí zachycení	3
20	99.900.045	0	SAMOLEPKA	STICKER	AUFKLEBER	NE Nebezpečí řazu el.pro velká 43 mm	1
21	99.900.046	0	SAMOLEPKA	STICKER	AUFKLEBER	HV Hlavní vypřnač	1
22	99.900.047	0	SAMOLEPKA	STICKER	AUFKLEBER	OBS Noste brýle sluchřška	1
23	99.900.048	0	SAMOLEPKA	STICKER	AUFKLEBER	PO Noste pevnou prac.obuv	1
24	99.900.049	0	SAMOLEPKA	STICKER	AUFKLEBER	CN Přečíst návod k použit	1
25	99.900.053	0	SAMOLEPKA	STICKER	AUFKLEBER	SS – Smeřová šipka	1
26	99.901.034	0	SAMOLEPKA	STICKER	AUFKLEBER	Individual 620.460 DGANC NEPOUŽÍVAT Nahrazuje ji 99.901.028	1

1. ROZVEDEC 201.W430-000 NAHRAZEN ROZVADEC 201.W430-400; 232/zm.276 HLADIL 3.12.2015

2. ŽRUS.VALEC Y407-210 A NAHR. Y407-310. 236/ZM362 2.09.2019 KOSYK

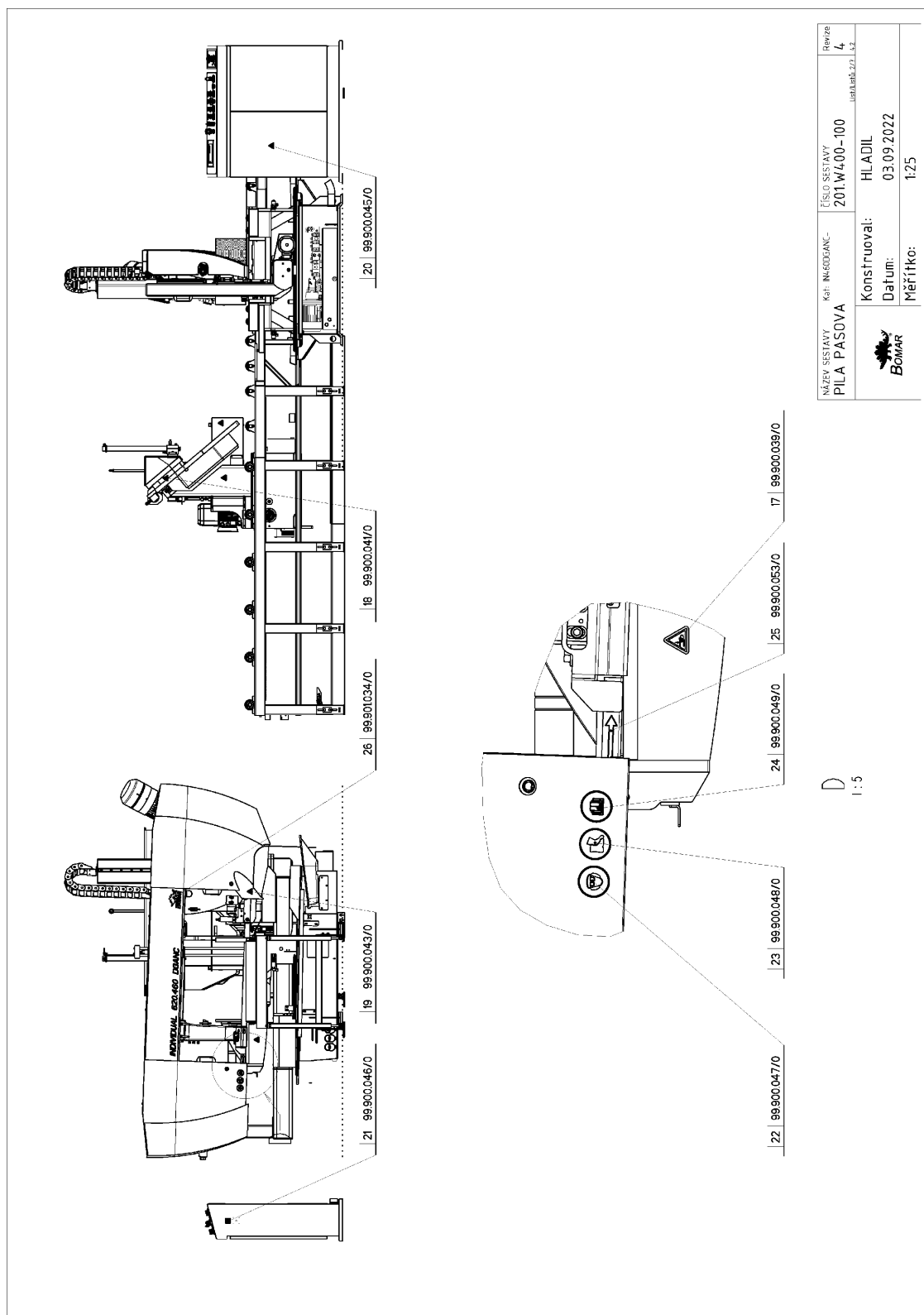
3. ŽRUS. CERTIFIKACNÍ SAMOLEPKA TUV SUD 99.901.032. 282/ZMI99 14.9.2021 KOVAR

4. ŽRUS.OVLADACÍ PANEL 201.W330-400 A NAHRAZEN 201.D330-300. 184/ZM353 19.12.2022 SLEZACKOVA

Číslo Sestavy/Number of assembly/Nummer der Baugruppe: Verze/Verze/Version/Version; Název sestavy/Assembly name/Name der Baugruppe; Poz.–Pozice/Position/Position; Objednáací číslo/Order number/Bestellnummer; Polotovár/Semi-product/Halbfabrikat; Vstupy/Input mat./Default material/Eingangsmaterial

Číslo Sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Pozice/Position/Position, Objednáací číslo/Order number/Bestellnummer, Polotovár/Semiprodukt/Halbfabrikat; Vstupní materiál/Input material/Default material/Eingangsmaterial;

9.3. Individual 620.460 DGANC



9.4. Kusovník / Stückliste / Piece list – Individual 620.460 DGANC

NAZEV SESTAVY		CISLO SESTAVY		REVIZE			
PILA PASOVA		201.W400-100		4			
Poz.	Objednáací číslo	Verze	Název CZ	Name EN	Name DE	Podtovar	Ks.
1	201.D330-300	0	ROZVADEC	DISTRIBUTOR	VERTEILER		1
2	201.V401-100	6	PODSTAVEC	BASE	UNTERSATZ		1
3	201.V402-200	7	KONZOLA OTOCNA	PIVOT BRACKET	DREHKONSOLE		1
4	201.V404-200	6	RAMENO	BEAM	RAHMEN		1
5	201.V409-200	6	SVERAK	VICE	SCHRAUBSTOCK		1
7	201.W450-000	16	PODAVAC	FEEDER	VORSCHUB		1
8	201.W460-000	5	TRAT	TRACK	BAHN		1
9	201.W480-100	1	DIL. PROPOJOVACI	CONNECTING PART	VERBINDUNGSTEIL		1
10	201.Y407-310	(2)	VALEC ZVEDACI	LIFTING CYLINDER	HEBEZYLINDER		1
12	203.X106-100	3	NOHA DOPRAVNIKU	CONVEYOR LEG	STÄNDER DES FÖRDERERS		1
13	221.V414-350	3	DORAZ	STOP PIECE	ANSCHLAG		1
14	30.W499-001	3	STITEK	LABEL	SCHILD		1
15	31.0899-004	0	SAMOLEPKA	STICKER	AUFKLEBER	zelená šipka malá 25 X 12 mm	1
17	99.900.039	0	SAMOLEPKA	STICKER	AUFKLEBER	NS Nebezpečí slištění	3
18	99.900.041	0	SAMOLEPKA	STICKER	AUFKLEBER	NN Nebezpečí nárazu	2
19	99.900.043	0	SAMOLEPKA	STICKER	AUFKLEBER	NZ Nebezpečí zachycení	3
20	99.900.045	0	SAMOLEPKA	STICKER	AUFKLEBER	NE Nebezpečí úrazu el.pro velká 43 mm	1
21	99.900.046	0	SAMOLEPKA	STICKER	AUFKLEBER	HV Hlavní výřinač	1
22	99.900.047	0	SAMOLEPKA	STICKER	AUFKLEBER	DBS Noste brýla sluchátka	1
23	99.900.048	0	SAMOLEPKA	STICKER	AUFKLEBER	PO Noste pevnou pracovní	1
24	99.900.049	0	SAMOLEPKA	STICKER	AUFKLEBER	CN Předřet návod k použití	1
25	99.900.053	0	SAMOLEPKA	STICKER	AUFKLEBER	SŠ – Směrová šipka	1
26	99.901034	0	SAMOLEPKA	STICKER	AUFKLEBER	Individual 620/460 DGANC NEPOUŽÍVAT Nahrazuje ji 99.901028	1

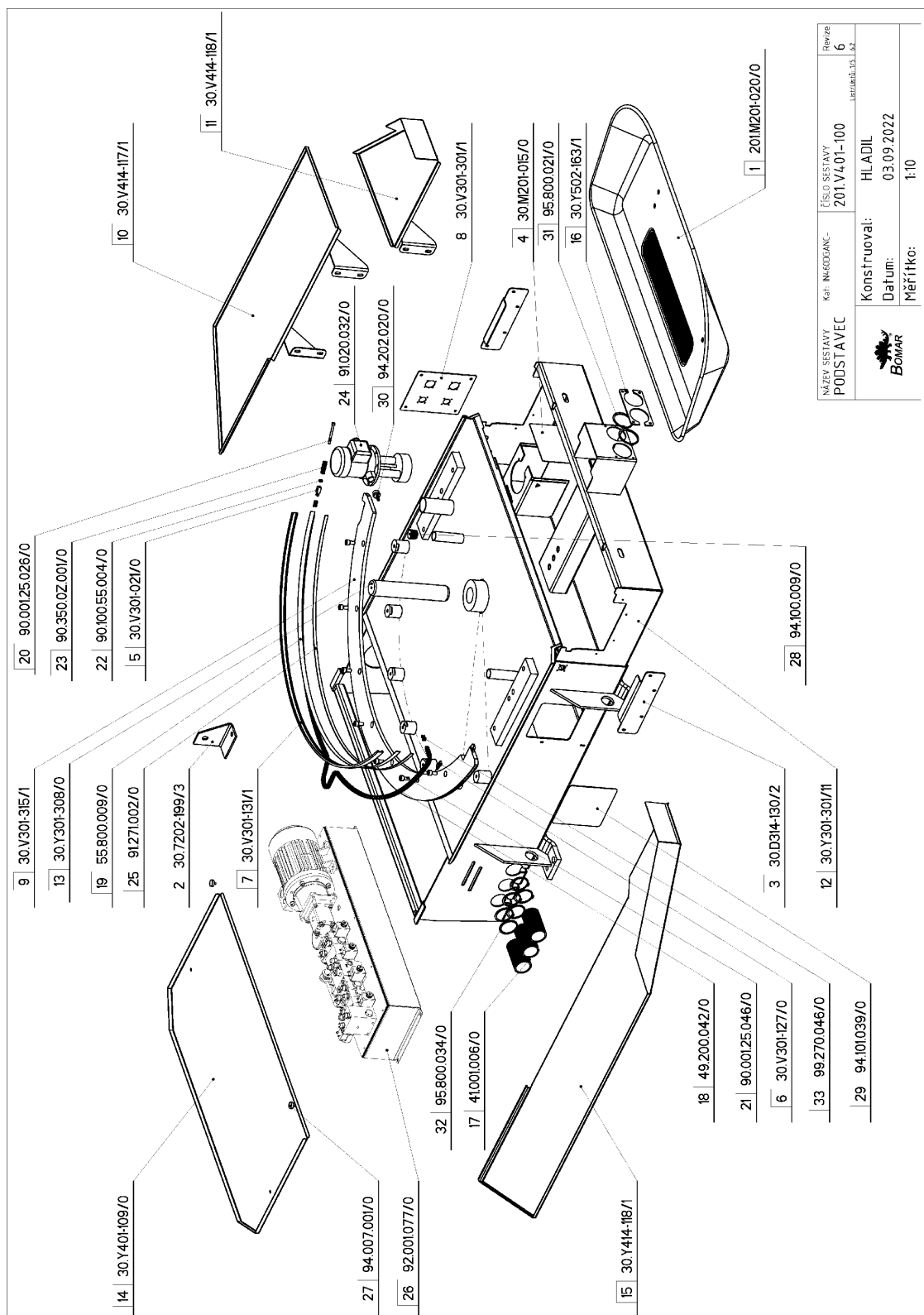
1. ROZVEDEC 201.W430-000 NAHRAZEN ROZVADEC 201.W430-400; 232/zm.276 HLADIL 3.12.2015

2. ZRUS. VALEC Y407-310 A NAHR. Y407-310. 236/ZM362 2.09.2019 KOSYK

3. ZRUS. CERTIFIKACNI SAMOLEPKA TUV SUD 99.901.032. 282/ZM199 14.9.2021 KOVAR

4. ZRUS. OVLADACI PANEL 201.W330-400 A NAHRAZEN 201.D330-300. 184/ZM353 19.12.2022 SLEZACKOVA

9.5. Podstavec / Untersatz / Base



 BOMAR	NÁZEV SOUSTAVY PODSTAVEC	Kód: HLADJANEC- 201V401-100	ČÍSLO SOUSTAVY 201V401-100	Revize 6
	Konstruoval: HLADIL			Legenda: 1:10
	Datum: 03.09.2022			
	Měřítko: 1:10			

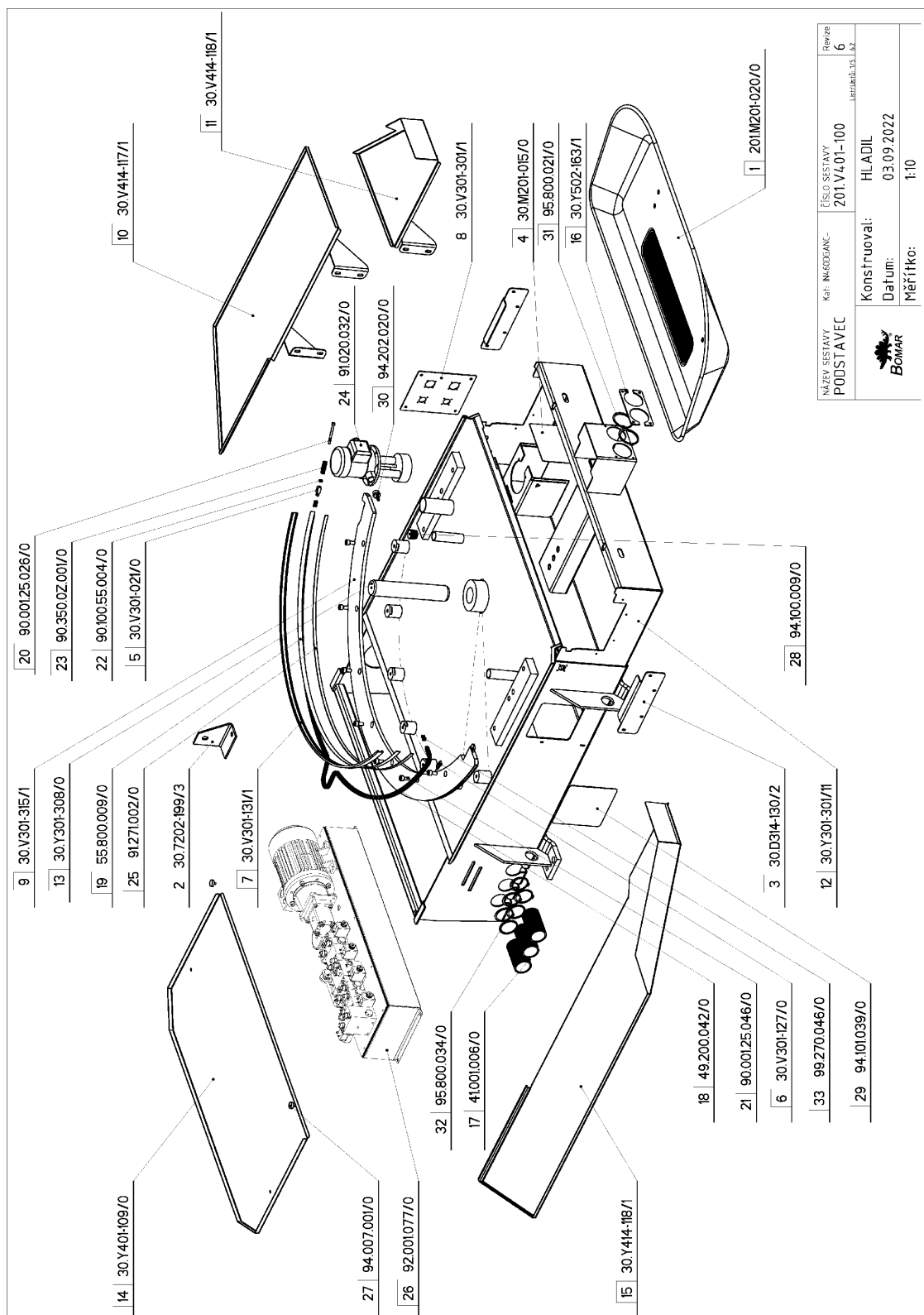
9.6. Kusovník / Stückliste / Piece list – Podstavec / Untersatz / Base

NAZEV SESTAVY		ČÍSLO SESTAVY		REVIZE			
PODSTAVEC		201.V401-100		6			
Poz.	Objednáací číslo	Verze	Název CZ	Name EN	Name DE	Podtovar	Ks.
1	201.M201-020	0	VANA	TANK	WANNE		1
2	30.7202-199	3	KONZOLA	BRACKET	KONSOLE	<Chybné parametry pro podtovar '40.001.01.37' typu 'P'>	1
3	30.D314-130	2	KRYT	COVER	ABDECKUNG	<Chybné parametry pro podtovar '40.001.01.04' typu 'P'>	2
4	30.M201-015	0	PLECH	SHEET METAL	BLECH	<Chybné parametry pro podtovar '40.002.01.07' typu 'P'>	1
5	30.V301-021	0	KOSTKA NAPINANI	TENSIONING CUBE	BANDSPANNUNGSWÜRFEL	HR10x10 - 30	1
6	30.V301-127	0	DORAZ	STOP PIECE	ANSCHLAG	HR12x5 - 40	1
7	30.V301-131	1	LISTA	SLAT	LEISTE		1
8	30.V301-301	1	VÍKO	COVER	DECKEL	<Chybné parametry pro podtovar '40.001.01.03' typu 'P'>	1
9	30.V301-315	1	SEGMENT	SEGMENT	SEGMENT		1
10	30.V414-117	1	KRYT	COVER	ABDECKUNG		1
11	30.V414-118	1	KRYT	COVER	ABDECKUNG		1
12	30.V301-301	11	PODSTAVEC	BASE	UNTERSATZ		1
13	30.V301-308	0	ČEP	PIVOT	BOLZEN	D50 - 265	1
14	30.V401-109	0	KRYT	COVER	ABDECKUNG	<Chybné parametry pro podtovar '40.001.01.02' typu 'P'>	1
15	30.V414-118	1	OKAP	DRAIN PLATE	ABLAUFPLATTE		1
16	30.V502-163	1	UCHYTKA	HANDLE	HALTER	<Chybné parametry pro podtovar '40.001.01.04' typu 'P'>	1
17	41.020.006	0	HADICE	HOSE	SCHLAUCH	PG48 černá PALL54 - EW-PAL-M50/P48	3
18	49.200.042	0	RETEZ POHONOVÝ	DRIVE BELT	ANTRIEBSKETTE	818-1 1/2"x1/8"x7.75 -5m/lbal.	1
19	55.600.009	0	PLANŽETA	null	null	0.3x15 Nerez podkládání strojů	1
20	90.001.25.026	0	SRUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	6x65 DIN 912 8.8 černý	1
21	90.001.25.046	0	SRUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	10x20 DIN 912 8.8 černý	7
22	90.100.55.004	0	MATICE PŘESNA ZINEK	PRECISION NUT - ZN	PRÄZISE MUTTER - ZN	6 DIN 934 8.8 Zn	1
23	90.350.02.001	0	PRŮŽINA TALIROVA	DISC SPRING	TELLERFEDER	12.5x6.2x0.5 DIN 2093	10
24	91.020.032	0	ČERPADLO CHLAZENÍ	COOLING PUMP	KÜHLMITTELPUMPE	PA70/120 with filter nahrazuje 91.020.004/015 4POMPA T0120 +122FILTRI	1
25	91.271.002	0	PASKA MAGNETICKÁ	MAGNETIC TAPE	MAGNETBAND	ELGO MB20-50-10-1-R-C Magnetická páska od 8_2019 bez ocelové lišty (91.17	1
26	92.001.077	0	AGREGÁT HYDRAULICKÝ	HYDRAULIC PUMP	HYDRAULIKAGREGAT	S001_131_2 - 400V * Proline 280H, 350H, 450H, INO 360,460 GH-DH-DG-Anc	1
27	94.007.001	0	SRUB PLASTOVÝ	PLASTIC BOLT	KUNSTSTOFFSCHRAUBE	šroub s rýhovanou hlavou M5x10	2
28	94.100.009	0	ZATKA	PLUGBLIND PLUG	BLINDSTÖPFEN	30x1-2 085-034 černá	1
29	94.101.039	0	ZATKA	PLUGBLIND PLUG	BLINDSTÖPFEN	kryt otvoru 151x154x4 rozměr 151x161x3	1
30	94.202.020	0	REDUKCE	REDUCTION / ADAPTOR	REDUKTION	1/2"-6 GES 6-R1/2"	1
31	95.600.021	0	KROUZEK POJIST VNEJŠÍ	EXTERNAL RETAINING RING	SICHERUNGSRING AUßEN	d62 DIN 471	2

Číslo Sestavy/Number of assembly/Nummer der Baugruppe_Ver_Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe_Poz_Pozice/Position/Position, Objednáací číslo/Order number/Bestellnummer_Podtovar/Suborder number/Unternummer des Bauteils, Materiál/Material/Material

Číslo sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Pozice/Position/Position, Objednávací číslo/Order number/Bestellnummer, Podtovar/Semiproduct/Halbfabrikat, Vstupní materiál/Input material, Vstupní materiál/Input material

9.7. Podstavec / Untersatz / Base



9.8. Kusovník / Stückliste / Piece list – Podstavec / Untersatz / Base

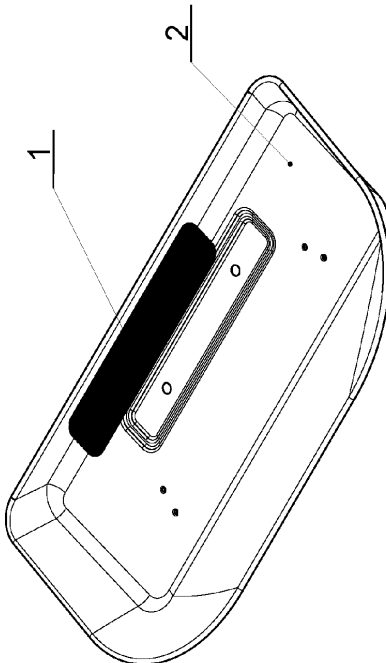
Poz.	Objednávací číslo	Verze	Název CZ	Name EN	Name DE	Polotovár	Ks.
32	95600.034	0	KROUZEK POJIST VNEJS	EXTERNAL RETAINING RING	SICHERUNGSRING AUßEN	d55 DIN 471	6
33	99270.046	0	CLANEK SPOJ.-RETEZ	CHAIN CONNECTING LINK	KETTENVERBINDUNGSGLEID	0818-1 spojka	2

1. PRID. KONZOLA 30.7202-199, 223/ZM297 11.10.2012 SLEZACKOVA
 2. ZRUS. VANA 30.Y301-310 A NAHR. 30.Y301-320 ZRUS. ZATKA 94.101.039 A NAHR. VIKEM 30.V301-301, 239/ZM105 29.3.2013 SLEZACKOVA
 3. ZRUS. PLECH 30.V301-118, ZRUS. CERPADO 91.020.015 A NAHR. 91.020.032, PRID. REDUKCE 94.202.021, ZRUS. VANA 30.Y301-320 A NAHR. 201.M201-020
 PRID. PLECH 30.M201-015, 024, 213/ZM073 14.3.2016 SLEZACKOVA
 4. ZRUS. REDUKCE 94.202.021 A NAHR. 94.202.020, 024/ZM200 12.7.2016 SLEZACKOVA
 5. PRID. JXKRYT 30.D314-130 A JXZATKA 94.101.039, 249/ZM313 21.9.2020 SLEZACKOVA
 6. ZRUS. ZATKA 94.101.044, PRID. 2x ZATKA 94.100.009, 153/ZM194 3.6.2022 CHAJDA

Číslo sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Pozice/Position/Position, Objednávací číslo/Order number/Bestellnummer, Polotovár/Semiproduct/Halbfabrikat, Vstupní materiál/Default material/Eingangsmaterial.

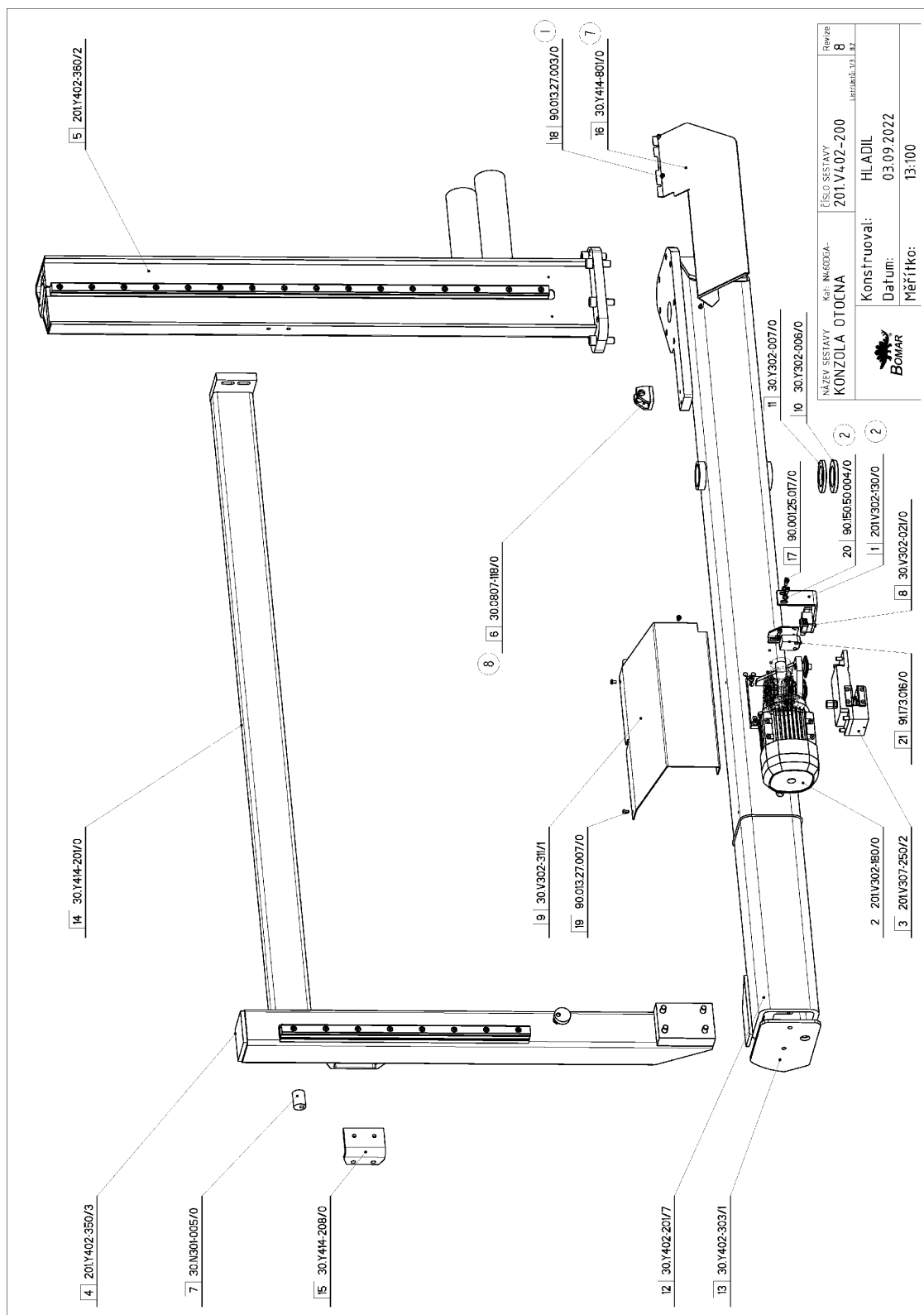
9.9. Vana / Tank / Wanne

Císlo Sestavy 201.M201-020		Ver. 0	Název sestavy VANA/TANK/WANNE		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.ER251-304	0	SITO / SIEVE / GITTERWERK	P1x95	1
2	30.M201-021	0	VANA / TANK / WANNE	P 0.8	1



Císlo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.10. Konzola otočná / Drehkonsole / Turnable consol



9.11. Kusovník / Stückliste / Piece list – Konzola otočná / Drehkonsole / Turnable consol

NAZEV SESTAVY		ČÍSLO SESTAVY		REVIZE			
KONZOLA OTOCNA		201.V402-200		8			
Poz.	Objednáč. číslo	Verze	Název CZ	Name EN	Name DE	Položovar	Ks.
1	201.V302-130	0	SNÍMAC MAGNET.	MAGNETIC SENSOR	MAGNETSENSOR		1
2	201.V302-180	0	POHON	DRIVE	ANTRIEB		1
3	201.V307-250	2	BRZDA	BRAKE	BREMSE		1
4	201.V402-350	3	SLOUP	POLE	SÄULE		1
5	201.V402-360	2	SLOUP	POLE	SÄULE		1
6	30.0807-118	8	DRŽAK	HOLDER	HALTER		1
7	30.N301-005	0	EXCENTR	EXCENTR	EXZENTER	D30 – 40	1
8	30.V302-021	0	DRŽAK	HOLDER	HALTER	P3 – 59x70	1
9	30.V302-311	1	KRYT MOTORU	MOTOR COVER	MOTORABDECKUNG		1
10	30.Y302-006	0	PODLOŽKA DISTANČNÍ	SPACER WASHER	DISTANZSCHEIBE		1
11	30.Y302-007	0	PODLOŽKA DISTANČNÍ	SPACER WASHER	DISTANZSCHEIBE	D80 – 10	1
12	30.Y402-201	7	KONZOLA OTOCNA	PIVOT BRACKET	DREHKONSOLE		1
13	30.Y402-303	1	VÍKO	COVER	DECKEL	P8 – 150x238	1
14	30.Y414-201	3	LISTA VODICI	GUIDING SLAT	FÜHRUNGSLEISTE		1
15	30.Y414-208	3	DRŽAK	HOLDER	HALTER	P8 – 100x110	1
16	30.Y414-801	7	OKAP	DRAIN PLATE	ABLAUFPLATTE	P1,5 – 277x503	1
17	90.00125.017	2	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	6x16 DIN 912 8,8 černěný	3
18	90.01327.003	1	SROUB PULKULATY	BUTTON HEAD SCREW	RUNDKOPFSCHRAUBE	5x10 ISO 7380 čern	4
19	90.01327.007	2	SROUB PULKULATY	BUTTON HEAD SCREW	RUNDKOPFSCHRAUBE	6x10 ISO 7380 čern	3
20	90.150.50.004	0	PODLOŽKA	WASHER	UNTERLEGSCHIEBE	6,4 M6 DIN 125 Zn	3
21	91.173.015	0	SPINAC KONCOVÝ	END SWITCH	ENDSCHALTER	BNS 819 – 99 – D – 13-S80 Koncový spínač – INO, mřížkový kontakt 1 250VAC	1

1. PRIDAN 4xSROUB M5x10(90.013.27.003). 003/ZM149 2.7.2015 SLEZACKOVA

2. PRID. SROUBY 3x90.001.25.017 A 3x90.013.27.007, PRID. 3xPODLOŽKA 90.150.50.004. 233/ZM383 22.10.2018 SZABARI

3. ZRUS. VZPERA 30.Y402-202 A NAHR. 30.Y414-201, PRID. DRŽAK 30.Y414-208. 067/ZM182 26.4.2019 SZABARI

5. ODEBRANO 2x POUZDRO 95.720.002. 297/ZM415 10.10.2019 BENDA

6. ZRUS. DRŽAK 30.0807-008 A NAHR. DRŽAKEM 30.0807-108. 280/ZM392 26.10.2021 KOVAR

7. ZRUS. OKAP 30.Y414-401 A NAHR. 30.Y414-801. 156/ZM179 23.5.2022 JAGNESAK

8. ZRUS. DRŽAK 30.0807-108 A NAHR. 30.0807-118. 022/ZM036 23.2.2023 JAGNESAK

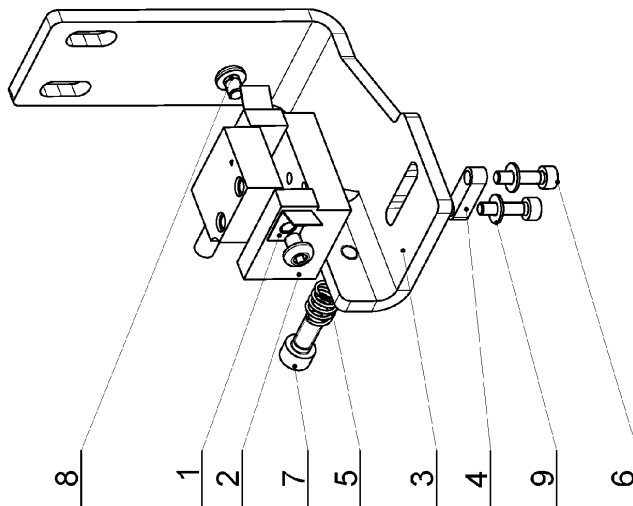
Číslo Sestavy/Number of assembly/Nummer der Baugruppe. Verze/Version/Version. Název sestavy/Assembly name/Name der Baugruppe. Poz.–Pozice/Position/Position. Objednáč. číslo/Order number/Bestellnummer. Položovar/Supplier/Abnehmer.kód: Všechny materiály/Vszystki mat./Der aut. material/Endgutsmaterial.

Číslo Sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Pozice/Position/Position, Objednáč. číslo/Order number/Bestellnummer, Položovar/Semiprodukt/Halbfabrikat, Vstupní materiál/Input material/Default material/Eingangsmaterial;

9.12. Snimač magnet. / Magnetsensor / Magnetic sensor

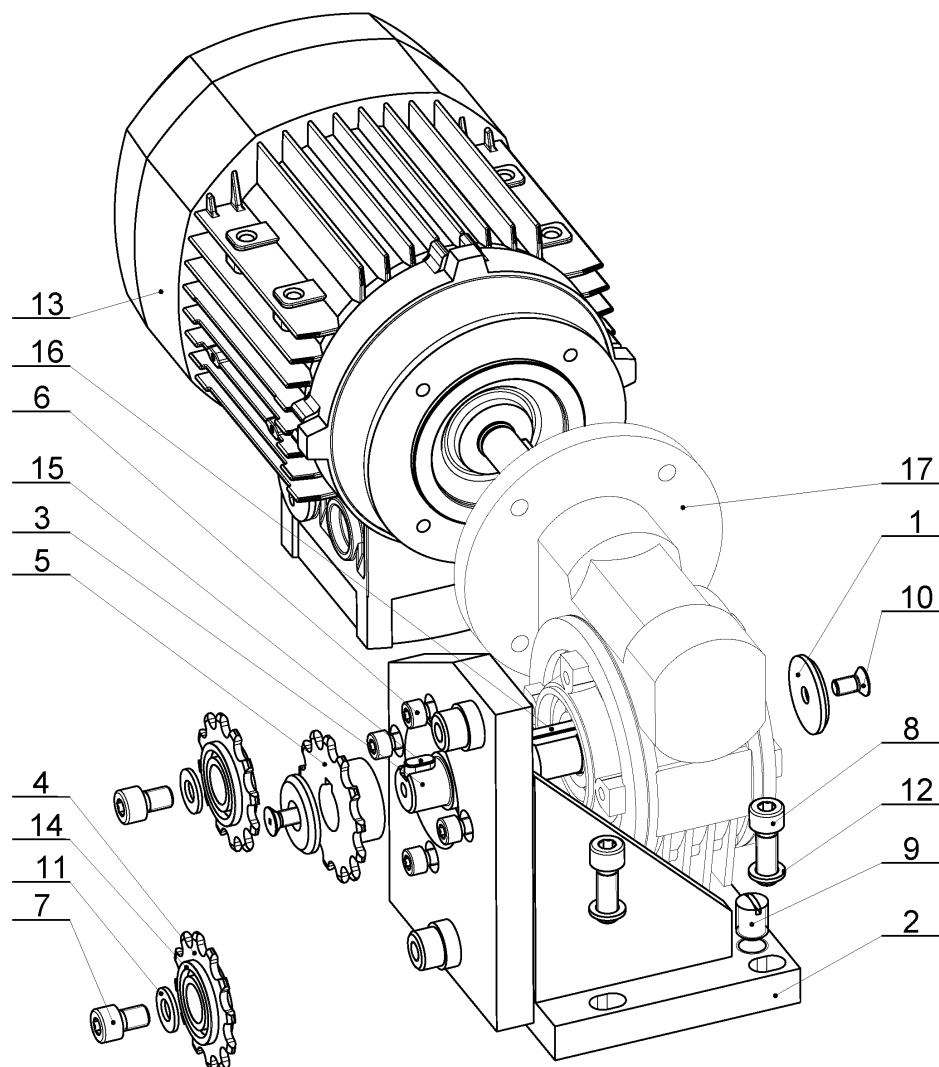
Číslo Sestavy 201.V302-130		Ver. 0	Název sestavy SNIMAC MAGNET./MAGNETIC SENSOR/MAGNETSENSOR		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.1504-017	0	ŠTERAC / WIPER / ABSTREIFER	P 0,3x11	2
2	30.V302-131	0	DRŽÁK / HOLDER / HALTER	HR 25x35	1
3	30.V302-132	0	DRŽÁK / HOLDER / HALTER	P 5x63	1
4	30.V302-133	0	PERO / PARALLEL KEY / PASSFEDER	PERO 6x6	1
5	31.1605-121	0	PRŮŽINA / SPRING / FEDER	1x9,5x12x4	1
6	90.001.25.004	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M4X16	2
7	90.001.25.092	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M6X14	1
8	90.013.27.002	0	SROUB PULKULATY / BUTTON HEAD SCREW / RUNDKOPFSCHRAUBE	M5X6	2
9	90.150.50.002	0	PODLOŽKA / WASHER / UNTERLEGSCHIEBE	PODLOŽKA 4,3	2
10	92.270.018	0	SNIMAC MAGNET. / MAGNETIC SENSOR / MAGNETSENSOR	ELGO	1

Číslo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz./Position/Position;
Objednací číslo/Purchase order number/Basistellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung



Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz./Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.13. Pohon / Antrieb / Drive



NAZEV SESTAVY POHON	CISLO SESTAVY 201.V302-180	STROJ IN360
	Konstruoval: MUSIL	
	Datum: 06. 12.2010	
	Meritko: 1:2	

9.14. Kusovník / Stückliste / Piece list – Pohon / Antrieb / Drive

Číslo sestavy 201.V302-180		Ver. 0	Název sestavy POHON/DRIVE /ANTRIEB	
Poz.	Objednávací číslo	Ver.	Název položky	Ks
1	30.1514-503	0	PODLOŽKA / WASHER / UNTERLEGSCHIBE	2
2	30.V302-081	0	KONZOLA / BRACKET / KONSOLE	1
3	30.V302-083	0	HRDEL / SHAFT / WELLE	1
4	30.V302-085	0	KOLO RETEZOVÉ / CHAIN WHEEL / KETTENRAD	2
5	30.V302-086	0	KOLO RETEZOVÉ / CHAIN WHEEL / KETTENRAD	1
6	90.001.25.017	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	4
7	90.001.25.029	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	2
8	90.001.25.033	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	4
9	90.002.2D.017	0	SROUB STAVEČI / SET SCREW / STELLSCHRAUBE	2
10	90.011.27.005	0	SROUB ZAPUSTNÝ / COUNTERSUNK SCREW / SENKSCHRAUBE	2
11	90.150.50.005	0	PODLOŽKA / WASHER / UNTERLEGSCHIBE	2
12	90.163.00.002	0	PODLOŽKA / WASHER / UNTERLEGSCHIBE	4
13	91.001.106	0	ELEKTROMOTOR / ELECTRIC MOTOR / ELEKTROMOTOR	1
14	95.001.006	0	LOŽISKO / BEARING / LAGER	2
15	95.810.004	0	PERO TESNE / FEATHER KEY / PASSFEDER	1
16	95.810.004	0	PERO TESNE / FEATHER KEY / PASSFEDER	1
17	99.001.119	0	PREVODOVKA SNEKOVÁ / WORM GEAR GEARBOX / SCHNECKENGETRIEBE	1

Číslo sestavy/Number of assembly/Baugruppe; Verze (Ver.)/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.15. Brzda / Bremse / Brake

Císlo Sestavy 201.V307-250	Ver. 0	Název sestavy BRZDA/BRAKE/BREMSE			
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.V307-251	0	DESKA / BOARD / PLATTE	HR 80x30	1
2	30.V307-252	0	CELIST POHYBLIVÁ / MOVING JAW / BEWEGLICHE BACKE	HR 80x40	1
3	30.V307-254	0	STERAC / WIPER / ABSTREIFER	BA18	4
4	30.V307-263	1	PIST / PISTON / KOLBEN	d 40	2
5	30.V307-265	1	CELIST / JAW / BACKE	d 32	2
6	90.001.25.036	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M8x40	4
7	90.001.25.038	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M8x50	2
8	90.002.2D.003	0	SROUB STAVEČI / SET SCREW / STELLSCHRAUBE	SROUB M5x6	2
9	90.011.27.003	0	SROUB ZAPUSTNÝ / COUNTERSUNK SCREW / SENKSCHRAUBE	SROUB M5x10	8
10	90.011.27.016	0	SROUB ZAPUSTNÝ / COUNTERSUNK SCREW / SENKSCHRAUBE	SROUB M8x25	2
11	92.002.101	0	SROUBENÍ PRÍME KOMPL. / null / null		1
12	96.001.019	2	O-KROUZEK STATICKÝ / O-RING STATIC / O-RING STATISCH	6x2	1
13	96.020.005	0	KROUZEK Q / Q RING / Q-RING	39.2x5.33	2
14	96.082.002	0	KROUZEK TESNICÍ / SEALING RING / DICHTUNGSRING	13/17x1.5 CU	1

1.ZRUS PIST 30.V307-253 A NAHR 30.V307-263 PRID CELIST 30.V307-265. 029/ZM008 23.1.2015 SLEZACKOVA
2.ZRUS KROUZEK TESNICI 96.002.003 A NAHR 96.001.019. 208/ZM014 14.1.2021 SLEZACKOVA

Císlo Sestavy/Number of assembly/Nummer der Baugruppe: Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz./Position/Position; Objednací číslo/Purchase order number/Bestellnummer. Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

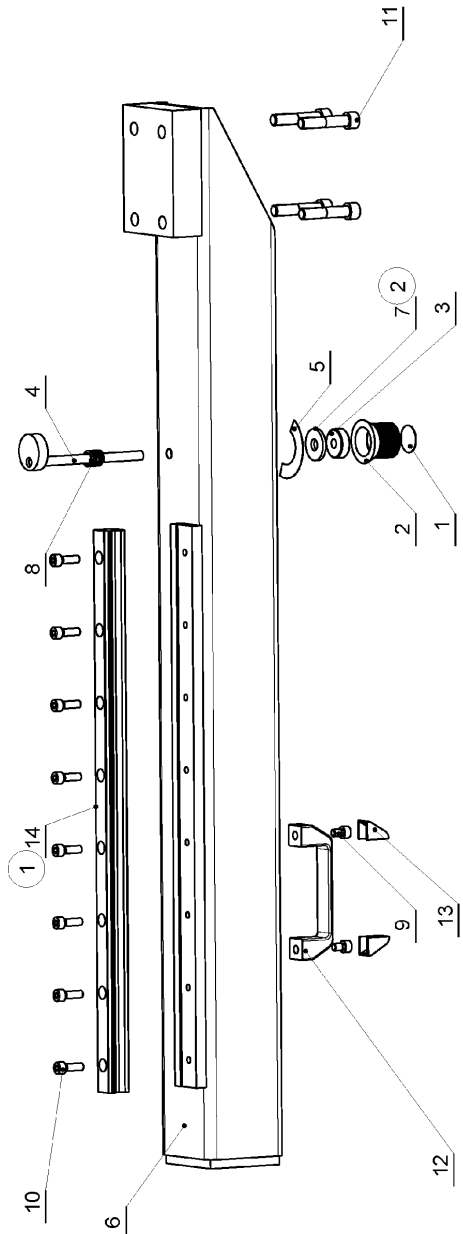
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Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.16. Sloup / Saule / Pole

Číslo Sestavy 201.Y402-350		Ver. 0	Název sestavy SLOUP/POLE/SÄULE		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.6130-012	0	VIKO / COVER / DECKEL	P 0.5x30	1
2	30.6130-020	0	HLAVICE / HEAD / KOPF	VYLISEK	1
3	30.Y302-058	2	KOLEČKO / WHEEL / ROLLE	d 32	1
4	30.Y402-055	0	OSA / AXLE / ACHSE	SVARENO	1
5	30.Y402-154	0	STUPNICE / SCALE / SKALA	P 0.5x34	1
6	30.Y402-351	0	SLOUP / POLE / SÄULE	SVARENO	1
7	31.K107-008 (2)	0	GUMA / RUBBER / GUMMI	d85	1
8	31.T302-054	0	PRUŽINA / SPRING / FEDER	d 2.24	1
9	90.001.25.029	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M8x12	2
10	90.001.25.033	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	8x25	8
11	90.001.25.063	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M12x60	4
12	94.012.001	0	RUKOJET / HANDLE / GRIFF		1
13	94.012.002	0	KRYT / COVER / ABDECKUNG		2
14	99.200.288 (1)	0	VEDENÍ LINEARNÍ / LINEAR GUIDE / LINEARE FÜHRUNG	MSA 30R 620 30/30N	1

1.ZRUS.LIN.VEDENÍ 99.200.124 A NAHR.99.200.288 . 056/ZM105 22.3.2012 SLEZACKOVA

2.ZRUS.SOUC.30.Y302-157A NAHR.31.K107-006. 125/ZM359 14.12.2012 SLEZACKOVA



Číslo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver./Version/Versioin; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;

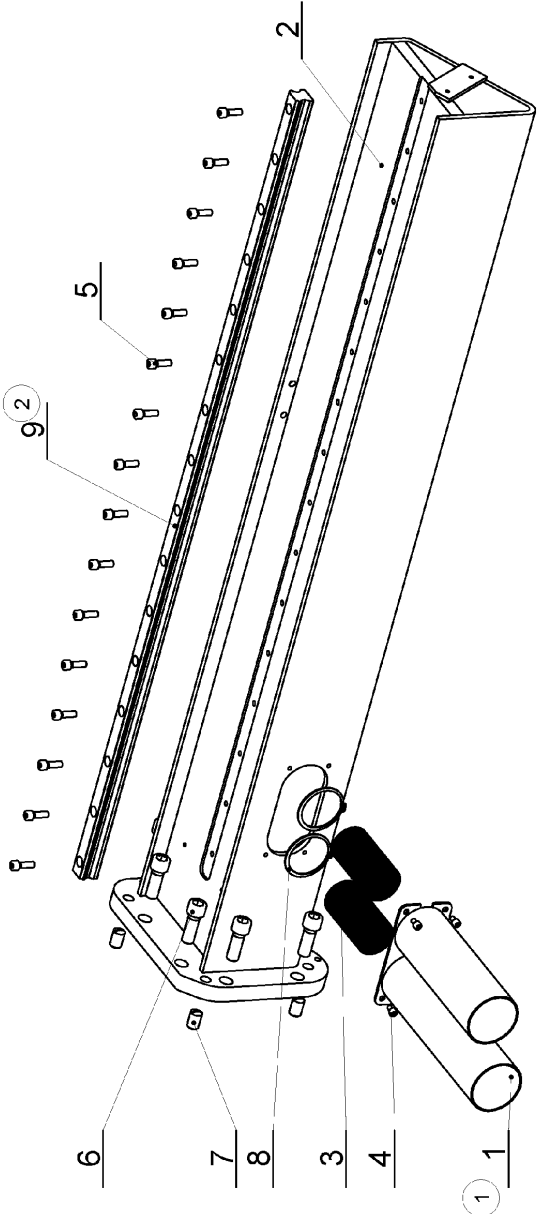
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Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.17. Sloup / Saule / Pole

Číslo Sestavy 201.Y402-360		Ver. 0	Název sestavy SLOUP/POLE/SAULE			
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks	
1	30.V302-125	1	DRŽÁK / HOLDER / HALTER		SVARENO	1
2	30.Y402-361	0	SLOUP / POLE / SAULE		PG48	1
3	41.001.006	0	HADICE / HOSE / SCHLAUCH		M6X10	2
4	90.001.25.015	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE		8x25	4
5	90.001.25.033	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE		M16X45	16
6	90.001.25.074	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE		SROUB M18x1,5x25	7
7	90.002.2D.028	0	SROUB STAVEČI / SET SCREW / STELLSCHRAUBE		POJISTNÝ KROUZEK 62	4
8	95.800.021	0	KROUZEK POJIST.VNEJŠÍ / EXTERNAL RETAINING RING / SICHERUNGSRING AUREN		MSA 30R 1240 20/20N	2
9	99.200.291	2	VEDENÍ LINEARNÍ / LINEAR GUIDE / LINEARE FÜHRUNG			1

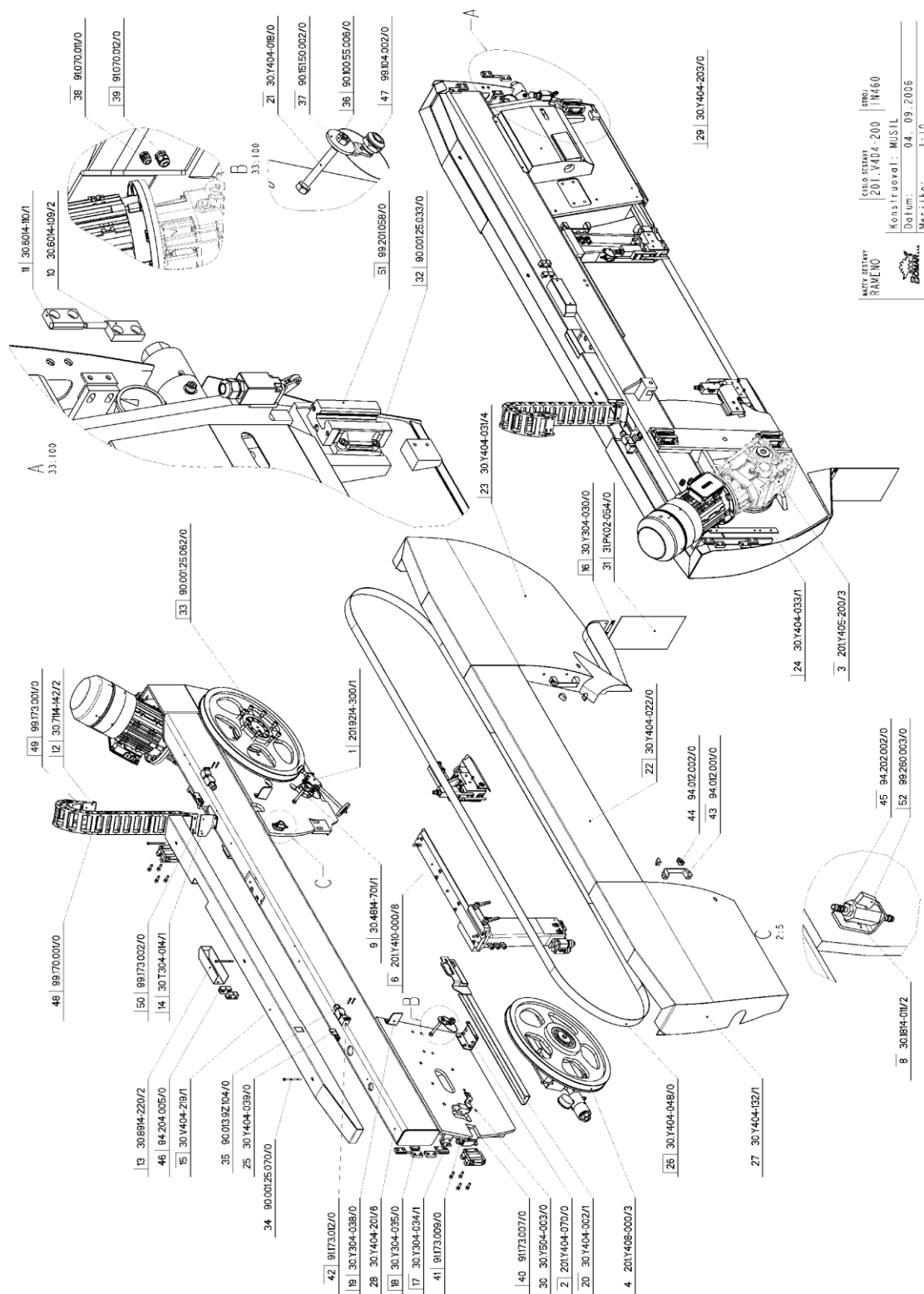
1.ZRUS.DRŽÁK 30.Y502-163 A NAHR.30.V302-125. 287/ZM322 9.12.2011 SLEZACKOVA

2.ZRUS.LIN.VEDENÍ 99.200.140 A NAHR.99.200.291(PMI). 056/ZM105 4.4.2012 SLEZACKOVA



Číslo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz./Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.18. Rameno / Sägerahmen / Saw arm



WATY SYSTEM RAMENO	CIELO SYSTEM 201.404-200	STRUK IN460
Konstruoval: MUSIL	Datum: 04. 09. 2006	Meritko: 1:10

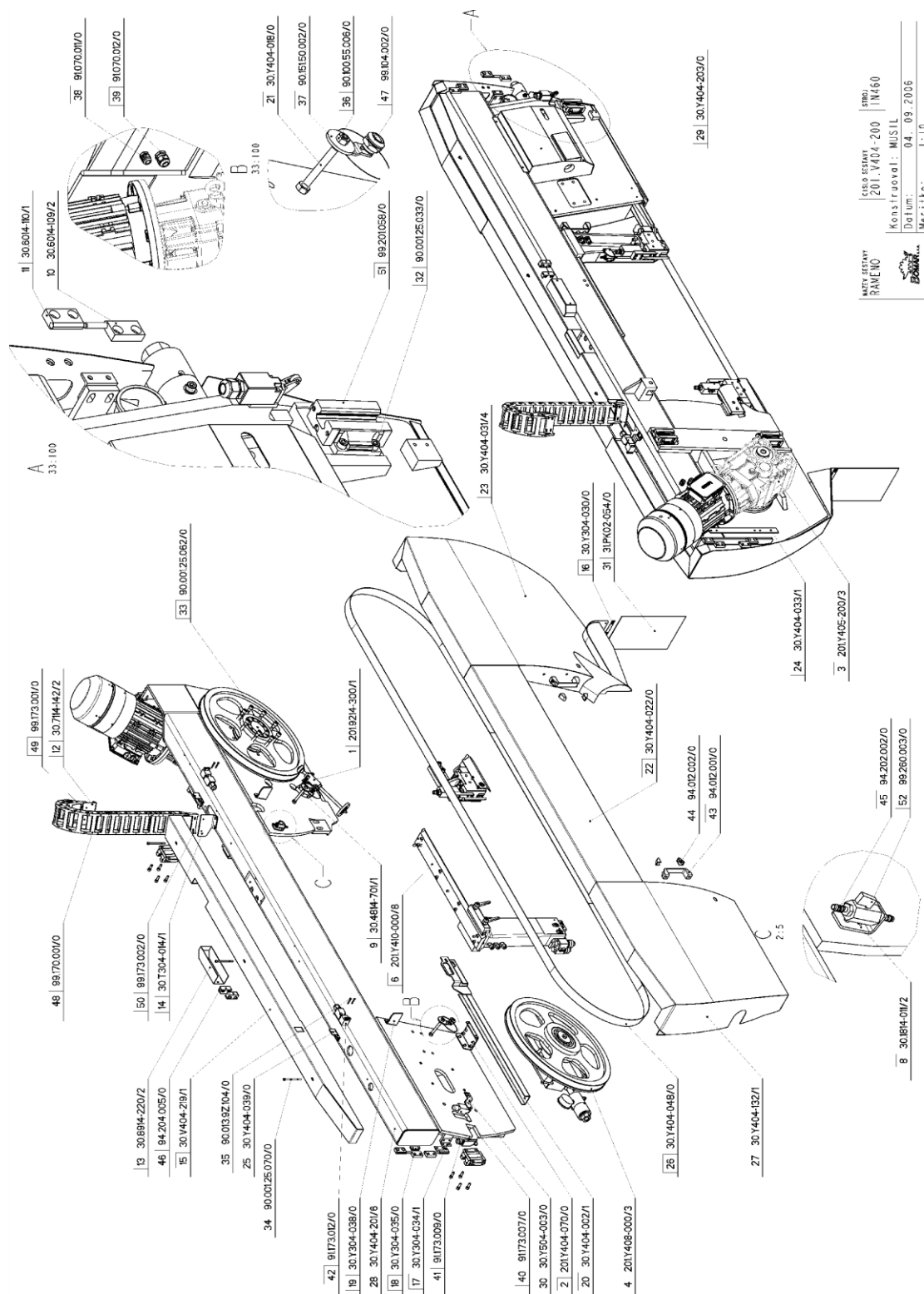
9.19. Kusovník / Stückliste / Piece list –
Rameno / Sägerahmen / Saw arm

NAZEV SESTAVY		ČÍSLO SESTAVY		REVIZE			
RAMENO		201.V404-200		6			
Poz.	Objednáací číslo	Verze	Název CZ	Name EN	Name DE	Polotovar	Ks.
1	201.9214-300	1	KARTAC	BRUSH	BÜRSTE		1
2	201.Y404-070	0	DRŽAK	HOLDER	HALTER		1
3	201.Y405-200	3	POHON	DRIVE	ANTRIEB		1
4	201.Y408-000	3	NAPINANI	TENSIONING	SPANNUNG		1
5	201.Y410-000	8	VEDENÍ PASU	SAW BAND GUIDE	SÄGEBANDFÜHRUNG		1
8	30.1814-011	2	DRŽAK	HOLDER	HALTER	P3 – 76x25	1
9	30.4814-701	1	ZAKLADNA	BASE	GRUNDLAGE	HR70x15 – 70	1
10	30.6014-109	2	PANT	HINGE	TÜRBAND		4
11	30.6014-110	1	DESKA	BOARD	PLATTE	HR30x12 – 50	4
12	30.7114-142	2	DRŽAK	HOLDER	HALTER	P4 – 97.3x100	1
13	30.8914-220	2	KRYT	COVER	ABDECKUNG	<Chybné parametry pro polotovar '40.00101.02' typu 'P'>	1
14	30.1304-014	1	DRŽAK	HOLDER	HALTER	P4 – 100x97	1
15	30.V404-219	1	KRYT	COVER	ABDECKUNG		1
16	30.Y304-030	0	DRŽAK	HOLDER	HALTER	<Chybné parametry pro polotovar '40.002.01.05' typu 'P'>	1
17	30.Y304-034	1	DRŽAK	HOLDER	HALTER	L30x20x3 – 50	1
18	30.Y304-035	0	DESKA	BOARD	PLATTE	HR20x5 – 50	4
19	30.Y304-038	0	DRŽAK	HOLDER	HALTER	<Chybné parametry pro polotovar '40.00101.05' typu 'P'>	2
20	30.Y404-002	1	KRYT PASU	BELT COVER	BANDABDECKUNG		1
21	30.Y404-018	0	TYČ ZAVITOVÁ	THREADED POLE	GEWINDESTANGE	TZM10x1SP – 120	2
22	30.Y404-022	0	KRYT	COVER	ABDECKUNG		1
23	30.Y404-031	4	KRYT RAMENE	ARM COVER	RAHMENABDECKUNG		1
24	30.Y404-033	1	DRŽAK	HOLDER	HALTER	L30x20x3 – 375	1
25	30.Y404-039	0	DRŽAK	HOLDER	HALTER	<Chybné parametry pro polotovar '40.00101.04' typu 'P'>	2
26	30.Y404-048	0	PAS PÍLOVÝ	SAW BAND	SÄGEBAND		1
27	30.Y404-132	1	KRYT RAMENE	ARM COVER	RAHMENABDECKUNG		1
28	30.Y404-201	6	RAMENO	BEAM	RAHMEN		1
29	30.Y404-203	0	KRYT NAPINÁNÍ	COVER FOR TENSIONING DEV.	BANDSPANNUNGSABDECKUNG		1
30	30.Y504-003	0	DRŽAK	HOLDER	HALTER	<Chybné parametry pro polotovar '40.00101.04' typu 'P'>	1
31	31.PK02-054	0	GUMA	RUBBER	GUMMI	352x206mm rýhovaná	1
32	90.00125-033	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	8x25 DIN 912 8.8 černý	12
33	90.00125-062	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	12x50 DIN 912 8.8 černý	8
34	90.00125-070	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	6x90 DIN 912 8.8 černý	3
35	90.013.9Z-104	0	SROUB PULKULATÝ	BUTTON HEAD SCREW	RUNDKOPFSCHRAUBE	4x30 ISO 7380 TX A2 BEZPEČNOSTNÍ S KOLÍČKEM	4
36	90.100.55-006	0	MATICE PŘESNA ZINEK	PRECISION NUT – ZN	PRÄZISE MUTTER – ZN	10 DIN 934 8.8 Zn	6
37	90.15150-002	0	PODLOZKA VELKOPL.	LARGE WASHER	GROßFLÄCHENSCHIBE	13.5x44x4 M12 DIN 440 Zn	2

Číslo Sestavy/Number of assembly/Nummer der Baugruppe_Voz-Vorserie/Version/Název sestavy/Assembly name/Name der Baugruppe_Poz.-Position/Position/Position; Objednáací číslo/Order number/Bestellnummer-Material/Samstag/Flabrat/mat./Default material/Einbaupassmaterial

Číslo Sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Versio, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Pozice/Position/Position, Objednáací číslo/Order number/Bestellnummer, Polotovar/Semiprodukt/Halbfabrikat, Vstupní materiál/Input material/Default material/Eingangsmaterial.

9.20. Rameno / Sägerahmen / Saw arm



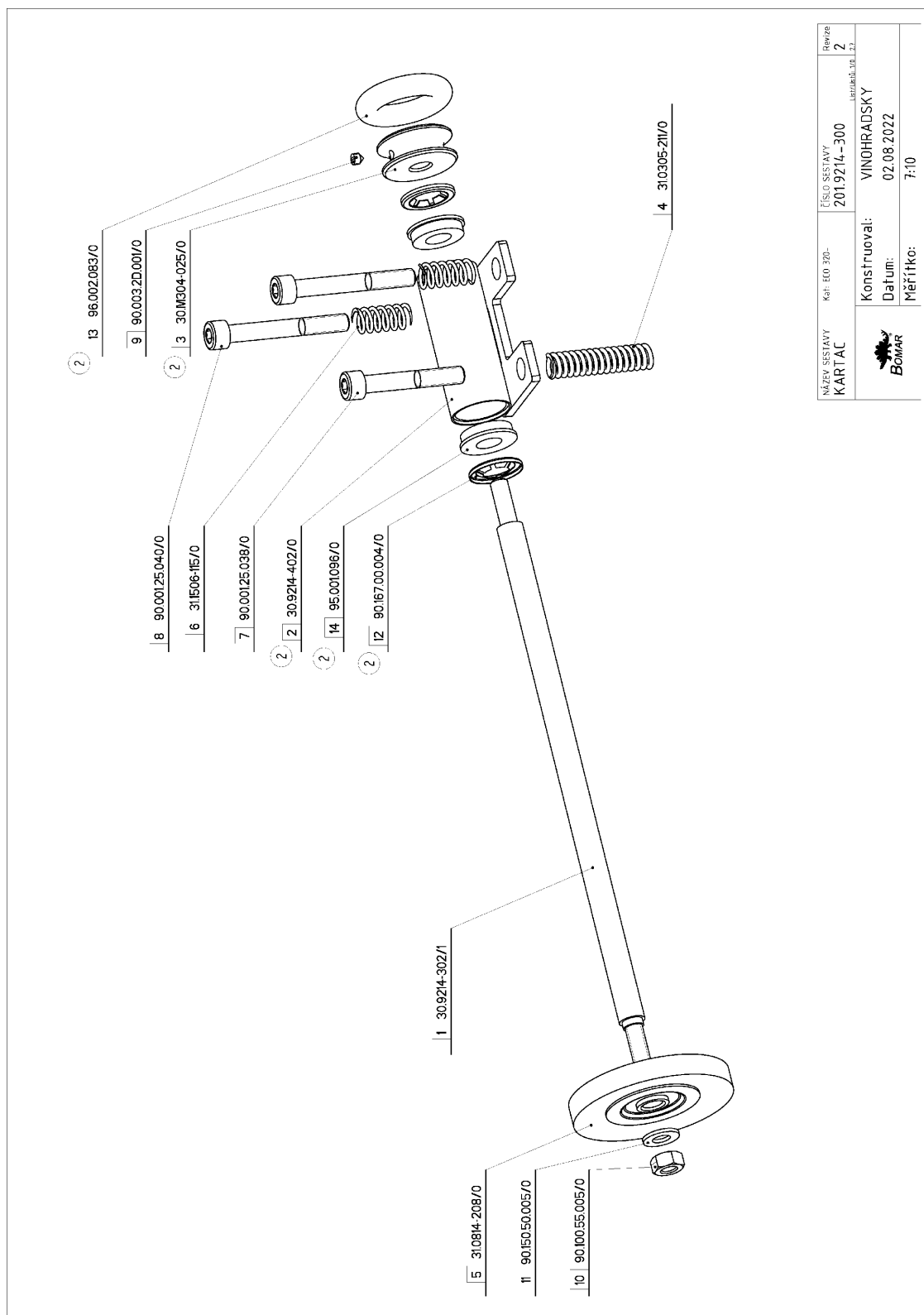
9.21. Kusovník / Stückliste / Piece list – Rameno / Sägerahmen / Saw arm

Poz.	Objednací číslo	Verze	Název CZ	Name EN	Name DE	Polotovár	Ks.
38	91070.011	0	VÝVODKA	OUTLET	TÜLE	AG-154517-10 V-BIMED M16x15 – černá	1
39	91070.012	0	VÝVODKA KLESTINOVA	COLLET WITH OUTLET	SPANNANZANGENTÜLE	AG-15452013 V-BIMED M20x15 – černá	1
40	91173.007	0	SPINAC KONCOVÝ	END SWITCH	ENDSCHALTER	KBA111 Lovato (DAN-4A31) 1xNO/1xNC	1
41	91173.009	0	SPINAC KONC'S KLADK	END SWITCH WITH PULLEY	ENDSCHALTER MIT ROLLE	PZ-FR605-M2 pro vysoké pak - 1xNO/1xNC	1
42	91173.012	0	SPINAC KONC-ZÁMEK	END SWITCH -LOCK	ENDSCHALTER - SCHLOSS	QKS8 2xNC, 250V/400V, 14A/8A, IP54	2
43	94.012.001	0	RUKOJET	HANDLE	GRIFF	503-043-151x42 možno s 2xkryt 94.012.002	2
44	94.012.002	0	KRYT	COVER	ABDECKUNG	krytka k 94.012.001 503-043-151	4
45	94.202.002	0	REDUKCE	REDUCTION / ADAPTOR	REDUKTION	1/4"-6 GFS 6-R1/4"	2
46	94.204.005	0	DRZAK	HOLDER	HALTER	LBG 314/14-PP 14 trubka dvojitý	2
47	95.104.002	0	ZÁMEK	LOCK	SCHLOSS	zámek na kryt ramene zámek + klíčka	2
48	95.170.001	0	RETEZ ENERGII	CABLE DRAG CHAIN	ENERGIEKETTE	EFK 0555.030.075.100 /// koncovky 99.173.001/002 36x75/R-100 /// 15přepážek	1
49	95.173.001	0	KONCOVKA VNEJŠÍ	OUTSIDE END	ÄUßERES ENDSTÜCK	AS 0555.075 0.3. 36x75 /// koncovka k 99.170.001	1
50	95.173.002	0	KONCOVKA VNITŘNÍ	INSIDE END	INNERES ENDSTÜCK	AS 0555.075 M.B. 36x75 /// koncovka k 99.170.002	1
51	95.201.058	0	VOZÍK LINEÁRNÍHO VEDENÍ	LINEAR GUIDE CART	LINEARFÜHRUNGSWAGEN	MSA30ESSFN	3
52	95.260.003	0	VENTIL KULOVÝ	BALL VALVE	KUGELVENTIL	1/4" /// možno nahradit 99.260.004 vnitřní/vnitřní China	1

1. KRYT 30.Y404-032 NAHRAZEN KRYTEM 30.Y404-132; PRIDANY 2x DRZAK 94.012.001 A 4x KRYTKA 94.012.002;
2. 276/Zm.304 HLADIL 23.11.2011
2.ZRUSENO LINEARNI VEDENI 99.201.007 A NAHRAZEN 99.201.058. 056/ZM105 22.3.2012 SLEZACKOVA
3.ZRUSEN KRYT PASU 30.Y404-009 A NAHRAZEN 30.Y404-002. 086/ZM092 4.4.2014 SLEZACKOVA
4.PRIDAN 4xSROUB M4x30 90.013.92.104. 171/ZM290 22.8.2018 SZABARI
5.ZRUSEN KRYT 30.Y404-028/058/ZM094 6.3.2019 SLEZACKOVA
6.ZRUS.PAS PILOVY 44.106.001 A NAHR.30.Y404-048. 148/ZM208 13.5.2020 SLEZACKOVA

Číslo Sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Pozice/Position/Position, Objednací číslo/Order number/Bestellnummer, Polotovár/Semi-product/Halbfabrikat, Vstupní materiál/Input material, Vstupní materiál/Input material

9.22. Kartáč / Bürste / Brush



9.23. Kusovník / Stückliste / Piece list – Kartáč / Bürste / Brush

NAZEV SESTAVY		ČÍSLO SESTAVY		REVIZE			
KARTAC		201.9214-300		2			
Poz.	Objednáč. číslo	Verze	Název CZ	Name EN	Name DE	Polotovar	Ks.
1	30.9214-302	1	HRDEL	SHAFT	WELLE	D12 – 295	1
2	30.9214-402	2	DRZAK	HOLDER	HALTER		1
3	30.M304-025	2	KOLEČKO	WHEEL	ROLLE	D35 – 10	1
4	31.0305-211	0	PRUŽINA	SPRING	FEDER	2.00x12x50x15.5	1
5	31.0814-208	0	KARTAC	BRUSH	BÜRSTE	d12 75, width 10, bore 9.5mm brassad steel, crimped wire 0.30mm	1
6	31.1506-115	0	PRUŽINA	SPRING	FEDER	1.6x12x25x7.5	2
7	90.00125.038	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	8x50 DIN 912 8.8 černý	1
8	90.00125.040	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	8x60 DIN 912 8.8 černý	2
9	90.0032D.001	0	SROUB STAVECI	SET SCREW	STELLSCHRAUBE	5x6 DIN 914, černý	1
10	90.10055.005	0	MATICE PŘESNA ZINEK	PRECISION NUT - ZN	PRAŽISE MUTTER – ZN	8 DIN 934 8.8 Zn	1
11	90.15050.005	0	PODLOŽKA	WASHER	UNTERLEGSCHIEBE	8.4 M8 DIN 125 Zn	1
12	90.16100.004	2	PODLOŽKA	WASHER	UNTERLEGSCHIEBE	12 STARLOCK pojistný kroužek černý	2
13	96.002083	2	O-KROUZEK DYNAMICKÝ	O-RING DYNAMIC	O-RING DYNAMISCH	25x10 – NBR 70Sh	1
14	95.001096	2	LOŽISKO	BEARING	LAGER	F5901 ZZ CMB	2

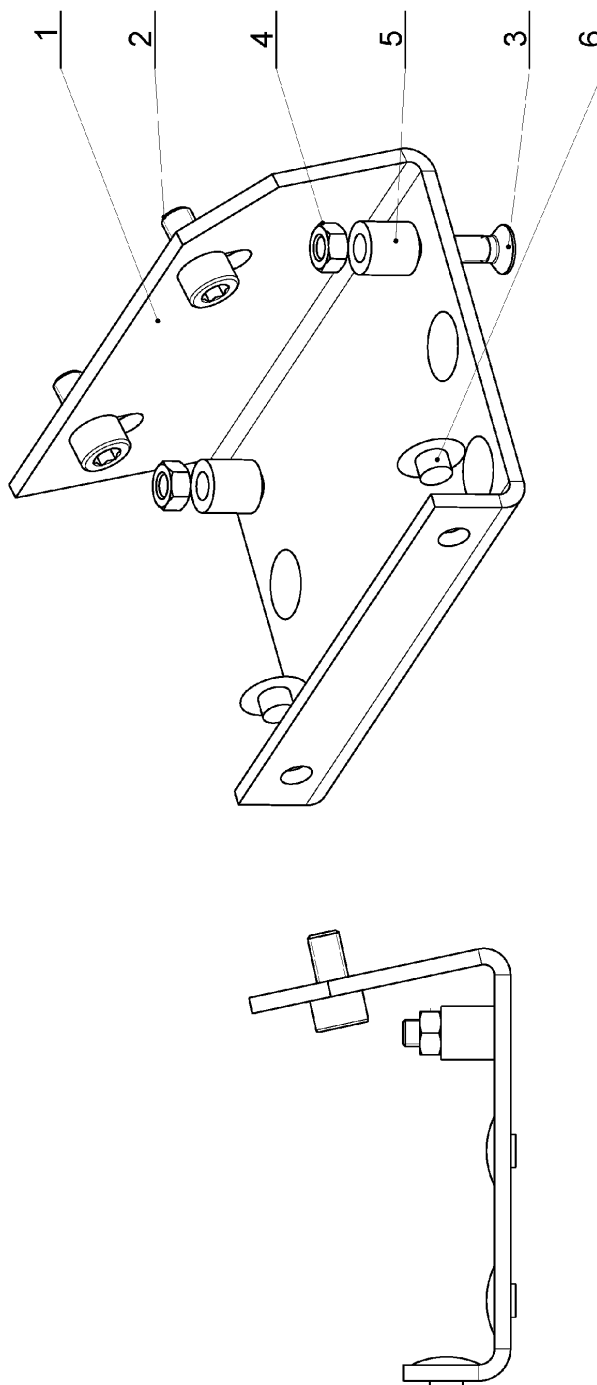
1. ZRUS. DRZAK 30.9214-301 A NAHR. 30.9214-401 11.3.2022 ZINDULKA

2. ZRUS. KROUŽKY 201.0814-204 A 30.0814-207;NAHR. KROUŽKY 30.M304-025 A 96.002.083;PRID 2x PODL. 90.167.00.004; ZRUS. DRZAK 30.9214-401 A NAHR. 30.9214-402; ZRUS. LOŽISKO 95.001.005 A NAHR. F6901Z 032/ZM029 24.03.2023 OSTRIZEK

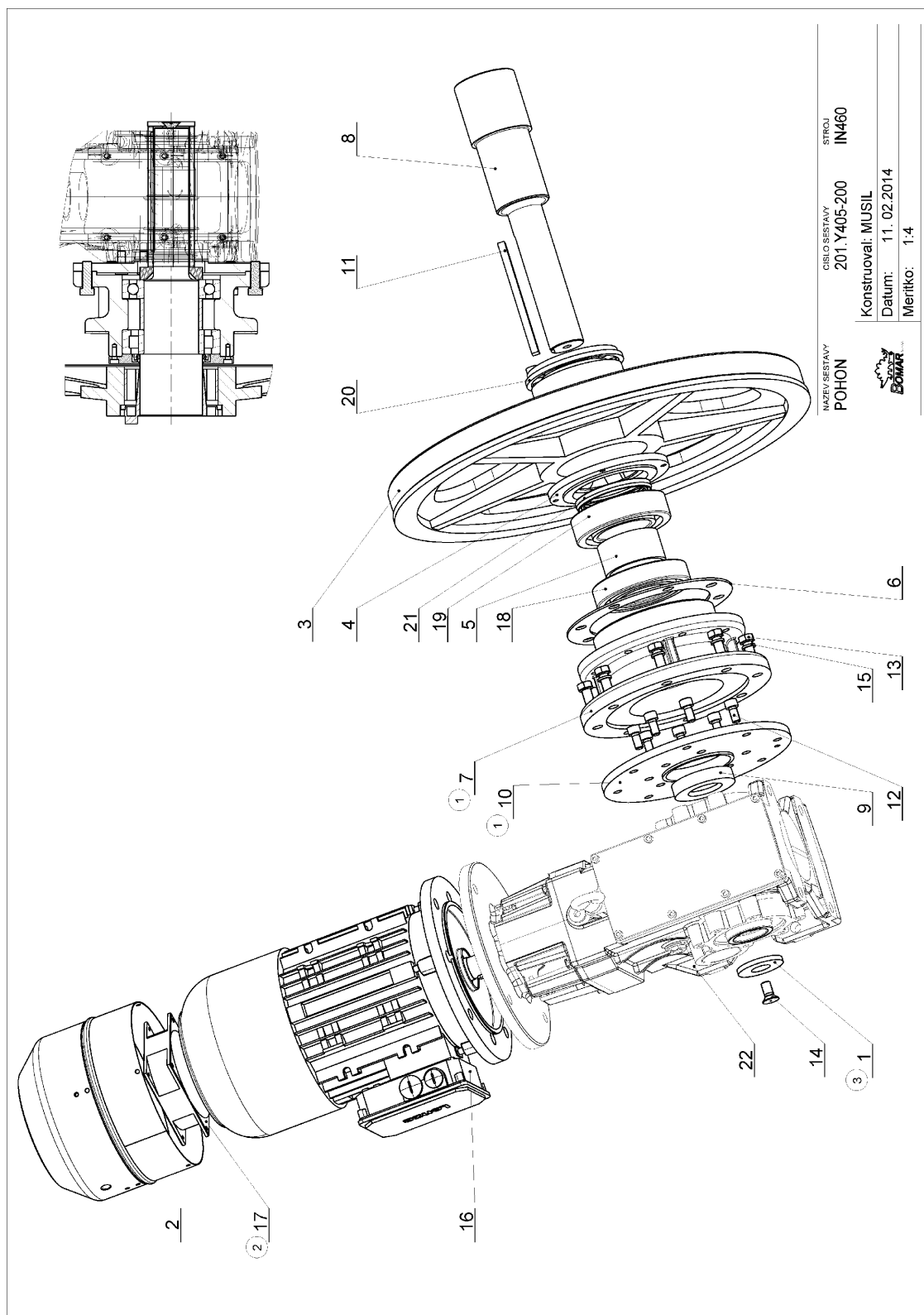
Číslo Sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Position/Position/Position, Objednáč. číslo/Order number/Bestellnummer, Polotovar/Semiprodukt/Halbfabrikat; Vstupní materiál/Input material/Default material/Eingangsmaterial;

9.24. Držák / Holder / Halter

Číslo Sestavy 201.Y404-070		Ver. 0	Název sestavy DRŽÁK/HOLDER/HALTER		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.Y404-071	0	DRŽÁK / HOLDER / HALTER	P 3x100	1
2	90.001.25.016	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M6X12	2
3	90.011.27.024	0	SROUB ZAPUSTNÝ / COUNTERSUNK SCREW / SENKTSCHRAUBE	SROUB M5X20	2
4	90.100.55.003	0	MATICE PŘESNA ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	MATICE _ M5	2
5	90.163.00.006	0	PODLOŽKA DISTANČNÍ / SPACER WASHER / DISTANZSCHEIBE	TR 10x5.3	2
6	94.101.029	0	ZATKA / PLUGBLIND PLUG / BLINDSTOPFEN	PRO IMBUS M8	6



9.25. Pohon / Antrieb / Drive



9.26. Kusovník / Stückliste / Piece list – Pohon / Antrieb / Drive

Číslo Sestavy 201.Y405-200		Ver. 0	Název sestavy POHON/DRIVE /ANTRIEB		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.0804-009	3	PODLOŽKA / WASHER / UNTERLEGSCHEIBE	P 6x60	1
2	30.4304-018	5	VENTILATOR / VENTILATOR / VENTILATOR		1
3	30.6005-001	5	KOLO HNACÍ / DRIVE WHEEL / ANTRIEBSRAD	ODLITEK	1
4	30.6105-604	0	VIKO / COVER / DECKEL	P 12x159	1
5	30.6105-605	0	KROUZEK DISTANČNÍ / SPACER RING / DISTANZRING	TR 80x5	1
6	30.6105-607	0	KROUZEK DISTANČNÍ / SPACER RING / DISTANZRING	P 4x220	1
7	30.R405-505	0	PRIRUBA / FLANGE / FLANSCH	ODLITEK	1
8	30.Y405-202	0	HRDEL / SHAFT / WELLE	d 90	1
9	30.Y405-203	0	KROUZEK DISTANČNÍ / SPACER RING / DISTANZRING	d 80	1
10	30.Y405-205	0	PRIRUBA / FLANGE / FLANSCH	P15x250	1
11	30.Y605-002	0	PERO / PARALLEL KEY / PASSFEDER	HR 14x9	1
12	90.001.25.046	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M10X20	7
13	90.005.55.033	0	SROUB 6HRANNÝ / HEX HEAD SCREW / SECHSKANTSCHRAUBE	SROUB M12X35	8
14	90.011.27.025	0	SROUB ZAPUSTNÝ / COUNTERSUNK SCREW / SENKSCHRAUBE	SROUB M12X25	1
15	90.158.50.009	0	PODLOŽKA PRUŽNA / SPRING WASHER / FEDERSCHNEIBE	PODLOŽKA 12	8
16	91.001.117	0	ELEKTROMOTOR / ELECTRIC MOTOR / ELEKTROMOTOR	4kW 4P B5 112	1
17	91.015.126	0	* / null / null	VENTILATOR RDH1238 B2	1
18	95.001.064	0	LOŽISKO / BEARING / LAGER	6214A	1
19	95.201.007	0	LOŽISKO / BEARING / LAGER	VALEČKOVÁ L. 1RADA	1
20	95.825.001	0	POUZDRO UPINACÍ / FIXING SLEEVE / SPANNHÜLSE	KTR210- 80x120	1
21	95.830.052	0	GUFERO / RADIAL SHAFT SEAL / WELLENDICHTRING	GUFERO 80X100X10	1
22	99.003.020	0	* / null / null	MBH80C PAM112	1

1.ZRUS.PRIRUBA 30.6105-608;30.Y405-201 A NAHR.30.R405-505;30.Y405-205 025/ZM029 8.2.2012 SLEZACKOVA

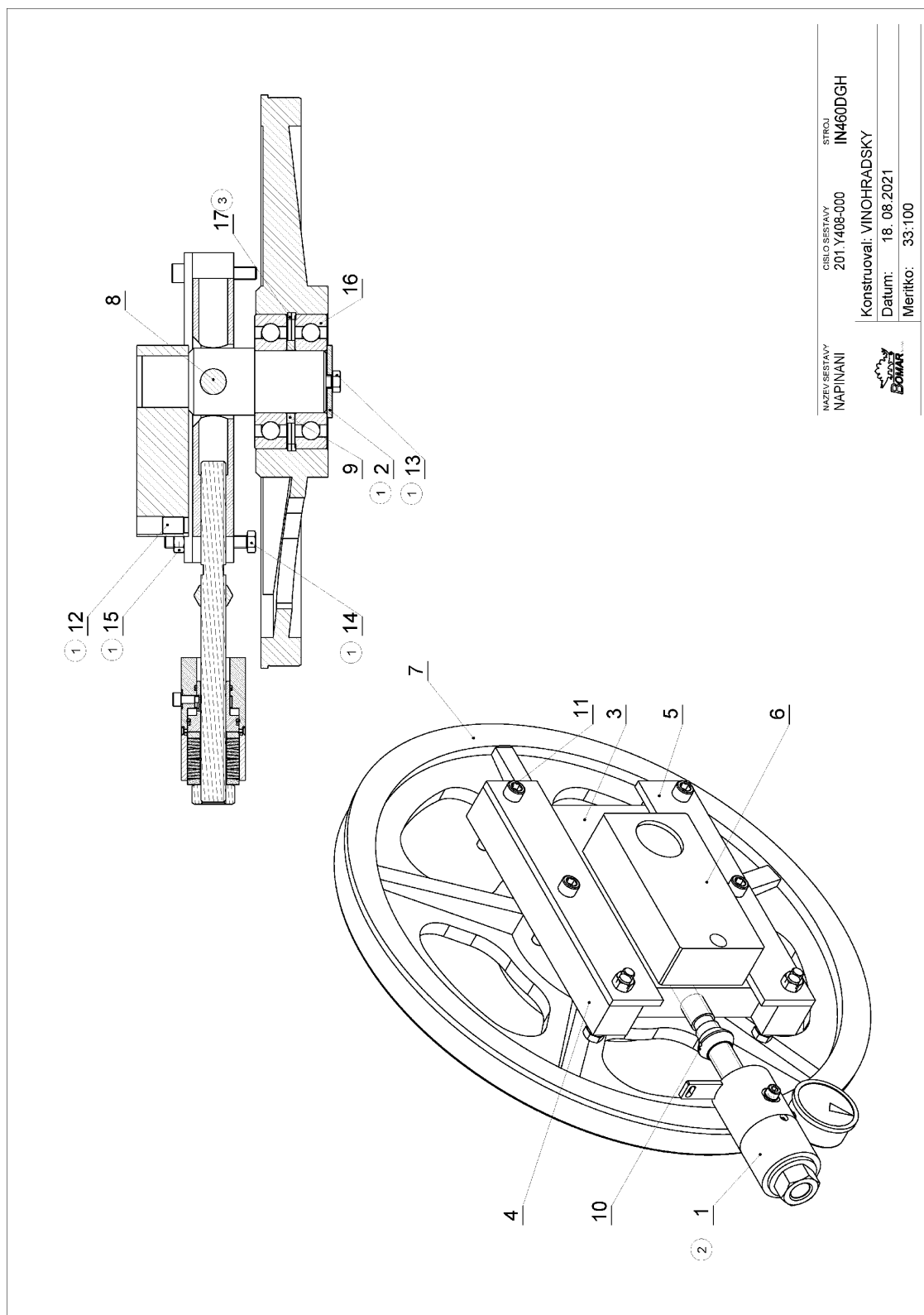
2.ZRUS.VENTILATOR 91.015.100 A NAHR.91.015.126. 074/ZM018 11.2.2014 SLEZACKOVA

3.ZRUS.PODLOŽKA 30.1804-010 A NAHR.30.0804-009. 100/ZM123 30.5.2014 SLEZACKOVA

Číslo Sestavy/Number of assembly/Nummer der Baugruppe: Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz./Position/Position; Objednací číslo/Purchase order number/Bestellnummer. Název položky/Volume title/Name der Position; Rozměr/Stock size/Almessung

Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.27. Napínání / Spannung / Tensioning



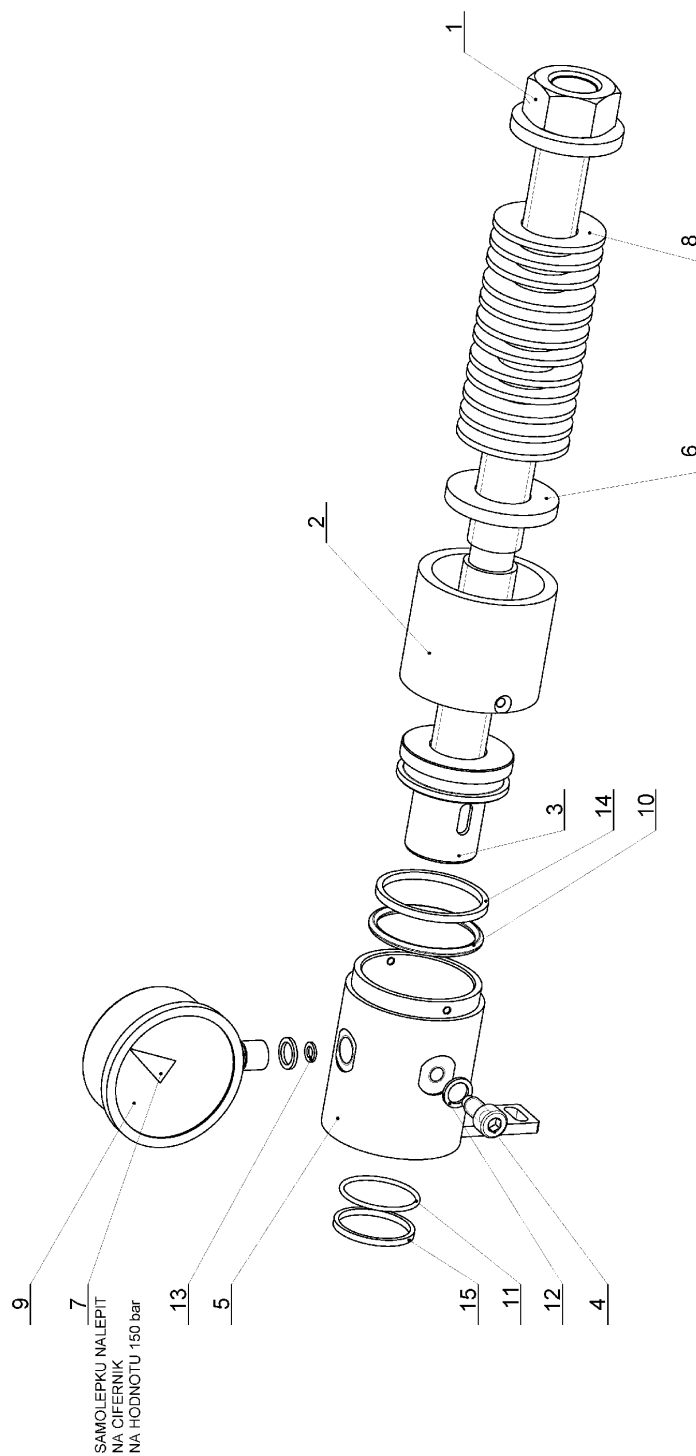
9.28. Kusovník / Stückliste / Piece list – Napínání / Spannung / Tensioning

Číslo Sestavy 201.Y408-000		Ver. 0	Název sestavy NAPINANI/TENSIONING/SPANNUNG		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	201.6107-360	2	VALEC / CYLINDER / ZYLINDER	SESTAVA	1
2	30.1804-014	1	PODLOŽKA / WASHER / UNTERLEGSCHIEBE	P 5x70	1
3	30.6008-001	2	KOSTKA NAPINANI / TENSIONING CUBE / BANDSPANNUNGSWÜRFEL	HR 160x40	1
4	30.6008-002	0	LISTA VODICI / GUIDING SLAT / FÜHRUNGSLEISTE	HR 40x40	2
5	30.6008-003	1	LISTA VODICI / GUIDING SLAT / FÜHRUNGSLEISTE	HR 60x8	2
6	30.6008-004	2	NAPINANI / TENSIONING / SPANNUNG		1
7	30.6008-006	0	KOLO NAPINACI / TENSIONING WHEEL / SPANNRAD		1
8	30.6008-014	1	ČEP NAPINANI / TENSIONING PIVOT / SPANNUNGSBOLZEN	d 25 h6	1
9	30.6708-002	1	DISTANC / SPACER / ABSTANDSTÜCK	TRUBKA 82.5x12.5	1
10	30.7208-006	0	DORAZ / STOP PIECE / ANSCHLAG	d40	1
11	90.001.25.064	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M12x70	5
12	90.002.2D.028	1	SROUB STAVECI / SET SCREW / STELLSCHRAUBE	SROUB M16x1.5x25	1
13	90.005.55.030	1	SROUB 6HRANNY / HEX HEAD SCREW / SECHSKANTSCHRAUBE	SROUB M12x20	1
14	90.005.55.036	1	SROUB 6HRANNY / HEX HEAD SCREW / SECHSKANTSCHRAUBE	SROUB M12x80	2
15	90.100.55.007	1	MATICE PRESNA ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	MATICE _ M12	2
16	95.001.041	0	LOŽISKO / BEARING / LAGER	6312A	2
17	95.801.025	3	KROUZEK POJIST.VNITR. / INTERNAL RETAINING RING / SICHERUNGSRING INNEN	POJISTNÝ KROUZEK 130	2
1.ZRUS.2XSROUB IMBUS M12x70(90.0001.25.064) A NAHR.2XSROUB 6HR M12x80(90.005.55.036),PRID.2XMATICE M12(90.100.55.007), 1xSTAVECI SROUB M16x25(90.002.2D.028),ZRUS.PODLOŽKA 30.1804-010 A NAHR.30.1804-014,ZRUS.SROUB ZAPUSTNÝ M12x20 (90.011.27.009) A NAHR.SROUB 6HR M12x20(90.005.55.030 164/ZM187 24.8.2015 SLEZACKOVA 2.ZRUS. VALEC 201.6107-360 A NAHR. VALCEM 201.6107-360. 083/ZM137 31.3.2017 VLACH 3.PRID. 2x POJISTNÝ KROUZEK 95.801.025. 191/ZM281 18.8.2021 KOVAR					

Číslo Sestavy/Number of assembly/Nummer der Baugruppe: Verze (Ver./Version/Version; Name sestavy/Assembly title/Name der Baugruppe; Pozice (Pos./Position/Position;
Objednací číslo/Purchase order number/Bestellnummer. Název položky/Volume title/Name der Position. Rozměr/Stock size/Abmessung

Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.29. Válec / Zylinder / Roller



NAZEV SESTAVY VALEC	CÍLOVÁ SESTAVA 201.6107-360	STROJ IND 460
Konsturoval: MAJZNER		
Datum: 31. 03. 2017		
Meritko: 3:5		

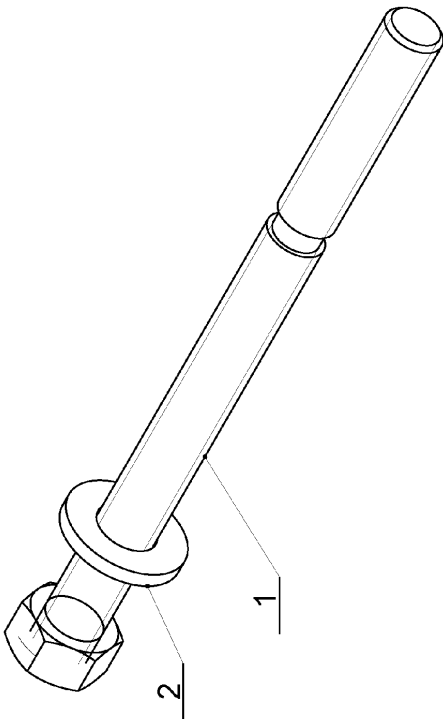
9.30. Kusovník / Stückliste / Piece list – Válec / Zylinder / Roller

Císlo Sestavy 201.6107-360		Ver. 0	Název sestavy VALEC/CYLINDER/ZYLINDER			
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks	
1	201.6108-020	0	SROUB / SCREW / SCHRAUBE		1	1
2	30.6008-013	0	TRUBKA / TUBE / ROHR	TR 62x8	1	1
3	30.6107-352	1	PIST / PISTON / KOLBEN	d 52	1	1
4	30.6107-354	1	SROUB / SCREW / SCHRAUBE	M8x20	1	1
5	30.6107-358	0	VALEC / CYLINDER / ZYLINDER		1	1
6	30.6107-359	1	DISTANC / SPACER / ABSTANDSTÜCK	P 8x50	1	1
7	31.0899-004	0	SAMOLEPKA / STICKER / AUFKLEBER		1	1
8	90.350.02.004	0	PRUŽINA TALIROVA / DISC SPRING / TELLERFEDER	50x25 4x3	12	12
9	92.080.004	0	MANOMETR / MANOMETER	d 63 - 250bar	1	1
10	96.001.033	0	O-KROUZEK STATICKY / O-RING STATIC / O-RING STATISCH	ORAR00224-N70	1	1
11	96.002.063	0	O-KROUZEK DYNAMICKY / O-RING DYNAMIC / O-RING DYNAMISCH	ORAR00125-N70	1	1
12	96.082.001	0	KROUZEK TESNICI / SEALING RING / DICHTRINGSRING	10/14x1.5 CU	2	2
13	96.082.005	0	KROUZEK OPERNY / SUPPORT RING / DICHTRINGSRING	5x8 8x1	1	1
14	96.083.010	0	KROUZEK OPERNY / SUPPORT RING / STÜTZRING	BG2700446-PT00	1	1
15	96.083.011	0	KROUZEK OPERNY / SUPPORT RING / STÜTZRING	BU2000320-PT00	1	1

Císlo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

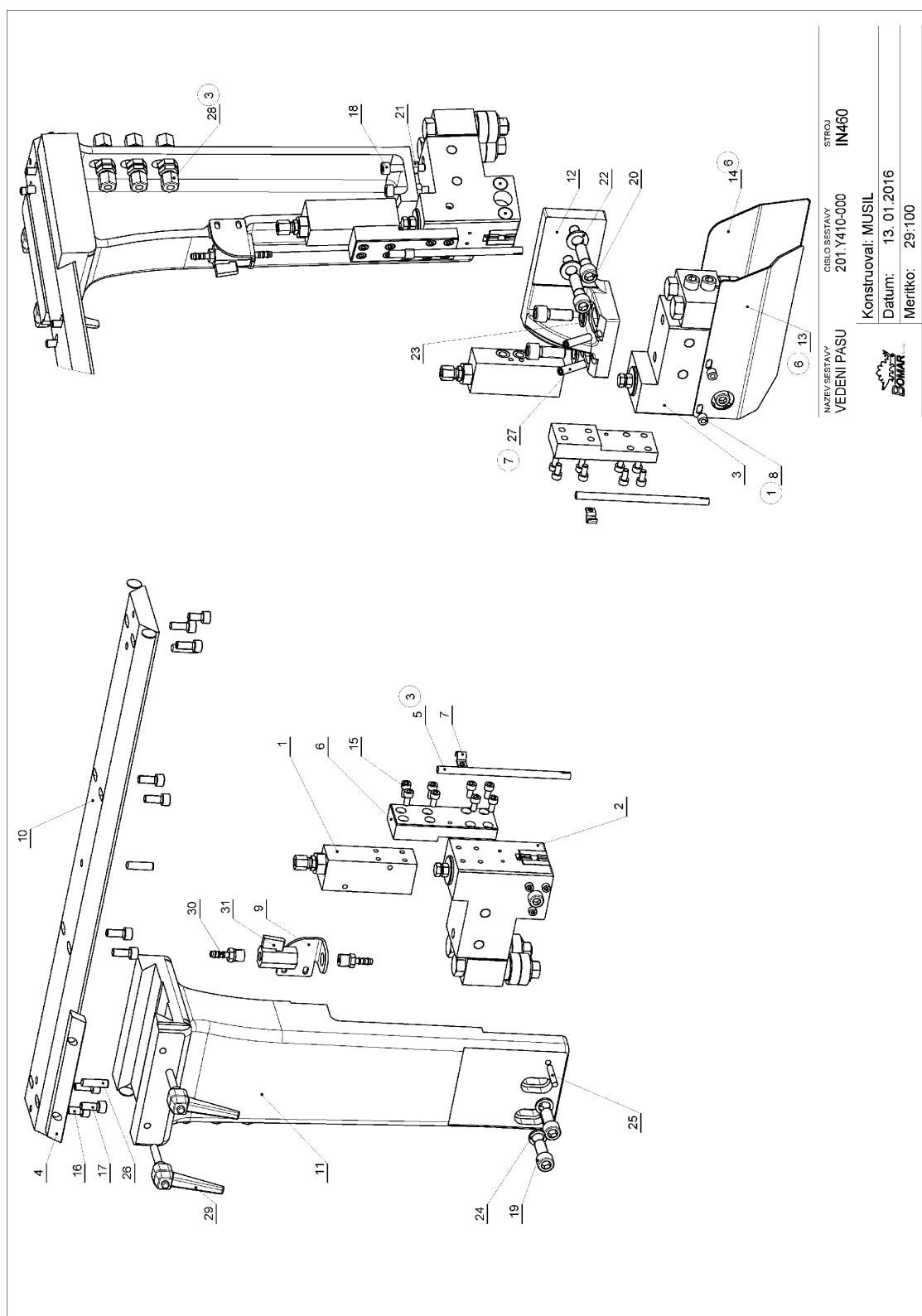
9.31. Šroub/ Schraube/ Bolt

Císlo Sestavy 201.6108-020	Ver. 0	Název sestavy SROUB/SCREW/SCHRAUBE			
Poz.	Objednací císlo	Ver.	Název položky	Rozměr	Ks
1	30.6108-009	0	SROUB / SCREW / SCHRAUBE		1
2	30.6107-359	1	DISTANC / SPACER / ABSTANDSTÜCK	P 8x50	1



Císlo Sestavy/Number of assembly/Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací císlo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.32. Vedení pásu / Sägebandführung / Belt guide

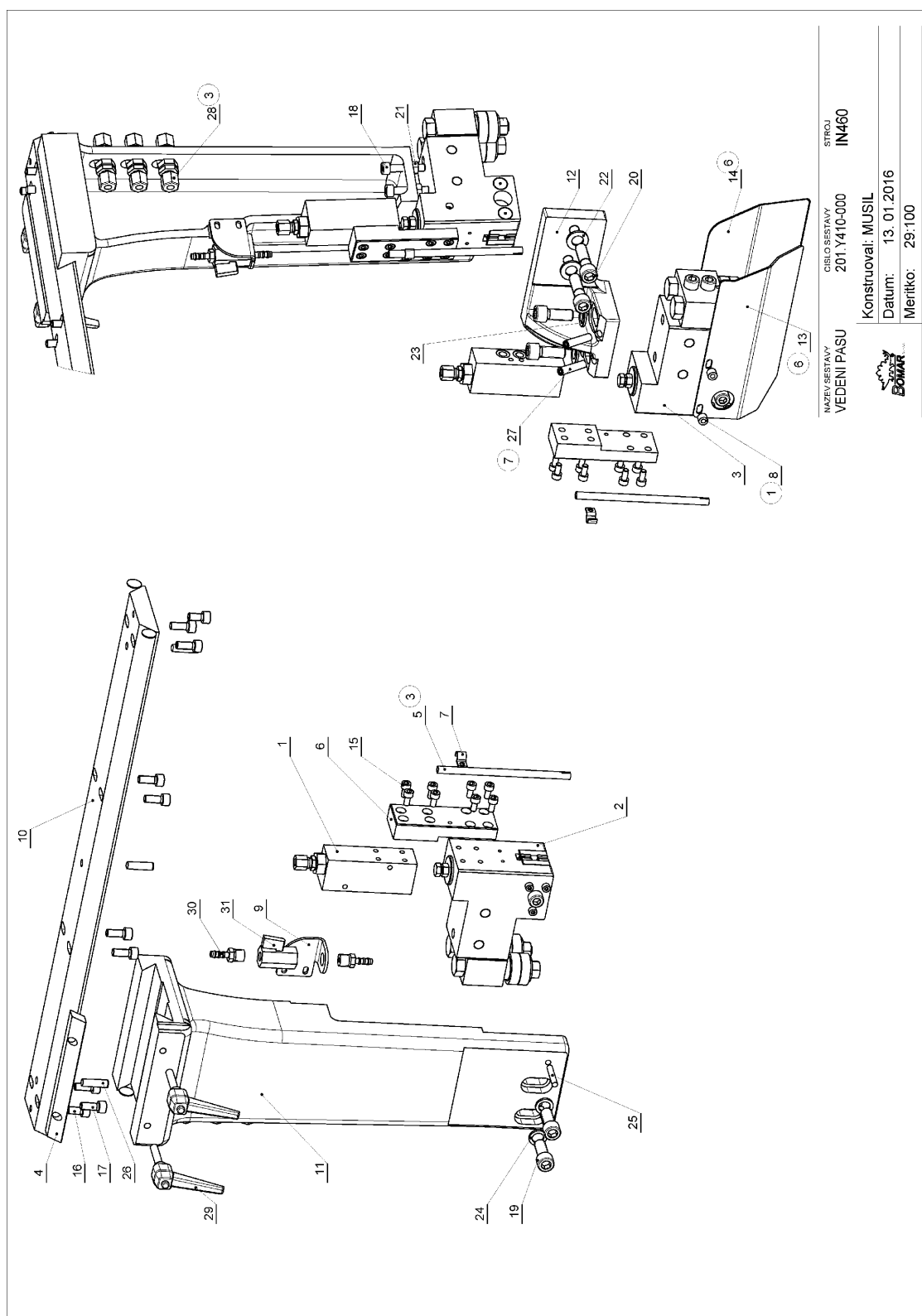


9.33. Kusovník / Stückliste / Piece list – Vedení pásu / Sägebandführung / Belt guide

Císlo sestavy 201.Y410-000		Ver. 0	Název sestavy VEDENÍ PASU/SAW BAND GUIDE/SÄGEBANDFÜHRUNG			
Poz.	Objednávací číslo	Ver.	Název položky	Rozměr	Ks	
1	201.6816-100	0	KOSTKA REGULACE / REGULATION CUBE / REGELUNGSWÜRFEL		2	
2	201.Y410-100	2	KOSTKA VODÍČI / GUIDING CUBE / FÜHRUNGSKLOTZ		1	
3	201.Y410-200	2	KOSTKA VODÍČI / GUIDING CUBE / FÜHRUNGSKLOTZ		1	
4	30.0810-011	0	LISTA / SLAT / LEISTE	HR 25x10	1	
5	30.3510-005	0	TRUBKA / TUBE / ROHR	TR 8x1	2	
6	30.6016-002	0	DESKA / BOARD / PLATTE	HR 40x20	2	
7	30.9010-003	0	DRŽÁK / HOLDER / HALTER	P15x10	2	
8	30.Y310-007	0	KROUZEK / RING / RING	TR 10x2,5	4	
9	30.Y310-008	1	DRŽÁK / HOLDER / HALTER	P 3x50	1	
10	30.Y410-003	0	LISTA / SLAT / LEISTE	HR 90x20	1	
11	30.Y410-104	0	KONZOLA / BRACKET / KONSOL		1	
12	30.Y410-105	4	DRŽÁK / HOLDER / HALTER		1	
13	30.Y410-106	0	KRYT PASU / BELT COVER / BANDABDECKUNG	P 2x108	1	
14	30.Y410-108	0	KRYT PASU / BELT COVER / BANDABDECKUNG	P 2x108	1	
15	90.001.25.016	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSHSCRAUBE	M6x12	16	
16	90.001.25.031	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSHSCRAUBE	8x16	2	
17	90.001.25.032	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSHSCRAUBE	8x20	8	
18	90.001.25.036	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSHSCRAUBE	M8x40	2	
19	90.001.25.058	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSHSCRAUBE	M12x30	4	
20	90.001.25.061	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSHSCRAUBE	M12x45	2	
21	90.100.55.005	0	MATICE PRESNA ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	MATICE _ M8	2	
22	90.150.50.007	0	PODLOŽKA / WASHER / UNTERLEGSCHEIBE	PODLOŽKA 13	2	
23	90.150.50.007	0	PODLOŽKA / WASHER / UNTERLEGSCHEIBE	PODLOŽKA B13	2	
24	90.163.00.003	0	PODLOŽKA / WASHER / UNTERLEGSCHEIBE	NORD-LOCK	2	
25	90.300.02.007	0	KOLÍK VALCOVÝ KALENÝ / CYLINDRICAL PIN HARDENED / ZYLINDERSTIFT GEHÄRTET	KOLÍK 6x36	2	
26	90.302.02.002	0	KOLÍK KUŽELOVÝ+ZAVIT / TAPER PIN + THREAD / KEGBOLZEN + GEWINDE	KOLÍK 8x30	3	
27	90.302.02.003	0	KOLÍK KUŽELOVÝ+ZAVIT / TAPER PIN + THREAD / KEGBOLZEN + GEWINDE	KOLÍK 8x36	2	
28	92.008.101	0	PRUCHODKA PRIMA KOMP / STRAIGHT GROMMET / WANDDURCHFÜHRUNG	G 1/4"	3	
29	94.008.003	0	PAKA MONTÁŽNÍ / ASSEMBLY LEVER / MONTAGEHEBEL	M8x40	2	
30	94.202.002	0	REDUKCE / REDUCTION / ADAPTOR / REDUKTION	REDUKCE 6R1/4"	2	

Císlo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz./Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.34. Vedení pásu / Sägebandführung / Belt guide

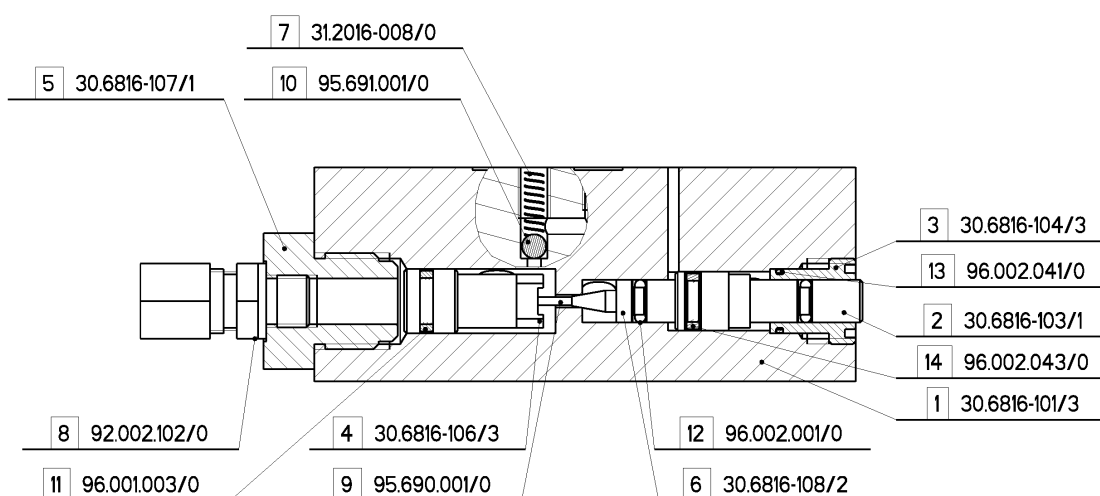


9.35. Kusovník / Stückliste / Piece list – Vedení pásu / Sägebandführung / Belt guide

31	99.260.003	0	VENTIL KULOVÝ / BALL VALVE / KUGELVENTIL	1/4"	1
1. PRIDANO KRYT 30.Y410-006, 30.Y410-008 A KROUZEK 30.Y310-007. 157/ZM188 17.9.2009 SLEZACKOVA 2. PRIDAN DRZAK 30.8910-004. 092/ZM093 3.5.2011 SLEZACKOVA 3. ZRUS. TRUBICKA 30.3510-004 A NAHR. 30.3510-005. 231/ZM264 29.10.2013 SLEZACKOVA 4. ZRUSEN DRZAK 30.8910-004, PRID. PLECH 30.Y410-001. 313/ZM310 19.12.2013 SLEZACKOVA 5. PRIDANA 3xPRUCHODKA PRIMA 92.008.101. 313/ZM028 14.2.2014 SLEZACKOVA 6. ZRUS. KRYT 30.Y410-006 A NAHR. 30.Y410-106, ZRUS. KRYT 30.Y410-008 A NAHR. 30.Y410-108. 066/ZM092 4.4.2014 SLEZACKOVA 7. PRIDAN 2xKOLIK 8x36 (90.302.OZ.003). 004/ZM009 13.1.2016 SLEZACKOVA 8. ZRUS. 30.Y410-001; 213/ZM378 19.10.2018 SCERBA					

Cislo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Nazev sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Nazev položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.36. Kostka regulace / Regulation cube / Regelungswürfel



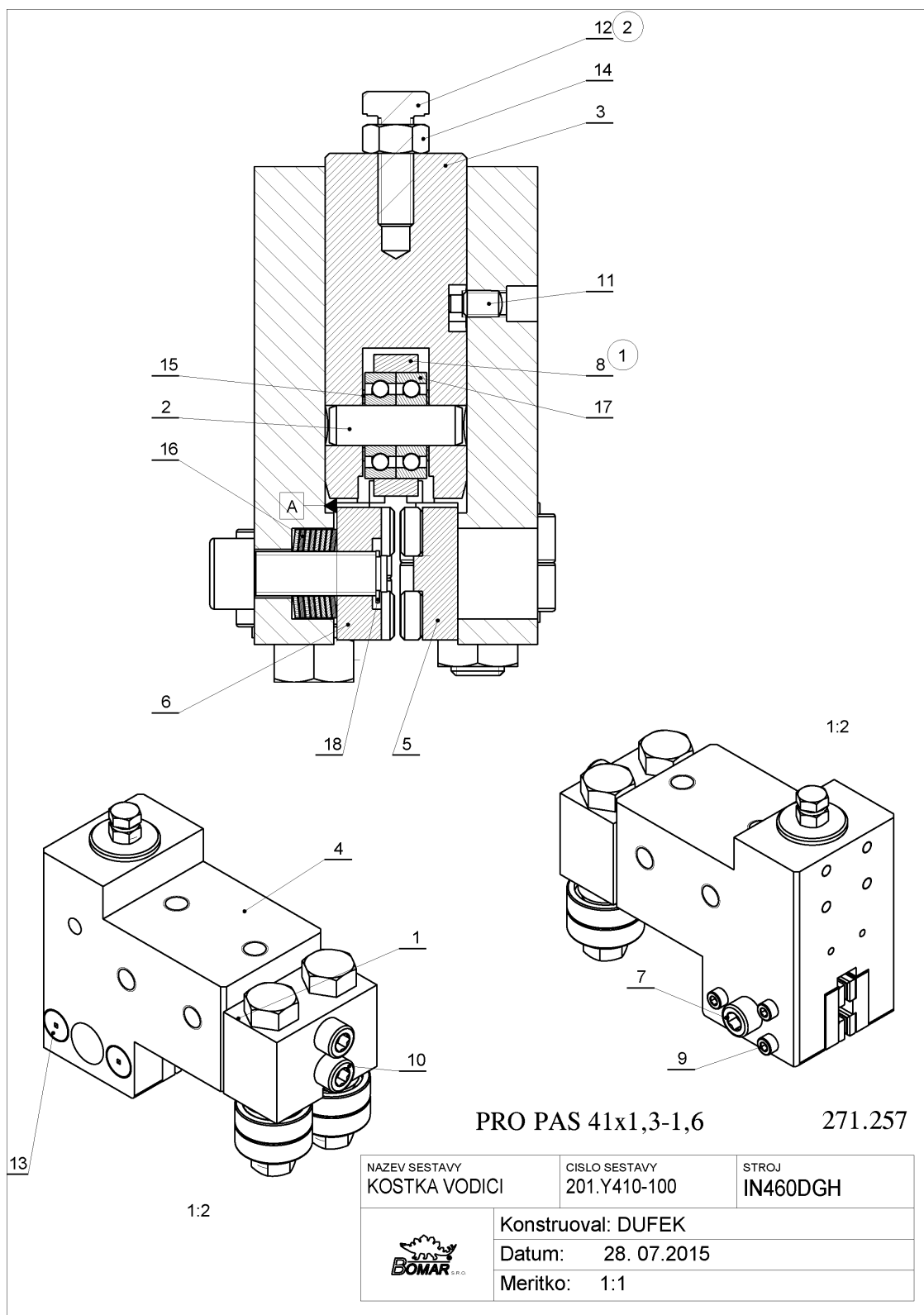
NÁZEV SESTAVY Kat: SL-520- KOSTKA REGULACE 	ČÍSLO SESTAVY 201.6816-100 List/Listů: 1/3 0.3		Revize 0
	Konstruoval: MARAK Datum: 02.08.2022 Měřítko: 1:1		

9.37. Kusovník / Stückliste / Piece list – Kostka regulace / Regulation cube / Regelungswürfel

NAZEV SESTAVY		ČÍSLO SESTAVY		REVIZE			
KOSTKA REGULACE		201.6816-100		0			
Poz.	Objednáč. číslo	Verze	Název CZ	Name EN	Name DE	Polotovár	Ks.
1	30.6816-101	3	KOSTKA REGULACE	REGULATION CUBE	REGELUNGSWÜRFEL	HR40x30 – 104	1
2	30.6816-103	1	PIST	PISTON	KOLBEN	D12 – 37	1
3	30.6816-104	3	VÍKO	COVER	DECKEL	D16 – 18	1
4	30.6816-106	3	PIST	PISTON	KOLBEN	D12 – 28	1
5	30.6816-107	1	VÍKO	COVER	DECKEL	6HR22 – 27	1
6	30.6816-108	2	JEHLA	NEEDLE	NADEL	D8 – 21	1
7	31.2016-008	0	PRUŽINA	SPRING	FEDER	kuličky0.25x3.6x12x9	1
8	92.002.102	0	SROUBENÍ PRÍME KOMPL	null	null	S-GEV 08LLRK 1/8" – 12x1 komplet, kužel. závit	1
9	95.690.001	0	JEHLA	NEEDLE	NADEL	VL NRB 1.5x11.8 G2	1
10	95.691.001	0	KULICKA LOŽISKA	BALL	KUGEL	KC 4,5 G100	1
11	96.001.003	0	O-KROUZEK STATICKY	O-RING STATIC	O-RING STATISCH	8x2 NBR 70Sh 8x2 NBR 70Sh	1
12	96.002.001	0	O-KROUZEK DYNAMICKY	O-RING DYNAMIC	O-RING DYNAMISCH	4x2 NBR 70Sh 4x2 NBR 70Sh	2
13	96.002.041	0	O-KROUZEK DYNAMICKY	O-RING DYNAMIC	O-RING DYNAMISCH	10x1 NBR 70Sh	1
14	96.002.043	0	O-KROUZEK DYNAMICKY	O-RING DYNAMIC	O-RING DYNAMISCH	7x2 NBR 70Sh – SG440 GA Hennlich – vyšší kvalita	1

Číslo Sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Pozice/Position/Position, Objednáč. číslo/Order number/Bestellnummer, Polotovár/Semiprodukt/Halbfabrikat, Vstupní materiál/Input material/Default material/Eingangsmaterial;

9.38. Kostka vodící / Führungsklotz / Lead cube



9.39. Kusovník / Stückliste / Piece list –
Kostka vodící / Führungsklotz / Lead cube

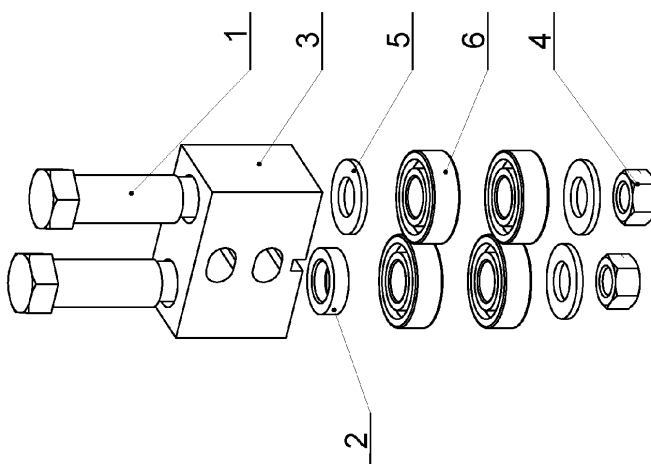
Císlo Sestavy 201.Y410-100		Ver. 2	Název sestavy KOSTKA VODÍCI/GUIDING CUBE/FÜHRUNGSKLOTZ			
Poz.	Objednávací číslo	Ver.	Název položky	Rozměr	Ks	
1	201.6110-510	0	VEDENÍ / GUIDE / FÜHRUNG		TYC 10	1
2	30.6710-108	1	KOLÍK / PIN / BOLZEN			1
3	30.6710-109	0	PIST / PISTON / KOLBEN		d 32	1
4	30.Y410-101	1	KOSTKA VODÍCI / GUIDING CUBE / FÜHRUNGSKLOTZ		HR 110x70	1
5	30.Y410-110	0	DRŽÁK TVRDOKOVU / HM HOLDER / HM-HALTER			1
6	30.Y410-120	0	DRŽÁK TVRDOKOVU / HM HOLDER / HM-HALTER			1
7	30.Y610-503	0	SROUB / SCREW / SCHRAUBE		M10X30	1
8	31.6710-110	0	KROUZEK / RING / RING		LH 2403210	1
9	90.001.25.011	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE		M5X25	3
10	90.001.25.054	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE		M10X80	2
11	90.004.2D.002	0	SROUB STAVEČI / SET SCREW / STELLSCHRAUBE		SROUB M6X12	1
12	90.005.55.016	2	SROUB GHŘANNÝ / HEX HEAD SCREW / SECHSKANTSCHRAUBE		SROUB M8X25	1
13	90.011.27.016	0	SROUB ZAPUSTNÝ / COUNTERSUNK SCREW / SENKSCHRAUBE		SROUB M8X25	2
14	90.100.55.005	0	MATICE PŘESNÁ ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN		MATICE_M8	1
15	90.154.50.003	0	PODLOŽKA VYMEZOVAČI / DISTANCE WASHER / AUSGLEICHSSCHEIBE		10x16x0.50	2
16	90.350.02.005	0	PRUŽINA TALIROVÁ / DISC SPRING / TELLERFEDER		20X10.2X1	8
17	95.001.044	0	LOŽISKO / BEARING / LAGER		609 2RS	2
18	95.900.002	0	KROUZEK POJIST.VNEJŠÍ / EXTERNAL RETAINING RING / SICHERUNGSRING AUBEN		POJISTNÝ KROUZEK 8	1

1.ZRUS.SOUC.30.6710-110 A NAHR.31.6710-110. 175ZM178 28.7.2015 SLEZACKOVA
2.ZRUS.SROUB M8x40(90.005.55.019) A NAHR.M8x25(90.005.55.016). 192ZM309 7.9.2020 SLEZACKOVA

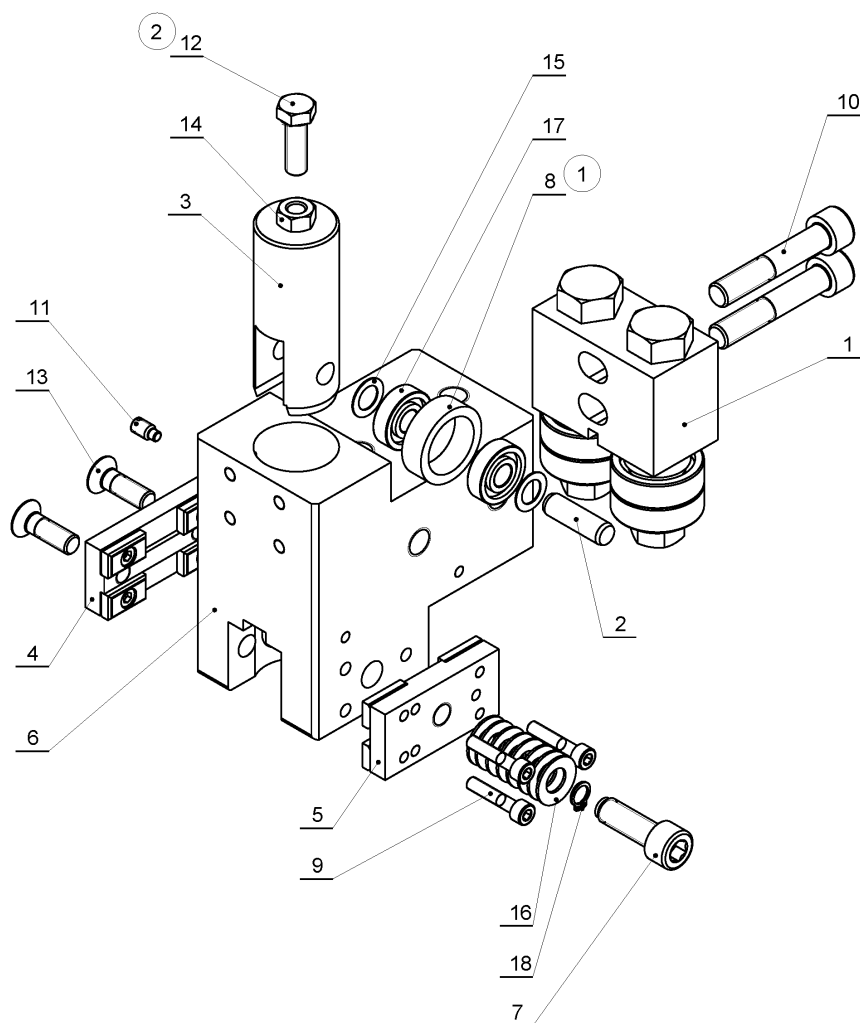
Císlo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Pos./Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.40. Vedení / Guide / Backenführung

Číslo sestavy 201.6110-510		Ver. 0	Název sestavy VEDENÍ/GUIDE/FÜHRUNG			
Poz.	Objednávací číslo	Ver.	Název položky	Rozměr	Ks	
1	30.6010-104	3	EXCENTR / EXCENTER	SK 22	2	
2	30.6010-108	0	KROUZEK DISTANČNÍ / SPACER RING / DISTANZRING	Tr 25x5	1	
3	30.6110-502	0	KOSTKA VODICI / GUIDING CUBE / FÜHRUNGSKLOTZ	HR 80x50	1	
4	90.100.55.007	0	MATICE PRESNA ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	MATICE _ M12	2	
5	90.150.50.008	0	PODLOŽKA / WASHER / UNTERLEGSCHIBE	PODLOŽKA 15	3	
6	95.001.015	0	LOŽISKO / BEARING / LAGER	6202 2RS	4	



9.41. Kostka vodící / Führungsklotz / Lead cube



271.256

NAZEV SESTAVY KOSTKA VODICI	CISLO SESTAVY 201.Y410-200	STROJ IN460DGH
	Konstruoval: MUSIL	
	Datum: 28. 07.2015	
	Meritko: 1:2	

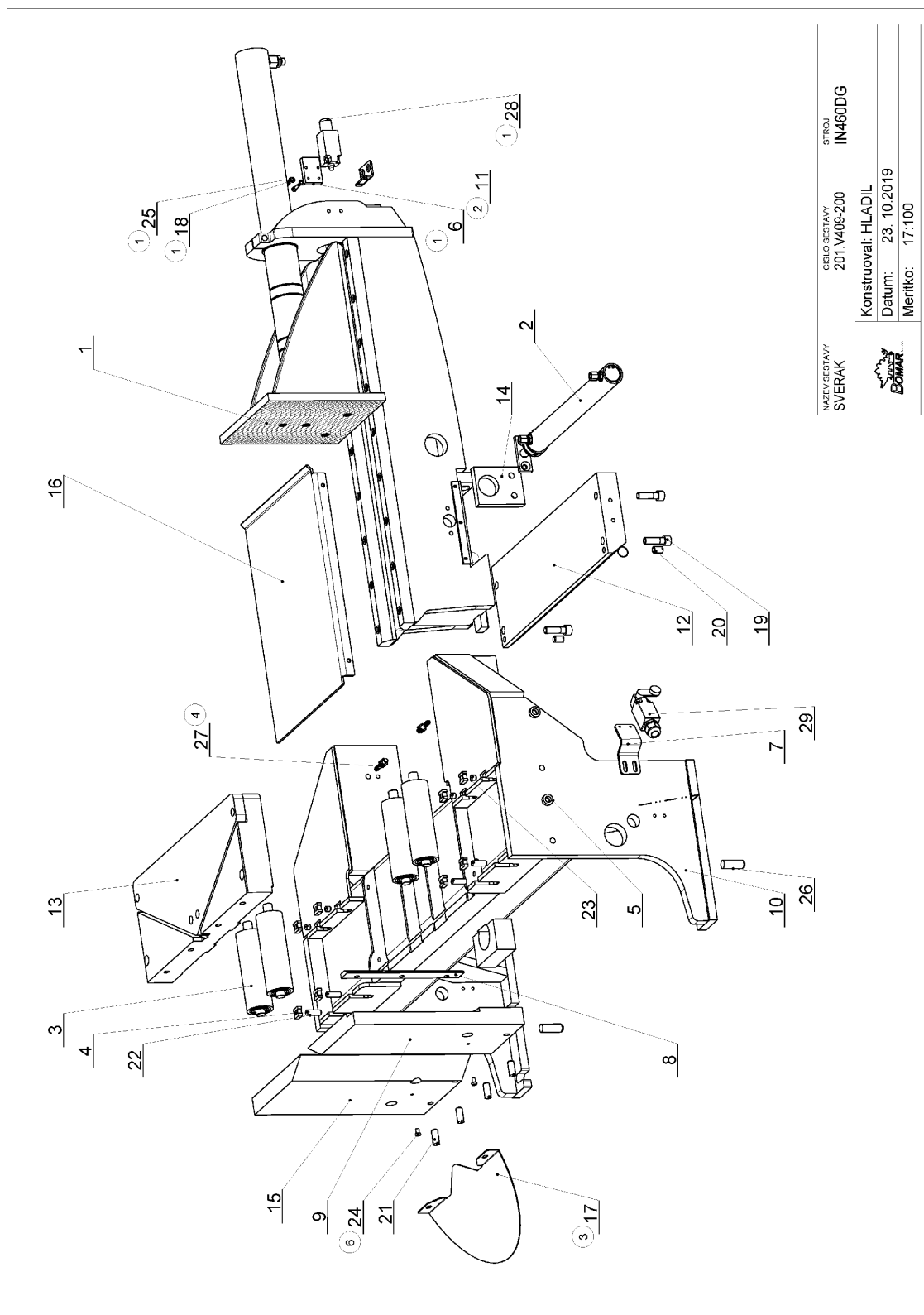
9.42. Kusovník / Stückliste / Piece list –
Kostka vodící / Führungsklotz / Lead cube 2

Císlo Sestavy 201.Y410-200		Ver. 2	Název sestavy KOSTKA VODÍCI/GUIDING CUBE/FÜHRUNGSKLOTZ			
Poz.	Objednávací číslo	Ver.	Název položky	Rozměr	Ks	
1	201.6110-510	0	VEDENÍ / GUIDE / FÜHRUNG		TYC 10	1
2	30.6710-108	1	KOLÍK / PIN / BOLZEN		d 32	1
3	30.6710-109	0	PIST / PISTON / KOLBEN			1
4	30.Y410-110	0	DRŽÁK TVRDOKOVU / HM HOLDER / HM-HALTER			1
5	30.Y410-120	0	DRŽÁK TVRDOKOVU / HM HOLDER / HM-HALTER			1
6	30.Y410-201	2	KOSTKA VODÍCI / GUIDING CUBE / FÜHRUNGSKLOTZ			1
7	30.Y610-503	0	SROUB / SCREW / SCHRAUBE	HR 170x70		1
8	31.6710-110	0	KROUZEK / RING / RING	M10X30 LH 2403210		1
9	90.001.25.011	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M5X25		3
10	90.001.25.053	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M10X55		2
11	90.004.2D.002	0	SROUB STAVEČI / SET SCREW / STELLSCHRAUBE	SROUB M6X12		1
12	90.005.55.016	2	SROUB GHŘANNÝ / HEX HEAD SCREW / SECHSKANTSCHRAUBE	SROUB M8X25		1
13	90.011.27.016	0	SROUB ZAPUSTNÝ / COUNTERSUNK SCREW / SENKSCHRAUBE	SROUB M8X25		2
14	90.100.55.005	0	MATICE PŘESNÁ ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	MATICE_M8		1
15	90.154.50.003	0	PODLOŽKA VYMEZOVACÍ / DISTANCE WASHER / AUSGLEICHSSCHEIBE	10x16x0.50		2
16	90.350.02.005	0	PRUŽINA TALIROVÁ / DISC SPRING / TELLERFEDER	20X10.2X1		8
17	95.001.044	0	LOŽISKO / BEARING / LAGER	609 2RS		2
18	95.900.002	0	KROUZEK POJIST. VNEJŠÍ / EXTERNAL RETAINING RING / SICHERUNGSRING AUBEN	POJISTNÝ KROUZEK 8		1

1.ZRUS.SOUC.30.6710-110 A NAHR.31.6710-110. 175ZM178 28.7.2015 SLEZACKOVA
2.ZRUS.SROUB M8x40(90.005.55.019) A NAHR.M8x25(90.005.55.016). 192ZM309 7.9.2020 SLEZACKOVA

Císlo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Pos./Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.43. Svěrák / Schraubstock / Vice



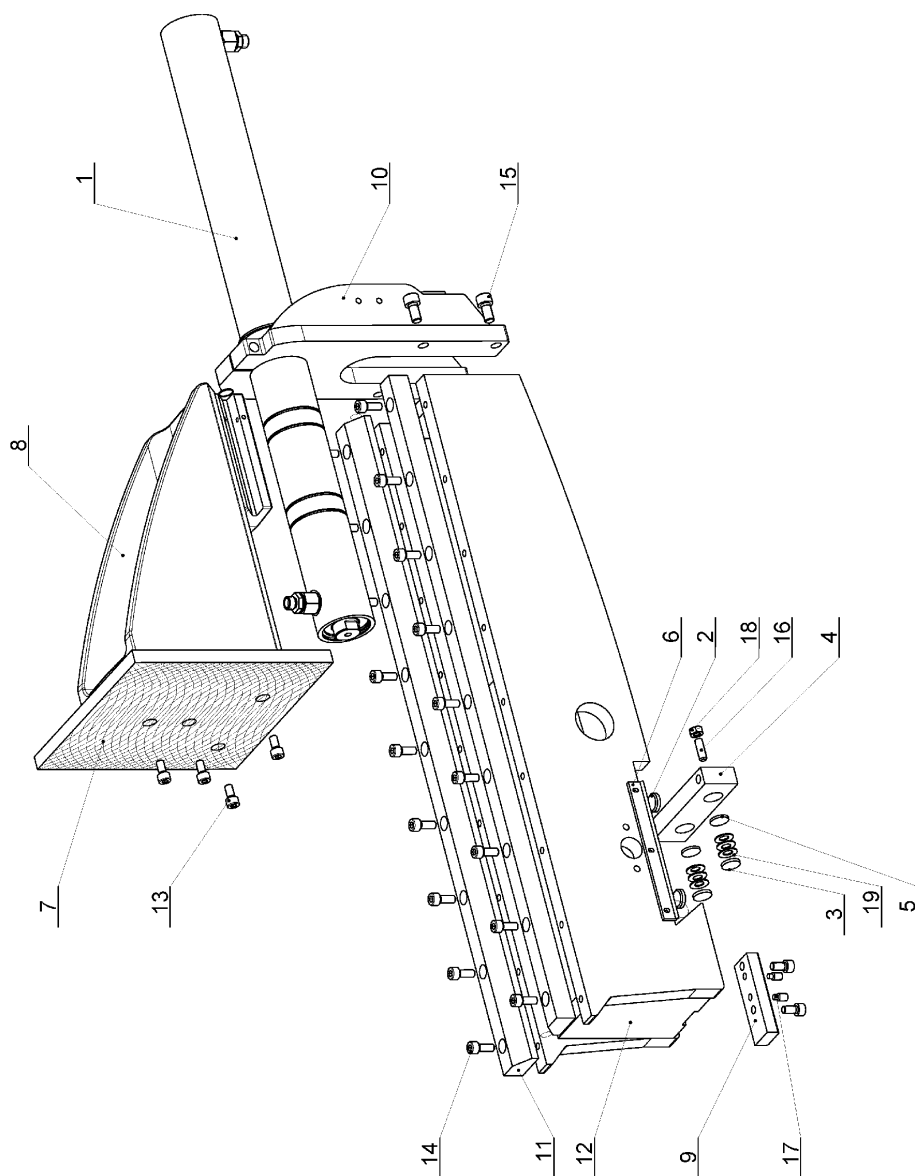
9.44. Kusovník / Stückliste / Piece list – Svěrák / Schraubstock / Vice

Číslo sestavy 201.V409-200		Ver. 0	Název sestavy SVERAK/VICE/SCHRAUBSTOCK			
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks	
1	201.V403-200	0	SVERAK / VICE / SCHRAUBSTOCK		1	
2	201.Y307-250	0	VALEC POMOCNÝ / AUXILIARY CYLINDER / HILFSZYLINDER		1	
3	201.Y309-230	0	VALEČEK / ROLLER / ROLLE		4	
4	30.1517-841	0	MATICE / NUT / MUTTER	P 8x19 d 20x4	8	
5	30.9002-007	0	DISTANC / SPACER / ABSTANDSTÜCK	HR 35x10	2	
6	30.V303-011	1	DRZAK / HOLDER / HALTER	P4	1	
7	30.V309-009	0	DRZAK / HOLDER / HALTER	HR 30x10	2	
8	30.V405-013	0	LISTA CELISTI / JAW SLAT / BACKENLEISTE	P35x222	1	
9	30.V409-202	0	CELIST PEVNA / FIXED JAW / FESTE BACKE		1	
10	30.Y309-201	0	PODSTAVEC SVERAKU / VICE BASE / SCHRAUBSTOCKUNTERSATZ		1	
11	30.Y309-204	2	DRZAK / HOLDER / HALTER	P 3x45	1	
12	30.Y309-205	0	VEDENÍ / GUIDE / FÜHRUNG	HR 160x40	1	
13	30.Y309-210	0	DESKA / BOARD / PLATTE		1	
14	30.Y309-213	0	DRZAK / HOLDER / HALTER	HR 75x15	1	
15	30.Y409-203	0	CELIST PEVNA / FIXED JAW / FESTE BACKE	P 35x242	1	
16	30.Y409-207	0	PLECH / SHEET METAL / BLECH	P 4x352	1	
17	30.Y414-202	3	SKLUZ / CHUTE / RUTSCH	P1 5x203	1	
18	90.001.25.010	1	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M5x20	2	
19	90.001.25.060	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M12x40	4	
20	90.002.20.018	0	SROUB STAVECI / SET SCREW / STELLSCHRAUBE	SROUB M12x20	2	
21	90.002.20.020	0	SROUB STAVECI / SET SCREW / STELLSCHRAUBE	SROUB M12x30	4	
22	90.002.20.024	0	SROUB STAVECI / SET SCREW / STELLSCHRAUBE	SROUB M10x30	4	
23	90.002.20.026	0	SROUB STAVECI / SET SCREW / STELLSCHRAUBE	SROUB M10x10	4	
24	90.013.27.007	6	SROUB PULKULATY / BUTTON HEAD SCREW / RUNDKOPFSCHRAUBE	M6x10	2	
25	90.150.90.003	1	PODLOZKA / WASHER / UNTERLEGSCHEIBE	PODLOZKA 5,3	2	
26	90.300.02.035	0	KOLIK VALCOVÝ KALENÝ / CYLINDRICAL PIN HARDENED / ZYLINDERSTIFT GEHÄRTET	KOLIK 16x45	2	
27	91.172.033	4	SPINAC INDUKTIVNÍ / INDUCTIVE SWITCH / INDUKTIVER SCHALTER	IME08-02BPSZT0S	2	
28	91.173.007	1	SPINAC KONCOVÝ / END SWITCH / ENDSCHALTER	-RIWK	1	
29	91.173.017	0	SPINAC KONC. S KLADK. / END SWITCH WITH PULLEY / ENDSCHALTER MIT ROLLE	FR 630	2	

1.PRID. DRZAK 30.V303-011, 2XSROUB M5x20(90.001.25.010), 2XPODLOZKA 5.3(90.150.50.003), 1XKONCOVÝ SPINAC 91.173.007), 239ZM304 25.10.2012 SLEZACKOVA
2.ZRUS REGULATE TLAKU SVERAKU 201.2115-200, PRIDAN DRZAK 30.Y309-204, 025/ZM065 8.3.2013 SLEZACKOVA
3.ZRUSEN SKLUZ 30.Y314-002 A NAHR. 30.Y414-202, 066/ZM092 4.4.2014 SLEZACKOVA
4.ZRUS 91.172.009 NAHR. 91.172.033, 068/ZM109 15.3.2019 SCERBA
5.ZRUS. VEDENÍ 30.V409-205, 200/ZM270 24.6.2019 SZABARI
6.PR. 2XSROUB M6x10 90.013.27.007, ZR. 4XKOLIK 8x40 90.300.02.011, 306/ZM436 23.10.2019 KOSYK

Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.45. Svěrák / Schraubstock / Vice



NÁZEV / SESTAVY SVĚRAK	CÍLOVÉ SESTAVY 201_V403-200	STROJ I460DGA
		
Konstruoval: HLADIL		
Datum: 10. 06.2015		
Měřítko: 1:4		

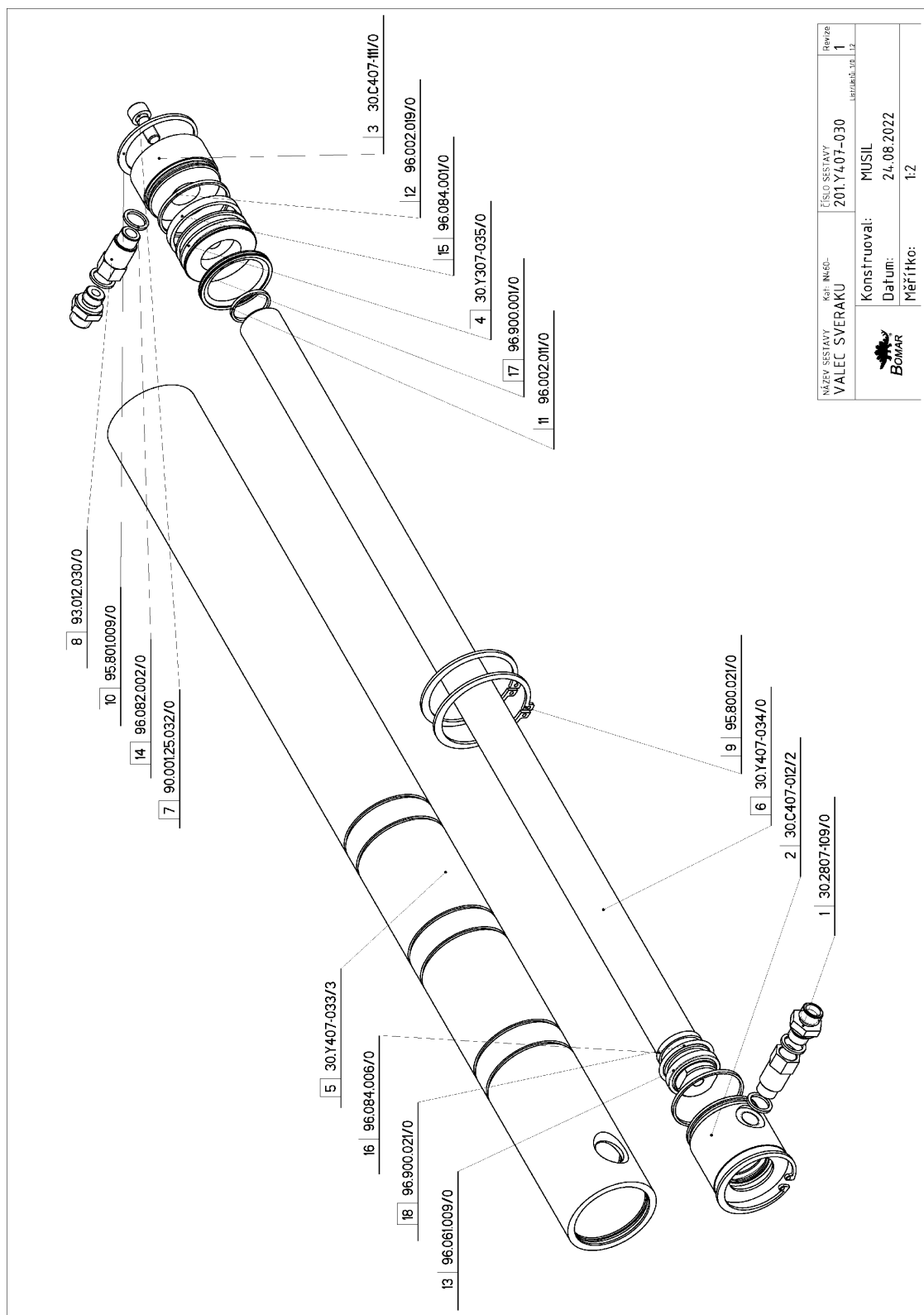
9.46. Kusovník / Stückliste / Piece list – Svěrák / Schraubstock / Vice

Číslo Sestavy 201.V403-200		Ver. 0	Název sestavy SVERAK/VICE/SCHRAUBSTOCK		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	201.Y407-030	0	VALEC SVERAKU / VICE CYLINDER / SCHRAUBSTOCKZYLINDER		1
2	30.0509-608	0	PODLOŽKA / WASHER / UNTERLEGSCHEIBE	d20	4
3	30.0803-005	0	DESKA / BOARD / PLATTE		2
4	30.V303-008	0	LISTA SVERAKU / VICE SLAT / SCHRAUBSTOCKLEISTE	HR 40x20	1
5	30.V303-010	0	PODLOŽKA / WASHER / UNTERLEGSCHEIBE	P 2.5x20	2
6	30.V309-011	0	STERAC / WIPER / ABSTREIFER	BA18	2
7	30.V403-007	0	CELIST / JAW / BACKE	P16x240	1
8	30.V303-005	0	CELIST / JAW / BACKE		1
9	30.V303-010	0	DESKA / BOARD / PLATTE	HR 30x15	1
10	30.V303-104	0	DRŽAK / HOLDER / HALTER		1
11	30.V403-002	0	LISTA SVERAKU / VICE SLAT / SCHRAUBSTOCKLEISTE	HR 40x25	2
12	30.V403-203	0	SVERAK / VICE / SCHRAUBSTOCK		1
13	90.001.25.031	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	8x16	6
14	90.001.25.032	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	8x20	18
15	90.001.25.046	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M10x20	4
16	90.002.2D.013	0	SROUB STAVECI / SET SCREW / STELSCHRAUBE	SROUB M8x25	2
17	90.004.2D.008	0	SROUB STAVECI / SET SCREW / STELSCHRAUBE	SROUB M8x16	2
18	90.100.55.005	0	MATICE PŘESNA ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	MATICE _ M8	2
19	90.350.02.005	0	PRUŽINA TALIROVA / DISC SPRING / TELLERFEDER	20X10.2X1	6

Číslo Sestavy/Number of assembly/Nummer der Baugruppe: Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz./Position/Position; Objednací číslo/Purchase order number/Bestellnummer. Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.47. Válec svěráku / Schraubstockzylinder / Vice cylinder



9.48. Kusovník / Stückliste / Piece list –
Válec svěráku / Schraubstockzylinder / Vice cylinder

NÁZEV SESTAVY			ČÍSLO SESTAVY		REVIZE	Kategorie: IN450-		Konstruktér: MUSIL			
VALEC SVĚRAKU			201.Y407-030		1	Datum: 24.08.2022					
			Listů/leť.č. 2/0		1,2						
pos.	číslo výkresu	verze	množství	název	položka	jakost	pov.úpr.	váha	poznámka		
1	30.2807-109	0	2	SROUBENÍ PRIME	92.002.001			0.0			
2	30.C407-012	2	1	VÍKO	D55 - 47 40.14.05.21	1109		0.4			
3	30.C407-111	0	1	VÍKO	D55 - 29 40.14.05.21	1109		0.4			
4	30.Y307-035	0	1	PIST	D55 - 17 40.14.05.21	1109		0.2			
5	30.Y407-033	3	1	VALEC	TR62x6 - 722 40.350.00.05	SF52- H8		5.8			
6	30.Y407-034	0	1	PISTNICE	D28 - 690 40.800.00.03	20MnV6		3.3			
7	90.001.25.032	0	1	SROUB IMBUS	8x20 DIN 912 8,8 černěný			0.0			
8	93.012.030	0	2	SROUBENÍ PRIME	2070 - 1/4 - 1/4 - L35 1/4" vnitřní - 1/4" vnější			0.0			
9	95.800.021	0	2	KROUZEK POJIST.VNEJS	d62 DIN 471			0.0			
10	95.801.009	0	2	KROUZEK POJIST.VNITR	d52 DIN 472			0.0			
11	96.002.011	0	1	O-KROUZEK DYNAMICKY	24x2 NBR 70Sh			0.0			
12	96.002.019	0	2	O-KROUZEK DYNAMICKY	46x2 NBR 70Sh 46x2 NBR 70Sh			0.0			
13	96.061.009	0	1	KROUZEK STIRACI	WD22020280 Z201 28.0x36.0x5.0x5.0			0.0			
14	96.082.002	0	4	KROUZEK TESNICI	13/17x15			0.0			
15	96.084.001	0	1	KROUZEK VODICI	GP6500500 - T47 50.0x5 6x2.5x16.9			0.0			
16	96.084.006	0	1	KROUZEK VODICI	GR4-300280 - T47 28.0x3 9x1.55x94.1			0.0			
17	96.900.001	0	1	TESNENÍ KOMBINOVANE	PW4-200500 - Z20N 39.0x50.0x4.2	ZURKON WYNSEAL		0.0			
18	96.900.021	0	1	TESNENÍ KOMBINOVANE	RSK200280- 46N 28.0x36.7x4.2			0.0			
INDEX ZMĚNA					DATUM		PODPIS				
I. ZRUS SROUBENI 30.1807-005 NAHR 93.012.030 . 323/ZM309 2.11.2022 KVASNICKA											

Číslo Sestavy/Number of assembly/Nummer der Baugruppe: Verze (Ver./Version/Version, Název sestavy/Assembly name/Name der Baugruppe: Datum/Date/Datum, Konstruktér/Designer/Konstrukteur,Číslo výkresu/Drawing number/Zeichnung nummer; Název/Name/Name, Položka/Component/Halbbauartikel; Vstupní materiál/Input material, Pov. úpr./Surface finish/Oberflächenaufte.Váha/Weight/Gewicht; Rozměry/Dimensions/Abmessungen/Note/Notiz

Číslo sestavy/Number of assembly/Nummer der Baugruppe, Verze (Ver.)/Version/Variation, Název sestavy/Assembly name/Name der Baugruppe, Datum/Date/Datum, Konstruktor/Designer/Konstrukteur, Číslo výkresu/Drawing number/Zeichnung number, Název/Name, Položka/Semiproduct/Halbfabrikat, Vstupní materiál/Vstupní mat./Default material/Eingangsmaterial, Jakost/Norm/Norm, Pov. úpr./Surface finish/Oberflächenpflege, Váha/Weight/Gewicht, Poznámka/Note/Notiz

9.50. Kusovník / Stückliste / Piece list – Válec pomocný / Hilfszylinder / Aux. cylinder

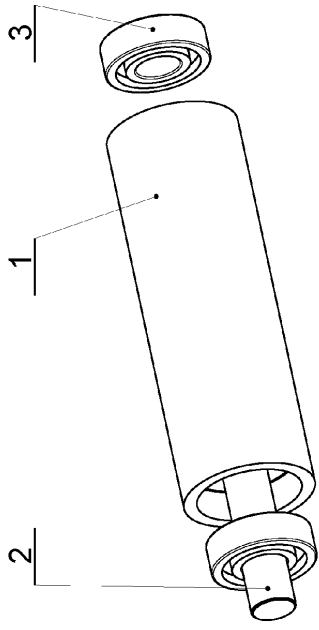
Císlo Sestavy 201.Y307-250		Ver. 0	Název sestavy VALEC POMOCNY/AUXILIARY CYLINDER/HILFSZYLINDER		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.6807-103	2	VIKO / COVER / DECKEL	TYC 35	1
2	30.6807-104	1	VIKO / COVER / DECKEL	TYC 35	1
3	30.6807-105	1	VIKO / COVER / DECKEL	TYC 35	1
4	30.6807-203	0	PIST / PISTON / KOLBEN	TYC 35	1
5	30.V307-157	0	DRŽAK / HOLDER / HALTER	HR 25x8	1
6	30.Y307-251	0	VALEC POMOCNY / AUXILIARY CYLINDER / HILFSZYLINDER	TR 40/30	1
7	30.Y307-252	0	PISTNICE / PISTON ROD / KOLBENSTANGE	d 16	1
8	90.001.25.017	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M6X16	1
9	90.100.55.006	0	MATICE PRESNA ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	MATICE _ M10	1
10	92.002.102	0	SROUBENI PRIME KOMPL / null / null	S-GEV-8LLR	2
11	95.800.015	0	KROUZEK POJIST.VNEJS / EXTERNAL RETAINING RING / SICHERUNGSRING AUßEN	POJISTNY KROUZEK 40	2
12	95.801.026	0	KROUZEK POJIST.VNITR / INTERNAL RETAINING RING / SICHERUNGSRING INNEN	POJISTNY KROUZEK 34	2
13	96.001.008	0	O-KROUZEK STATICKY / O-RING STATIC / O-RING STATISCH	26x2 NBR 70SH	2
14	96.002.006	0	O-KROUZEK DYNAMICKY / O-RING DYNAMIC / O-RING DYNAMISCH	12x2 NBR 70SH	1
15	96.041.001	0	MANŽETA / CUFF / MANSCHETTE	16x24x4 UN	1
16	96.060.001	0	KROUZEK STRIACI / WIPER RING / ABSTREIFRING	16x22 NBR 70	1
17	96.062.001	0	KROUZEK TESNICI / SEALING RING / DICHTUNGSRING	10/14	2
18	96.900.007	0	TESNENI KOMBINOVANE / COMBINED SEALING / KOMBIDICHTUNG	PW4100300-Z20	1

Císlo Sestavy/Number of assembly/Nummer der Baugruppe, Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe, Pozice (Poz.)Position/Position;

Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

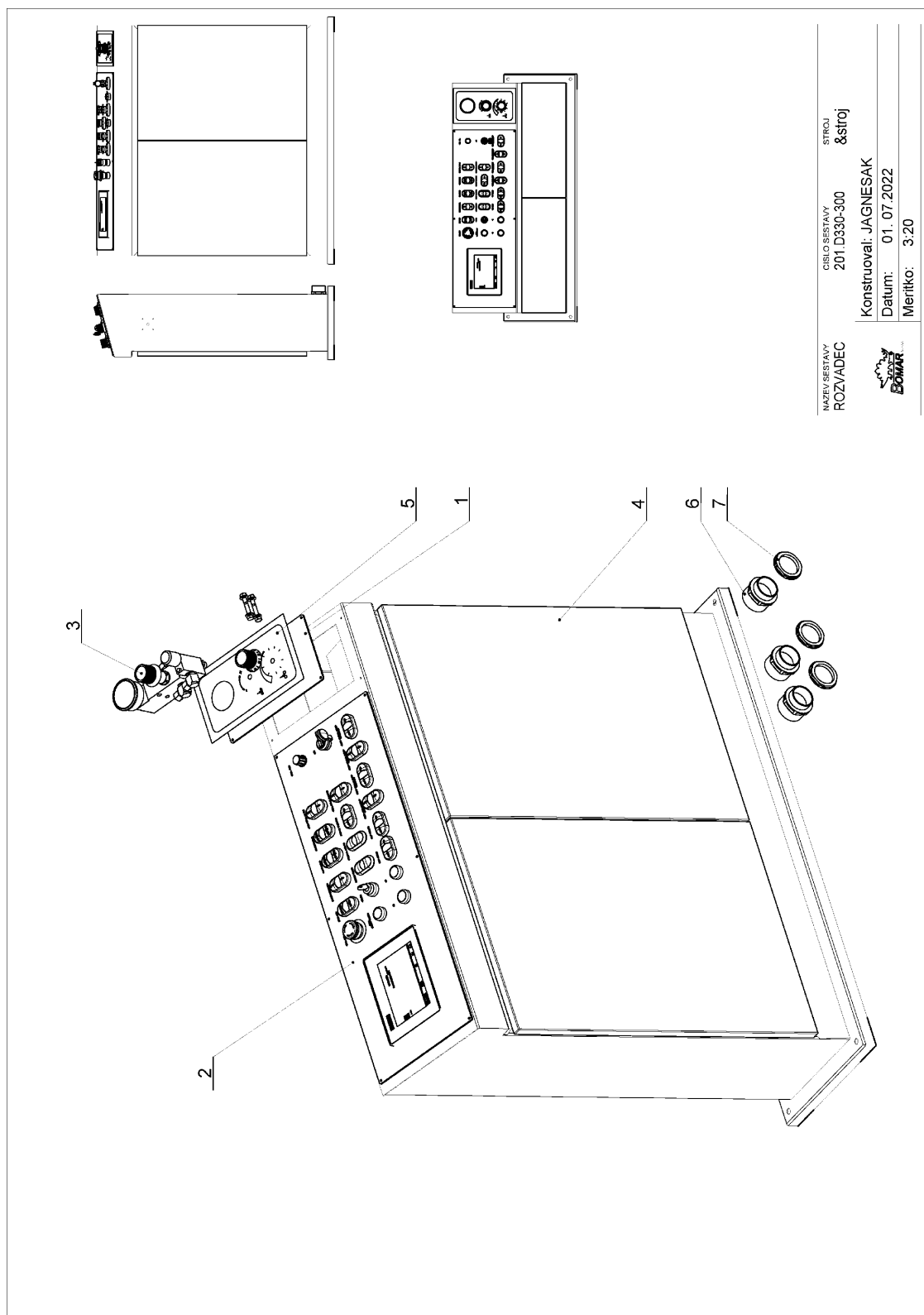
9.51. Váleček / Rolle / Cylinder

Číslo sestavy 201.Y309-230		Ver. 0	Název sestavy VALECEK/ROLLER/ROLLE	
Poz.	Objednací číslo	Ver.	Název položky	Ks
1	30.Y309-231	0	VALECEK / ROLLER / ROLLE	1
2	30.Y309-232	0	OSA / AXLE / ACHSE	1
3	95.001.016	0	LOŽISKO / BEARING / LAGER	2



Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.52. Rozvaděč / Verteiler / Distributor

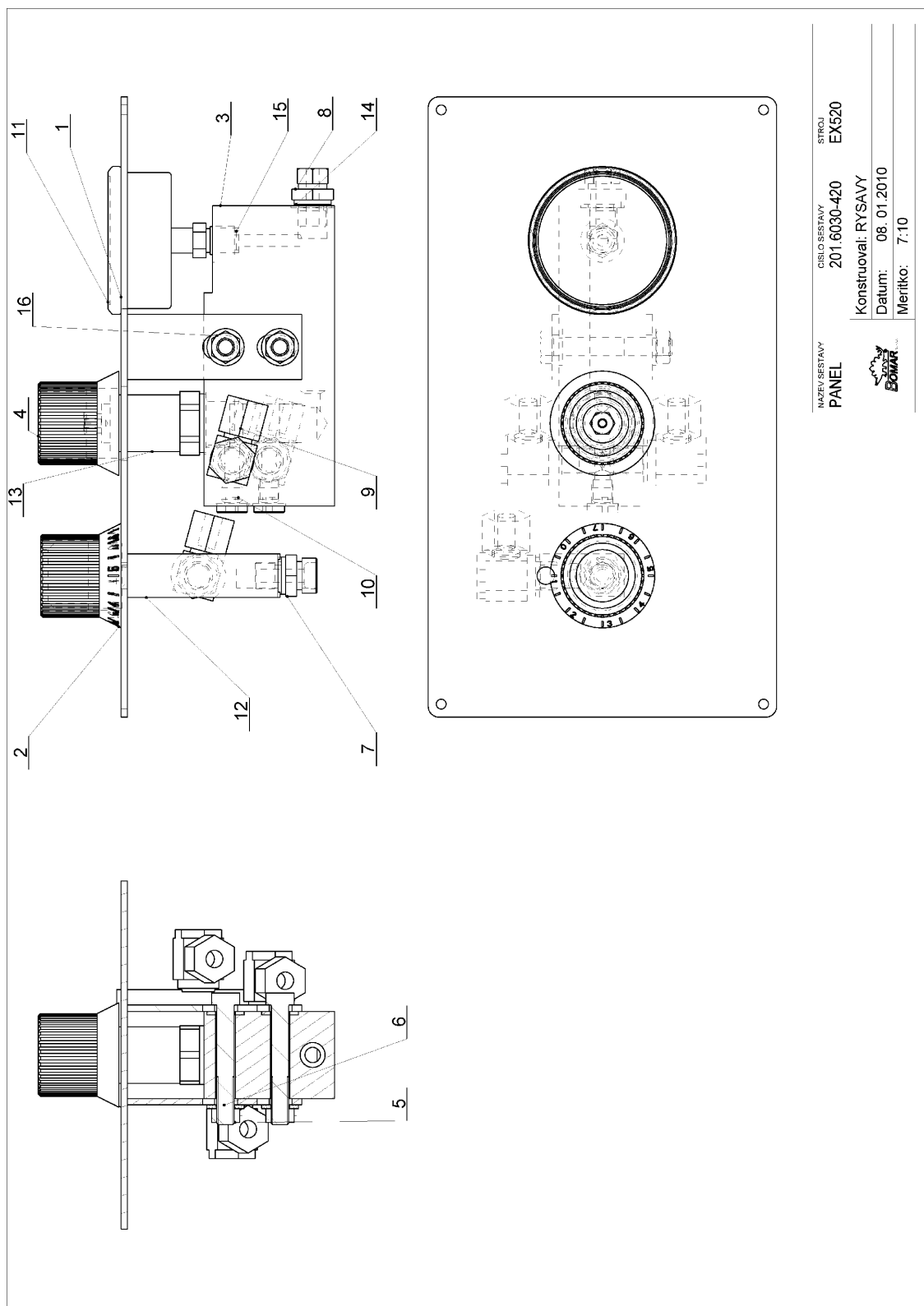


9.53. Kusovník / Stückliste / Piece list – Rozvaděč / Verteiler / Distributor

Číslo sestavy 201.D330-300		Ver. 0	Název sestavy ROZVADEC/DISTRIBUTOR/VERTEILER			
Poz.	Objednávací číslo	Ver.	Název položky	Rozměr	Ks	
1	201.6030-420	0	PANEL / PANEL / PANEL		1	
2	201.W330-557	0	OVLÁDACÍ PANEL / CONTROL PANEL / BEDIENPULT	SESTAVA	1	
3	30.6130-012	0	VIKO / COVER / DECKEL	P 0.5x30	2	
4	30.W330-101	0	ROZVADEC / DISTRIBUTOR / VERTEILER	KOMPLET	1	
5	31.6030-410	0	PANEL / PANEL / PANEL	FOLIE	1	
6	91.071.022	0	VÝVODKA HADICE / OUTLET FOR HOSE / SCHLAUCHTÜLLE		3	
7	91.072.016	0	MATICE ČERNA / BLACK NUT / MUTTER ROH		3	

Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

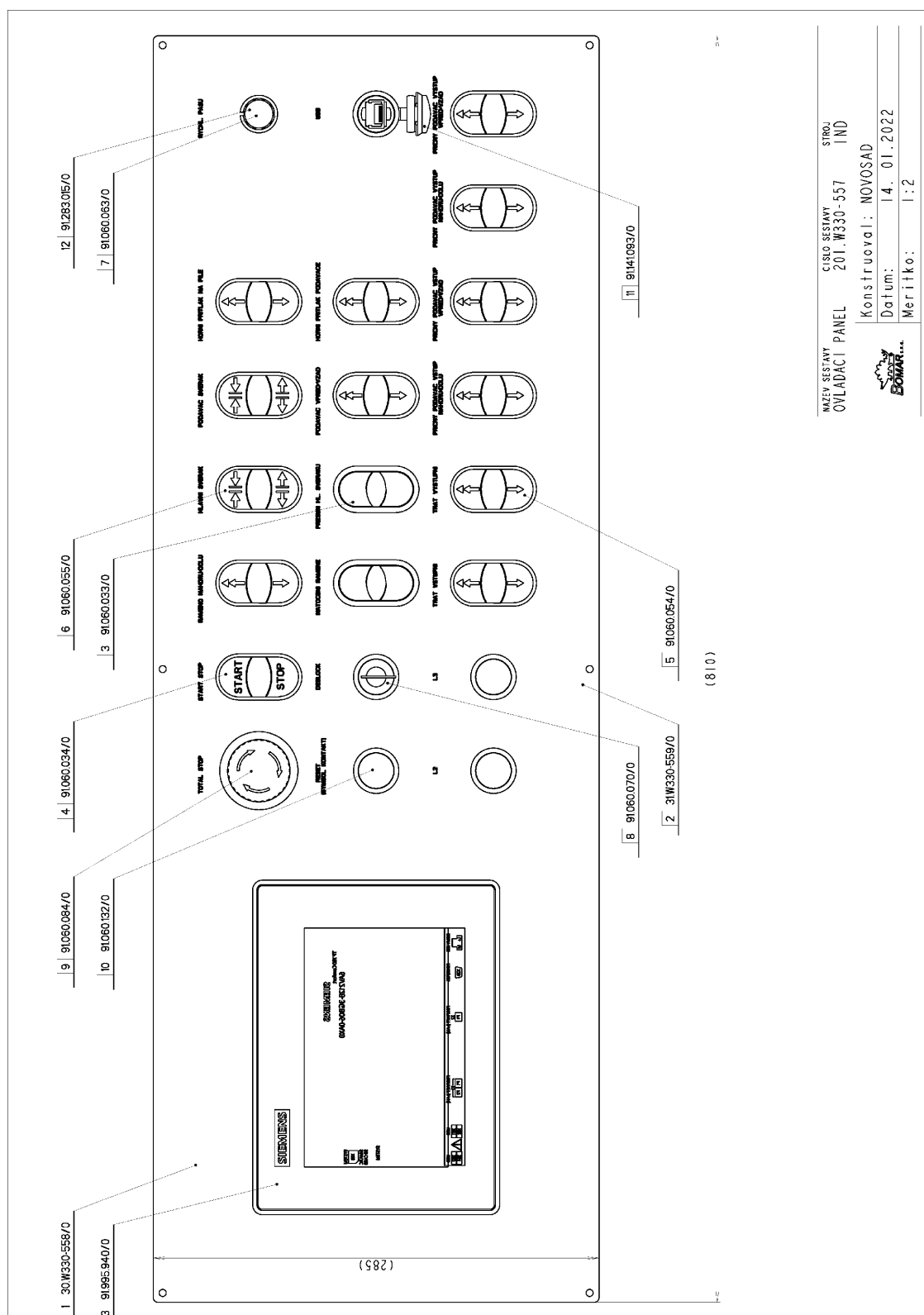
9.54. Panel / Panel / Panel



9.55. Kusovník / Stückliste / Piece list – Panel / Panel / Panel

Číslo Sestavy 201.6030-420		Ver. 0	Název sestavy PANEL/PANEL /PANEL		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.6030-411	0	PANEL / PANEL / PANEL		1
2	30.6130-021	0	HLAVICE / HEAD / KOPF	VYLISEK	1
3	30.6130-103	2	KOSTKA / CUBE / WÜRFEL	TYG 60x40	1
4	31.6130-008	0	HLAVICE / HEAD / KOPF		1
5	90.100.55.005	0	MATICE PRESNA ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	MATICE _M8	2
6	90.150.50.005	0	PODLOŽKA / WASHER / UNTERLEGSCHIBE	PODLOŽKA 8,4	4
7	92.002.103	0	SROUBENI PRIME KOMPL / null / null	G 1/4" tr12	1
8	92.002.107	0	SROUBENI PRIME KOMPL / null / null	G 1/4" 6	1
9	92.003.001	0	SROUBENI UHL.NATAC. KOVOVE / null / null	P-RSWS-08LR	3
10	92.019.003	0	ZATKA / PLUGBLIND PLUG / BLINDSTOPFEN	G1/4" VNITRNI IMBUS	2
11	92.060.002	0	MANOMETR / MANOMETER / MANOMETER	d 63 - 60bar	1
12	92.152.001	0	VENTIL SKRTICI / CHOKE VALVE / DROSSELVENTIL	VS01-04/R 2.5-O	1
13	92.154.001	0	VENTIL REDUKCNI / REDUCING VALVE / REDUKTIONSVENTIL		1
14	96.082.002	0	KROUZEK TESNICI / SEALING RING / DICHTUNGSRING	13/17x1.5 CU	5
15	96.082.005	0	KROUZEK TESNICI / SEALING RING / DICHTUNGSRING	5x8.8x1	2
16	DIN933_M8x55_ZN	0	SROUB 6HRANNY / HEX HEAD SCREW / SECHSKANTSCHRAUBE	SROUB M8x55	2

9.56. Ovladač pult / Bedienpult / Control panel

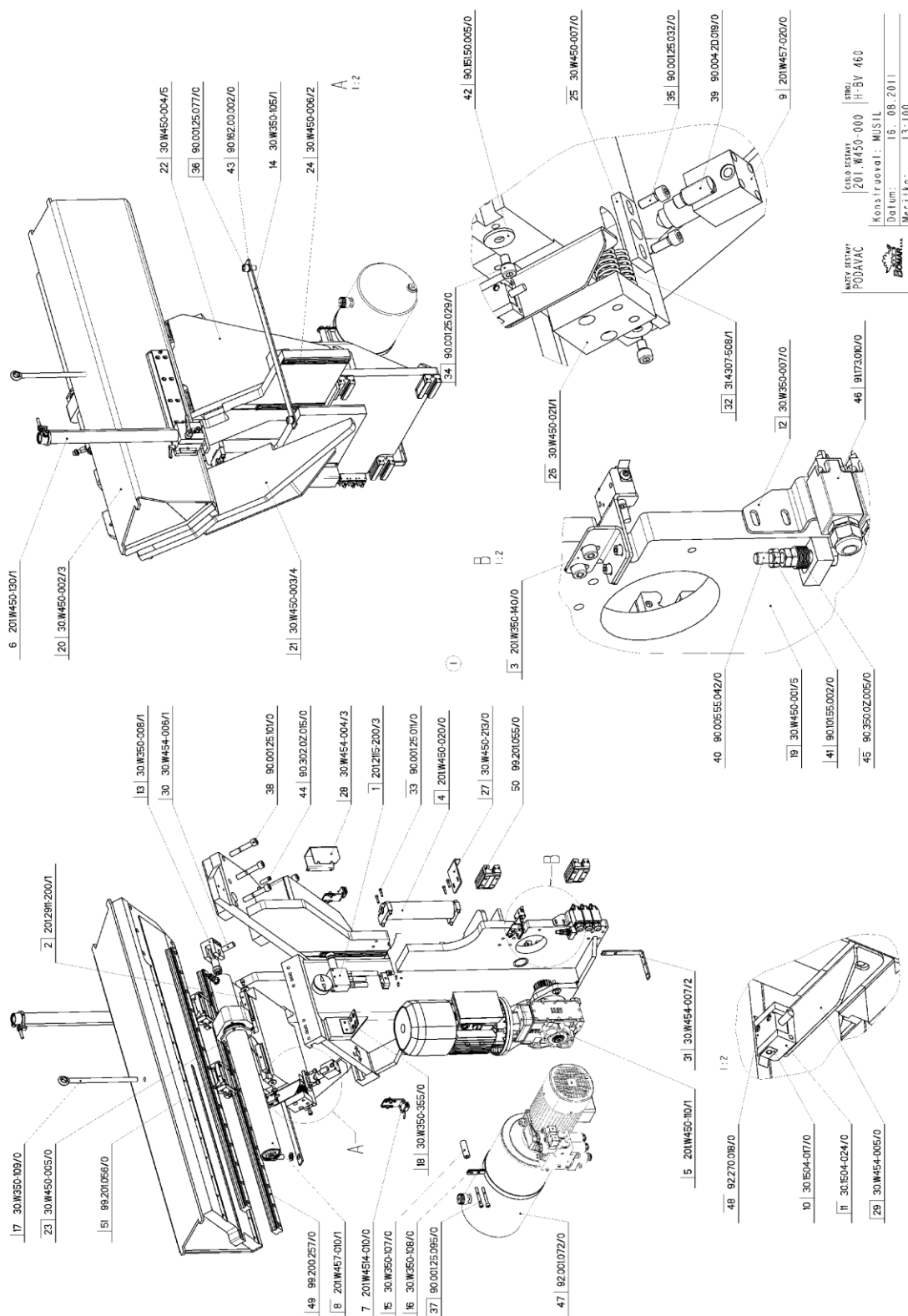


9.57. Kusovník / Stückliste / Piece list – Ovladačí pult / Bedienpult / Control panel

NAZEV SESTAVY		ČÍSLO SESTAVY		REVIZE			
OVLADACÍ PANEL		201.W330-557		0			
Poz.	Objednáací číslo	Verze	Název CZ	Name EN	Name DE	Polotovár	Ks.
1	30.W330-558	0	PLECH	SHEET METAL	BLECH	<Chybné parametry pro polotovár '40.00101.04' typu 'P'->	1
2	31.W330-559	0	SAMOLEPKA	STICKER	AUFKLEBER	Individual 360 460 DGA PRBMR02060	1
3	91.060.033	0	HLAVICE	HEAD	KOPF	bílá/černá Moeller M22-DDL-WS	2
4	91.060.034	0	HLAVICE	HEAD	KOPF	START/STOP Moeller M22-DDL-WS-GB1/GB0	1
5	91.060.054	0	HLAVICE	HEAD	KOPF	M22-DDL-WS-*-* b/černá šipka nahoru/dolu	10
6	91.060.055	0	HLAVICE	HEAD	KOPF	M22-DDL-W-S-* b/černá světlák zav-/otev	2
7	91.060.063	0	HLAVICE	HEAD	KOPF	S8877 BLK Hlavice potenciometru - 24mm	1
8	91.060.070	0	HLAVICE	HEAD	KOPF	M22-WRS ovládací hlavíklíč, 2poloh s aretací	1
9	91.060.084	0	HLAVICE TOTAL STOP	TOTAL STOP HEAD	TASTE TOTAL STOP	YWIB-V4E02R Total stop - hlavice + 3xNC	1
10	91.060.132	0	HLAVICE	HEAD	KOPF	M22-DL-B modré prosvět. Eaton, zapuštěná bez aretace	3
11	91.141.093	0	KONEKTOR	CONNECTOR	STECKVERBINDER	IE-FCM-USB-A,101864 konektor USB	1
12	91.283.015	0	POTENCIOMETR	POTENTIOMETER	POTENTIOMETER	TP 195 4K7/N 20A Potenciometr 5k	1
13	91.995.940	0	PANEL	PANEL	PANEL	6AV2128-3GB06-0AX0 SIMATIC HMI MTP700, Unified Comfort Panel, touch opo	

Číslo Sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Pozice/Position/Position, Objednávací číslo/Order number/Bestellnummer, Polotovár/Semiprodukt/Halbfabrikat, Vstupní materiál/Input material/Default material/Eingangsmaterial;

9.58. Podavač / Vorschub / Feeder

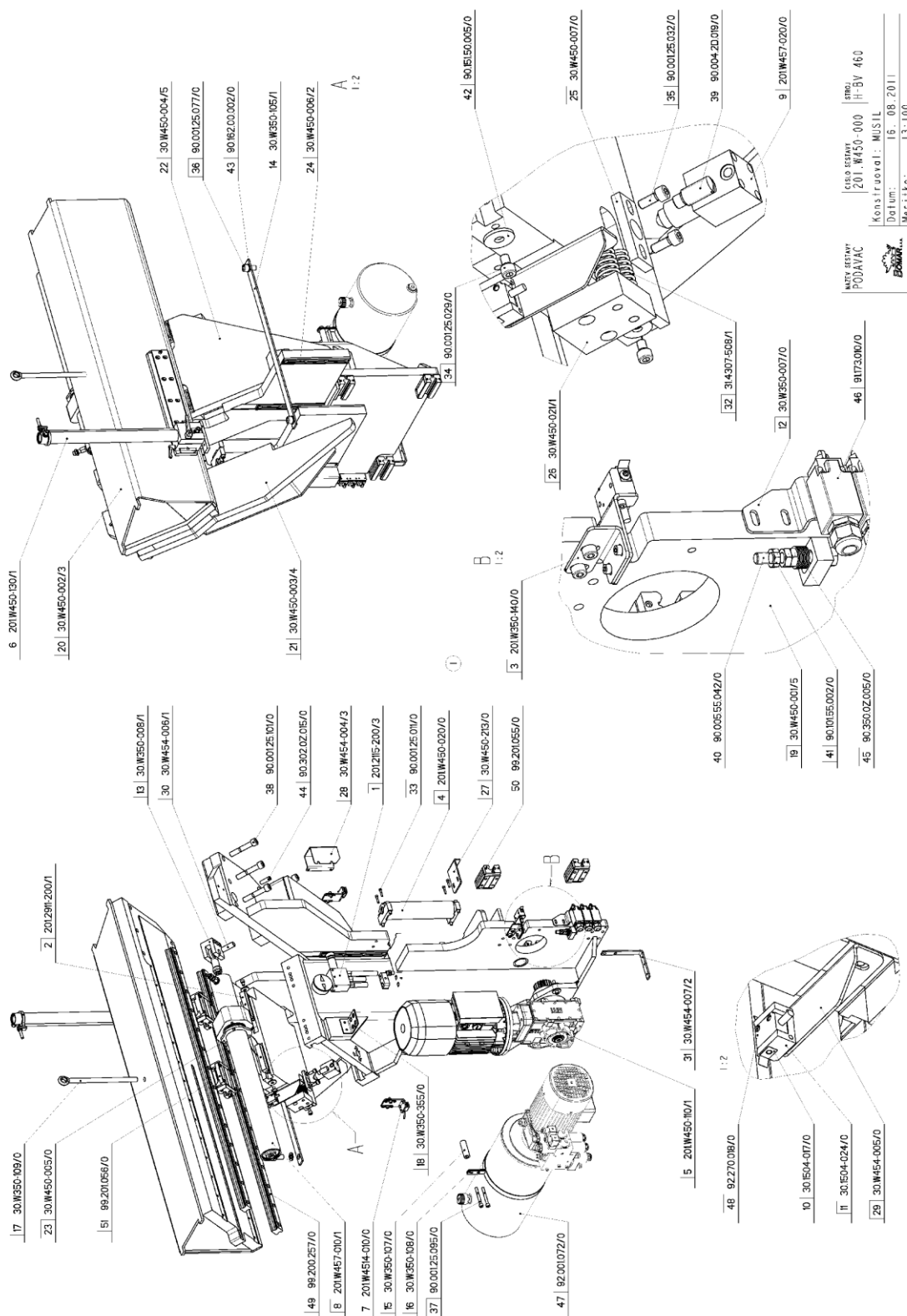


9.59. Kusovník / Stückliste / Piece list – Podavač / Vorschub / Feeder

NAZEV SESTAVY		ČÍSLO SESTAVY		REVIZE		REVIZE	
PODAVAC		201.W450-000		16			
Poz.	Objednáací číslo	Verze	Název CZ	Name EN	Name DE	Polotovár	Ks.
1	201.2115-200	3	REGULACE TL. SVERAKU	VICE PRESSURE REGULATION	SCHRAUBSTOCK-DRUCKREGELUNG		1
2	201.2311-200	1	ELEMENT VALECKOVY	ROLLER ELEMENT	ROLLELEMENT		4
3	201.W350-140	0	ODMEROVANI	MEASURING	GEHRUNGSMESSUNG		1
4	201.W450-020	0	VALECEK	ROLLER	ROLLE		1
5	201.W450-110	1	POHON	DRIVE	ANTRIEB		1
6	201.W450-130	1	UPINANI HORNÍ	TOP CLAMPING	SPANNVORRICHTUNG OBEN		1
7	201.W4514-010	0	ZAVORA OPTICKA	OPTICAL GATE	LICHTSCHRANKE		1
8	201.W451-010	1	VALEC UPINACÍ	FIXING CYLINDER	SPANNZYLINDER		1
9	201.W451-020	0	VALEC POMOCNÝ	AUXILIARY CYLINDER	HILFSZYLINDER		1
10	30.1504-017	0	STERAC	WIPER	ABSTREIFER	P03 - 11x22	2
11	30.1504-024	0	DRZAK	HOLDER	HALTER		1
12	30.W350-007	0	DRZAK	HOLDER	HALTER	<Chybné parametry pro polotovár '40.001.01.04' typu 'P'>	1
13	30.W350-008	1	DRZAK	HOLDER	HALTER	HR60x60 - 49	1
14	30.W350-105	1	TYC	POLE	STANGE	HR30x5 - 690	1
15	30.W350-107	0	DISTANC	SPACER	ABSTANDSTÜCK	TR20x5 - 62	1
16	30.W350-108	0	DRZAK	HOLDER	HALTER	<Chybné parametry pro polotovár '40.002.01.07' typu 'P'>	1
17	30.W350-109	0	DRZAK	HOLDER	HALTER		1
18	30.W350-355	0	DRZAK	HOLDER	HALTER	<Chybné parametry pro polotovár '40.001.01.04' typu 'P'>	1
19	30.W450-001	5	VOZÍK	CART	WAGEN		1
20	30.W450-002	3	NOSNIK	BEAM	TRÄGER		1
21	30.W450-003	4	ČELIST POHYBLIVÁ	MOVING JAW	BEWEGLICHE BACKE		1
22	30.W450-004	5	ČELIST PEVNÁ	FIXED JAW	FESTE BACKE		1
23	30.W450-005	0	PRÍLOŽKA	CLIP	CLIP	<Chybné parametry pro polotovár '40.001.01.31' typu 'P'>	1
24	30.W450-006	2	LISTA	SLAT	LEISTE	HR30x10 - 250	4
25	30.W450-007	0	DESKA	BOARD	PLATTE	HR30x10 - 71	1
26	30.W450-021	1	DORAZ	STOP PIECE	ANSCHLAG	HR60x40 - 75	1
27	30.W450-213	0	DORAZ	STOP PIECE	ANSCHLAG	<Chybné parametry pro polotovár '40.001.01.05' typu 'P'>	1
28	30.W454-004	3	KRYT	COVER	ABDECKUNG	P2 - 100x188	1
29	30.W454-005	0	DRZAK	HOLDER	HALTER	<Chybné parametry pro polotovár '40.001.01.04' typu 'P'>	1
30	30.W454-006	1	ČEP	PIVOT	BOLZEN	D17 - 48	1
31	30.W454-007	2	DRZAK	HOLDER	HALTER	<Chybné parametry pro polotovár '40.001.01.37' typu 'P'>	1
32	314.307-508	1	PRUŽINA	SPRING	FEDER	2.5x23x38x6.5	2
33	90.001.25.011	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	5x25 DIN 912 8.8 černý	4
34	90.001.25.029	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	8x12 DIN 912 8.8 černý	4
35	90.001.25.032	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	8x20 DIN 912 8.8 černý	2

Číslo Sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Position/Position/Position, Objednáací číslo/Order number/Bestellnummer, Polotovár/Semiprodukt/Halbfabrikat, Vstupní materiál/Startup material/Default material/Eingangsmaterial.

9.60. Podavač / Vorschub / Feeder



9.61. Kusovník / Stückliste / Piece list – Podavač / Vorschub / Feeder

Poz.	Objednávací číslo	Varze	Název CZ	Name EN	Name DE	Podávovar	Ks.
36	90.001.25.077	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	16x30 DIN 912 8,8 černěný	2
37	90.001.25.095	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	8x70 DIN 912 8,8 černěný	2
38	90.001.25.101	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	16x90 DIN 912 8,8 černěný	5
39	90.004.2D.019	0	SROUB STAVEČ	SET SCREW	STELLSCHRAUBE	16x40 DIN 915 černěný	1
40	90.005.55.042	0	SROUB 6HRANNÝ	HEX HEAD SCREW	SECHSKANTSCHRAUBE	10x70 DIN 933 8,8 Zn	1
41	90.101.55.002	0	MATICE PRŮŽKA ZN	PRECISION THIN NUT - ZN	PRÄZISE MUTTER NIEDRIGE - ZN	10 DIN 439 Zn	3
42	90.151.50.005	0	PODLOŽKA VELKOPL.	LARGE WASHER	GROßFLÄCHENSCHIBE	9x28x3 M8 DIN 440 Zn	4
43	90.162.00.002	0	PODLOŽKA	WASHER	UNTERLEGSCHEIBE	16x28x3 DIN 1440 Zn	2
44	90.302.02.015	0	KOLÍK KUZELOVÝ-ZAVIT	TAPER PIN + THREAD	KEGELBOLENZEN + GEWINDE	12x40 DIN 1978	2
45	90.350.02.005	0	PRŮŽINA TALIROVA	DISC SPRING	TELLERFEDER	20x10,2x1 DIN 2093	8
46	91.173.010	0	SPINAC KONČS KLADK	END SWITCH WITH PULLEY	ENDSCHALTER MIT ROLLE	D4N-LA32 /// lze nahradit 91.173.044 pro dopravníky -1xN0/1xN0	závodně 1
47	92.001.072	0	AGREGAT HYDRAULICKÝ	HYDRAULIC PUMP	HYDRAULIKAGREGAT	284.86700 - 400V * pro podavace ind 360, 460 DGA	1
48	92.270.018	0	SNIMAC MAGNET.	MAGNETIC SENSOR	MAGNETSENSOR	LMIX2-076-08.0-1-00-L Lineární inkrementální snímač - pravoúhlý, 10-30VDC	2
49	99.201.257	0	VEDENÍ LINEARNÍ	LINEAR GUIDE	LINEARE FÜHRUNG	MSA35R-1080 20/20 N	2
50	99.201.055	0	VOZÍK LINEARNÍHO VEDENÍ	LINEAR GUIDE CART	LINEARFÜHRUNGSWAGEN	MSA30SSSFN	4
51	99.201.056	0	VOZÍK LINEARNÍHO VEDENÍ	LINEAR GUIDE CART	LINEARFÜHRUNGSWAGEN	MSA35ESSFN	4

1. ZRUS.LIN.VEDENI(HIWIN) 99.200.190 A NAHR. 99.200.257(PMI), ZRUS.VOZIK LIN.VEDENI (HIWIN) 99.201.011 A NAHR. 99.201.056(PMI), ZRUS.VOZIK LIN.VEDENI(HIWIN) 99.201.019

A NAHR. 99.201.055(PMI), 056/ZM146 3. 5.2012 SLEZACKOVA

2. PRID.4xPODLOZKA VELKOPLOSHA 90.151.50.005 A 4xSROUB M8x12 90.001.25.029. 169/ZM220 12.7.2012 SLEZACKOVA

3. PRIDAN DORAZ 30.W450-213. 192/ZM259 1.10.2012 SLEZACKOVA

4. PRIDANA TTC 30.W350-105.2xPODLOZKA 16 (90.162.00.002). 2xSROUB M16x30 (90.001.25.077). 290/ZM357 13.12.2012 SLEZACKOVA

5. ZRUS.ELGO SNIMAC 91.270.011 A NAHR. 92.270.018. 140/ZM178 25.6.2013

6. ZRUS.SNIMAC 92.270.018 A NAHR. 91.270.011, PRID.1xDRZAK 30.W350-108. 1xDISTANC 30.W350-107. 2xSROUB M8x25 (90.001.25.095), 4xSROUB M5x25 (90.001.25.011).

140.064/ZM131 13.6.2014 SLEZACKOVA

7. ZRUSEN SENZOR 91.270.011 A NAHR. 92.270.018. 054/ZM035 4.3.2015 SLEZACKOVA

8. ZRUS.SNIMAC BALUFF91.400.003.91.400.004 A NAHR.SNIMACEM SCHWACHTLLEUZE 91.400.059.91.400.060.91.400.061. ZRUS.DRZAK 30.W354-001 A NAHR.30.W354-006.

198/ZM224 12.10.2015 SLEZACKOVA

9. ZRUS.DRZAK 30.W350-006 A NAHR.30.W350-107+ZMENA POLOHY SNIMACE ELGO. 12/ZM015 25.1.2016 HLADIL

10. PRIDAN DRZAK HADIC 30.W350-355. ZM038 3.2.2017 HLADIL

11. ZRUS.SOUCASTI 92.270.018 (1ks). 30.W350-013(1ks). 30.W350-024(1ks). 30.W350-017(2ks) A NAHR.SESTAVOU 201.W350-140. 092/ZM113 23.7.2017 HLADIL

12. ZRUS.SNIMAC 91.400.059.91.400.061 A NAHR.SESTAVOU 91.400.075.058/ZM271 3.9.2018 SLEZACKOVA

13. ZRUS.SNIMAC 91.400.075. DRZAK30.W354-006 A NAHR.OPTICKOU ZAVOROU 201.W4514-010. 249/ZM350 23.8.2019 BENDA

14. ZRUSEN POHON 201.W450-010 A NAHR.201.W450-110. 6.11.2019 BENDA

15. PRIDAN DRZAK HADIC 30.W350-109. 093/ZM185 16.4.2020 SLEZACKOVA

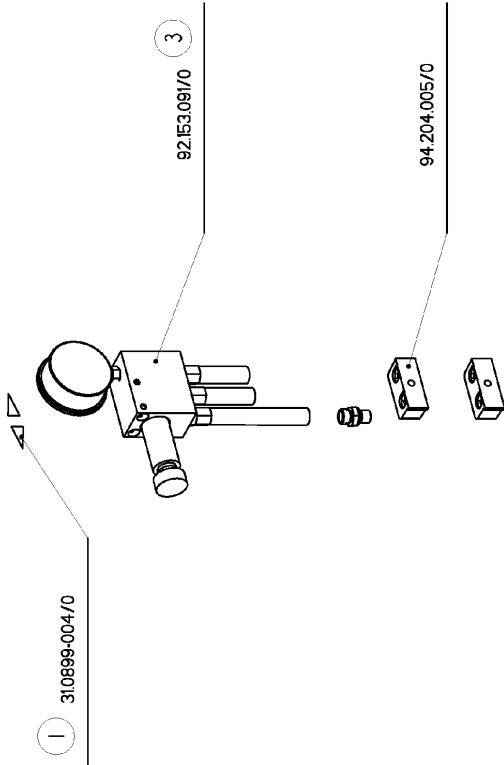
16. ZRUS.DRZAK30.8910-005. 211/ZM272 28.7.2020 SLEZACKOVA

Číslo sestavy/Number of assembly/Nummer der Baugruppe. Ver.-Verze/Version/Version. Název sestavy/Assembly name/Name der Baugruppe. Poz.-Pozice/Position/Position. Objednávací číslo/Order number/Bestellnummer. Podávovar/Semiprodukt/Halbfabrikat. Vstupní materiál/Input mat./Default material/Eingangsmaterial.

9.62. Regulace tl. svěráku / Schraubstock druckregelung / Vice pressure regulation

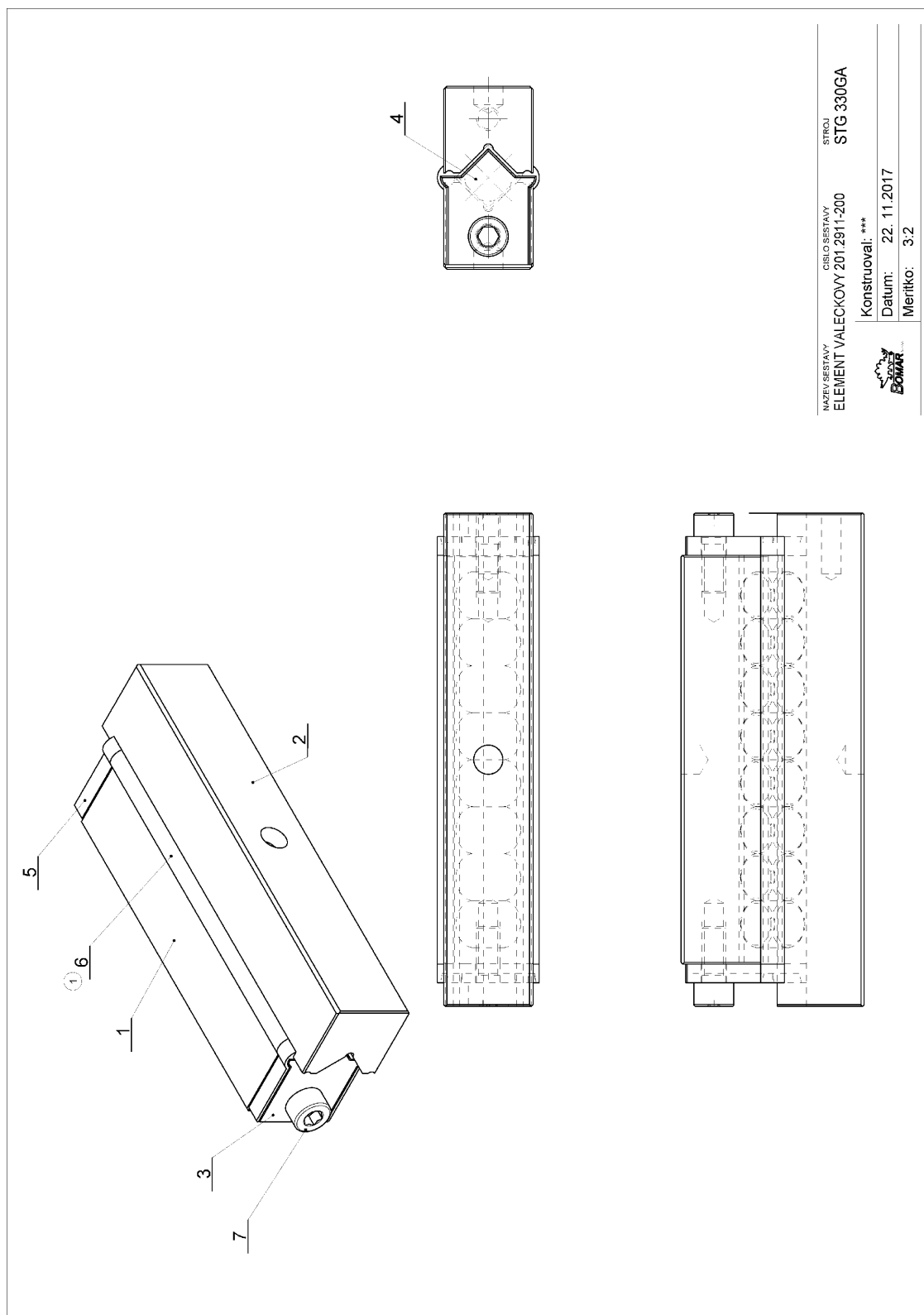
NÁZEV SESTAVY REGULACE TL. SVĚRAKU		ČÍSLO SESTAVY 201.2115-200	REVIZE 3	Kategorie: 230-44.05A- Datum: 17.08.2022 Konstruktér:				
pos. číslo výkresu 1 31.0899-004. (1) 0 2 92.153.091 (3) 0 3 94.204.005 0		verze množství 0 2 1 1 2 2	název SAMOLEPKA BLOK DRŽÁK	předmět zelená šipka malá 25 X 12 mm S203_007_2-02 * regulace tl. svěráku x řada (4 řady) LB5 314/714-PP 1/4 trubka dvojitá	jakost ZELENA PLAST	pov. úpr. 0.0 2.4 0.1	váha 0.0 2.4 0.1	poznámka
INDEX ZMĚNA		DATUM		PODPIS				

1. PRID. 2xSAMOLEPKA ŠIPKA 31.0899.004. 101/ZM131 29.5.2009 SLEZACKOVA
2. ZRUS. TESNĚNÍ 96.082.002. 290/ZM470 17.12.2018 SZABARI
3. ZM. SOUC. 30.2115-101, 30.1816-102, 30.2116-008, 92.080.001, 92.002.001, 92.154.001 NA BLOK 92.153.091 301/ZM346
14.12.2022 GAGO



Číslo sestavy/Number of assembly/Nummer der Baugruppe, Verze (Ver./Version/Versión, Název sestavy/Assembly name/Name der Baugruppe, Datum/Date/Datum, Konstruktor/Designer/Konstrukteur, Číslo výkresu/Drawing number, Zeichnung nummer, Název/Name, Předmět/Semiproduct/Halbfabrikat, Vstupní materiál/Input material/Default material/Eingangsmaterial, Jakost/Norm/Norm, Pov. úpr./Surface finish/Oberflächenpflege, Váha/Weight/Gewicht, Poznámka/Note/Notiz

9.63. Element válečkový / Roller element / Rollenelement



9.64. Kusovník / Stückliste / Piece list – Element válečkový / Roller element / Rollenelement

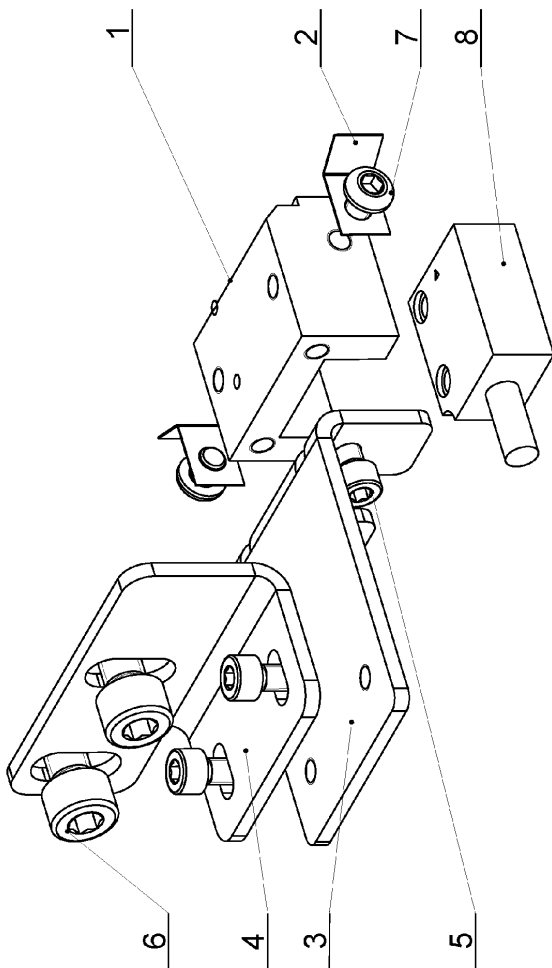
Číslo sestavy 201.2911-200		Ver. 1	Název sestavy ELEMENT VALEČKOVÝ/ROLLER ELEMENT/ROLLENELEMENT	
Poz.	Objednací číslo	Ver.	Název položky	Ks
1	30.2911-201	1	LISTA / SLAT / LEISTE	1
2	30.2911-202	1	LISTA / SLAT / LEISTE	1
3	30.2911-206	0	PRÍLOŽKA / CLIP / CLIP	2
4	30.4311-203	0	VALEČEK / ROLLER / ROLLE	8
5	31.2911-204	0	STERAC / WIPER / ABSTREIFER	2
6	89.2911-205	1	PRACHOVKA / DUST COVER / STAUBSCHUTZ	2
7	90.001.25.008	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	2

1.ZM.CISLOVANI 31.2911-205 NA 89.2911-205; 129/ZM233 4.7.2018 SCERBA

Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.65. Odměrování / Measuring / Gehrungsmessung

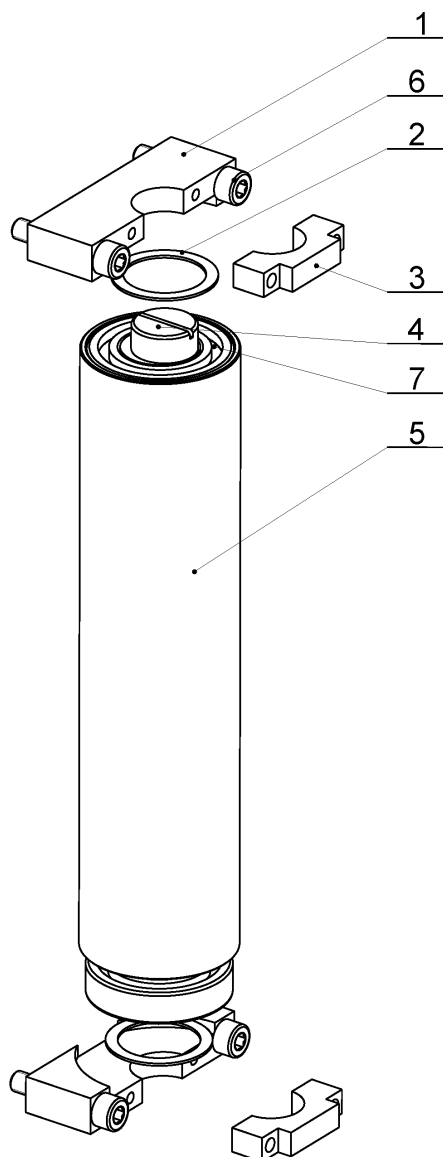
Císlo Sestavy 201.W350-140		Ver. 0	Nazev sestavy ODMEROVANI/MEASURING/GEHRUNGSMESSUNG		
Poz.	Objednací číslo	Ver.	Nazev položky	Rozměr	Ks
1	1504-024_ELGO_DRZAK	0	DRZAK / HOLDER / HALTER	HR 40x20	1
2	30.1504-017	0	STERAC / WIPER / ABSTREIFER	P 0,3x11	2
3	30.TL311-241	0	DRZAK / HOLDER / HALTER	P 3x48	1
4	30.W650-141	0	DRZAK / HOLDER / HALTER	P3x58	1
5	90.001.25.007	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M5X10	4
6	90.001.25.029	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M8X12	2
7	90.013.27.002	0	SROUB PULKULATY / BUTTON HEAD SCREW / RUNDKOPFSCHRAUBE	M5X6	2
8	92.270.018	0	SNIMAC MAGNET / MAGNETIC SENSOR / MAGNETSENSOR	ELGO	1



Císlo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver./Version/Version; Nazev sestavy/Assembly title/Name der Baugruppe; Pozice (Poz./Position/Position;
Objednací číslo/Purchase order number/Bestellnummer. Nazev položky/Volume title/Name der Position - Rozměr/Stock size/Auflassung

Císlo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.66. Váleček / Rolle / Cylinder



NAZEV SESTAVY VALECEK	CISLO SESTAVY 201.W450-020	STROJ H-BV460
	Konstruoval: MUSIL	
	Datum: 16. 09.2010	
	Meritko: 1:2	

9.67. Kusovník / Stückliste / Piece list – Váleček / Rolle / Cylinder

Číslo Sestavy 201.W450-020		Ver. 0	Název sestavy VALECEK/ROLLER/ROLLE		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.W350-021	0	DESKA / BOARD / PLATTE	HR 30x15	2
2	30.W350-022	0	PODLOŽKA / WASHER / UNTERLEGSCHEIBE	P 1x40	2
3	30.W350-025	0	DESKA / BOARD / PLATTE	HR 20x10	2
4	30.W450-023	0	HRDEL / SHAFT / WELLE	D30	1
5	30.W450-024	0	VALEC / CYLINDER / ZYLINDER	TR 60x6	1
6	90.001.25.036	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M8x40	4
7	95.001.008	0	LOŽISKO / BEARING / LAGER	6006 2RS	2

Číslo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer. Název položky/Volume title/Name der Position. Rozměr/Stock size/Abmessung

Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung



9.69. Kusovník / Stückliste / Piece list –
Pohon / Drive / Antrieb

Číslo Sestavy 201.W450-110		Ver. 0	Název sestavy POHON/DRIVE /ANTRIEB		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.1514-503	0	PODLOŽKA / WASHER / UNTERLEGSCHLEIBE	P 4x30	2
2	30.2908-001	2	PODLOŽKA / WASHER / UNTERLEGSCHLEIBE	P6	2
3	30.W350-014	0	KOLO OZUBENÉ / COG WHEEL / ZAHNRAD		1
4	30.W450-015	0	ČEP / PIVOT / BOLZEN	d 50	1
5	30.W450-111	0	PRIRUBA / FLANGE / FLANSCH	d 120	1
6	30.W450-112	0	PRIRUBA / FLANGE / FLANSCH		1
7	30.W450-113	0	HRDEL / SHAFT / WELLE	d 35	1
8	30.W450-116	0	PODLOŽKA / WASHER / UNTERLEGSCHLEIBE	P 3x35	1
9	90.001.25.037	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M8x45	1
10	90.001.25.038	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M8x50	4
11	90.011.27.005	0	SROUB ZAPUSTNÝ / COUNTERSUNK SCREW / SENKSCHRAUBE	SROUB M6x12	2
12	90.151.50.005	0	PODLOŽKA VELKOPL. / LARGE WASHER / GROßFLÄCHENSCHLEIBE	PODLOŽKA 8	1
13	91.001.394	0	ELEKTROMOTOR / ELECTRIC MOTOR / ELEKTROMOTOR	BN 90S 4	1
14	95.001.019	0	LOŽISKO / BEARING / LAGER	6206 2RS	2
15	95.700.006	0	POUZDRO / SLEEVE / BÜCHSE	40x40	1
16	95.801.010	0	KROUZEK POJIST.VNITR. / INTERNAL RETAINING RING / SICHERUNGSRING INNEN	POJISTNÝ KROUZEK 62	1
17	95.810.007	0	PERO TESNÉ / FEATHER KEY / PASSFEDER	PERO 8x7x25	3
18	99.003.039	0	PREVODOVKA KUZELOCEL / RIGHT ANGLE GEARBOX / KEGELRADGETRIEBE	i=20,24	1

1.ZR.ELEKTROMOTOR 91.001.384 A NAHR.91.001.394. 133.ZM.173 7.4.2020 KOSYK

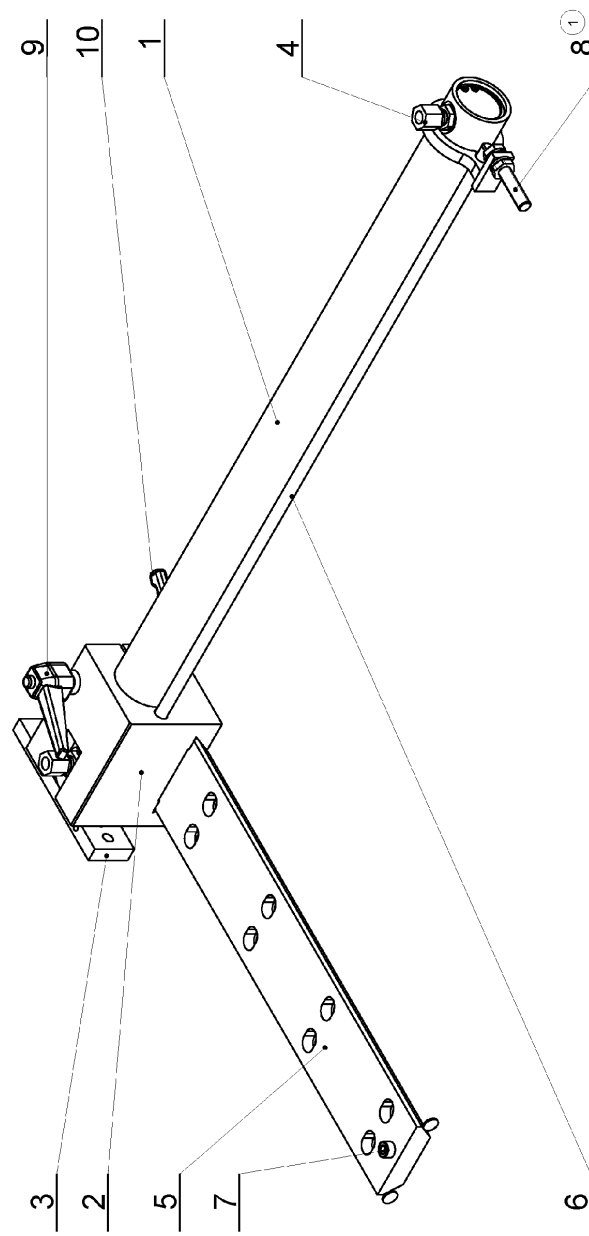
Číslo Sestavy/Number of assembly/Nummer der Baugruppe: Verze (Ver./Version/Version; Name der Baugruppe; Pozice (Poz./Position/Position; Objednací číslo/Purchase order number/Bestellnummer: Název položky/Volume title/Name der Position: Rozměr/Stock size/Abmessung

Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

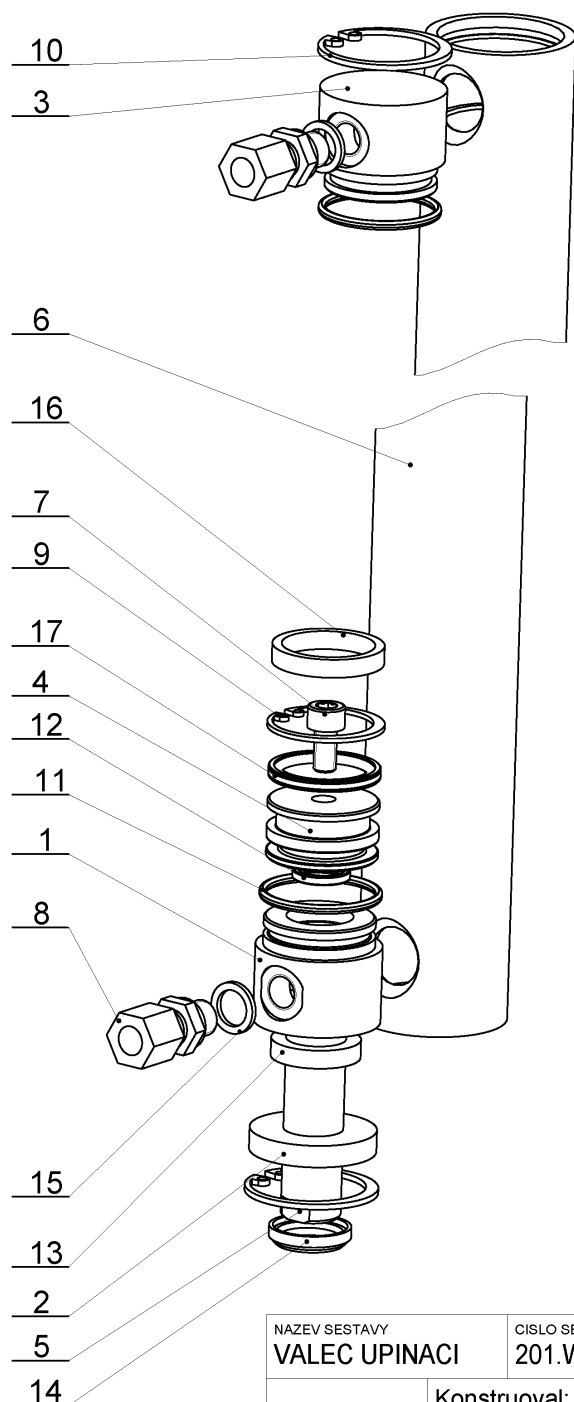
9.70. Upínání horní / Spannvorrichtung Oben / Top clamp

Číslo sestavy 201.W450-130		Ver. 0	Název sestavy UPÍNÁNÍ HORNÍ/TOP CLAMPING/SPANNVORRICHTUNG OBEN			
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks	
1	201.W407-020	0	VALEC UPÍNACÍ / FIXING CYLINDER / SPANNZYLINDER		1	
2	30.W350-132	0	KLUZÁK / GLIDER / GLEITER	HR 70x70	1	
3	30.W350-133	0	DESKA / BOARD / PLATTE	HR 30x10	1	
4	30.W350-136	0	DRŽÁK / HOLDER / HALTER		1	
5	30.W450-131	0	LISTA / SLAT / LEISTE	HR 60x15	1	
6	30.W450-134	0	TYC VODICÍ / LEAD POLE / FÜHRUNGSTANGE	D 8	1	
7	90.001.25.015	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M6x10	2	
8	91.172.008	1	SPÍNACÍ INDUKTIVNÍ / INDUCTIVE SWITCH / INDUKTIVER SCHALTER	JPS30D081.SPNOFC	1	
9	94.008.006	0	PAKA MONTÁŽNÍ / ASSEMBLY LEVER / MONTAGEHEBEL	M10	1	
10	94.008.015	0	PAKA MONTÁŽNÍ / ASSEMBLY LEVER / MONTAGEHEBEL		1	

1.ZRUS 91.172.009 NAHR. 91.172.033; 068/ZM109 15.3.2019 SCERBA



9.71. Válec upínací / Spannzyylinder / Fixing cylinder



NAZEV SESTAVY	CISLO SESTAVY	STROJ
VALEC UPINACI	201.W407-020	IN460
Konstruoval: MUSIL		
Datum: 17. 08.2011		
Meritko: 7:10		



9.72. Kusovník / Stückliste / Piece list – Válec upínací / Spannzyylinder / Fixing cylinder

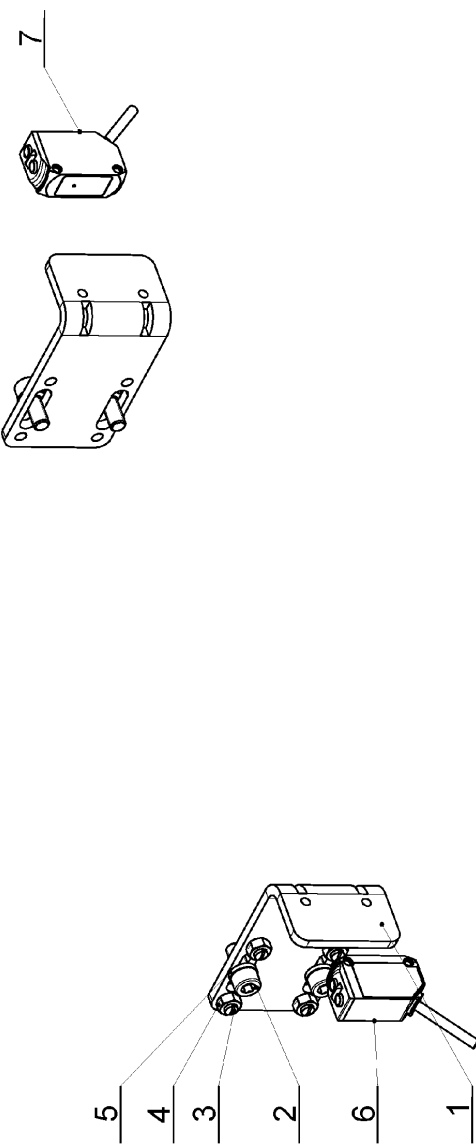
Číslo Sestavy 201.W407-020		Ver. 0	Název sestavy VALEC UPINACI/FIXING CYLINDER/SPANNZYINDER		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.6807-103	2	VIKO / COVER / DECKEL	TYC 35	1
2	30.6807-104	1	VIKO / COVER / DECKEL	TYC 35	1
3	30.6807-105	1	VIKO / COVER / DECKEL	TYC 35	1
4	30.6807-106	0	PIST / PISTON / KOLBEN	TYC 32	1
5	30.W607-022	0	PISTNICE / PISTON ROD / KOLBENSTANGE	d 16 f8	1
6	30.W407-021	0	VALEC UPINACI / FIXING CYLINDER / SPANNZYINDER	TR 40/30	1
7	90.001.25.016	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M6X12	1
8	92.002.102	0	SROUBENI PRIME KOMPL / null / null	S-GEV-8LLR	2
9	95.801.002	0	KROUZEK POJIST.VNITR / INTERNAL RETAINING RING / SICHERUNGSRING INNEN	POJISTNÝ KROUZEK 30	1
10	95.801.026	0	KROUZEK POJIST.VNITR / INTERNAL RETAINING RING / SICHERUNGSRING INNEN	POJISTNÝ KROUZEK 34	2
11	96.001.008	0	O-KROUZEK STATICKY / O-RING STATIC / O-RING STATISCH	26x2 NBR 70SH	2
12	96.002.006	0	O-KROUZEK DYNAMICKY / O-RING DYNAMIC / O-RING DYNAMISCH	12x2 NBR 70SH	1
13	96.041.001	0	MANŽETA / CUFF / MANSCHETTE	d16	1
14	96.060.001	0	KROUZEK STIRACI / WIPER RING / ABSTREIFRING		1
15	96.082.001	0	KROUZEK TESNICI / SEALING RING / DICHTRINGSRING	10/14x1.5 CU	2
16	96.084.005	0	KROUZEK VODICI / GUIDE RING / FUHRUNGSRING	GP6500300-T47	1
17	96.900.007	0	TESNENI KOMBINOVA NE / COMBINED SEALING / KOMBIDICHTUNG	PW4100300-Z20	1

Číslo Sestavy/Number of assembly/Nummer der Baugruppe: Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer: Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

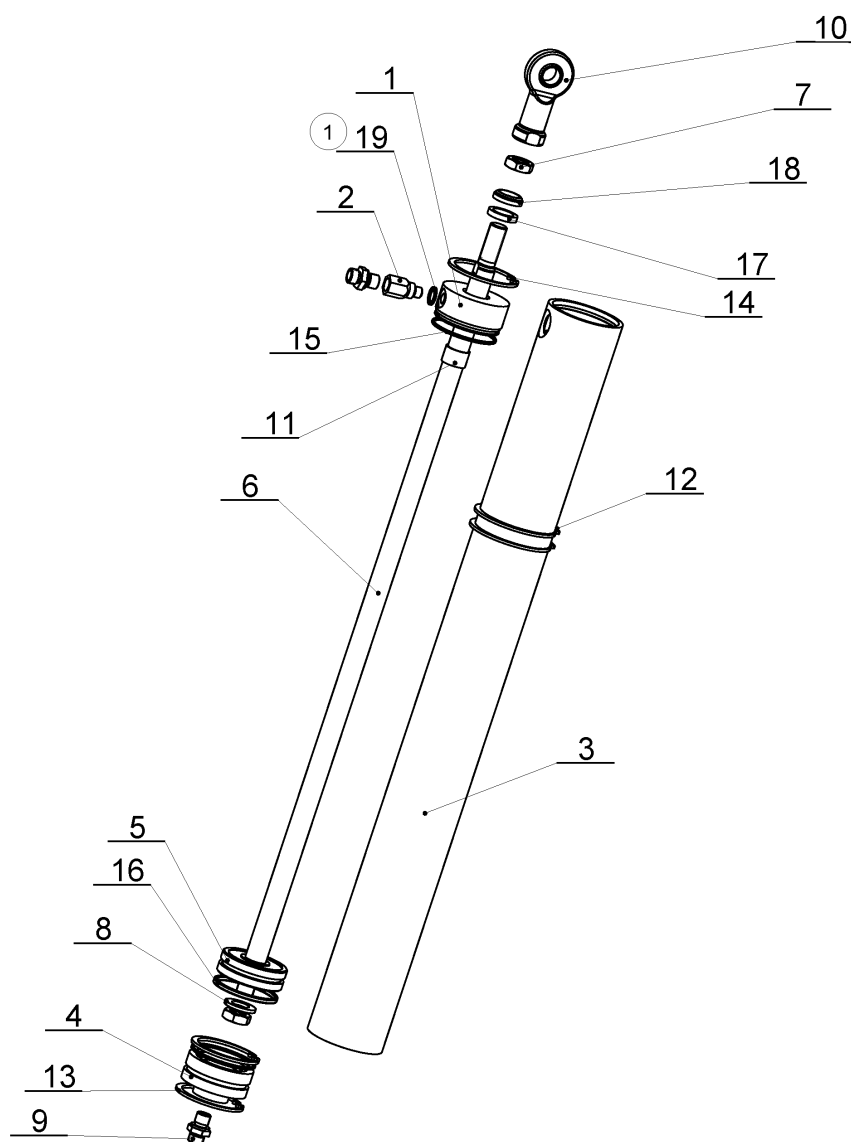
9.73. Závora optická / Lichtschränke / Optical gate

Císlo Sestavy 201.W4514-010		Ver. 0	Název sestavy ZAVORA OPTICKA/OPTICAL GATE/LICHTSCHRANKE	
Poz.	Objednací číslo	Ver.	Název položky	Ks
1	30.W4514-011	0	PLECH / SHEET METAL / BLECH	2
2	90.001.25.092	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	4
3	90.002.2D.005	0	SROUB STAVEČI / SET SCREW / STELLSCHRAUBE	4
4	90.100.55.003	0	MATICE PRESNA ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	4
5	90.163.00.012	0	PODLOŽKA / WASHER / UNTERLEGSCHEIBE	4
6	91.401.030	0	ZAVORA OPTICKA / OPTICAL GATE / LICHTSCHRANKE	1
7	91.401.031	0	ZAVORA OPTICKA / OPTICAL GATE / LICHTSCHRANKE	1



Císlo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz./Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.74. Válec upínací / Spannzyylinder / Fixing cylinder



NAZEV SESTAVY VALEC UPINACI	CISLO SESTAVY 201.W457-010	STROJ H-BV
	Konstruoval: MUSIL	
	Datum: 17. 08.2011	
	Meritko: 1:5	

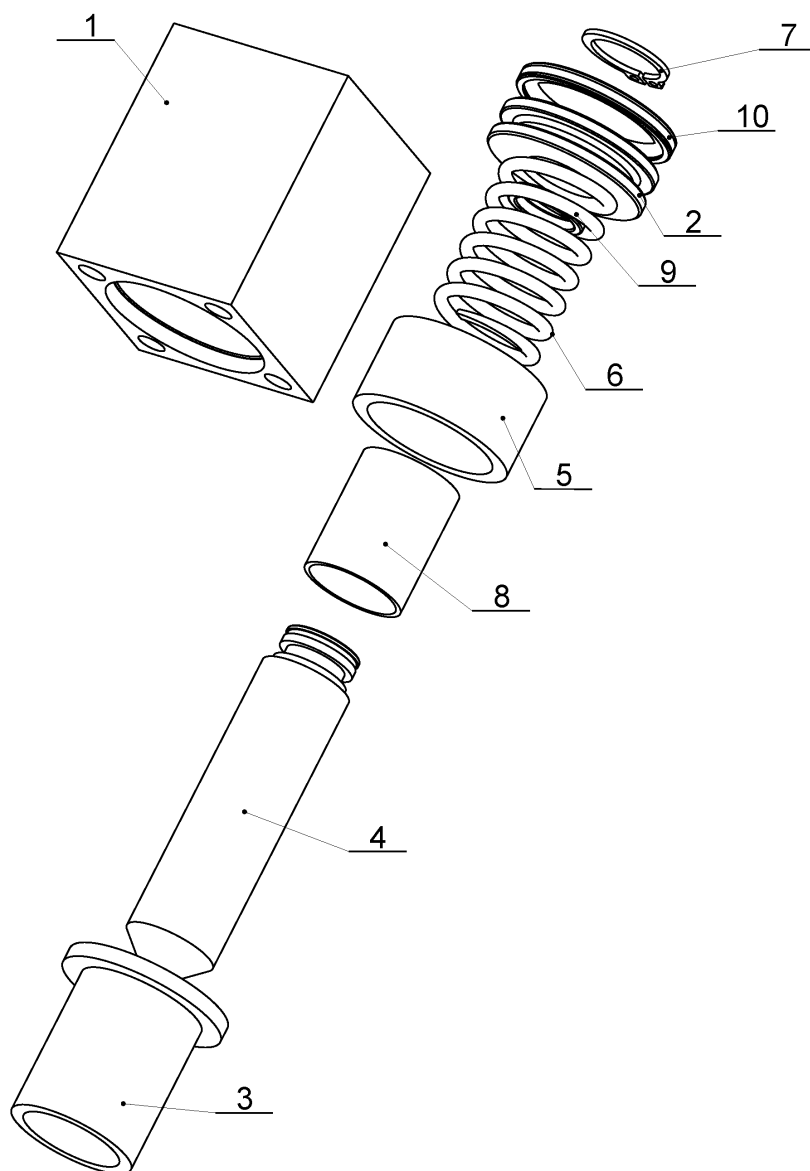
9.75. Kusovník / Stückliste / Piece list –
Válec upínací / Spannzyylinder / Fixing cylinder

Číslo Sestavy 201.W457-010		Ver. 0	Název sestavy VALEC UPINACI/FIXING CYLINDER/SPANNZYLINDER		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.1807-001	0	VIKO / COVER / DECKEL	D 70	1
2	30.3407-103	1	REDUKCE / REDUCTION / ADAPTOR / REDUKTION	TYG 17	1
3	30.W457-011	0	VALEC / CYLINDER / ZYLINDER	TRUBKA 73/63	1
4	30.W457-012	0	VIKO / COVER / DECKEL	d 65	1
5	30.W457-014	0	PIST / PISTON / KOLBEN	D 65	1
6	30.W457-015	0	PISTNICE / PISTON ROD / KOLBENSTANGE	TYG 20	1
7	90.101.55.003	0	MATICE PR.NIZKA ZN / PRECISION THIN NUT - ZN / PRÄZISE MUTTER NIEDRIGE - ZN	MATICE M16	2
8	90.150.50.009	0	PODLOZKA / WASHER / UNTERLEGSCHIEBE	PODLOZKA 17	1
9	92.002.001	0	SROUBENI PRIME / TUBE FITTING - STRAIGHT / GERADE VERSCHRAUBUNG	GES 08LR	2
10	95.170.003	0	HLAVICE / HEAD / KOPF	INA GIR17-UK	1
11	95.700.003	0	POUZDRO / SLEEVE / BÜCHSE	20X15	1
12	95.800.026	0	KROUZEK POJIST.VNEJS / EXTERNAL RETAINING RING / SICHERUNGSRING AUBEN	POJISTNY KROUZEK 72	2
13	95.801.011	0	KROUZEK POJIST.VNITR / INTERNAL RETAINING RING / SICHERUNGSRING INNEN	POJISTNY KROUZEK 63	2
14	95.801.012	0	KROUZEK POJIST.VNITR / INTERNAL RETAINING RING / SICHERUNGSRING INNEN	POJISTNY KROUZEK 65	1
15	96.001.015	0	O-KROUZEK STATICKY / O-RING STATIC / O-RING STATISCH	56X3.55	2
16	96.002.020	0	O-KROUZEK DYNAMICKY / O-RING DYNAMIC / O-RING DYNAMISCH	56x3.5 NBR 70SH	1
17	96.041.002	0	MANŽETA / CUFF / MANSCHETTE	601-20x28x5	1
18	96.060.002	0	KROUZEK STIRACI / WIPER RING / ABSTREIFRING	20x28	1
19	96.062.002	1	KROUZEK TESNICI / SEALING RING / DICHTUNGSRING	13/17x1.5 CU	1

1.ZRUS. 1xTESNENI 96.062.002. 290/ZM003 8.1.2019 SZABARI

1.ZRUS. 1xTESNENI 96.082.002. 290/ZM003 8.1.2019 SZABARI

9.76. Válec pomocný / Hylfszylinder / Aux. cylinder

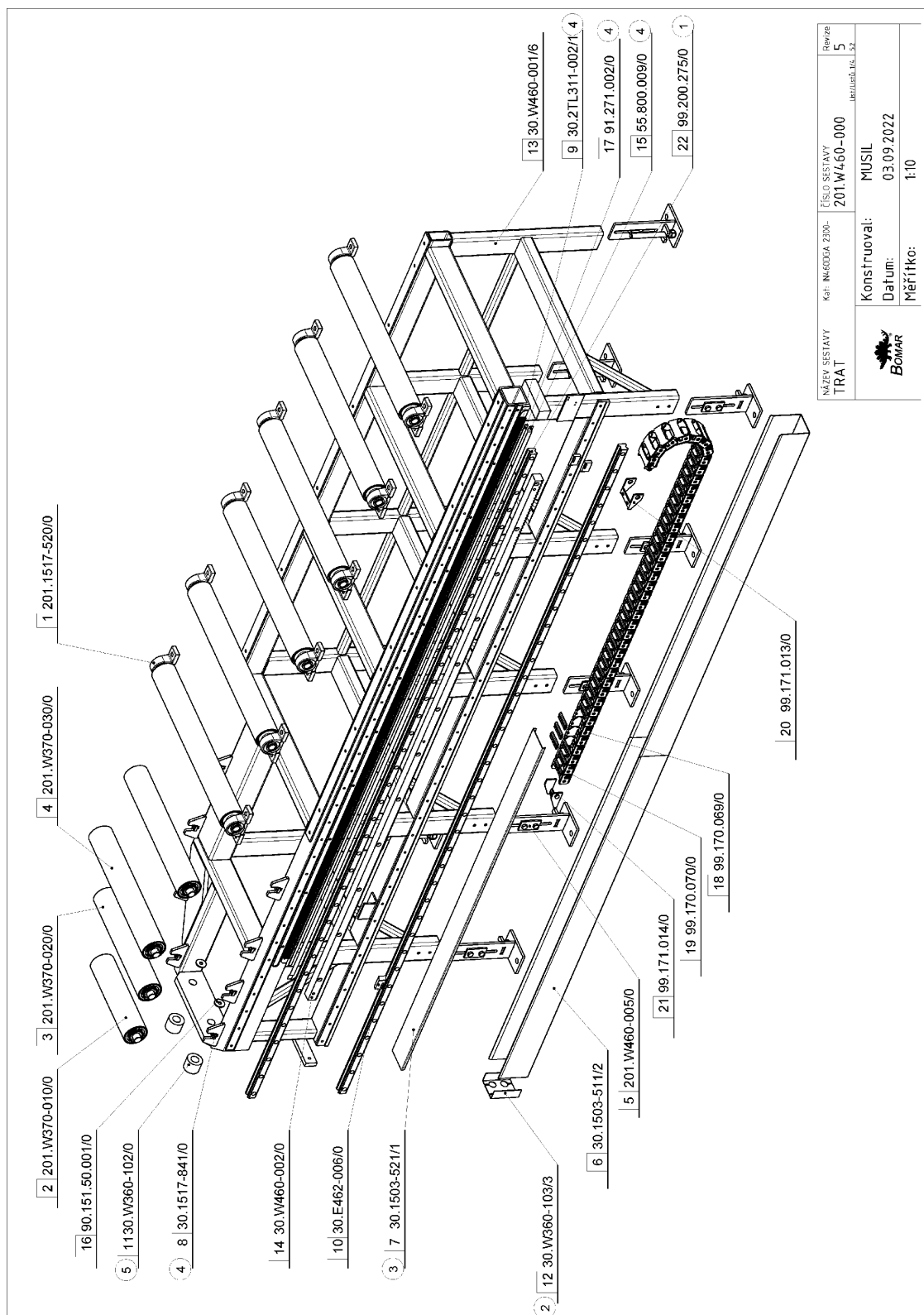


NAZEV SESTAVY	CISLO SESTAVY	STROJ
VALEC POMOCNY	201.W457-020	H-BV
	Konstruoval: &konstruoval	
	Datum: 17. 09.2010	
	Meritko: 1:1	

9.77. Kusovník / Stückliste / Piece list –
Válec pomocný / Hilfszylinder / Aux. cylinder

Číslo sestavy 201.W457-020		Ver. 0	Název sestavy VALEC POMOCNY/AUXILIARY CYLINDER/HILFSZYLINDER	
Poz.	Objednací číslo	Ver.	Název položky	Ks
1	30.4307-501	1	KOSTKA / CUBE / WÜRFEL	HR 40x40 1
2	30.4307-503	1	PIST / PISTON / KOLBEN	TYC 35 1
3	30.4307-504	3	ZATKA / PLUGBLIND PLUG / BLINDSTOPFEN	D 35 1
4	30.4307-506	0	PISTNICE / PISTON ROD / KOLBENSTANGE	d 18 1
5	30.4307-507	0	KROUZEK / RING / RING	TR 32 x 3 1
6	31.4307-508	0	PRUZINA / SPRING / FEDER	2.5x23x38x6 5 1
7	95.800.006	0	KROUZEK POJIST.VNEJŠÍ / EXTERNAL RETAINING RING / SICHERUNGSRING AUBEN	POJISTNY KROUZEK 15 1
8	95.700.019	0	POUZDRO / SLEEVE / BÜCHSE	18X25 1
9	96.002.006	0	O-KROUZEK DYNAMICKÝ / O-RING DYNAMIC / O-RING DYNAMISCH	12x2 NBR 70SH 1
10	96.900.004	0	TESNENÍ KOMBINOVANÉ / COMBINED SEALING / KOMBIDICHTUNG	PWXX 1

9.78. Trať / Bahn / Track



9.79. Kusovník / Stückliste / Piece list – Trať / Bahn / Track

NAZEV SESTAVY		ČÍSLO SESTAVY		REVIZE			
TRAT		201.W460-000		5			
Poz.	Objednáací číslo	Verze	Název CZ	Name EN	Name DE	Polotovary	Ks.
1	201.1517-520	0	VALEC	CYLINDER	ZYLINDER		6
2	201.W370-010	0	VALECEK	ROLLER	ROLLE		1
3	201.W370-020	0	VALECEK	ROLLER	ROLLE		1
4	201.W370-030	0	VALECEK	ROLLER	ROLLE		2
5	201.W460-005	0	NOHA	LEG	STÄNDER		10
6	30.1503-511	2	KORYTO	CHANNEL	RINNE	P4.5 – 297x1500	2
7	30.1503-521	1	VÍKRO	COVER	DECKEL	<Chybné parametry pro polotovary '40.002.01.05' typu 'P's>	1
8	30.1517-841	0	MATICE	NUT	MUTTER	<Chybné parametry pro polotovary '40.001.01.31' typu 'P's>	8
9	30.2TL311-002	1	PROFIL	PROFILE	PROFIL		1
10	30.E462-006	0	DORAZ	STOP PIECE	ANSCHLAG	HR25x10 – 50	3
11	30.W360-102	0	DISTANC	SPACER	ABSTANDSSTÜCK	TR51x12.5 – 40	2
12	30.W360-103	3	VÍKRO	COVER	DECKEL	<Chybné parametry pro polotovary '40.001.01.02' typu 'P's>	1
13	30.W460-001	6	TRAT	TRACK	BAHN		1
14	30.W460-002	0	HREBEN	COMB	KAMM	HR30x30 – 2420	1
15	55.800.009	0	PLANZETA	null	null	0.3x15 Nerez podkládání strojů	1
16	90.15150.001	0	PODLOZKA VELKOPL.	LARGE WASHER	GROßFLÄCHENSCHIBE	11x34x3 M10 DIN 440 Zn	2
17	91.2171.002	0	PASKA MAGNETICKA	MAGNETIC TAPE	MAGNETBAND	ELGO MB20-50-10-1-R-C Magnetická páska od 8_2019 bez ocelové křídly (91.17	
18	99.170.069	0	RETEZ ENERGII	CABEL DRAG CHAIN	ENERGIEKETTE	MR-0300050609500; přep.99.170.070 R-U-díl MP 3002.5 R 095 22ks #41m	
19	99.170.070	0	*	null	null	MR-030000905600 111 22ks = 1m R-rámová přepážka DE 3002.5 111/4kde	
20	99.171.013	0	KONCOVKA VNEJŠÍ	OUTSIDE END	ÄUßERES ENDSTÜCK	MR-030000007600 6x56 KA/Z3002.5	1
21	99.171.014	0	KONCOVKA VNITŘNÍ	INSIDE END	INNERES ENDSTÜCK	MR-030000007600 26x56 KA/Z3002.5	1
22	99.200.275	0	VEDENÍ LINEARNÍ	LINEAR GUIDE	LINEARE FÜHRUNG	MSA30R-3000 20/20-N	2

1. ZRUS.LINEARNÍ VEDENÍ(HIWIN) 99.200.062 A NAHR. 99.200.275(PMI). 056/ZM146 3.5.2012 SLEZACKOVA
2. PRIDANO VIKO 30.W360-103. 239/ZM304 29.10.2012 SLEZACKOVA
3. ZRUS.VIKO 30.1503-515 A NAHR. 30.1503-521. 125/ZM159 2.5.2013 SLEZACKOVA
4. PRIDAN PROFIL 30.2TL311-002, ELGO PASKA 91.271.002, KRYCÍ PLECH 55.800.009 A MATICE 30.1517-841 (6ks);
27.3.2017 092/zm.113 HLADIL
5. PRID. 2x DISTANC. KROUZ. 30.W360-102. 247/ZM280 5.10.2022 CHAJDA

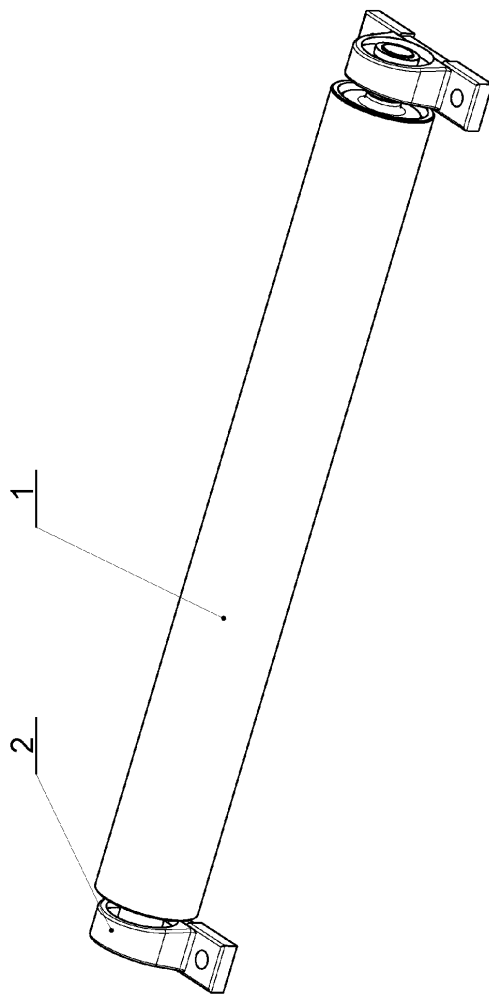
Číslo Sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Pozice/Position/Position, Objednáč. číslo/Order number/Bestellnummer, Polotovary/Semi-products/Halbfabrikat: Vstupní materiál/Input material/Default material/Eingangsmaterial;

9.80. Válec / Zylinder / Roller

Císlo Sestavy 201.1517-520		Ver. 0	Název sestavy VALEC/CYLINDER/ZYLINDER		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.1517-502	0	VALEC / CYLINDER / ZYLINDER		1
2	95.160.001	0	LOŽISKO / BEARING / LAGER	UCP 205	2

1

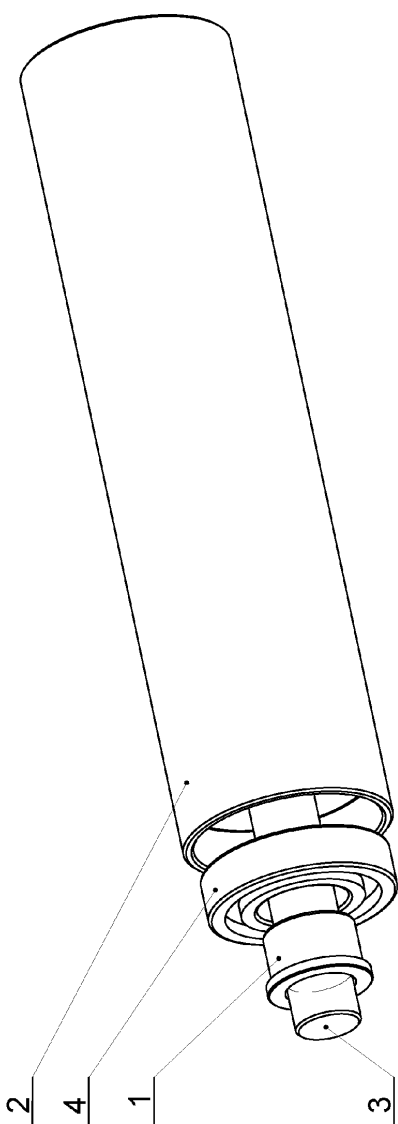
2



Císlo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;

9.81. Váleček / Rolle / Cylinder

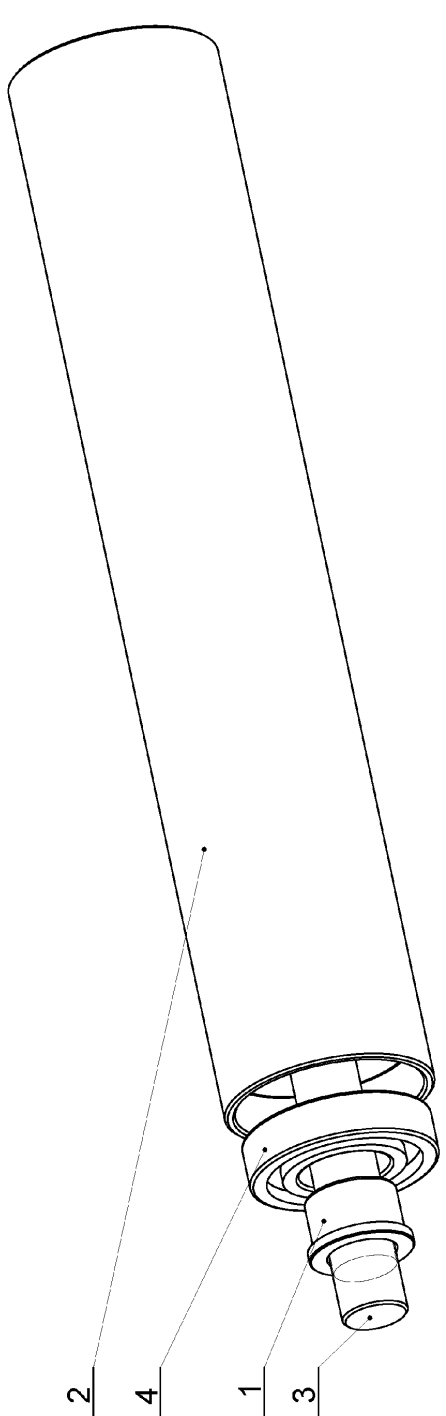
Číslo Sestavy 201.W370-010		Ver. 0	Název sestavy VALECEK/ROLLER/ROLLE		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.1501-004	0	POUZDRO / SLEEVE / BÜCHSE	d 40	2
2	30.W370-011	0	TRUBKA / TUBE / ROHR	Tr 80x5	1
3	30.W370-012	0	ČEP / PIVOT / BOLZEN	d 25	1
4	95.001.020	0	LOŽISKO / BEARING / LAGER	6207 2RS	2



The technical drawing illustrates a roller assembly. It consists of a long, thin cylindrical tube (labeled 2) that is mounted on a flange (labeled 4). The flange is supported by two bearings (labeled 4) which are mounted on a central pivot (labeled 3). A dimension line (labeled 1) indicates the length of the tube. The drawing is a perspective view showing the assembly from the side.

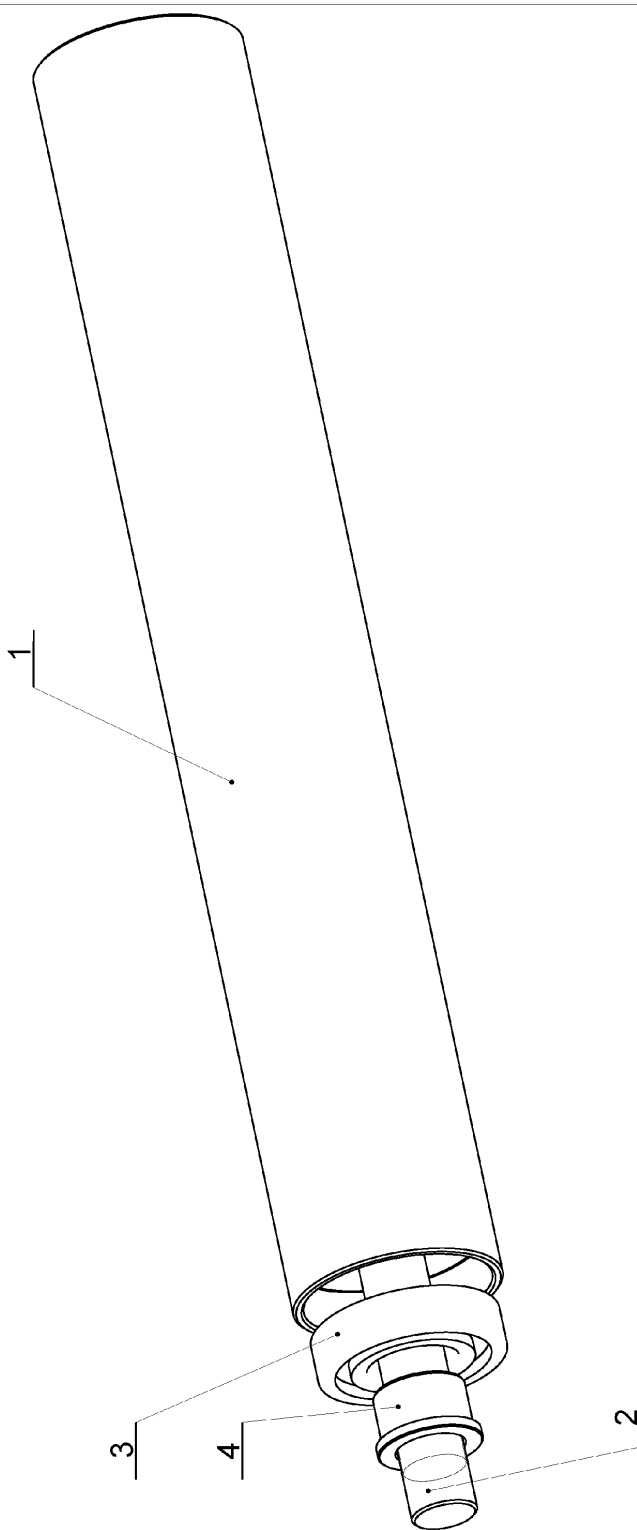
9.82. Váleček / Rolle / Cylinder

Číslo sestavy 201.W370-020		Ver. 0	Název sestavy VALEČEK/ROLLER/ROLLE			
Poz.	Objednávací číslo	Ver.	Název položky		Rozměr	Ks
1	30.1501-004	0	POUZDRO / SLEEVE / BÜCHSE		d 40	2
2	30.W370-021	0	TRUBKA / TUBE / ROHR		Tr 80x5	1
3	30.W370-022	0	ČEP / PIVOT / BOLZEN		d 25	1
4	95.001.020	0	LOŽISKO / BEARING / LAGER		6207 2RS	2



9.83. Váleček / Rolle / Cylinder

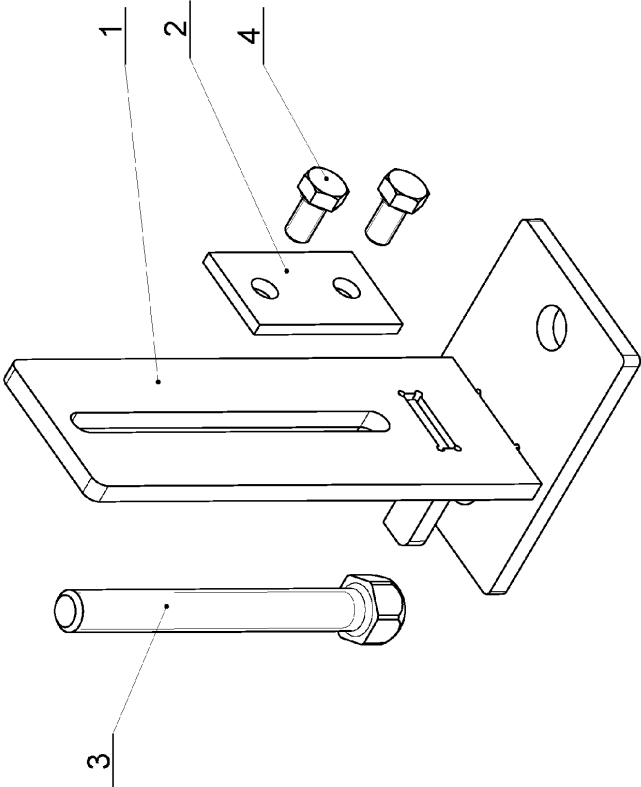
Číslo Sestavy 201.W370-030		Ver. 0	Název sestavy VALECEK/ROLLER/ROLLE		
Poz.	Objednáci číslo	Ver.	Název položky	Rozměr	Ks
1	30.W370-031	0	TRUBKA / TUBE / ROHR	Tl 80x5	1
2	30.W370-032	0	ČEP / PIVOT / BOLZEN	d 25	1
3	95.001.020	0	LOŽISKO / BEARING / LAGER	6207 2RS	2
4	30.1501-004	0	POUZDRO / SLEEVE / BÜCHSE	d 40	2



Číslo sestavy/Number of assembly/Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.84. Noha / Leg / Ständer

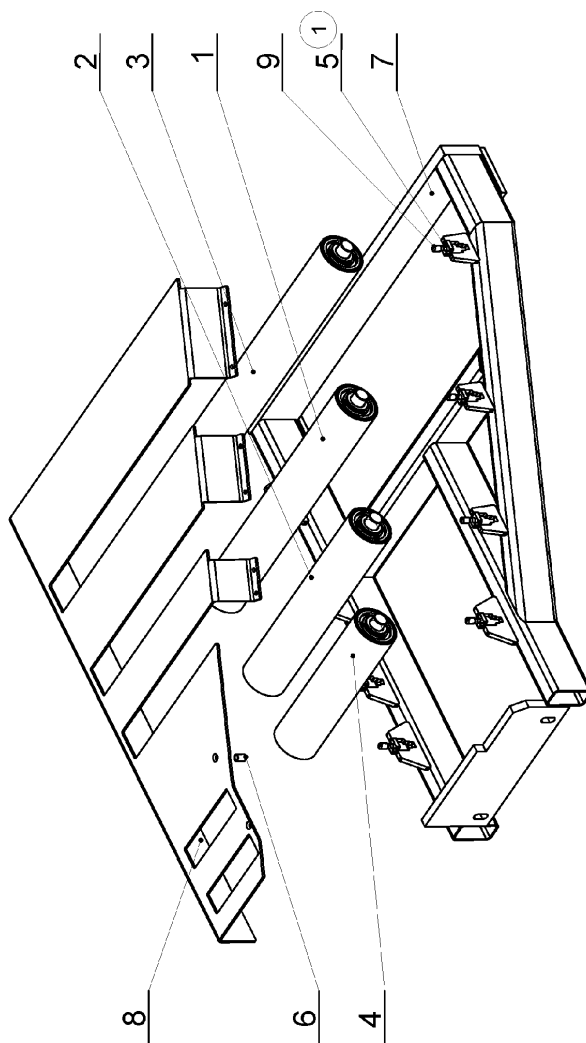
Číslo Sestavy 201.W460-005		Ver. 0	Název sestavy NOHA/LEG/STÄNDER			
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks	
1	30.1515-690	3	NOHA / LEG / STÄNDER		1	
2	30.1515-681	0	PRÍLOŽKA / CLIP / CLIP	P 5x40	1	
3	31.1514-102	0	SROUB STÁVEČI / SET SCREW / STELLSCHRAUBE	M 16	1	
4	90.005.55.023	0	SROUB 6HRANNÝ / HEX HEAD SCREW / SECHSKANTSCHRAUBE	SROUB M10X20	2	



Číslo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.85. Díl propojovací / Connecting part / Verbindungsteil

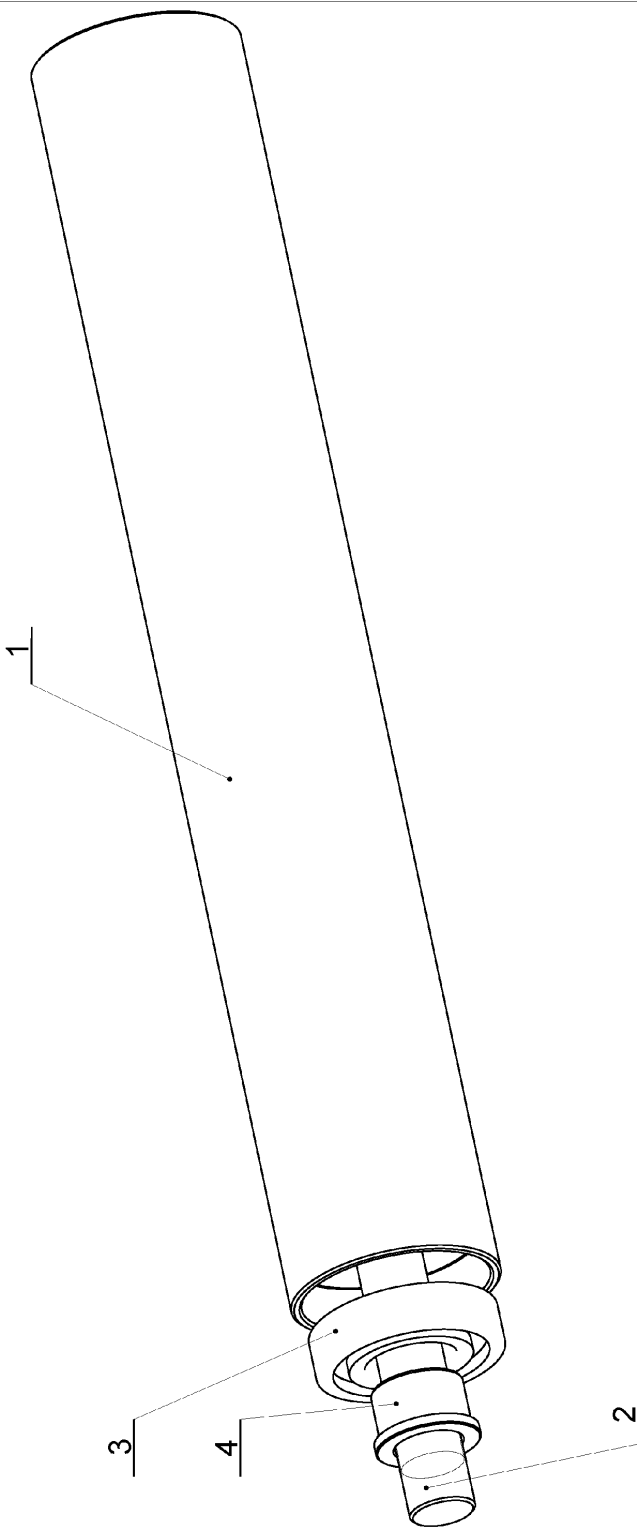
Číslo sestavy 201.W480-100		Ver. 0	Název sestavy DÍL PROPOJOVACÍ/CONNECTING PART/VERBINDUNGSTEIL	
Poz.	Objednávací číslo	Ver.	Název položky	Ks
1	201.W370-030	0	VALEČEK / ROLLER / ROLLE	1
2	201.W370-040	0	VALEČEK / ROLLER / ROLLE	1
3	201.W480-010	0	VALEČEK / ROLLER / ROLLE	1
4	201.W480-020	0	VALEČEK / ROLLER / ROLLE	1
5	30.1517-841 (1)	0	MATICE / NUT / MUTTER	8
6	30.W380-008	0	DISTANC / SPACER / ABSTANDSTÜCK	1
7	30.W480-101	0	TRAT / TRACK / BAHN	1
8	30.W480-102	0	KRYT / COVER / ABDECKUNG	1
9	90.002.2D.014	0	SROUB STAVEČÍ / SET SCREW / STELLSCHRAUBE	1
1.PRIDAN 8xMATICE 30.1517-841. 329/ZM451 2.12.2021 SLEZACKOVA				8



Číslo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.86. Váleček / Rolle / Cylinder

Číslo Sestavy 201.W370-030		Ver. 0	Název sestavy VALEČEK/ROLLER/ROLLE			
Poz.	Objednací číslo	Ver.	Název položky		Rozměr	Ks
1	30.W370-031	0	TRUBKA / TUBE / ROHR		Tl 80x5	1
2	30.W370-032	0	ČEP / PIVOT / BOLZEN		d 25	1
3	95.001.020	0	LOŽISKO / BEARING / LAGER		6207 ZRS	2
4	30.1501-004	0	POUZDRO / SLEEVE / BÜCHSE		d 40	2

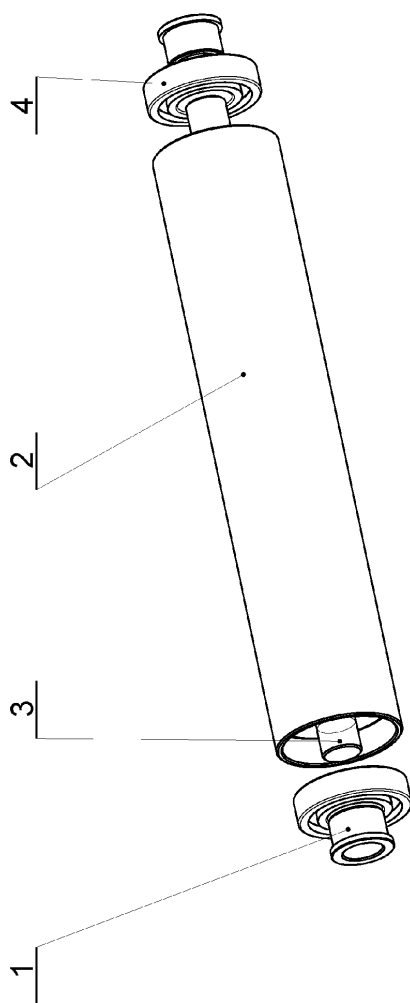


Technical drawing of a roller assembly. The drawing shows a long cylindrical tube (1) with a flange at one end. The flange has a central shaft (2) with a bearing (3) and a pivot (4). The entire assembly is housed in a sleeve (4).

Číslo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.87. Váleček / Rolle / Cylinder

Číslo Sestavy 201.W370-040		Ver. 0	Název sestavy VALECEK/ROLLER/ROLLE		
Poz.	Objednáci číslo	Ver.	Název položky	Rozměr	Ks
1	30.1501-004	0	POUZDRO / SLEEVE / BÜCHSE	d 40	2
2	30.W370-041	0	TRUBKA / TUBE / ROHR	Tr 80x5	1
3	30.W370-042	0	ČEP / PIVOT / BOLZEN	d 25	1
4	95.001.020	0	LOŽISKO / BEARING / LAGER	6207 2RS	2



Číslo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednáci číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.88. Váleček / Rolle / Cylinder

Číslo Sestavy 201.W480-020		Ver. 0	Název sestavy VALECEK/ROLLER/ROLLE		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.1501-004	0	POUZDRO / SLEEVE / BÜCHSE	d 40	2
2	30.W480-021	0	TRUBKA / TUBE / ROHR	Tr 80x5	1
3	30.W480-022	0	ČEP / PIVOT / BOLZEN	d 25	1
4	95.001.020	0	LOŽISKO / BEARING / LAGER	6207 2RS	2

2

4

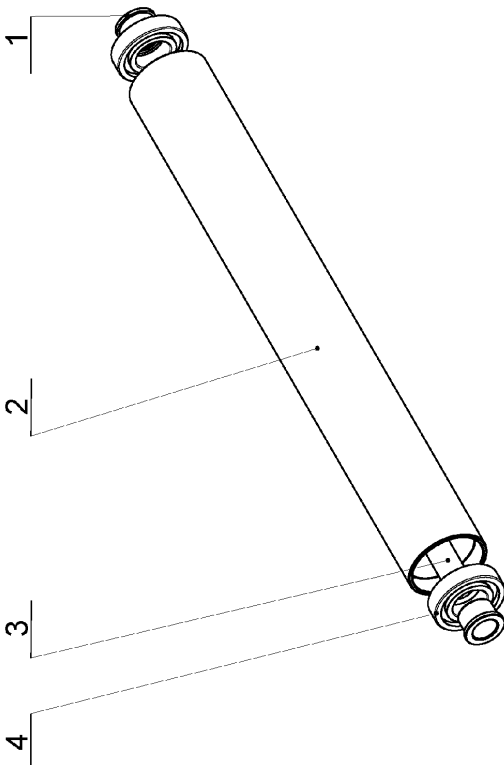
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3

Číslo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

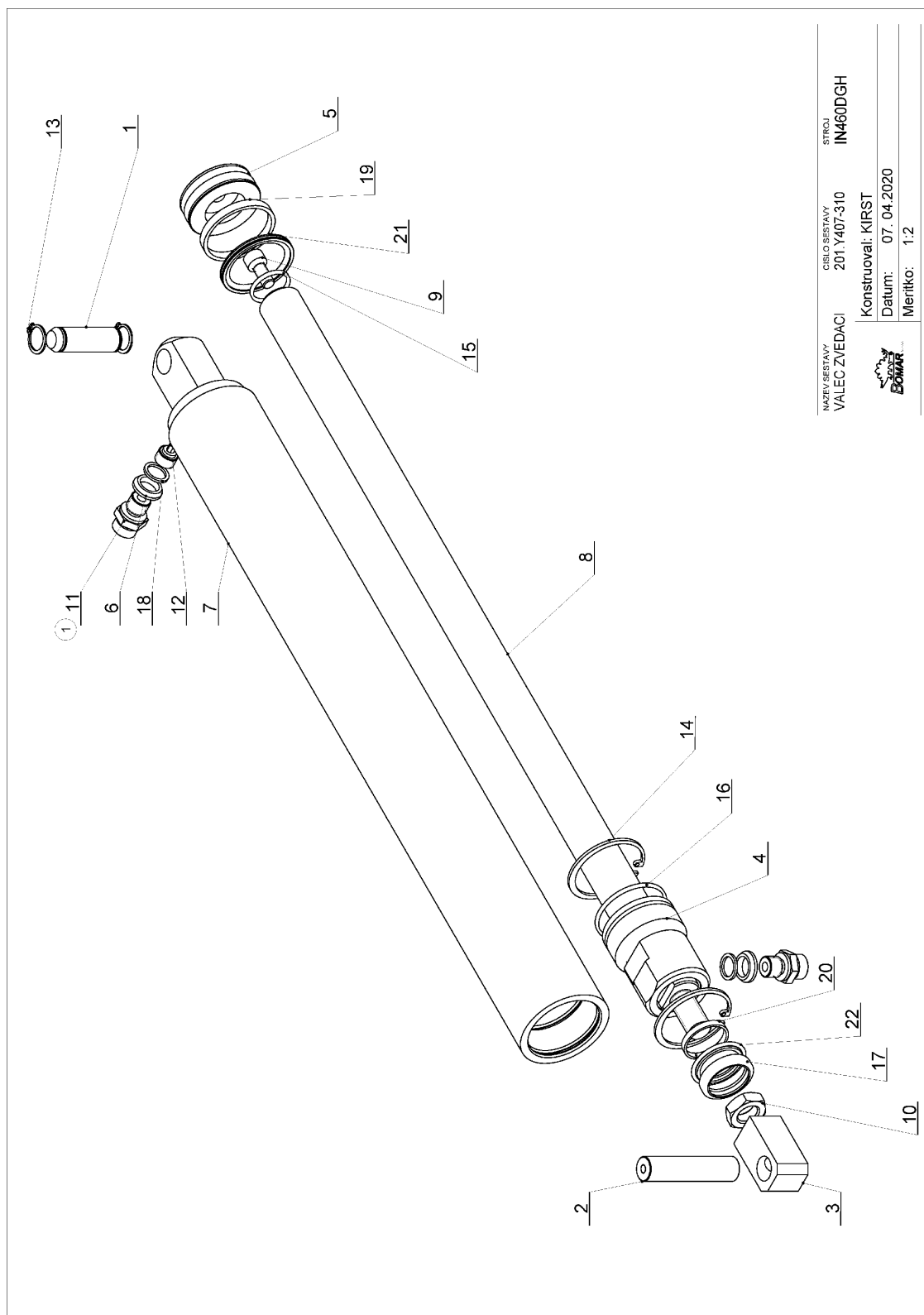
9.89. Váleček / Rolle / Cylinder

Číslo Sestavy 201.W480-010		Ver. 0	Název sestavy VALECEK/ROLLER/ROLLE		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.1501-004	0	POUZDRO / SLEEVE / BÜCHSE	d 40	2
2	30.W480-011	0	TRUBKA / TUBE / ROHR	Tr 80x5	1
3	30.W480-012	0	ČEP / PIVOT / BOLZEN	d 25	1
4	95.001.020	0	LOŽISKO / BEARING / LAGER	6207 2RS	2



Číslo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.90. Válec zvedací / Hebezyylinder / Lifting cylinder



9.91. Kusovník / Stückliste / Piece list –
Válec zvedací / Hebezyylinder / Lifting cylinder

Číslo Sestavy 201.Y407-310		Ver. 0	Název sestavy VALEC ZVEDACI/LIFTING CYLINDER/HEBEZYLINDER		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.0807-009	2	CEP / PIVOT / BOLZEN	d 16h9	1
2	30.8307-205	0	CEP / PIVOT / BOLZEN	d 16h9	1
3	30.8607-001	1	DRŽAK / HOLDER / HALTER	HR 25x25	1
4	30.M307-254	1	VÍKO / COVER / DECKEL	D 52	1
5	30.Y307-035	0	PIST / PISTON / KOLBEN	d 55	1
6	30.Y307-612	0	REDUKCE / REDUCTION / ADAPTOR / REDUKTION	TR 20x4	2
7	30.Y407-120	0	VALEC / CYLINDER / ZYLINDER		1
8	30.Y407-302	0	PISTNICE / PISTON ROD / KOLBENSTANGE	d 28 f8	1
9	90.001.25.105	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M8X18	1
10	90.101.55.003	0	MATICE PR.NÍZKA ZN / PRECISION THIN NUT - ZN / PRÄZISE MUTTER NIEDRIGE - ZN	MATICE M16	1
11	92.002.007	0	SROUBENÍ PRÍME / TUBE FITTING - STRAIGHT / GERADE VERSCHRAUBUNG	G 1/4"	2
12	92.151.008	0	VENTIL POJISTNÝ / SAFETY VALVE / SICHERUNGSVENTIL	VPN-H 1/4"	1
13	95.800.007	0	KROUZEK POJIST.VNEJŠÍ / EXTERNAL RETAINING RING / SICHERUNGSRING AUßEN	POJISTNÝ KROUZEK 16	2
14	95.801.018	0	KROUZEK POJIST.VNITŘ. / INTERNAL RETAINING RING / SICHERUNGSRING INNEN	POJISTNÝ KROUZEK 50	2
15	96.002.011	0	O-KROUZEK DYNAMICKÝ / O-RING DYNAMIC / O-RING DYNAMISCH	24X2	1
16	96.002.019	0	O-KROUZEK DYNAMICKÝ / O-RING DYNAMIC / O-RING DYNAMISCH	46x2 NBR 70SH	1
17	96.061.009	0	KROUZEK STRACÍ / WIPER RING / ABSTREIFRING	WD2200280 Z201	1
18	96.082.002	0	KROUZEK TESNICÍ / SEALING RING / DICHTUNGSRING	13/17x1.5 CU	2
19	96.084.001	0	KROUZEK VODICÍ / GUIDE RING / FÜHRUNGSRING	GP6500500-T47	1
20	96.084.006	0	KROUZEK VODICÍ / GUIDE RING / FÜHRUNGSRING	GR4300280-T47	1
21	96.900.013	0	TESNENÍ KOMBINOVANÉ / COMBINED SEALING / KOMBIDICHTUNG	PT0200500	1
22	96.900.021	0	TESNENÍ KOMBINOVANÉ / COMBINED SEALING / KOMBIDICHTUNG	RSK200280-48N	1

1.ZR.SROUBENÍ 92.002.017 A NAHR.92.002.007. 123/ZM177 7.4.2020 KOSYK

Císlo Sestavy/Number of assembly/Nummer der Baugruppe: Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz./Position/Position; Objednací číslo/Purchase order number/Bestellnummer. Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

Číslo sestavy/Number of assembly/Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.92. Noha dopravníku /Ständer des Förderers / Feeder Leg

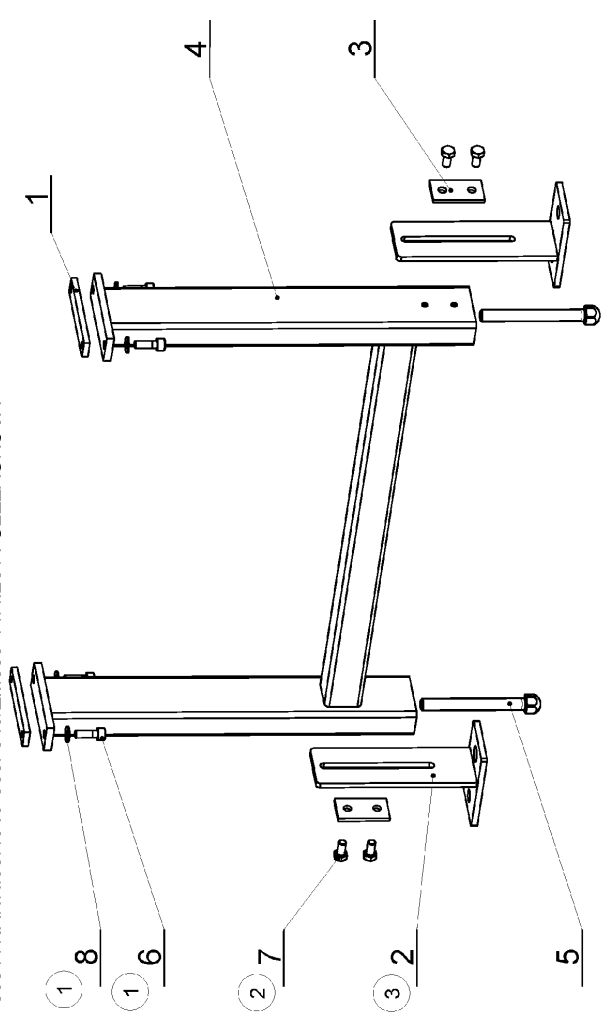
Číslo sestavy 203.X106-100		Ver.	Název sestavy NOHA DOPRAVNÍKU/CONVEYOR LEG/STÄNDER DES FÖRDERERS			
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks	
1	30.1315-701	3	PRÍLOŽKA / CLIP / CLIP	HR 25x8	2	
2	30.1515-660	3	NOHA / LEG / STÄNDER		2	
3	30.1515-681	0	PRÍLOŽKA / CLIP / CLIP	P 5x40	2	
4	30.X106-101	0	RAM / FRAME / RAHMEN		1	
5	31.1514-102	0	SROUB STAVEČI / SET SCREW / STELLSCHRAUBE	M 16	2	
6	90.001.25.048	1	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSHSCRAUBE	M10x30	4	
7	90.005.55.023	2	SROUB 6HRANNÝ / HEX HEAD SCREW / SECHSKANTSCHRAUBE	SROUB M10x20	4	
8	90.150.50.006	1	PODLOŽKA / WASHER / UNTERLEGSCHNEIBE	PODLOŽKA 10,5	4	

1.ZRUS.SROUB M10x30 (90.005.55.025) A NAHR.SROUBEM IMBUS M10x30 (90.001.25.048), PRÍD.PODLOŽKA 10,5 (90.150.50.006).

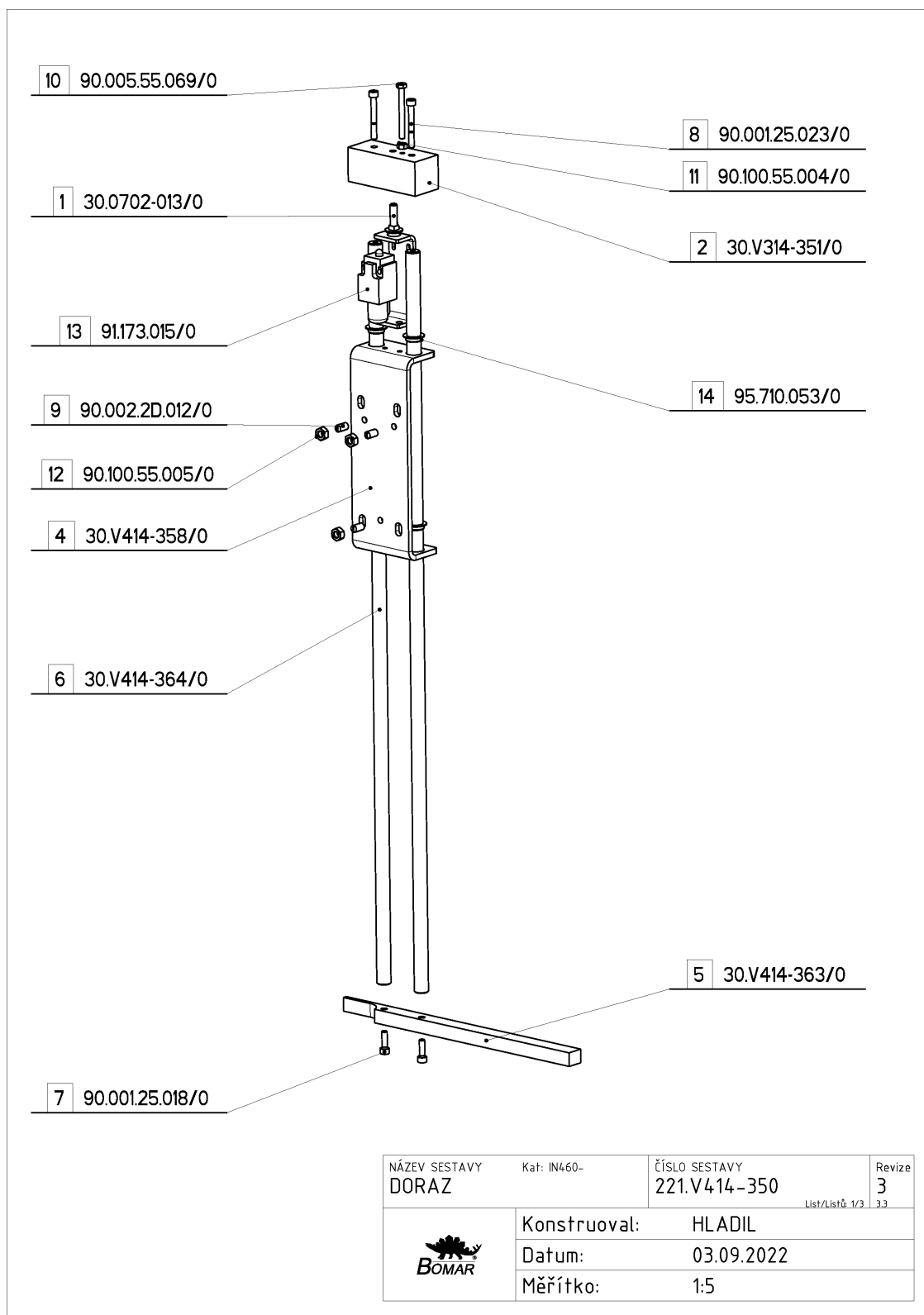
ZRUS.SROUB M10x20(90.005.55.023) A NAHR. M10x25(90.005.55.024),280/ZM288 25,10.2010 SLEZACKOVA

2.ZRUS.SROUB M10x25(90.005.55.024) A NAHR.M10x20(90.005.55.023). 269/ZM339 3.12.2012 SLEZACKOVA

3.ZRUS.NOHA 30.1515-690 A NAHR.30.1515-660. 049/ZM096 14.4.2014 SLEZACKOVA



9.93. Doraz / Anschlag / Stop piece



9.94. Kusovník / Stückliste / Piece list –
Doraz / Anschlag / Stop piece

NAZEV SESTAVY		ČÍSLO SESTAVY		REVIZE			rpt.index
DORAZ		221.V414-350		3			
Poz.	Objednáčí číslo	Verze	Název CZ	Name EN	Name DE	Polotovár	Ks.
1	30.0702-013	0	SROUB	SCREW	SCHRAUBE		1
2	30.V314-351	0	HRANOL	BLOCK	PRISMA	HR40x40 – 100	1
3	30.V414-206	0	DRŽÁK	HOLDER	HALTER	P4 – 36x150	1
4	30.V414-358	0	PLECH	SHEET METAL	BLECH	P6 – 84x314	1
5	30.V414-363	0	DORAZ	STOP PIECE	ANSCHLAG	HR20x16 – 350	1
6	30.V414-364	0	TYČ VODÍČI	LEAD POLE	FÜHRUNGSSTANGE	D16 – 872	2
7	90.00125-018	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	6x20 DIN 912 8,8 černěný	2
8	90.00125-023	0	SROUB IMBUS	HEXAGON SOCKET SCREW	IMBUSSCHRAUBE	6x50 DIN 912 8,8 černěný	2
9	90.0022D-012	0	SROUB STAVEČI	SET SCREW	STELLSCHRAUBE	8x16 DIN 913 4,5H žeměň	3
10	90.00555-069	0	SROUB 6HRANNÝ	HEX HEAD SCREW	SECHSKANTSCHRAUBE	6x60 DIN 933 8,8 Zn	1
11	90.100.55.004	0	MATICE PŘESNA ZINEK	PRECISION NUT – ZN	PŘÁZISE MUTTER – ZN	6 DIN 934 8,8 Zn	1
12	90.100.55.005	0	MATICE PŘESNA ZINEK	PRECISION NUT – ZN	PŘÁZISE MUTTER – ZN	8 DIN 934 8,8 Zn	3
13	91.173.015	0	SPINAC KONCOVÝ	END SWITCH	ENDSCHALTER	FK3301-M1 malý – 1xNC/1xNC	1
14	95.710.053	0	POUZÍŘO	SLEEVE	BÜCHSE	GF1-1618-09 1gus	4

1. PRIDAN HRANOL 30.V314-052,ZRUS.HRANOL 30.V414-357 A NAHR.30.V314-351,1xPRID.SROUB M6x60 (90.005.55.069),
1xMATICE M6(90.100.55.004) . 239/ZM304 25.10.2012 SLEZACKOVA

2.ZRUSENY DILY 30.V414-351, 30.V414-352; PRIDANY DILY 30.V414-358, 90.002.2D.012 a 95.710.053
1607zm.168 24.5.2013 HLADIL

3.DIL 30.V414-353 NAHRAZEN DILEM 30.V414-364; ZRUSENY DILY: 30.V314-052, V414-356, 30.V414-355, 30.V414-354;
PRIDAN DIL 30.V314-363; 042/zm.026 20.2.2015 HLADIL

Číslo Sestavy/Number of assembly/Nummer der Baugruppe. Ver-Verze/Version/Version. Název sestavy/Assembly name/Name der Baugruppe. Poz-Position/Position/Position. Objednáčí číslo/Order number/Bestellnummer. Polotovár/Semi-product/Halbfabrikat: Všechny materiály/Všetchní materiály/Defaut material/Defautmaterial

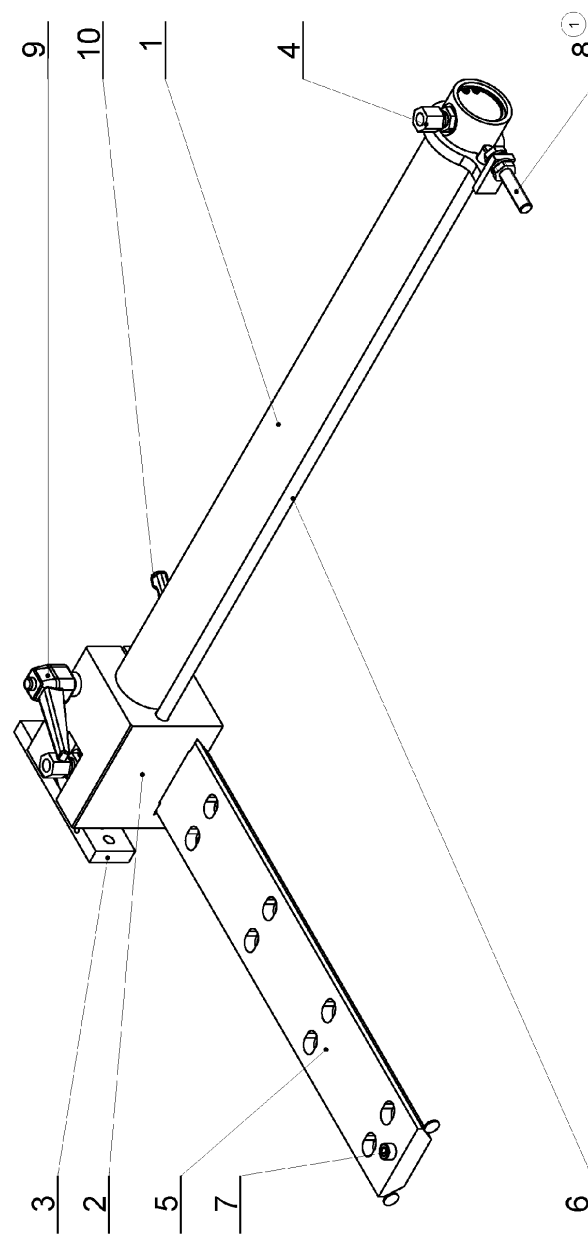
Číslo Sestavy/Number of assembly/Nummer der Baugruppe, Ver.-Verze/Version/Version, Název sestavy/Assembly name/Name der Baugruppe, Poz.-Pozice/Position/Position, Objednáč. číslo/Order number/Bestellnummer, Polotovár/Semiprodukt/Halbfabrikat; Vstupní materiál/Input material; Default material/Eingangsmaterial;

9.95. Volitelné příslušenství / Optional accessories

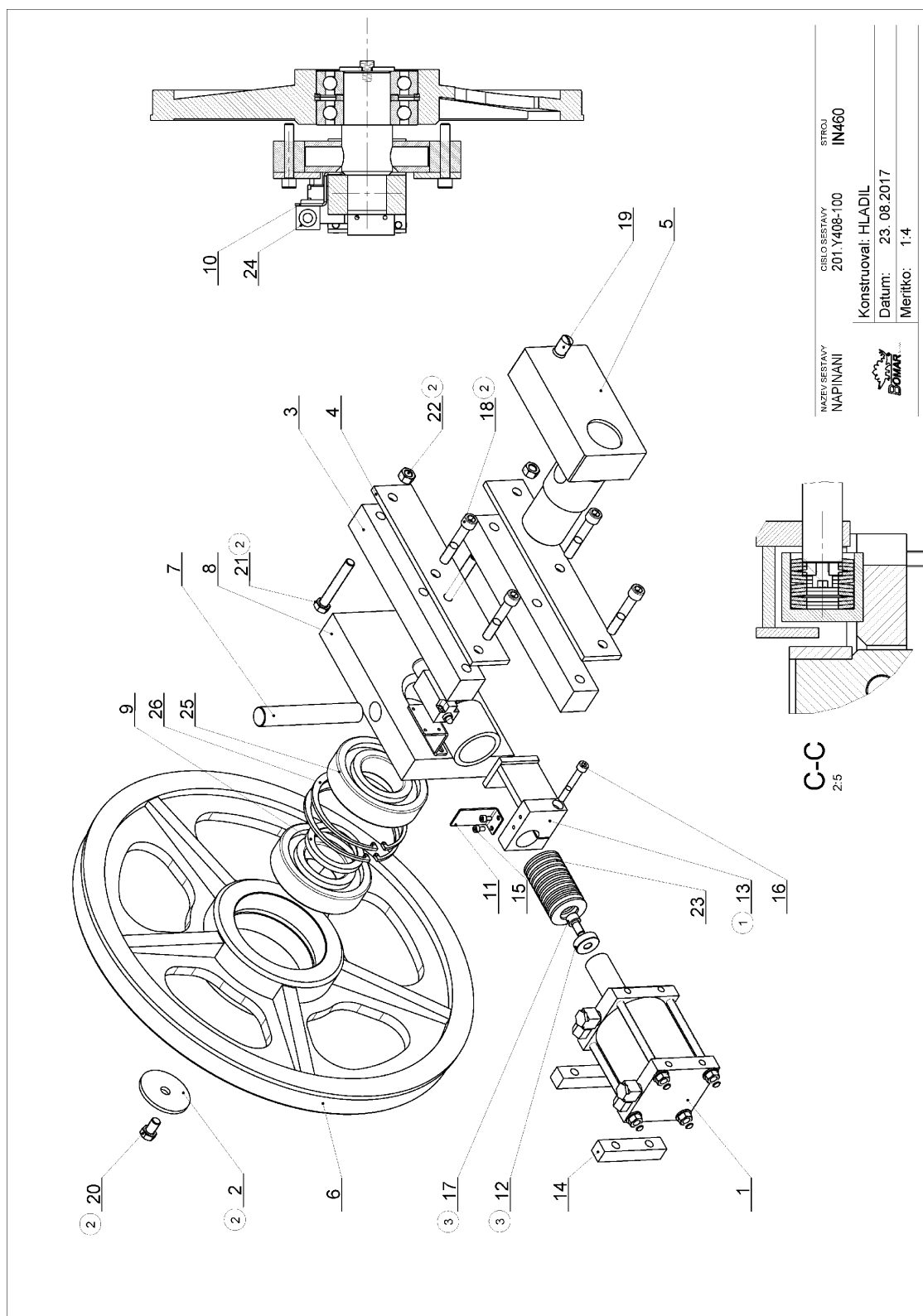
9.95.1. Upínání horní / Top clam / Spannvorrichtung oben

Císlo Sestavy 201.W450-130	Ver. 0	Název sestavy UPINANI HORNÍ/TOP CLAMPING/SPANNVORRICHTUNG OBEN			
Poz.	Objednáací číslo	Ver.	Název položky	Rozměr	Ks
1	201.W407-020	0	VALEC UPINACÍ / FIXING CYLINDER / SPANNZYLINDER		1
2	30.W350-132	0	KLUZÁK / GLIDER / GLEITER	HR 70x70	1
3	30.W350-133	0	DESKA / BOARD / PLATTE	HR 30x10	1
4	30.W350-136	0	DRŽÁK / HOLDER / HALTER		1
5	30.W450-131	0	LISTA / SLAT / LEISTE	HR 60x15	1
6	30.W450-134	0	TYC VODICÍ / LEAD POLE / FÜHRUNGSSTANGE	D 8	1
7	90.001.25.015	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M6x10	2
8	91.172.009	1	SPINAC INDUKTIVNÍ / INDUCTIVE SWITCH / INDUKTIVER SCHALTER	JPS30D081.5PNOFC	1
9	94.008.006	0	PAKA MONTÁŽNÍ / ASSEMBLY LEVER / MONTAGEHEBEL	M10	1
10	94.008.015	0	PAKA MONTÁŽNÍ / ASSEMBLY LEVER / MONTAGEHEBEL		1

1.ZRUS 91.172.009 NAHR. 91.172.033; 068/ZM109 15.3.2019 SCERBA



9.95.2. Napínání / Tensioning / Spannung



9.95.3. Kusovník / Stückliste / Piece list –
Napínání / Tensioning / Spannung

Číslo Sestavy 201.Y408-100		Ver. 0	Název sestavy NAPINANI/TENSIONING/SPANNUNG		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	201.V307-130	0	VALEC NAPINACÍ / TENSIONING CYLINDER / SPANNZYLINDER		1
2	30.1804-014	2	PODLOŽKA / WASHER / UNTERLEGSCHIBE	P 5x70	1
3	30.6008-002	0	LISTA VODICÍ / GUIDING SLAT / FÜHRUNGSLEISTE	HR 40x40	2
4	30.6008-003	1	LISTA VODICÍ / GUIDING SLAT / FÜHRUNGSLEISTE	HR 60x8	2
5	30.6008-004	2	NAPINANI / TENSIONING / SPANNUNG		1
6	30.6008-006	0	KOLO NAPINACÍ / TENSIONING WHEEL / SPANNRAD		1
7	30.6008-014	1	CEP NAPINANI / TENSIONING PIVOT / SPANNUNGSBOLZEN	d 25 h6	1
8	30.6708-001	0	NAPINANI / TENSIONING / SPANNUNG		1
9	30.6708-002	1	DISTANC / SPACER / ABSTANDSTÜCK	TRUBKA 82.5x12.5	1
10	30.6708-303	0	DRŽÁK / HOLDER / HALTER	P 3x50	1
11	30.6708-304	0	DORAZ / STOP PIECE / ANSCHLAG	P 2x20	1
12	30.Y408-101	3	DISTANC / SPACER / ABSTANDSTÜCK	D 32	1
13	30.Y408-103	1	TRMEN / BINDER / BÜGEL		1
14	30.Y408-105	0	PODLOŽKA / WASHER / UNTERLEGSCHIBE	HR 20x20	2
15	90.001.25.007	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M5X10	2
16	90.001.25.040	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M8X60	1
17	90.001.25.046	3	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M10X20	1
18	90.001.25.064	2	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M12X70	4
19	90.002.2D.028	0	SROUB STAVECÍ / SET SCREW / STELLSCHRAUBE	SROUB M16x1.5x25	1
20	90.005.55.030	2	SROUB 6HRANNÝ / HEX HEAD SCREW / SECHSKANTSCHRAUBE	SROUB M12X20	1
21	90.005.55.036	2	SROUB 6HRANNÝ / HEX HEAD SCREW / SECHSKANTSCHRAUBE	SROUB M12X80	2
22	90.100.55.007	2	MATICE PRESNA ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	MATICE _ M12	2
23	90.350.02.004	0	PRUŽINA TALIROVÁ / DISC SPRING / TELLERFEDER	50X25.4X3	12
24	91.173.007	0	SPINAC KONCOVÝ / END SWITCH / ENDSCHALTER	-RIWK	1
25	95.001.041	0	LOŽISKO / BEARING / LAGER	6312A	2
26	95.801.025	0	KROUZEK POJIST.VNITR. / INTERNAL RETAINING RING / SICHERUNGSRING INNEN	POJISTNÝ KROUZEK 130	2

1.ZRUS.TRMEN 30.Y408-106 A NAHR.30.Y408-103 . 119/ZM161 6.5.2013 SLEZACKOVA

2.ZRUS.2xSROUB IMBUS M12x70(90.001.25.064) A NAHR.2xSROUB 6HR M12x80(90.005.55.036) A MATICE M12(90.100.55.007).

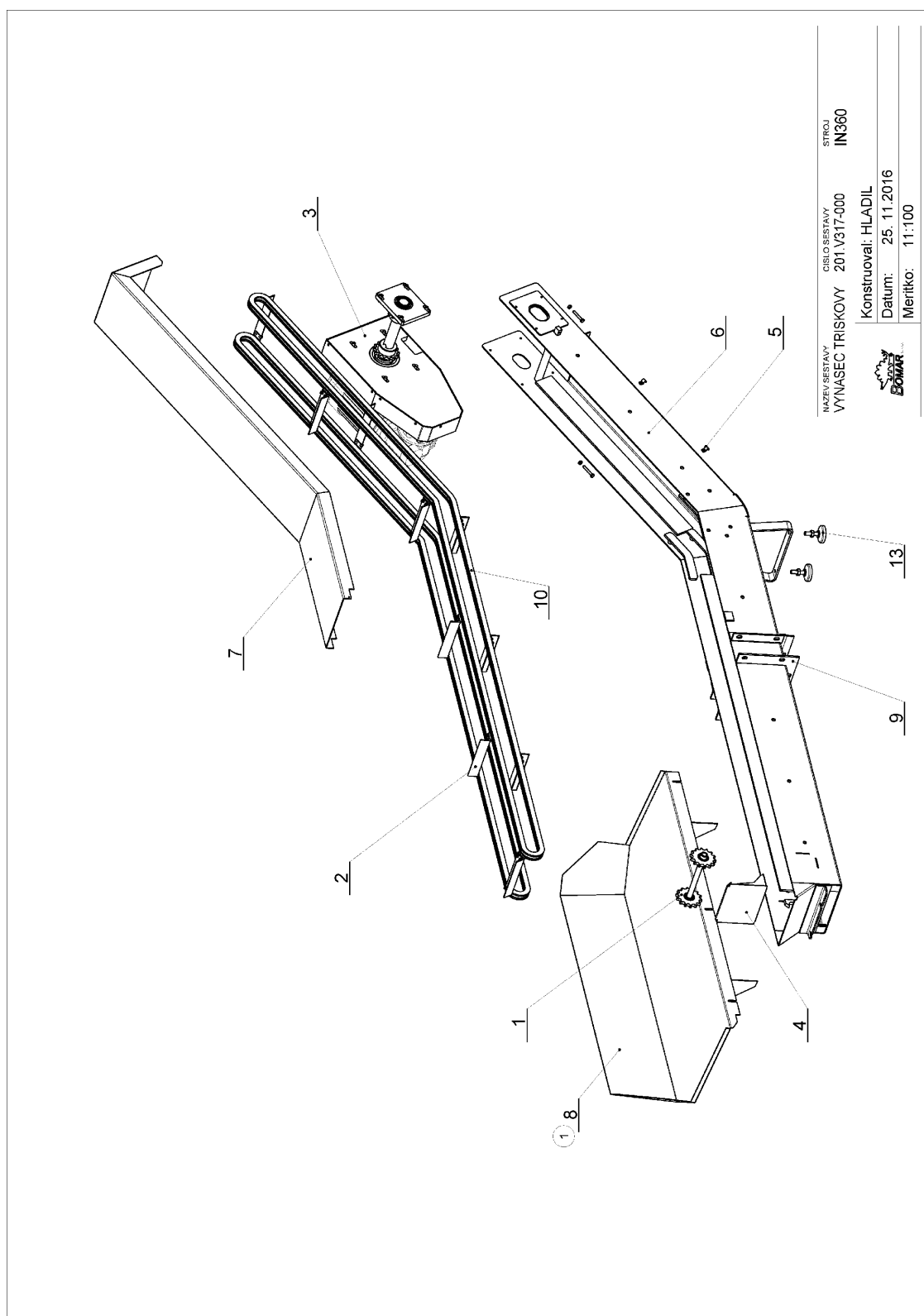
ZRUS.PODLOŽKA 30.1804-010 A NAHR.30.1804-014,ZRUS.ZAPUJSTNY SROUB M12x20(90.011.27.009) A NAHR.6HR SROUB M12x20 (90.005.55.030).164/ZM187 24.8.2015 SLEZACKOVA

3.PRID.DISTANC 30.Y408-101 A SROUB M10x20 90.001.25.046.186/ZM276 23.8.2017 CERNY

Číslo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver./Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz./Position/Position; Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

Číslo sestavy/Number of assembly/Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednávací číslo/Order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.95.4. Vynašeč třískový / Chip extractor / Spanabführung



9.95.5. Kusovník / Stückliste / Piece list –
Vynašeč třískový / Chip extractor / Spanabführung

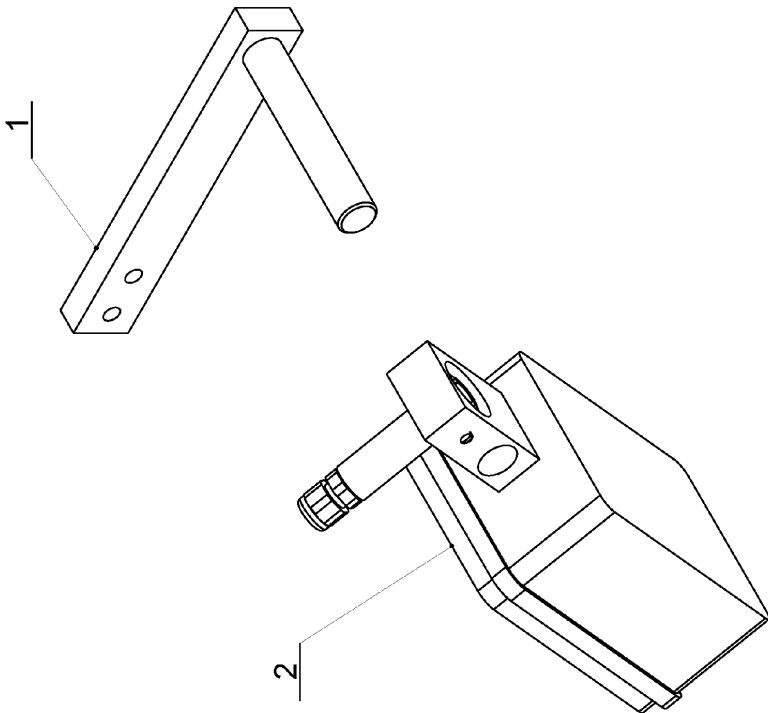
Číslo sestavy 201.V317-000		Ver. 1	Název sestavy VYNASEC TRISKOVY/CHIP EXTRACTOR/SPANABFÜHRUNG	
Poz.	Objednací číslo	Ver.	Název položky	Ks
1	201.6017-103	0	KOLO NAPINACÍ / TENSIONING WHEEL / SPANNRAD	1
2	201.6017-104	2	RETEZ POHONOVÝ / DRIVE BELT / ANTRIEBSKETTE	10
3	201.V317-050	0	POHON / DRIVE / ANTRIEB	1
4	30.6017-121	0	SÍTO / SIEVE / GITTERWERK	1
5	30.9010-003	0	DRŽÁK / HOLDER / HALTER	2
6	30.V317-001	4	KORYTO / CHANNEL / RINNE	1
7	30.V317-003	0	KRYT / COVER / ABDECKUNG	1
8	30.V317-009	0	KRYT / COVER / ABDECKUNG	1
9	31.7217-032	0	TESNĚNÍ / SEALING / DICHTUNG	1
10	49.200.018	0	RETEZ POHONOVÝ / DRIVE BELT / ANTRIEBSKETTE	2
11	90.005.55.012	0	SROUB 6HRANNÝ / HEX HEAD SCREW / SECHSKANTSCHRAUBE	2
12	90.100.55.004	0	MATICE PRESNÁ ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	2
13	94.015.002	0	NOHA / LEG / STÄNDER	2

1.ZRUS.KRYT 30.V317-008 A NAHR.SVARKEM 30.V317-009.139/ZM182 8.6.2012 KOHUT

Číslo sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver.)/Version/Version; Název sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;
Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.95.6. Laser – ukazovátko / Laser / Laser

Číslo Sestavy 202.6120-101		Ver. 0	Název sestavy LASER-UKAZOVATKO/LASER - LINER/LASER - LINER		
Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.6120-001	0	DRŽAK / HOLDER / HALTER		1
2	202.5010-000	0	DRŽAK / HOLDER / HALTER	DRŽAK LASERU	1



1

2

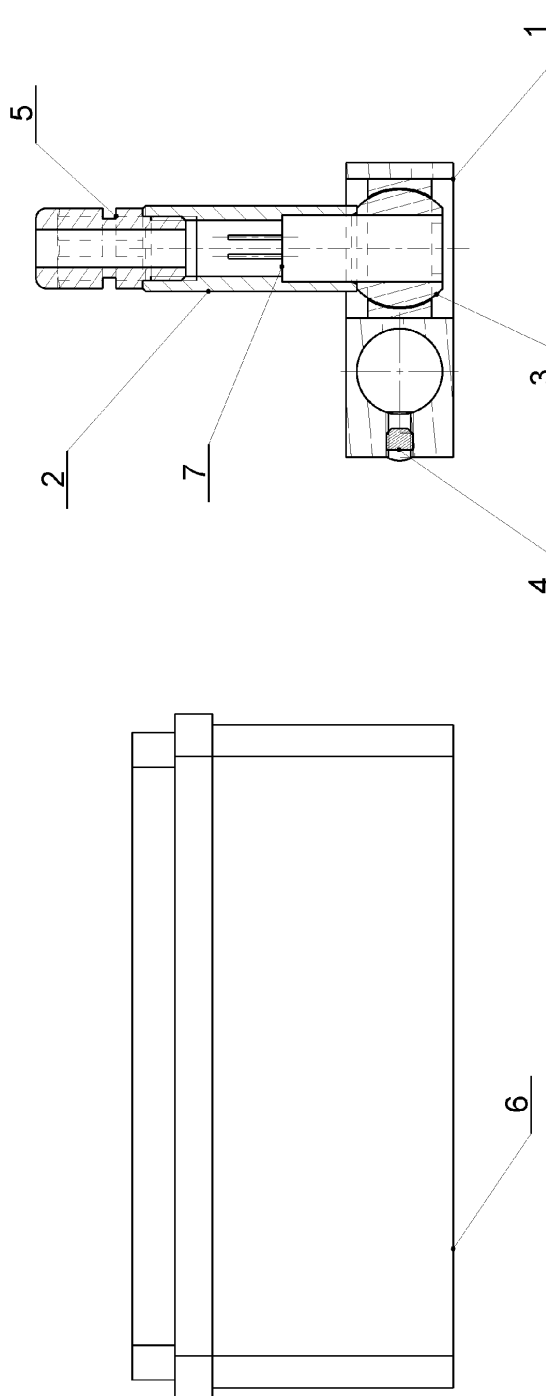
9.95.7. Laser – ukazovátka / Laser / Laser

Číslo Sestavy
202.5010-000

Ver.
0

Název sestavy
DRŽAK/HOLDER/HALTER

Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.5010-001	0	DRŽAK / HOLDER / HALTER	HR 55x20	1
2	30.5010-002	0	DRŽAK / HOLDER / HALTER	d 16	1
3	30.5010-003	0	KLOUB / JOINT / GELENK	KGLM-12	1
4	90.002.2D.003	0	ŠROUB STAVEČI / SET SCREW / STELLSCHRAUBE	ŠROUB M5x6	2
5	91.070.010	0	VÝVODKA KLESTINOVÁ / COLLET WITH OUTLET / SPANNZANGENTÜLLE	M12x1,5	1
6	91.100.101	0	ZDROJ / SOURCE / QUELLE	ZDROJ	1
7	91.100.105	0	LASER-UKAZOVÁTKO / LASER - LINER / LASER - LINER	d 12,5-32	1



9.95.9. Kusovník / Stückliste / Piece list –
Kontrola vychýlení pásu / Bandsaw deflection control / Band
Ausschlagkontrolle

Cislo Sestavy 202.6914-100		Ver. 2	Nazev sestavy SNIMAC/SENSOR/SENSOR		
Poz.	Objednaci cislo	Ver.	Nazev polozky	Rozmer	Ks
1	30.6914-101	2	KOSTKA / CUBE / WURFEL	HR40x40	1
2	30.K602-209	2	DISTANC / SPACER / ABSTANDSSTÜCK	TR 10x2	2
3	30.R214-301	2	DRZAK / HOLDER / HALTER	P 3x115	1
4	90.001.25.004	2	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M4X16	2
5	90.001.25.009	2	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M5X16	6
6	90.003.2D.011	0	SROUB STAVECI / SET SCREW / STELLSCHRAUBE	SROUB M4X10	1
7	90.300.0Z.005	0	KOLIK VALCOVY KALENY / CYLINDRICAL PIN HARDENED / ZYLINDERSTIFT GEHÄRTET	KOLIK 6X20	2
8	91.063.058	0	OSVETLENI / LIGHTING / BELEUCHTUNG	SL-CB-100	1
9	91.063.059	2	OSVETLENI / LIGHTING / BELEUCHTUNG	SL7-L-Y	1
10	91.063.061	2	OSVETLENI / LIGHTING / BELEUCHTUNG	SL7-L24	1
11	91.070.010	0	VYVODKA KLESTINOVA / COLLET WITH OUTLET / SPANNZANGENTÜLLE	M12x1.5	1
12	91.172.016	1	SNIMAC / SENSOR / SENSOR	BAWR06	1
13	91.995.084	0	JEDNOTKA RIDICI / CONTROL UNIT / STEUEREINHEIT	BDM-2	1

1 z ks storje zrusit snimac 91.172.011 a nahradit jej snimacem 91.172.016

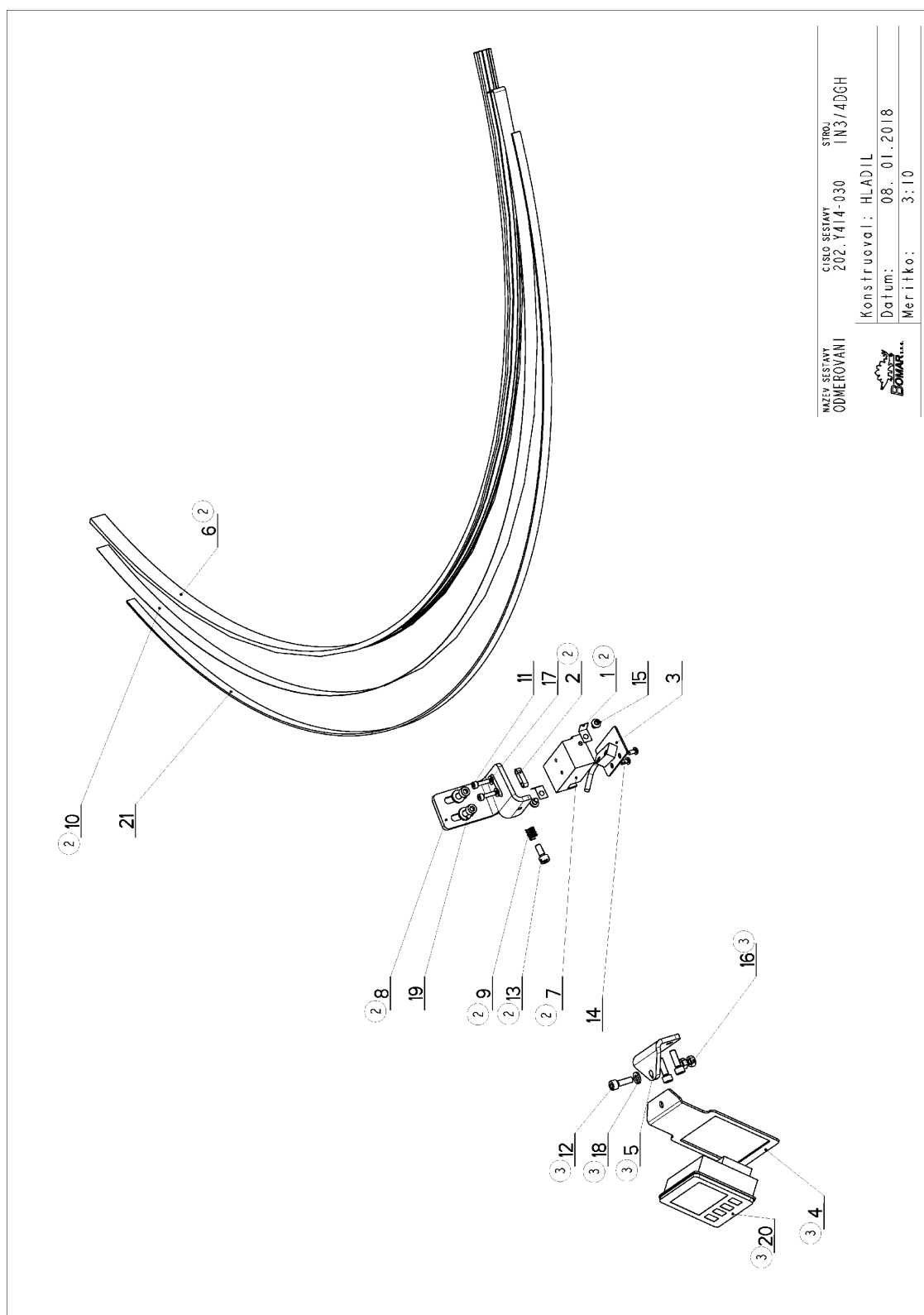
6.10.2008./325-2008 vinohradsky

2.ZRUS 93.017.172; PRID 30.K602-209,30.R214-301,2x90.001.25.004,4x90.001.25.009,91.063.059,91.063.061; 080/ZM129 26.3.2019 SCERBA

Cislo Sestavy/Number of assembly/Nummer der Baugruppe; Verze (Ver./Version/Version; Nazev sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position;

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Objednací číslo/Purchase order number/Bestellnummer; Název položky/Volume title/Name der Position; Rozměr/Stock size/Abmessung

9.95.10. Odměrování / Measuring / Gehrungsmessung



9.95.11. Kusovník / Stückliste / Piece list –
Odměrování / Measuring / Gehrungsmessung

Císlo Sestavy
202.Y414-030

Ver.
3

Název sestavy
ODMEROVÁNÍ / MEASURING / GEHRUNGSMESSUNG

Poz.	Objednací číslo	Ver.	Název položky	Rozměr	Ks
1	30.1504-017 (2)	0	STERAC / WIPER / ABSTREIFER	P 0,3x11	2
2	30.V302-133 (2)	1	PERO / PARALLEL KEY / PASSFEDER	PERO 6x6	1
3	30.Y414-033	0	VÍKO / COVER / DECKEL	PI.5 - 33	1
4	30.Y414-043 (3)	0	DRŽAK / HOLDER / HALTER	P 2x110	1
5	30.Y414-044 (3)	0	PLECH / SHEET METAL / BLECH	P 5x60	1
6	30.Y414-045 (2)	0	PROFIL / PROFILE / PROFIL		1
7	30.Y414-046 (2)	0	DRŽAK / HOLDER / HALTER	HR 25x35	1
8	30.Y414-047 (2)	2	DRŽAK / HOLDER / HALTER	P 5x67	1
9	31.1605-121 (2)	0	PRUŽINA / SPRING / FEDER	1x9,5x12x4	1
10	55.800.009 (2)	0	PLANZETA / nut / null	P 0,3 - 15	1
11	90.001.25.004	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	MAX16	2
12	90.001.25.018 (3)	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M6x20	5
13	90.001.25.092 (2)	0	SROUB IMBUS / HEXAGON SOCKET SCREW / IMBUSSCHRAUBE	M6x14	1
14	90.013.27.001	0	SROUB PULKULATY / BUTTON HEAD SCREW / RUNDKOPFSCHRAUBE	M4x8	2
15	90.013.27.002	0	SROUB PULKULATY / BUTTON HEAD SCREW / RUNDKOPFSCHRAUBE	M5x6	2
16	90.100.55.004 (3)	0	MATICE PŘESNA ZINEK / PRECISION NUT - ZN / PRÄZISE MUTTER - ZN	MATICE - M6	2
17	90.150.50.002	0	PODLOŽKA / WASHER / UNTERLEGSCHIBE	PODLOŽKA 4,3	2
18	90.150.50.004 (3)	0	PODLOŽKA / WASHER / UNTERLEGSCHIBE	PODLOŽKA 6,4	1
19	90.163.00.009	0	PODLOŽKA / WASHER / UNTERLEGSCHIBE	NORD-LOCK 6	2
20	91.270.017 (3)	0	SNIMAC MAGNET. / MAGNETIC SENSOR / MAGNETSENSOR	I216E-000-1-01,6-0	1
21	91.271.005	0	PÁSKA MAGNETICKÁ / MAGNETIC TAPE / MAGNETBAND	MB 20.25	1

1.ZRUS.VYVODKA M12 91.071.013, MATICE M12 91.072.010. 014/ZM049 4.3.2013 SLEZACKOVA

2.ZRUS.KOSTKA 30.Y414-031 A NAHR. 30.Y414-046, ZRUS.DRŽAK 30.Y414-032 A NAHR. 30.Y414-047, ZRUS.STERAC 30.Y414-035
A NAHR. 30.1504-017, ZRUS.STERAC 30.Y414-036, PRID.PROFIL 30.Y414-045, PRUŽINA 31.1605-121, 1xSROUB M6x14(90.001.25.092) .
PERO 30.V302-133. 123/ZM174 12.6.2013 SLEZACKOVA

3.PRID.PLECH 30.Y414-044, DRŽAK 30.Y414-043, 1xPODLOŽKA 6,4(90.150.50.004), 3xSROUB M6x20(90.001.25.018),
2xMATICE M6(90.100.55.004), ZRUS.SNIMAC 91.270.016 A NAHR. 91.270.017, ZRUS.DRŽAK 30.Y414-038, KRABICE 30.Y414-039
270/ZM014 8.1.2018 SLEZACKOVA

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NEMAZAT – vložena záložka pro generování obsahu