Series **Ergonomic**



CE





Ergonomic 320.250 G

Operating instructions

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

Seriové číslo / Serien Nummer / Serial Number



Service and information

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Version:		
1.05 / Mar. 2010		
rev. 1		
BOMAR, spol. s r.o. [©] – Subject to m	odifications and am	endments.



	E	EC Declarati	on of Confor	mity		
1) We BOMAR, spol. s r.o. Těžební 1236/1 627 00 Brno, The Czech Republic Id.no: 48908827						
		decla	re herewith,			
that the following desig	nated device b	ased on its conce	ption and construct	tion as v	well as the de	sion launched by us
meets the relevant basi modification not approv	c safety requir	ements of the dec	rees of the govern			
Name:		Band Saw				
Type range:		Ergonomic 320).250 G			
Serial number:						
Manufacturer:		BOMAR, spol	s r.o., Těžební 12	236/1, 62	27 00 Brno	
		<i>*</i> •		,		
Product data:	Determination:		and cutting of rolled an- ferrous metals and pla		bars and profiles	made of steel,
	Description:		g unit with the arm, saw		d drive, control pa	anel
		Hydraulic	yes	s 🗖	no 🖂	
		Control system	yes	5 D	no 🖂 / semia	automat
	Technical data:	cutting rate	Standard 40/80.m	n/min Fred	q. conv. 20–120 r	m/min
		cutting angle	0° – 60°			
		Total dimensions i	n mm (l×w×h)		1670×1166×12	39 mm
		weight	345 kg			
		Supplyvoltage	400 V, total powe	r requirer	ment 1,7 kW,	
The applied decrees of governments:	ıf	No. 24/2003 Co	oll. (Directive 98/3)	7/EC)		
		No. 616/2006 C	Coll. (Directive 200	4/108/E	EC)	
		No. 17/2003 Co	oll. (Directive 2006	(95/EC))	
The applied harmonize National standards and ČSN EN ISO 13857:20 ed.2:2007	technical spec					
The pro	duct is safe on	condition of the c	ommon and determi	ined usa	age.	
The conformity judging wa 2) ²⁾ The declaration of co Prague 4 – Czech Repul	onformity was ca	arried out in the cod	operation with the TÜ	İV SÜD		
The inspection certifica				Téžební Czech IČO: 48	AR, spol. s r. ii 1236/1, 627 00 Br Republic 3906827 Z48908827	Alfred Pull
		chlmann, managir				- 1
Point of issue, datum		and function consible subject			Signati	
Name of person responsib						
 Name, address and identificatio The authorized or accredited bo 			/ declaration (producer of in	nporter)		
If the equipme buyer) then EC EC Declaration other with equi All machine elu	nt is installed with C declaration loses n of conformity is v ivalent safety devi ements and compo	out safety equipment of validity. ralid only if customer (ce in accordance with	current applicable regul into the device by BOM	MAR safe ations an	ty equipment with d standards.	n the machine or with some





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1. 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!

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!

Attention!

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

1.1. Machine determination

The band saw **Ergonomic 320.250 G** 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 angles from 0° 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.

Attention!

Consider the safety signs on the machine. Do not remove or damage them!

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!



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.

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.

Do not connect the machine to electricity if the covers are removed. Do not touch the electrical equipment.

- 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

Attention!

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

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

Only qualified person can do the servicing and repairs. For parts changing, use only parts, which are identical with the originals. Otherwise, there is possibility of health hazard. Use only recommended type of the hydraulic oils and oils and lubricants!

Attention!



Do not remove or do not lock the limit switches or safety equipments! Any use of the saw, accessories or machine parts other than that intended by the BOMAR, spol. s r.o. company is not permitted. The guarantee on this product will be afterward lost and BOMAR, spol. s r.o. takes no responsibility for caused damages.

1.5. Safety machine accessories

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.

Enhanced risk!

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

1.5.1. Total Stop

TOTAL STOP button is used for emergency switching – off the machine in case defect or health hazard. By pressing **TOTAL STOP** button is interrupted the supply of the electrical power.

If any damages or fault appears, immediately press TOTAL STOP button! Release the pressing button is possible by twisting of the upper part of the button.

1.5.2. Arm cover

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.



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

1.5.3. Band saw cover

It covers the visible area of the saw band from guiding cube to the frame.



Never turn-ON saw band when cover is not mounted!

1.5.4. Saw band stretching and rupture inspection

This device checks the saw band tension and causes immediate machine stop if the band incidentally ruptures.





The device includes a limit switch. Its adjustment is described in chapter "Servicing and adjusting". Check the switch carefully and periodically – adjust it if necessary.

1.6. 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

1.6.1. 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.

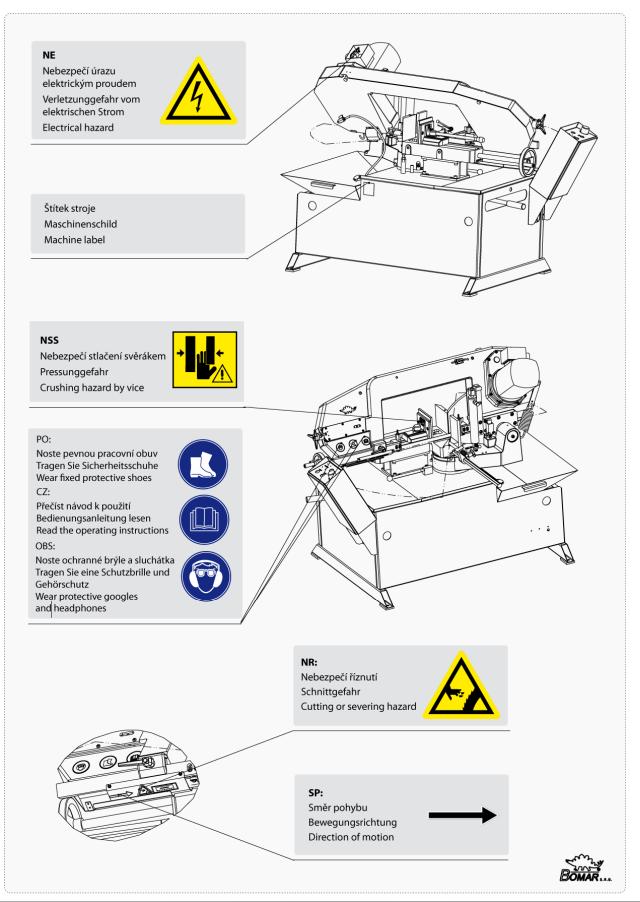
1.7. Umístění štítku stroje / Maschinenschild position / Position of machine label



Machine label is placed on saw band base.



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



Bezpečnostní pokyny Sicherheitshinweise Safety notes



2. Machine documentation



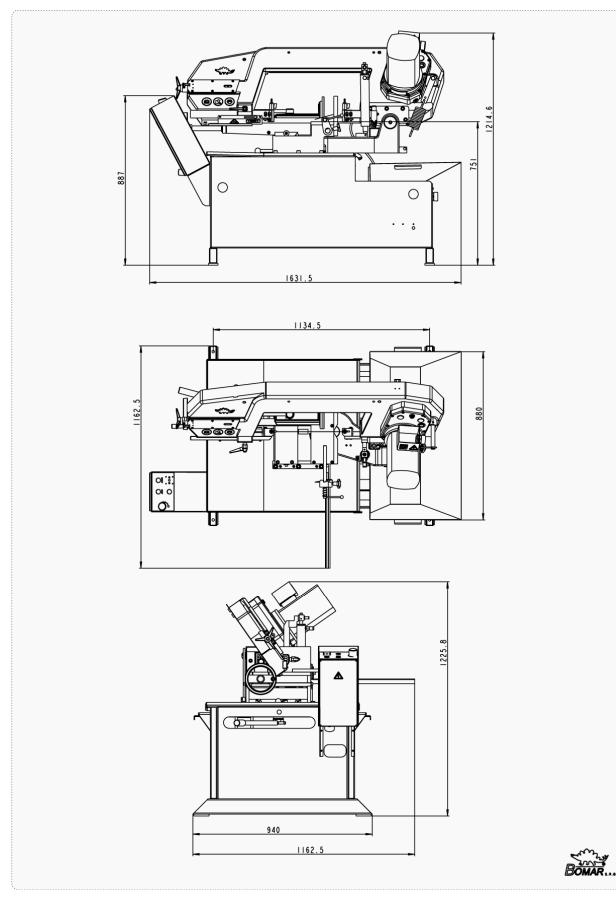
 Hmotnost / Gewicht / 	Weight			345 kg
Rozměry stroje / Maschin	engröße / Machine s	ize :		
 Délka / Länge / Lenghi Šířka / Breite / Width Výška / Höhe / Height 	t			1670 mm 1166 mm 1239 mm
Elektrické vybavení / Elek	trische Ausrüstung /	Electical equipmen	ıt:	
 Napájení / Versorgung Příkon / Gesamptschlu Max,jištění / Max. Vorso Krytí / Schutzart / Prote 	isswert / Total Input chaltsicherung / Max. F	Ĵ		~ 3×400V, 50H : 1,7 kV 16 / IP 54
Akustický tlak / Schalldru	ckpegel / Acoustic p	ressure:		
• Ergonomic 320.250 G			L _{Aeqv} =59/65 dB 40) m.min ⁻¹ / 80 m.min ⁻
Pohon / Atrieb / Drive:				
 Typ / Typ / Type Výkon / Leistung / Out Jmenovité otáčky / Mc 		minal speed		TM 90-2/4S B 1,1 / 1,5 kV 2800/1420 m/mi
Chladící zařízení / Kühlmi				
 Výkon / Leistung / Out Obsah nádrže / Volum 		apacity		0,09 kV 12 dm
Rozměr pásu / Sägebando	dimension / Band siz	e:		
	291	0×27×0,90 mm		
Řezná rychlost / Schnittgo	eschwindigkeit / Cut	ting speed:		
Stan	<i>dard:</i> 40/80 m/m	in. Freq. converte	r: 20–120 m/min	
Řezné rozsahy / Schnittbe	ereiche / Cutting size	:		
R60° (+60°) R45° 0° (+45°)	Ο			
0°	Ø250 mm	320×170 mm	290×240 mm	240×240 mm
R 45°	Ø220 mm	230×140 mm	200×230 mm	200×200 mm

Level of acoustic pressure:

Equivalent level of acoustic pressure A (noise) at operator position are $L_{Aeqv}=59 / 65 dB$ for speed 40 m.min⁻¹ / 80 m.min⁻¹. Mentioned values are levels of emission which doesn't have to represent safe levels. Factors which influence real level of acoustic pressure on machine operator are: working place characteristics, cut material, saw band. These factors have significantly influence on acoustic pressure.



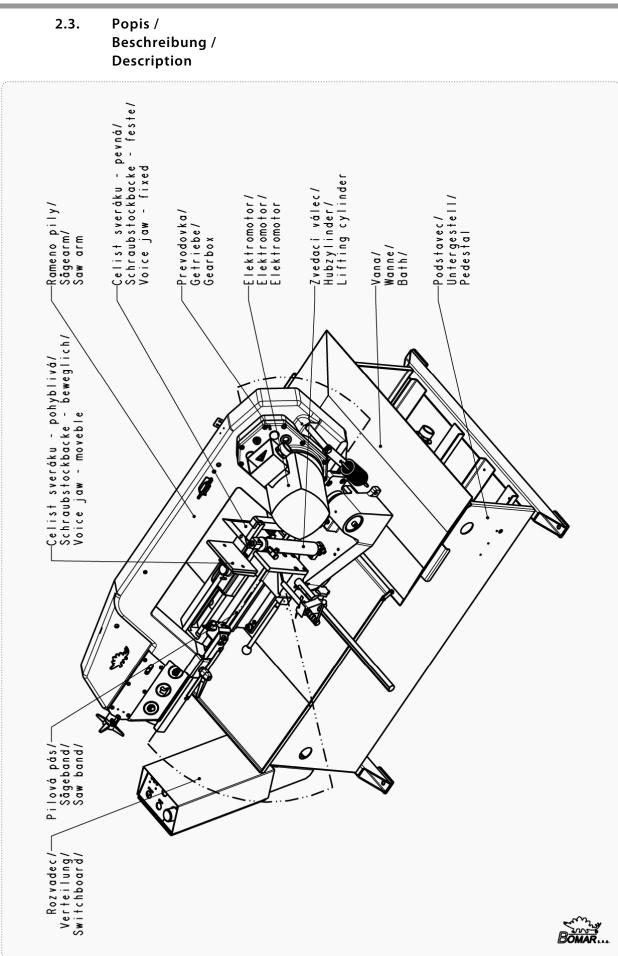
2.2. Rozměrové schéma / Aufstellzeichnung / Installation diagram



Dokumentace stroje Dokumentation der Maschinen Machine documentation



Dokumentace stroje Dokumentation der Maschinen Machine documentation





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.

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

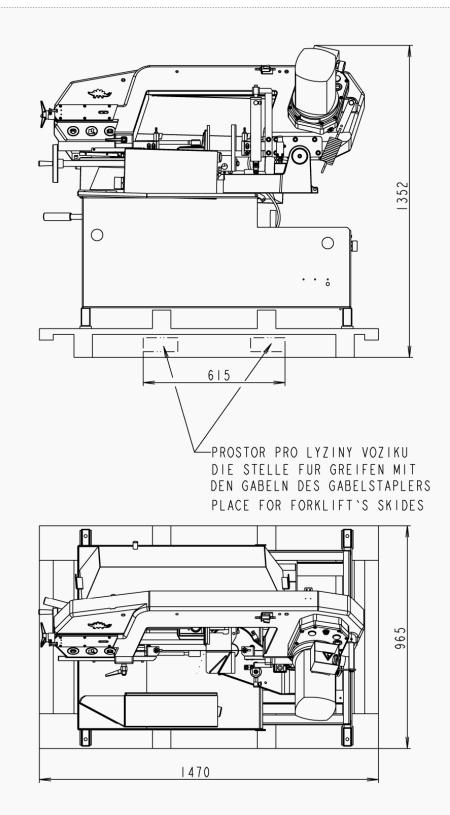
The machine must be secured during transportation. Screw on the palette to the floor of the van or the trailer. Be careful that the machine is not damaged during transportation. Store the machine only under conditions mentioned in the manual, to avoid damage of the machine.

It is forbidden to handle the machine any other way, than it is written in this operating instructions, the machine can be damaged.



Dokumentace stroje Dokumentation der Maschinen Machine documentation

2.4.4. Transportní schéma / Transport schema / Transport scheme







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:

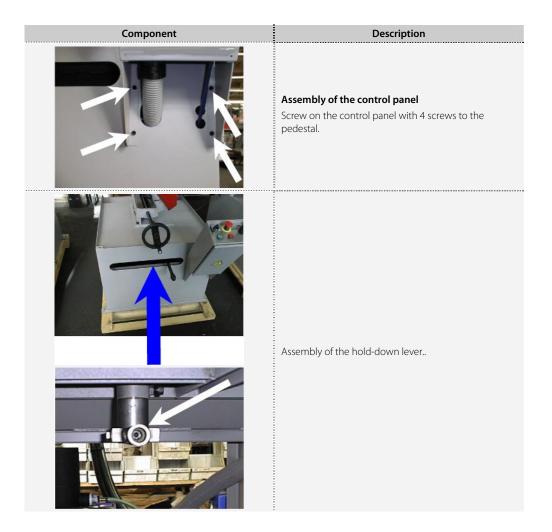
- At temperature air from **5°C to 40°C**, the temperature average during 24 hours must **not exceed over 35°C**.
- At relative dampness of the air in the extend from 30% to 95% (not concentrate)
- Altitude lower than 1000 metres.
- Do not expose the machine to the radiation (for example microwave radiation, 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

Remove the packing from the machine and unpack all parts.

Attention!

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







Description

Hand wheel assembling

Take down the nut from holder of the hand wheel. Insert it to the hole on back side of the wheel and screw on the holder.

Length stop assembly

- 1. Take on the length stop to the hole on vice side.
- 2. Shift the length stop till the saw band (arrow 1) and set the scale to the value $_{n}0^{"}$ (arrow 2).
- 3. Secure it with screw on the bottom side of the vice.

Drainage metal plate installing

Install drainage metal plate on the backside of the band saw.

Lifting spring assembly

- 1. Lift the saw arm up.
- 2. Unscrew the screw and remove the washer from the holder.
- 3. Put together the spring and draw bar. Put the assembly on the holder and the console
- 4. Put the washer on the holder and screw on the screw.



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 – Ergonomic 320.250 G – 345 kg

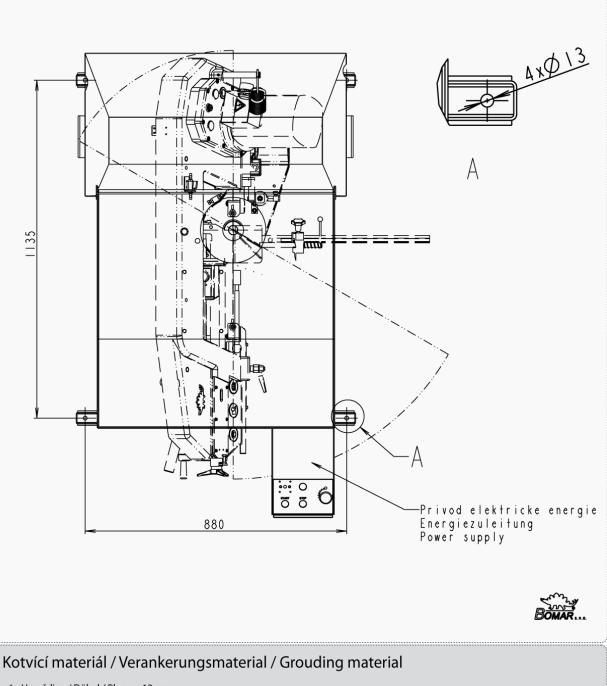
- + weight of accessories
- + maximum weight of material
- The machine must be levelled at the horizontal position. All feet of the machine must touch with the floor after levelling
- The machine must be levelled by means of the calibrated spirit level. Spirit level is put on the vice area. Set the roller 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. 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.



2.6.3. Kotevní plan / Verankerungsplan / Grounding plan



• 4× Hmoždina / Dübel / Plug – ø12 mm

- Vrtáno do hloubky / In die Tiefe gebohrt / Drilled to 140 mm
- Šrouby / Schraube / Screws M12
- Šrouby podložit deskami o min. rozměrech P10×100-100
- Die Schrauben mit Platten mit Minimaldimensionen P10×100-100 unterlegen

Screew 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



2.7. 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:
 - Total input / Max. fuse: 1,7 kW / 16 A

~ 3×400 V, 50 Hz, TN-C-S

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 values of the crosscut of the conductor and the rated current are in the norms.

Connect the service cable of the machine on the clamps of the electric distribution.

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 kW.

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 main switch becomes primary and the main switch on the machine has only secondary function.

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.

2.8. 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.



2.9. 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.

2.10. Saw band

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

2.10.1. Saw band size

2910×27×0,90 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

1. *Constant tooth system* – the saw band has parallel tooth pitch all over length. This way is suitable for cutting of solid material.

BOMAR for recommended Variable tooth system for band saw.

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 regrinding saw bands too.

2.10.4. Tables for teeth selection

	SHAPED MATERIAL (D _p , S = mm)						
Dp S	Dp S	Dp			s		
				or cutting of more pieces			
	s double size of the w	all of one profile (tha		ates to 2×S). In table, ther th system (Z₂Z)	e are tooth systems con	stant and variable.	
Size of the wall				er of the profile D _p [i	mml		
S [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 20	-	5–8 S	5–8 S 4–6 K	4–6 K 4–6 K	4–6 K 4–6 K	4–6 K 3–4 K	
20	-	-	4–6 K	4–6 K 3–4 K	4–6 K 3–4 K	3–4 K 3–4 K	
50	-	-	-	/1 +-C -	// +*=C -	3–4 K	
		I				J T N	
Size of the				th system (Z _P Z)	_		
wall				er of the profile D _p [I			
S [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 6–10 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	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	4–0 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	-	-	SOLID MATERIA	0,75–1,25 K	0,75–1,25 K	0,75–1,25 K	
	Constant toot				Variable tooth system		
-	f the cut D	tooth system	(Z _p Z)	length of the cu	t D too	oth system (Z _p Z)	
	8 mm	32		to 30 mm		10-14	
	5 mm 0 mm	24		20–50 mm 25–60 mm		8-12 6-10	
to 10 mm to 15 mm		18		35–80 mm		5-8	
	i0 mm	14		50–100 mm		4-6	
	i0 mm	8		70–120 mm		4-5	
	0 mm	6		80–150 mm		3-4	
80-12	20 mm	4		120–350 mm		2-3	
120-2	.00 mm	3		250–600 mm		1,4-2	
200-4	400 mm	2		500–3000 mm	nm 0,75–1,25		
	800 mm	1,25					
700-30	000 mm	0,75					



Ovládání stroje Bedienung der Maschine Machine control



Ovládání stroje Bedienung der Maschine Machine control

3. Machine control

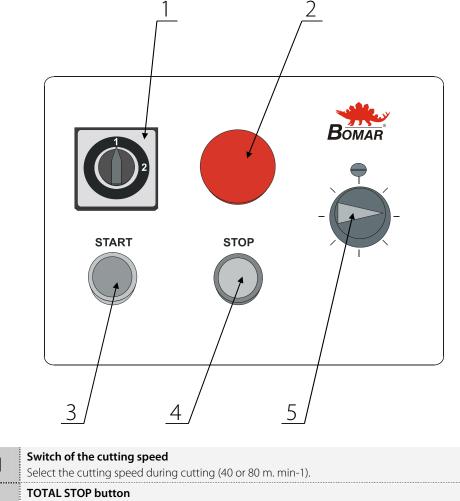


3.1. Control elements



Main switch It is on the vice side of the distributing box. It is not depicted on the diagram.





1	Select the cutting speed during cutting (40 or 80 m. min-1).
2	TOTAL STOP button In case of emergency, the machine is stated to the order! ATTENTION! By pressing button TOTAL STOP is not stopped saw frame sinking!
3	START Start of the saw band drive.
4	STOP Stop of the saw band drive.



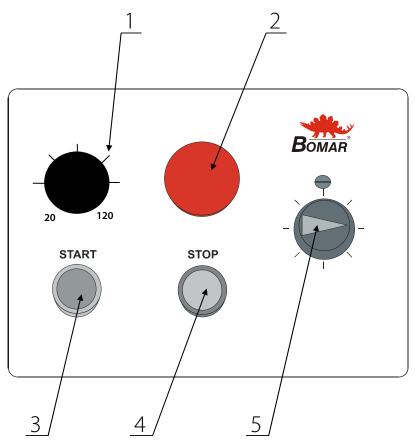
Governing valve

5

Adjust the speed of the arm sinking to the cut by governing valve.

Notice: If you keep closing the throttle valve too tightly, the valve seat may wear off which causes its leakage. Therefore, close the valve always gently.

3.1.2. Ergonomic 320.250 G with frequency converter



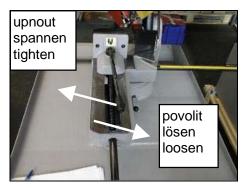
1	Switch of the cutting speed Select the cutting speed during cutting (20–120 m. min ⁻¹).
	TOTAL STOP button
2	In case of emergency, the machine is stated to the order!
	ATTENTION! By pressing button TOTAL STOP is not stopped saw frame sinking!
С	START
2	Start of the saw band drive.
Л	STOP
4	Stop of the saw band drive.
	Governing valve
5	Adjust the speed of the arm sinking to the cut by governing valve.
5	Notice: If you keep closing the throttle valve too tightly, the valve seat may wear off which causes its leakage. Therefore, close the valve always gently.
	causes its leakage. Therefore, close the valve always gently.



3.2. Machine control

3.2.1. Cutting

- 1. Open the vice of the band saw.
- 2. Set the length stop to the desired length of the material.
- 3. Set the desired cutting angle.
- 4. Insert the material and pull it to the length stop.



- 5. Pull vice jaws about 5 mm from the material by hand wheel.
- 6. Tighten the material by the clamping lever.
- 7. Set the saw band speed.
- 8. Start saw band drive by button START.

Note:

Saw band drive is possible to stop by button **STOP** or by button TOTAL STOP in emergency causes during cutting. **ATTENTION!** Saw frame sinking is possible to stop by governing valve closing! By pressing button TOTAL STOP **is not stopped** saw frame sinking!

- 9. Set the speed of the saw frame sinking.
- 10. Close the governing valve of the frame sinking and lift the saw frame to the top position after cutting
- 11. Remove the cut. Now you can repeat whole progress.

3.2.2. Setting of the material length

Release the securing screw, move the length stop on the desired length of the material and fasten the securing screw.



Note:

The length stop makes bounce listel of the material, so that the saw band will be not compressed in the cut. Turn the lever to the arrow direction..

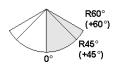


3.2.3. Cutting speed adjustment

Picture	Description
Ergonomic 320.250 G without freq. converter	 speed 40 m.min⁻¹ – turn speed switch into pos. no. 1 speed 80 m.min⁻¹ – turn speed switch into pos. no. 2
Ergonomic 320.250 G with freq. Converter	 Change bansaw speed by frequency converter in range 20–120 m.min⁻¹.

3.2.4. Angular cut setting

The cut angle can be varied from **0°** to **60°**. The angles **0°**, **+45°** and **60°** is set by means of the fixed stop.



Picture	Description
povolit lösen loosen utáhnout festziehen tighten	 Loosen the saw arm and release-securing lever of the console.
	 Set the desired angle of the cut. If you want set the cut angle bigger then 45°, pull out the stop pin.
	3. Turn the saw frame to the desired angle according to the scale on the turning console and tighten the securing lever of the console.

3.2.5. Optimal adjusting of the guide cubes span

If you want to achieve a smooth and precise cut, it is helpful to position the guide cube as close as possible to the material.



Ovládání stroje



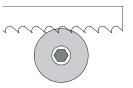
- 1. Release the lever of the left listel and move left part of the guide apparatus so that the left guide cube edge is as close to the cut material as possible.
- 2. Lower the frame to the lower position and check the position of the guide cube towards vice loading area. The guide cube must be a distance of at least 10 mm from the vice loading area.
- 3. Tighten the lever of the gib and check the guide cube setting once more for possible collision with binding table or vice jaw.

3.2.6. Brush adjustment

The brush has essential influence on cutting performance, saw band lifetime and lifetime of wheels and hard metal guides and finally cut accuracy. Therefore the brush has to be checked during every shift.



- 4. Release the tightening screw of the brush so that it is possible to move with the brush.
- 5. Get the brush closer to the saw band teeth. After the brush is set, its ends must not reach the saw band teeth bottoms.
- 6. Tighten the screw again and turn on the band driver.
- 7. If the chip removing brush is correctly fastened the brush moves and turns smoothly with the saw band.



3.3. 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!

3.3.1. 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!



Machine control

Bedienung der Maschine

Ovládání stro

3.3.2. 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!

3.3.3. Bundle material cutting

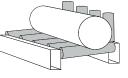
If you want to cut the material in the bundle, there are suggestions for the positioning of bundles

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.



Údržba stroje Wartung / Machine service



Údržba stroje Wartung Machine service

4. Machine service



4.1. Saw band dismantling

1. Lift the saw frame to the top position. Stop the saw frame in top position by control valve.



2. Dismantle yellow protective cover of the saw band. The cover is clamped with two screws.



3. Dismantle back covering sheet metal of the saw frame. The covering sheet metal is clamped with two screws with plastic head.



4. Release brush holder and turn it. The brush must not defend saw band dismantling.



5. Turn by stretching star to the left side, release saw band stretching and pull saw band from blade wheels.







6. Pull up the saw band from the guiding cubes.

4.2. 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 fit tightly to the wheel rim. Then push the saw band as far back as possible.
- 4. By turning the stretching star to the right, you will stretch the saw band slightly.



5. Put the brush into the function position and screw up the holder.





6. Install the rear protective cover of the frame.



7. Install the yellow protective cover of the band. The arrow on the cover must match the direction of the arrow on the band. If it does not, you must turn the band round.

4.3. 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.

4.3.1. Saw band stretching

1. The saw band must not fall from the wheels after setting.



- 2. Install the Tenzomat on the saw band and secure it with screws.
- 3. Stretch the saw band until it is stretched to the recommended value.

4.3.2. 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.

4.4. 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	 corrosion protection is diminished 	• the cooling ability is decreased
•	impurity		foam behaviour increases
•	outside oil contamination (hydraulics, gears)	 Iubrication decreases microbial attack is more likely 	emulsions stability deterioratessticky residue develops
•	high operating temperatures		
•	lack of air circulation		

- wrong concentration

4.4.1. 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.

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



Testing	Interval	Method	Condition	Precaution		
Foam reaction	when necessary	Shaking test		avoid aeration, increase water hardness, ix with defoamer		
* according to manufacturers' instructions						

* according to manufacturers' instructions

4.4.2. 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 microspray installation, the chips must also be handed over to a disposal company.

4.5. Greases and oils

4.5.1. 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.

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

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!

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

Band saw	Gearbox oil	Capacity
Ergonomic 320.250 G	Paramo PP7	21
Swarf conveyer	Shell Tivela S 320	0,075 l

Comparative table of the gearbox oils

Manufacturer	Viscosity grade						
Manufacturer	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 MW 100	Alpha SP 220 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				

4.5.2. 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
	FETT EGL 3144
Esso	Beacon EP 1
	Beacon EP 2
FINA	FINA LICAL M12
	Microlube GB0
Klüber	Staburags NBU8EP
	Isoflex Spezial
Optimol	Optimol Longtime PD 0, PD1, PD2
Shell Aseol AG	ASEOL Litea EP 806-077
Техасо	Multifak EP1

4.5.3. Lubrication

Na stroji se vyskytuje několik uložení, která je nutno pravidelně promazávat, aby byla zajištěna správná funkce stroje.

Lubrication place	Description
	The upper pivot of the lifting cylinder – drop the oil once a week.

4.5.4. Hydraulic oils

Replace the hydraulic oil once in 2 years, 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.

Use oils with specification DIN 51524-HLP, ISO 6743-4 and viscosity grade ISO VG 46 in hydraulic aggregates.

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!

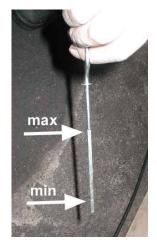


Comparative table of the hydraulic oils:

Manufacturer	Туре	Manufacturer	Туре
Agip	Oso 46	Ina	Hidraol 46 HD
Aral	Vitam GF 46	Klüber	Lamora HLP 46
Avia	Avilub RSL 46	Hungary	Hidrokomol P 46
Benzina	OH-HM 46	Mobil	Mobil DTE 25
BP	Energol HLP 46	ÖMV	HLP 46
Bulgaria	MX-M/46	Poland	Hydrol 30
Castrol	Hyspin AWS 46	Rumania	H 46 EP
Čepro	Mogul HM 46	Russia	IGP 30
DEA	Astron HLP 46	Shell	Tellus Oil 46
Elf	Elfolna 46	Sun	Sunvis 846 WR
Esso	Nuto H 46	Техасо	Rando HD B 46
Fam	HD 5040	Valvoline	Ultramax AW 46
Fina	Hydran 46		

4.5.5. 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
- Cheb 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						2
Change interval	-	-	-	-	-	-
Other checks						



Interval	daily	weekly	monthly	three monthly	six monthly	annually
External Leakages	•	-	-	-	-	-
Contamination	•	-	-	-	-	-
Damages	•	•	-	_	-	_
Noise-(level)			_	_	_	_
Gauges	-	-	•	-	-	-

4.6. 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 main and feeding vice.
- The guiding of the feeder.
- Loading surface of the main, feeding vice, and area under them.
- Threaded bar of the main and feeding vice.

4.7. Worn pieces replacement

4.7.1. Hard metal guides replacement

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



1. Remove the hosepipe leading to the cooling agent and dismantle saw band and saw band guiding cube.



2. Fasten the guiding cube to the vice and screw out the screws of both the hard metal desks.





- 3. Screw out the adjusting screw of the adjustable guiding desk as far from the guide cube so that it is not possible to see it from the inner side.
- 4. Now insert new hard metal guides and fasten them tightly and fasten the guide cube to the gib.
- 5. Install the saw band and adjust guide cube and hard metal guides.

Attention!

Vice must has aluminum jaws or should be placed in a vice aluminum produc, that avoid damage to the pin during clamping.

4.7.2. Saw band guiding rollers replacement

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

Attention! Guiding rollers must be replaced together on both guide cubes!



1. Remove the hosepipe leading to the cooling agent and dismantle saw band and saw band guide cube.



2. Grip the guide cube in the vice and screw out both fastening screws of the eccentrics.

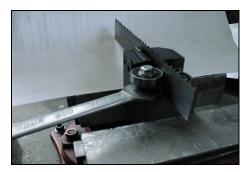




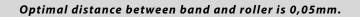
3. Pull both guide rollers from their eccentrics.



4. Put new guide rollers on the eccentrics and screw the eccentrics to the guide cube.



5. Now insert a test piece of saw band (cca 15 - 20 cm) into the guide cube. Adjust both eccentrics so that the band runs in the middle of milled groove. This groove is located between both eccentrics. Guide rollers may not press too much on the band, but they must spin freely.



6. Install the cube on the gib. Install the saw band and adjust guiding cubes.

Attention!

Vice must has aluminum jaws or should be placed in a vice aluminum produc, that avoid damage to the pin during clamping.

4.7.3. Round brush replacement

If the chip removing brush is so worn, that it does not fulfil its function, the brush must be replaced.





- 1. Release the nut of the brush, exchange old brush to new brush and screw on the nut of the brush.
- 2. Set the brush to the saw band.

4.7.4. Stretching wheel replacement

3. Dismantle the saw band.



- 4. Screw off the screw of the stretching wheel and pull off the washer.
- 5. Screw on the auxiliary screw to the shaft of the stretching wheel.



6. Put on the three-leg puller on the stretching wheel and pull off it from the shaft.



7. If the lower bearing stays on the shaft, pull of it from the shaft with two-leg puller. Check both bearings; eventually replace them for a new.





- 8. Insert the retaining ring to the hole in the new stretching wheel.
- 9. Insert the bearing to the hole in the wheel and push it to the retaining ring.



10. Clean the shaft and oil it. Install the new stretching wheel on the shaft.



11. Install the distance ring on the shaft and push it to the lower bearing.



12. Install second bearing on the shaft and push it to the distance ring.





- 13. Install the washer and screw on the stretching wheel.
- 14. Install the saw band. Wheel replacement is ready.

4.7.5. Driving wheel replacement

1. Dismantle the saw band.



2. Screw of the fastening screw of the driving wheel and pull off the washer.



3. Screw on the auxiliary screw to the driving shaft.



4. Install the three-leg puller on the driving wheel and pull off it from the shaft.





5. Check, if the feather and the driving shaft are not damaged. Contact your supplier for parts replacement.



6. If the shaft and the feather are in good order, clean them, oil them and install them on the driving shaft.



- 7. Install the washer and screw on the driving wheel.
- 8. Install the saw band.

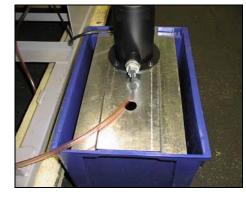
4.7.6. Cooling pump replacement

Only a qualified worker can carry out the connection! High-voltage shock may have fatal results.



1. Pull out the cooling agent tank from the machine base as far as possible.

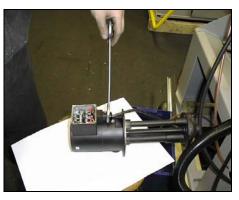




2. Remove the hosepipe leading the cooling agent from the connection on the pump. Unscrew four screws on the cooling pump flange and pull out the pump from the metal sheet holder.



3. Remove the cover of the pump terminal switchboard. Disconnect 4 terminal connectors of the input cables. Cables are identified according to the red clamps.



4. Loosen the bushing and pull the cable out from the pump.



5. Dismantle new pump switchboard cover. Push the cable through the bushing and fasten it.



5. Závady / Troubleshooting



Problem **Possible causes** Repair Set according to the chapter "Servicing and Wrongly adjusted hard metal guides. adjustment" Worn hard metal guides. Replace to the chapter "Worn pieces replacement" Wrongly adjusted cubes of the saw Set according to the chapter "Servicing and band guiding. 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. Slanting cut 6. Wrongly chosen tooth system of the Replace the saw band and keep the instructions of manufacturer on new saw band choice. saw band. 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 Clamp the guiding arm. loosened. Guiding arm and cube are too far from Set the guiding cube to the material. the material Too fast cutting rate. Lower the material feeding speed. Unexpected oscillation in material Set the cut and feeding speed to the relevant quality. 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". 7. The cut is not cut upon desired angle 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 Fasten the guiding arm and the cube. loosened. Dirt between material and clamping Cleanse the material and mating jaw. 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". Check the swarf brush condition and replace it in Worn swarf brush. 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" Short lifetime of the 8 Over stretched saw band saw band Lower stretching of the saw band and set the limit switch of the saw band stretching according to chapter "Servicing and adjustment" Check the adjustment of the hard metal guides Wrongly adjusted hard metal guides. and carry out adjustment as described in chapter "Servicing and adjustment" Worn hard metal guides of the saw Check the condition of the hard metal guide and if it is too worn, replace hard metal guides band according to chapter "Worn pieces replacement"

5.1. Mechanical problems



	Problem		Possible causes	Repair
		-	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"
		-	Worn saw band.	Replace the saw band and keep instructions of the manufacturer on the choice.
9.	Insufficient cut output.	-	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.
10.	The cut is not finished.	-	Wrongly adjusted lower stop point of the saw frame.	Check lower limit switch and screw.
10.		-	Stop point surface is messed-up.	Cleanse stop point surface of the limit switch from debris and residue material.
11.	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.
	possible turn	-	Metal clams are in body of valve.	Valve must be cleared or changed.
12.	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.
13.	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 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.
14.	Damage tooth system of the saw band	-	In gripping the lifting cylinder is backlash.	
	of the saw band	-	Squeezed pin upper or downer holder of the lifting cylinder.	Exchange complete upper or downer holder of lifting cylinder.
15.	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.
16.	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.



	Problem		Possible causes	Repair
		-	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.
1	The saw arm periodically rise and fall during the cut; this cause short lifetime of the saw band.		Backslash 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.	

5.2. Electric problems

	Problem		Possible causes	Repair
18.	Machine is not	-	In socket is not voltage	Line voltage must be checked.
	possible start.	-	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.
19.	When cut is finished, the frame is not	-	Bottom limit switch is adjusted wrong.	Bottom limit switch must be adjusted according to chapter ADJUSTING.
	raising.	-	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.
20.	Electric motor and pump are without voltage. Between contactor and thermal protector is not voltage.	-	Wrong contactor.	Replace contactor of engine.
21.	The indicator of speed	-	Sensor of speed is not adjusted.	Sensor of speed must be adjusted.
	saw band is not functional.	-	Defective display	The display must be changed.
	Tunctional.	-	Wrong sensor – diode of indicator speed is not light.	Sensor must be changed and adjusted.
22.	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.
23.	The hydraulic aggregate cannot be started		Auxiliary contact on thermo-relay FA1 is defective.	Replace the defective contact on motor starter FA1.
24.	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.
25.	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.



5.3. Hydraulic problems

Problem	Possible causes	Repair
26. 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.
27. 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
28. Increased mechanical noise	damaged joint drive	Call service
	damaged or destroyed motor bearings	Call service
	• air intake	Check for leaks.
29. 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
30. 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
31. Overheating oil	cooler malfunction	Check the cooler function or call service.
	wear the pump, the energy is converted into heat	Call service
32. 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



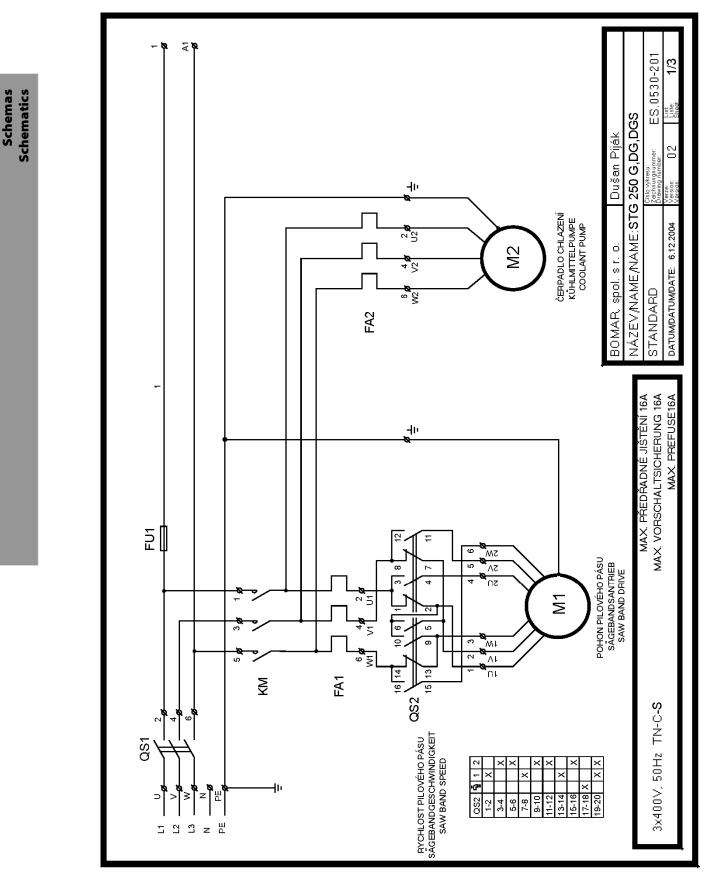


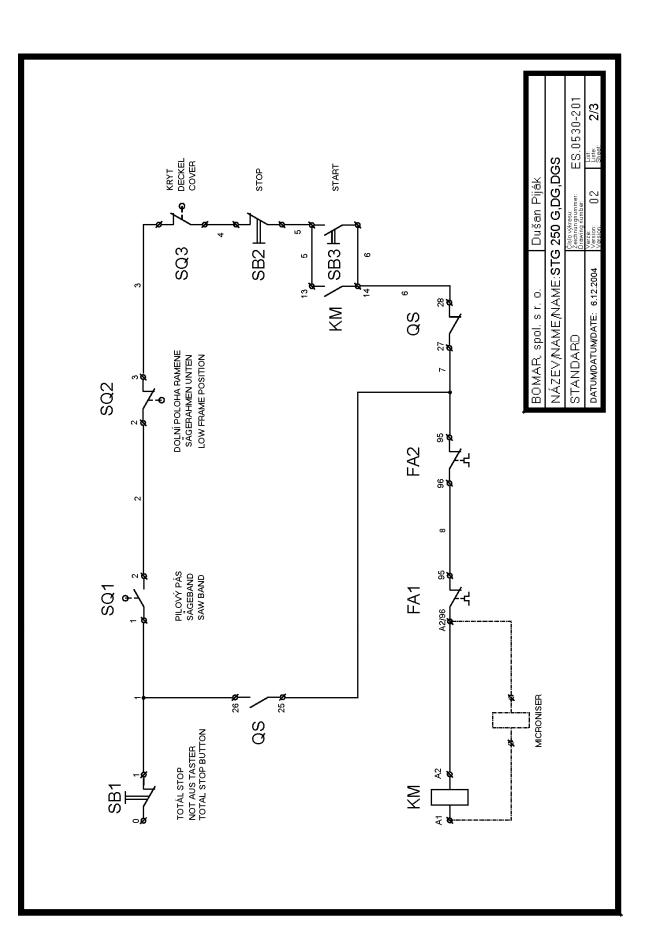
Schémata / Schemas / Schematics



Schémata

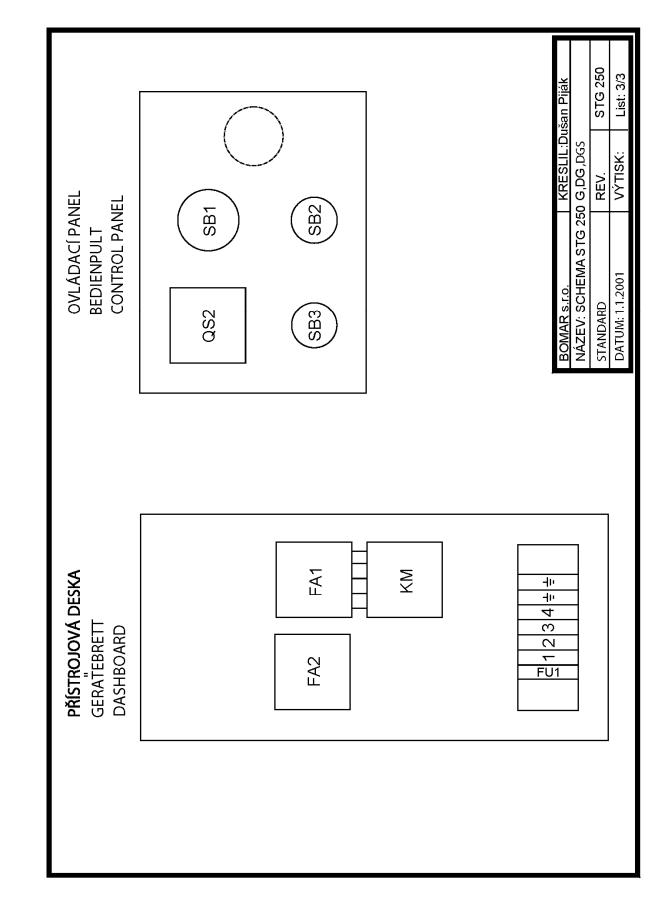
6.1. Elektrická schémata / Elektroschemas / Wiring diagrams – bez frekv. měniče / ohne Frequenzumrichter / without frequency convertor – 3×400 V/50 Hz, TN-C-S









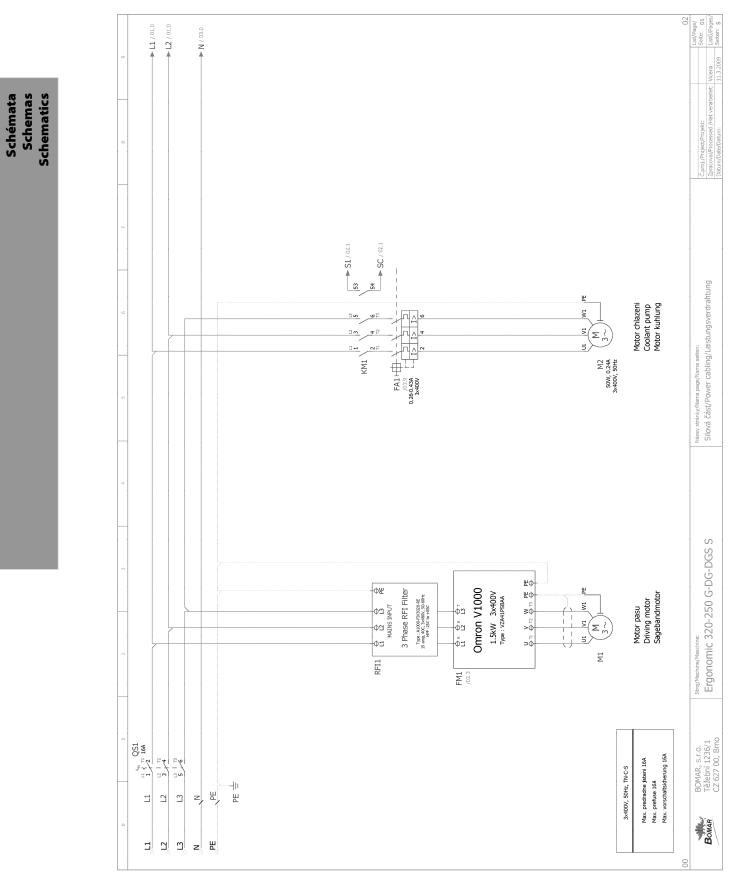


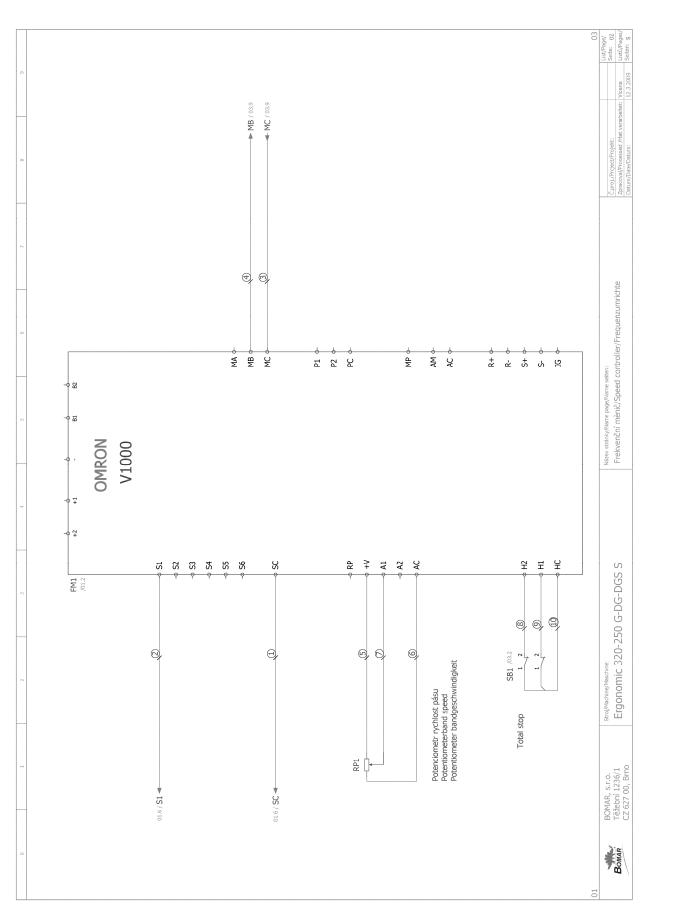


Objednací číslo	Název položky		Ozn.	ks
Bestell - Nr.	Bezeichnung		Signatur	Menge
Reference No.	ltem		Sign.	Pcs.
91.001.007	Elektromotor / Elektromotor / Electromotor	TM902/4 B5	M1	1
91.020.006	Čerpadlo chlazení / Kühlmittelpumpe / Coolant pump	3COA2-22H	M2	1
91.040.001	Stykač / Schaltschütz / Contactor	9A 230V	KM	1
91.050.003	Relé tepelné / Electro thermal relay / Thermorelais	0.26-0.43A	FA2	1
91.050.009	Relé tepelné / Electro thermal relay / Thermorelais	3.0-4.7A	FA1	1
91.060.012	Hlavice TOTAL STOP / NOT-AUS Taste / Total stop jugulum	ZB5AS844	SB1	1
91.061.006	Kontakt rozp.+adapt. / Schaltkontakt / Expand.+adapt. contact	ZB5AZ102	SB1	1
91.060.015	Hlavice rudá / Kopf – rot / Red jugulum	ZB5AA4	SB2	1
91.061.006	Kontakt rozp.+adapt. / Schaltkontakt / Expand.+adapt. contact	ZB5AZ102	SB2	1
91.060.014	Hlavice zelená / Kopf – grün / Green jugulum	ZB5AA3	SB3	1
91.061.007	Kontakt spín.+adapt. / Schaltkontakt / Switch.+adapt. contact	ZB5AZ101	SB3	1
91.170.003	Spínač vačkový / Schalter / Cam switch	194L-E16-1753	QS1	1
91.180.001	Deska spínače černá / Schalterplatte – schwarz / Black board of the switch	194L-HE4E-175	QS1	1
91.171.006	Spínač vačkový / Schalter / Cam switch	S10-60129	QS2	1
91.173.012	Spínač konczámek / Endschalter / Limit switch-lock	QKS8	SQ3	1
91.173.007	Spínač koncový / Endschalter / Limit switch	Pizzato	SQ1,2	2
91.230.001	Pojistka / Sicherung / Fuse	2A	FU1	1
91.190.004	Krabice elektro / Buchse / Box			1



6.2. Elektrické schema / Elektroschema / Wiring diagrams – Erg. 320.250 G-F/DG-F/DGS-F, 3×400 V TN-C-S

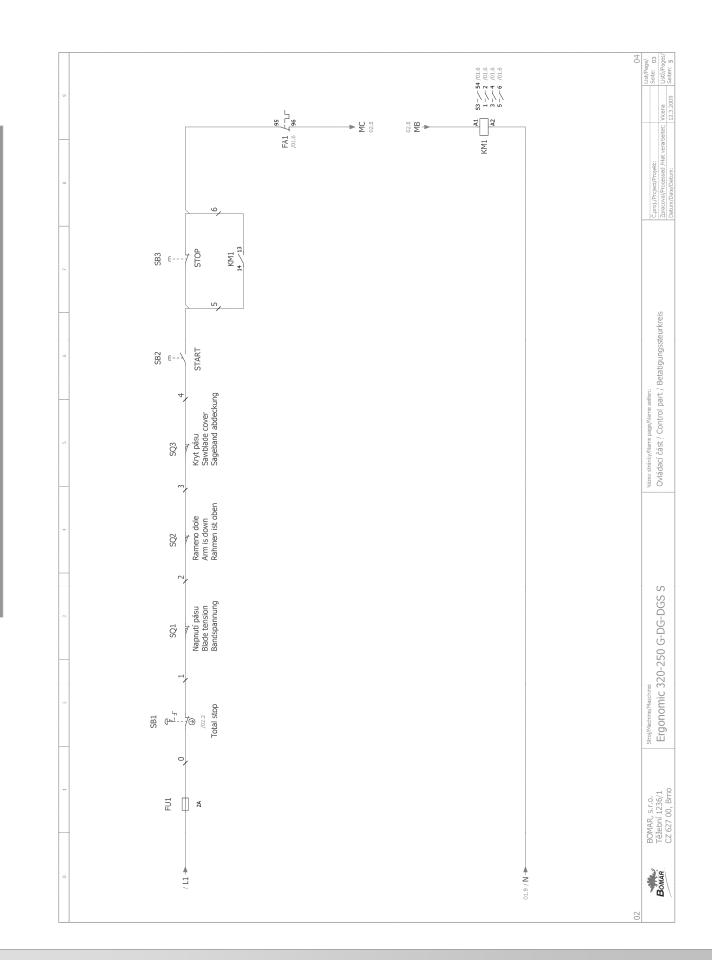




BOMAR



Schémata Schemas Schematics



Kusovník artiklů ^{Označení přístroje}						
usovník artiklů _{zračení přístroje}						
)značení přístroje Typ přístroje						
		Objednací ďslo	Výrobce	Skladové číslo	Množství	Umístění (strana.sloupec)
-FA1 Tepelná ochrana 0,26 - 0,43A	0,43A	MT03C	GE	91.050.003		/01.6
-FM1 Frekvenční měnič 1,5kW		VZA41P5BAA	OMRON	91.012.026		/02.3
-FU1 Pojistkové pouzdro		WK4/THSi5U	WIELAND	91.251.102		/03.1
-FU1 Pojistka trubičková 2A, 5x20	5×20	F2A/250V	ESKA	91.230.001		/03.1
-KM1 Pomocný kontakt ke stykači	kači	MARN422AT	GE	91.041.005	yest	/01.6
-KM1 Stykač 230V AC, 9A		MCIA 10E	Ш	91.040.001		/03.9
-M1 Motor Pásu		TM 90 2S B5		91.001.027	yest	/01.2
-M2 Čerpadio 50W, 0.24A 3x400V, 50Hz	400V, 50Hz	2C0P1-22 HP1		91.020.006		/01.6
-QS1 Hlavní vypínač 16A		P016	GIOVENZANA	91.170.003	1	/01.1
-QS1 Hlavní vypínač-ovládání		SE 16	GIOVENZANA	91.180.001		/01.1
-RFI1 Filtr k frekvenčnímu měniči 1,5kW	niči 1,5kW	A1000-FIV3010-RE	OMRON	91.012.027	ved	/01.2
-RP1 Potenciometr 4k7		TP195 4k7-N20A	TES-Ostrava	91.283.002		/02.1
-RP1 Svorka rychloupinaci		Svorka rychloupinaci	WIELAND	91.250.009	e	/02.1
-SB1 Hlavice hřibového ovládače	ače	ZB5 AS844	TELEMECANIQUE	91.060.012	1	/03.2
-SB1 Rozpínací kontakt s adaptérem	Dtérem	ZB5AZ102	TELEMECANIQUE	91.061.006		/03.2
-SB1 Rozpínací kontakt		ZBE-102	TELEMECANIQUE	91.061.008	2	/02.2
-SB2 Hlavice zelená		ZB5AA3	TELEMECANIQUE	91.060.014		/03.6
-SB2 Kontakt s adaptérem spínací	hací	ZB5AZ101	TELEMECANIQUE	91.061.007	e	/03.6
-SB3 Hlavice červená		ZB5AA4	TELEMECANIQUE	91.060.015	y-4	/03.7
-SB3 Rozpínací kontakt s adaptérem	otérem	ZB5AZ102	TELEMECANIQUE	91.061.006	e-4	/03.7
-SQ1 Koncový spínač		D4N-4A31	OMRON	91.173.007	Y==§	/03.3
-SQ2 Koncový spínač		D4N-4A31	OMRON	91.173.007	quel	/03.4
-SQ3 Bezpečnostní koncový spínač	oínač	QKS8	KEDU	91.173.012	y1	/03.5

Výrobce si vyhrazuje použít ekvivalentní náhrady přístrojů.

Ergonomic 320-250 G-DG-DGS Somar s.r.o.

03 Datum



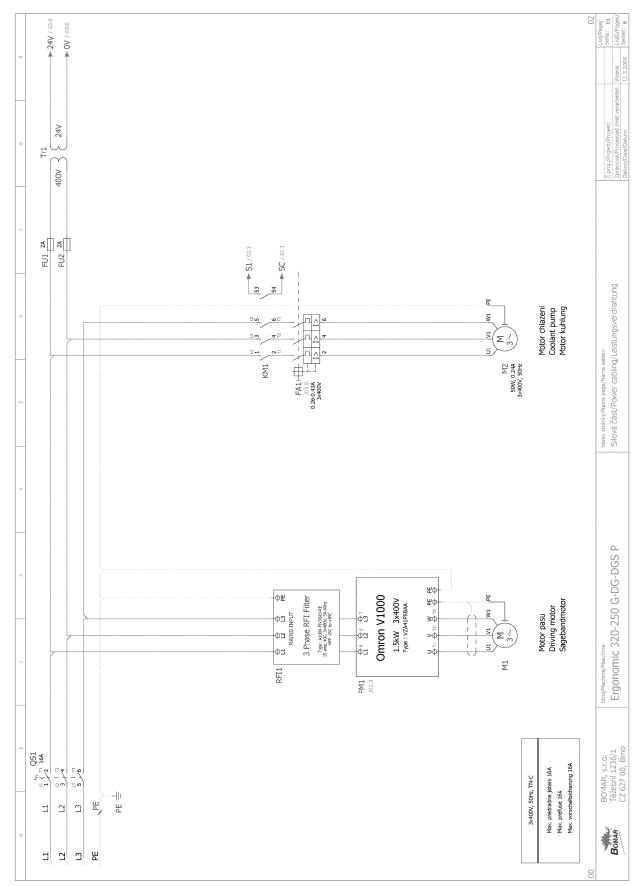


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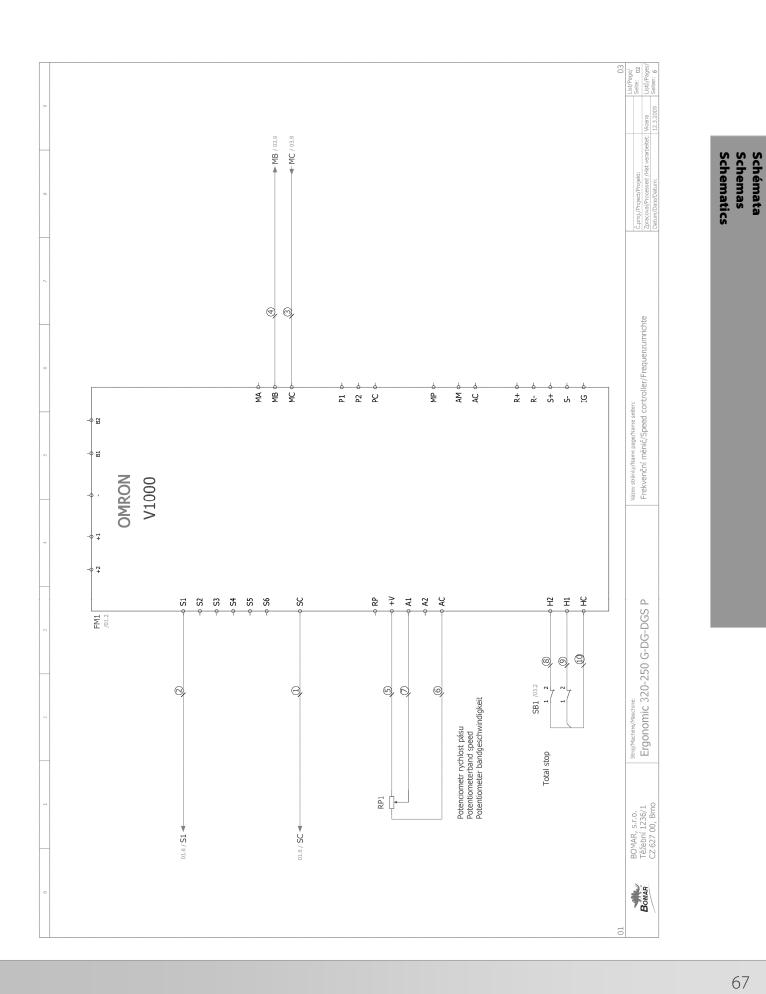
List List



6.3. Elektrické schema / Elektroschema / Wiring diagrams – Erg. 320.250 G-F/DG-F/DGS-F, 3×400V TN-C



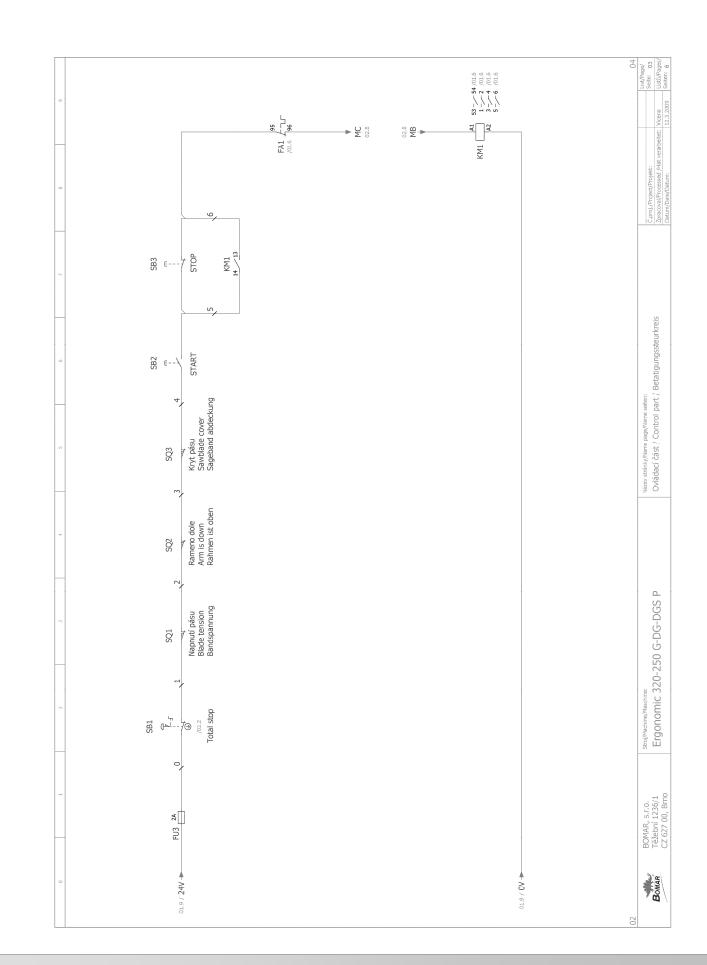
Schémata Schemas Schematics







Schémata Schemas Schematics



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WK4/THSJ5U WIELAND WIELAND 1.251.102 1 F2X/250V ESKA 91.230.001 1 F2X/250V ESKA 91.230.001 1 MARN42ZT E 91.20.001 1 MCJ 10E E 91.001.027 1 MCJ 10E E 91.0001 1 MOL 10E E 91.0001 1 MOL 10E E 91.0002 1 MOL 10E E 100-FIV3010-FE 91.0003 1 MOL 10D-FE MORON 91.0001 1 1 MOL 10D-FE MORON 91.0003 1 1 MOL 10D-FE MORON 91.0001 1 1 MOL 10D-FE MORON 100-FIV300 1 1 MOL 10D-FE MORON 100-FIV300 1 1 MOL 10D-FE MORON 100-FIV300 1 1 MOL 10D-FE FE MORON 10.000 1 1 FE	Width HSU WiELAND WIELAND UI.251.02 1 F2A/250V ESKa 91.230.001 1 MARW22AT ESKa 91.230.001 1 MARW22AT ESKa 91.230.001 1 MARW22AT ESKa 91.230.001 1 MC1A IOE EF 91.640.001 1 TM 90 25 BS POLE 91.640.001 1 ZODT-22 IPPI ET BS 91.60.001 1 DII CODT-22 IPPI ET BS 91.700.05 1 DII ET BS ET BS 91.200.05 1 ADOT-TVJDLE MELAND 91.200.05 1 1 ADOT-TVJDLE MERNAND 91.230.02 1 1 SE 16 COVENZANA 91.230.02 1 1 ADOT-TVJDLE MERNANDA MELAND 91.230.02 1 SE 16 COVENZANA 91.230.02 1 1 ZODT-Z IPIN MELAND MERNANDA 91.000.02 1 <	=U2	Pojistka trubičková 2A, 5x20		F2A/250V	ESKA	91.230.001		/01.7
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MCIA IDE GE 91.064.001 1 TM 90 25 B5 91.001.027 91.001.027 91.001.027 TM 90 25 B5 200P1-22 HP1 91.001.027 91.001.037 91.001.037 PD16 GTOVENZAMA 91.170.003 91.170.003 91.170.003 91.170.003 PD16 GTOVENZAMA GTOVENZAMA 91.170.003 91.130.001 91.130.001 PD16 GTOVENZAMA GTOVENZAMA 91.130.003 91.130.003 91.130.003 91.130.003 91.130.003 91.130.003 91.130.003 91.130.003 91.130.003 91.130.003 91.130.003 91.130.003 91.101 91.101 91.101 91.101 91.101 91.101 91.101 91.101 91.101 91.101 91.101 91.101 91.101 91.101 91.101 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.102.001 91.10	MCIA IOE GE 91.04001 1 TM 90 25 B5 TM 90 25 B5 91.01.027 1 ZCP1-22 HP1 COP1-22 HP1 91.01.003 1 ZCP1-22 HP1 GIOVENZAMA 91.170.003 1 P016 GIOVENZAMA 91.170.003 1 ZE 16 GIOVENZAMA 91.180.001 1 ZE 16 GIOVENZAMA 91.180.003 1 ZE 16 GIOVENZAMA 91.180.001 1 ZE 16 MELAND MELAND 91.180.003 1 ZE 44 TE-MECANIQUE 91.260.004 1 1 ZE 5 X5844 TELEMECANIQUE 91.260.004 1 1 ZE 5 X2102 TELEMECANIQUE 91.260.004 1 1 ZE 5 X2102 TELEMECANIQUE 91.060.005 1 1 ZE 5 X2102 TELEMECANIQUE 91.060.006 1 1 ZE 5 X2102 TELEMECANIQUE 91.060.006 1 1 ZE 5 X2102 TELEMECANIQUE 91.060.006	TWJ	Pomocný kontakt ke stykači		MARN422AT	GE	91.041.005		/01.6
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ZC0P1-22 HP1 2C0P1-22 HP1 91.C20.006 91.20.005 PD16 GT0VENZANA 91.170.003 91.170.003 SE 16 GT0VENZANA 91.180.001 91.000 SE 16 CMRON 91.180.001 91.00 A1000-FIV3010-RE CMRON 91.180.001 91.01 A1000-FIV3010-RE CMRON 91.010.003 91.01 Set 447 TES-Stava 91.233.002 91.01 Softa ychloupinaci TES-Stava 91.020.009 91.01 ZB5 AS844 TELEMECANIQUE 91.060.012 91.060.012 ZB5AZ102 TELEMECANIQUE 91.061.006 91.061.006 ZB5A3 TELEMECANIQUE 91.061.006 91.050.002 ZB5A3 TELEMECANIQUE 91.061.006 91.070 ZB5A4 TELEMECANIQUE 91.051.006 91.070 ZB5A4 TELEMECANIQUE 91.051.007 91.073.007 ZB5A4 TELEMECANIQUE 91.051.007 91.073.007 ZB5A101 TELEMECANIQUE 91.050.007 91.050.007 <	ZC0P1-Z2 HP1 D16 D17-Z2 HP1 D110 D110 <thd10< th=""> D110 D110</thd10<>	41	Motor Pásu		TM 90 2S B5		91.001.027		/01.2
P016 ETOVENZAMA P1.170.003 P1.170.003 P1.180.01 RE 16 GROVENZAMA P1.80.01 P1.80.01 P1. RE 16 GROVENZAMA P1.80.01 P1.80.01 P1. A1000-FIV3010-RE OMRON P1.120.027 P1.91 P1.91 TP195 447-N20A TES-Ostrava P1.283.002 P1.02 P1.02 Svorka rychloupinaci TES-Ostrava P1.283.002 P1.02 P1.02 Svorka rychloupinaci TELEMECANIQUE P1.050.009 P1.050.009 P1.050.009 ZB5 A5844 TELEMECANIQUE P1.060.012 P1.060.012 P1.060.013 P1.050.009 ZB5 A5102 TELEMECANIQUE P1.060.016 P1.060.015 P1.070.009 P1.73.007 <	P016 GIOVENZANA 91.170.003 1 SE 16 GIOVENZANA 91.180.001 1 SE 16 GIOVENZANA 91.180.001 1 A1000-FIV3010-RE OMRON 91.012.027 1 TP195 4K7-N20A TEG-OSTEAva 91.012.027 1 TP195 4K7-N20A TEG-OSTEAva 91.012.027 1 Swirke rychloupinaci TEG-OSTEAva 91.012.027 1 Swirke rychloupinaci WTELAND 91.012.027 1 ZB5 ASB44 TELEMECANIQUE 91.050.009 3 ZB5 ASB10 TELEMECANIQUE 91.061.006 1 ZB5 ASB10 TELEMECANIQUE 91.061.006 1 ZB5 ASB10 TELEMECANIQUE 91.061.006 1 ZB5 ASB10 TELEMECANIQUE 91.061.007 1 ZB5 ASB1 TELEMECANIQUE <td>42</td> <td>Čerpadio 50W, 0.24A 3x400V</td> <td>, 50Hz</td> <td>2C0P1-22 HP1</td> <td></td> <td>91.020.006</td> <td></td> <td>/01.6</td>	42	Čerpadio 50W, 0.24A 3x400V	, 50Hz	2C0P1-22 HP1		91.020.006		/01.6
SE 16 GIOVENZANA 91.180.001 91.180.001 A1000-FIV3010-RE CMRON 91.02.027 91.01.027 TP195 4/7-N20A TES-Ostrava 91.283.002 91.01.01 Svorka rychloupinaci TES-Ostrava 91.283.002 91.001 Svorka rychloupinaci TELEMECANIQUE 91.260.009 91.001 ZB5 A5844 TELEMECANIQUE 91.060.012 91.060.012 ZB5AZ102 TELEMECANIQUE 91.061.006 91.061.006 ZB5A3 TELEMECANIQUE 91.061.016 91.061.007 ZB5A101 TELEMECANIQUE 91.061.006 91.061.006 ZB5A2102 TELEMECANIQUE 91.061.006 91.061.007 ZB5A101 TELEMECANIQUE 91.073.007 91.073.007 ZB5A44 TELEMECANIQUE 91.073.007 91.073.007 ZB5A44 TELEMECANIQUE 91.073.007 91.073.007 ZB5A44 CMON 91.073.007 91.073.007 ZB5A44 CMON 91.073.007 91.073.007 ZB5A44 CMON 91.073.007 91.073.007 ZB5A44 CMON 91.073.007	SE 16 GIOVENZANA 91.180.001 1 A1000-FLY3010-RE OMRON 91.012.027 1 A1000-FLY3010-RE OMRON 91.012.027 1 TP195 4K7-N20A TES-Ostrava 91.263.002 1 Svorka rychloupinaci TES-Ostrava 91.263.002 1 Svorka rychloupinaci TELEMECANIQUE 91.260.009 3 ZB5 AS844 TELEMECANIQUE 91.060.012 1 ZB5 AS102 TELEMECANIQUE 91.060.012 1 ZB5 AS102 TELEMECANIQUE 91.061.006 1 ZB5 AS102 TELEMECANIQUE 91.061.007 1 ZB5 AS102 TELEMECANIQUE 91.061.007 1 ZB5 AS101 TELEMECANIQUE 91.061.007 1 ZB5 AS101 TELEMECANIQUE 91.061.007 1 ZB5 AS101 TELEMECANIQUE 91.051.007 1 ZB5 AS102 TELEMECANIQUE 91.051.007 1 ZB5 AS102 TELEMECANIQUE 91.051.007 1 ZB5 AS102 <t< td=""><td>051</td><td>Hlavní vypínač 16A</td><td></td><td>POI6</td><td>GIOVENZANA</td><td>91.170.003</td><td></td><td>/01.1</td></t<>	051	Hlavní vypínač 16A		POI6	GIOVENZANA	91.170.003		/01.1
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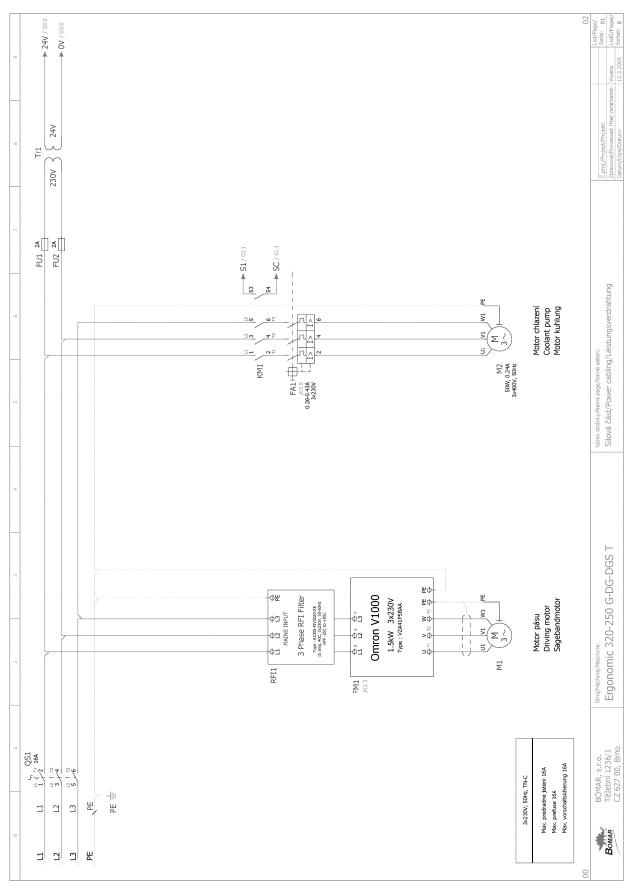


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Kusovník artiklů



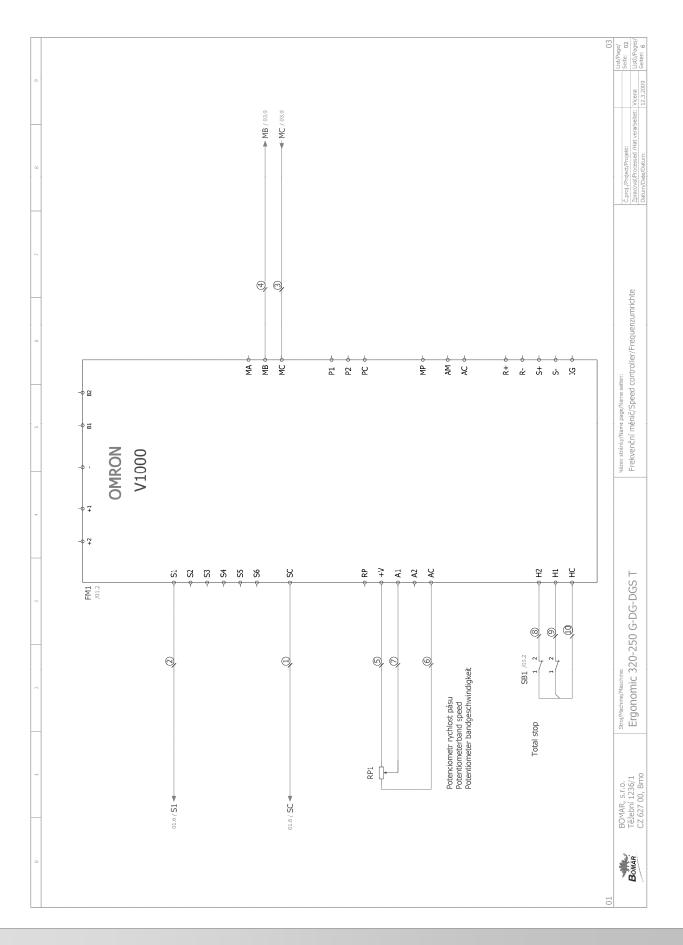
6.4. Elektrické schema / Elektroschema / Wiring diagrams – Erg. 320.250 G-F/DG-F/DGS-F, 3×230 V

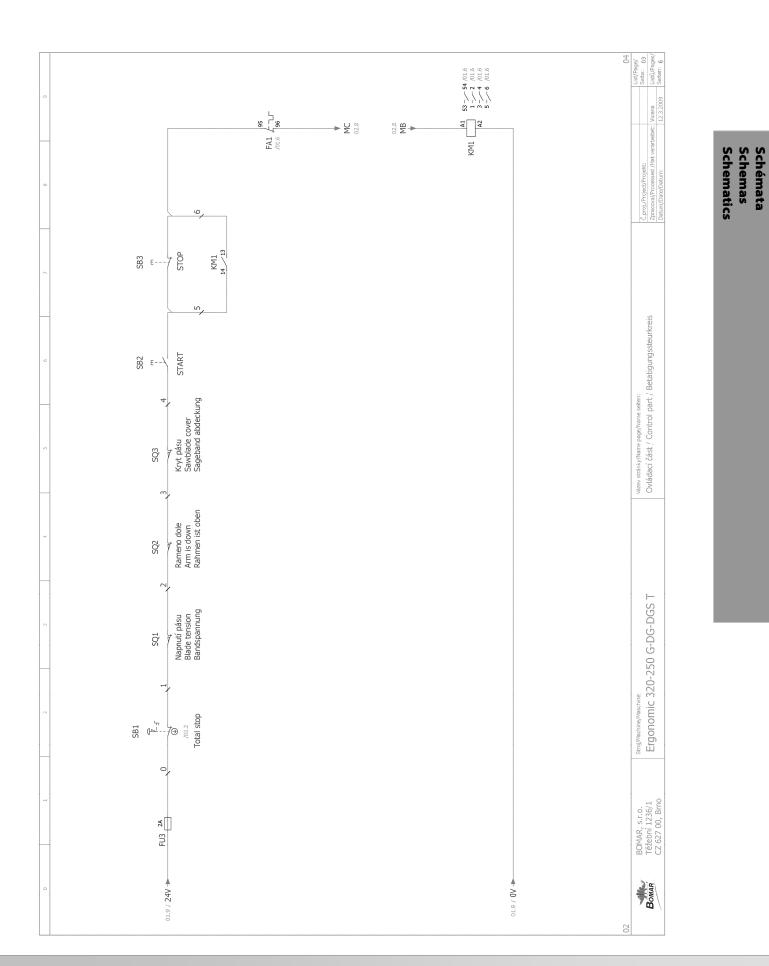


Schémata Schemas Schematics

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Schémata Schemas Schematics

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Havrit vypinač-ovládníEI 6GIOVENZANAFilty K feckvenčním měniči 1,5KWA1000-FTV3010-REOMRONFilty K feckvenčním měniči 1,5KWA1000-FTV3010-REOMRONPotencimer 4k7Potencimer 4k7Potencimer 4k7MIELANDNorka rychloupinaciSvorka rychloupinaciMIELANDMIELANDJavice hibového ovládečeZB5 A5844TELEMECANQUERozpinaci kontakt s adaptéremZB5 A5844TELEMECANQUENorice zelenáZB5 A102TELEMECANQUEHavice zelenáZB5 A102TELEMECANQUEHavice zelenáZB5 A101TELEMECANQUEHavice zelenáZB5 ZI02TELEMECANQUEHavice zelenáZB5 ZI02TELEMECANQUEHavice zelenáZB5 ZI02ZB5 ZI02Havice zelenáZB5 ZI02ZB5 ZI	1 //01.1
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Rozpinaci kontakts adaptéremZB5AZ102TELEMECANIQUERozpinaci kontaktsZBE-102TELEMECANIQUERozpinaci kontaktZB5-102TELEMECANIQUEHavice zelenáZB5A33TELEMECANIQUEKontakt s adaptérem spinaciZB5A2101TELEMECANIQUEHavice čerenáZB5A2101ZB5A2101Rozpinaci kontakt s adaptéremZB5A44TELEMECANIQUERozový spinačRoncový spinačZB5A2102Roncový spinačD4N-4A31OMRONRoncový spinačP4N-4A31CMRONRoncové spinačCMRONCMRONRoncové spinačCMRONCMR	1 /03.2
Rozpínací kontaktZBE-102TELEMECANIQUEHavice zelenáZB5A3TELEMECANIQUEKontakt s adaptérem spínacíZB5A101TELEMECANIQUEHavice červenáZB5A2101TELEMECANIQUERozpínací kontakt s adaptéremZB5A2102TELEMECANIQUERozový spínačKontakt s adaptéremZB5A2102TELEMECANIQUEKoncový spínačKoncový spínačD4N-4A31OMRONRozové spínačD4N-4A31D4N-4A31DMRONRozové spínačD4N-4A31DMRONDAN-ANIRozové spínačD4N-4A31DMRONDMRONRozové spínačD4N-4A31DMRONDMRONRozové spínačD4N-4A31DMRONDMRONRozové spínačD4N-4A31DMRONDMRONRozové spínačD4N-4A31DMRONDMRONRozové spínačD4N-4A31DMRONDMRONRozové spínačD4N-4A31DMRONDMRONRozové spínačDAN-ANIDMRONDMRONRozové spínačDAN-ANIDMRONDMRONRozové spínačDAN-ANIDMRONDMRONRozové spínačDAN-ANIDMRONDMRONRozové spínačDAN-ANIDMRONDMRONRozové spínačDMRONDMRONDMRONRozové spínačDMRONDMRONDMRONRozové spínačDMRONDMRONDMRONRozové spínačDMRONDMRONDMRONRozové spínačDMRONDMRONDMRONRozové spínačDMROND	1 /03.2
Havice zelenáZB5A3TELEMECANIQUEKontakts adaptérem spínacíZB5A2101TELEMECANIQUEHavice červenáZB5A2102TELEMECANIQUERospinací kontakts adaptéremZB5A24TELEMECANIQUEKoncový spínačZB5A2102TELEMECANIQUEKoncový spínačD4N-4A31OMRONRosové spínačP4N-4A31OMRONRosové spínačD4N-4A31OMRONRosové spínačD4N-4A31OMRONRosové spínačD4N-4A31OMRONRosové spínačD4N-4A31OMRON	2 /02.2
Kontakts adaptérem spínacíZB5AZ101TELEMECANIQUEHavice červenáZB5A4TELEMECANIQUERoznica kontakts adaptéremZB5A4TELEMECANIQUERozový spínačZB5A2102TELEMECANIQUEKoncový spínačD4N-4A31OMRONRozový spínačP4N-4A31OMRONBanačonetní koncovú spínačD4N-4A31OMRONBanačonetní koncovú spínačD4N-4A31OMRONBanačonetní koncovú spínačD4N-4A31OMRON	1 /03.6
Hlavice červená ZB5A44 TELEMECANIQUE Rozpinací kontakt s adaptérem ZB5A2102 TELEMECANIQUE Koncový spinač D4N-4A31 OMRON Roncový spinač D4N-4A31 OMRON	1 /03.6
Rozpínací kontakt s adaptérem ZB5AZ102 TELEMECANIQUE Koncový spínač D4N-4A31 OMRON Koncový spínač D4N-4A31 OMRON	1 /03.7
Koncový spínač D4N-4A31 OMRON Koncový spínač D4N-4A31 OMRON Baznačenctní koncové spínač OMRON OMRON	1 /03.7
Koncový spínač Bosneženetní koncový enírač OMRON OKS8 KEDU	1 /03.3
Raznačovctní koncový cnínač KEDLI	1 /03.4
	1 /03.5
Výrobce si vyhrazuje použít ekvivalentní náhrady přístrojů.	

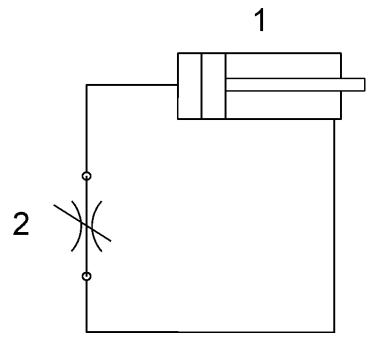


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6	Umístění (strana slounec)	(Julianaradow)		1911 1911		90110	
00	Množství					Jenematics	
~	Skladové číslo	91.080.003			-		
¢	Výrobce	ELEKTROKOV a.s. ZNOJMO					
σ	Objednací číslo	JBC E2025 - 0173		gomar s.r.o.			
m		- 3	trojû.	Ergonomic 320-250 G-DG-DGS			
2		/230V/24V 20VA	Výrobce si vyhrazuje použít ekvivalentní náhrady přístrojů.	ш 	-		
	IKIů Typ přístroje	Transformátor 400V/230V/24V 20VA	uje použít ekviv				
-	Kusovník artiklů Označení přístroje Typ přístroje	L TT.	/robce si vyhrazu				
	Ý Lo	1		Datum			





6.5. Hydraulické schéma Hydraulisches Schéma Hydraulic diagram



Poz.	Název položky		ks
Pos.	Bezeichnung		Menge
Pos.	ltem		Pcs.
1	251.056	Hydraulický válec / Hydraulischer Zylinder / Hydraulic cylinder	1
2	92.152.002	Regulační ventil / Regelventil / Control valve HYTOS	1



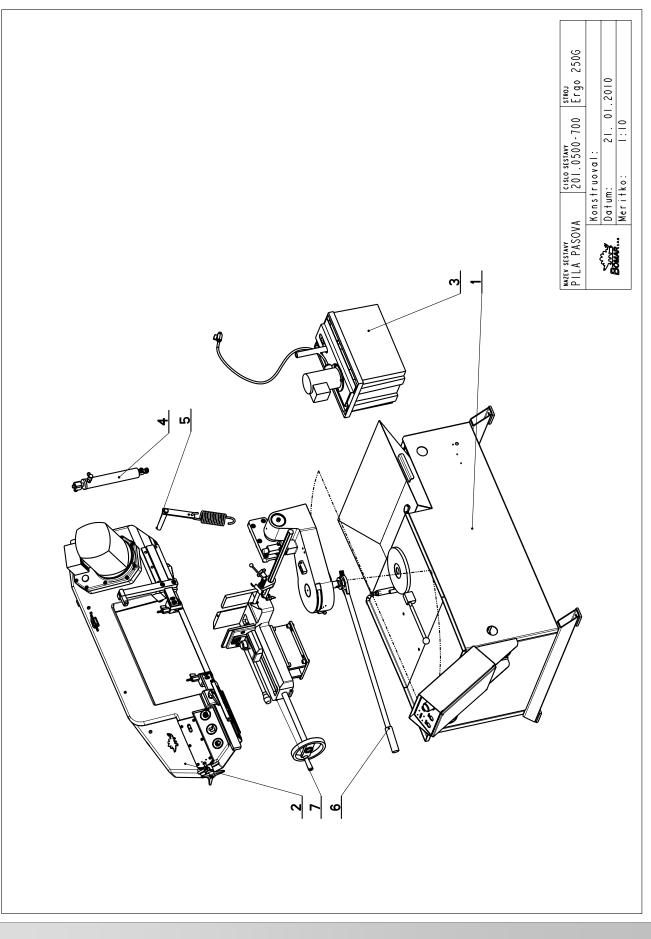
7. Výkresy sestav pro objednání náhradních dílů / Zeichnungen für Bestellung der Ersatzteile / Drawing assemblies for spare parts order

 Při objednávání náhradních dílů vždy uvádějte: typ stroje (např. practix Ergonomic 320.250 G), výrobní číslo (např. 125) a rok výroby (např. 1999).

- In die Bestellung der Ersatzteile führen Sie immer an: Maschinentyp (z. B. Ergonomic 320.250 G), Serien Nr. (z. B. 125) und Baujahr (z. B. 1999).
- For spare parts order, you must always to allege: type of machine (for example Ergonomic 320.250 G), serial number (for example 125, see cover page) and year of construction (for example 1999).



7.1. Ergonomic 320.250 G





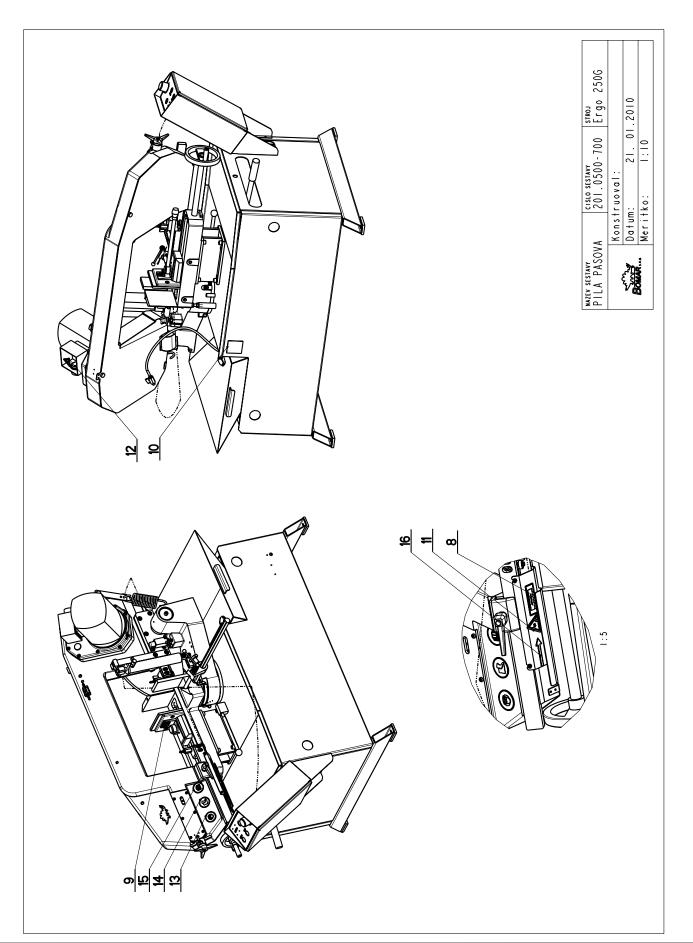
Cisle	Cisto Sestary	Ver.			
102	007 - 0060 .	_	PILA PASOVA/BAND SAW/BANDSAGE		
Poz.	Objednaci cislo	Ver.	Nazev polozky	Rozmer	Ks
_	201.0501-500	4	PODSTAVEC / BASE / UNTERSATZ		_
~	201.0504-700	5	RAMENO / SHOULDER / SÄGERAHMEN		_
m	201.0506-000	0	CHTAZENI / COOLING / KÜHLUNG		_
4	201.0507-000	_	VALEC ZVEDACI / LIFTING CYLINDER / HEBEZYLINDER		_
5	201.0514-750	0	PRUZINA / SPRING / FEDER		_
9	201.0702-000	2	KONZOLA OTOCNA / TURNABLE CONSOL / DREHKONSOLE		_
1	201.0703-000	0	SVERAK / VICE / SCHRAUBSTOCK		_
80	31.0104-026	0	SAMOLEPKA / STICKER / AUFKLEBER		_
6	31,0599-005	0	SAMOLEPKA / STICKER / AUFKLEBER		_
2	31.0599-801	0	STITEK / LABEL / SCHILD	P 0.5x65	_
=	99,900,040	0	SAMOLEPKA / STICKER / AUFKLEBER		_
12	99.900.045	0	SAMOLEPKA / STICKER / AUFKLEBER		_
3	99.900.047	0	SAMOLEPKA / STICKER / AUFKLEBER		_
14	99.900.048	0	SAMOLEPKA / STICKER / AUFKLEBER		_
15	99.900.049	0	SAMOLEPKA / STICKER / AUFKLEBER		_
91	99.900.053	0	SAMOLEPKA / STICKER / AUFKLEBER		_

7.2. Kusovník / Stückliste / Piece list – Ergonomic 320.250 G

I ZM.Z ks.STROJE ZRUSIT PODSTAVEC 201.0501-000 A NAHRADIT JEJ CISLEM 201.0501-500. 4.6.2008 VINOHRADSKY



7.3. Ergonomic 320.250 G





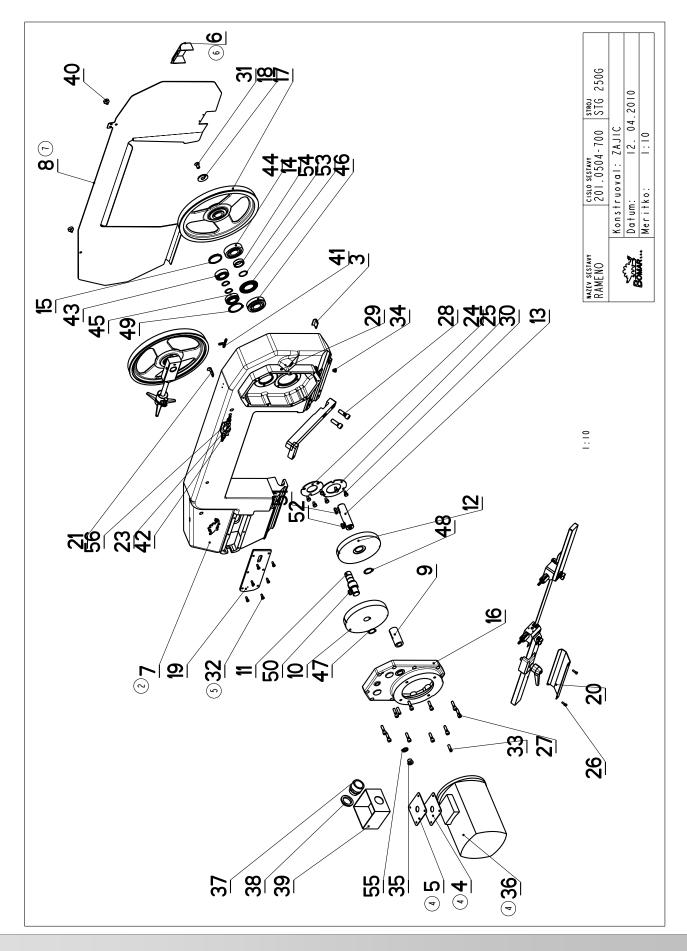
Cisto Sestary 201.0500-700 Poz. Objednaci c	stavv				
	500-700	ver.	PILA PASOVA/BAND SAW/BANDSÅGE		
	Objednaci cislo	Ver.	Nozev polozky	Rozmer	Ks
1 2	201.0501-500	4	PODSTAVEC / BASE / UNTERSATZ		
2 2	201.0504-700	5	RAMENO / SHOULDER / SÅGERAHMEN		
3 2	201.0506-000	0	CHLAZENI / COOLING / KÜHLUNG	_	
4 2	201.0507-000	_	VALEC ZVEDACI / LIFTING CYLINDER / HEBEZYLINDER	_	
5 2	201.0514-750	0	PRUZINA / SPRING / FEDER		
6 2	201.0702-000	2	KONZOLA OTOCNA / TURNABLE CONSOL / DREHKONSOLE		
7 2	201.0703-000	0	SVERAK / VICE / SCHRAUBSTOCK		
8 3	31.0104-026	0	SAMOLEPKA / STICKER / AUFNLEBER	_	
9 3	31,0599-005	0	SAMOLEPKA / STICKER / AUFNLEBER		
10 3	31.0599-801	0	STITEK / LABEL / SCHILD	P 0.5x65	
6 11	99.900.040	0	SAMOLEPKA / STICKER / AUFNLEBER		
12 9	99.900.045	0	SAMOLEPKA / STICKER / AUFNLEBER	_	
13 9	99.900.047	0	SAMOLEPKA / STICKER / AUFNLEBER		
14 9	99.900.048	0	SAMOLEPKA / STICKER / AUFNLEBER	_	
15 9	99.900.049	0	SAMOLEPKA / STICKER / AUFNLEBER		
16 9	99.900.053	0	SAMOLEPKA / STICKER / AUFNLEBER	_	

7.4. Kusovník / Stückliste / Piece list – Ergonomic 320.250 G

I ZM.Z ks.STROJE ZRUSIT PODSTAVEC 201.0501-000 A NAHRADIT JEJ CISLEM 201.0501-500. 4.6.2008 VINOHRADSKY



7.5. Rameno / Sägerahmen / Saw arm



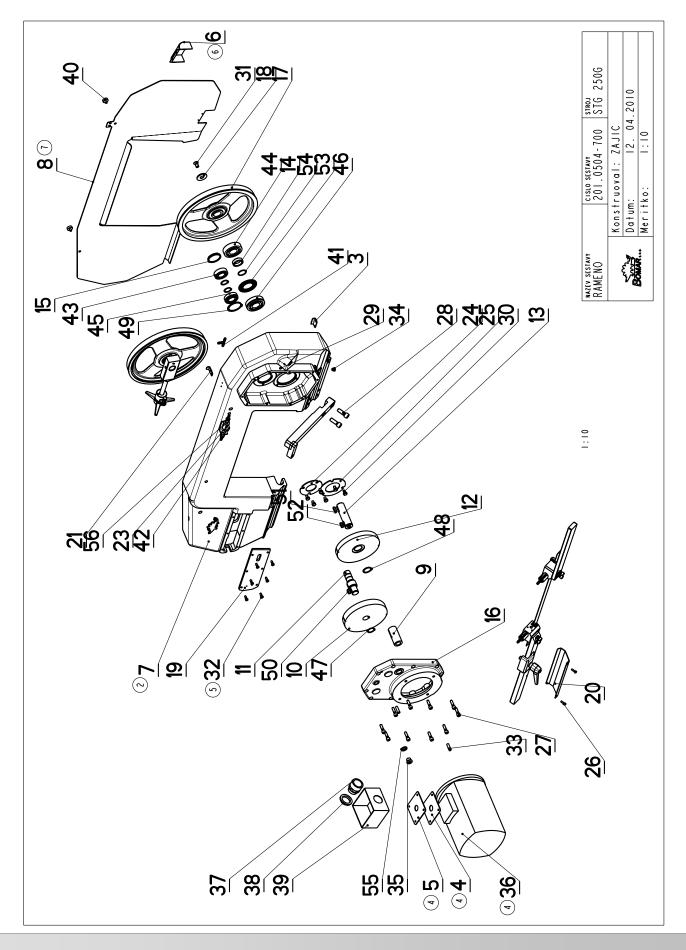
	Objednoci cislo 201.0508-000 201.0510-000 201.0510-000 30.0504-010 30.0504-011 4 30.0504-012 30.0504-010 30.0504-011 30.0504-012 30.0504-012 30.0504-012 30.0504-012 30.0504-012 30.0504-012 30.0505-002 30.0505-003 30.0505-003 30.0505-003 30.0505-013 30.0505-013 30.0505-201 30.0505-201	Ver. 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	Nozev polozky R Nozev polozky APPINANI / TENSIONING / SPANNUNG VEDENI PASU / BELT GUIDE / SÅGEBANDFÜHRUNG P VEDENI PASU / BELT GUIDE / SÅGEBANDFÜHRUNG P UCHYTKA / CLIP / HALTER P UCHYTKA / CLIP / HALTER P UCHYTKA / CLUP / HALTER P UCHYTKA / CLUP / HALTER P UCHYTKA / CLUP / HALTER P DESKA ELEKTRO / ELECTRIC BOARD / PLATINE P TOURA / RUBBER / GUMAI P RAFT / COVER / BANDSPANUNGSABDECKUNG P RAMENO / SHOULDER / SÄGERAHMEN P RAMENO / SHOULDER / SÄGERAHMEN P RAMENO / SHOULDER / SÅGERAHMEN P RAMENO / SHOULDER / SAGERAHMEN P RAMENO / SHOULDER / SAGERAHMEN P RAMENO / SHOULDER / SHET / WELLE P ROLO OZUBENE / COG WHEEL / ZAHNRAD D HRIDEL / SHAFT / WELLE P	Rozmer P 2- 36 P 1.5 - 95 TL.2-95 P 1.5x84 80.0504-701 P 1.5x84 80.0504-701 P 1.5-492 0 1.5x8 0 176 0 180 0	<u>x</u>
		Ver.	ANDF ÜHRUNG PLATINE / BANDSPANNUNGSABDE CKUNG AD AD	ozmer 2- 36 1.5 - 95 1.2-95 1.2-95 1.5-884 0.0504-701 1.5-492 1.5-492 3.5 3.5 1.5-492 1.5-5-492 1.5-5-5-5 1.5-5-5-5 1.5-5-5-5 1.5-5-5-5 1.5-5-5-5 1.5-5-5-5 1.5-5-5-5 1.5-5-5-5-5 1.5-5-5-5-5-5-5-5-5-5-5-5-5-5-5-5-5-5-5-	\$
		<u>o</u> <u>-</u> <u>o</u> <u>-</u> <u>o</u> <u>o</u> <u>-</u> <u>o</u> <u>o</u> <u>-</u> <u>o</u> <u>o</u> <u>-</u> <u>o</u> <u>o</u> <u>-</u> <u>o</u>	ANDF ÜHRUNG PLATINE / BANDSPANNUNGSABDE CKUNG AD AD	2- 36 2- 36 1.5 - 95 1.2-95 1.2-95 1.5-84 0.0504-701 1.5-492 1.5-492 3.5 3.5 1.76 1.76 1.76 1.76 1.76 1.76 1.76 1.75 2.5 2.5 2.5 2.5 2.5 2.5 2.5	_ _ _ _ _ _ _ _ _ _ _
			/ SÅGEBANDF ÜHRUNG BOARD / PLATINE RAHMEN vg COVER / BANDSPANNUNGSABDECKUNG EL / ZAHNRAD / ZAHNRAD	2- 36 1.5 - 95 1.2 - 95 1.2 - 95 1.2 - 95 1.5 - 492 1.5 - 492 1.5 - 492 3.5 - 492 1.7 6 1.7 6 40 1.7 6 1.7 7 1.7 6 1.7 7 1.7 6 1.7 7 1.7 7 1.7 6 1.7 7 1.7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7	
		<u> </u>	BOARD / PLATINE BAHMEN KAHMEN KG COVER / BANDSPANNUNGSABDECKUNG EL / ZAHNRAD / ZAHNRAD	2- 36 1.5 - 95 1.2 -95 1.2 -95 1.5 -84 0.0504 - 701 1.5 - 492 1.5 - 492 3.5 1.5 - 492 1.5	
		- 0 0 0 - 0 0 0	BOARD / PLATINE RAHMEN G COVER / BANDSPANNUNGSABDECKUNG EL / ZAHNRAD / ZAHNRAD	1.5 - 95 1.2-95 1.5-84 0.0504-701 0.0504-701 1.5-492 3.5 3.5 1.76 1.76 1.76 1.80 1.80 1.80 1.80 1.80 1.80 1.80 1.80	
		o o o - o o o	RAHMEN VG COVER / BANDSPANNUNGSABDECKUNG EL / ZAHNRAD / ZAHNRAD	L. 2-95 1. 5484 0. 0504-701 1. 5-492 3. 5 3. 5 40 180 180 180 180 180 180 180 18	
		• • <u>-</u> • <u>-</u> • <u>-</u> •	AHMEN vg Cover / Bandspannungsabdeckung el / Zahnrad / Zahnrad	1.5x84 0.0504-701 1.5-492 35 35 35 40 176 40 180 7C 35 74,5x8 55	
		o _ o o o	EERAHMEN ING COVER / BANDSPANNUNGSABDECKUNG IZEL EL / ZAHNRAD EL / ZAHNRAD	0. 0504 - 701 1. 5 - 492 35 35 176 176 40 180 180 70 35 74 , 5x8 55	
	04 - 153 (7) 05 - 002 505 - 003 505 - 004 505 - 001 505 - 001 505 - 013 505 - 201 505 - 201	- 0 0 0	VING COVER / BANDSPANNUNGSABDECKUNG 12EL el / Zahnrad el / Zahnrad	1 . 5- 492 35 176 176 40 180 VC 35 VC 35 VC 35 S5	
	05-002 05-003 505-004 505-005 505-009 505-013 505-201 505-201	o o o	IZEL EL / ZAHNRAD EL / ZAHNRAD EL / ZAHNRAD	35 176 40 180 YC 35 55	
	05-003 505-004 505-005 505-007 505-009 505-013 505-201 505-701		EL / ZAHNRAD EL / ZAHNRAD	176 40 180 7(2 35 7(35 55	
	05-004 505-005 505-007 505-009 505-201 505-201		EL / ZAHNRAD	40 180 YC 35 F 44,5x8 55	
)05-005)05-007)05-009)05-013)05-201)05-701	0 0	EL / ZAHNRAD	180 YC 35 r 44,5x8 55	
	505-007 505-009 505-201 505-201 505-701	0		YC 35 r 44,5x8 55	
	065-009 065-013 505-201 505-701	- 0		r 44,5x8 55	
	305-013 305-201 505-701	•		55	
	<u> 505 - 201</u> 505 - 701		ZATKA / PLUG / STOPFEN	-	Γ
	505-701	_	VIKO / COVER / DECKEL COVER / DECKEL	C.M.80.0705-001	_
		0	KOLO HNACI / DRIVE WHEEL / ANTRIEBSRAD		_
18 30.05	30.0508-002	0	PODLOZKA / WASHER / UNTERLEGSCHEIBE	d 40	_
19 30.07	30,0704-007	2	KRYT NAPINANI / TENSIONING COVER / BANDSPANNUNGSABDECKUNG	VYPALEK	_
20 30.07	30.0704-021	-	KRYT PASU / BELT COVER / BANDABDECKUNG	P 1.5-101	_
21 30.07	30.0704-032	2	PRILOZKA / STRAP / LASCHE	2 - 15	_
22 30.07	30.0707-012	-	DRZAK / HOLDER / HALTER		_
23 30.18	30,1814-011	0	DRZAK / HOLDER / HALTER	P 3- 76	_
24 81.01	81.0105-007	0	PRILOZKA / STRAP / LASCHE	P2.5-90	_
25 81.05	81.0505-010	0	PRILOZKA / STRAP / LASCHE	P 2.5- 108	_
26 90.00	90.001.25.009	0	HEAD BOLT / IMBUSSCHRAUBE	M5X16	2
27 90.00	90.001.25.034	0	SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE	M8X30	10
28 90.00	90.001.25.059	0		MI 2X35	2
29 90.00	90.004.2D.00I	0	SROUB STAVECI / ADJUSTMENT BOLT / STELLSCHRAUBE	SROUB M6X8	_
30 90.00	90.005.55.013	0	SROUB 6HRANNY / 6 SIDED BOLT / SECHSKANTSCHRAUBE	SROUB M8X12	9
31 90.01	90.011.27.008	0	SROUB ZAPUSTNY / COUNTERSINK BOLT / SENKSCHRAUBE	SROUB MIOX20	_
32 90.01	90.013.27.008 5	0	SROUB PULKULATY / HALF ROUND BOLT / HALBRUNDSCHRAUBE	M6X16	6
33 90.30	90.302.02.002	0	KOLIK KUZELOVY / TAPER PIN / KEGELBOLZEN	KOL I K 8X30	2
	90.400.52.001	0		MI0xI	_
35 90.40	90.400.52.002	0	L.	M16x1.5	_
36 91.00	91.001.007 (4)	0	ELEKTROMOTOR / ELECTRIC MOTOR / ELEKTROMOTOR		_

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





7.7. Rameno / Sägerahmen / Saw arm



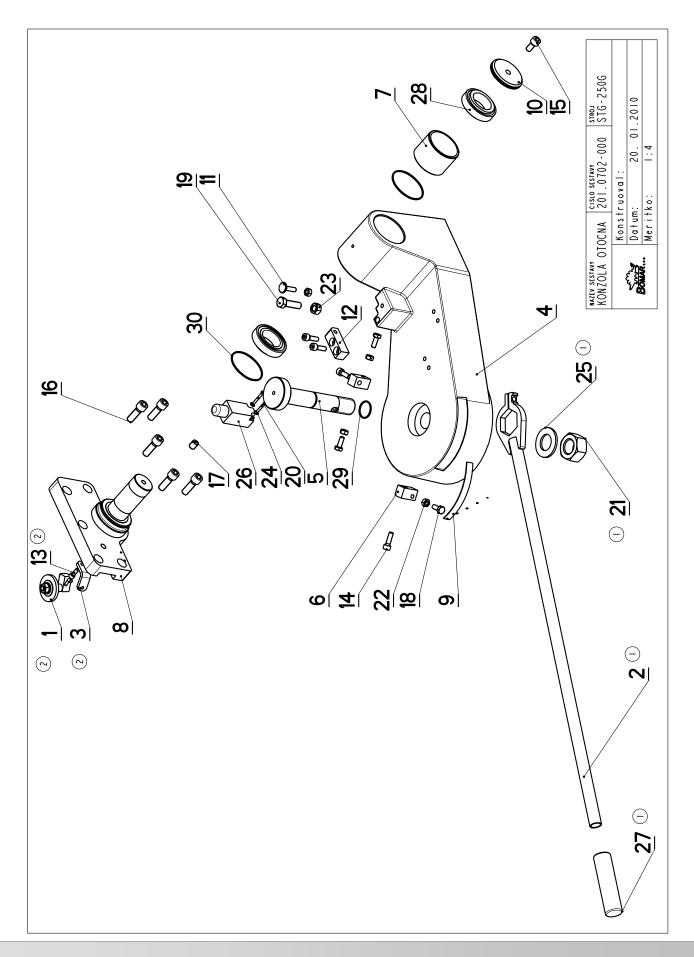
cislo 201.	cislo Sestory 201.0504-700	Ver. 5	Nozev sestovy RAMENO/SHOULDER/SÅGERAHMEN		
		-			
Poz.	Objednaci cislo	Ver.	Nazev polozky	Rozmer	Ks
37	91.071.004	0	VYVODKA / BUSHING / TÜLLE	VYVODKA	_
38	91.072.007	0	MATICE / NUT / MUTTER	MATICE	_
39	91,190,004	0	KRABICE ELEKTRO / ELECTRO BOX / ELEKTRODOSE		_
40	94,007,002	0	SROUB / BOLT / SCHRAUBE		2
41	94.200.001	0	REDUKCE / REDUCTION / ADAPTOR / REDUKTION	9	_
42	94.202.002	0	REDUKCE / REDUCTION / ADAPTOR / REDUKTION	GES 6/R1/4"	2
43	95.001.018	0	LOZISKO / BEARING / LAGER	6205 2RS	_
44	95,001,025	0	LOZISKO / BEARING / LAGER	6306 2RS	_
45	95.003.002	0	LOZISKO / BEARING / LAGER	6205AN	_
46	95,003.003	0	LOZISKO / BEARING / LAGER	6306AN	_
47	95.800.012	0	KROUZEK POJIST. VNEJS / OUTSIDE SAFETY RING / SICHERUNGSRING AUBEN	POJISTNY KROUZEK 25	~
48	95.800.013	0	KROUZEK POJIST.VNEJS / OUTSIDE SAFETY RING / SICHERUNGSRING AUBEN	POJISTNY KROUZEK 30	_
49	95.800.019	0	KROUZEK POJIST. VNEJS / OUTSIDE SAFETY RING / SICHERUNGSRING AUBEN	POJISTNY KROUZEK 52	_
50	95.810.006	0	PERO / SPRING / FEDER	PERO 8X7X20	_
51	95.810.007	0	PERO / SPRING / FEDER	PERO 8X7X25	_
52	95.810.023	0	PERO / SPRING / FEDER	PERO 8X7X22	_
53	95.830.005	0	GUFERO / GIT SEAL / DICHTUNG	GUFERO 40X72X7	_
54	96.002.034	0	KROUZEK O DYNAMICKY / DYNAMIC O RING / O-RING DYNAMISCH	30X2	_
55	96.081.001	0	KROUZEK TESNICI / SEAL RING / DICHTUNGSRING	23x I 5x 3	_
56	99.260.003	0	VENTIL / VALVE / VENTIL	1/4"	_
I.ZRU	I.ZRUSENA SOUCAST 30.0504-004 A NAHR. 30.0504-010	004 A N	NAHR. 30.0504-010 , ZRUSENA SOUCAST 30.0504-005 A NAHR. 30.0504-011. 24.10.2005 SLEZACKOVA	EZACKOVA	
2.VYA	4ENA RAMENE A KRYTU RAN	MENE,	2.VYMENA RAMENE A KRYTU RAMENE, ZRUSENY SOUC.30.0504-701,30.0504-702 A NAHR. 30.0504-751,30.0504-752. 558/ZM281 16.10.2006 SLEZACKOVA	6.10.2006 SLEZACKOVA	
3. ZRI 318/	3.ZRUS.PLECH ELEKTRO 30.0504-010 A NAHR. 30.0504-01 318/ZM295 11.9.2008 SLEZACKOVA	04-010 CKOVA	A NAHR. 30.0504-012,ZRUS.GUMA 30.0504-011 A NAHR. 30.0504-013,ZRUS.MOTOR 91.001.007 A NAHR. 91.001.129)07 A NAHR. 91.001.129	
4.VYN ZRUS.	MENA MOTORU - ZRUS.MOTO .GUMA 30.0504-013 A NAI	OR CIN: HR.GUM	4.VYMENA MOTORU - ZRUS.MOTOR CINSKY 91.001.129 A NAHR.MOTOREM EMP SLAVKOV 91.001.129,ZRUS.PLECH ELEKTRO 30.0504-012 A NAHR. PLECHEM 30.0504-010, ZRUS.GUMA 30.0504-013 A NAHR.GUMOU 30.0504-011. 061/ZM085 25.3.2009 SLEZACKOVA	12 A NAHR. PLECHEM 30.0504-0	.01
5.ZR A NA	US.KARTACEK 201.07 HRAZEN SROUBEM S P	04-10 ULKUL,	5.ZRUS.KARTACEK 201.0704-100,PRID.KRYT KARTACKU 30.0504-603,ZRUS.SROUB IMBUS M6x16 (90.001.25.017) A NAHRAZEN SROUBEM S PULKULATOU HLAVOU M6x16 (90.013.27.008). 183/ZM211 26.11.2009 SLEZACKOVA	(2)	
6.ZR	USEN KRYT KARTACKU	30.05	6.ZRUSEN KRYT KARTACKU 30.0504-603 A NAHRAZEN 30.0504-604. 052/ZM050 22.2.2010 SLEZACKOVA		
7.ZRI	7.ZRUSEN KRYT 30.0504-752 A NAHRAZEN 30.050	752 A	NAHRAZEN 30.0504-753. 036/ZM095 12.4.2010 SLEZACKOVA		

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





7.9. Konzola / Konzole / Console



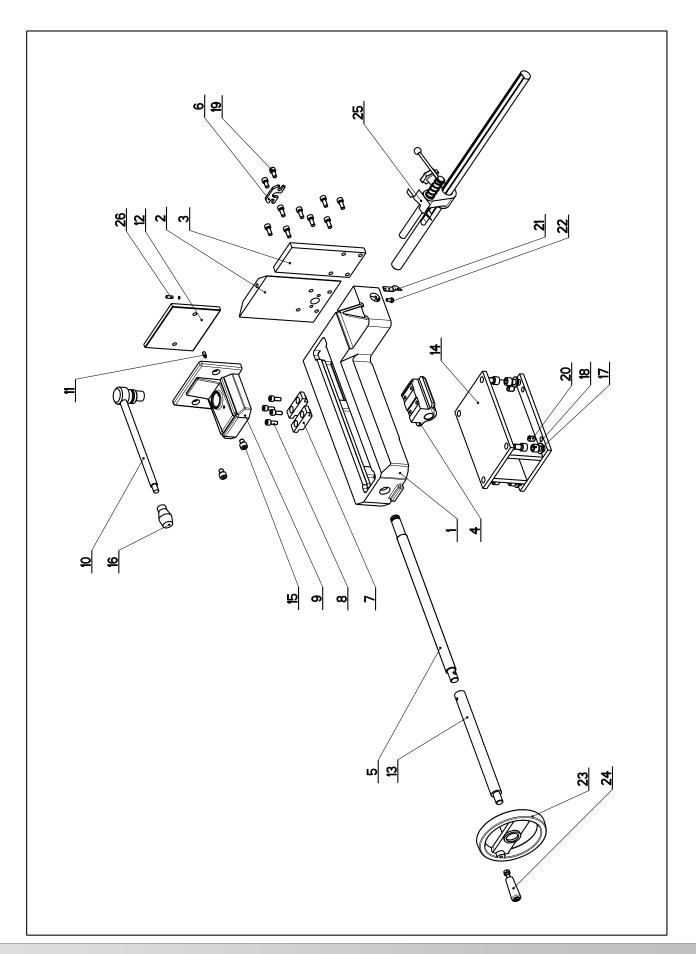
	201.0702-000	5	KONZOLA OTOCNA/TURNABLE CONSOL/DREHKONSOLE		
Ρ٥٤.	Objednaci cislo	Ver.	Nozev polozky	Rozmer	Ks
	201.0704-100 2 2	0	KARTAC / BRUSH / BÜRSTE		-
	30.0502-004	0	PAKA / LEVER / HEBEL	SVARENO	-
	30.0514-603 (2)	0	DRZAK / HOLDER / HALTER	HR20x5	_
	30.0702-001	2	KONZOLA / CONSOLE / KONSOLE		-
	30.0702-002	2	CEP / LUG / BOLZEN	M30x173	-
	30.0702-006	0	DORAZ / STOP PIECE / ANSCHLAG	TYC 20x20	2
	30.0702-008	0	POUZDRO / SLEEVE / BÜCHSE	TR 70x5	-
	30.0702-010	0	DRZAK / HOLDER / HALTER		-
	30.0702-011	0	STUPNICE / SCALE / SKALA	P1-15	-
0	30.0702-012	0	VIKO / COVER / DECKEL	d 70	-
=	30.0702-013	0	SROUB / BOLT / SCHRAUBE	M8	-
12	30.0707-011	0	DRZAK / HOLDER / HALTER	TYC 20x20	-
13	90.001.25.017 (2)	0	SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE	M6X16	_
14	90.001.25.033	0	SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE	8x25	4
15	90.001.25.046	0	SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE	M10X20	_
16	90.001.25.059	0	SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE	M12X35	5
17	90.002.2D.017	0	SROUB STAVECI / ADJUSTMENT BOLT / STELLSCHRAUBE	SROUB MI2X16	-
18	90.005.55.015	0	SROUB 6HRANNY / 6 SIDED BOLT / SECHSKANTSCHRAUBE	SROUB M8X20	3
61	90.005.55.034	0	SROUB 6HRANNY / 6 SIDED BOLT / SECHSKANTSCHRAUBE	SROUB MI2X40	-
20	90.012.50.007	0	SROUB / BOLT / SCHRAUBE	SROUB M4X30	~
21	90.100.25.001 (I)	0	MATICE / NUT / MUTTER	MATICE _ M30	-
22	90.100.55.005	0	MATICE / NUT / MUTTER	MATICE _ M8	4
23	90.100.55.007	0	MATICE / NUT / MUTTER	MATICE _ MI2	-
24	90.150.50.002	0	PODLOZKA / WASHER / UNTERLEGSCHEIBE	PODLOZKA 4,3	2
25	90.150.50.XXX (1)	0	PODLOZKA / WASHER / UNTERLEGSCHEIBE	PODLOZKA 31	-
26	91.173.007	0	SPINAC KONCOVY / END SWITCH / ENDSCHALTER	- R I WK	-
27	94.004.502 (I)	0	RUKOJET / HANDLE / GRIFF	022	-
28	95.300.002	0	LOZISKO / BEARING / LAGER	32008AX	2
29	96.001.008	0	KROUZEK O STATICKY / STATIC O RING / O-RING STATISCH	26X2	-
30	96.001.018	0	KROUZEK O STATICKY / STATIC O RING / O-RING STATISCH	63X2	2
Z M 4 . 0(. Z ks.STROJE ZRUS 0.502,90.100.25.00	SENO: 3 01,90.	I ZM. Z ks.STROJE ZRUSENO:30.0301-012,30.0502-002,30.0502-001,94.00.2.001, NOVE SOUCASTI:30.0502-004 94.00.502,90.100.25.001,90.150.50.018. II.6.2008 VINOHRADSKY	2 - 004	
2			Ο ΒΡΙΝΑΝ ΚΑΡΤΑΛΈΚ ΟΟΙ ΟΤΟΑ-ΙΟΟ ΝΡΤΑΚ ΚΑΡΤΑΓΚΗ 3Ο ΟΕΙΑ-ΕΩ Α ΕΡΟΗΡΙΜΈΝΕΥΕ (ΟΟ ΟΟΙ ΟΕ ΟΤΤ 183/7ΜΟΤΗ ΟΟ ΟΙΕΤΑΛΈΛΟΝΟ	אטעכ עו טכ וו	

7.10. Kusovník / Stückliste / Piece list – Konzola / Konzole / Console





7.11. Svěrák / Schraubstock / Vice

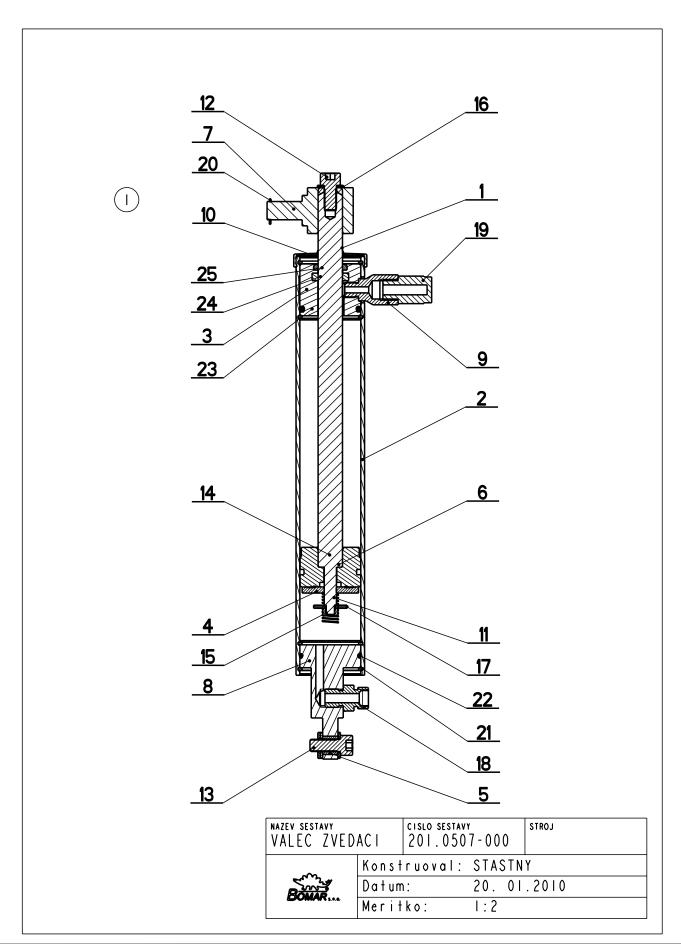


	:HRAUBSTOCK	Rozner	2
		Romer	2
		Rozaer	2
		Rozmer	K S
			-
	CELISI / JAT / BACRE	HR 150±20	-
	CELIST / JAW / BACKE	HR 90±15	-
2	MATICE / NUT / MUTTER	ODL I TEK	-
_	SROUB / BOLT / SCHRAUBE	TR24±5L	-
_	PRILOZKA / STRAP / LASCHE	HR 60 ± 5	-
_		20±20	~
	/ INBUSCHRAUBE	8:20	~
	ELIST / JAM / BACKE		-
•	XCENTR / CAN / EXZENTER		-
•		SROUB MEXIE	-
•		HR 130±10	-
_		d 25	-
•	ONZOLA / CONSOLE / KONSOLE		-
•	/ IMBUSSCHRAUBE	M10X12	~
•	LAVICE / HEAD / KOPF		-
•	OOLOZKA / MASHER / UNTERLEGSCHEIBE	PODLOZKA 13	-
•	/ INBUSSCHRAUBE	M12=20	
•	/ IMBUSSCHRAUBE	8±16	~
		SROUB MI2X16	-
•		P 1.5 - 12	-
	SECHSMANTSCHRAUBE	SROUB M6X12	_
•	OLECKO / WHEEL / ROLLE		-
0	UKOJET I MANDLE – I GRIFF		-
•			-
	DORAZ / STOP PIECE / ANSCHLAG		-
	DORAŽ / STOP PIECE / ANSCHLAG		+
	<u> </u>	HOLIG BOLT / INGUSSCRAAUBE BOLT / INGUSSCRAAUBE T BOLT / STELLSCMRAUBE BOLT / INGUSSCRAAUBE BOLT / INGUSSCRAAUBE BOLT / INGUSSCRAAUBE BOLT / INGUSSCRAAUBE BOLT / INGUSSCRAAUBE BOLT / INGUSSCRAAUBE BOLT / SECRAAUBE BOLT / SECRAAUBE	s / INBUSSCIARAUBE T / STELLSCHAAUBE T / STELLSCHAAUBE / INBUSSCIARAUBE / INBUSSCIARAUBE / INBUSSCIARAUBE / INBUSSCIARAUBE / INBUSSCIARAUBE / STELLSCHAAUBE / SECREAAUBE / SECREAAUBE

7.12. Kusovník / Stückliste / Piece list – Svěrák / Schraubstock / Vice







7.13. Válec zvedací / Hebezylinder / Liftink cylinder

	~					_				-											-,						
	Ks	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	4	-	-	1	-	4	-	-	-	-	
	Rozmer	d 16f8	TRUBKA 45/40	d 45	d 38	d 12	d 45	HR 30x 30	d 40	TYC 17		0.63x10x20x9.5	8x16	8×20	SROUB M5X12	MATICE _ M6	PODLOZKA 8.4	PODLOZKA 6	6 1/4"		POJISTNY KROUZEK I2	POJISTNY KROUZEK 40	d36x2	d34x3	d16	16x22	
VALEC ZVÉDACI/LIFTING CYLINDER/HEBEZYLINDER	. Nazev polozky	PISTNICE / PISTON ROD / KOLBENSTANGE	VALEC / ROLLER / ZYLINDER	VIKO / COVER / DECKEL	KLAPKA / PULLEY / VENTILKLAPPE	POUZDRO / SLEEVE / BÜCHSE	PIST / PISTON / KOLBEN	DRZAK / HOLDER / HALTER	DRZAK / HOLDER / HALTER	REDUKCE / REDUCTION / ADAPTOR / REDUKTION	VIKO / COVER / DECKEL	PRUZINA / SPRING / FEDER	SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE	SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE	SROUB STAVECI / ADJUSTMENT BOLT / STELLSCHRAUBE	MATICE / NUT / MUTTER	PODLOZKA / WASHER / UNTERLEGSCHEIBE	PODLOZKA / WASHER / UNTERLEGSCHEIBE	SROUBENI PRIME / DIRECT BOLTING / GERADE VERSCHRAUBUNG	SROUBENI UHLOVE / ANGLE BOLTING / WINKELVERSCHRAUBUNG	KROUZEK POJIST.VNEJS / OUTSIDE SAFETY RING / SICHERUNGSRING AUBEN	KROUZEK POJIST.VNITR / INSIDE SAFETY RING / SICHERUNGSRING INNEN	KROUZEK TESNICI / SEAL RING / DICHTUNGSRING	KROUZEK O STATICKY / STATIC O RING / O-RING STATISCH	TESNENI / SEALING / DICHTUNG	KROUZEK STIRACI / SCRAPER RING / ABSTREIFRING	
_	Ver.	0	_	•	_	-	0	0	0	-	0 (0	0	0	0	0	0	0	0	0	0	0	0	0	0	•	
											(1))															
201.0507-000	Objednaci cislo	30.0507-001	30.0507-002	30.0507-003	30.0507-004	30.0507-005	30.0707-001	30.0707-009	30.0907-001	30.3407-103	31.0507-010	31.0707-014	90.001.25.031	90.001.25.032	90.003.20.003	90.100.55.004	90.150.50.005	90.151.50.004	92.002.001	93.009.002	95.800.004	95.801.005	96.001.010	96.002.017	96.041.001	96.060.001	
. 01	Poz.	_	2		4	5	9	1	8	6	01	Ξ	12	13	14	15	16	17	81	19	20	21	22	23	24	25	

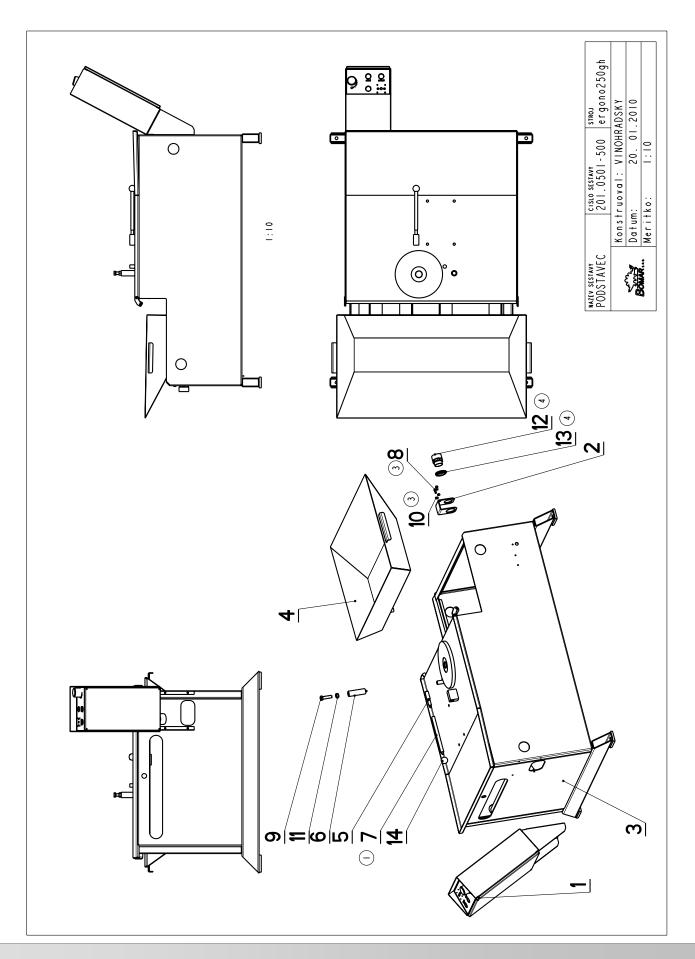
7.14. Kusovník / Stückliste / Piece list – Válec zvedací / Hebezylinder / Liftink cylinder



I.dopl.polozka 31.0507-010, 8.6.04 Stastny



7.15. Podstavec / Untersatz / Base

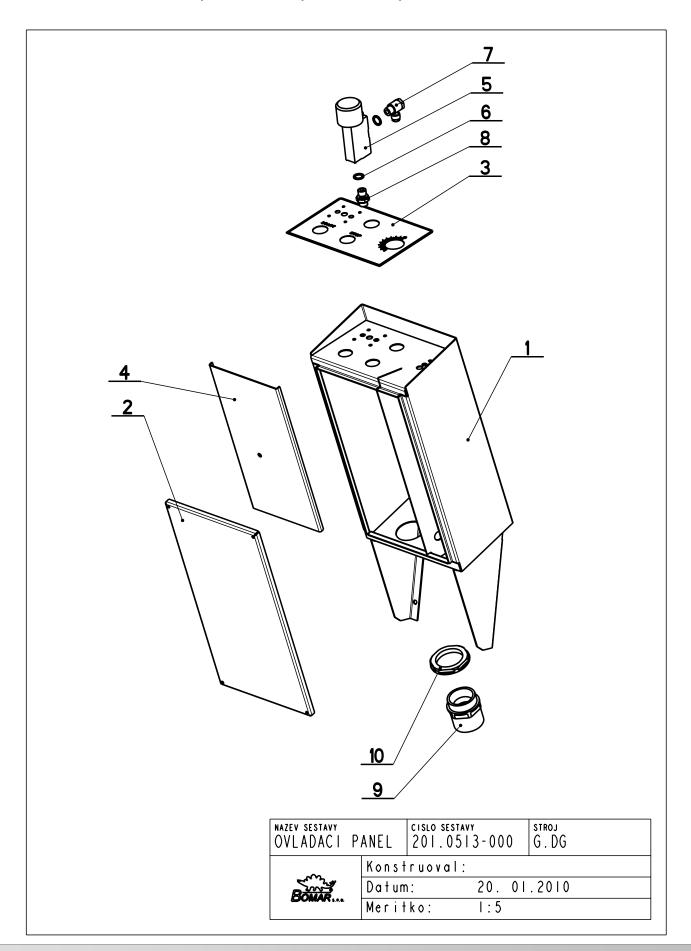


	10	•		200		tav										e list – e
	Ks	_	_	_	_	_	_	_	2	_	2	_	_	_	_	
	Rozmer		P3 - 60			d 16h9	d 25	d 14	M6X12	SROUB MI2X45	MATICE _ M6	MATICE _ MI2	VYVODKA	MATICE		100.55.004). 08)
PODSTAVEC/BASE/UNTERSATZ	Nazev polozky	OVLADACI PANEL / CONTROL PANEL / BEDIENPULT	DRZAK / HOLDER / HALTER	PODSTAVEC / BASE / UNTERSATZ	VANA / TANK / WANNE	DORAZ / STOP PIECE / ANSCHLAG	CEP / LUG / BOLZEN	NASTAVEC / EXTENSION / ANSATZ	SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE	SROUB 6HRANNY / 6 SIDED BOLT / SECHSKANTSCHRAUBE	MATICE / NUT / MUTTER	MATICE / NUT / MUTTER	VYVODKA / BUSHING / TÜLLE	MATICE / NUT / MUTTER	HLAVICE / HEAD / KOPF	I. PRIDAN NADSTAVEC 30.1003-004. 403/ZM393 14.11.2008 SLEZACKOVA 2. ZM. POLOHY OVLADACIHO PANELU. 048/ZM069 9.3.2009 SLEZACKOVA 3. ZRUS. 2*SROUB M5x6 (90.001.25.006) A NAHR. 2*SROUB M6x12 (90.001.25.016), PRID. 2×MATICE M6 (90.100.55.004) 113/ZM135 10.6.2009 SLEZACKOVA 4. ZRUS. VYVODKA PG36 (91.071.005) A NAHR. VYVODKOU PG29 (91.071.004), ZRUS. MATICE PG36 (91.072.008) A NAHR.MATICI PG29 (91.072.007). 133/ZM163 20.7.2009 SLEZACKOVA
Ver. 4	Ver.	0	_	5	_	0	0	0	0	•	0	•	•	0	•	1003 PANE 0.001 EZAC
cisto Sestory 201.0501-500	Poz. Objednaci cislo	1 201.0513-000	2 30.0501-003	3 30.0501-501	4 30.0501-602	5 30.0701-016	6 30.070 <u>1-02</u> 7	7 30.1003-004	8 90.001.23.016	9 90.005.55.035	10 90.100.(53.004	11 90.100.55.007	12 91.04.004	13 91.072(0647)	14 94.001.002	 I. PRIDAN NADSTAVEC 30. 1003-004. 403/ZM393 14. Z. ZM. POLOHY OVLADACIHO PANELU. 048/ZM069 9.3. ZRUS. 2xSROUB M5x6 (90.001.25.006) A NAHR.2> 113/ZM135 10.6.2009 SLEZACKOVA ZRUS. VYVODKA PG36 (91.071.005) A NAHR. VYV A . ZRUS. VYVODKA PG39 (91.072.007). 133/ZM163

Kusovník / Stückliste / Piece list –

7.16.





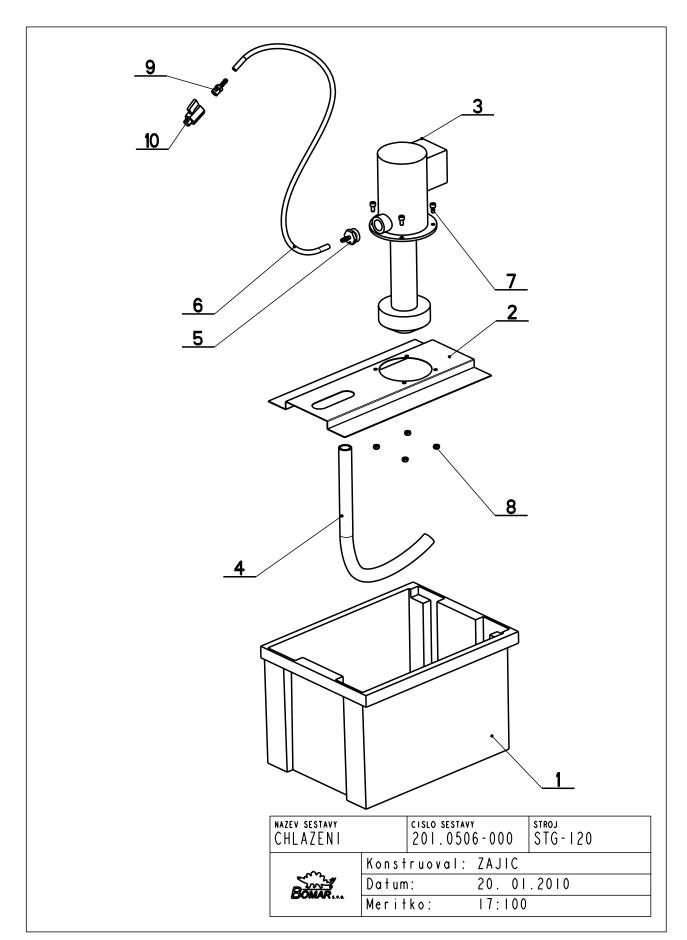
7.17. Ovládací panel / Bedienpult / Control panel



7.18. Kusovník / Stückliste / Piece list – Ovládací panel / Bedienpult / Control panel





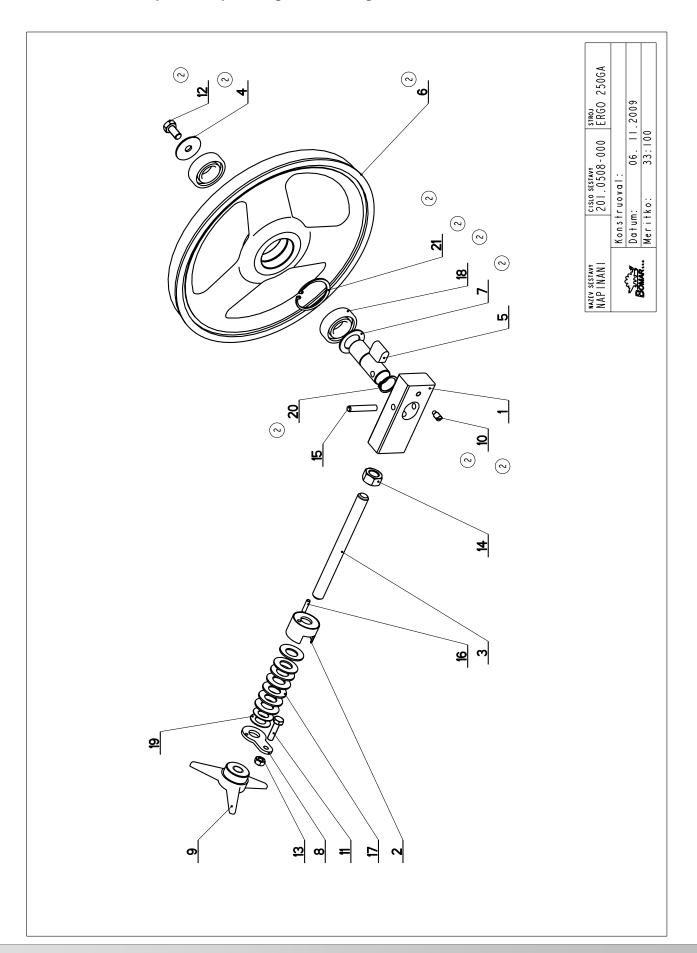




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	K s	_	_	_	_	_	_	4	4	-	-
									9	R / 4 -	710
	Rozmer	POLYPACK	P 0.8 - 249	3C0A 2-22		3/4"-6	5.	12	MATICE _ M6	REDUKCE 6/RI/4"	VENTIL KULOVY
	Roz	Pol	4	о Х	1913	3/4	6x1.5	M6X12	MAT	RED	KEN
				UMPE							
				MITTELF		NO		CHRAUBE		NOI	
UNG				v / KŮHL		REDUKT		I MBUSSO		REDUKTI	
/KŮHL		TER		CERPADLO CHLAZENI / COOLING PUMP / KÜHLMITTELPUMPE		REDUKCE / REDUCTION / ADAPTOR / REDUKTION		SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE		REDUKCE / REDUCTION / ADAPTOR / REDUKTION	
I I NG		/ BEHÅL	ECKEL	/ COOLI	HLAUCH	N / ADA	HLAUCH	N HEAD	TER	N / ADA	FNTIL
CHLAZENI/COOLING/KÜHLUNG	k y	ITAINER	R / D	ILAZENI	SE / SC	EDUCTIC	SE / SC	/ ALLE	IT / MUT	EDUCTIC	VENTIL / VALVE / VENTIL
AZEN	Nazev polozky	NADRZ / CONTAINER / BEHÅLTER	VIKO / COVER / DECKEL	ADLO CH	HADICE / HOSE / SCHLAUCH	IKCE / R	HADICE / HOSE / SCHLAUCH	INBUS	MATICE / NUT / MUTTER	IKCE / R	
		IDADI	VIK	CERI	HAD	REDI	HAD	SROI	MAT	REDI	VEN.
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	cislo	_	_	ما		<u>د</u>		.016	.004	5	_
Cisto Sestery 201.0506-000	Objednoci cislo	94.403.001	30.0506-001	91.020.006	42.020.003	94.202.005	42.020.001	90.001.25.016	90.100.55.004	94.202.002	99.260.001
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5 <u>6</u>	Poz.	-	~	~	4	ŝ	9	1	8	6	2

7.20. Kusovník / Stückliste / Piece list – Chlazení / Kühlung / Cooling





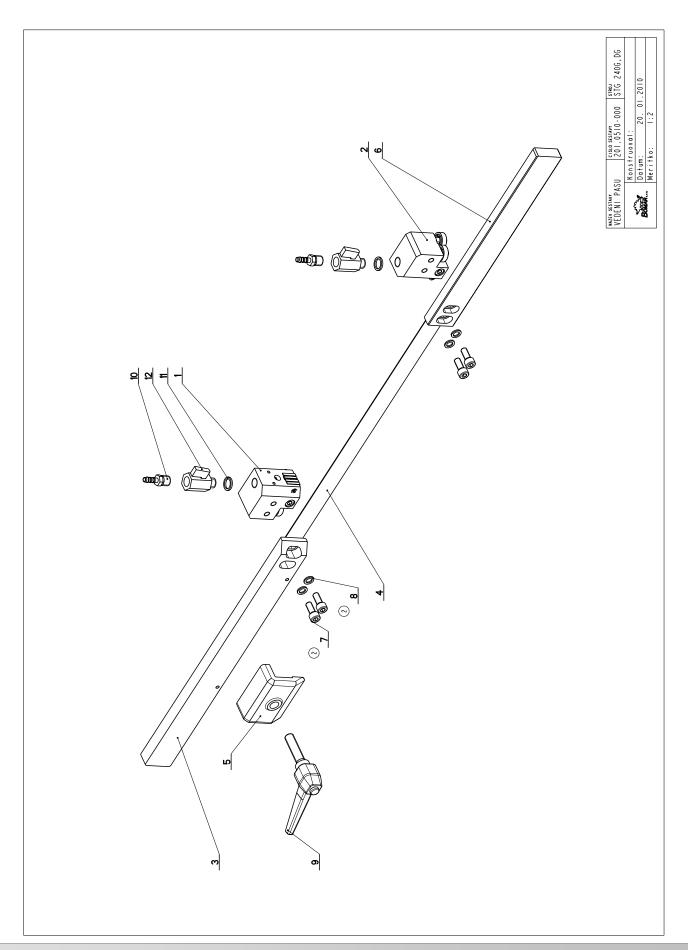
7.21. Napínání / Spannung / Tensioning

Poz.					
Po2.					
_	Objednoci cislo	Ver.	Nazev polozky	Rozmer	¥.
	30,0104-002	0	HRANOL / BLOCK / PRISMA	HR 50x 30	_
2	30,0104-004	2	DRZAK / HOLDER / HALTER		_
m	30.0303-005	0	SROUB / BOLT / SCHRAUBE	MI6	_
4	30,0505-011 (2)	0	PODLOZKA / WASHER / UNTERLEGSCHEIBE	TYC 40	_
5	30.0508-004 2	0	CEP NAPINANI / TENSIONING LUG / SPANNUNGSBOLZEN		_
و	30.0508-701 2	4	KOLO NAPINACI / TENSIONING WHEEL / UMLENKRAD		_
2	30.0702-023 (2)	0	KROUZEK DISTANCNI / DISTANCE RING / DISTANZRING		_
80	30.0704-025	m	DRZAK / HOLDER / HALTER	P 4x 36	_
6	31.0104-006	0	HVEZDICE / STAR WHEEL / STERN	PLAST	_
0	90.004.20.008 2	0	STAV SR S CIP / ADJUSTMENT BOLT / STELLSCHRAUBE	SROUB M8X16	_
=	90.005.55.017	0	6 HR SROUB ZIN / 6 SIDED BOLT / SECHSKANTSCHRAUBE	SROUB M8X30	_
12	90.005.55.023	0	6 HR SROUB ZIN / 6 SIDED BOLT / SECHSKANTSCHRAUBE	SROUB MI0X20	_
13	90.100.55.005	0	MATICE DIN 934 / NUT / MUTTER	MATICE _ M8	_
14	90,100.55.008	0	MATICE DIN 934 / NUT / MUTTER	MATICE _ MI6	_
15	90.300.02.012	0	KOLIK VALC. KAL. / PIN / BOLZEN	KOLIK 8X50	_
16	90.303.02.008	0	KOLIK PRUZNY / PIN / BOLZEN	KOLIK 5X20	_
17	90.350.02.002	0	PRUZINA TALIROVA / DISC SPRING / TELLERFEDER	35.5X18.3X2.0X2.8	~
18	95.001.018 (2)	0	LOZISKO / BEARING / LAGER	6205 2RS	2
61	95.750.001	0	KROUZEK KU / KU RING / KU-RING	16×1	2
20	95.800.012	0	KROUZEK POJIST.VNEJS / OUTSIDE SAFETY RING / SICHERUNGSRING AUBEN	POJISTNY KROUZEK 25	_
21	95.801.009 (2)	0	SEGR DIRA / INSIDE SAFETY RING / SICHERUNGSRING INNEN	POJISTNY KROUZEK 52	_
() ZME 05i 2. ZRI	 TMENA 30.0702-023 NA 30.0508-006, 0508-701 NA 0508 0505-011 NA 0508-002, 95.801.009 NA 95.801 2.ZRUSENA ZMENA I. NEBYLA REALIZOVANA. 266/ZM255 28 	08-006 95.81 EALIZO) ZMENA 30.0702-023 NA 30.0508-006, 0508-701 NA 0508-102, 0508-004 NA 0508-007, 0104-002 NA 0508-008, 95.001.018 NA 95.001.036 0505-011 NA 0508-002, 95.801.009 NA 95.801.010 14.5.2004 URICAR 2.ZRUSENA ZMENA 1. NEBYLA REALIZOVANA. 266/ZM255 28.7.2008 SLEZACKOVA	95.001.036	

7.22. Kusovník / Stückliste / Piece list – Napínání / Spannung / Tensioning







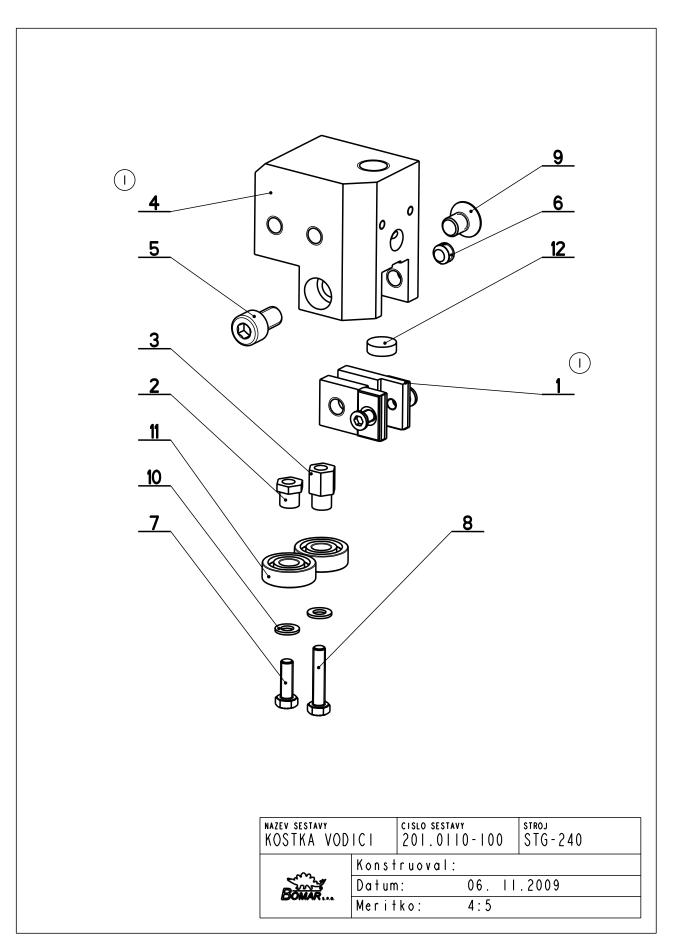
7.23. Vedení pásu / Sägebandführung / Belt guide

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		20110			YC 40x20	910x25(7)x0.90	DLITEK	YC 40×15	x20	DDLOZKA 8	12	EDUKCE 6/RI/4"	7.8×13.5×2	ENTIL KULOVY	4
					170	29		170		POI		RE	11		Ny 4xSROUB M8x16 A NAHR.SROUBEM M8x20. 161/ZM148 14.5.2008 SLEZACKOVA
. Nozev sestovy Vedeni Pasu/Belt guide/sågebandführung	Nota	MULEY POINTRY			LISTA / TRIM / LEISTE	PAS PILOVY / SAW BELT / SÅGEBAND	UPINKA / FASTENER / SPANNEISEN	LISTA / TRIM / LEISTE	SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUB	PODLOZKA / WASHER / UNTERLEGSCHEIBE	PAKA UPINACI / ATTACHMENT LEVER / SPANNHEBEL	REDUKCE / REDUCTION / ADAPTOR / REDUKTION	TESNENI / SEALING / DICHTUNG	VENTIL / VALVE / VENTIL	
- Ker			•	-	4	0	~	4	0	0	0	0	0	0	0, 6 x 2
islo Sestavy 01.0510-000			201.0110-100		30,0104-015	30,0504-961	30.0704-010	30,0704-014	90.001.25.032 (2)	90.163.00.002 (2)	94.008.009	0 94.202.002	1 96.080.001	2 99.260.001	I.dopl.kol.kuzel.6x20,6x26, 13.4.04 Stast 2.PRID.4x PODLOZKA NORDLOCK M8 90.163.00.002,ZRUS
Cislo 201.0			_	2	3	4	5	9	1	æ	6	0	=	12	- ~ ~
	Cisio Sestavy 201.0510-000 201.0510-000	Ver. Nozev sestovy I VEDENI PASU/BELT GUIDE/SÅGEBANDFÜHRUNG VVV NVVV NVVV OSACOLOLLO	Ver. Nazev sestavy I vEDENI PASU/BELT GUID aci cisto Ver. Nazev polozky	Ver. Nozev sestavy v EDENI PASU/BELT GUIDE/SÅGEBANDFÜHRUNG oci cisto Ver. Acev polozky Rozmer 10-100 0	Ver. Nazev sestovy VEDENI PASU/BELT GUIDE/SÅGEBANDFÜHRUNG doi visio Ver. Nazev polozky doi o Kostra vodici / LEAD CUBE / FÜHRUNGSKLOTZ Rozmer 10-200 1 KOSTRA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ	Ver Nozer sestory VEDENI PASU/BELT GUIDE/SÅGEBANDFÜHRUNG aci cislo Ver. no Nozer polozky 10-100 0 10-200 1 1 KOSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ 4-015 4	Ver Nozev selovy v Edeni Pasu/Belt Guide/sågebandführung oci visio Ver. Nozev polozky Rozmer oci visio Ver. Nozev polozky Rozmer oci visio Ver. Nozev polozky Rozmer 10-100 0 Kostra vodici / Lead cube / Führungsklot2 Nozev polozky Nozev polozky 10-200 1 Kostra vodici / Lead cube / Führungsklot2 Nozev polozky Nozev polozky 4-015 4 Lista / Trim / Leiste Trim / Leiste Trim / Leiste 2910x25(7)x0.90	VerNozer sestory vEDENI PASU/BELT GUIDE/SÄGEBANDFÜHRUNGaci cistoVernormNozer polozkyaci vistoVernormNozer polozkynormNorm<	Ver. Nazev sestovy vEDENI PASU/BELT GUIDE/SÄGEBANDFÜHRUNG oci cisto Ver. Nazev polozky Rozmer oci cisto Ver. Nazev polozky Rozmer oci cisto Ver. Nazev polozky Rozmer 10-100 0 KOSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ Rozmer 4-015 1 KOSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ TTVC 40x20 4-015 1 KOSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ TTVC 40x20 4-015 1 KOSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ TTVC 40x20 4-010 2 PAS PILOVY / SAW BELT / SÄGEBAND TTVC 40x20 4-010 3 UPINKA / FASTENER / SPANNEISEN DULITEK 4-014 4 LISTA / TRIM / LEISTE TTC 40x15	Ver. Nozev sestory VEDEMI PASU/BELT GUIDE/SÄGEBANDFÜHRUNG aci (islo Ver. 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Nozev polozky Rozmer Acticitio Ver. Nozev polozky Rozmer 10-100 0 Kostra vodici / LEAD CUBE / FÜHRUMGSKLOTZ Rozmer 10-200 1 Kostra vodici / LEAD CUBE / FÜHRUMGSKLOTZ Tru / Ver. 10-200 1 Kostra vodici / LEAD CUBE / FÜHRUMGSKLOTZ Tru / Ver. 4-015 4 LISTA / TRIM / LEISTE Tru / Ver. Tru / Ver.20 4-010 3 UPINKA / FASTENER / SPANNEISEN DOI JIEK Tru / 40.20 4-014 4 LISTA / TRIM / LEISTE Tru / 20.25(7):0.90 DOI JIEK 25.032 2 0 SROUB INBUS / ALLEN HEAD BOLT / INBUSCHRAUBE BA:20 00-002 2 0 POLOZKA / WASHER / NATELEGSCHE IE POLOZKA / WASHER / SPANNHEBEL MI2	Ver. Nozev sesiony Ver. Nozev sesiony Net. Nozev sesiony Net. aci cislo Ver. Nozev polozky Romer aci cislo Ver. Nozev polozky Romer 10-100 0 KoSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ Romer 10-200 1 KoSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ Romer 10-200 1 KOSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ Romer 10-200 1 KOSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ TRIM / LEISTE 4-015 4 LISTA / TRIM / LEISTE TRIM / LEISTE 4-010 3 UPINKA / FASTENER / SAMBELT / SÁGEBAND 2910.225171.00.90 4-011 3 UPINKA / FASTENER / SAMBELT / INBUSSCHRAUBE 2310.225171.00.90 255.032 2 0 SROUB INBUS / ALLEN HEAD BOLT / INBUSSCHRAUBE 8.20 0.00.002 2 0 PONLOZNA / WSHER / UNTERLEGSCHEALBE 8.20 000 0 PAKA UPINACI / ATTACHNERT LEVER / SPANNHEBEL NI2 8.20 001 0 REDUKCI / ADAPTOR / REDUKTION MI2 8.20	Ver. N226** 56510Y VEC. Ver. N226** 56510Y VEC. Ver. N226** 56510Y VEC. Ver. N226** 56510Y VEC. N226** 5610Y VEC. N24** N24*** N24*** N24*** N24*** N24*** N24*** N24**** N24**** N24**** N24**** N24**** N24****** N24******* N24********* N24************* N24*************************** <	Ver. Mozer sesiony UEDEMI PASU/BELT GUIDE/SAGEBAMDFÜHRUMG aci cislo Ver. Mozer polorły Rozmer aci cislo Ver. Mozer polorły Rozmer 0:000 0 KOSTKA VODICI / LEAD CUBE / FÜHRUMGSKLOTZ Rozmer 0:000 0 KOSTKA VODICI / LEAD CUBE / FÜHRUMGSKLOTZ Rozmer 4:015 4 LISTA / TRIM / LEISTE TriC 40:20 4:010 3 UPINKA / FASTEKER / SAMBELSEM 2910.25(7):40:90 4:013 3 UPINKA / FASTEKER / SAMBELSEM 0011TEK 4:014 4 LISTA / TRIM / LEIST 177C 40:15 2:5.032 2 0 POLMAA / KASHEL / MEDUSCHAUBE 0011TEK 0:002 2 0 POLOLAT / MELLESCHELBE 001012K 8 8:20 0:002 0 PAAA UPINACI / ATIACHMENT LEUSCHELBE 00102K 8 8:20 0020X 8 0:01 0 REDUKCE / REDUCTION / ADAPTOR / REDUKTION 001 001 0012K 8 0:01 0 REDUKCE / SALING / DOLUCTION REDUKCE / REUKTION 0012K 8 011

7.24. Kusovník / Stückliste / Piece list – Vedení pásu / Sägebandführung / Belt guide







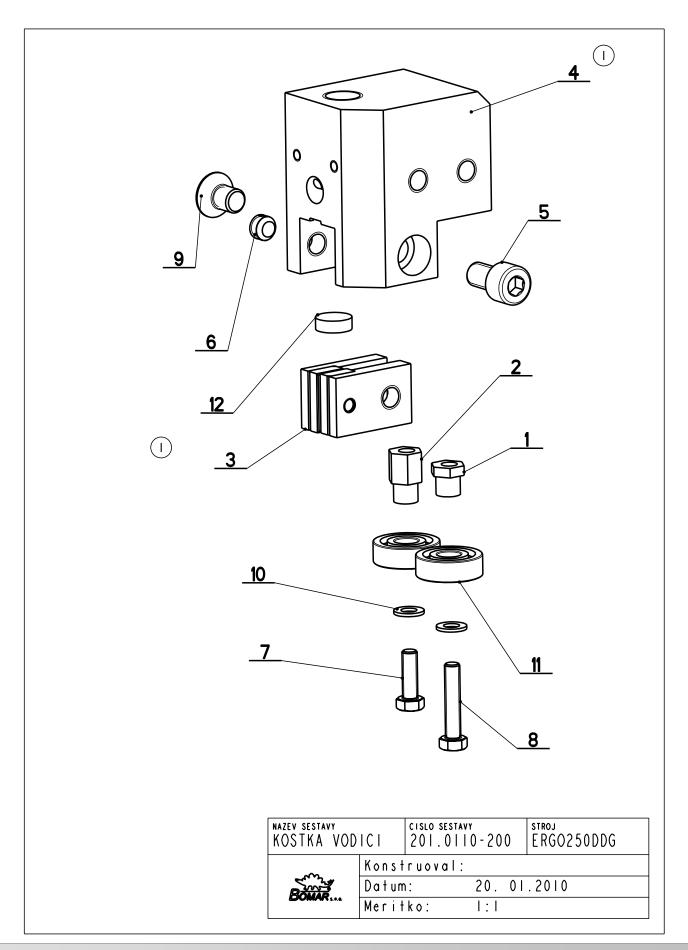
7.25. Vodící kostka / Führungsklotz / Guiding cube – 1

Roimer Ks Roimer Ks Skilo 2 Skilo 1 Skouß Mskilo 1	Rezmer Rezmer Ski0 Ski0 Ski0 Ski0 Bazia Bazia Ski0 Bazia Sk00B Bizis	Rezmer Rezmer Ski0 Ski0 Ski0 Ski0 Baxia Baxia Ski0 Baxia Sk00B Bixi5	Rezmer Rezmer Ski0 Ski0 Ski0 Ski0 Baxia Baxia Ski0 Baxia Sk00B Bixi5 Sk00B Bixi5 Sk00B Bixi5 Sk00B Bixi5 Sk00B Bixi5 Sk00B Bixi5 Sk00B Bixi5	R / HALTER Reimer / EXZENTER Reimer / EXZENTER SK10 / EXZENTER SK10 / LEAD CUBE / FÜHRUNGSKLOTZ SK10 / LEAD USTMENT BOLT / SECHSAUBE SR0UB MSX16 M / 6 SIDED BOLT / SECHSAUBE SR0UB MSX16 M / 6 SIDED BOLT / SECHSAUBE SR0UB MSX16 ZS / MASHER / UNTERSINK BOLT / SECHSAUBE SR0UB MSX12 ZS / MASHER / UNTERSINK BOLT / SECHSAUBE PODLOZAA 5,3
Rozmer Rozmer Sk 10 Sk 10 Sk 10 MSK 14 SR 10 MSK 16 SR 10 MSK 16 SR 10 MSK 15 SR 10 MSK 15 SR 10 MSK 12 SR 10 MSK 12 SR 10 MSK 12 SR 10 MSK 12 SR 10 SR 12 SR 10 SR 12 SR 10 SR 12 SR 10 SR 12 SR 12 SR 12 SR 12 SR 12 SR 12 SR 12				R / HALTER / EXZENTER / EXZENTER / EXZENTER / EZZENTER / LEAD CUBE / FÜHRUNGSKLOTZ / LEAD CUBE / FÜHRUNGSKLOTZ / LEAD CUBE / FÜHRUNGSKLOTZ / LEAD CUBE / FÜHRUNGSKLOTZ / LEAD CUBE / MBUUSCHRAUBE / ADJUSTWENT BOLT / STELLSCHRAUBE / ADJUSTWENT BOLT / STECHSANDSE / AD LUSTWENT BOLT / STECHSANDSE
	HANDE HANDE ANDE ANDE ANDE ANDE ANDE ANDE ANDE	ICSCHEIBE SSKLOTZ 1 / IMBUSSCHRAUBE / STELLSCHRAUBE / STELLSCHRAUBE CHSKANTSCHRAUBE / SEMSCHAUBE / SEMSCHAUBE		
	IGSKLOTZ IRAUBE IAUBE AUBE AUBE AUBE UBE	E / F UHR UNG SKL OT Z GSKLOT Z GSKLOT Z I / IMBUSSCHRAUBE / STELLSCHRAUBE / STELLSCHRAUBE / SEMSCHRAUBE / SEMSCHRAUBE / SEMSCHRAUBE / SEMSCHERAUBE / SEMSCHERAUBE		
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	IGSKLOTZ HRAUBE ANBE ANBE ANBE UBE	E / F ÜHRUNGSKLOTZ kesklotz kesklo		
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	IGSKLOTZ HRAUBE AUBE AUBE AUBE UDE	E / F ÜHRUNGSKLOTZ KGKLOTZ K		
		CSTKA VODICI/L COSTKA VODICI/L COSTKA VODICI/L REAK POLDER PALTEI REAK POLDER ALTEI CSTKA VODICI / LEAD CI CSTKA VODICI / LEAD CI CSTKA VODICI / LEAD CI NOUB IMBUS ZIMEK / ALI TAVECI S KUZEL / ADJUU ROUB ZAPUSTNY / G SIDI HR SROUB ZIM / G SIDI HR SROUB ZIM / G SIDI HR SROUB ZIM / G SIDI ROUB ZAPUSTNY / COUNTI ROUB ZAPUSTNY / COUNTI COLOZKA DINIZS / WASH UL. LOZ. I RADE / BEAI VEDDKOV / HARD METAL .	CSTKA V (OSTKA V 2224 polozk RZAK / HOLD RZENTR / CA XCENTR / CA XCENTR / CA XCENTR / CA XCENTR / CA XCENTR / CA STRA VOIC ROUB IMBUS IAVECI S KU HR SROUB Z HR SROUB Z HU L LOZ. I UL. LOZ. I VRDOMOV / H	
Nozek sestory Nozek polozky Nozek polozky DRZAK / HOLDER / HALTER EXCENTR / CAM / EXZENTER EXCENTR / CAM / EXZENTER EXCENTR / CAM / EXZENTER KOSTKA VODICI / LEAD CUBE / KOSTKA VODICI / LEAD CUBE / SROUB INBUS ZINKK / ALLEN HE STAVECI S KUZEL / ADJUSTMENT 6 HR SROUB ZINK / 6 SIDED BOL 6 HR SROUB ZINK / 6 SIDED BOL 6 HR SROUB ZINK / 6 SIDED BOL 5 ROUB ZADSTAN / COUNTERSINK PODLOZAA DINIZS / WASHER / U KUL. LOZ. I RADE / BEARING / KUL. LOZ. I RADE / BEARING / KUL. LOZ. I RADE / BEARING / KUL. LOZ. I RADE / BEARING /	NOZEK SESIONY NOZEK VODICI/LEAD Nozek polozky DRZK / HOLDER / HALTER EXCENTR / CAM / EXZENTER EXCENTR / CAM / EXZENTER EXCENTR / CAM / EXZENTER ROUB INBUS ZINEK / ALLEN HE SROUB INBUS ZINEK / ALLEN HE SROUB INBUS ZINEK / ALLEN HE STAVECI S KUZEL / ADJUSTMENT 6 HR SROUB ZIN / 6 SIDED BOL 6 HR SROUB ZIN / 6 SIDED BOL 6 HR SROUB ZIN / 6 SIDED BOL 8 ROUB ZAPUSTW / COUNTERSINK PODLOZAA DINIZS / WASHER / U KUL. LOZ. I RADE / BEARING / KUL. LOZ. I RADE / BEARING / VRDOKOV / HARD METAL / HN-S			
Nozer sestory KOSTKA VÓDICI/LEAD Nozer polozky DRZAK / HOLDER / HALTER EXCENTR / CAM / EXZENTER EXCENTR / CAM / EXZENTER EXCENTR / CAM / EXZENTER KOSTKA VODICI / LEAD CUBE / KOSTKA VODICI / LEAD CUBE / SROUB INBUS ZINEK / ALLEN HE STAVECI S KUZEL / ADJUSTMENT 6 HR SROUB ZINK / 6 SIDED BOL 6 HR SROUB ZINK / 6 SIDED BOL 5 ROUB ZAPUSTW / COUNTERSINK PODLOZAA DINIZS / WASHER / U KUL. LOZ. I RADE / BEARING / KUL. LOZ. I RADE / BEARING / KUL. LOZ. I RADE / BEARING /	NOZEK SESIONY NOZEK VODICI/LEAD Nozek polozky DRZAK / HOLDER / HALTER EXCENTR / CAM / EXZENTER EXCENTR / CAM / EXZENTER EXCENTR / CAM / EXZENTER ROUB INBUS ZINEK / ALLEN HE SROUB INBUS ZINEK / ALLEN HE SROUB INBUS ZINEK / ALLEN HE STAVECI S KUZEL / ADJUSTMENT 6 HR SROUB ZIN / 6 SIDED BOL 6 HR SROUB ZIN / 6 SIDED BOL 6 HR SROUB ZIN / 6 SIDED BOL 5 ROUB ZAPUSTW / COUNTERSINK PODLOZAA DINIZS / WASHER / U KUL. LOZ. I RADE / BEARING / KUL. LOZ. I RADE / BEARING / KUL. LOZ. I RADE / BEARING /			
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Ver. No.25 TKA VOD IC I / LE AD cislo Ver. Nozer polozky 21 0 DRZAK / HOLDER / HALTER 8 0 EXCENTR / CAM / EXZENTER 9 0 EXCENTR / CAM / EXZENTER 00 0 SROUB INBUS ZINER / ALLEN HE 003 0 STAVECI S NUZEL / ADJUSTMENT 003 0 SROUB ZINE / 6 SIDED BOL 001 0 SROUB ZINE / 6 SIDED BOL 003 0 SROUB ZINE / 0 SINE ZINE / 1 MH-S 003 0 NUL. LOZ. I RADE / BEARING / 1 MH-S	Vec. Nozer, setiony 0 KOSTKA VODICI/LEAD ver. Nozer polozky 0 DRZAK / HOLDER / HALTER 0 DRZAK / HOLDER / HALTER 0 EXCENTR / CAM / EXZENTER 0 KANONCI / LEAD CUBE / 0 STAVECI S KUZEL / ADJUSTNENT 0 KUL. LOZ. I RADE / BERNENT 0 KUL. LOZ. I RADE / BERRING / HH-S 0 KUL. LOZ. I RADE / MARRA / HH-S <td>Ker. Ver. 0 0 21 0 8 0 9 0 9 0 003 0 003 0 003 0 003 0</td> <td>Ker. Ver. 0 0 21 0 8 0 9 0 9 0 003 0 003 0 003 0 003 0</td> <td>Ver. Ver. 21 Ver. 21 Ver. 8 0 9 0 9 0 003 0 003 0 003 0 003 0</td>	Ker. Ver. 0 0 21 0 8 0 9 0 9 0 003 0 003 0 003 0 003 0	Ker. Ver. 0 0 21 0 8 0 9 0 9 0 003 0 003 0 003 0 003 0	Ver. Ver. 21 Ver. 21 Ver. 8 0 9 0 9 0 003 0 003 0 003 0 003 0

7.26. Kusovník / Stückliste / Piece list – Vodící kostka / Führungsklotz / Guiding cube – 1







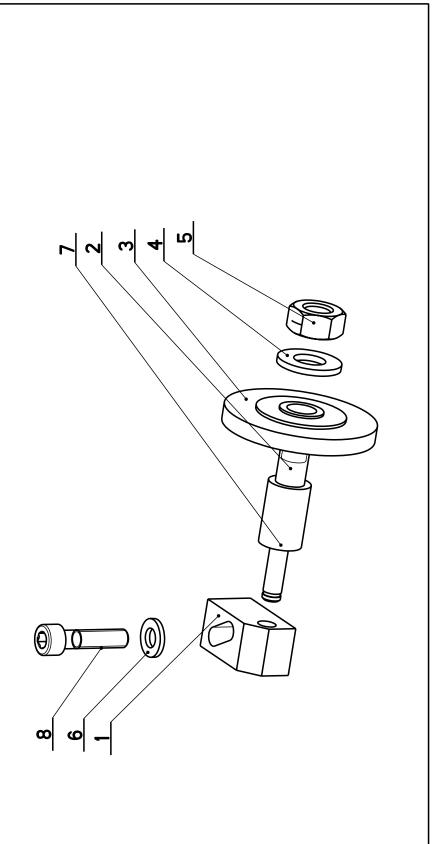
7.27. Vodící kostka / Führungsklotz / Guiding cube – 2

							-		-	-	-		-	ngsklotz / Guiding cube – 2
	Ks	_	_	2	_	_	_	_	_	_	2	2	_	_
	Rozmer	SKIO	SKID		TYC 60x40	M8X14	SROUB M8X6	SROUB M5X16	SROUB M5X25	SROUB M8X12	PODLOZKA 5,3	608 2RS	C 4	JC. 30.0104-031.
Mosev sestory KOSTKA VODICI/LEAD CUBE/FÜHRUNGSKLOTZ	Nazev polozky	EXCENTR / CAM / EXZENTER	EXCENTR / CAM / EXZENTER	DRZAK / HOLDER / HALTER	KOSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ	SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE	SROUB STAVECI / ADJUSTMENT BOLT / STELLSCHRAUBE	SROUB 6HRANNY / 6 SIDED BOLT / SECHSKANTSCHRAUBE	SROUB 6HRANNY / 6 SIDED BOLT / SECHSKANTSCHRAUBE	SROUB ZAPUSTNY / COUNTERSINK BOLT / SENNSCHRAUBE	PODLOZKA / WASHER / UNTERLEGSCHEIBE	LOZISKO / BEARING / LAGER		TVRDOKOV / HARD NE TAL / HW-SEGMENT NAHRAZENA SOUC.30.0104-021, ZRUS.SOUCAST 30.0104-016 NAHRAZENA SOUC.30.0104-031.
- Ker.	Ver.	0	0	0	2	0	0	0	0	0	0	0	-	
ste Sestery 01.0110-200	. Objednaci cislo	30.0104-018	30,0104-019	30.0104-021 (1)	30.0104-031	90.001.55.082	90.002.2D.009	90.005.55.003	90.005.55.005	90.011.27.007	0 90.150.50.003	95.001.001		I ZRUS. SOUCAST 30.0104-020 297/ZM272 12.8.2008 KRPEC
	KOSTKA VODICI/L	Ver. Nozev sestovy I KOSTKA VÖDICI/LEAD CUBE/FÜHRUNGSKLOTZ islo Ver. Nozev polozky I Rozmer	Ver. Nozev sestavy I KOSTKA VODICI/LEAD CUBE/FÜHRUNGSKLOTZ islo Ver. Nozev polozky isl 0 EXCENTR / CAM / EXZENTER	Ver. Nozev sestavy I KOSTKA VODICI/LEAD CUBE/FÜHRUNGSKLOTZ islo Ver. Nozev polozky islo Ver. Nozev polozky islo EXCENTR / CAM / EXZENTER SKI0 islo EXCENTR / CAM / EXZENTER SKI0	Ver. Nozev sestavy I Nozev sestavy I KOSTKA VODICI/LEAD CUBE/FÜHRUNGSKLOTZ islo Ver. Nozev polozky 0 EXCENTR / CAM / EXZENTER 0 EXCENTR / CAM / EXZENTER 0 DRZAK / HOLDER / HALTER	Ver. Mazer sestory 1 KOSTKA VODICI/LEAD CUBE/FÜHRUNGSKLOTZ islo Ver. Nozer polozky islo Ver. Nozer polozky islo isto Rozmer 0 Excentr / cam / exzenter ski0 1 0 DRZak / HOLDER / HALTER ski0 1 2 KOSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ TYC 60x40	Ver. Mazev sestory I KeSTKA VODICI/LEAD CUBE/FÜHRUNGSKLOTZ isio Ver. Nazev polozky Rozmer isio Ver. Nazev polozky Skio isio D EXCENTR / CAM / EXZENTER Skio 0 EXCENTR / CAM / EXZENTER 1 2 KOSTKA VODICI / LEAD CUBE / FÜHRUNGSKLOTZ 82 0 SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE	Ver. Mazer sestory 1 KOSTKA VODICI/LEAD CUBE/FÜHRUNGSKLOTZ isio Ver. Mazer polozky isio Ver. Nazer polozky isio Ver. Nazer polozky isio Ver. Nazer polozky isio Ver. Nazer polozky isio Nezemter Skio 0 Excenter / cam / exzenter Skio 1 2 Kostra vodici / Lead cube / führungsklotz 17C 60±40 82 0 Skoub indus / allen bolt / indussklotz Maxia 0 Stoub Staveci / adjustent bolt / stellschraube Sroub Maxia	Ver. Nozek sestory I KOSTKA VODICI/LEAD CUBE/FÜHRUNGSKLOTZ isio Ver. Nozek polozky isio isio Rigo isio isio Rigo isio isio Skio isio isio Skio isio isio Skio isio D Rika vodici / LEAD CUBE / FÜHRUNGSKLOTZ Skio isio SROUB IMBUS / ALLEN HEAD BOLT / IMBUSSCHRAUBE Maxia isioub Staveci / ADJUSTMENT BOLT / SECHSANTSCHRAUBE SROUB BARANY / 6 SIOED BOLT / SECHSANTSCHRAUBE SROUB MSK6	Ver Nozev sestovy 1 KOSTKA VODICI/LEAD CUBE/FÜHRUNGSKLOTZ islo Ver. Nozev polozky 0 Excentre / cam / exzenter Skio 1 2 Nostak / Holder / Halter 1 2 Kostra vodici / Lead cube / führungsklot2 It'c 60±40 82 0 Sroub inbus / Allen Head Bolt / imbusschraube Nostia 0 Sroub street / adjustent Bolt / inbusschraube Nostia Nostia 0 Sroub street / adjustent Bolt / stelskantschraube Sroub misk Sroub misk 0 Sroub street / adjustentabe Sroub misk Sroub misk 0 Sroub street / siden Bolt / stelskantschraube Sroub misk Sroub misk 0 Sroub street / adjust Sroub misk Sroub misk Sroub misk 0 Sroub street / stelskantschraube Sroub misk Sroub misk Sroub misk	Ver. Nazer sestory 1 KÖSTKA VÖDICI/LEAD CUBE/FÜHRUNGSKLOTZ islo Ver. Nazer polozky 0 Excentr / CAM / EXZENTER Rozmer 1 2 Kozka vodici / LEAD CUBE / FÜHRUNGSKLOTZ 1 2 Kost avodici / LEAD CUBE / FÜHRUNGSKLOTZ 1 2 Kost avodici / LEAD CUBE / FÜHRUNGSKLOTZ 1 2 Kost vodici / LEAD CUBE / FÜHRUNGSKLOTZ 1 2 Kost avodici / LEAD CUBE / FÜHRUNGSKLOTZ 1 2 Kost avost a	Ver. Macere sestory 1 KOSTKA VODICI/LEAD CUBE/FÜHRUNGSKLOT2 1 KOSTKA VODICI/LEAD CUBE/FÜHRUNGSKLOT2 1 Noer polozky 1 Nobici / Exemeter 1 Nobici / Lead cube / Führundsklot2 1 Z Nobici / Lead cube / Führundsklot2 1 Nobici / Lead cube / Führunds	Ver. Nazer settory 1 KOSTKA VODICI/LEAD CUBE/FÚHRUNGSKLOTZ 1 KOSTKA VODICI/LEAD CUBE/FÚHRUNGSKLOTZ 1 Nerer polozky 1 Rozmer 1 Rozer polozky 1 Rozer polozy 1 Rozer polozy <th>Ver. Nazer sestory 1 KOSTKA VÖDICI/LEAD CUBE/FÜHRUNGSKLOTZ 1 KOSTKA VÖDICI/LEAD CUBE/FÜHRUNGSKLOTZ 1 Ner. 1 Ner. <!--</th--></th>	Ver. Nazer sestory 1 KOSTKA VÖDICI/LEAD CUBE/FÜHRUNGSKLOTZ 1 KOSTKA VÖDICI/LEAD CUBE/FÜHRUNGSKLOTZ 1 Ner. 1 Ner. </th

7.28. Kusovník / Stückliste / Piece list – Vodící kostka / Führungsklotz / Guiding cube – 2



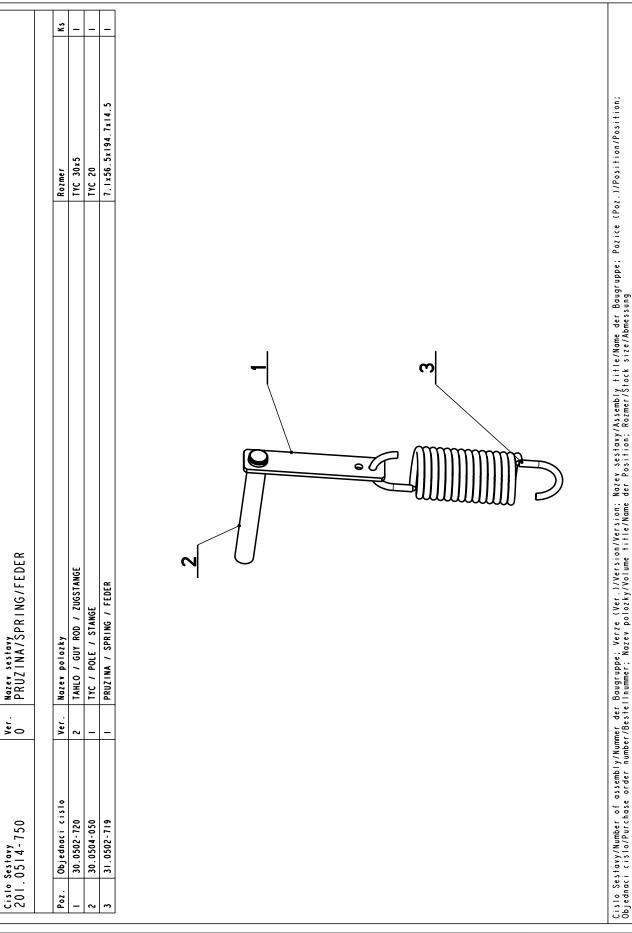
cislo 201	cislo Sestory 201.0704-100	ver. 0	Nozev sestovy KARTAC/BRUSH/BŮRSTE		
Poz.	Objednaci cislo	Ver.	Nazev polozky	Rozmer	Ks
_	30.0104-022	0	DRZAK / HOLDER / HALTER	HR I6xI6	_
2	30,0704-029	0	HRIDEL / SHAFT / WELLE	d 14	_
۳	31,0704-031	0	KARTAC / BRUSH / BÛRSTE		_
4	90,150,50,006	0	PODLOZKA DINI25 / WASHER / UNTERLEGSCHEIBE	PODLOZKA 10,5	_
5	90,100.55.006	0	MATICE / NUT / MUTTER	MATICE _ MIO	_
و	90,150.50.004	0	PODLOZKA / WASHER / UNTERLEGSCHEIBE	PODLOZKA 6.4	_
7	95,800,001	0	KROUZEK POJIST.VNEJS / OUTSIDE SAFETY RING / SICHERUNGSRING AUBEN	POJISTNY KROUZEK 6	_
8	90,001.25.019	0	SROUB IMBUS CERNENY / ALLEN HEAD BOLT / IMBUSSCHRAUBE	M6X25	_



7.29. Kartáč / Bürste / Brush

BOMAR

		Boman
ng		
		on; Nazev sestavy/Assembly title/Name der Baugruppe; Pozice (Poz.)/Position/Position; ame der Position; Rozmer/Stock size/Abmessung
	e T T T T T T T T T T T T T T T T T T T	on; Nazev sestavy/Assembly fitle/Name der B ame der Position; Rozmer/Stock size/Abmessu



7.30. Pružina / Feder / Sprin