# UE-127DV1

## PORTABLE BAND SAW MACHINE

Study Carefully Before Operating

## Specifications

| Capacity: | ● | ■ |
|---|---|---|
| **90°** | 125 mm | 120 x 120 mm |
| **45°** | 70 mm | 120 x 70 mm |
| **60°** | 35 mm | 65 x 35 mm |

| | |
|---|---|
| **Blade Size** | 13 x 0.65 x 1440 mm |
| **Blade Speed** | 23 ~ 75 MPM |
| **Blade Motor** | 300 W (DC) |
| **Packing Size (LxWxH)** | 730 x 383 x 475 mm |
| **Weight (N.W / G.W)** | 24 kg / 27 kg |

K05-E03 4/2015

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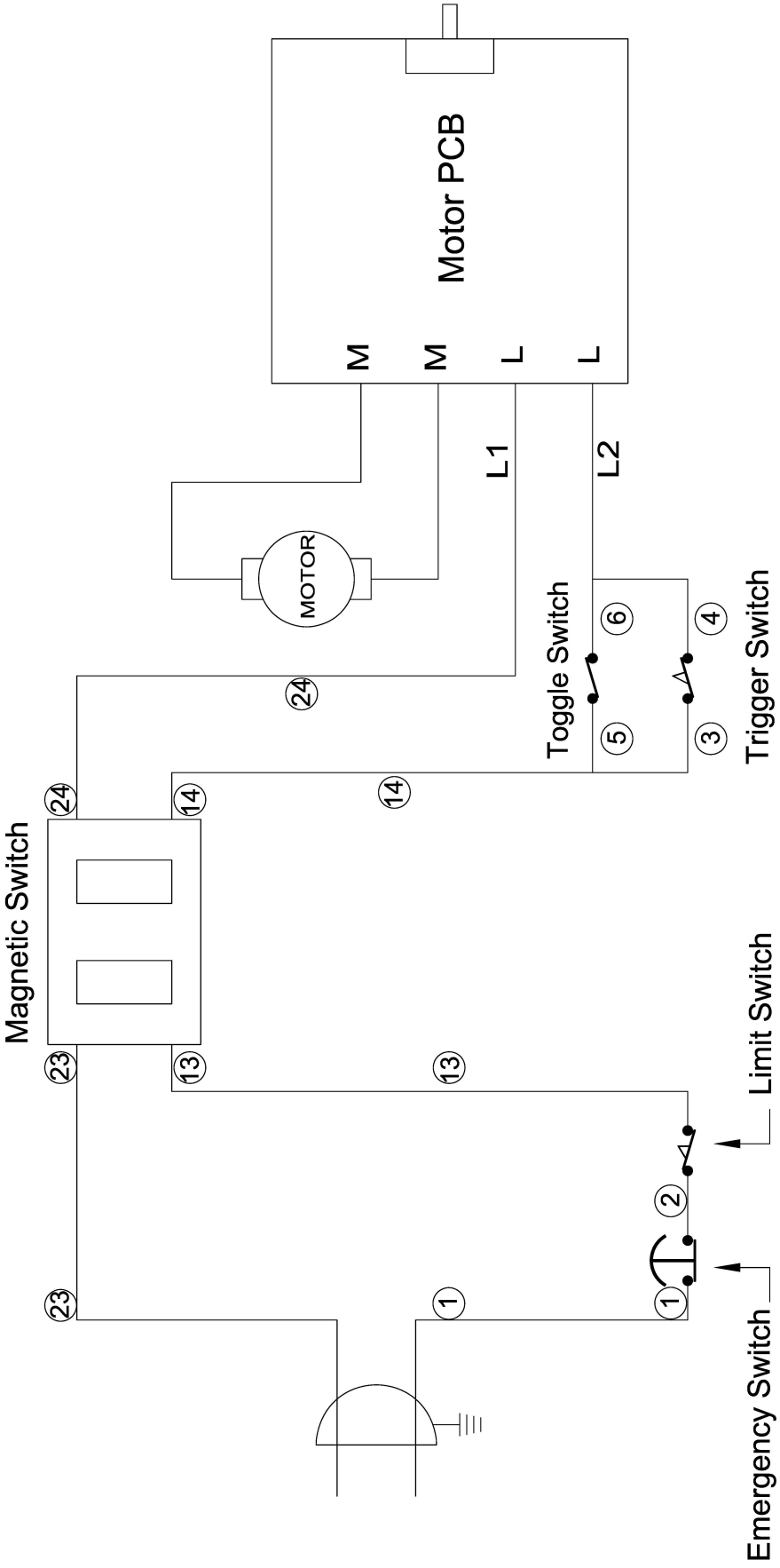
## 1. *General Safety Rules*

### ⚠ WARNING

1. Read and understand instructions of this manual entirely before operating the machine.
2. Always wear approved safely glasses /face shields when using the machine.
3. Make certain the machine is properly grounded.
4. Before machine in operation, remove tie, ring, watch, other jewelry, and roll your sleeves up to above elbows. Remove loose clothing and confine long hair.
5. Keep the floor around this machine clean and free of scrap material, oil and grease.
6. Keep machine guards in place at all times when the machine is in use. If it removed for maintenance purpose, pay extra attention and replace these guards at once.
7. Do not over reach. Keep a balanced stance all the time so that your don't fall lean against blade or some other moving parts.
8. Whenever make any adjustments or maintenance with the machine must unplugged the power source.
9. Use the right tool. Don't force a tool or attachment to do a job that it was not designed for.
10. Replace warning labels if they have become obscured or removed.
11. Make certain the motor switch is in "off" position while connecting the machine into the power supply.
12. Pay your work undivided attention. Looking around, and carrying on a conversation, or "Horse-play" are careless acts which might result in serious injury.
13. Keep visitors a safe distance from the work area.
14. Use recommended accessories, and parts. Improved accessories may be hazardous.
15. From the good habit of checking, to see keys and wrenches are removed before turning on this machine.
16. Always keep hands & fingers away from the black when this machine is running.
17. Never hold a material with this saw in the horizontal position. Please be sure always use the vise to clamp it securely.
18. Read and understand warnings that posted on the machine.
19. Always provide necessary support for long and heavy material.
20. Use a sharp blade and always keep machine clean for a best and safest performance.
21. Failure to comply with any of these warnings may cause serious injury.

## Electrical Schematic



**⚠ BEFORE CUTTING**

Release the lock pin (A) in Fig.1 to free this saw. After service, must relock in the pin properly for your safety and carry. Failure to comply with the warning could result in personal injury and machine damage.

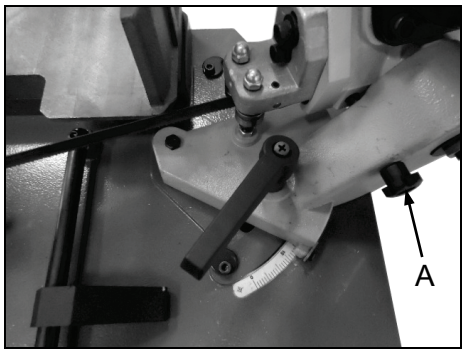
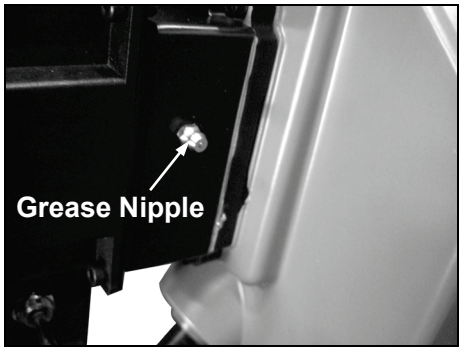



Fig. 1

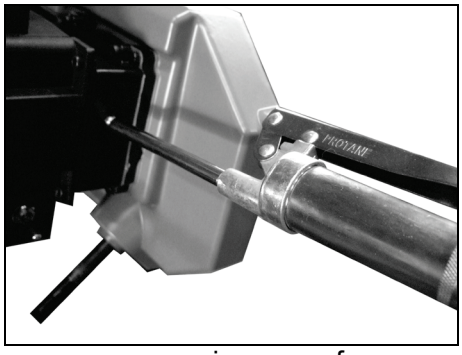
## Before Cutting and Pump Grease

**⚠ ATTENTION**

Pump grease into the gear reducer every week to lubricate the gears avoid gears got high temperature when machine be used continuously.
Choose super high-density grease.




Grease nipple located at rear of gear reducer



Use grease gun pump in grease from grease nipple.

## 2. *The Quick Vise and Work Set Up*

## Usage of the Vise

The vise is mounted on the machine base. Follow the easy steps to open or close the vise.

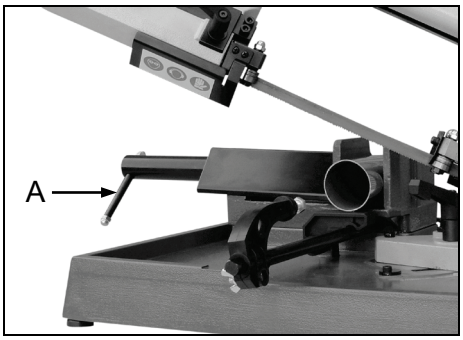



Fig. 2

1. Turn the handle (A) in Fig.2 counter clock-wise to open the vise jaw to allow the width of vise can load work piece.
2. Make sure the work piece is well located on the table. Turn the handle (A) in Fig.2 clock-wise to close the vise jaw to clamp the work piece.

**CAUTION !**

NEVER OPERATE SAW WITHOUT BLADE GUARDS IN PLACE.

## Work Set Up

1. Raise saw head to proper position in Fig.3.
2. Open vise to accept the piece to be cut by pulling the hand lever at the end of the base.
3. Place work piece on saw bed if the piece is long, support the end.

Fig.3

## 3. *Special Safety Rules for Metal Saw*

> ⚠ **WARNING:** For your own safety, do not operate your metal saw until it is completely assembled and installed according to the instructions…and until you have read and understood the following.

## Before Using the Saw

1. Assembly and alignment.
2. Learn the function and proper use of:
   A. The on-off start switch, trigger switch, blade speed knob and stop button.
   B. The lower blade guards.
   C. The fixing saw bow latch.
   D. The bevel clamp, fence clamps, and metal lock handle.
3. Read and understand all safety instructions and operating procedures throughout the manual.
4. Read the warning labels on the metal saw.

## Before Each Use

1. Inspect your saw. If any part of this metal saw is missing, or bent, or has failed in any way, or any electrical parts do not work properly, turn the saw off and unplug the saw. Replace damaged, missing, or failed parts before using the saw again.
2. Plan your work to protect your eyes, hands, face and ears.
   A. Wear safety goggles (not glasses) that comply with DIN 58214 (show on package). Using any power tool can result in foreign objects being thrown into the eyes, which can result in permanent eye damage. Goggles are available at stores. Use of glasses or use of goggles not in compliance with DIN 58214 could result in severe injury from breakage of the eye protection.
   B. For dusty operations, wear a face shield along with safety goggles.
   C. To avoid injury from jams, slips or thrown piece:
      - It is important to choose the right blade for the material and the type of cutting you plan to do. This saw is equipped with a bi-metallic blade which can be used to cut stainless steel, steel, iron, brass, aluminum, wood, plastic and so on.
      - Make sure the direction of rotation arrow on the blade matches the direction arrow on the saw. The blade teeth should always point downward at the front of the saw.
      - Make sure the blade is sharp, undamaged and properly aligned. With the saw unplugged, push the power-head all the way down. Head spin the blade and check for clearance. If the blade hits anything, make the adjustments shown in the Maintaining Maximum Cutting Capacity section.
      - Make sure the blade and arbor collars are clean.
      - Make sure all clamps and locks are tight and there is no excessive play in any parts.
      - Never cut freehand:

      a. Brace your work piece solidly against the fence and table top so it will not rock or twist during the cut. Make sure no debris is caught beneath the work piece.
      b. Make sure no gaps between the work piece, fence and table will let the work piece shift after it is cut in two.
      c. Use jigs, fixture or a different tool for unstable work pieces.

      - Never cut more than one work piece at a time.
      - Make sure the cut-off piece can move sideways after it is cut off. Otherwise, it could get wedged against the blade and thrown violently.
      - Make sure bystanders are clear of the tool and work piece. Keep them clear of the area behind the saw where debris will be thrown.
      - Never turn your metal saw “ON” before clearing everything except the work piece and related support devices off the table.

   D. To avoid risk of hearing damage, wear ear plugs or muffs during extended period of operation.

   E. To avoid being suddenly pulled into the blade:
      - Do not wear gloves.
      - Remove all jewelry and loose clothing.
      - Tie back long hair.
      - Roll long sleeves above the elbow.

F. To avoid injury from accidental starting, always unplug saw before disconnecting the guard, installing or removing any blade, accessory or attachment, or making any adjustment.
G. To avoid an electrical shock, make sure your fingers do not touch the metal prongs on the plug when inserting or removing the plug to or from a live outlet.
H. Never put lubricants on the blade while it is spinning.
I. To avoid burns or other fire damage, never use the saw near flammable liquids, vapors or gases.
J. To avoid injury from unsafe accessories use only accessories shown on the recommended accessories list in this manual.

## Whenever Saw is Running

⚠ **WARNING:** Do not allow familiarity (gained from frequent use of your metal saw) to cause a careless mistake. Always remember that a careless fraction of a second is enough to cause a severe injury.

1. Before actually cutting with the saw, let it run for a while. If your saw makes an unfamiliar noise or if it vibrates excessively, stop immediately. Turn the saw off. Unplug the saw. Do not restart until finding and correcting the problem.
2. Never confine the piece being cut out. Never hold it, clamp it, touch it, or use length stops against it. It must be free to move sideways. If confined, it could get wedged against the blade and thrown violently.
3. Avoid awkward hand positions where a sudden slip could cause a hand to move into the blade.
4. Let the blade reach full speed before cutting.
5. Feed the saw into the work piece only fast enough to let the blade cut without bogging down or binding.
6. Before freeing jammed material, turn the switch off and unplug the saw. Wait for all moving parts to stop.
7. After finishing a cut, keep holding the power head down, release the switch, and wait for all moving parts to stop before moving your hands.

⚠ **WARNING:**
Read the following warning labels found on the front of the saw.

⚠ **DANGER**
- Keep hands out of saw blade path.
- Never cut anything freehand.
- Never reach behind or beneath blade.
- To avoid electric shock, do not expose to rain.

⚠ **DANGER**
- Tighten arbor screw and all clamps before turning power on.

## 4. *Power Supply*

## Motor Specifications

The DC motor is used in this saw as the following specifications:

| | |
|---|---|
| Maximum capacity (kW) | 0.30 |
| Voltage (V) | 230 |
| Saw blade speed (MPM) | 23~75 |
| Blade rotating direction | counter-clockwise |
| Weight N.W (kg) | 24 |

⚠ **WARNING:** To avoid electrical hazards, fire hazard, or damage to the tool, use proper circuit protection or circuit breaker to avoid shock or fire, if power cord is worn or cut, or damaged in any way, have it replaced immediately.

Noise information according to DIN 45635

| | |
|---|---|
| No load | under 60 dB |
| Working | 60-65 Db |

## Earth

This metal saw is single insulated tool, so the earth system is provided to protect you from being shocked. The appropriate earth system is set up as soon as this machine is plugged into the proper power supply system. Therefore, the standard power supply system shall be provided for this machine in order to protect you from the risk of shock.

⚠ **DANGER:** To avoid electric shock
1. Do not change the power cord and plug to another specification not provided by the manufacturer.
2. Do not use in rain or where floor is wet. This tool is intended for indoor residential use only.

## Motor Safety Protection

⚠ **CAUTION:** To avoid motor damage, this motor should be blown out or vacuumed frequently to keep sawdust from interfering with normal motor ventilation.

1. Connect this tool with a fuse or circuit breaker. Using the wrong size fuse can damage the motor.
2. If the motor does not start, press the stop button down immediately. UNPLUG THE TOOL. Check the saw blade to make sure it turns freely. If the blade is free, try to start the motor again.
3. If the motor still does not start that have to check the motor's carbon brushes which can be used 600~800 hours if carbon brushes has been worn, please change the new one.
4. If the motor suddenly stalls while cutting material, press the stop button off, unplug the tool, and free the blade from the steel Then you may restart the motor and finish the cut.
5. Fuses may "blow" or circuit breakers may trip frequently if:
   a. Motor is overloaded-overloading can occur if you feed too rapidly or make too many start/stops in a short time.
   b. Voltage not more than 10% above or below the nameplate voltage can handle normal loads. For heavy loads, however, the voltage (caused by a small size wire in the supply circuit or an overly long supply circuit wire) may drop too low for the motor to operate. Always check the connections, the load and the supply circuit whenever motor does not work well. Check wire sizes and length with the Wire Size Chart below.
6. Most motor troubles may be trace to loose or incorrect connections, overload, low voltage (such as small size wire in the supply circuit) or to overly long supply circuit wire. Always check the connections, the load and the supply circuit whenever motor doesn't work well. Check wire size and length with the Wire Size Chart below.

## Wire Sizes

The use of any extension cable will cause some loss of power. To keep this to a minimum and to prevent overheating and motor burn-out, use the table below to determine the minimum wire size (lead cross-section) of an extension cable.
For circuits that are more than 40m away from the electrical service box, the wire size must be increased proportionately in order to deliver ample voltage to the saw motor.

| Length of the Conductor | Wire Sizes Required For 220V |
|---|---|
| up to 15m | 1.5mm$^2$ |
| 15-40m | 2.5mm$^2$ |

## 5. *Unpacking and Checking Contents*

The Metal Saw is shipped complete in one carton. Separate all parts from packing material and check each item with illustration and Make certain all items are accounted for, before discarding any packing material.

⚠ **WARNING:** If any parts are missing, do not try to assemble the metal saw, plug in the power cable or turn the switch on until the missing parts are obtained and installed correctly.

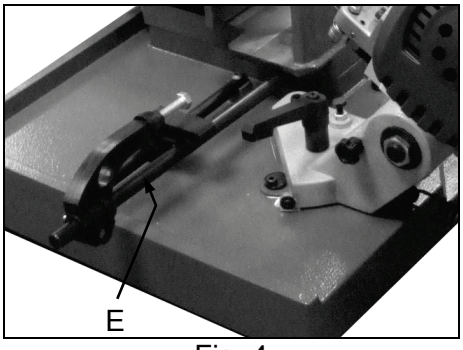


Fig. 4

| Item | Attached Parts | Q'TY |
|---|---|---|
| 1 | Stop Rod Assembly (E) Fig.4 | 1set |
| 2 | Instruction Manual | 1 |

## 6. *Description and Characteristics*

1. This 127DV1 portable band saw is made as light as 24 kg by weight for your fitness to transport to any worksites.
2. This machine frame is cast by the aluminum. The base formed by the steel so that body construction becomes stronger and smoother.
3. During operation, the noise level of this machine is about 60 db, which is much less than any of the other band saws, and of course, it can present a comfortable working environment.
4. This machine is made ready for the blade tension adjustment by holding the handle to give a little turn for the tension increasing, or decreasing as you wish during the period of blade replacement or machine in operation. Also attached compression spring that for reducing vibration that is from a defective work piece popping while machine is running. It permits the blade to be used much longer.
5. The drive of this machine is through gear transmission that gives steadier, stronger, and smoother cuts superior to any of pulley drive band saws, and make less trouble after service. Note: If anything unusual happens on your gear transmission system, do not try to fix or restore it personally. Send it back to your dealer for check-up or repair. Failure to comply can result in machine damage.
6. The machine combines miter, and horizontal cutting and is designed for full efficiency and operator convenience in each position.

**⚠ WARNING**

SHUT OFF THE POWER SOURCE ALL THE TIME, BEFORE THIS MACHINE IS IN MAINTENANCE, OPERATION, ADJUSTMENT, OR REPAIRMENT.

**⚠ WARNING**

Disconnect machine from the power source! No matter when, where, or how. Pay extra attention to the saw during it in transportation, operation, maintenance, or adjustment. Failure to comply may cause serious injury!

## 7. *Operating*

### Information before Operation

Be sure the blade isn't in contact with the work when the motor is started.

Run the motor allow the saw to come to full speed. Begin the cut by letting the head down slowly onto the work.

DO NOT DROP. Let the weight of the saw provide the cutting force or use the trigger switch handle operating by hand.

Press green button down (Fig. 5) for auto cutting, feed rate by bow weight, the trigger switch (FIG.6) for manual cutting.

Finished cutting or stop the cutting by press down the red button or switch off the trigger switch.

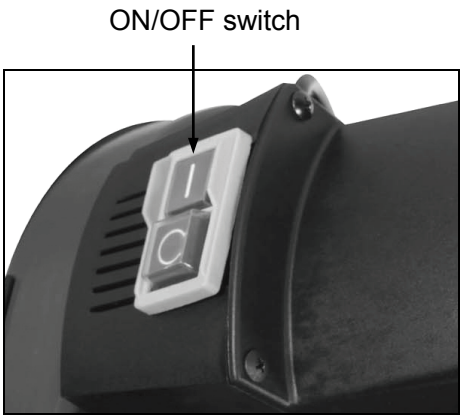



Fig. 5

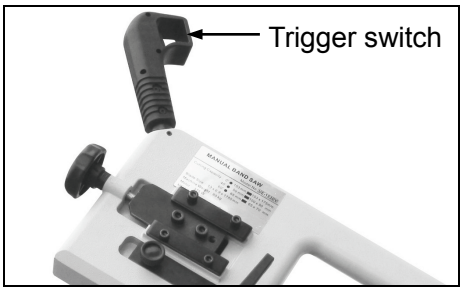
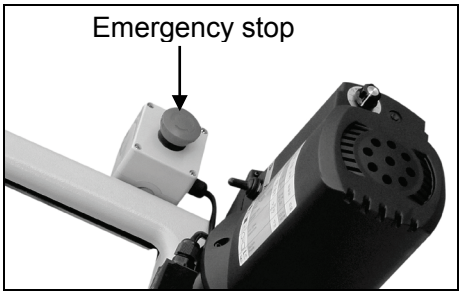


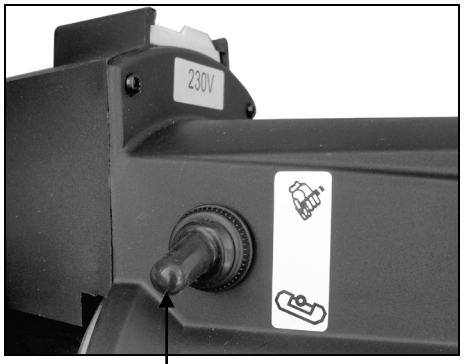

Fig. 6

While cutting, If any emergency event need to stop the machine immediately, Push the red button to stop the machine.

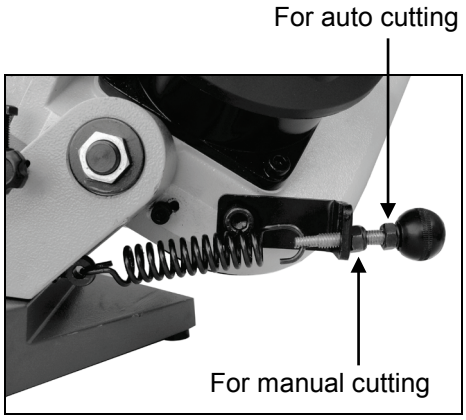


## *Auto Cutting*
### Feed Rate by spring holding

Turn toggle switch to down location. Select spring as outer location. Press green button down to start auto cutting.

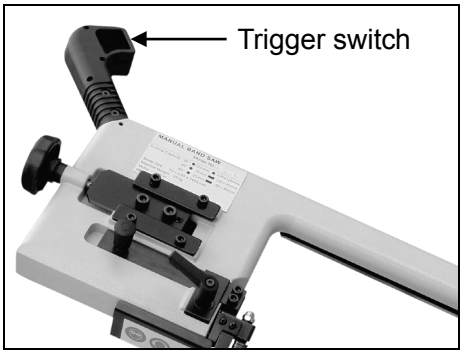



Cutting mode switch




## *Manual Cutting*
### Feed Rate by Handle with Trigger Switch

Turn toggle switch to upper location.
Select spring as inner location.
Push down the trigger switch for cutting material by handle.




## Angle Cutting

The machine uses a swivel miter base for angle cutting from 0 ~ 60 degree. On the sawing arm, there is an attached scale (Q) in Fig.7. This machine is preset zero degree before leaving the factory. Angle cutting is adjusted as follows.

1. Loosen handle (R) Fig.7 to release the arm.
2. Move this swivel arm forward along the scale to search a right index for the work to be cut.
3. If the pointer matches the right index on the scale. Tighten the handle, and a perfect angle cut will be given.

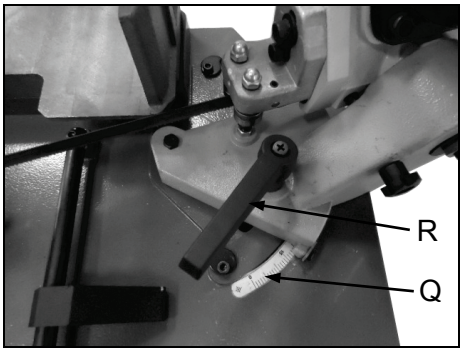



Fig. 7

**⚠ WARNING**
Disconnect machine from the power source! No matter when, where, or how. Pay extra attention to the saw during it in transportation, operation, and maintenance. Or adjustment. Failure to comply may cause serious injury!

## Changing Blade

1. Raise this saw head up-to proper position by lifting up the arm Fig. 8.

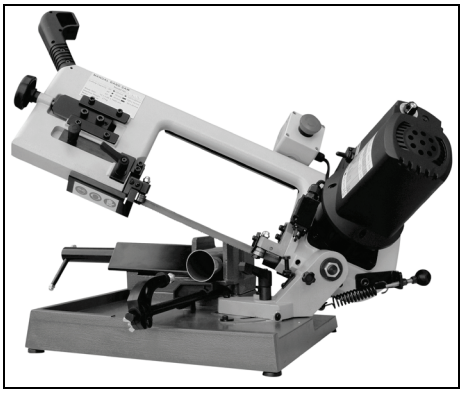


Fig. 8

2. Remove the blade guard by loosening two screws (U) in Fig. 9 on the saw frame.

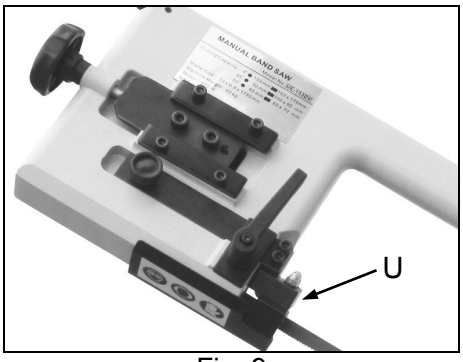



Fig. 9

3. Remove blade cover by loosening four screws (V) in Fig.10 on the saw frame.

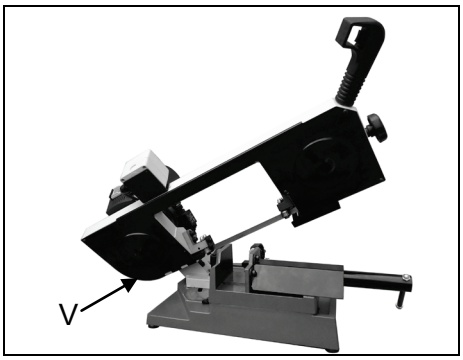
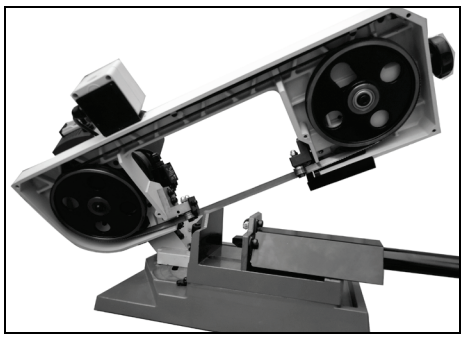



Fig. 10



4. Turn the blade tension wheel (W) in Fig.11, Counter-clockwise let the blade slip off.

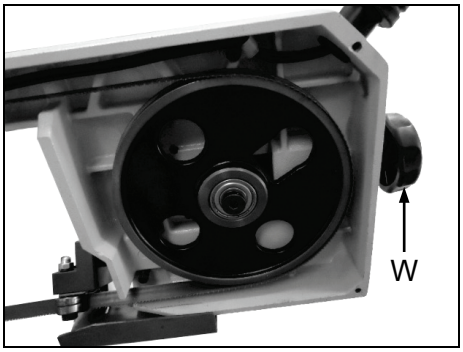



Fig. 11

5. Remove blade from both wheels and blade guides bearings (X) in Fig.12.

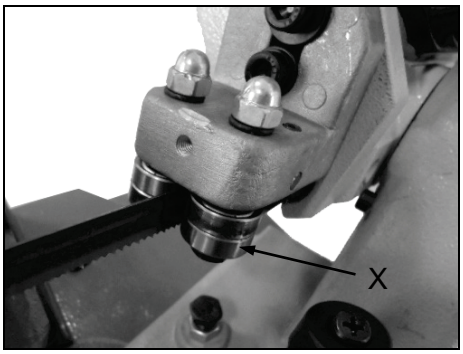



Fig. 12

6. Place a new blade on the wheels but not too tight, twist blade slightly and let it slip into between each of guide bearings. Make sure the teeth of blade face down toward the bed.
7. Turn the tension wheel clockwise to make the blade tension be tensioned properly.
8. Replace blade cover (V) in Fig.10 and guards Fig.9.
9. Start the machine to see that the blade runs properly.

Caution: Be sure that the machine is disconnected from the power source before attempting to service or take any component away!

## Magnetic Switch

The band saw is equipped with magnetic switch in Fig.13, which is designed for operating safety. After power failure, the machine has to be restarted by pushing the green “ON” button.

There is a red button, which depresses it to stop all machine functions.

Fig. 13

## 8. *Adjusting*

## Adjusting Blade Guide

An unbounded handle (A) in Fig.14 is mounted on the unit for freely changing blade guide device position by loosens it counter- clockwise.

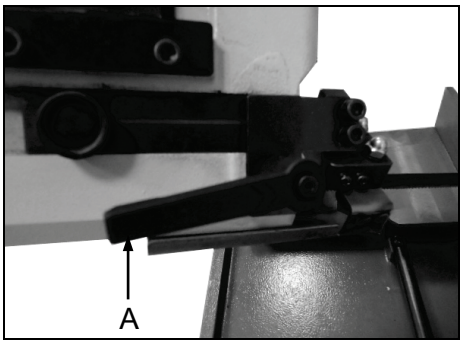


Fig. 14

It's designed for your convenience to adjust blade guide easily and quickly at any time, and under any situation. Adjustment of this blade guide is in accordance with the sizes of work pieces. The one located at the left of the saw head can be adjusted and the other is fixed.

When cutting a small work, move the guide toward the work as close as it can be. Both cuttings will present you satisfactory jobs.

> ⚠ **WARNING**
> Do not make any adjustments, or load, unload work from vise when machine is running!

## Adjusting Poor Cutting

The machine has been adjusted and power-tested with several test cuts before leaving the factory to insure proper cutting. If there is any poor cuts occurred, correct it as follows.

1. Bad cuts due to blade worn, replace a new blade.
2. The saw uses fixed ball bearings and can be adjusted ball bearing by eccentric bearing shaft (B) in Fig.15, 16 (A) is to keep the tolerance with the blade. For keeping proper cutting, the best way is to replace them every three or six months depending on the frequency of service.
3. Poor cuts can be made because the nuts (A) in Fig.15, 16 are getting loose. Then tighten it properly.

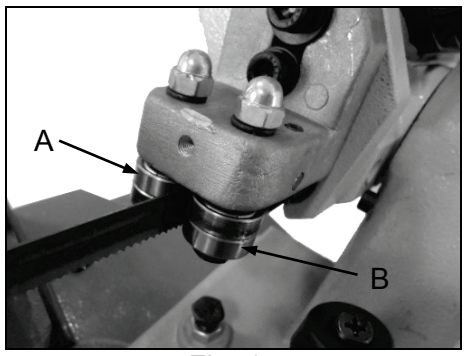


Fig. 15

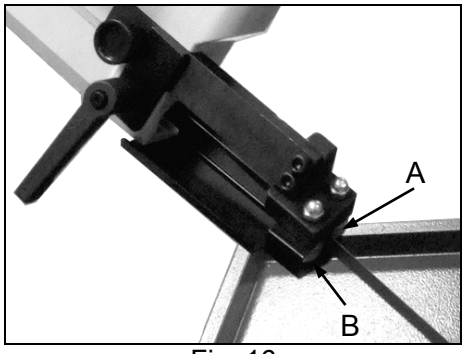


Fig. 16

> ⚠ **WARNING**
> SHUT OFF THE POWER SOURCE BEFORE THIS MACHINE IS IN ADJUSTMENT, MAINTENANCE, OR REPAIRMENT.

## Changing the Motor Carbon Brushes

If the motor is making an unusual noise then the carbon brushes may need to be replaced.

1. Disconnect machine from power supply.
2. Remove two tap screws connected with on/off switch's box, and three Phillips head screws around cover base. (Fig. 17)
3. There are two plastic covers on the motor (Fig.18) after uncovering the motor's cover. Remove plastic covers.
4. There are coppers sheet with wiring covered on the carbon brushes (Fig.19).
5. Slide copper sheet to the one way (Fig.20), the carbon brush will jumps out (Fig.21).
6. Replace the carbon brushes (Fig. 22). Both brushes must be replaced at the same time.
7. Replace the carbon brushes' cover and motor cover.

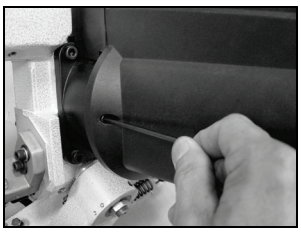


Fig. 17

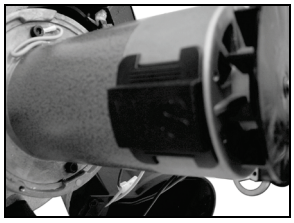
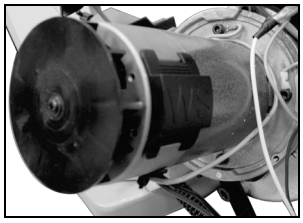



Fig. 18

Fig. 19

Fig. 20

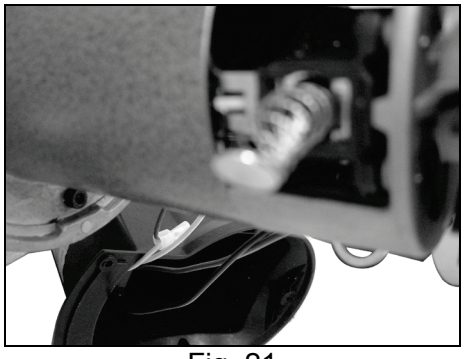


Fig. 21

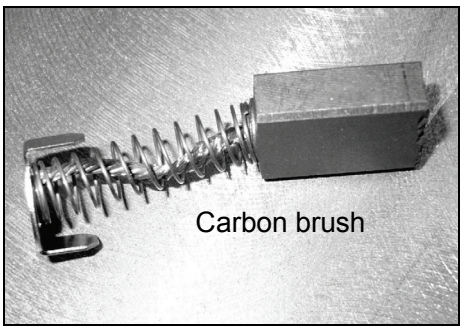



Fig. 22

## Adjust Assistant Plate

This assistant plate can move depend on material length. If the working piece is longer than vise, adjust assistant plate (Fig. 23, A) location to support working piece. It offers the support point while cutting. This plate makes cutting more stable and easy. While miter cutting, it will cut plate slightly. It won't damage with plate. This plate is replaceable.

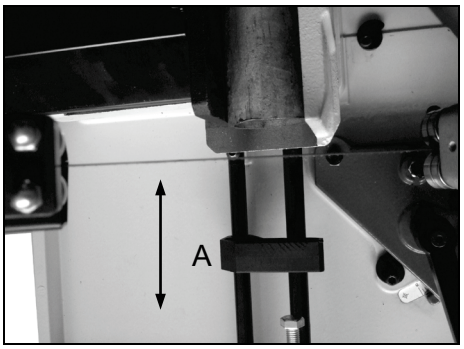



Fig. 23

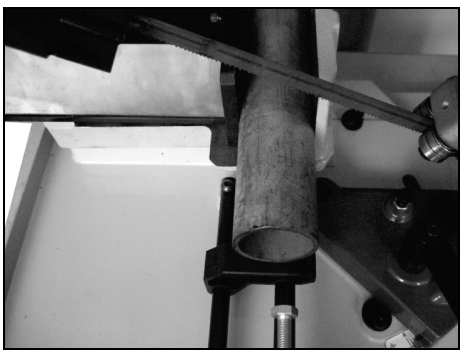
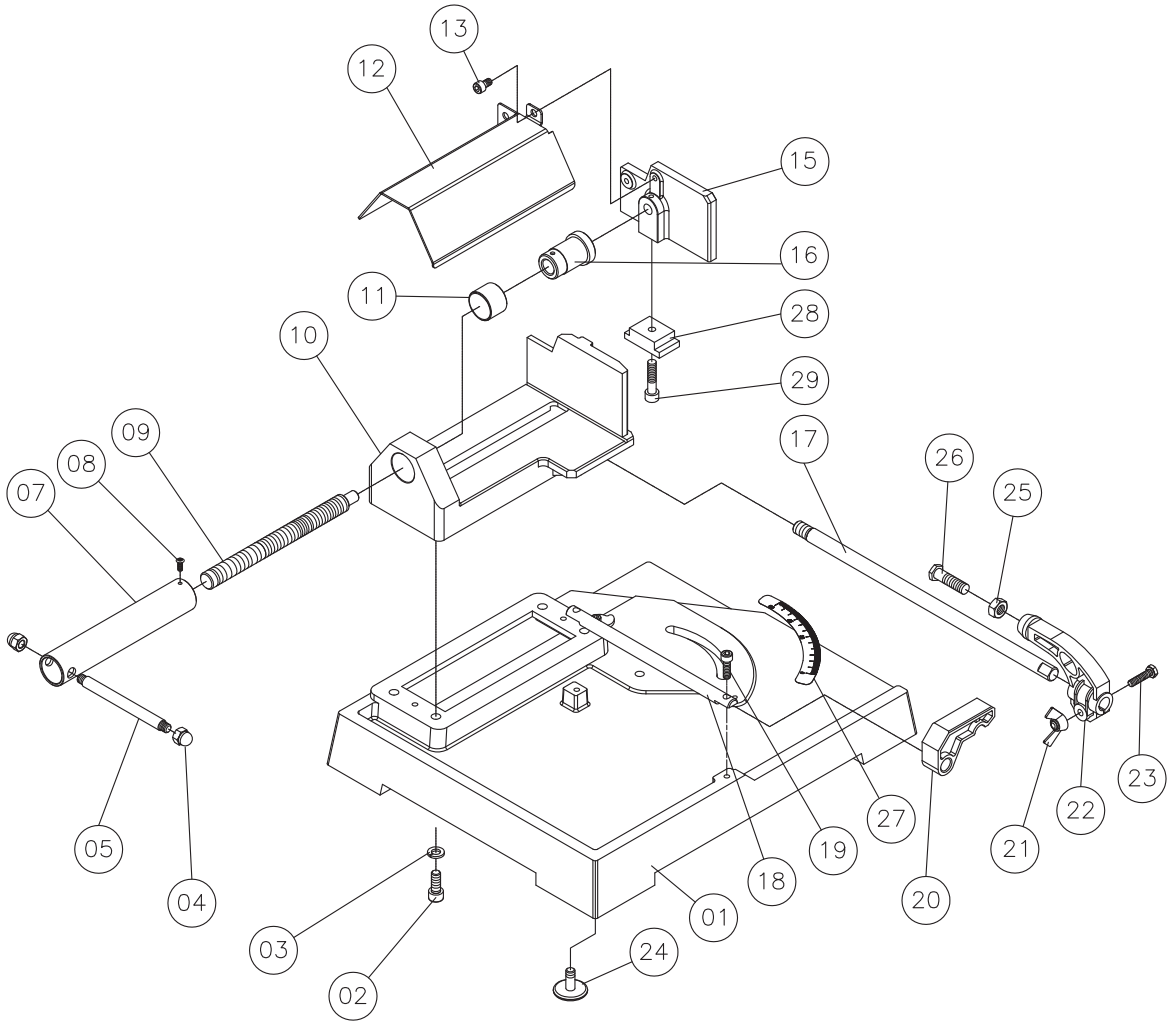


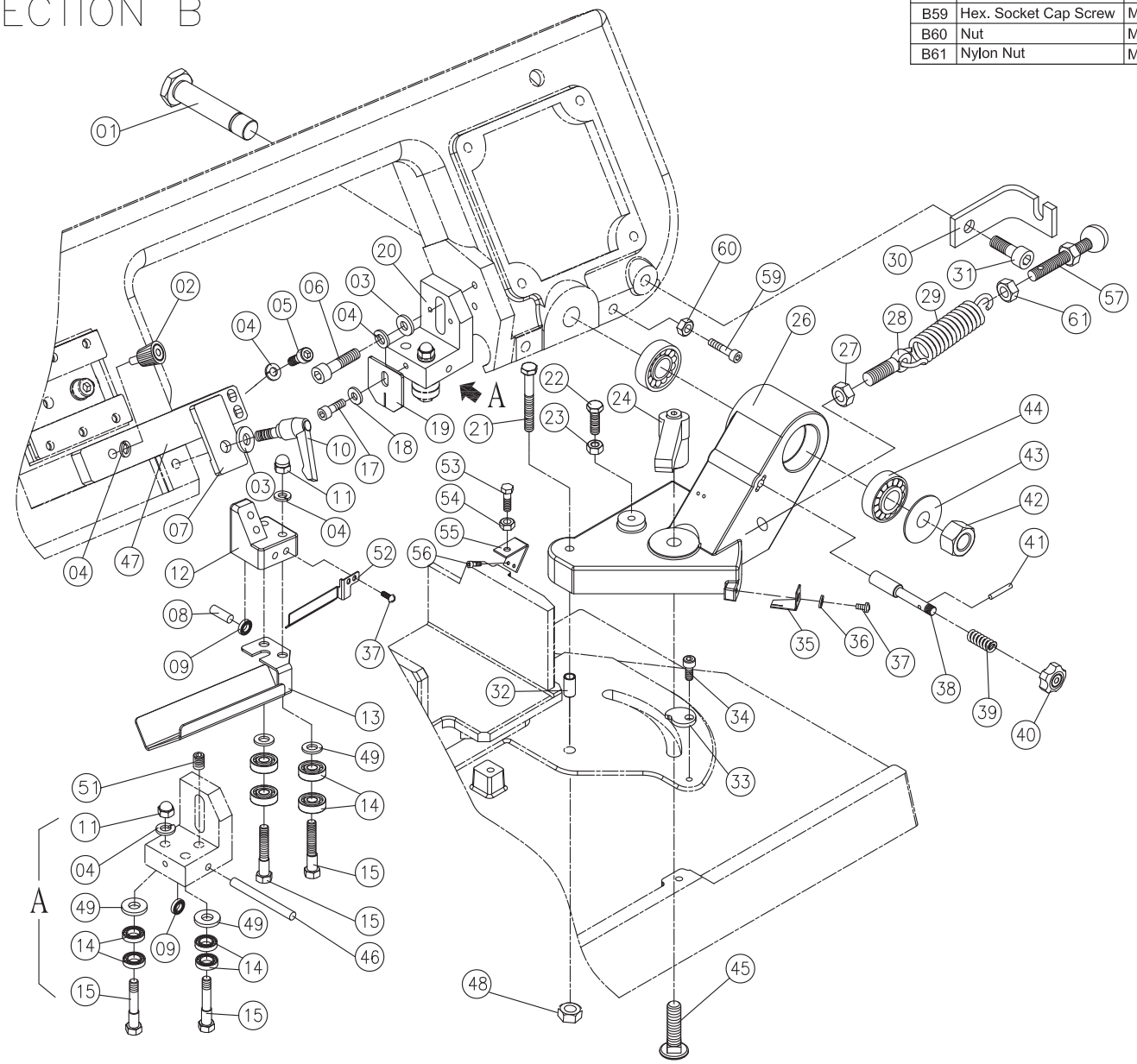
Fig. 24

# SECTION A




| PARTS LIST | | | |
|---|---|---|---|
| Part No. | Description | Size No. | Q'ty |
| A01 | Table Base | | 1 |
| A02 | Hex. Socket Cap Screw | M8x20 | 4 |
| A03 | Spring Washer | M8 | 4 |
| A04 | Nut | M8 | 2 |
| A05 | Handle | | 1 |
| A07 | Handle Base | | 1 |
| A08 | Round Head Screw | M4x6 | 2 |
| A09 | Lead Screw | | 1 |
| A10 | Vise Table | | 1 |
| A11 | DU Bushing | 25x28x25 | 1 |
| A12 | Vise Cover Plate | | 1 |
| A13 | Hex. Socket Cap Screw | M6x10 | 2 |
| A15 | Vise Plate | | 1 |
| A16 | Screw Nut | | 1 |
| A17 | Length Rod | | 1 |
| A18 | Assistant Rod | | 1 |
| A19 | Hex. Socket Cap Screw | M5x10 | 2 |
| A20 | Assistant Plate | | 1 |
| A21 | Wing Nut | M6 | 1 |
| A22 | Plastic Stopper | | 1 |
| A23 | Hex. Cap Bolt | M6x20 | 1 |
| A24 | Foot Pad | | 4 |
| A25 | Nut | M8 | 1 |
| A26 | Hex. Cap Bolt | M8x13x25 | 1 |
| A27 | Angle Scale | | 1 |
| A28 | T type Block | | 1 |
| A29 | Hex. Socket Cap Screw | M8x25 | 1 |

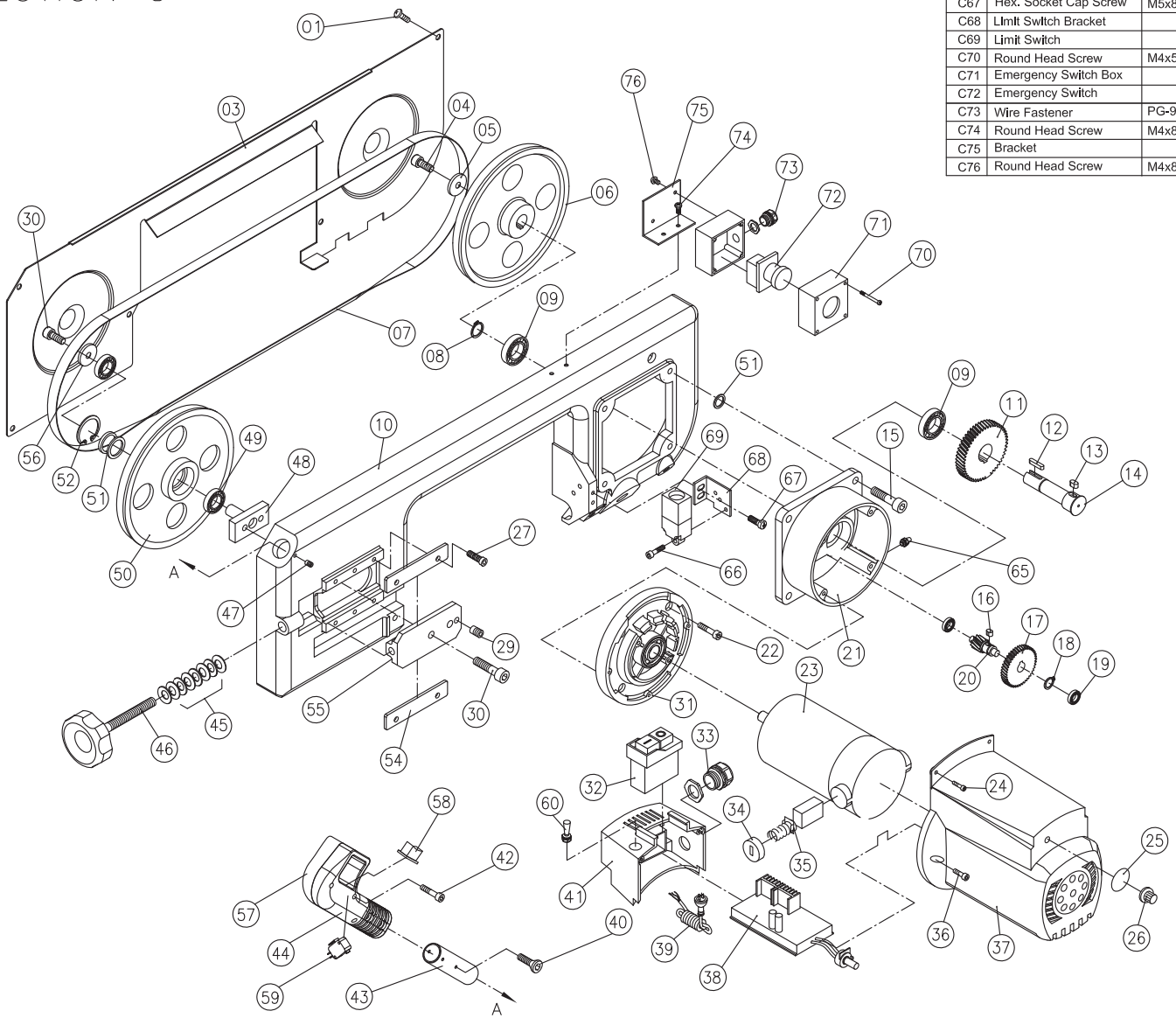
# SECTION B




| Part No. | Description | Size No. | Q'ty |
|---|---|---|---|
| B01 | Saw Head Shaft | | 1 |
| B02 | Knob | 1/4 | 1 |
| B03 | Washer | M6X16X2 | 3 |
| B04 | Spring Washer | M6 | 11 |
| B05 | Hex. Socket Cap Screw | M6x16 | 2 |
| B06 | Hex. Socket Cap Screw | M6x25 | 2 |
| B07 | Compress Plate | | 1 |
| B08 | Pin | ø5x14 | 1 |
| B09 | Bearing | 625ZZ | 2 |
| B10 | Locking Handle | M6x16 | 1 |
| B11 | Nut | M6 | 4 |
| B12 | Front Bearing Seat | | 1 |
| B13 | Blade Guard | | 1 |
| B14 | Bearing | 607ZZ | 8 |
| B15 | Eccentric Shaft | | 4 |
| B17 | Hex. Socket Cap Screw | M5x10 | 1 |
| B18 | Washer | M5 | 1 |
| B19 | Small Plate | | 1 |
| B20 | Rear Bearing Seat | | 1 |
| B21 | Hex. Cap Bolt | M6x50 | 1 |
| B22 | Hex. Cap Bolt | M6x20 | 1 |
| B23 | Nut | M6 | 1 |
| B24 | Locking Handle | 3/8 | 1 |
| B26 | Swiveling Base | | 1 |
| B27 | Nut | M10 | 1 |
| B28 | Tension Hook | | 1 |
| B29 | Tension Spring | | 1 |
| B30 | Tension Bracket | | 1 |
| B31 | Hex. Socket Cap Screw | M10x20 | 1 |
| B32 | Position Shaft | | 1 |
| B33 | 45° Angle Cutting Plate | | 2 |
| B34 | Hex. Socket Cap Screw | M5x10 | 2 |
| B35 | Angle Plate | | 1 |
| B36 | Washer | M4X12X1 | 1 |
| B37 | Round Head Screw | M4x8 | 3 |
| B38 | Locking Rod | | 1 |
| B39 | Compress Spring | | 1 |
| B40 | Plastic Knob | M6 | 1 |
| B41 | Spring Pin | ø2.5x8 | 1 |
| B42 | Shaft Nut | M15 | 1 |
| B43 | Bearing Cover | | 1 |
| B44 | Taper Bearing | 30202 | 2 |
| B45 | Locking Bolt | 3/8x1-3/4 | 1 |
| B46 | Pin | ø5x30 | 1 |
| B47 | Front Bearing Bracket | | 1 |
| B48 | Nylon Nut | M6 | 1 |
| B49 | Washer | M6X13X1.5 | 5 |
| B51 | Set Screw | M5X8 | 1 |
| B52 | Safety Plate | | 1 |
| B53 | Hex. Cap Bolt | M8x25 | 1 |
| B54 | Nut | M8 | 1 |
| B55 | Cut off Position Seat | | 1 |
| B56 | Round Head Screw | M4x8 | 2 |
| B57 | Bolt | M8x50 | 1 |
| B59 | Hex. Socket Cap Screw | M6x20 | 1 |
| B60 | Nut | M6 | 1 |
| B61 | Nylon Nut | M8 | 2 |

1040420-V3

# SECTION C




| Part No. | Description | Size No. | Q'ty |
|---|---|---|---|
| C65 | Oil Nipple | 1/4x28T | 1 |
| C66 | Round Head Screw | M4x25 | 2 |
| C67 | Hex. Socket Cap Screw | M5x8 | 2 |
| C68 | Limit Switch Bracket | | 1 |
| C69 | Limit Switch | | 1 |
| C70 | Round Head Screw | M4x50L | 4 |
| C71 | Emergency Switch Box | | 1 |
| C72 | Emergency Switch | | 1 |
| C73 | Wire Fastener | PG-9 | 2 |
| C74 | Round Head Screw | M4x8 | 2 |
| C75 | Bracket | | 1 |
| C76 | Round Head Screw | M4x8 | 2 |

| Part No. | Description | Size No. | Q'ty |
|---|---|---|---|
| C01 | Big Round Head Screw | M5x8 | 5 |
| C03 | Blade Cover | | 1 |
| C04 | Hex. Socket Cap Screw | M6x16 | 1 |
| C05 | Washer | M6X22X2 | 1 |
| C06 | Driver Wheel | | 1 |
| C07 | Blade | 1440x13x0.65 | 1 |
| C08 | C Ring | S-15 | 1 |
| C09 | Bearing | 6202 | 2 |
| C10 | Saw Head | | 1 |
| C11 | Output Gear | | 1 |
| C12 | Key | 4x4x20 | 1 |
| C13 | Key | 5x5x10 | 1 |
| C14 | Driver Wheel Shaft | | 1 |
| C15 | Hex. Socket Cap Screw | M8x25 | 4 |
| C16 | Key | 4x4x6 | 1 |
| C17 | Connect Gear | | 1 |
| C18 | C Ring | S-11 | 1 |
| C19 | Ball Bearing | 607 | 2 |
| C20 | Motor Gear | | 1 |
| C21 | Gear Gase | | 1 |
| C22 | Hex. Socket Cap Screw | M5x20 | 4 |
| C23 | Motor | 230V/300W | 1 |
| C24 | Tap Screw | M3x15 | 2 |
| C25 | Speed Scale | 23-75MPM | 1 |
| C26 | Speed Knob | | 1 |
| C27 | Hex. Socket Cap Screw | M6x16 | 4 |
| C29 | Set Screw | M8X10 | 1 |
| C30 | Hex. Socket Cap Screw | M8x15 | 3 |
| C31 | Motor Front Cover | | 1 |
| C32 | Magnetic Switch | | 1 |
| C33 | Wire Fastener | PG-9 | 1 |
| C34 | Brush Cover | | 2 |
| C35 | Carbon Brush | | 2 |
| C36 | Hex. Socket Cap Screw | M4x12 | 3 |
| C37 | Motor Case | | 1 |
| C38 | IC Control Board | 230V | 1 |
| C39 | Power Cable | | 1 |
| C40 | Flat Head Screw | M5x8 | 4 |
| C41 | Switch Cover | | 1 |
| C42 | Tap Screw | M3x15 | 3 |
| C43 | Cutting Handle | | 1 |
| C44 | Handle (L) | | 1 |
| C45 | Disc Washer | M10X20X0.8 | 8 |
| C46 | Tension Bolt | M10x50 | 1 |
| C47 | Set Screw | M5x8 | 1 |
| C48 | Shaft Seat | | 1 |
| C49 | Ball Bearing | 6201 | 2 |
| C50 | Idle Wheel | | 1 |
| C51 | Washer | 12.2X16.8X0.5 | 4 |
| C52 | C Ring | R32 | 1 |
| C54 | Slider Guide | | 2 |
| C55 | Slider Block | | 1 |
| C56 | Washer | M8X19X2 | 1 |
| C57 | Handle (R) | | 1 |
| C58 | Handle Button | | 1 |
| C59 | Limit Switch | | 1 |
| C60 | Toggle Switch | | 1 |