

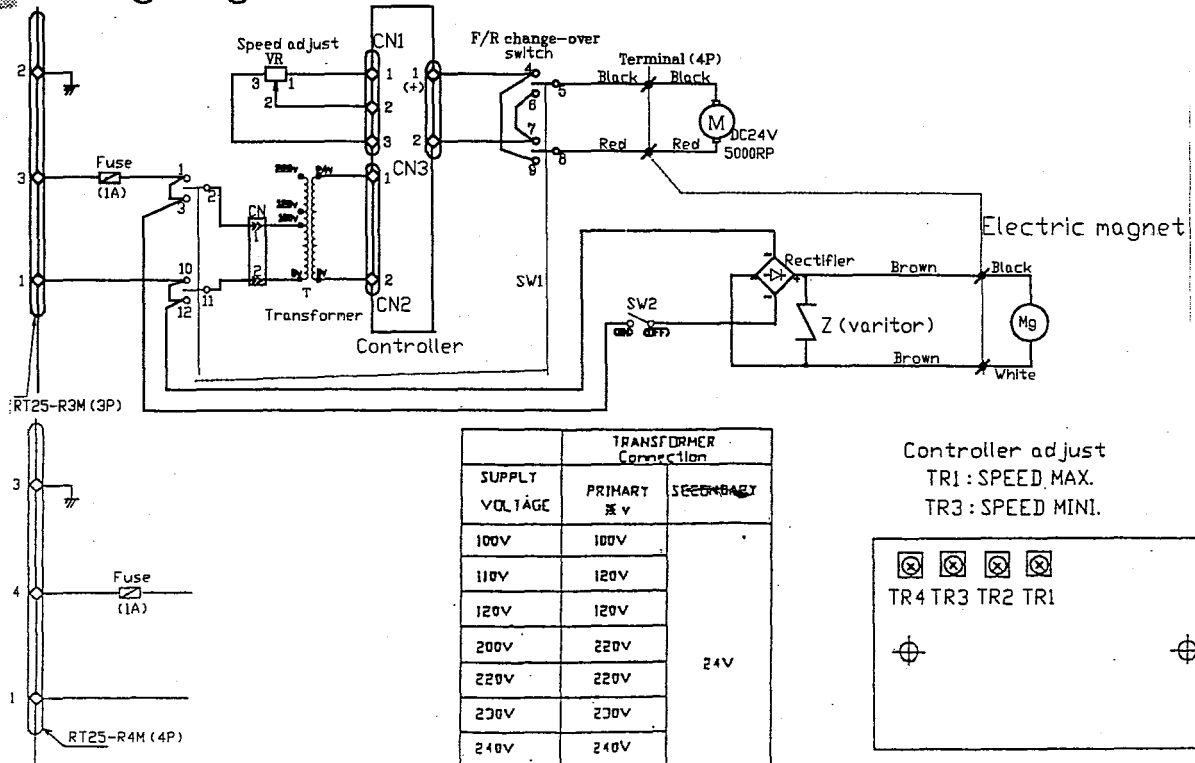
3) The machine will not move. (The motor runs.)

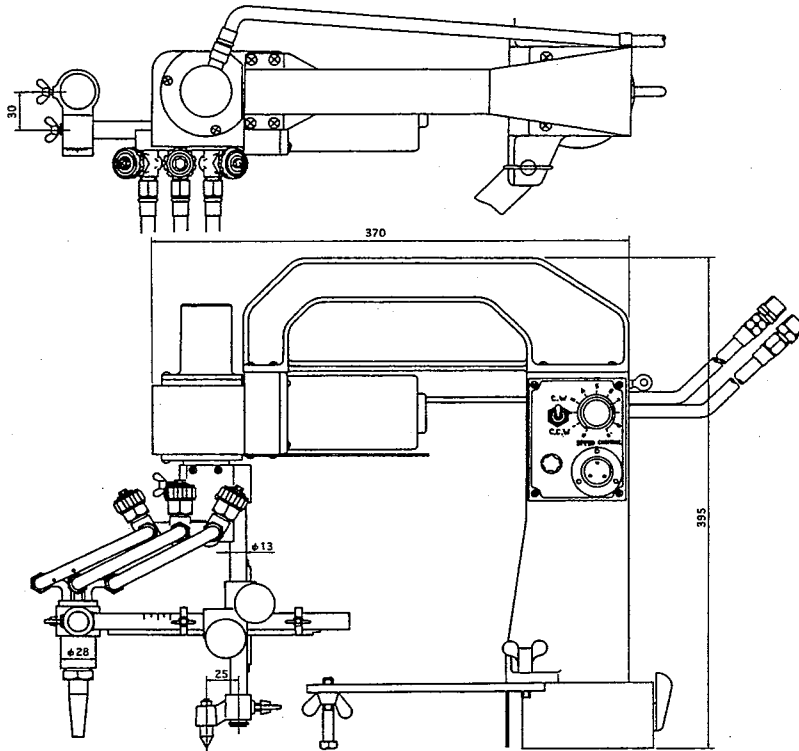
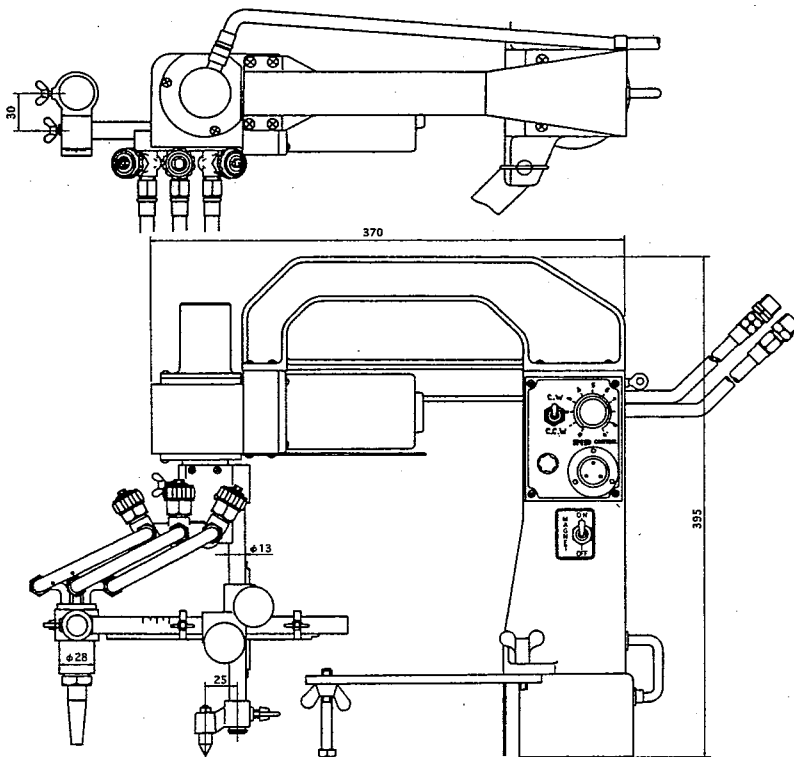
Cause	Inspection point	Correction
1)Malfunction	Remove the speed reducer box to check the clutch operation.	Disassemble and clean.

4) The machine runs incorrectly.

Cause	Inspection point	Correction
1)The speed is too fast.	The supply voltage is abnormal.	Check the voltage.
2)Low speed is not possible.	①Speed control resistor is defective.	Replace with a new one.
	②Defective wiring	Correct the wiring.
	③Defective motor	Replace with a new one.
	④Defective controller	Replace with a new one.
3)High speed is not possible.	When the supply voltage has dropped.	Check with a tester.
4)Knocking occurs.	①Abrasion of gears	Replace.
	②Hoses or cabtire cords hinder smooth running.	Consider during operation.
	③Breakage of FP ring.	Replace

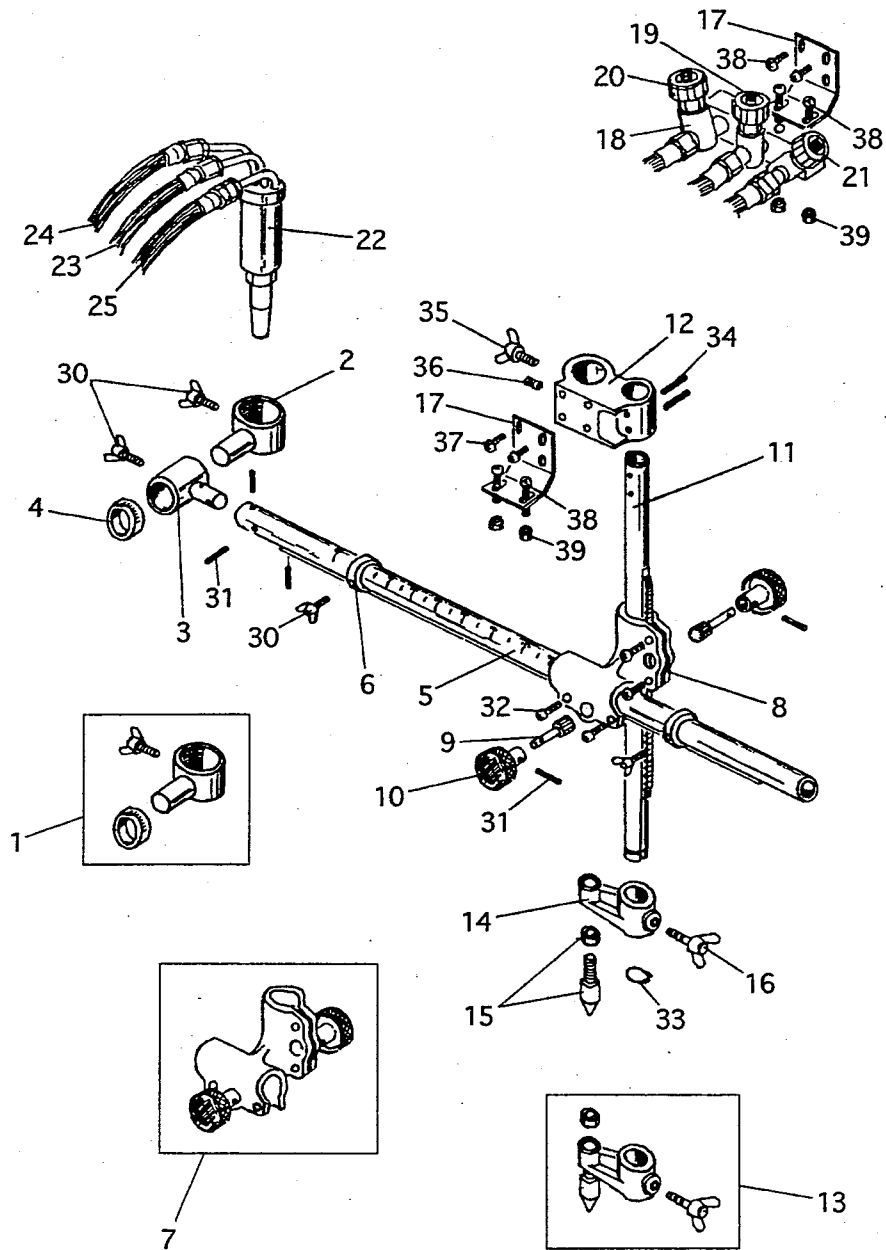
### 8 Wiring diagram



**9 Assembly drawing of CIR-CUT****■ CIR-CUT I****■ CIR-CUT II**

# 10 Parts List

## 10.1 Gas unit

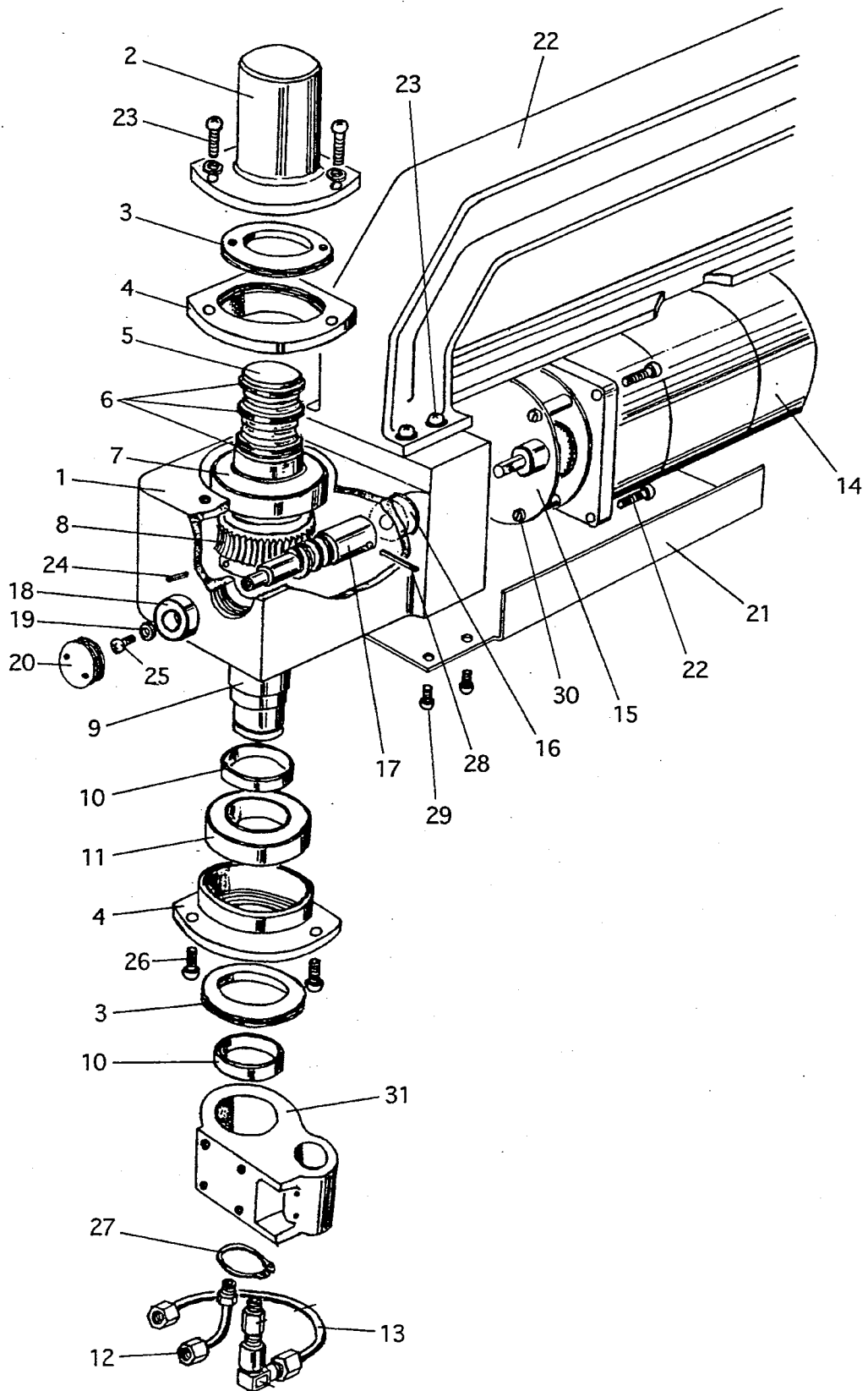


## Gas unit

ITEM No.	PART NAME	QTY	STOCK No.	REMARKS
1	Torch holder assembly	1	60032600	
2	Torch holder	1	60032601	
3	Torch holder base	1	60032602	
4	Graduation collar	1	60030906	With screw
	Graduation pipe	1	60032603	With rack Except USA
5	Graduation pipe	1	60032604	With rack USA Only
6	Stopper	2	60032650	
7	Cross feed holder assembly	1	60032655	
8	Cross feed holder	1	60032605	
9	Pinion	2	60031627	
10	Handle	2	60031628	
11	Rotary pipe	1	60032606	With rack
12	Rotary pipe holder	1	60032607	
13	Center holder assembly	1	60032609	
14	Center holder	1	60032608	
15	Pivot pin	1	60030913	
16	Stop handle	1	60030915	
17	Distributor bracket	1	60032637	
18	Distributor	1	60013103	Except USA,KE
	Distributor	1	60013104	USA Only
	Distributor	1	60013016	KE Only
19	Valve for jet oxygen	1	60015351	Except KE
	Valve for jet oxygen	1	60015352	KE Only
20	Valve for preheat oxygen	1	60015355	Except KE
	Valve for preheat oxygen	1	60015358	KE Only
21	Valve for gas	1	60015356	
22	Torch	1	60010353	Except USA,KE
	Torch	1	60010354	USA Only
	Torch	1	60010355	KE Only
23	Hose for jet oxygen	1	60032638	Except USA,KE
	Hose for jet oxygen	1	60032639	USA Only
	Hose for jet oxygen	1	60032640	KE Only

ITEM No.	PART NAME	QTY	STOCK No.	REMARKS
24	Hose for preheat oxygen	1	60032640	Except USA
	Hose for preheat oxygen	1	60032639	USA Only
25	Hose for gas	1	60032641	Except USA
	Hose for gas	1	60032642	USA Only
30	Wing bolt	3	BS-4×8	M4×8
31	Spring pin	3	PR-2×12	
32	Screw	4	SP-4×15	M4×15
33	Stop ring	1	STW×13	
34	Spring pin	2	PR-2.5×20	
35	Wing bolt	1	BS-5×10	M5×10
36	Screw	1	SS-5×8	M5×8
37	Screw	2	SP-4×8	M4×8 With WF
38	Screw	2	SP-4×25	M4×25 With WF
39	Nut	2	NH-4	

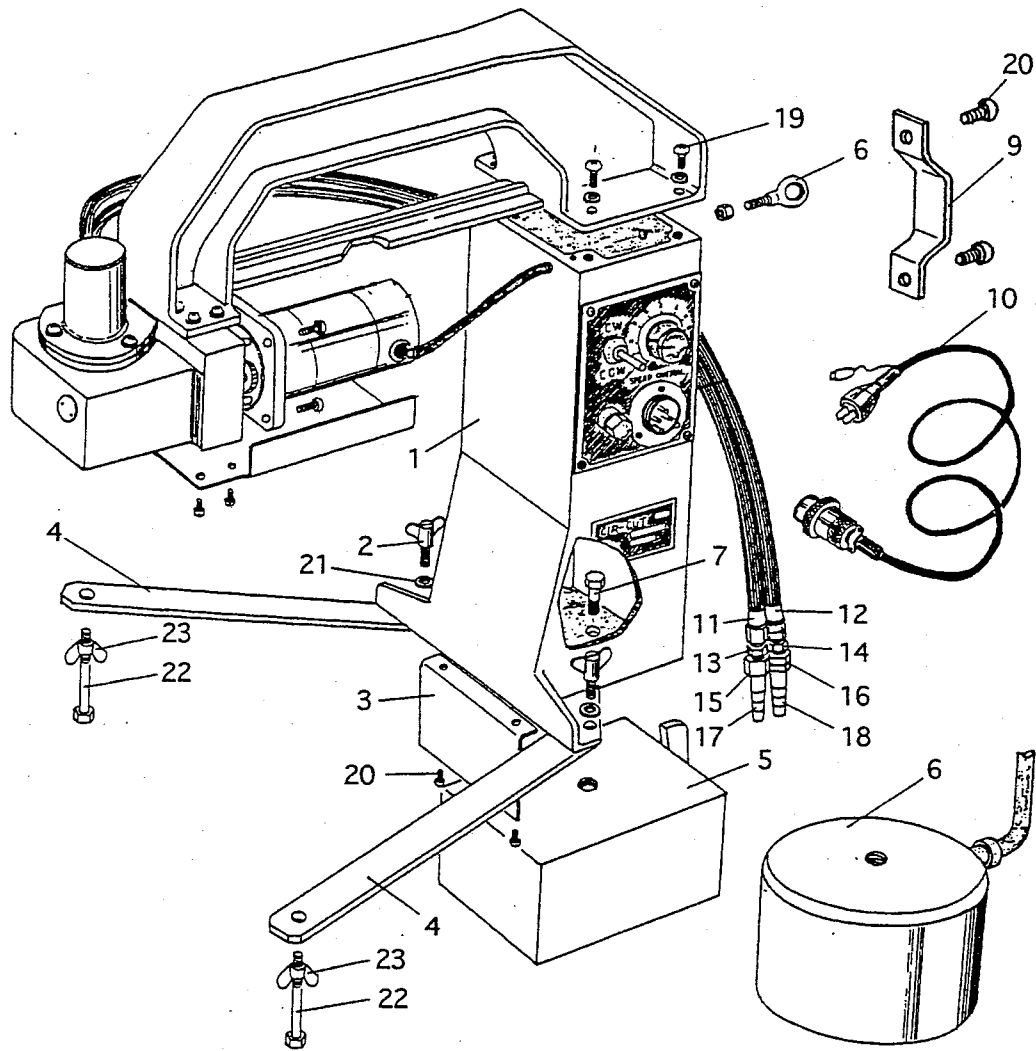
## 10.2 Speed reducer unit



## Speed reducer unit

ITEM No.	PART NAME	QTY	STOCK No.	REMARKS
1	Gear box	1	60032612	
	Distributor Cover	1	60032621	EXcept USA
2	Distributor Cover	1	60032622	USA Only
3	Adjusting Screw	2	60032614	
4	Casing	2	60032613	
5	Rotary distributor	1	60032620	
6	FP ring	3	60030922	
7	Bearing	1	60031451	6005ZZ
8	Worm wheel	1	60032617	
9	Sleeve	1	60032615	
10	Collar	2	60032616	
11	Bearing	1	60031743	6906ZZ
12	Conduit pipe for gas	1	60032623	
13	Conduit pipe for oxygen	1	60032624	
14	Motor	1	69000126	DC24V 15W 5000 R.P.M
15	Gear	1	60032656	R B -54 1/30
16	Bush	1	60032625	
17	Worm	1	60032618	
18	Bearing	1	60031033	627ZZ
19	Washer	1	60031015	
20	Bearing retainer	1	60031014	
21	Motor cover	1	60032619	
22	Grip	1	60032629	
23	Screw	11	SP-4×15	M4×15 With SW
24	Spring pin	1	PR-2.5×5	
25	Screw	1	SP-4×8	M4×8
26	Screw	3	SP-4×10	M4×10
27	Stop ring	1	STW-25	
28	Spring pin	1	PR-2.5×15	
29	screw	4	SP-4×6	M4×6
30	Screw	3	SP-3×20	M3×20
31	Rotary pipe holder	1	60032607	

### 10.3 Frame

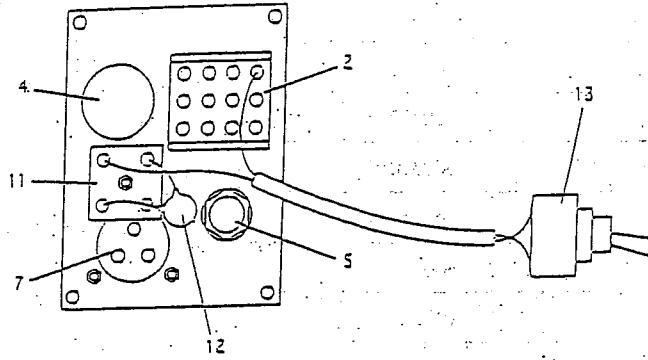


## Frame

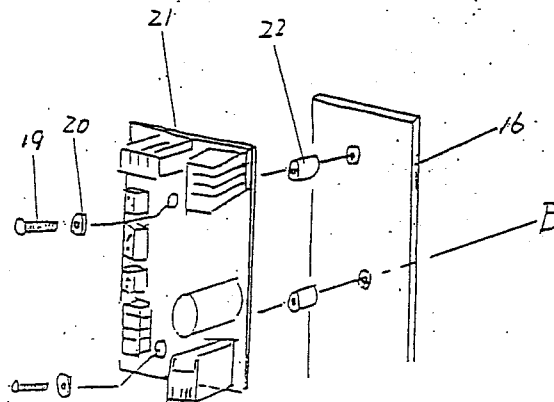
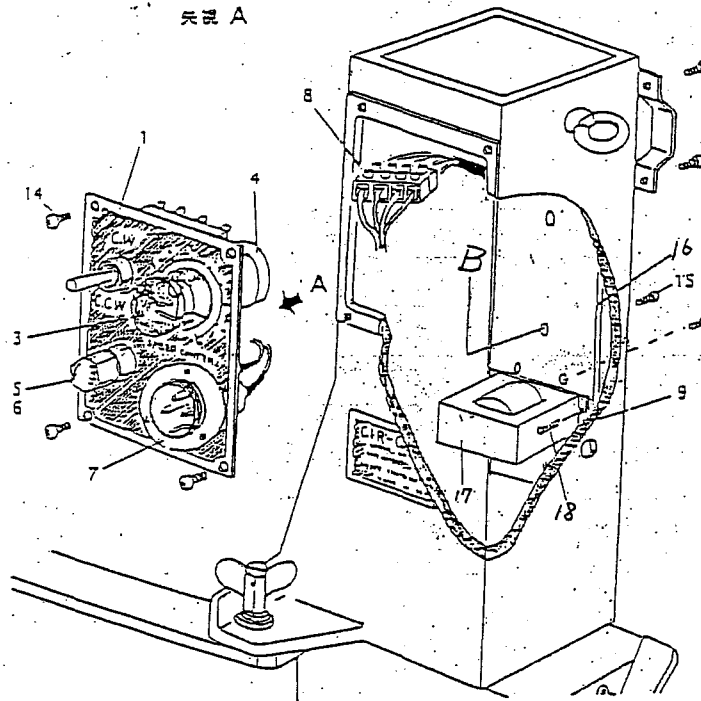
ITEM No.	PART NAME	QTY	STOCK No.	REMARKS
1	Machine base( I )	1	60032627	
	Machine base( II )	1	60032628	
2	Wing bolt	2	60030215	M 8 × 2 0
3	Heat shield( I )	1	60031053	
	Heat shield( II )	1	60032633	
4	Leg	2	60032630	
5	Magnet	1	60031653	( I )Type (100K)
6	Electric magnet	1	60032652	( II )Type (K E - S 300 R)
7	Bolt for magnet	1	60032632	( II )Type (M 10 × 25)
	Bolt for magnet	1	60031055	( I )Type (M 12 × 15)
8	Hook bolt	1	60031654	M 8 With nut
9	Hose bracket	1	60032631	
10	Cabtyre cord	1	60030201	3 P × 5 M 100T
11	Hose for jet oxygen	1	60031106	Except USA, KE
	Hose for jet oxygen	1	60031107	USA Only
	Hose for jet oxygen	1	60031108	KE Only
12	Hose for gas	1	60031110	Except USA
	Hose for gas	1	60031111	USA Only
13	Connection nipple for oxygen	1	60031001	Except USA
	Connection nipple for oxygen	1	60031002	USA Only
14	Connection nipple for gas	1	60031003	Except USA
	Connection nipple for gas	1	60031004	USA Only
15	Nut for oxygen	1	60015001	Except USA
	Nut for oxygen	1	60015056	KE Only
16	Nut for gas	1	60015002	Except USA
	Nut for gas	1	60015054	KE Only
17	Hose connector (ox)	1	60015003	Except USA
	Hose connector (ox)	1	60015040	KE Only
18	Hose connector (gas)	1	60015004	Except USA
	Hose connector (gas)	1	60015062	KE Only
19	Screw	4	SP-4 × 18	M 4 × 18 With SW
20	Screw	4	SP-4 × 6	M 4 × 6

ITEM No.	PART NAME	QTY	STOCK No.	REMARKS
21	Washer	2	WF-8	
22	Hexagon bolt	2	BH-8 × 35	( I )Type (M 8 × 3 5)
	Hexagon bolt	2	BH-8 × 45	( II )Type (M 8 × 4 5)
23	Wing nut	2	NB-8	
10	Cabtyre cord		60030296	AP × 5 M 210 ~ 220T ( I )Type only

10.4 Electrical



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## Electrical

ITEM No.	PART NAME	QTY	STOCK No.	REMARKS
1	Control panel	1	60032647	
2	Switch	1	60031458	S-43
3	Grip	1	60031332	
4	Variable resistor	1	60030745	
5	Fuse holder	1	60030749	
6	Fuse	1	60030709	(1 A)
7	Metal socket (3P)	1	60030273	For 100V
8	Terminal	1	60031666	(I) Type (2P)
	Terminal	1	60030656	(II) Type (4P)
9				
10				
11	Rectifier	1	60032644	(II) Type only
12	Varistor	1	60032645	(II) Type only
13	Switch	1	60030743	(II) Type only (M S - 140)
14	Screw	4	SP-4X8	M4X8
15	Screw	2	SP-4X40	M4X40
16	Bracket	1		
17	Transformer	1	61000472	For 100~220V
			61000672	For 220~240V
			61000473	For 42V (KE)
18	Screw	2	M3X10	with SW
19	Screw	2	M3X10	
20	Isolation washer	2	60036394	
21	Controller	1	69000105	
22	Spacer	2	6R020001	
7	Metal socket (4P)		60030274	For 200~240V (I) Type only

220V = (I) TYPE ONLY

(I) TYPE ONLY