

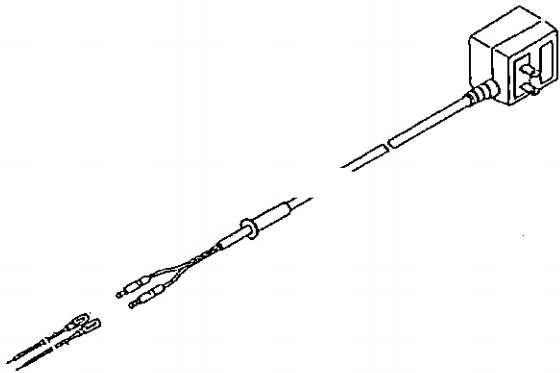
Handy Auto Power Cord Selection



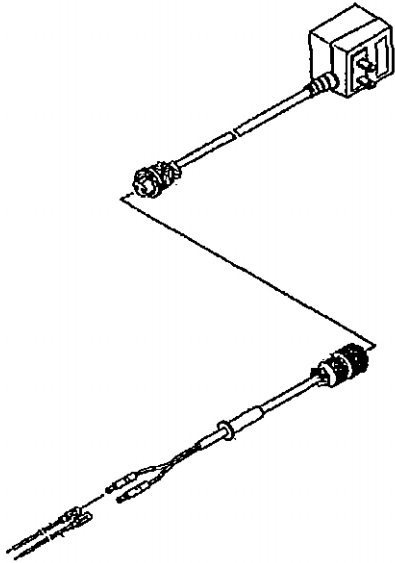
Old Power Cord (64000017) Plug ZS30029
Mating Socket ZS30053
Adapter & Lead Assembly ZS30052



New Power Cord (64000232) Plug 6N100066
Mating Socket 6N100067
Adapter & Lead Assembly 61004650



If You have this type of Power Cord (ZS30032) you will need to order Part Number 64000232 and Part Number 61004650



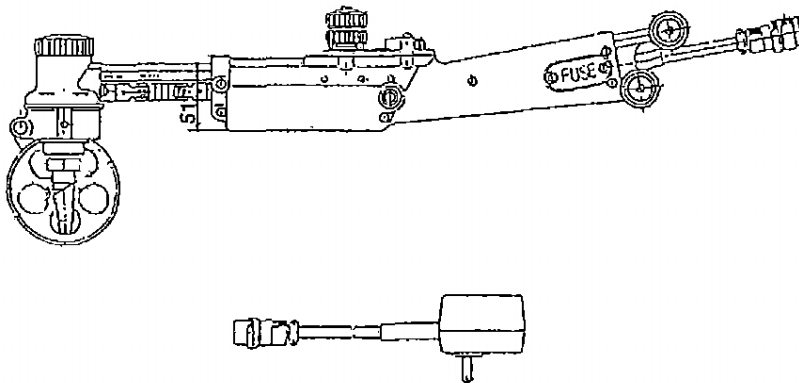
If you Have this type of Power Cord you will need to order Part Number 64000232

NOTE

If the plug on the existing power cord is made of Black Plastic (64000017) you will also need to order Part Number 61004650 (Adapter & Lead) or Part Number 6N100067 (Socket)

If the plug on the existing Power Cord is made of Green Plastic (64000232) you will only need to order the Power Cord Part Number 64000232

The ZS30052 Adapter & Lead will only be used for a replacement part on existing machines still using the Power Cord (64000017) with the Black Plastic Plug. **It should not be sold with a new 64000232 Power Cord.**



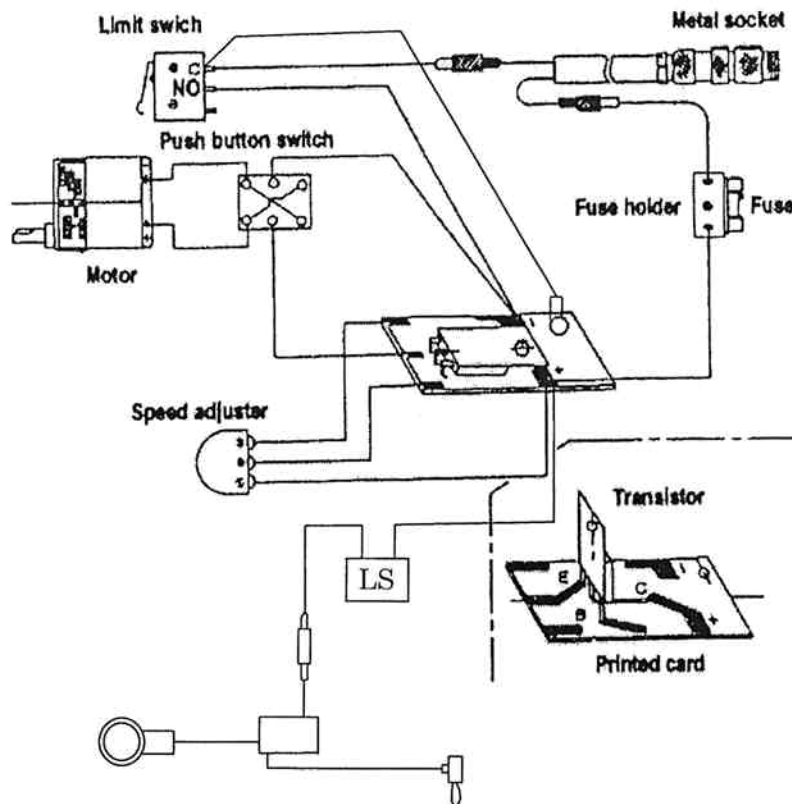
All Replacement Power Cords will have a connector that will allow the customer to replace the power cord by simply unplugging it from the machine as shown above.

Possible Cause	Procedure	Remedy
1) Slag between the drive wheel and the beveling gear.		Clean

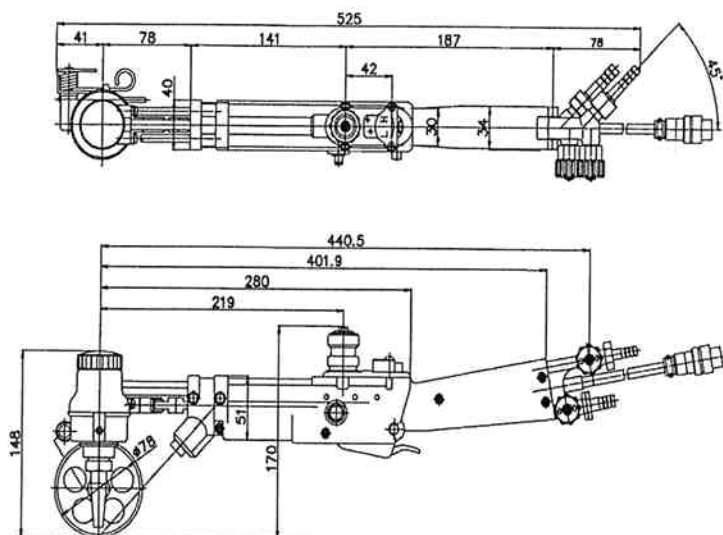
5) Wheel rotates but speed cannot be adjusted.

Possible Cause	Procedure	Remedy
Faulty speed adjuster or transistor.		Repair or replace.

8 Wiring diagram

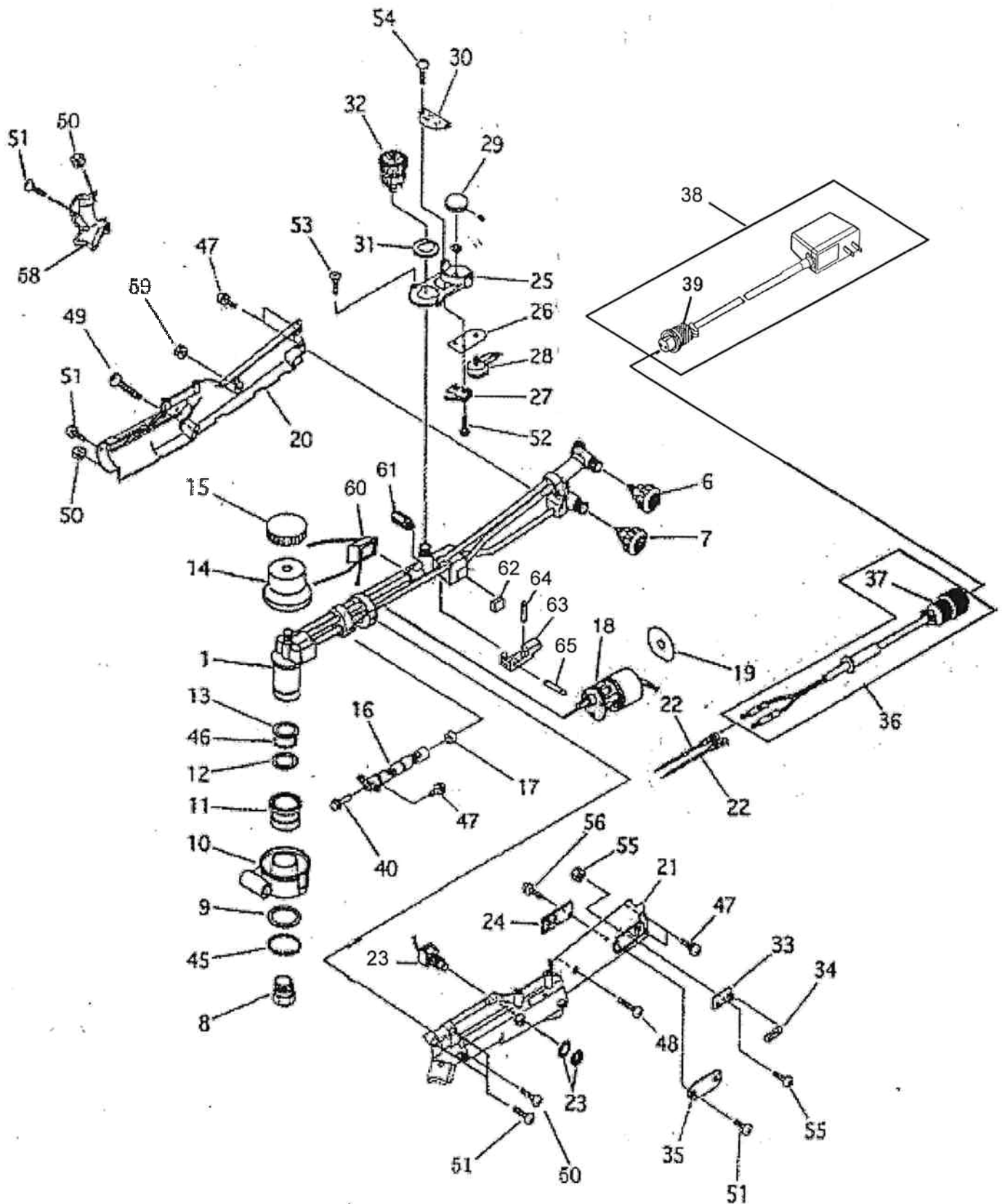


9 Assembly drawing of Handy Auto PLUS



10 Parts list

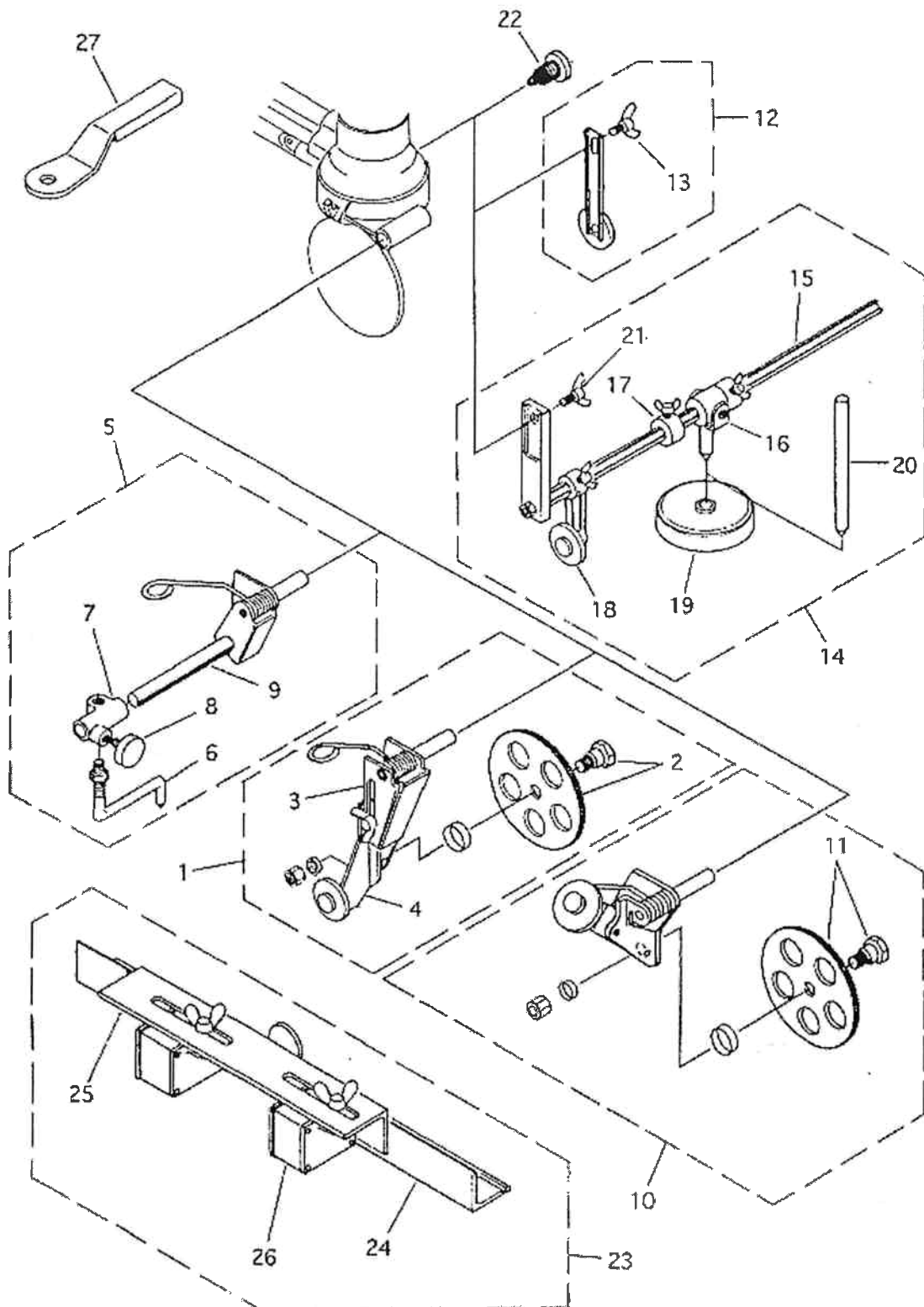
10.1 Main units



Main units

Item No.	Part name	Q'ty	Stock No.	Remarks
1	Torch	1	61001952	2A01357A0
6	Valve for preheat oxygen	1	80015777	Blue
7	Valve for gas	1	80015778	Red
8	Tip fixing nut	1	60015032	
9	Torch head collar	1	60030003	
10	Gear cover	1	60030004	
11	Bevel gear	1	60030007	With DU bush
12	Thrust collar (Lower side)	1	60030008	
13	Thrust collar (Upper side)	1	60030009	
14	Torch head cover	1	60030005	
15	Position setting knob	1	60030006	
16	Universal joint	1	60030010	
17	Reduction gear collar	1	60030097	
18	Motor with speed reduction gear	1	60030088	
19	Motor insulating plate	1	60030038	
20	Main unit cover (right)	1	61001724	
21	Main unit cover (left)	1	61001723	
22	Mid way terminal	1	60030028	
23	Press button switch	1	61002003	
24	Printed circuit card	1	60030064	
25	Limit switch cover	1	60030014	
26	Limit switch insulating cover	1	60030017	
27	Limit switch	1	60030023	
28	Speed adjuster	1	60030024	
29	Speed adjuster knob	1	60030065	With screw
30	Speed adjuster cover	1	60030016	
31	Limit switch top	1	60030012	
32	Jet oxygen valve with knob	1	60030013	
33	Fuse holder	1	60030026	
34	Fuse	1	60030027	
35	Fuse cover	1	60030018	
36	Metal socket with cord	1	60030052	
37	Plug	1	6N100067	NCS-162-Ad ★
38	AC adapter with cabtyre cord (16F)	1	64000232	★
39	Plug	1	6N100066	NCS-162-P ★
40	Bevel gear (S)	1	60030062	
45	Stop ring	1	6B530280	ISTW-28
46	Steel ball	32	60030181	
47	Screw	1	6C530410	SP-4x10,With WS
48	Screw	1	6C530430	SP-4x30,With WS
49	Screw	1	6C520435	SP-4x35
50	Screw	1	6C610418	SP-4x18,With NH
51	Screw	4	6C520408	SP-4x8
52	Screw	2	6C520210	SP-2x10
53	Screw	2	6C500408	SF-4x8
54	Screw	2	6C520408	SP-4x8
55	Screw	1	6C610306	SP-3x6,With NH
56	Screw	1	6C520406	SP-4x6
58	Nozzle cover	1	61001725	
59	Hexagon nut	1	6D010040	NH-4
60	Ignition Transformer	1	61001726	
61	Support	1	64000055	PLSBWRK7-20
62	Micro limit switch	1	64000147	
63	Lever	1	80009299	
64	Pin	1	80009325	
65	Wave spring pin	1	6B400003	PS-3x17

10.2 Option units

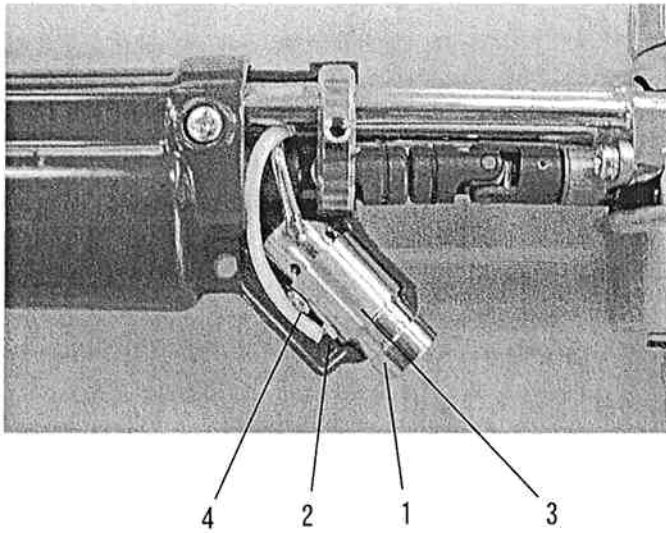


Option units

Item No.	Part name	Q'ty	Stock No.	Remarks
1	Standard wheel assembly	1	60030100	
2	Drive wheel (3inch diameter)	1	60030107	With shaft and nut
3	Standard wheel bracket	1	60030108	
4	Guide roller	1	60030109	
5	Small circle cutting attachment assembly	1	61001597	HAP
6	Centering needle	1	61001556	HAP
7	Centering needle holder	1	60030113	
8	Radius setting knob	1	60030114	
9	Bracket bar assembly	1	61001599	HAP
10	Beveling wheel assembly	1	60030102	
11	Beveling wheel	1	60030110	With shaft and nut
12	Auxiliary wheel assembly	1	60030101	
13	Wing bolt	1	60030126	
14	Large circle cutting attachment assembly	1	60030106	For XL cutting see note below
15	Bar (19.7inch diameter)	1	60030120	
16	Free holder	1	60030121	
17	Stop collar	1	60030122	With wing bolt
18	Support roller	1	60030123	
19	Magnet	1	60030124	
20	Magnet center	1	60030125	
21	Wing bolt	1	60030127	
22	Clutch knob	1	60030115	
23	Straight rail assembly	1	60030104	
24	Rail	1	60030117	
25	Rail bracket	1	60030118	
26	Magnet	1	60030119	
27	Guide lever	1	60030105	

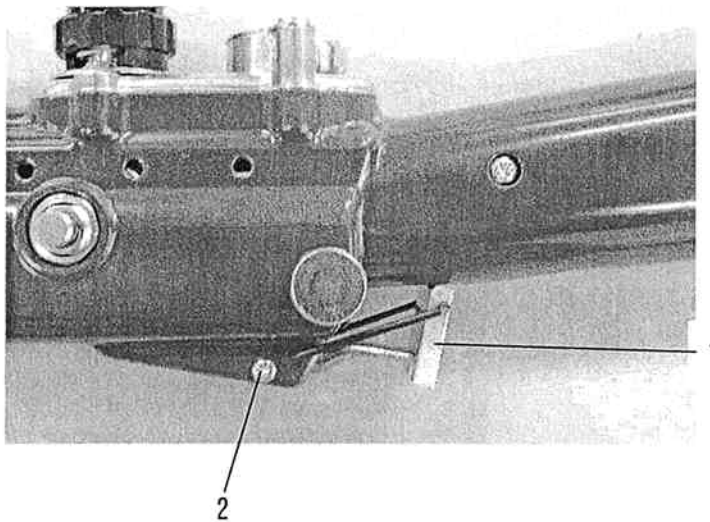
NOTE: For ZS30130 Extra-Large Circle cutting attachment all parts shown in assembly 14 are correct. A longer cross Bar (39.4 in) is used. Part # ZS30132 Extra Large Cutting Arm

1 0 . 3 Pilot unit Assy



Item	Parts Name	Q'ty	Stock No.	Remarks
1	Mixing pipe	1	80009322	
2	Electrode	1	80009324	
3	Cover	1	80009328	
4	Set screw	1	6C520305	SP-3x5

1 0 . 4 Safety lock assy



Item	Parts Name	Q'ty	Stock No.	Remarks
1	Safety lock ass'y	1	61002199	
2	Set screw	1	6C520303	SP-3x3